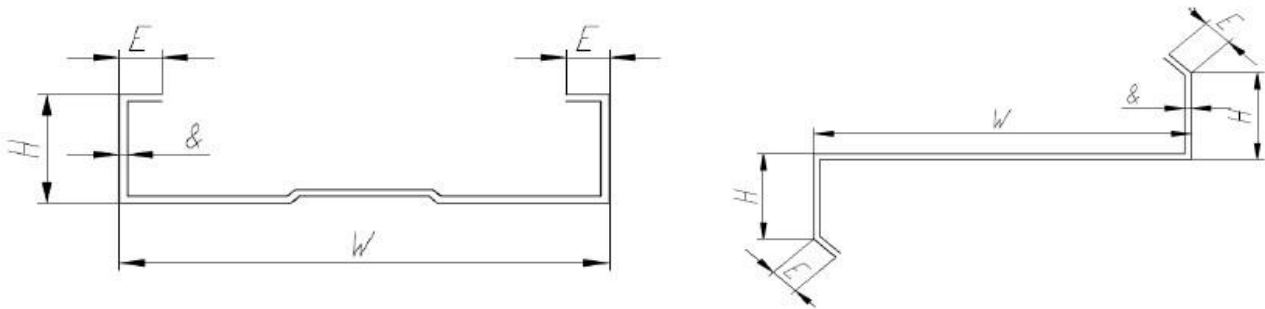


**C TO Z QUICK-CHANGE PURLIN MACHINE FOR C100-300/Z140-300 PROFILE
(POST PUNCHING & CUTTING TYPE)**



PROFILE DRAWING



E (lip)	: 10~20±0.5mm
H (height)	: 30 ~ 80±1mm for C, 50-80mm±1mm for Z
W (width)	: 100 ~ 300±2mm for C purlin and 140 ~ 300±2mm for Z purlin
Purlin length	: L±2mm

With punching holes (single hole or double holes) on WEB side of options

Purlin length	: L+5mm
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MATERIAL

Material thickness	: 1.0~3.0mm
Material Width	: 162~495mm
Applicable Material	: CRC, GI (with yield strength 350~550Mpa)

MACHINE COMPONENTS

Manual Decoiler : one set

Un-powered, manually control steel coil inner bore shrinkage and stop,

Max. feeding width : 500mm, coil ID range 470mm±30mm

Capacity : Max. 3 Ton



Cold Rolling Mill

With feeding material guide, body frame made from 500# H type steel by welding; Wall board thickness: 30mm

Rollers manufactured from GCr15 bearing steel, precision machined, hard Chrome Coated. Shafts manufactured from 45#, Main shafts Diameter = $\Phi 90$ and for other Shafter Diameter $\Phi 75$ mm, precision machined.

Motor Driving, chain spocket transmission, about 19-step to form.

Main Motor = 18.5Kw, Frequency speed control

Forming speed approx. 15m/min

Hydraulic Punching & Cutting Device : (Punching & cutting are after roll forming)

Cutter frame made from high quality 20mm steel plate by welding.

Punching and cutting are after roll forming , also with

Hydraulic Pre cutting device for easy operation.

1 set slitting die for all sizes, no need to change cutter for each purlin and specification.

Hydraulic motor : 5.5KW, Hydraulic pressure range : 16Mpa

Cutting tool material : Cr12, Heat treatment

Hole size for punching 14*25mm or customized size



PLC CONTROL SYSTEM

Interchange between C purlin and Z purlin : by manual changed, with following steps :
 a) Loosen dowel pin; b) Rotate the adjust tooling 180 degree : c) fix dowel pin. But from C100-300 or Z140-300, change size by PLC system automatically: change over by just press keys on touch screen. Control the quantity and punching, cutting length automatically.
 Combined with : PLC, Inverter, Touch Screen, Encoder etc. Cut to length tolerance $\leq \pm 2\text{mm}$
 Control voltage 24V
 PLC : FATEK brand (Taiwan)
 Inverter : Finland VOCAN / Denmark Danfoss
 Touch screen : WEINVIEW brand (Taiwan)
 Encoder : KOYO brand (Japan)
 Switch bottom, Indicate light, Power supply, Intermediate relay , AC Contactor, Thermal relay: Schneider brand (German) Air Switch : LG brand (Korea)



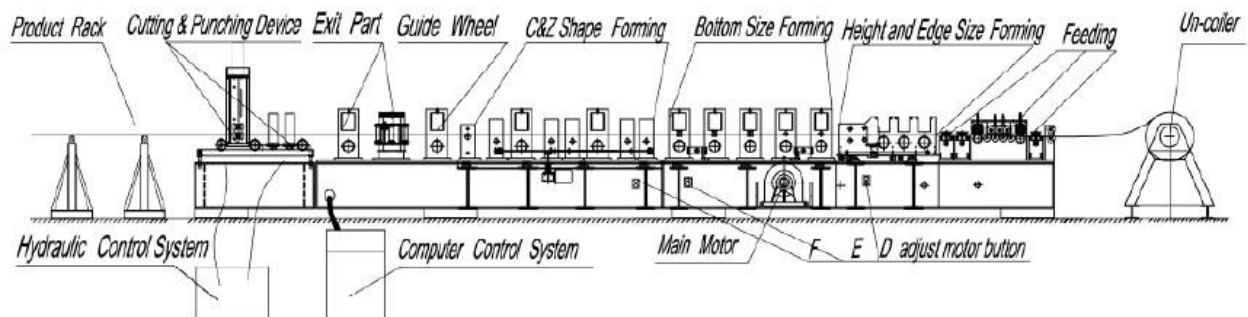
EXIT RACK UN POWERED, 2 UNITS



With heavy duty design, **the weight of the machine: about 12 tons**

OTHER TERMS: Electric Standard: 380V50Hz/3Ph, Major color of machine Painting: Grey White + Blue

FLOW CHART





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Decoiler → Feed and leveling Device → Hydraulic Pre-Cutting Device → Rolling Forming System → Hydraulic Punching & Cutting → Product Support Frame