



AMERICAN CONSOLIDATED INDUSTRIES, INC.

Monarch Cleveland

		Light Line	Heavy Line	Number of Mults					
Gauge Range	0.025 - 0.105	0.070 - 0.250	Gauge	40 KSI & Under	50 KSI	60 KSI	70 KSI	80 KSI	
Entry Width	62"	62.5"	Light	**KSI Yield Strength**					
Exit Width	60"	60"	0.025	17	16	16	15	14	
			0.036	16	16	15	14	13	
I.D. Entry	20 - 30"	16 - 32"	0.048	15	12	11	9	8	
O.D. Entry	72"	72"	0.060	15	11	10	8	7	
I.D. Exit	20 - 24"	20 - 24"	0.075	15	10	8	7	6	
O.D. Exit	72"	72"	0.090	See Plant Manager					
			0.105	See Plant Manager					
			Heavy						
Coil Weight Entry	44,000 Lbs.	54,000 Lbs.	0.070	18	18	18	18	18	
Coil Weight Exit	41,000 Lbs.	54,000 Lbs.	0.090	18	18	18	18	17	
			0.104	18	18	18	17	15	
Banding Line Max	18"		0.120	18	18	16	14	12	
Height & Weight	10,000 Lbs.		0.135	16	14	12	11	9	
			0.150	13	11	10	9	7	
Pad Stands	Will NOT remove oil from material		0.164	11	10	8	7	6	
Minimum Slit Width	No slit width under 1.50" due to tooling and equipment capabilities		0.179	10	8	7	6	5	
Edge Trim	0.187/ ea. side	0.250/ ea. side	0.194	9	7	6	5	4	
Slit Width Tolerance	Narrow mults up to 23" (0.010")		0.210	7	6	5	4	3	
	Wide mults 24" and over (+0.0625)		0.244	5	5	4	3	2	
			0.250	5	4	3	2	1	

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

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Linear Footage
0.035 & Lighter not to exceed 6500 linear ft. on 24" I.D. and 7500 linear ft. on a 20" Telescoping and/or oscillation is likely to occur when slitting two mults
Tooling
Our tooling allows for 18 mults on each machine
Overarm
Overarm mult widths plus 0.125 disc separators and clearance not to exceed 60"

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