



TSF
MACHINERIES

Technology Solution
Factories Machines TR L.L.C
شركة حلول التقنية
لتجارة معدات المصانع ذ.م.م

CNC AUTO DUCT FORMING LINE 5 MODEL: ADL-5U-1300



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MACHINE DESCRIPTION:

U SHAPE AIR DUCT PRODUCTION LINE 5 BLKMA's Duct line features with highly efficiency and automatic and also saves material. It is very suitable for mass production of square duct manufacture.

Auto-line V is consists of feeding frame, leveling, grooving roller machine, hydraulic punching and square notch equipment, mechanical hand fixed position feeding frame plat, double drive TDF flange former and double drive singe hem former, servo feeding plat and TDF hydraulic folder.

All systems are controlled by a computer. The feeding is by servo with precise location. When producing "Square" shape duct, the folding is with high precision. The maximum work speed is 16m/min. The diagonal line tolerance is $\pm 0.5\text{mm}$. HCH-V can produce 2 kinds of ducts: TDF flange and WITH DRIVE CLEAT CONECTION. It saves work space, with linear type structure, high efficiency. It can produce "square" shape duct with small section, the minimum section area of TDF duct is 200×200mm.

PERFORMANCE FEATURES

1. Honest strengthens the basis in the pursuit of customer satisfaction and constant innovation helps customers to achieve the goals.
2. During feeding mechanism with pneumatic servo manipulator helps to ensure stability and speed of the machine, and the accuracy of its locating system.
3. It only takes 20-25 seconds to make one L-shaped work piece and the efficiency will double comparing with the linear type.
4. Without moving back and forth the fixed locking machine is able to improve the efficiency.
5. All the rolling reels are made of bearing steel so that the lifetime prolongs more than 5 times.
6. Under the material-saving mode of CNC system, wastage is less than 20 mm per roll.
7. With production memory functions, the production orders can be tracked and checked.
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FUNCTIONS

It's mainly for TDF / angle steel / C-shaped flange forming with daily processing capability of 10002500 square meters. Only with inputting dimensions in duct, production line can automatically complete uncoiling, leveling, beading, punching, shearing, locking, forming TDF /angle steel / Cshaped flange and folding



TECHNICAL PARAMETERS

MODEL	: ADL-5U-1300
Brand Name	: BLKMA
Sheeting Thickness	: 0.5-1.2
Maximum width	: 1300mm
Max working speed	: 15m/min
Coiler Max weight	: 7T
Power	: 30KW
Weight	: 13T
Dimensions (L x W x H)	: 12000 * 5500 * 1500mm
Brand New	: China

BASIC CONFIGURATION

ITEM	QUANTITY
Electric coil cradle (four material trays 5-7T each roll)	2 set
Carrier aircraft	1 set
Host (line 2 host)	1 set
Mechanical arm clutching ,locating and transferring	1 set
Displacement type locking machine	1 set
Duplex TED flange forming machine	1 set
Duplex angel steel flange forming machine	1 set
Servo feeding platform	1 set
Hydraulic folding machine	1 set
CNC computer control system and production software	1 set

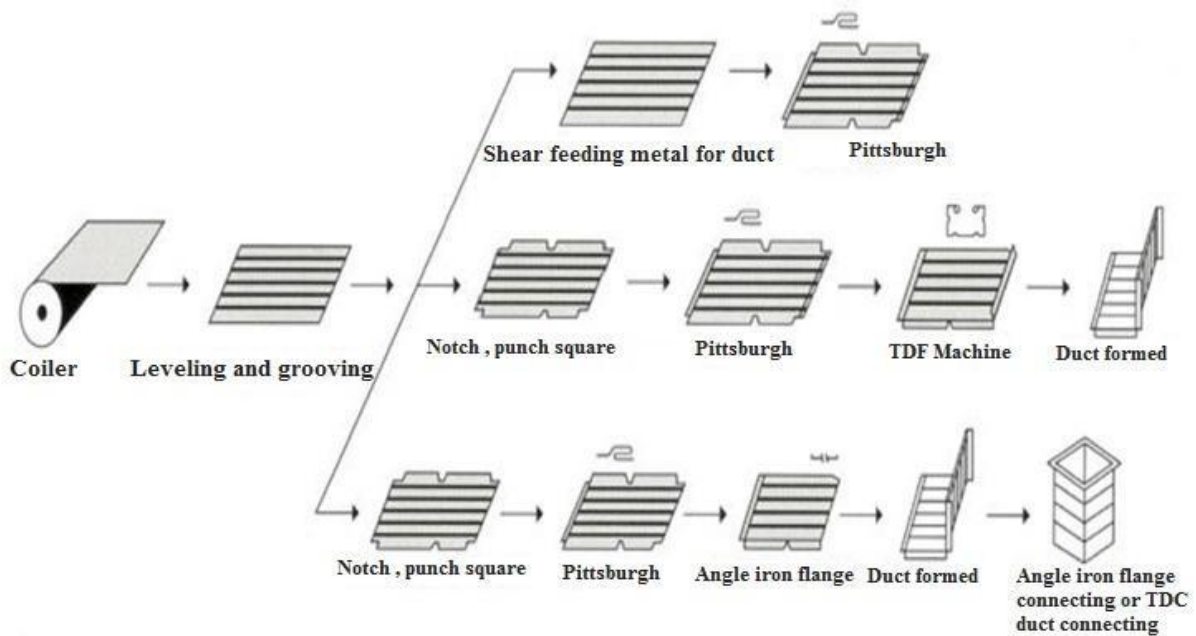
MAIN IMPORT CONFIGURATION

ITEM	BRAND	QUANTITY
FESTO Cylinder	FESTO	1 set
Hydraulic system	Huade	1 set



Encoder	Omron	1 set
CNC System	Mitsubishi	1 set
Electrical system	Schneider	1 set
Linear guide ways	Hiwin	1 set
Servo motor	Teco	1 set
Frequency converter	Taiwan Quartet	1 set

WORKING SCHEMATIC DIAGRAM





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WORKING FLOW

