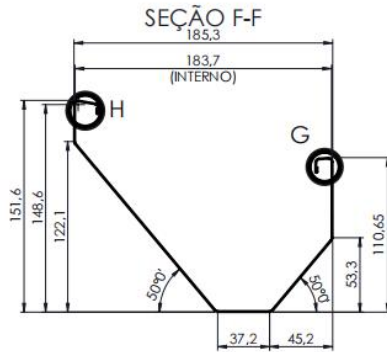
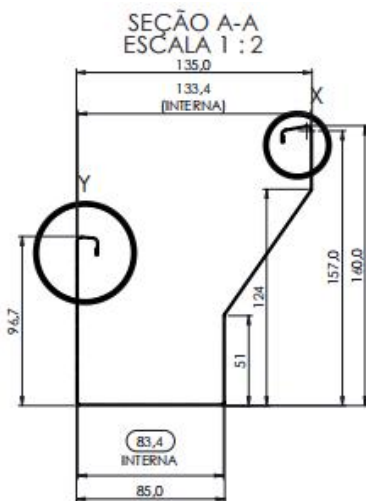


FEED TROUGH ROLL FORMING MACHINE

◎ PROFILE 1



PROFILE 2



◎ Material

Applicable Material: Galvanized Sheet Coil & Cold Rolled Steel

Material Thickness: 0.8mm; Feeding Width: 400mm;

Material Yield Strength: 235-345Mpa;

Effective Width Tolerance: ±1mm;

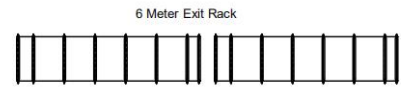
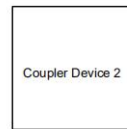
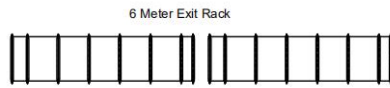
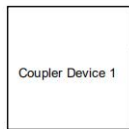
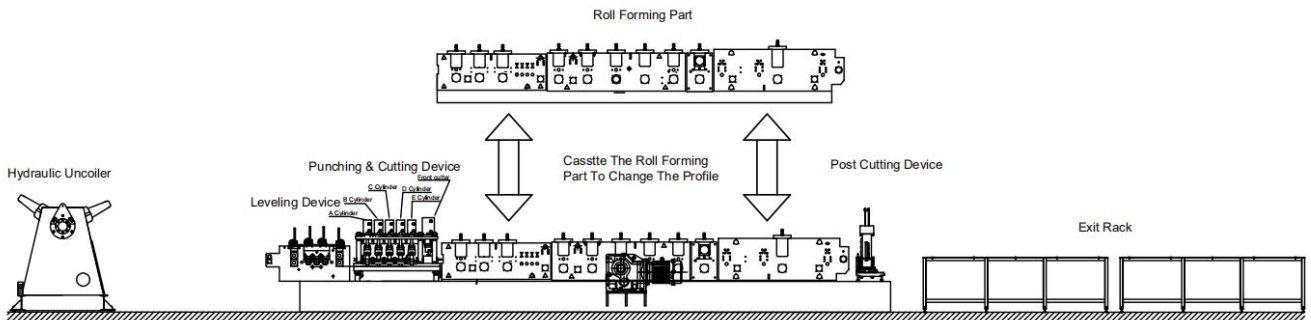
The Wave Height Tolerance: ±1mm;

The Length Of Tolerance: ±1mm(6m);

FEED TROUGH ROLL FORMING MACHINE

©Work Flow

Hydraulic Uncoiler → Feeding Guide Device → Leveling Device → Hydraulic Punching Device → Hydraulic Pre-Cutting Device → Main Forming System (Casstte Change Profiles) → Hydraulic Post Cutting Device → Exit Rack



<p style="text-align: center;">Quick Change Table type</p>		<p>The roller set can be easily moved out and put the new roller set in. This enable production the different product profiles in the same machine without performing re-alignment.</p>
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FEED TROUGH ROLL FORMING MACHINE

©The Shared Device

- | | |
|---------------------------------|-------------------------|
| 1.Hydraulic Uncoiler | 6.Body Frame H450 Steel |
| 2.Leveling Device | 7.Exit Rack |
| 3.Hydraulic Pre-Punching Device | 8.Motor |
| 4.Hydraulic Pre-Cutter Device | 9.PLC Control System |
| 5.Post Hydraulic Cutter Device | 10.Hydraulic Station |

