



HORIZONTAL SPIRAL ACCUMULATOR

By SRET Equipment



SRET Equipment

Horizontal Spiral Accumulators

The World-Class Strip Accumulators manufactured by SRET Equipment

SRET Equipment designs, engineers and manufactures the horizontal spiral accumulators that can allow for a continuous strip supply to a tube mill for a non-stop line operation.

Installed between shear end welder and forming mill, the horizontal spiral accumulator by SRET Equipment can store a large amount of strip in a reasonable footprint space to give enough time for shear end welder to cut and join the ends of two successive coils to feed a constantly running tube mill. The strip is fed into the accumulator by sets of pinch rollers twisting the strip by 90 degree. As the strip enters the accumulator, it's supported and conveyed by a rotary table or sets of rollers, which is sophisticatedly designed to minimize the resistance for reduced chance of strip cobbling, jam-ups, marking, tension, etc. The drive has three modes of stopped, high-speed fill, and line synchronized, and the number of strip wraps in the accumulator can be either fixed or variable, depending on the thickness and width of material.

More than 30 years ago, SRET Equipment was the first company in China to develop the horizontal spiral accumulator, and since then has been always recognized in China's market as the supreme supplier with most successful installation references and continuous technology innovation.

Why Chose SRET Equipment?



In-Depth Experience



Service Commitment



Latest Technology



Cost Effectiveness



Production Quality



Full Compliance



It's All About Results - Leveraging our powerful technology expertise and extensive domain experience is why so many trust SRET Equipment to deliver real results

Depending on the need of use, tube size, material type, material steel grade, performances required, our large range of accumulators satisfy a variety of applications.

Categories	Applications	Features & Customer Values	Specifications
Turning Table Type	≤ Ø89; Wall thickness from 0.5-4.0mm; Material grade: low carbon steel, high strength steel	Great suitability to high-speed tube mill line of up to 140m/min, high productivity	Variable number of loops, great storage capability of Max. 2,000m
		No scratch on the strip surface, suitable for storage of galvanized strip, bright strip, etc.	Sophisticated mechanic design to ensure no jam, no rubbing during the whole process from strip entering through to exiting the accumulator
		Able to adjust the accumulator layout to fit the actual plant site, maximize the plant space utilization ratio	Make use of the physical properties of the steel strip to make U or L shaped layout to reduce the longitudinal or transverse space occupied
		No elastic deformation for extra wide and thin material entering and exiting the accumulator	Thanks to our extensive experiences plus engineering knowledge, the scientific angles of strip entering and exiting are designed to significantly reduce its resistance for no deformation
Roller Type	Ø89-Ø165; Wall thickness from 0.8-6.0mm; Material grade: low carbon steel, high strength steel	Super practicability, suitable for a large range of strip thickness, a same accumulator can work to the strip thickness from 0.8 up to 6.0mm	Adopt reasonable strip storage loop diameters to realize super practicability of small structure
		No scratch on strip surface, no jam-ups, high yield	Rollers driven plus scientific structure design for a smoothly moving of strip
		Reduced investment capital and longer machine service life	Centralized driving system, wear resistant treatment applied to all the rollers
		PLC controlled network communications to realized a complete automation of the entire tube mill entry line from uncoiler to accumulator	Equipped with functionalities of counting and remote monitoring, centralized control system for all the equipments of tube mill entry line
Large-Scale Specialties	Ø219-711; Wall thickness for 5.0-25.0mm; Material grade: Low-carbon steel Q235A-Q345B, X42-X80 J55, N80, etc.	Reduced resistance of strip pulling out of accumulator, no need to have a pinch roll device at the exit even for 25mm thick strip	The sophisticatedly calculated radius of curvature and spiral-up angles are designed to ensure the smooth and accurate entry of the steel strip into the tube forming mill
		No elastic deformation, no strip edge piling, save the rollers' life	Reasonably designed structure of strip storage ensures no jam, no rubbing during the whole process from strip entering through to exiting the accumulator
		Reduced noise of strip filling in, reduced dust	Equipped with measures of anti-noise and dust removal
		Great diversify of mechanical structure, drive system, and layout	Centralized or decentralized drive, straight line, L-, or U-shaped layout for customers to choose from
		Suitable for high strength steel of up to 2,400mm thick, 22mm wide, and 610Mpa yield strength	Sophisticated design because of in-depth knowledge and experiences accumulated from hundreds of sets of large-scale accumulators manufactured in the past over 30 years
		PLC controlled network communications to realized a complete automation of the entire tube mill entry line from uncoiler to accumulator	Equipped with functionalities of counting and remote monitoring, centralized control system for all the equipments of tube mill entry line

Turning Table Type



Roller Type



Large Scale





Technical Data Sheet - Horizontal Spiral Accumulator

Model No.	Coil Width (mm)	Thickness (mm)	Fill-in Speed (m/min)	Storage (m)	Structure
WLHT32	40 - 120	0.6 - 1.6	Max. 300	400 - 1200	Turning Table Type
WLHT50	60 - 200	0.8 - 3.5	Max. 300	400 - 1200	Turning Table Type
WLHT76	100 - 260	1.0 - 4.0	Max. 300	400 - 1000	Turning Table Type or Roller Type with centralized drive
WLHT89	110 - 280	1.5 - 4.0	Max. 160	400 - 900	Roller Type with centralized drive
WLHT114	120 - 400	1.5 - 6.0	Max. 160	400 - 900	Roller Type with centralized drive
WLHT165	160 - 520	2.0 - 7.0	Max. 160	400 - 800	Roller Type with centralized drive
WLHT219	240 - 700	3.0 - 8.0	Max. 170	350 - 800	Roller Type with centralized or decentralized drive
WLHT273	320 - 900	3.0 - 10.0	Max. 120	300 - 800	Roller Type with centralized or decentralized drive
WLHT325	300 - 1,100	5.0 - 12.7	Max. 120	300 - 800	Roller Type with centralized or decentralized drive
WLHT406	600 - 1,300	6.0 - 14.0	Max. 120	300 - 800	Roller Type with centralized or decentralized drive
WLHT508	700 - 1,650	6.0 - 16.0	Max. 100	300 - 800	Roller Type with centralized or decentralized drive
WLHT630	900 - 2,000	6.0 - 20.0	Max. 100	300 - 800	Roller Type with decentralized drive

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