

N1 ROLL FORMING LINE mod. PRH 30/300 for shutter blind slats

MAIN FEATURES

A/ Material to be processed :

Type	coil	:	Mild / galvanised steel
. Maximum thickness	mm	:	4-6/10 ^e
. Width	mm	:	232
. Max. weight	Kg	:	1500

B/ Production speed :

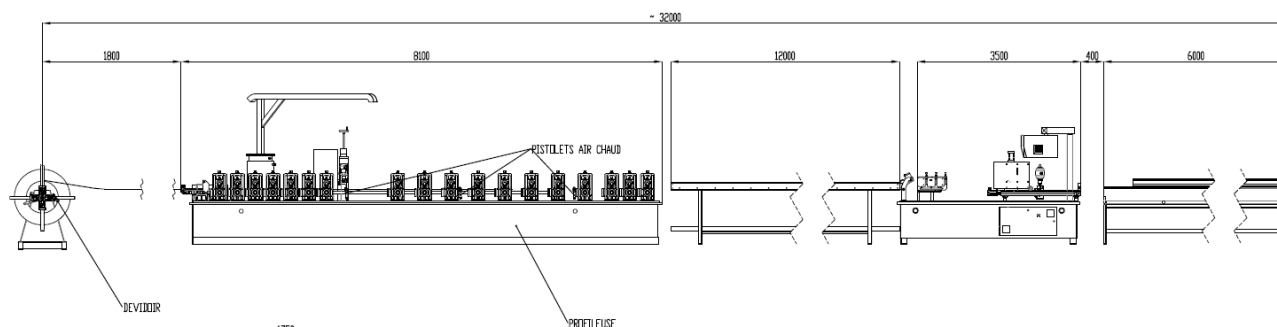
. Max. speed	m/1'	:	15
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C/ Total installed power :

. Motor	a.c.	Kw	:	7,5
	a.c.	HP	:	12,5
	Brushless	Kw	:	1,5

. Electrical supply	Volts	:	400
	Hz	:	50

DESCRIPTION



① DECOILER mod. DMR 315

. Capacity	Kg	:	1500
. Maximum width	mm	:	400
. Centering	mm	:	450-650

- Adjustable **diskbrake**
- Manual operated **centering**



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② **ROLL FORMING MACHINE mod. PRH 30/300**

. Maximum width between stands	mm	:	300
. Maximum width over stands	mm	:	0
. Diameter of shafts	mm	:	55
. Number of forming stations	N	:	18 (frame allowed for 30)
. Motors a.c. (electronic control)	Kw	:	7,5

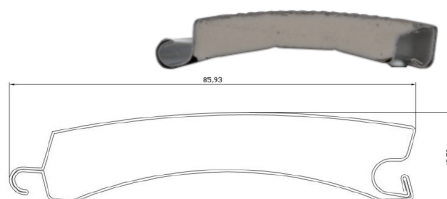
- **one piece table**, from planed steel with lining up grooves for the transmission uprights
- **N18 stations** with special **cast-iron stands**, housing large bearings of the best domestic and foreign brands.
- Lateral stands with reverse vertical rolls
- Steel roller shafts, entirely ground with 10 mm slots.
- Inferior shafts holder rolls fixed
- **Upper rolls shafts adjustable** according to the thickness to be worked, with graded vernier scale for setting.
- **Adjustable** introducing **guides** to line up the strips on the different sets of rolls
- Group of straighteners lined up on each set of rollers
- **One piece transmission shaft** Ø mm 40 from the motor **to the different stations** with conical gears
- Start up directly from the main electrical panel, or from a **remote control** box with forward and backward
- **Electrical reheating** + closing casings



③ **SETS OF ROLL FORMERS** in special tempered and rectified steel as drawings attached

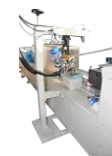
N1 set of roll formers + reverse vertical rolls for rolling shutters P77

- **Electrical reheating** jets
- Predisposition for foaming



④ **POLYURETHANE INJECTION PLAN**

- Injection **jet** with automatic arm
- Injector **washing** after each stop, controlled by CNC



⑤ **FOAMING PLANT**

- On line **automatic foaming** mod. CMC3/CAJ
- Injection **jet** cooling
- High accuracy **volumetric pump**
- **Discharge** controlled **electronically** by inverter
- Powered dynamic blender

⑥ **POLYMERIZATION TUNNEL**

. length	mm	:	12 000 (4 x 3 m)
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- Mechanically welded steel frame
- Closed tunnel & **electrical reheating** device
- **Temperature control**
- Horizontal & vertical rollers driving the profile during the polymerization



⑦ **HYDRAULIC FLYING CUTTING**

. course	mm	:	250
. motor Brushless	Kw	:	1,5

- **Carriage** on rectified **balls grooves**
- Speed **synchronization** by **Brushless** motor
- Straightening & sizing group with n6 + n6 rolls



⑧ **HYDRAULIC PLANT**

. Tank	L	:	150
. Hydraulic unit motor pump	HP	:	12,5
. Accumulator	L	:	4
. Nb of electrovalves	n	:	2+1

- Heat **exchanger** of temperature + CNC control
- Very **high speed cutting** by accumulator



⑨ **ELECTRICAL EQUIPMENT AND HANGING UP ADJUSTABLE CONTROL PANEL**

• P.C. industriel mod. **CNC SNAP** :

- video TFT touch screen colors 12"
- Windows 8.1
- P .C. office
- internet



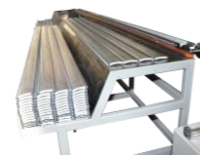
• Control by **CNC SNAP** :

- punching,
- cutting,
- synchronization introducing / cutting – punching / forming

⑩ **AUTOMATIC DISCHARGING TABLE**

. Max. length mm : 6 000

- Profiles cooling table, 700 mm width
- Pneumatic dropped table 6 m
- Pneumatic unloading of the profiles on side



OPTIONAL :

① **Stamp for aeration window mm 100 x 50**

- n4 columns
- jack \varnothing 100 with double effect
- **K100** material **TiAln** coated
- adujstable pitch 20 to 50 mm