©Then Change Device

- 1.Roll Forming Part
- 2.Post Cutting Mould

©5T-500 Hydraulic Uncoiler:One Set

Hydraulic Control Steel Coil Inner Bore Shrinkage And Stop

Max. Feeding Width:600mm

Coil ID Range:508+/-30mm

Max Capacity:5 T



FEED TROUGH ROLL FORMING MACHINE

©Leveling Device:**One Set**

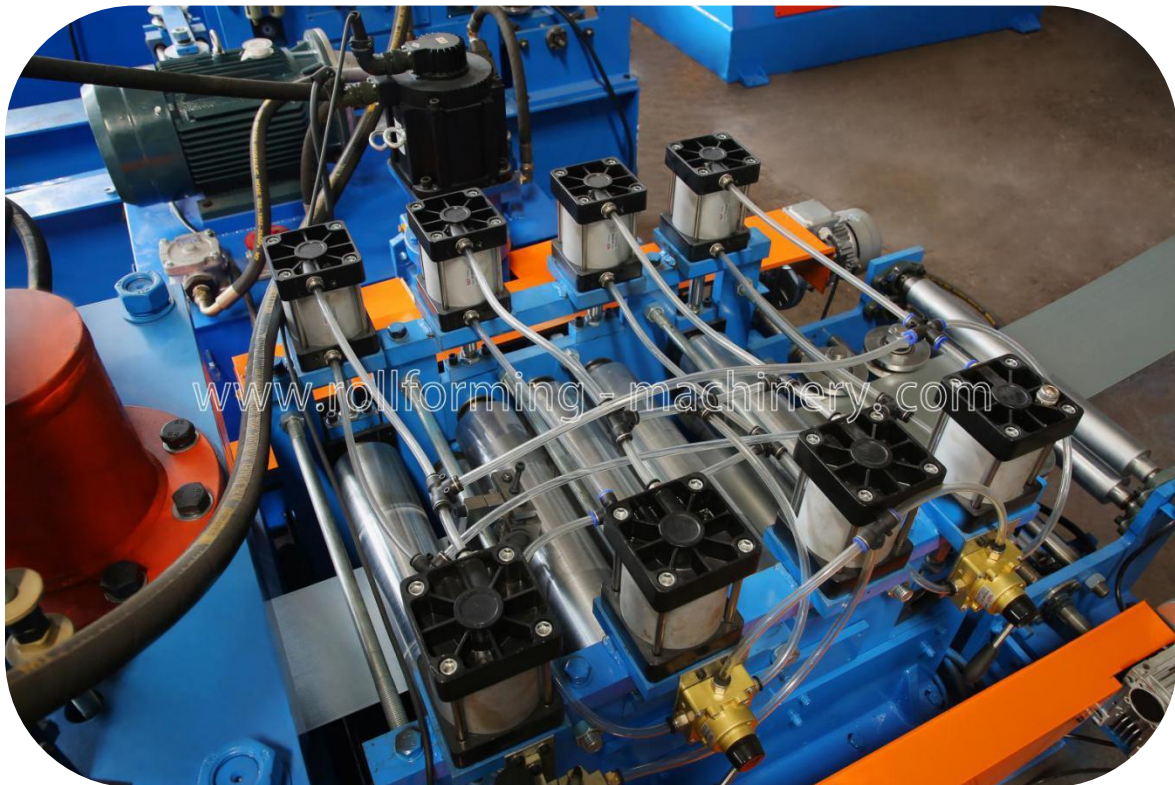
With Feeding Material Guide

Side Wall Thickness: **Q235 t18mm**

Up **Three** Down **Four** Totally **Seven** Shafts Leveling Device

Body Frame Made From **H450** Type Steel By Welding

Shafts Make From **GCr15 Steel**,Diameter= ϕ **95mm**,High Frequency Heat Treatment



©Hydraulic Pre Punching & Cutting Device:**One Set**

Pre-Punching & Cutting And Post-Cutting,Use The Same Hydraulic System

Hydraulic Motor:**11KW**,Hydraulic Pressure Range:**0-16Mpa**

Punching & Cutting Tool Material:**Cr12MoV(=D2 Steel)**,Heat Treatment To **HRC58-62**

