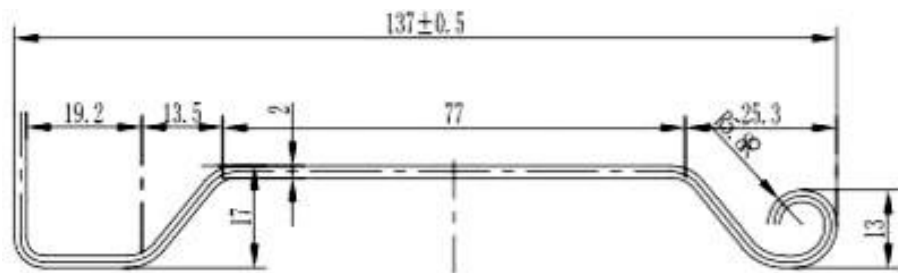


137x13mm DOOR SHUTTER ROLL FORMING MACHINE



Theoretical slitter width: 188mm

Main Parameters:

1. Raw material: G.I strip in coil.
2. Thickness of raw material: 1.5 – 2.0mm
3. Width of the profile: 137mm
4. Height of profile: 13mm
5. Width of incoming material: as actual width.
6. The shape and size of profile: as per drawings

The complete roll forming line comprised by the following unit:

A. Decoiler

1. Apply manual expansion device
2. Max. outer diameter: 1400mm
3. Inner diameter of coil: 400-450mm
4. Max. coil width: 300mm
5. Loading capacity: 1.5 tons

B. Main Machine

1. Roll forming stations: 12 Nos
2. Material of rollers: GCr15 steel
3. Hardness of roller after heat treatment: 55°~57°
4. The appearance of the rollers has been polished.
5. Diameter of roller's shaft: 50mm, material: 45# steel.
6. Wall thickness: 25mm
7. Main bearing: 60309
8. Motion transmitting system: gear and chain
9. Thickness of gear: 45 mm
10. Main motor power 5.5kw, 350 reducer.
11. Forming speed: 10m/min
12. With water cooling device.

C. Cut Off Device

1. Apply hydraulic automatically cut-off device.
2. Motor power: 4KW
3. Equip with one set of cut-off mould (with waste cut-off mode)
4. The oil stand with wind cooling device

D. Run Out Table

1. Apply angle steel welding.
2. Length: 6m
3. With the end switch to set the length of profile.

E. Control System

1. Adopted normal control system by knob.
2. Electrical components adopted SILIN or joint venture products.
3. Length control by defending plate mode.
4. Stop to cut.
5. Power supply: 380V, 50HZ.

A schematic diagram of the roll forming line layout. It shows a horizontal sequence of components: a Decoiler on the left, followed by the Roll Forming Host Machine (a long unit with multiple stations), a Hydraulic Pump Stand, a Hydraulic Cut-Off, a Fixed-Length Switching mechanism, and a Stacker on the right. Labels with leader lines identify each component.

Technical drawing of a mechanical part with dimensions. The drawing shows a profile with a total width of 142 ± 0.5 . Key dimensions include a height of 29 on the left, a central width of 20, a distance of 69 from the center to the right edge, and a right-side width of 22. Radii are specified as R4, R3, and R3.5. A hole with a diameter of $\phi 11$ is located on the right side, with a distance of 11.5 from the centerline to the hole's center.