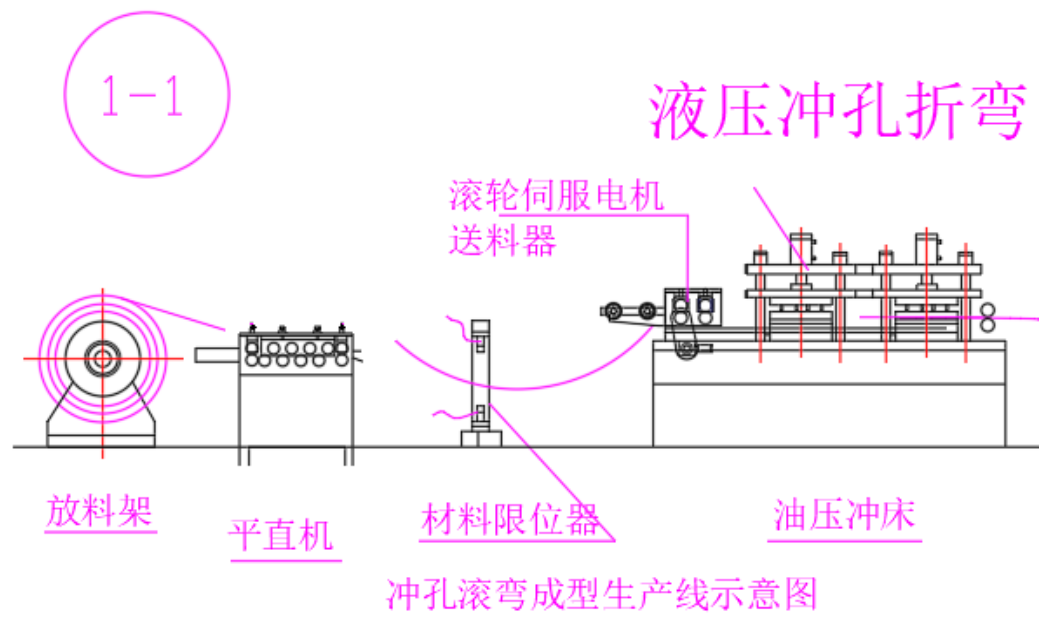


## CZ PURLIN ROLL FORMING MACHINE

Machine Type	Unit	Fob Price
CZ PURLIN ROLL FORMING MACHINE	1	US\$25,168



### Equipment Use And Model

- Purpose: Customize molding machinery and equipment according to product data or drawings provided by users.
- Model: Roll Forming Machine (The following is the model breakdown)
  - CYSCX—Bending And Feeding and Cutting Lines
- 200—The range of feeding specifications for the roller die.
- 80—the shaft diameter of the roller mold is 80mm, and there are 15 roller molds on each side.
- P—flat feeding.
- 1.2—means that the maximum thickness of the material used for this equipment is 1.2mm. (cold plate))

### The Working Procedure and Principle Of The Equipment

- Process: unloading→leveling→servo feeding→stamping mold→collecting finished products
- 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 forming by concave-convex pressing.

#### **2. Roller modulus:**

15 pieces each for upper and lower.

#### **3. Roller mold:**

Material cr15mov round steel, high frequency heat treatment, outer diameter fine turning, inner hole fine grinding

#### **4. Use width: 200mm.**

#### **5. Rolling thickness:1.5mm.**

#### **6. Motor power: 1.5KW servo motor**

#### **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:**

The No. 10 square steel welding frame is used, and the bottom is laid with 20mm steel plate for flashing and grinding. , to ensure that the frame is firm and annealed to relieve stress and prevent deformation. The whole machine adopts an integral wall panel structure, and the bottom angle of the screw can be adjusted for rack installation.

**9.** The thickness of the wallboard is 35mm , and the surface is processed by flashing and grinding, and the holes are cut by wire. Steel plates are laid on the bottom for flash processing to ensure the parallelism of equipment installation.

#### **10. Machine weight and floor space:**

It weighs about 3T, covers an area of 1m in width, 3m in length, and 1.5m in height.

## Main Parts Of The Machine

### 1. Bearings:

SKF brand 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:

automatic shrinking unwinding rack.

### 6. Stamping system:

120 tons hydraulic press

7. Discharge speed, 3--6 meters per minute

### 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
Feeder	Inverter control,	The steel plate processing character steel is firmly welded and can withstand 5T	4kw
Leveling machine	Frame, motor, leveling shaft, etc.	Gantry milling, wire cutting, CAC	4kw
Stamping system	mold, hydraulic system	Assemble with die	7.5kw
Servo Feeder	Servo motor, feed shaft	CNC machining, fine turning and fine grinding	3kw sky servo
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: $\leq 2$ t
Leveling machine (300)	1) Number of working rolls: 5 rolls for leveling, 2 rolls for front and rear pinch 2) Structural features: After tempering and chrome plating, the mechanical properties such as rigidity and surface roughness are greatly improved; it is composed of a pinch roller and a leveling roller, the pinch roller can be adjusted separately, and the leveling upper roller adopts The overall structure has two adjustment points at the front and rear .

	<p>3) The material of the roller is 45# steel, and the hardness of intermediate frequency treatment is HRC 55~58.</p> <p>4) The maximum material width is 300mm, and the material thickness range: 1.0-3.0mm.</p>
NC300 Servo Feeder	<p>1) Function: feeding</p> <p>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: high power, fast speed, stable conveying, with reducer.</p> <p>3) Motor configuration: 380V 3.8KW 4 poles, the air compressor needs to be equipped separately. (The flow is 0.5m<sup>3</sup>/min; the pressure is 0.6MPa.)</p> <p>4) The feeding speed depends on the hole-to-hole distance</p> <p>5) Equipped with planetary reducer</p> <p>6) Material thickness range: 0.8 ~ 1.0mm, maximum width: 300mm</p>
Pnching Mchine	<p>1) Using hydraulic punching, hydraulic station pressure 12 OT (motor power 11)</p> <p>2) Hydraulic cylinder movement times 50-60 times/ min</p> <p>3) 1 punching machine, 1 vertical station,</p> <p>4) 1 set of punching dies, die step distance 300 mm .</p> <p>5) Punching speed 0 ~ 6m/min</p>
Roll	<p>22 passes; the roll material is Cr12MoV, the quenching hardness is HRC58-62, and the surface is finished.</p>
Specification replacement method	<p>Specifically, the spacer sleeve is loosened and replaced by rotating the external roll head, which is more convenient and quick</p>
Transmission	<p>① 2 reducers (JCQ350 type)</p> <p>② The main transmission chain is 1.5 inches double row, and the negative</p>

	transmission chain is 1.2 inches
roll shaft	Shaft diameter $\phi 62$ , material 45# quenched and tempered , finely ground
Bearing Type	HRB608-2RS 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 , two 7.5KW 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 3 sets
Receiving table	The length of the receiving rack is 6000mm. Roller test, manual collection.
Electrical control box (1 set)	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 . 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. 3) Equipped with a cordless remote control brake operator

	4) There is a manual operation panel next to the machine to facilitate workers to operate
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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
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

### After Sale Service

Warranty period is 36 months after receiving the machine; any quick-wear part is available for free during guarantee period under proper operation, customers only need to pay for the freight of the replaced new parts.

Installation and training service are optional for customers, any client can ask for this service from HARSLE, they should assume the airfare and accommodation for our engineer during the journey. The salary for each engineer is USD200 per day.

### Term Of Payment

### Term of Payment

30% by T/T in advance, 70% by T/T before delivery.

### Lead Time

60 days after receiving advance payment, sometimes we will have ready machines in stock.