http://www.superdamachine.com export@superdamachine.com

Roll former manufacturer YX

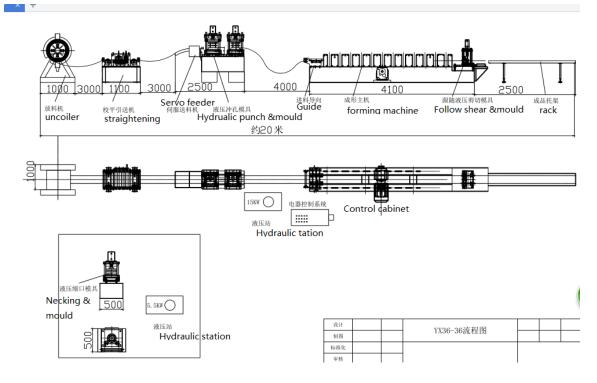
- Roll forming machine technical parameters

No.	ITEM		PARAMETER	REMARK
1	MATERIAL	Туре	Cold-rolled strip steel,	
			galvanized sheet	
		T. (mm)	0.8-1.5mm	
		Yield		
		Strength	Q235	
		(Mpa)		
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

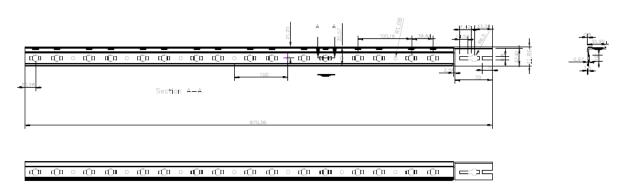
A: 4T Simple Uncoiler → Straightening-servo feeder/hydraulic punching breach → Guide device → roll forming machine →hydraulic punch hole → hydraulic shear device (including knife) → finished product rack

B: Box bending



三、Plate drawing as below:

Metal Rack Drawing:





四, Machines List

- -) 4T simple uncoiler
 - 1, Type: Manual
 - 2, Parameter
 - 1) Passive discharge
 - 2) Coil weight: < 4T
 - 3)Coil inner D. : ϕ 460mm- ϕ 520mm
 - 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 thickess: 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 $^{\circ}$ C.
- 6.5 Motor power: 5.5KW.
- 6.6 Main Roller : ⊄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), Manchine 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 Stype: 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

+), 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

Devices:

No.	Machine name	QTY	REMARK
1	2T×200 Simple uncoiler	1	No power
2	Straigtening 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.