FEED TROUGH ROLL FORMING MACHINE

5 Hydraulic Cylinders Punching System For Punching Both On Web And Flange



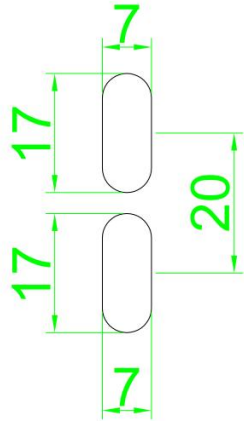
The Punching On The Web And Flange Will Be Done Through PLC Programme Automatic;



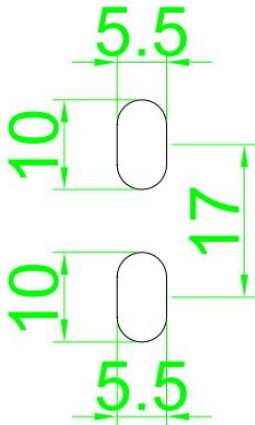
FEED TROUGH ROLL FORMING MACHINE

Punching Holes Show:

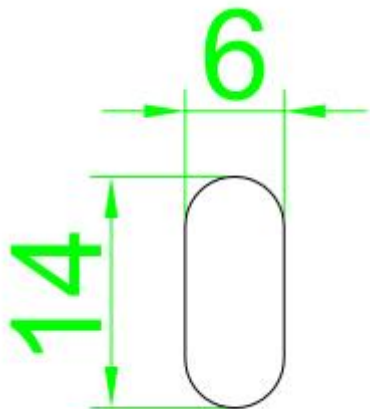
A Cylinder: To Punching The 7mm*17mm Oval Holes(One Punching Mould);



B Cylinder: Punching The 5.5*10mm(One Punching Mould);

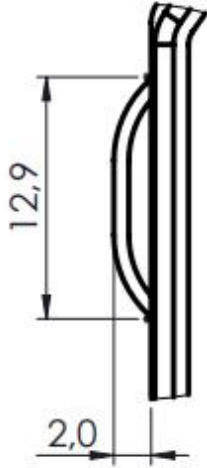


C Cylinder: Punching The 6mm*14mm(One Punching Mould);



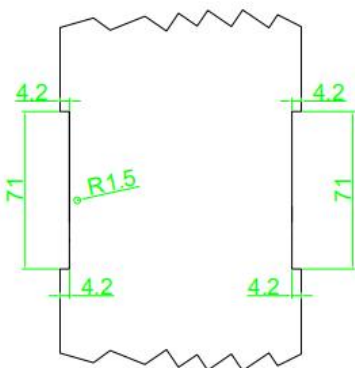
FEED TROUGH ROLL FORMING MACHINE

D Cylinder: Punching The Dimple Hole (One Punching Mould);

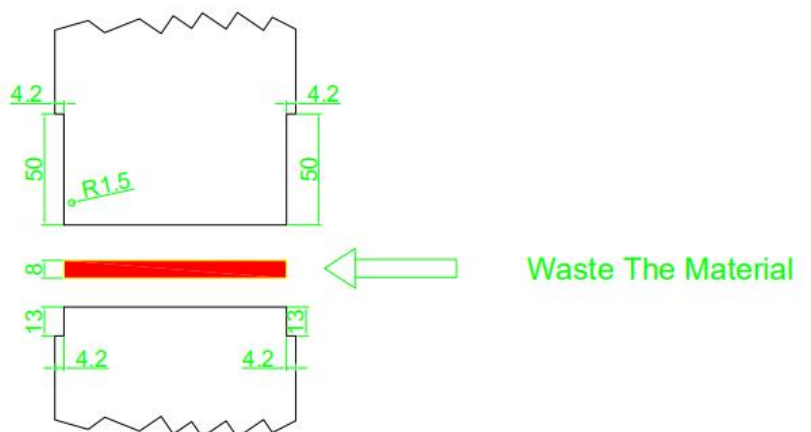


E Cylinder: Use The E Cylinder To Punching Left And Right Notch, Then Use The Post Cutting Device To Cutting The 8mm Width Material.

