



VISHAY
PRECISION
GROUP



Market Solutions

Billet Weighing System

Allegany

A Brand of VPG Process Weighing



Nobel
Elektronik



www.weighingsolutions.com

Billet Weighing Produces Significant Savings

- Delivering exact billet weights improves melt shop yield by 0.5%
- Reduced tailings improve rolling mill yield by 0.5%
- Achieve weighing accuracy of ± 1 kilogram per every 1000 kilograms

Visit <http://www.weighingsolutions.com>, use the online billet weighing system calculator, and see exactly how much you can save.

System Payback

With over 25 systems in operation worldwide, documented return-on-investment (ROI) statistics prove that savings from reductions in shorts and scrap will pay for an installed system in less than a year. Manufacturers that installed billet weighing systems in 1987 are still reaping the benefits today.

Typical caster torches cut all billets to a given length. Cutting to length, however, results in large variances in actual billet weight. Rolling mills roll by weight rather than length. Overweight billets leave rolling mill customers

with extra “scrap” steel, which has to be returned and remelted. Cutting by weight, rather than length, resolves the scrap/remelt problem. Rugged construction and an easily customized operating system ensure that billet weighing systems will work for any caster in any environment.

Cutting Billets by Weight Negates all Caster Variables

Many factors contribute to cross-sectional density variations as billets are produced, especially as the “heats per mold” ratio increases. Factors include:

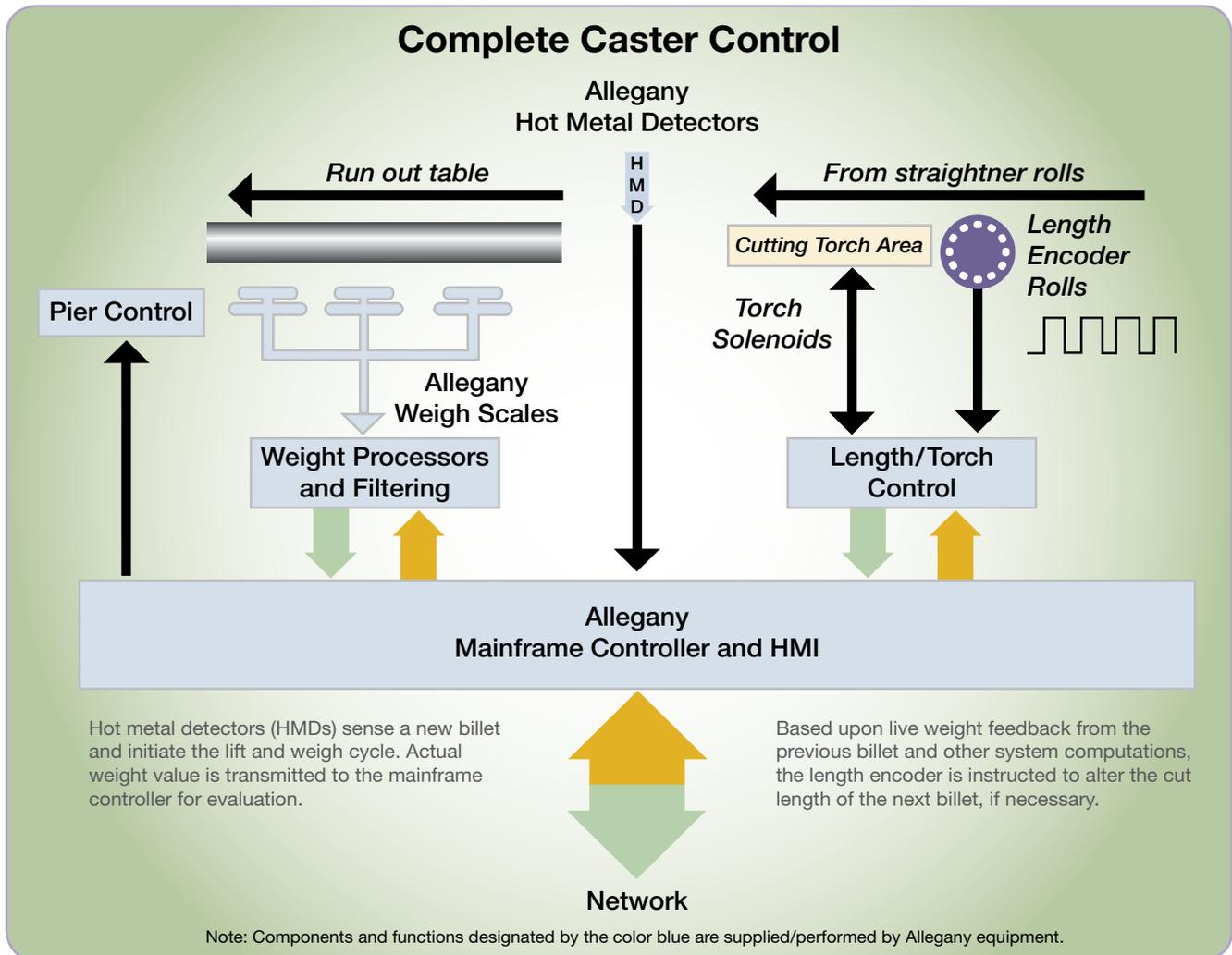
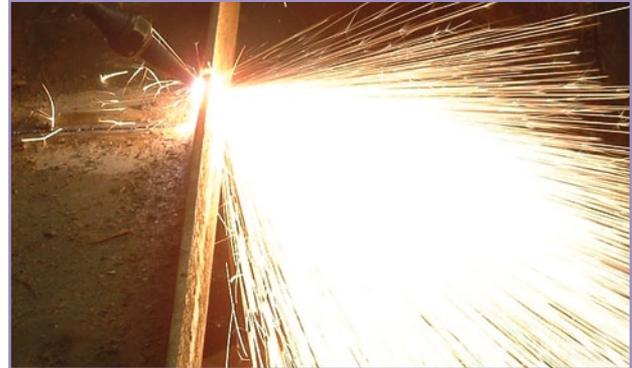
- Mold abrasion
- Metal temperature
- Ferrostatic pressure
- Caster speed
- Spray cooling water volume and temperature
- Inconsistent torch “home” position
- Proximity and temperature of other billets on the strand



