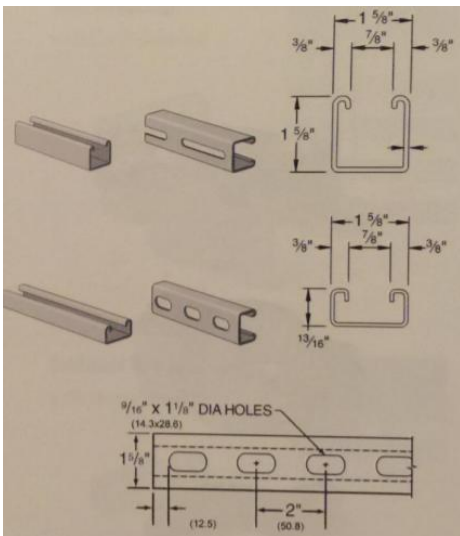


U PROFILE ROLL FORMING MACHINE 41X41/41X21 (2.5-3.0) (AUTOMATICALLY HYDRAULIC CUTTING, AUTOMATICALLY PUNCHING HOLE)

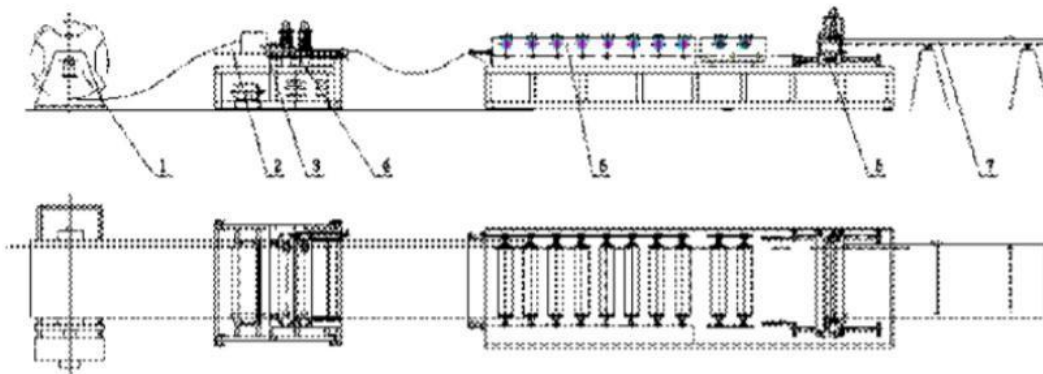
A) PROFILE SIZE : 41 x 41 & 41 x 21

1	Material	: Galvanized steel, Q235, cold-rolled steel, stainless steel
2	Material Thickness	: 2.5-3.0mm 1.0-1.4 (stainless steel)
3	You can choose one machine make two profile 41x41 and 41x21.	
4	Also you can choose one machine make one profile: 41x41 or 41x21.	
5	One machine one profile means you need have two machines.	

B) U PROFILE DRAWING



C) WORKING CHART



Working flow: Uncoiler—leveling material—Servo feeding material—hydraulic punching hole—Roll forming machine—Hydraulic cutting—Run out table

D) MAIN PARAMETER

1	Material	: Cold-rolled steel, hot-rolled steel, galvanized steel
2	Material thickness	: 2.5-3.0mm.
3	C Profile size	: 41x41, 41x21mm
4	Products angle tolerance	: $\leq \pm 1^\circ$
5	Products straightness tolerance	: $< 1-1.5\text{mm}$ (products length 3000mm)
6	Roller number:	: 14-16 stations
7	Working speed	: Max. 13m/min (including punching and cutting) (PLC control)
8	Total	: 16.7kw (main machine 5.5kw, hydraulic punching 7.5, hydraulic cutting 3.7kw)
9	Hydraulic station	: Two sets
10	Die	: Two sets (one for punching hole, one for cutting)

E) MACHINE COMPONENT

1	Motor Uncoiler one set
2	Leading and leveling material Hydraulic punching device one set
3	Main roll forming machine one set
4	Hydraulic cutting device one set
5	Run out table one set

E-1 MOTOR UNCOILER

1	Put the coil on decoiler and send material for forming machine.
2	Structure: single cantilever structure (without motor)
3	Max. loading :3T
4	Uncoiler expansion range: $\varnothing 450\text{mm}$ — $\varnothing 530\text{mm}$ (or $\varnothing 500\text{mm}$ — $\varnothing 600\text{mm}$, please remark when place order.)
5	Max. Coil outer diameter: $\varnothing 1250$

E-2 LEADING AND LEVELING MATERIAL , HYDRAULIC PUNCHING DEVICE

1)	Leading and leveling material device
	Leveling device one set, front pinching roller two pieces, back pinching roller two pieces; Max. width:200mm
	Leading material roller processing way: hardness-chrome-plating
	Two sides use fastening type leading material, Cr12 heat treatment—CNC processing, long time working later, without scratch.
	Servo material feeding device one set
	Servo brand: Japanese Panasonic or Yaskawa; Max. width:200mm
2)	Hydraulic Punching Device
	Hydraulic punching device : one set
	Hydraulic station : one set
	Hydraulic motor :7.5kw

E-3 MAIN ROLL FORMING MACHINE

1)	<u>Structure:</u> Whole side board structure, thickness 25mm.
	Processing way: grinding surface—milling four sides—electric spark eroding—surface blacking.
	Roller number : 14-16 stations
	Working speed : Max. 13m/min (PLC and Frequency adjust speed)
	Roller material : Cr12
	Roller processing way: CNC machines processing, vacuum heat treatment, hardness HRC58-62°(roller surface like mirror, acid-resistant, alkali-resistant, corrosion resistance. Life time 3-5 times higher than ordinary roller.)
2)	<u>Roller Shaft</u>
	Material : 45# steel
	Diameter : Φ52mm
	Heat treatment : tempering
3)	<u>Surface:</u> Finish grinding
4)	<u>Frame</u>
	10# square steel welded, frame surface welded Q235A steel board (thickness 16mm); whole frame aging treatment to increase hardness and intensity, annealing treatment to eliminate internal stress. (Without this kind heat treatment, welded frame internal stress can't be eliminated, the hardness and intensity reduce, finally will affect the work price tolerance.)

5)	Motor : 5.5KW
6)	Reducer : Model 350
7)	Transmission Way: motor drives speed reducer and the chain gear drive; gear sprocket surface high frequency and hardness heat treatment.

E-4 HYDRAULIC CUTTING DEVICE

1	Cutting way : Length setting cutting
2	Hydraulic motor : 3.7kw
3	Hydraulic station : one set
4	Cutting die material : Cr12,vacuum heat treatment, hardness HRC58-62°

E-5 ELECTRICAL CONTROL SYSTEM

1	Operation way : Man machine interface, manual to automatic free replacement.
2	Man machine interface : Touch screen display, easy to operate.
3	PLC : Programmable PLC control system (MITSUBISHI or Panasonic brands),
4	Frequency transformer : INVT
	Other electrical components: OMRON