

# Horizontal Spiral Strip Accumulators

Robust Design    Smooth Operation  
Low Maintenance    Maximum Strip Storage  
Operator-friendly    Adjusts to Mill Speed



# Horizontal Spiral Strip Accumulators

When you're ready to take your mill to the next level, and eliminate downtime between coils, T&H Lemont is ready to build an accumulator that will suit your needs. From our smallest models that support the lightest gauges at speeds up to 600 feet per minute, to our heavier-duty designs that handle thicknesses up to a half inch and process strip at 150 feet per minute, T&H Lemont has a tried-and-true design for you.

Simplicity and reliability are critical at the mill's starting gate. T&H Lemont puts these needs at the forefront of every horizontal strip accumulator it designs and builds.

A simple, reliable design, coupled with a state-of-the-art programmable controller, is the ideal combination of technologies for precise feed timing and smooth strip processing. And it has a second combination of features to support smooth operations: Storage capacity and independent fill-and-empty rates. Maximum strip storage and the accumulator's independent filling and emptying speeds are the elements that help ensure the operator has enough time to load the next coil and join the two coil ends.

Model	OD	Wall Thickness	Line Speed (FPM)
280/3.2	0.50 – 3.50	0.03 – 0.13	600
280/4	0.50 – 3.50	0.04 – 0.16	400
350/4	0.75 – 4.25	0.04 – 0.16	500
400/5	1.00 – 5.00	0.04 – 0.20	450
600/7	1.50 – 7.50	0.06 – 0.28	400
700/9.5	3.00 – 8.63	0.08 – 0.38	300
850/10	3.50 – 10.75	0.10 – 0.40	300
1100/16	4.50 – 12.75	0.12 – 0.63	250
1600/16	6.00 – 16.00	0.12 – 0.63	200
2000/16	8.63 – 24.00	0.19 – 0.63	150
2000/19	8.63 – 24.00	0.19 – 0.75	150

All dimensions are in inches except where noted.

## Features and Benefits

- The storage portion of the accumulator consists of an outer frame assembly, which is driven, and an inner frame assembly, which is stationary. The inner basket comprises a series of horizontal and vertical idler rollers. Hardened transition bars are provided to transfer the strip from the outer frame to the inner frame.
- Two sets of heavy-duty roller-type twist stands change the strip orientation by 90 degrees as the strip enters and exits the accumulator.
- Vertically mounted pinch rolls are located in a separate housing between the entry supports and the accumulator. An AC motor drives the pinch rolls via a gear reducer. Hydraulically actuated levers apply pinch pressure.
- Eliminates coil changeover downtime.
- Improves yield for continuous operations such as seam annealing.



**T&H LEMONT**  
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