Adaptive Feedback Activates the Cutting Torch

An adaptive filtering algorithm computes and dictates the cut length for each successive billet. Torches or shears are activated based upon analysis of the following criteria:

- The billet previously weighed
- An historical evaluation of strand densities
- Trend analysis software
- Input for the length measurement encoders
- Maximum “prime cuts” per heat



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The Americas

United States, Canada

Vishay Precision Group – Weighing Systems
P.O. Box 1484 • Cumberland, Maryland 21502
Ph: +1-301-722-5900 • Fax: +301-722-7346
E-mail: obw.usa@Vishaypg.com

Asia

Taiwan, R.O.C.

Vishay Precision Group – Weighing Systems*
8F-1, 171, Section 2, Datong Road • Sijhih City, Taipei 22183
Ph: +886-2-8692-6888 • Fax: +886-2-8692-6818
E-mail: pw.roc@vishaypg.com
*Asia except China

P.R. China

Vishay Precision Group – Weighing Systems
A8220, Shanghai Jia Hua Business Center
No. 808 Hong Qiao Road • Shanghai 200030
Ph: +86-21-6448-6090, Ext. 6098 • Fax: +86-21-6448-6070
E-mail: pw.prc@vishaypg.com

Israel

Vishay Precision Group – Weighing Systems
2 HaOfan Street • Holon 58814
Ph: +972-3-557-0888 • Fax: +972-3-556-8116
E-mail: pw.il@vishaypg.com

Europe

United Kingdom

Vishay Precision Group – Nobel Weighing Systems
Airedale House • Canal Road • Bradford BD2 1AG
Ph: +44-1274-782229 • Fax: +44-1274-782230
E-mail: pw.uk@vishaypg.com

Germany

Vishay Precision Group – Nobel Weighing Systems
Tatschenweg 1 • 74078 Heilbronn
Ph: +49-7131-39099-0 • Fax: +49-7131-39099-229
E-mail: pw.de@vishaypg.com

France

Vishay Precision Group – Nobel Weighing Systems
16 Rue Francis Vovelle • 28000 Chartres
Ph: +33-2-37-33-31-25 • Fax: +33-2-37-33-31-29
E-mail: pw.fr@vishaypg.com

Sweden

Vishay Precision Group – Nobel Weighing Systems
P.O. Box 423 • SE-691 27 Karlskoga
Ph: +46-586-63000 • Fax: +46-586-63099
E-mail: pw.se@vishaypg.com

Norway

Vishay Precision Group – Nobel Weighing Systems
Brobekkveien 80 • 0582 Oslo
Ph: +47-22-88-40-90 • Fax: +47-22-88-40-99
E-mail: pw.no@vishaypg.com