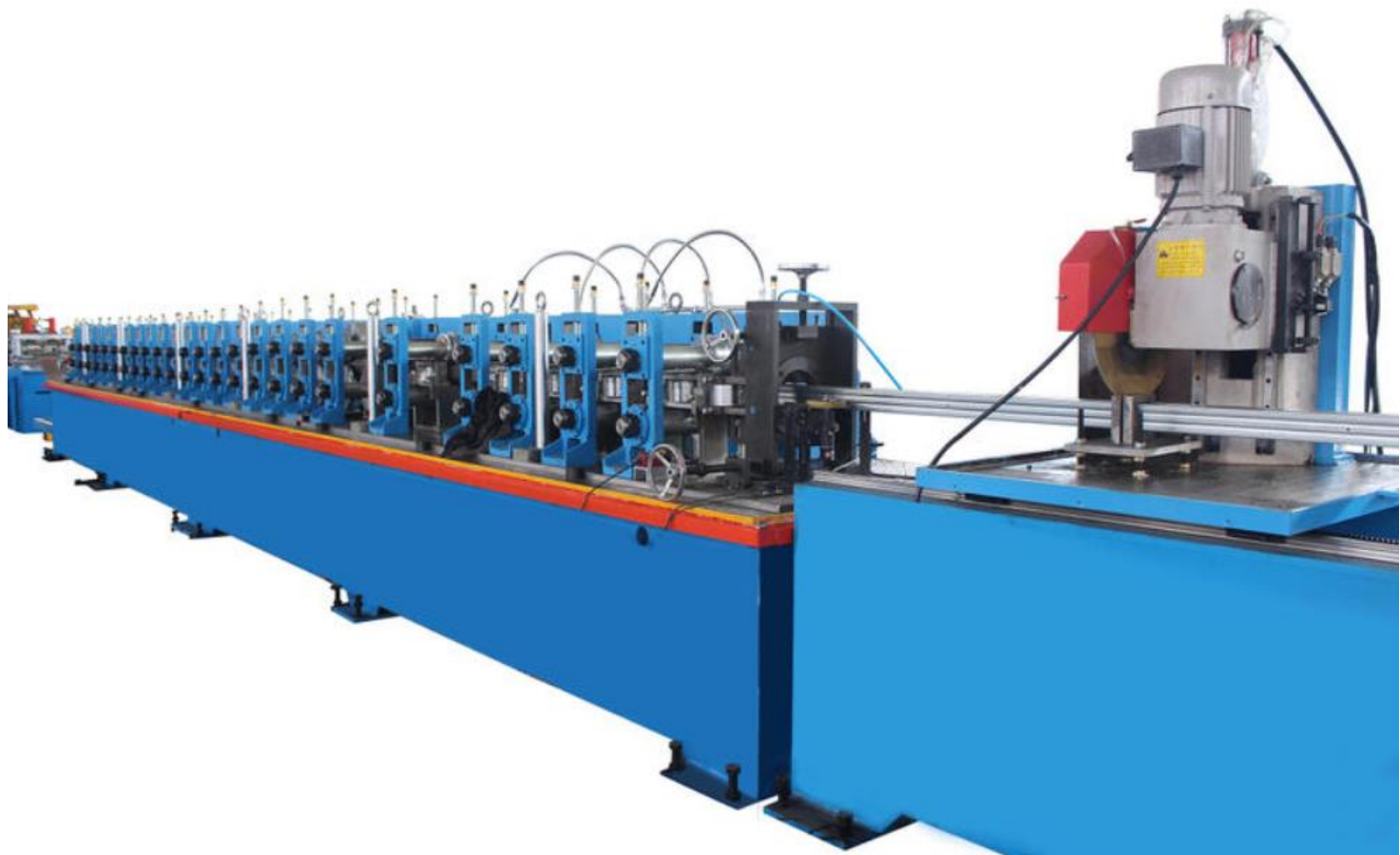


LIGHT KEEL VILLA ROLL FORMING MACHINE

Machine Type	Unit	Fob Price
C89 LIGHT KEEL VILLA ROLL FORMING MACHINE	1	US\$50,830



Equipment Use And Model

1. Purpose: Customize molding machinery and equipment according to product data or drawings provided by users.
2. Model: LIGHT KEEL ROLL FORMING MACHINE (The following is the model breakdown)
 - (1) SYJX—dual-purpose slot machine machinery
 - (2) 52—The feed specification range of the roller die.
 - (3) 52—The shaft diameter of the roller mold is 52mm, and there are 16 roller molds for the upper and lower parts.
 - (4) P—flat feeding.
 - (5) 1—represents that the maximum thickness of the material used for this equipment is 1mm. (galvanized sheet)

The Working Procedure and Principle Of The Equipment

1. Process: unloading → forming → non-stop servo tracking and cutting → collecting samples
2. Principle: The device uses a tablet with a limited width to intervene, and the manual button is used to start the operation; only one operator is required..

Detailed Technical Parameters Of The Equipment

1.Application:

For special steel products, the principle of step-by-step molding by concave-convex pressing.

2. Roller modulus:

16 pieces for upper and lower parts.

3. Roller mold:

Material cr12mf round steel, high frequency heat treatment, outer diameter fine turning, inner hole fine grinding

4. Use width: 155/200

5. Rolling thickness:1.2mm.

6. Motor power: 7.5kw.

7. Transmission mode:

Straight tooth occlusion is used for up and down synchronization, the tooth thickness is 30mm, and the module is 6. It is used in conjunction with the gearbox turbine box.

