



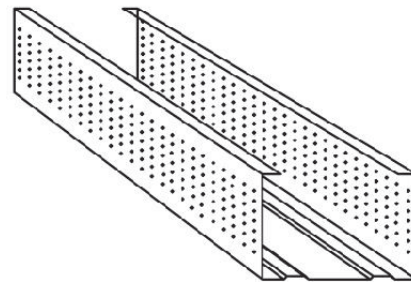
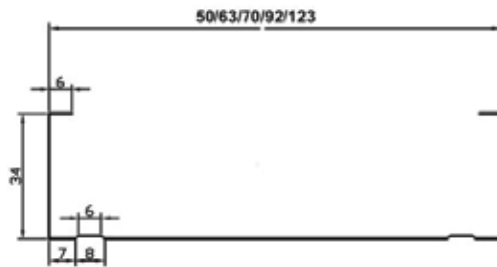
## ROLL FORMING LINE FOR STUD PROFILE



### Material Parameter:

- Materials : Galvanization Steel
- Thickness : 0.4-1.0 mm
- Material Width : For track 50mm :125 mm  
63mm : 138 mm - 70 mm : 145 mm  
92 mm : 166 mm - 123 mm : 197 mm

### Work Piece Drawing

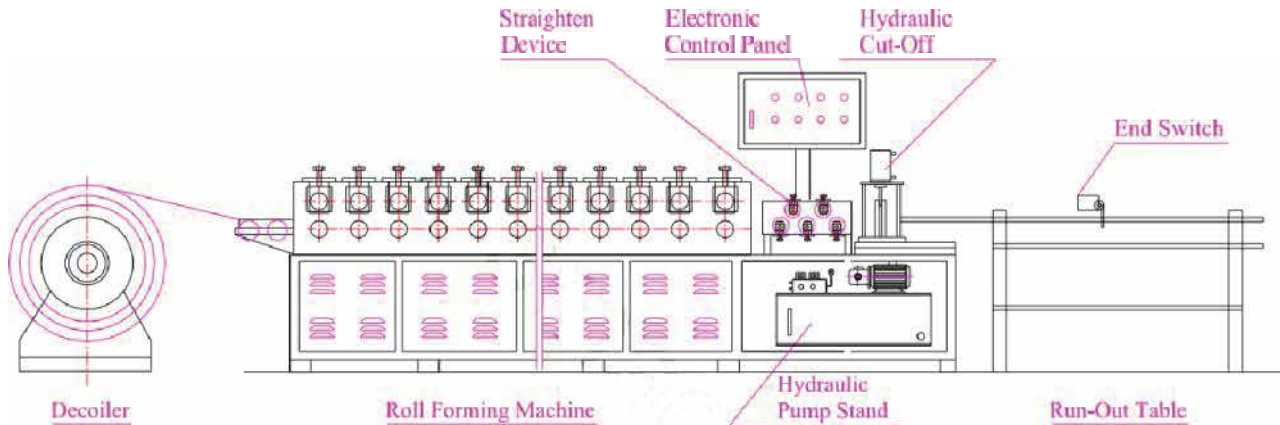


### Work Piece Sample



## Production Process:

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

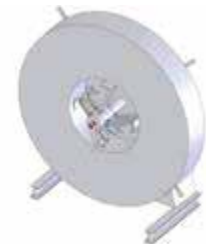
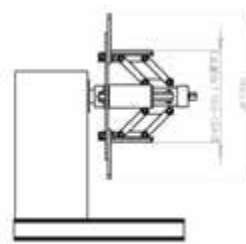


## Machine's Specification:

### A. Expand Manual De-coiler

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

1 set



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 1 set

Forming steps: 13 stations with entry guide stand. Each station consists of 2 sets of roller around 2 shafts one up and one down. High class and precise welding treatment assemble Main machine base.

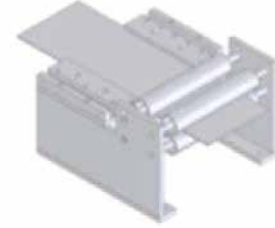
Transmit System	:	Chain and Gear
Main Machine Motor	:	3KW
Roll Forming Speed	:	8 M/Min
Roller's Specification	:	GCr15
Quenching Hardness	:	HRC55-57
Shaft	:	45# steel with heat treatment; diameter: 42mm.



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:

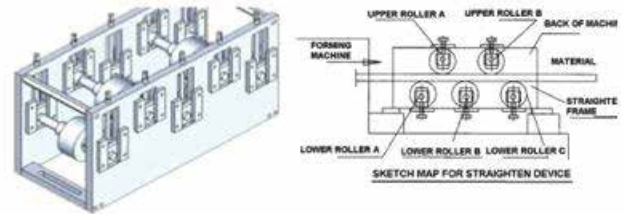
It is used to press the material plate to the shape according to the drawing, composed of 13 groups of rollers. Its rollers are fixed, vertical adjustable. It is driven by motor, decelerated by speed-reducer, power-transferred by chains and gears.



Side Wall Installation Sketch

### 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.



#### C. Hydraulic cut-off system 1 set

Material of the Cut-Off Blade	:	Cr12
Quenching Hardness	:	HRC60-62
Clean Cut with Burring		
Hydraulic Oil Pump Power	:	4KW
Cut-Off Blade (with Burs)	:	5 set
Hydraulic oil station supplying power to system		

#### D) Product run-out table

Table Length	:	4000 mm
Table 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