



Modernization of HPT 250 Cold Pilger Mill for CRA - USA, 2013

GENERAL TECHNICAL CHARACTERISTICS

Blank characteristics

Outer diameter, mm	104... 355.6 (14")
Wall thickness, mm	5... 30
Length, mm	3... 6
Weight (kg), maximum	1500
Tolerated diameter deviation, %	± 1.0
Tolerated wall thickness deviation, %	± 10

Finished product characteristics

Outer diameter, mm	90... 317.5 (12.5")
Wall thickness, mm	2.5... 25.0
Length (after cutting), mm	4... 10
Tolerated diameter deviation, %	
For pipe diameters 90-150 mm	0.38
For pipe diameters 151-200 mm	0.30
For pipe diameters 201-250 mm	0.25
Tolerated wall thickness deviation, %	
For pipe wall thickness 2.5-5 mm	± 6.0
For pipe wall thickness above 5 mm	± 5.0

Technology process parameters

Number of double strokes per minute, maximum	60
Optimal number of stand double strokes, per minute	25... 45
Number of double strokes for stand adjustment, per minute	10... 15
Blank feed value, mm	4... 40
Pipe rotation angle, maximum	60°
Blank cross-section reduction (%) maximum:	
When rolling carbon steel	70
When rolling stainless steel	60
Blank outer diameter reduction, mm, maximum:	
When rolling carbon steel	70
When rolling stainless steel	50
Blank wall thickness reduction, mm, maximum:	
When rolling carbon steel	50
When rolling stainless steel	40