

No.	Item	Parameters	Remark
1	Forming speed	18-20(m/min)	Frequency speed control No including cutting time
2	Main motor	11KW	Voltage: 380V/60Hz/3Ph
3	Hydraulic motor	4KW	Voltage: 380V/60Hz/3Ph
4	Forming steps	16 steps	Motor Driving,Gear chain transmission
5	Body Frame	H450 Steel	Made from H450 steel plate welding,milling/polishing
6	Side wall	18mm	Thickness
7	Shaft	Diameter= ϕ 75 Round steel	Precision machined S45C High-Frequency Induction Hardening
8	Roller Material	Cr12=D3=SKD1	CNC lathes,Heat Treatment HRC58-62
9	Sprocket Wheel	S45C	Heat Treatment
10	Post-Cutter	Cr12Mov=D2=SKD11	Heat Treatment HRC58-62
11	Dimensions	About L8500×W1250×H1400mm	
12	Weight	About 6.5Tons	

II. Material:

Effective width: 140mm

Feeding width: **About 250mm**

Material Thickness: **1.5-2.0mm**

Testing material thickness: **1.5mm Or 2.0mm**

Applicable material: Galvanized Steel(GI), Cold rolled steel, Black sheet
with yield strength **235-345Mpa**

Effective width tolerance: $\pm 0.5\text{mm}$

The wave height tolerance: $\pm 0.5\text{mm}$

The length of tolerance: $\pm 1.0\text{mm}(6\text{m})$

★Feeding Device

A left and right guiding device at the main entrance of the machine. During work, Raw materials on both sides of the plate the enter into the machine by the left and right guiding device, make the raw materials and roll forming system to maintain the correct position. The guiding position can be adjusted by the manual screw mechanism, and the left and right can be adjusted independently.



★ Roll forming system

Roll forming system is composed of a machine frame, transmission parts and forming roller group etc.

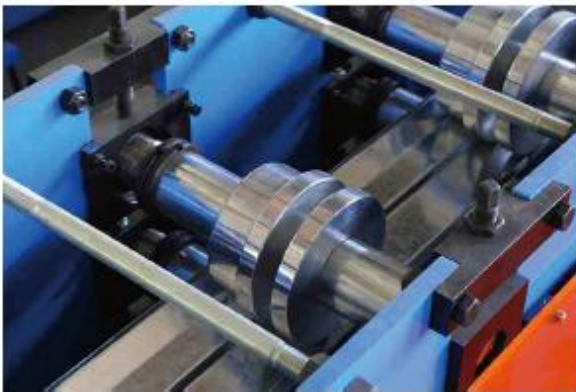
1)The frame section after manufacturing and connected,integral welding of profile with polishing treatment.

2)Roller wheel adopts Cr12 after forging, precision CNC machining, surface plating hard chromium polishing treatment. Part of the roller is equipped with bearings.

3)The shaft adopts 45# steel after quenching and tempering treatment.

4)The lower roller group is rotated by the chain and motor, parts of the upper and lower rollers are driven by a gear.

5)Adjusting the upper and lower roll gap by hand screw,in order to adapt to the plate with different thickness



★ Hydraulic Post-Cutting system

The cutting system consists of cutting machine frame, cutter die and cutting oil cylinder etc.

1)Cut after roll forming, stop to cut, no blanking; Cutting tool material adopts **Cr12MOV = MOLD STEEL SKD11**

2) The cutting power is provided by the main hydraulic station.



★ Electronic control system

1)Using PLC control technology, variable frequency speed regulation technology, to realize the automatic production of the whole machine.

2)System provides a friendly man-machine interface,can set the batch, the length of the work piece, quantity, etc.

3)operate mode:input screen + button.

4)Encoder count ,with counting numbers and counting length function.