E Cylinder



Post Citting Later



FEED TROUGH ROLL FORMING MACHINE

Hydraulic Pre-Cutting Device:One Set

Profile 1 & Profile 2 All Use 400mm Feeding Width,But When Change The Roll forming Part need Use Hydraulic Pre-cutting Device To Cut The Plate,So I add This Cutting For you.



Hydraulic Station With Air Cooling Device:One Set



FEED TROUGH ROLL FORMING MACHINE

©Roll Forming Part: **One Set**

Body Frame Made From **H450** Type Steel By Welding;

Side Wall Thickness: **Q235 t18mm**;



Rollers Make From **45# Steel**, Precision Work, Hard Chrome Plating;



FEED TROUGH ROLL FORMING MACHINE

Shafts Diameter= ϕ 75, Make From 45#, Quenching And Tempering;



Gear/Sprocket Driving, 18-Steps To Form Profile 1 & 18 Steps To Form Profile 2;

Servo Motor=11KW , Frequency Speed Control;

Speed Reducer Motor: **K Series**;

Sliding Block: **130*140mm**; All The Screw Bolts With **Grade 8.8**;

Real Forming Speed: **22m/min**;

© Post Hydraulic Cutting Device

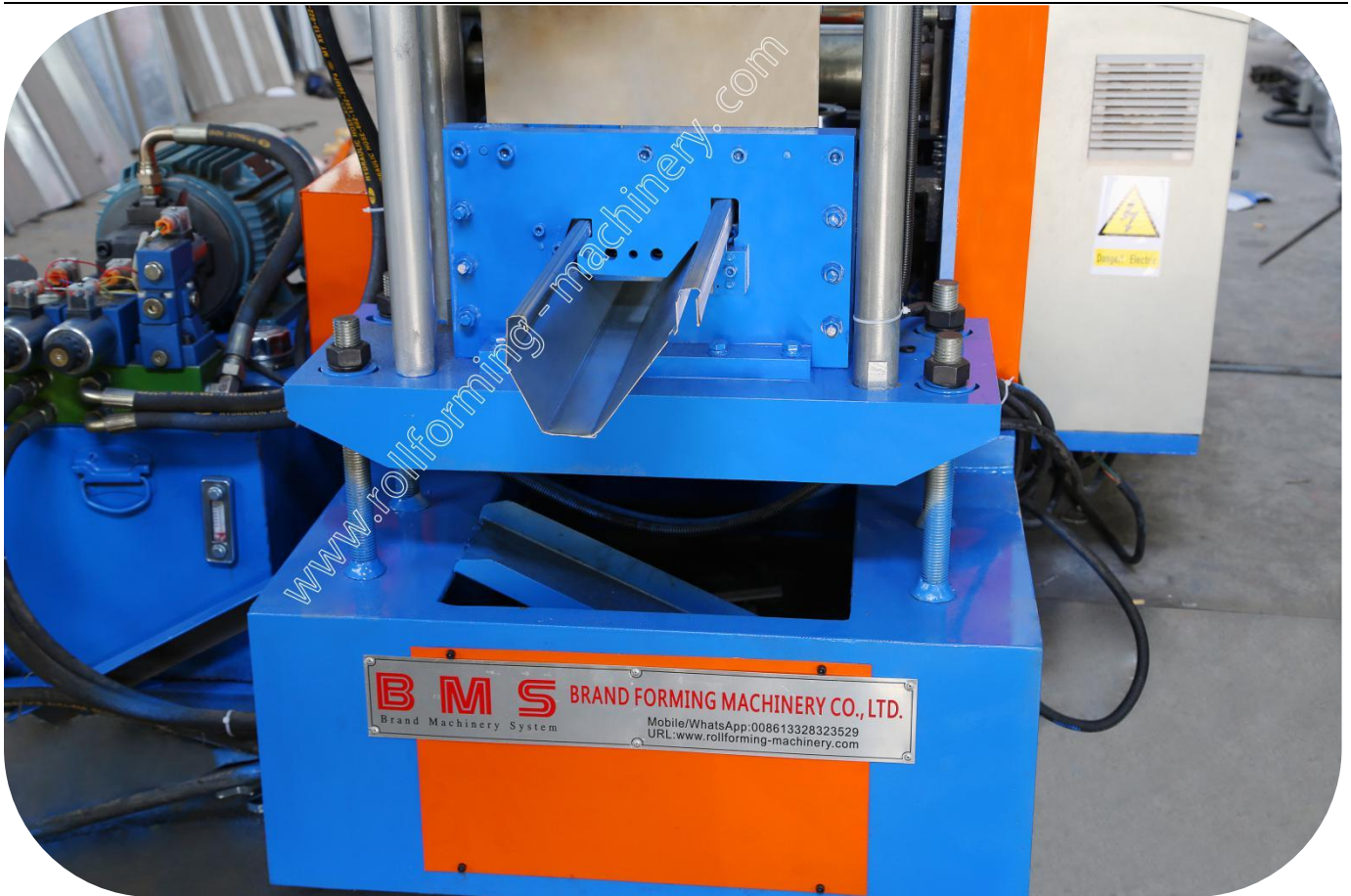
Post To Cut, Stop To Cutting, **Three Pieces** Type Of Cutting Blade Design;

