



ROLL FORMING MACHINE LINE MODEL : FURRING CHANNEL



TECHNICAL PARAMETERS:

MATERIAL PARAMETER

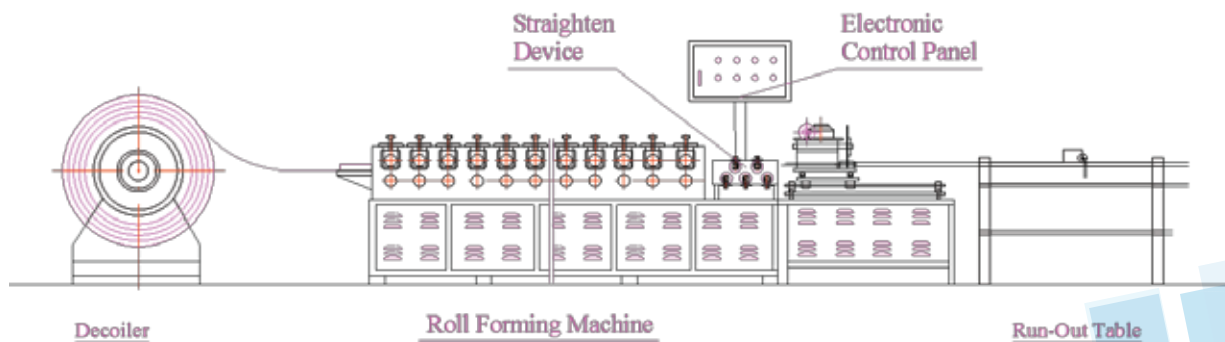
- MATERIAL : M.S OR G.I
- THICKNESS : 0.4 - 0.5mm
- MATERIAL WIDTH : 108mm



FURRING PROFILE SAMPLE

PRODUCTION PROCESS

Uncoil > Roll Forming > Cut-Off After Sizing > Final Product

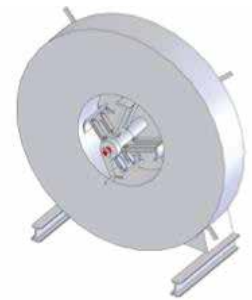
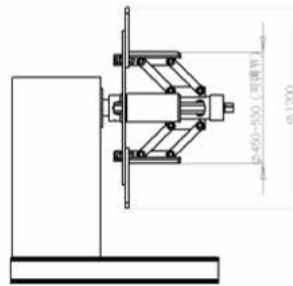




MACHINE COMPONENTS:

Expand Manual De-coiler (1 set)

- Expand quomodo: Manual
- Inner Diameter: 350-500
- Max. Load capacity: 1000 kg
- Outer diameter: 1200 mm
- Max. width: 300 mm



This 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.

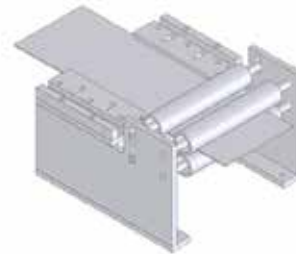
Roll Forming Machine

- Forming steps: 15 team
- Leveling steps: 5 team
- Roller's specification: GCr15
- Quenching hardness: HRC58°-60°
- Bearing model: 6207
- Roll shaft: #45
- Diameter: $\phi 42$
- Motor: 4 kw
- Roll forming speed: 6-8 m/min

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

1) Feed Guide Plate:

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.



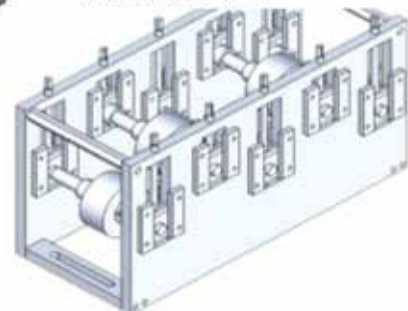
2) Roll forming Machine:

It is used to press the material plate to the shape according to the drawing, composed of 15 groups of rollers. Its rollers are fixed, vertical adjustable. It is driven by motor, decelerated by speed-reducer, powertransferred by chains and gears.



3) Straighten Device:

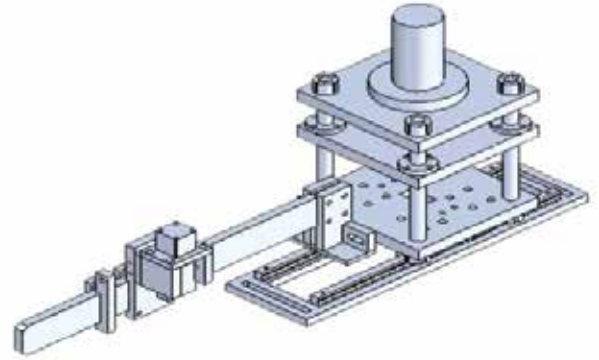
It is composed of 5 groups of straightening rollers (two upper and three lower). It is set at the back of the roll forming machine to straighten the product after roll-formed.





Pneumatic Cut-off System

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

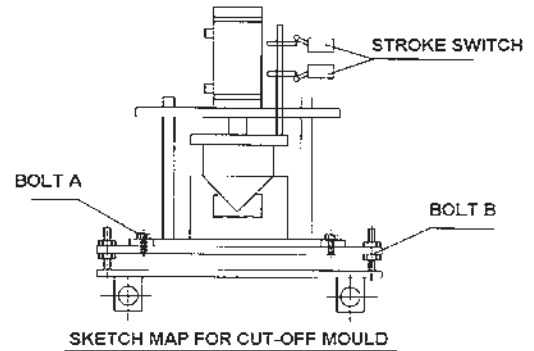


Cut-Off Mould:

When Air-powered cutting, the lower mould should make the material go through successfully.

The left-or-right position of the lower mould can be adjusted by the bolt A, and the up- and-down position can be adjusted by bolt B.

The cut-off stroke adjusts by the stroke switch. And the cut-off pressure adjusts by the relief valve of the pneumatic station.



Product Run-Out Table

- 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 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 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

