



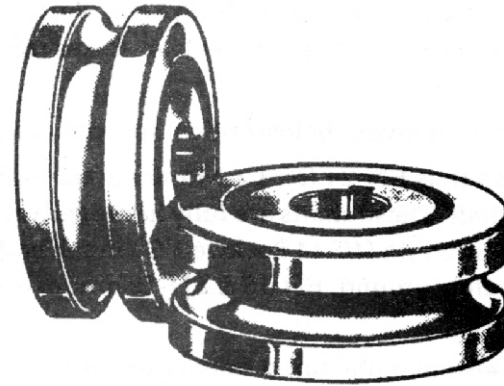
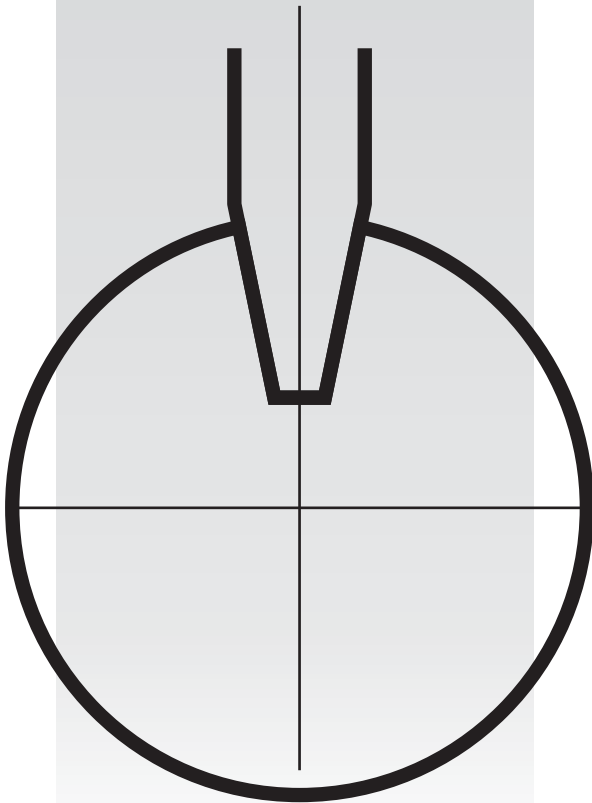
NEWS VIEWS

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Determination to Establish Excellence
Through Efficiency and Expertise

FIN

A very important
component for
Tube Making



After strip is formed into round shape, inner fibres of tube come closer and outer fibres fall apart. If such a tube is welded then it will be a very weak welding, as both surfaces of open tube will not be matching. For this reason round shape is made to pass through fin pass rolls. There are 2 to 3 stands depending upon tube size, gauge and mill design. Fin conditions the strip edges for proper welding. Its functions are -

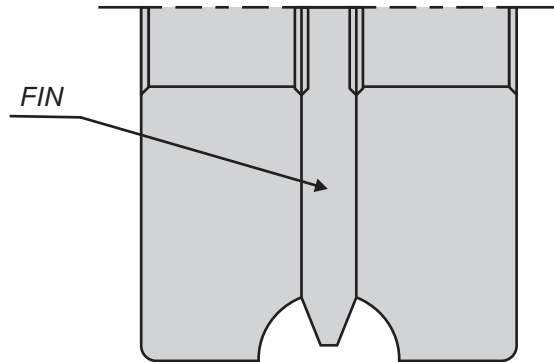
- Guiding the edges of strip
- Squaring the edges for butt welding
- Directing the tube to squeeze rolls for perfect welding



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DeeTee stands for total quality movement



General Arrgt. for Mounting Thin Fins

Fin should be wear resistant & tough. Best raw material for Fin is AISI-D2.

C = 1.50, Si = 0.40, Mn = 0.40

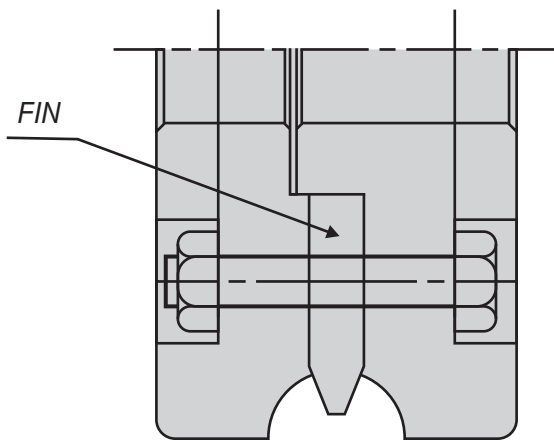
Cr = 12.0, Mo = 0.90, V = 0.70

Edges of strip strike and rub fin on both sides.

Recommended hardness is 56/58 HRC.

Next best Raw Materials for Fin are Cr-V / Ni-Cr Steel with hardness 56/58 HRC.

In India Fins are also made from AISI-D3 & SAE-52100 having hardness 56/58 HRC.



General Arrgt. for Mounting Thick Fins

Recommended tolerances on Fin are -

Outer diameter	=	± 0.1 mm
I.D.	=	G-7
Keyway Width	=	+ .1 / + .4
Keyway Depth	=	+ .2 / + .5
Keyway corner radius	=	2.0 R
Thickness	=	± 0.02 mm
Bevel	=	± 30'
Bevel Diameter	=	± 0.5 mm
P.C.D. on holes	=	± 1.0 mm

Note : Please ensure all sharp edges to be removed.