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## YX41-41 Solar bracket Roll Forming machine

### 一、Technical parameters

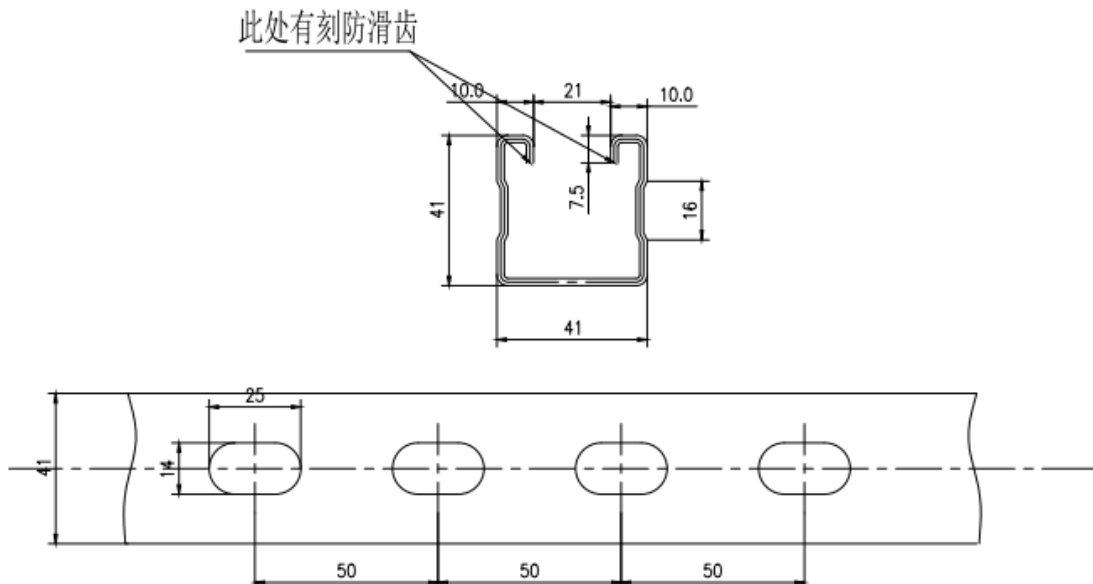
No.	ITEM	PARAMETER	REMARK
1	MATERIAL	Type	Cold-rolled strip steel, galvanized sheet
		T. (mm)	1.6-2.0mm
		Yield Strength	G300MPa
2	Forming product Width	41mm	
3	Forming speed (m/min)	10-18m	
4	Forming main power (KW)	18.5 KW	FYR
5	Hydraulic power (KW)	7.5 KW	FYR
7	Voltage	AC380V, 50Hz, 3P	

### 二、process

(A) Simple Uncoiler → Hydraulic punch → Guide device → roll forming machine → shear device (including knife) → finished product rack

### 三、Plate drawing as below:

#### Section part Drawing:



#### 四, Machines List

##### 一) Uncoiler straightener 2 in 1

1、 Type: Manual Expansion

2、 Parameter

1) Passive discharge

2) Coil weight: < 2T

3)Coil inner D. :  $\phi$  450mm-  $\phi$  530mm

4) Max. Width. **200mm**

5) Thickness .1. 0-3. 0mm



Photo just for reference

2), Servo Feeder for feeding to roller system



## 二) Hydraulic hole punching system

3.1 Function: Hydraulic punch

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

3.3 Hydraulic system working pressure: 16MPa

3.4 Hydraulic station: 7.5KW ( Hydraulic punch hole/shear use same station)

## 三) Guide device

## 四) Main Forming machines

6.1 Forming Roller: 20 stations, 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:10-18 **m/min**。
- 6.4 Roller material: GCr15, overall quenching, hardness HRC50-55 °C.
- 6.5 Motor power: 7.5KW。
- 6.6 Main Roller :  $\varnothing$ 80mm, 45 #。
- 6.7 Equipment base: 45 # 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.



##### 五) 、 Follow shear

- 6.1 Follow shear (Cut style): Hydraulic cut (blanking).

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



六)、 Flat collect rack 3m

七)、 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: **DELTA**

Inverter: Shilin

Encoder: Omron

Touch screen: WEINVIEW

Some components are Schneider brand devices.



#### Devices:

No.	Machine name	QTY	REMARK
1	Uncoiler straightener	1	
2	Hydraulic machine	1	With mould

3	Servo Feeder	1	
4	Guide device	1	
5	Forming machine	1	
6	Follow Shear	1	Including knife
7	Collect rack	1	
8	Control system	1	

### Brand

No.	Name	manufacturer
1	Motor & Reducer	Domestic brands
2	The main key bearing	Domestic brands
3	Inverter	Shilin
4	PLC Systems	Delta
5	Low-voltage electrical	Schneider
6	Encoder	Omron
7	touch screen	Weinview
8	Hydraulic system	Domestic brands