8. Rack structure:.

No. 10 square steel welding frame is adopted, and the whole machine adopts integral wall panel structure

9. The thickness of the wallboard is 25mm, and the surface is processed by flashing and grinding, and the holes are cut by wire.

10. Machine weight and land occupation: It weighs about 4T, occupies an area of 1m in width, 6m in length, and 1.5m in height.

11. The discharge rate is 15-20 m/min.

Main Parts Of The Machine

1. Bearings:

Harbin factory bearings are used.

2. Electrical components:

Xinjie inverter, Xinjie plc are used as the main components, and equipped with emergency stop and remote control handle.

3. Other standard parts:

market procurement and outsourcing, some special parts are self-made.

4. Unwinding rack:

Manually shrink the unloading rack.

5. Hydraulic system:

7.5kw hydraulic station, 80*80 standard steel.

5. Production cycle

1.)Design: about 5 days.
- 2.) Processing: about 30 days.
- 3.) Installation: about 15 days.
4.)Mode: about 10 days.

A total of about 60 working days.

Configuration And Technical parameters

Name	Components	Processing rules	power
Stamping system	mold, hydraulic system	Assemble with die	5.5kw
Servo Tracking System	Servo motor, feed shaft	CNC machining, fine turning and fine grinding	3kw sky servo
Forming unit	Roller dies, motors, frame servo motors, etc.	manual assembly	11kw
Electric control box	combination control	Supporting the use of	20kw

Unwinding frame (1 set)	1) Frame structure: cantilever type 2) Sheet width: maximum 3000mm; 3) Inner diameter of material roll: $\phi 500$ mm; 4) Expansion method: manual expansion 5) Unwinding form: passive unwinding 6) Inner diameter expansion and contraction range $\phi 460-520$ mm; 7) Maximum outer diameter of material roll: $\phi 1400$ mm; 8) Bearing weight: $\leq 2t$
Matching servo motor	1) Function: feed tracking cut off 2) Structural features: 1.5KW driven by servo motor (with planetary reducer). Multi-stage feeding: 10 groups of different feeding lengths can be input, and each group provides 9999 punching times. The LCD touch display is convenient for changing and setting various technical parameters. The automatic induction starting system is linked with the punch press (controlling the start of the punch press). Main features: large power, fast speed, stable delivery, 3) Motor configuration: 380V 3.8KW 4 poles, air compressor needs to be equipped separately. (The flow is 0.5m

	³ /min; the pressure is 0.6MPa.) 6) Material thickness range: 0.8 ~ 1.0mm, maximum width: 300mm
Roll	18 channels; the roll material is Cr12MoV, the quenching hardness is HRC58-62, and the surface is finished.
Transmission	2 reducers (JCQ250 type) The main transmission chain is 1.2 inches double row, the negative transmission chain is 1.0 inches
Roll shaft	Shaft diameter $\phi 52$, material 45# quenched and tempered , finely ground
Bearing Type	HRB62082RS Harbin Bearing
Frame	The square tube and steel plate are welded, the thickness of the bottom plate is 20 mm, and the surface of the machine is finished to ensure that the surface of the machine is level.
Roll support frame	Side plate type, plate thickness 25mm
Forming motor	Domestic brand , 7.51KW three-phase 380V50HZ (Jiangmen)
Reducer	Two JZQ250 hard tooth surface reducers
Cutting method	1) Hydraulic no-waste thwarting shearing, 2) Hydraulic motor 7.5KW 3) The number of hydraulic movements is 25 to 30 times 4) Cutting assembly mold 1 set
Straightening method	Straightening method: five-roller (upper 2 lower 3) straightening method
Cool down	Circulating cooling system, emulsion cooling (atomization type)

Receiving table	The length of the receiving rack is 6000mm. Roller test, manual collection.
Electrical control box (1 set)	<p>1) The whole line adopts PLC control, liquid crystal display touch screen, man-machine interface. Realize the interaction between human and PLC. The operator automatically runs through the set program (programmable control) and monitors the control process, so that the operator can control the production line and modify the control parameters, and can monitor the equipment operating status, operating parameters and fault indications in real time. Real-time monitoring of equipment operating status and fault indications .</p> <p>2) There are two modes of operation: manual/automatic. It has manual and automatic switching functions: in the manual state, it can run as a stand-alone machine, which is convenient for debugging and maintenance; in the automatic state, it can carry out production and operation of the whole line, and start in sequence; the whole line is equipped with an emergency stop button, which is easy to deal with emergencies and ensures the safety of the equipment. Operator safety.</p> <p>3) Equipped with a cordless remote control brake operator</p> <p>4) There is a manual operation panel next to the machine to facilitate workers to operate</p>

Serial number	Name	Brand
1.	Main motor	Siemens
2.	Inverter	Inovance
3.	Hydraulic system	For forming machine
4.	Touch screen	Kunlun Tongtai touch screen 7 inches
5.	Hydraulic valve	Howard
6.	Reducer	JZQ



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7.	main bearing	Halbin
8.	PLC	Xinjie
9.	Encoder	Japan Internal Secret Control
10.	Server Driver	PeiSky
11.	Servo motor	PeiSky
12.	Electrical components	Schneider and Omron
13.	Machine system	For forming machine