



ROLL FORMING LINE FOR C & ANGLE PROFILES

2 IN 1





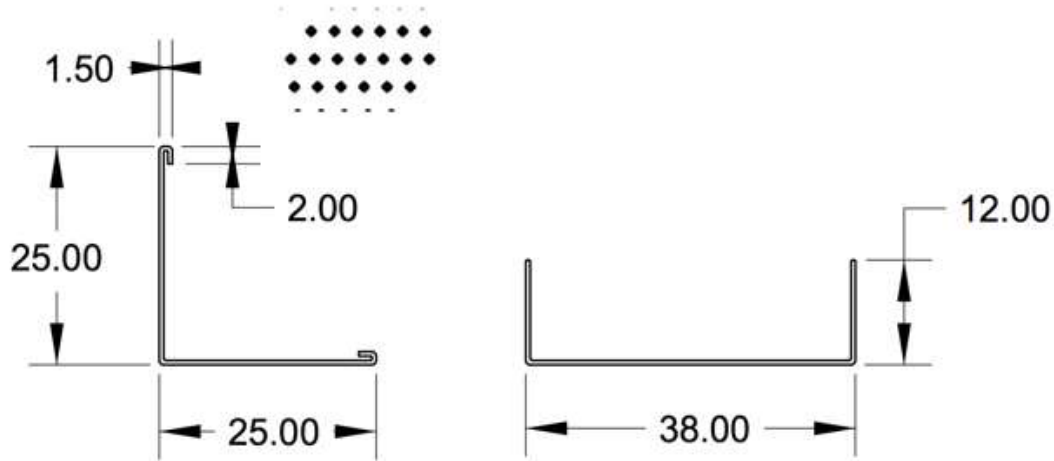
ROLL FORMING LINE FOR C & ANGLE TECHNICAL PARAMETERS

Material Parameter :

- Materials: Galvanization Steel
- Thickness: **0.35-0.8mm**
- Material Width:

Work Piece drawing:

For angle profile empossing surface as option



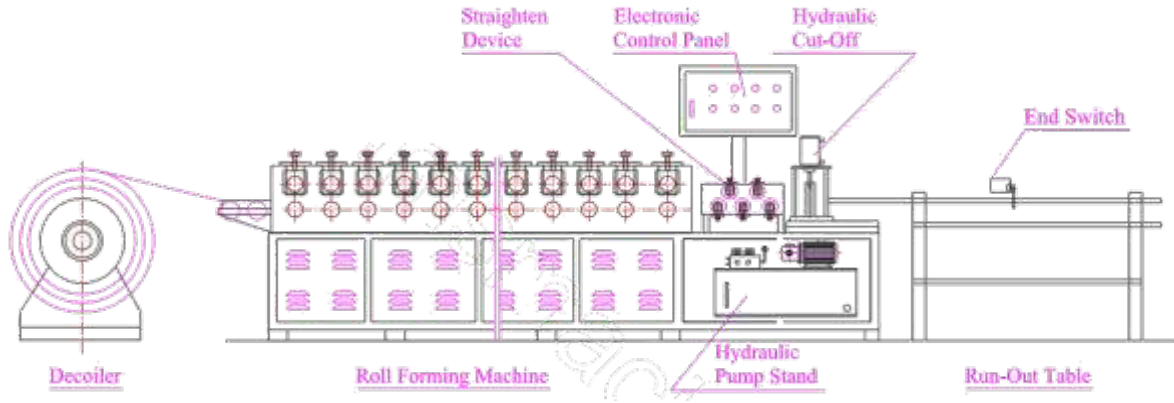
Material : G.I
Thickness: 0.35 - 0.8 mm

Work Piece sample:



Production Process:

Uncoil > Roll Forming > Cut-Off after sizing > Final product



NOTES: THE MACHINE CONTAINS TWO NUMBERS FROM EACH ITEMS AND IT CAN PRODUCE ONE PROFILE IN THE TIME BY SHIFTING THE GEAR FROM 1ST ROLL FORMING TO 2ND ROLL FORMING



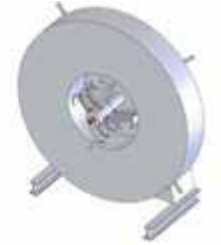
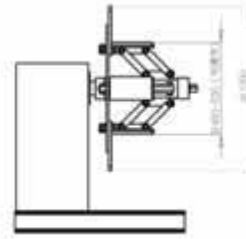


Machine's Specification:

A. Expand Manual De-coiler

2 sets

Max. Load capacity: 1500kgs
Inner diameter: 450-500mm
Outer diameter: 1400mm
Max. Width: 500~600mm
Expansion to tighten coil by manual



De-coiler is de-coiled attractively by roll forming machine and expanded or shrunk by manual operation (de-coiler can be adjusted to expand or shrink by revolving de-coiler center screw).

