



**AMERICAN CONSOLIDATED INDUSTRIES, INC.**

Monarch Decatur								
Gauge Range	Light Line	Heavy Line	Number of Mults					
	0.025 - 0.105	0.070 - 0.250	Gauge	40 KSI	50 KSI	60 KSI	70 KSI	80 KSI
Entry Width	62"	62.5"	Light	& Under	**KSI Yield Strength**			
Exit Width	60"	60"	<b>0.015</b>	25	25			
Exit Width Min @ 20"	8"	12"	<b>0.024</b>	25	25			
Exit Width Min @ 24"	8"	12"	<b>0.030</b>	25	25			
I.D. Entry	20 - 24"	20 - 24"	<b>0.040</b>	25	25			
O.D. Entry	72"	76"	<b>0.060</b>	19	19			
I.D. Exit	20 - 24"	20 - 24"	<b>0.090</b>	8	8			
O.D. Exit	72"	76"	<b>0.125</b>	See Plant Manager				
			<b>Heavy</b>					
Coil Weight Entry	60,000 Lbs.	80,000 Lbs.	<b>0.054</b>	See Plant Manager				
Coil Weight Exit	60,000 Lbs.	80,000 Lbs.	<b>0.067</b>					
			<b>0.075</b>	19	19	19	19	15
Banding Line Max	23"	32"	<b>0.090</b>	17	17	17	17	14
Height & Weight	10,000 Lbs.	15,000 Lbs.	<b>0.105</b>	16	16	16	16	13
			<b>0.120</b>	15	15	15	15	12
Edge Trim Per Side	0.250" min.	0.375" min.	<b>0.135</b>	14	14	14	14	11
			<b>0.150</b>	13	13	13	13	11
Slit Width Tolerance	Gauge up to 0.175 (+/-0.005)		<b>0.179</b>	13	13	13	13	11
	Gauge 0.175+ (+/-0.010)		<b>0.209</b>	12	12	12	12	10
			<b>0.224</b>	11	11	11	11	9
			<b>0.250</b>	10	10	10	10	8
			<b>0.312</b>	9	9	9	9	7
			<b>0.375</b>	8	8	8	8	7

Monarch Steel Company, Inc. Monarch Steel of Alabama, Inc. Parthenon Tube, Inc.

Premium Metals, Inc. Southeast Tube, Inc.

4650 Johnston Parkway

Cleveland, Ohio 44128

(216) 587-8000

www.acihq.com

## Monarch Decatur

		Multi-Blanking Capabilities		CTL Capabilities										
		Finished Goods	Master Coil	HG Leveler Yield Strength			LG Leveler Yield Strength							
Materials	CR, Coated, & HRP&O		Max Thick	Min Thick	Max Thick	Min Thick	Max Thick	Min Thick						
Gauge Range	0.020 - 0.135"	0.020 - 0.135"	<b>45000</b> Y	0.530	0.197	<b>45000</b> Y	0.200	0.048						
Widths	12 - 60"	13 - 60"	<b>50000</b> Y	0.530	0.187	<b>50000</b> Y	0.200	0.048						
Max Weight	20,000 Lbs.	55,000 Lbs.	<b>55000</b> Y	0.530	0.178	<b>55000</b> Y	0.200	0.048						
Length	12 - 144"		<b>60000</b> Y	0.530	0.171	<b>60000</b> Y	0.200	0.049						
I.D.'s		20 - 24"	<b>65000</b> Y	0.530	0.164	<b>65000</b> Y	0.190	0.051						
Min O.D.		30"	<b>70000</b> Y	0.530	0.158	<b>70000</b> Y	0.163	0.052						
Max O.D.		72"	<b>75000</b> Y	0.46	0.153	<b>75000</b> Y	0.142	0.054						
Min I.D.		20"	<b>80000</b> Y	0.405	0.148	<b>80000</b> Y	0.125	0.055						
Max I.D.		24"				<b>0.048 to 0.070 is 20' Max Length</b>								
Features		Line Speed 50-300 ft./min							<b>0.070 to 0.530 is 60' Max Length</b>					
		55,000 Lbs. Uncoiler										<b>All Gauges' Min Length is 12"</b>		
		1 Looping Pit: 15' Deep												
		Width Tolerance +/- 0.005												
Length Tolerance +/- 0.064														
						HG Leveler Laser Quality			LG Leveler Laser Quality					
Max Thick						Min Thick	Max Thick	Min Thick	Max Thick	Min Thick				
<b>25000</b> Y				0.530	0.197	<b>25000</b> Y	0.200	0.048						
<b>25000</b> Y	0.530	0.187	<b>25000</b> Y	0.200	0.048									
<b>27500</b> Y	0.530	178	<b>27500</b> Y	0.200	0.048									
<b>30000</b> Y	0.530	0.171	<b>30000</b> Y	0.200	0.049									
<b>32500</b> Y	0.530	0.164	<b>32500</b> Y	0.190	0.051									
<b>35000</b> Y	0.530	0.158	<b>35000</b> Y	0.163	0.052									
<b>37500</b> Y	0.460	0.153	<b>37500</b> Y	0.142	0.054									
<b>40000</b> Y	0.405	0.148	<b>40000</b> Y	0.125										

Monarch Steel Company, Inc.    Monarch Steel of Alabama, Inc.    Parthenon Tube, Inc.

Premium Metals, Inc.    Southeast Tube, Inc.

4650 Johnston Parkway

Cleveland, Ohio 44128

(216) 587-8000

[www.acihq.com](http://www.acihq.com)