

<http://www.superdamachine.com>  
[export@superdamachine.com](mailto:export@superdamachine.com)

## Roll former manufacturer YX

### 一、Roll forming machine technical parameters

No.	ITEM	PARAMETER	REMARK
1	MATERIAL	Type	Cold-rolled strip steel, galvanized sheet
		T. (mm)	0.8-1.5mm
		Yield Strength (Mpa)	Q235
2	Forming speed (m/min)	2-8m	Including hole
3	Forming main power (KW)	7.5KW	FYR
4	Hydraulic power (KW)	18.5KW	FYR
5	Bending machine (KW)	3 KW	
5	Total Power	29 KW	FYR
6	Voltage	AC380V, 50Hz, 3P	

### 二、process

A: 4T Simple Uncoiler → Straightening-servo feeder/hydraulic punching breach → Guide device → roll forming machine → hydraulic punch hole → hydraulic shear device (including knife) → finished product rack

B: Box bending





#### 四, Machines List

##### 一) 4T simple uncoiler

1、 Type: Manual

2、 Parameter

1) Passive discharge

2) Coil weight: < 4T

3) Coil inner D. :  $\phi 460\text{mm}$  -  $\phi 520\text{mm}$

4) Max. Width. 1000mm



##### 二) Straightening machine

2.1 Number of working roller:7pcs. Up 3pcs/Down 4pcs, Dia.50mm (Max. width 200mm

2.2 Leveling roll material: leveling roll quenched, chrome plated handle its rigidity, surface roughness and other mechanical properties greatly improved; its feed by a nip roller and leveling roller composition, pinch roller can be individually adjusted, leveling roller of the overall structure, before and after the establishment of two adjustment points, can form a certain angle, easy to improve the quality of leveling. Leveler infeed end with a pair of flat guide rollers and two pairs of vertical guide rollers, guide rollers movable vertical movement and at the same time.

Photo just for reference



三) , Servo Feeder

3.1 Max. feeding width:200mm

3.2 Feeding thickness: 0.4-1.6mm

3.3 Motor ,0.85 K W(Yaskawa)

Photo just for reference



#### 四), Hydraulic hole punching system

4.1 Function: Hydraulic punch hole (Mould 2 set)

4.2 Structure: set the length, automatic length measurement, automatic positioning reaches the set distance stop action , hydraulic cylinder driven punching die, stamping automatic shutdown.

4.3 Hydraulic system working pressure: 16MPa

4.4 Hydraulic station: 15KW ( Hydraulic punch hole/shear use same station)

#### 五) Guide device

#### 六) Main Forming machines

6.1 Forming Rack: 12 Pair, and add Rub-roll, To make sure the surface profile no scratches.

6.2 Side Panel: T.18mm ,A3 steel Heavy duty 。

6.3 Rolling speeding: 5-8 m/min。

6.4 Roller material: GCr15, overall quenching, hardness HRC56-62 °C.

6.5 Motor power: 5.5KW。

6.6 Main Roller :  $\varnothing$ 65mm, 45#。

6.7 Equipment base: 30 # H type using welded steel plate.

6.8 Transmission: chain drive.

6.9 Security: across the board with emergency stop buttons, easy to handle emergencies, to ensure that equipment and operator safety. And other gear in the chain and the staff could easily lead to injury transmission section covered with protective cover, to ensure the safety of workers.

Photo roll former just for reference



七)、 Follow shear

7.1 Cut style:Hydraulic cut (No blanking), Machine non-stop can cut product.

7.2 Knife material: Cr12, quenching hardness of up to HRC56-58 degrees.

八)、 Flat collect rack

九)、 Necking machine

9.1 Necking Style: hydraulic compression mouth.

9.2 Necking mould material: Cr12, quenching hardness of up to HRC56-58 degrees.

9.3 Hydraulic system working pressure: 16MPa

9.4 Hydraulic power: 5.5KW

十)、electrical control system

The entire line imported PLC control, LCD touch screen, man-machine interface. People interact with the PLC. Operator setting the program to run automatically (programmable control) and control process monitoring, production line operator control and modify the control parameters, and real-time monitoring the equipment status & parameters and fault indication. Workpiece length digital setting, adjustable length can be adjustable as well. Real-time monitoring of equipment operating status and fault indication.

Operation manual / automatic two styles. With manual and automatic switching function: In the manual mode, can be stand-alone operation, easy maintenance; In automatic mode, carry out full production run, in order to start; across the board with emergency stop buttons, easy to handle emergencies, to ensure that equipment and operating personnel Safety.

\*\* The main components of the brand:

**PLC control system: Siemens**

**Inverter: Siemens**

Encoder: Omron

**Touch screen: Siemens**

Roll former components are Schneider brand devices.

Devices:

No.	Machine name	QTY	REMARK
1	2T×200 Simple uncoiler	1	No power
2	Straightening machine	1	
3	Servo Feeder	1	
4	Hydraulic hole punch	1	With 2 mould
5	Guide device	1	
6	Froming machine	1	
7	Follow Shear	1	
8	Collect rack	1	
9	Necking machine	1	With 1 mould
10	Control system	1	

Remark: Please offer the real sample before making machine.