The brake belt can control the speed of de-coiler.

B. Roll forming machine

2 sets

Forming steps: 10 teams
Leveling steps: 5 teams
Roller's specification: GCr15
Quenching hardness: HRC58o-60o
Bearing model: 6207
Roll shaft: 45#
Diameter: Φ42
Motor: 4KW
Reduction box: JZQ250
Roll forming speed: 8-10 M/min

Roll forming Machine: It is composed of feed guide plate, roll forming machine, and straighten device.

1) Feed Guide Plate

2 sets

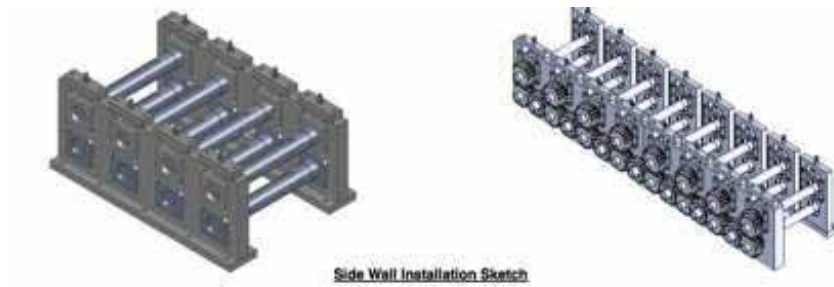
It is used to fix the left-or-right place of the material plate. If the size of product after processing is not up to requirement, operators can adjust it.



2) Roll forming Machine

2 Sets

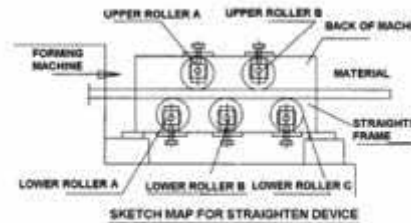
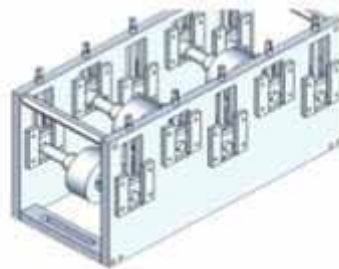
It is used to press the material plate to the shape according to the drawing, composed of 13 groups of rollers. Its rollers are fixed, vertical adjustable. It is driven by motor, decelerated by speed-reducer, power-transferred by chains and gears.



3) Straighten Device

2 sets

It is composed of 5 groups of straightening rollers (two upper and three lower). It is set at the back of the roll-forming machine to straighten the product after roll-formed.

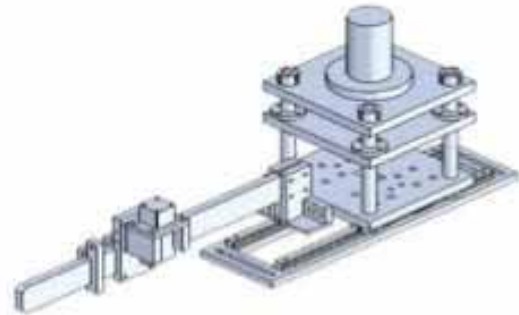
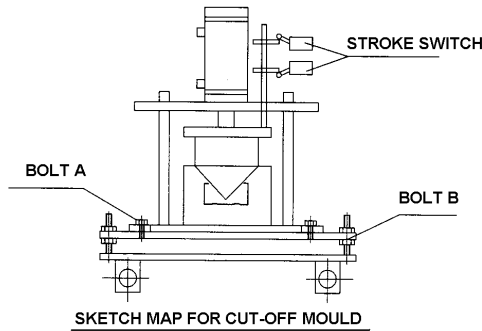


C. Pneumatic cut-off system

2 sets

- Material of the cut-off blade: Cr12MoV
- Quenching hardness: HRC58~62°
- Cut-off blade (with burs): 1 set
- Return quomodo:Cylinder

Pneumatic Cut-off: The pressure cut off the material according to the cut-off mold driving by the cylinder. The pressure supply by the air compressor, composed of cylinder, cut-off mold and mold running-out table



D) Product run-out table

2 sets

Table lengths: 4000 mm
Width: 100 mm

Run-Out Table: It is used to support profile after roll-formed and fix the Length of the profile. Run out table consists of Length control device.

Length Control Deviceit's pneumatic cylinder fixed on the support table on the correct position to give the required length, when the profile touch the stopper the sensor give order to the roll forming machine to stop and also to start the pneumatic cutter, once it cut the profile with required length, the pneumatic cylinder will move and release the profile from the support table.

Electric Control Panel:It is used to central-control and supply power, generally fix on the top of the machine



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