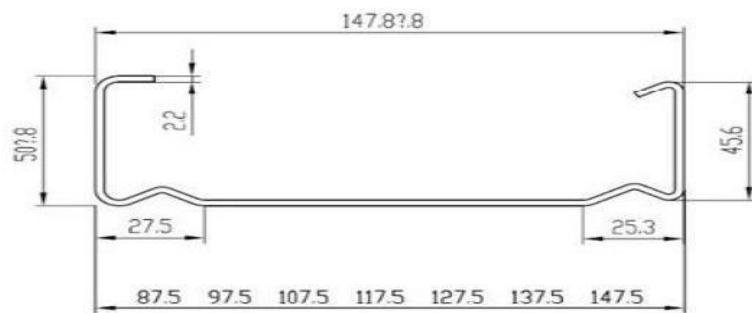


SHELF BEAM ROLL FORMING MACHINE



PROFILEDRAWING:

SCHEME TWO

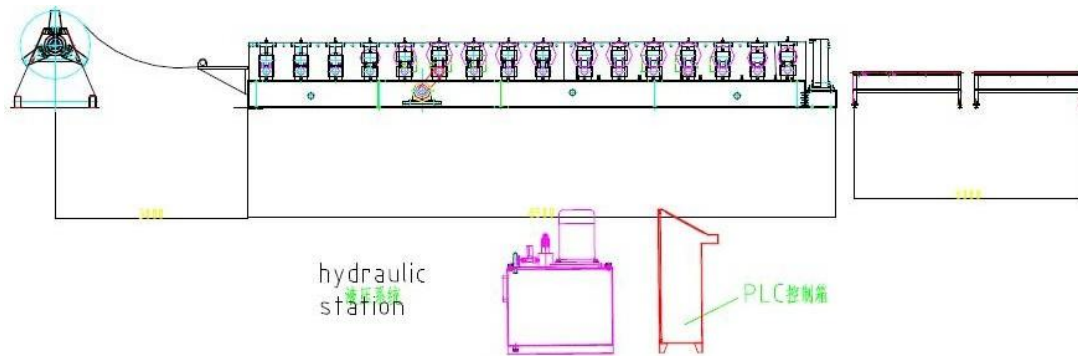


ROLLFORMING DRAWING



PRESSING DRAWINGS

MACHINE ARRANGEMENT:



MACHINE PICTURE

Roll Forming Machine

Area of production line: length 8.5m x width 1.5m height 1.7m



A. Seamer Machine



Seamer machine control by the button plate, control the machine forward, reverse, stop and the speed.

TECHNICAL PLAN FOR ROLL FORMING MACHINE

• TECHNICAL PARAMETERS

Material Spec	: Steel plate
Thickness	: 1.8mm to 2.3mm (Change 1mm-2.3mm)
Coil stress	: 230-300Mpa
Forming speed	: 16m/min
Roller stands	: 16 stands
Type of cutting	: Roll-formed and length-set cutting
Main motor	Forming machine : 18.5kw for the main body, hydraulic cutter 5.5kw. Seamer machine : 7.5kw for drive depend on final design

• MATERIAL OF MAIN EQUIPMENT

Roller Material	: Gcr15 steel being quenched treatment, with digital-controlled procession, which ensures the rollers hardness to be HR60 and durable.
Level Rollers	: High grade No. 45 with grinding process, total 5 sets
Active shaft material	: High grade No. 45 carbon wrought steel, which can improve the integrated mechanic feature of the shaft, Diameter 65mm.
Electric Elements	: PLC control panel, transducer imported from SIEMENS OF GERMANY. Other elements from famous suppliers in China
Cutter blade	: Cr12 mould steel with quenched treatment.

COMPONENT AND FUNCTION

1. 4 Ton decoiler



Manual Decoiler

Max width 350mm
 Max capacity 4000kg
 Inner dia 350-520mm
 Outer dia 1500mm

2) Leveling parts

- A) Working roller** : Total 4 rollers type leveling
- B) Feature of structure** : after the quenching and tempering, chrome-plating processing, the rigidity, surface roughness of the roller etc. are all enhance greatly. It is composed by the clamping roller and the leveling roller, the clamping roller may the independent control, the leveler has one pair of horizontal guide roller and two pairs of vertical guider roller and easy to adjust by hand wheel.



- 3) Roll Forming system** : The main frame of machine is welded separately. The rollers are surface-chrome plated after being machined by the exact machine tool.

Hydraulic Station : Supplies the initial power to the cutter through a closed oil tank. It is off without cutting, which can save the power.

PLC Control Panel : The electric controlling system of this machine consists of five parts.

- Operating system
- Screen
- PLC
- Transducer and
- Strong electricity parts

The controlling system of this machine is important from **SIEMENS** of Germany. The system uses modularized structure and has convenient, reasonable, canonical wiring arrangement. The independent operating console facilitates the mutual dialogue between the operator and the machine. The operation is easy and steady and can choose operation by manual or automatically.

Cutting parts : The length and blocks can be set by the buyer through the control panel, when reach the set length, the machine will cutting the panel automatically.

Supporter Table : To support the finished panels. The quantity we supply is 2 pieces with length 6000mm; it can support panels with 10000mm at normal condition.

EQUIPMENT PART LIST

NO	PART NAME	TYPE OF EQUIPMENT	QUANTITY	POWER OF MOTOR	REMARK
1	Decoiler	Manual , Max weigh 4 ton	1 set		
2	Leveler	5 number	1 set		
3	Main forming machine	Main motor 18.5kw , 16 stands roll forming	1 set		Seamer machine with another 7.5kw power motor
4	Hydraulic cutting machine		1 set	5.5kw	
5	Collection table	12 Meter	2 sets		
6	Electric control system	PLC Control	1 set		

HYDRAULIC DECOILER

3 Ton passive de-coiler with brake device
 Outside diameter of coil : 550mm
 Inside diameter of the coil : 450mm

