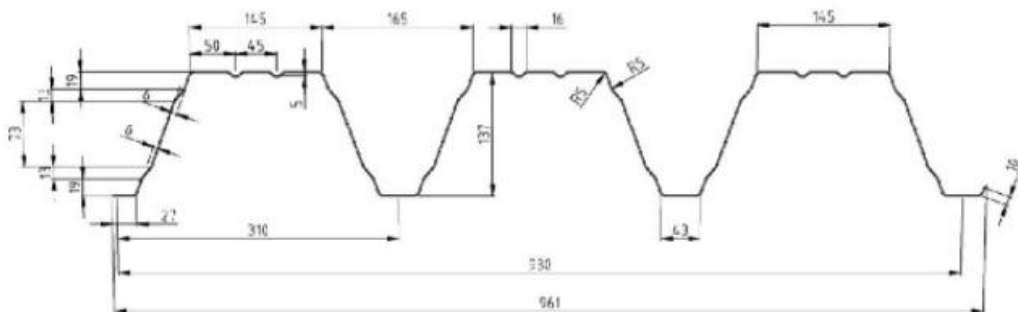
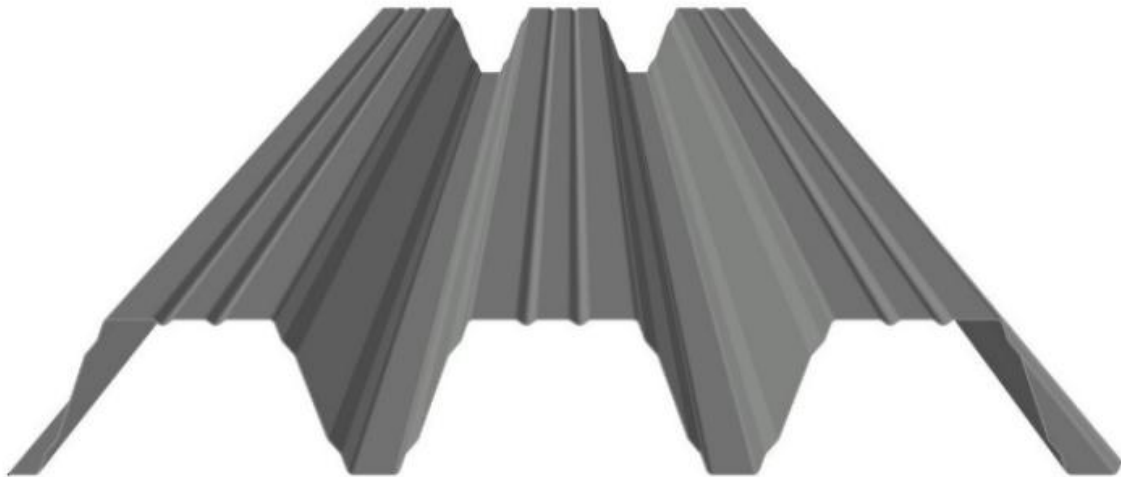
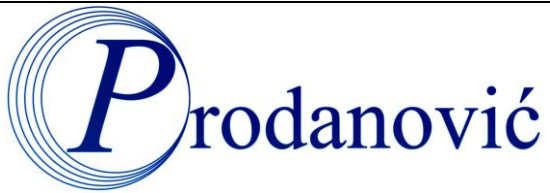


Profile



Effect width: $930 \pm 5\text{mm}$

Galvanized Coil, **Yield strength: 350MPa**



Machine Components

15Ton*1250mm Hydraulic un-coiler (with car)

Hydraulic system to expand coil inner hole, **Pump motor: 7.5KW**

Taper wedge expand type

Double level expanding palms with two coil bore variations of 480-530 for Palm 1 and 580-630 for Palm 2



Load Capacity: Max. 15 Tons; Coil Width Max. 1250mm

Coil Outer-diameter Max. 1500mm

Retarding Motor to turn the coil, **Motor: 7.5KW**

Slippage guiding equipped on the base frame. There is a hydraulic oil cylinder on the base to drive the un-coiler to make correction when the shaft-line is off-position with the forming machine, to make sure the generatrix of the coil consistent with the forming machine.



Maintain arm on the top, to avoid coil become loose when stop to be packed.

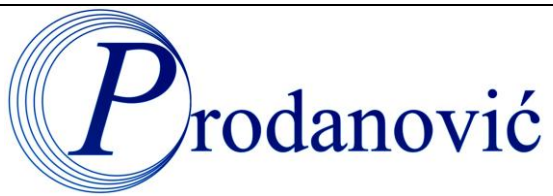
The arm to be driven by pneumatic cylinder, manual control

The air supplier should be provide by the user

Up/Down stroke of Coil Car: Max. 450mm

Forward/backward stroke of Coil Car: Max. 2000mm

Self-contained electric controller, out of control system of the complete line



Automatic feeding device(to design with uncoiler)

Automatic feeding device components:

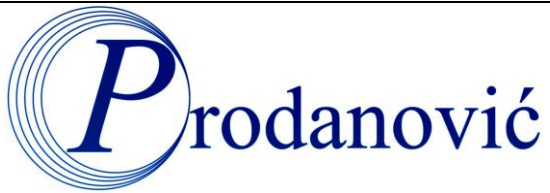
Motor drive the coil turning, motor power 5.5kw

Pressing coil device for assist the coil feed in, share the same hydraulic station with uncoiler

Coil receiving platform, for receiving the coil

Below diagram for reference:





Entry Bench Un-powered

HYDRAULIC PRE-SHEARING DEVICE, MANUAL CONTROL

Hydraulic Pre-shearing device, manual control

Share in the same hydraulic group with post cutting device

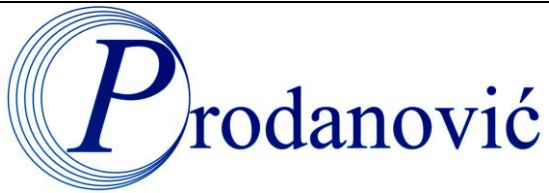
Only for cutting the first piece and the end piece of the sheet

One extra stage with rubber shaft required in front of the pre-shearing device
for assistance to feed in the sheet

Cold roll mills

Feeding section with guide

Gear/Sprocket driving; **38-step to form**



Wall-plate-frame-design

Rollers manufactured from 45# steel, CNC lathes, hard Chrome Coated

Shafts Diameter=φ95mm, Precision Machined

Main motor =18.5KW x 3, close loop motor

Forming speed: Approx. 20m/min

Protection Mesh Cover (full mesh type) Above Roll-former To Avoid Hands go

Inside, slip type



Hydraulic Cutting Device

Stop to cut, Post cut, Slug Breaker;

Cutting tool material : Cr12MOV, Heat treatment;

Hydraulic group, Pump motor =11KW

One set of cutting blade(including upper and lower blade)for spare



PLC Control System

Control the quantity & cutting length automatically;

Combined with: PLC, Touch Screen(Siemens), Inverter (Schneider)

Encoder (Omron)

Cut-to-length control tolerance $\leq \pm 2\text{mm}$

Control voltage 24V



12 meter Single level pneumatic stacker for decking profile

Powered run out table

Pile up the sheet piece by piece

Single level stacker

Action controlled by Pneumatic system

The air supply provided by the user

Support arm action in horizontal direction, driven by pneumatic system