Hydraulic Motor: **11KW**; Cutting pressure: **0-16Mpa**;

Cutting Tool Material: **Cr12MoV**(= **SKD11** With At Least One Million Times Of Cutting Life), **Heat Treatment** To HRC58-62 Degree;

The Cutting Power Is Provided By The Main Engine Hydraulic Station;

FEED TROUGH ROLL FORMING MACHINE



©PLC Control System: **One Set**

Control The Quantity And Cutting Length Automatically Input The Production Data(ProductionBatch,pcs,Length,etc.)On The Touch Screen,It Can Finish The Production Automatically.Combined With: PLC, Inverter, Touch Screen, Encoder Switch Bottom, Indicate Light, Power Supply, Intermediate Relay, AC Contactor;

PLC:**Schneider(France Brand);**

Inverter:**Schneider(France Brand);**

7-Inch Color Touch Screen:**Schneider(France Brand);**

Encoder:**Omron (Japan Brand);**

Thermal Relay:**Schneider(France Brand);**

FEED TROUGH ROLL FORMING MACHINE

Air Switch:LG-LS(Korea Brand);

Cut-to-Length Tolerance $\leq \pm 1$ mm;

Control Voltage 24V;

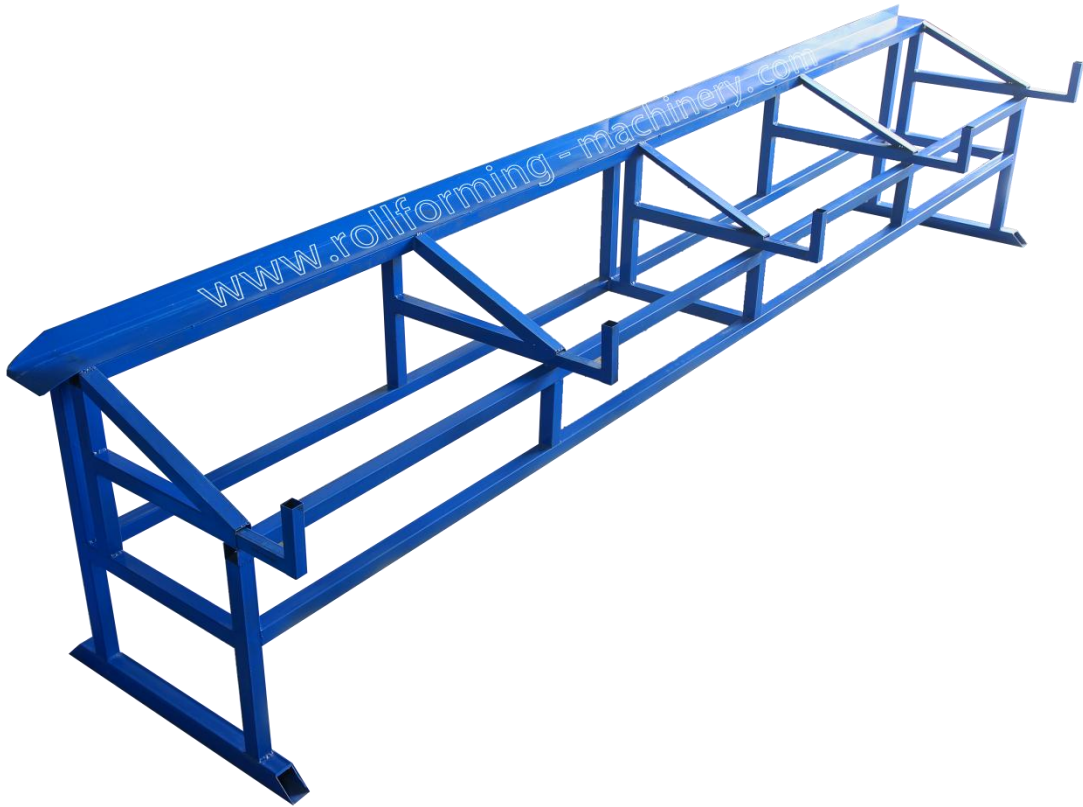


Chinese & English Language



FEED TROUGH ROLL FORMING MACHINE

© 4 Meter Exit Rack: **One Set**

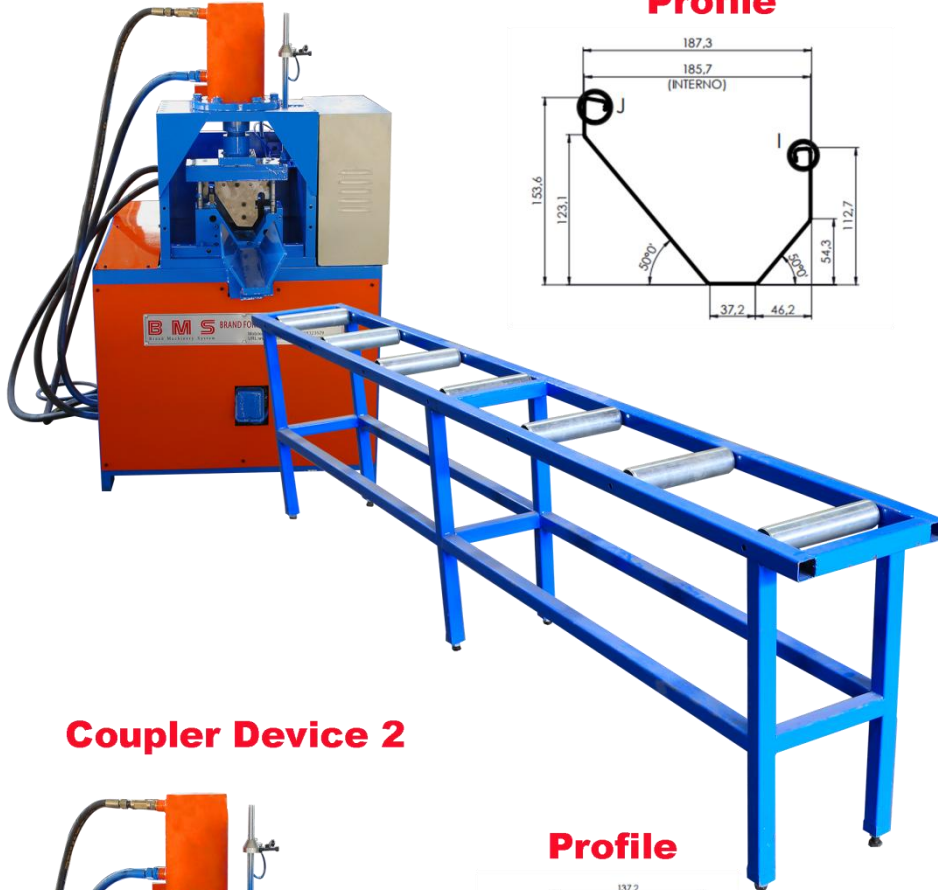


© Coupler Hydraulic Punching Device: **Two Sets**

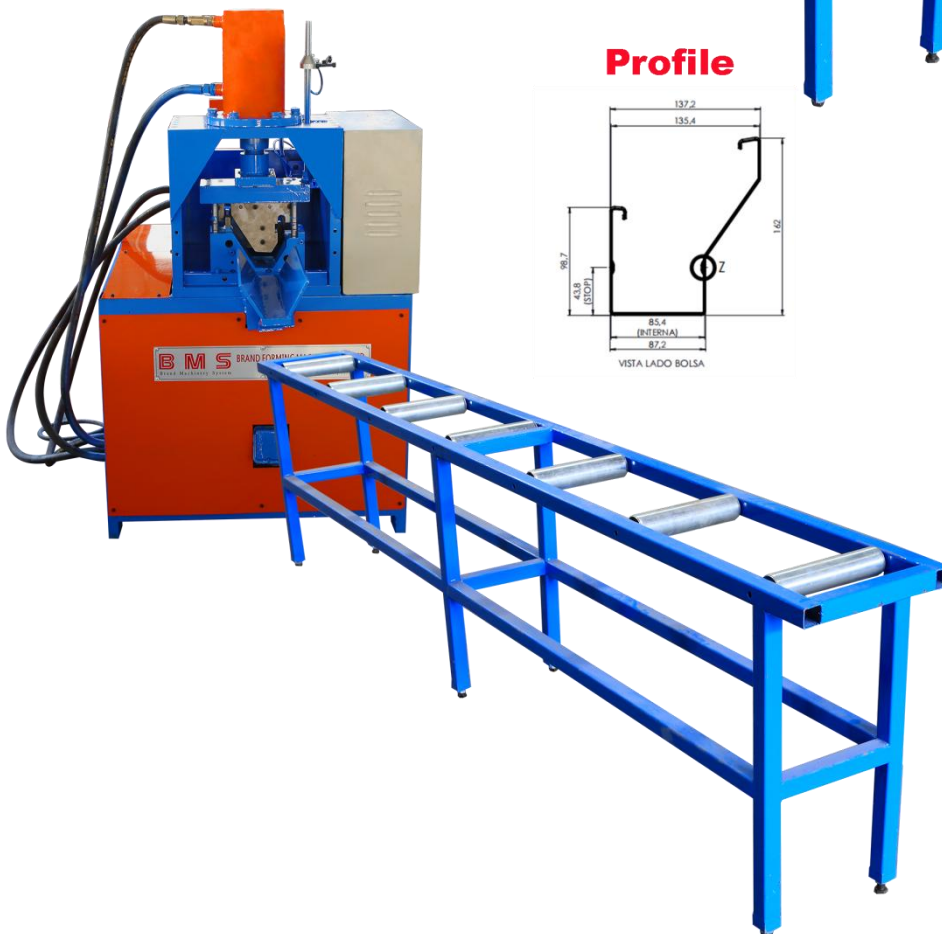


FEED TROUGH ROLL FORMING MACHINE

Coupler Device 1



Coupler Device 2



FEED TROUGH ROLL FORMING MACHINE

