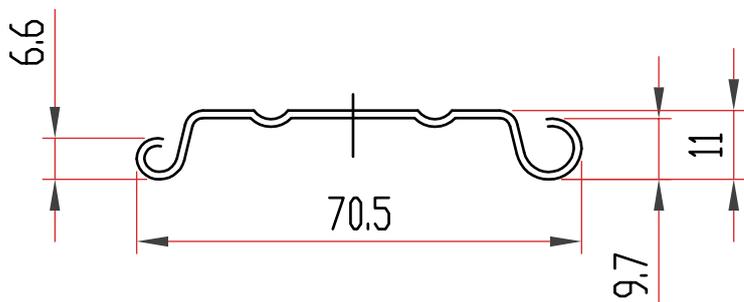




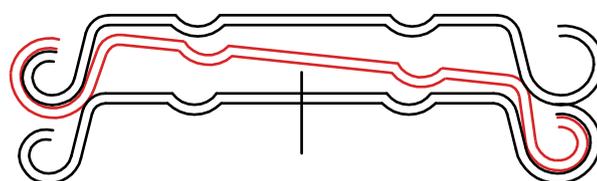
FIRE DAMPER BLADE ROLL FORMING MACHINE MODEL : FD-B70.5



WORK PROFILE DRAWING



connected blade



WORK PROFILE SAMPLE





NOTE: FOR THE FINAL PROFILE

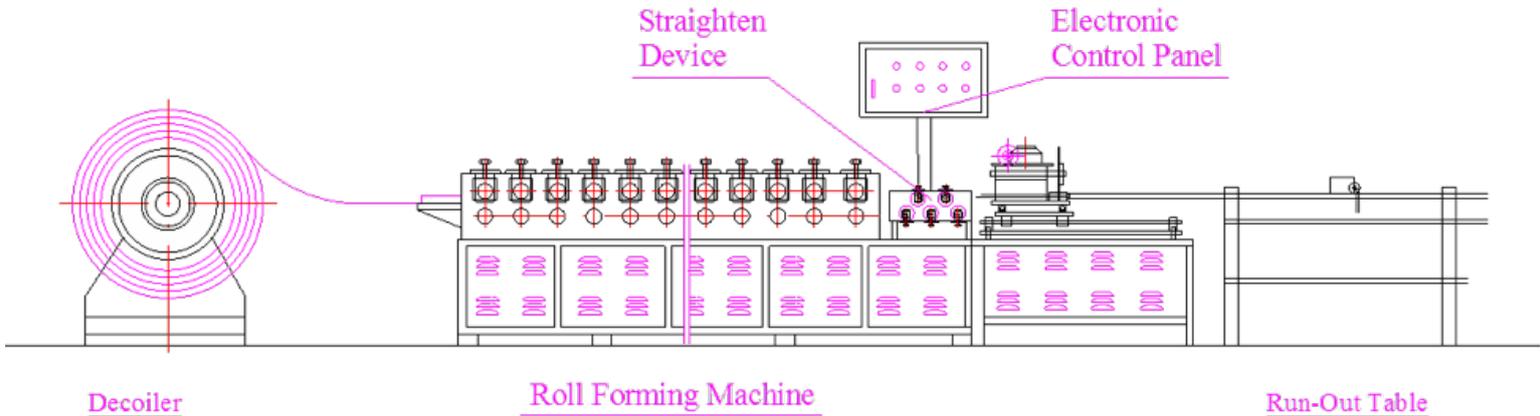
1. The folding part of 90° angle may have gap, not entirely link up
2. Total tolerance for each size: $\pm 0.8\text{mm}$
Length tolerance: $\pm 0.8\text{mm}$
Linear curve and torsion: 1.0mm

MAIN TECHNICAL PARAMETER

Material: G.I/S.S Steel
Thickness: 0.7mm
Profile Width: 70.5mm
Profile Height: 9mm(to be confirmed)

MACHINE LAY OUT

De- Coiler — Adjustable Feeding and Guiding — Roll Forming Machine —
Hydraulic Cutting — Run Out Table



DECOILER - 1 SET

Loading Capacity : 2Tons
Outer Diameter : $\phi 1200\text{mm}$
Inner Diameter : $\phi 350\text{mm}-\phi 400\text{mm}$
Decoiling Width: 400mm
Manual Expansion, No Power, with Manual Brake



ROLL FORMING MACHINE - 1 SET

Roller Stations	:	10 Groups (5No's Straighten Rollers)
Material of Roller	:	GCr15 Steel
Heat Treatment of Rollers	:	HRC55-57°
Surface of roller has been chrome plate.		
Material of coil strip	:	G.I/S.S
Thickness of coil strip	:	0.7mm
Width of coil strip	:	as actually used
Diameter of roller shaft	:	ø40mm, made of 45# Steel
Pinch wall thickness	:	22mm
Driven Method	:	Gear and Chain
Gear thickness	:	35mm, 45# HF surface treatment
Main bearings	:	6208
Power of main motor	:	2.2kw, cycloid pin
Forming speed	:	6-8m/min

CUTTER - 1 SET

Motor Power	:	2.2kw
Cutter die set 1 set (with waste cut off)		
Material of cutting dies	:	Cr12MoV Steel
Hardness of cutting dies	:	HRC60-62°

Hydraulic Stand - 1 SET

SUPPORT TABLE

Length	:	4m(As per customer requirement)
Made by C channel		

ELECTRIC CONTROL

It is used to control the machine operation and supply power, generally it fix on the top of the machine, Common parts for control panel from Japan

LENGTH CONTROL DEVICE

It'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 aslo to start the hydraulic cutter, once it cut the profile with required length, the pneumatic cylinder will move and release the profile from the support table.