©Tools And Spare Parts:One Set

Open Wrench 24x22, 22x19, 19x17, 17x14

A Hex Wrench (Size 1 to 10)

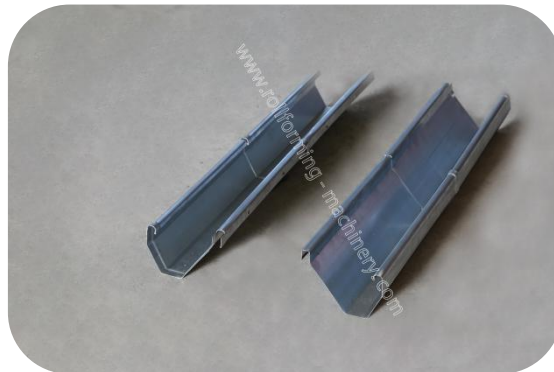
A Vise,A Cross And A Flat-Head Screwdriver, A Feeler,A Iron A Hammer, A Tape Measure

Spare Parts:

- 1.Drive Chain x 1
- 2.Drive Bearing x 2
- 3.Limite Switch x 1



©Sample Show



FEED TROUGH ROLL FORMING MACHINE

©Price

NO.	Item Name	Quality	Delivery Time
1	5T-500 Hydraulic Uncoiler	1	75 days
2	Leveling Device	1	
3	Hydraulic Pre-Punching Device	1	
4	Hydraulic Pre-Cutting Device	1	
5	Roll Forming Part	2	
6	Post Hydraulic Universal Cutting Device	1	
7	PLC Control System	1	
8	Exit Rack	3	
9	Coupler Hydraulic Punching Device	2	
10	Tools And Spare Parts	1	