

## N1 ROLL FORMING LINE mod. PRHL 15/400

*For water draining grates*

### MAIN FEATURES

. Material to be processed	:	Coils
- Type	:	Mild / galvanised steel
- Max weight	Kg :	1 500
- Maximum thickness	mm :	1,5
- Max. production speed	m/1' :	20
- production speed thickness 10/10 <sup>e</sup>	m/1' :	5/6
- production speed thickness 15/10 <sup>e</sup>	m/1' :	7/8
. Electrical supply	V :	400
	Hz :	50
. Motors Brushless AKM73P	Kw :	7,1
Alternating current	HP :	22,5

### DESCRIPTION

#### ① MANUAL DECOILER mod. DMR 315

. Capacity	Kg :	1500
. Maximum width	mm :	400
. Centering	mm :	450-650
- Adjustable <b>diskbrake</b>		
- Manual operated <b>centering</b>		



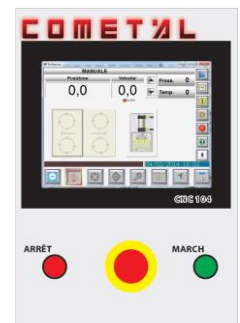
#### ② ROLL FORMING MACHINE mod. PRHL 15/400

. Maximum width between stands	mm :	400
. Maximum width over stands	mm :	250
. Diameter of shafts	mm :	55
. Number of forming stations	N :	8 (frame allowed for 15)
. Brushless motor AKM 73 P	Kw :	7,1

- **One piece table**, from planed steel with lining up grooves for the transmission uprights
- N8 stations with special **cast-iron stands**, housing large bearings of the best domestic and foreign brands.
- Steel roller shafts, entirely ground with 10 mm slots.
- **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
- Motorization brushless Kolmorgen **direct**
- **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.

#### ③ ELECTRICAL EQUIPMENT AND HANGING UP ADJUSTABLE CONTROL PANEL

- **P.C. industrial mod. CNC 104 :**
  - video TFT touch screen colors 10"
  - Windows 8.1
  - P .C. office
  - internet
- **Control by CNC :**
  - punching,
  - cutting,
  - synchronization introducing / cutting – punching / forming



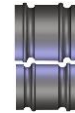
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④ **HYDRAULIC PLANT**

- . Tank L : 150
- . Hydraulic unit motor pump HP : 22,5
- . Nb of electrovalves n : 3+1

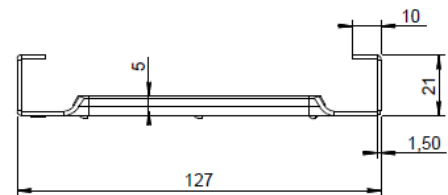


- **Heat exchanger + control by CNC**
- High pressure special pump 30 L
- Oil storage **8 L**
- Air / oil heat **exchanger** mod. **extra** for continuous 8 hours work, control by CNC 104

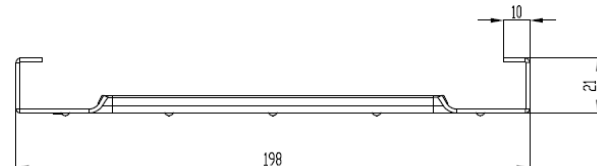


⑤ **SETS OF ROLL FORMERS** in special tempered and rectified steel as drawings attached

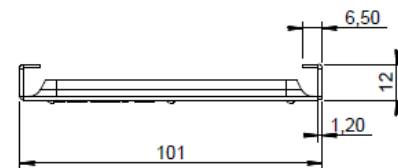
- **N1 set of roll formers + straightener for draining grate mm 127 x 21**



- **N16 magnetics spacers mm 71 quick coupling for draining grate base 198**



- **N1 set of roll formers + straightener for draining grate mm 101 x 12**



⑥ **HYDRAULIC PUNCHING TOOLING**

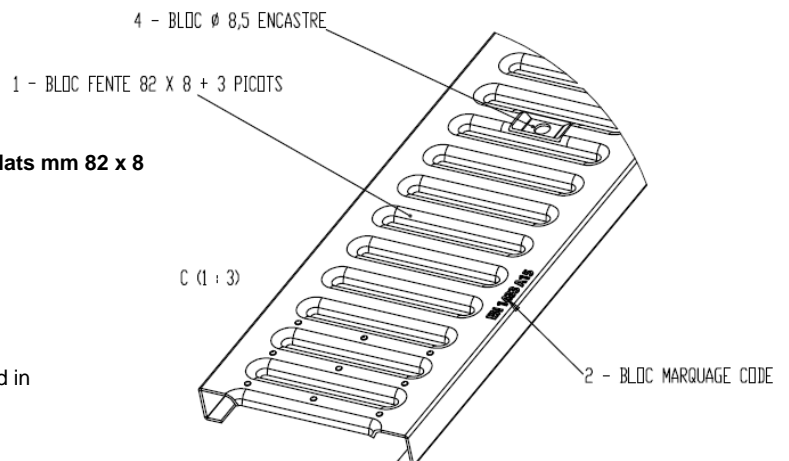
- . Hydraulic jacks  $\varnothing$  60 mm
- . Cutting discharge
- . Punches and dies TiAlN coated, fully grinded
- . Stroke electronic control
- . Pneumatic lubrication plant by Venturi system with CNC control

- **N1 hydraulic punching device complete for wide mouthed slats mm 129 x 8**  
+ anti skid tips, pitch 200 mm for grate **198**

- **N1 hydraulic punching device complete for wide mouthed slats mm 82 x 8**  
+ anti skid tips, pitch 200 mm for grate **mm 101 + 127**

- **N1 hydraulic punching device complete for  $\varnothing$  mm 8,5 builded in**

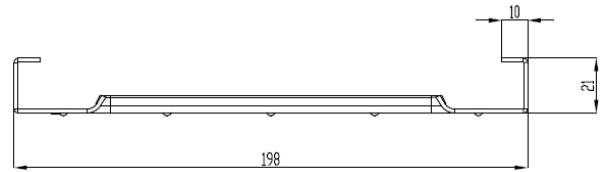
- **N1 hydraulic punching device complete for printing stamp**



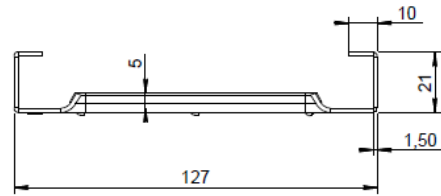
⑦ **HYDRAULIC CUTTING TOOLING**

- . complete hyd. cutting unit on line
- . blades & matrix of hard and ground steel
- . CNC control
- . hydraulic jack + position electronic sensor

- N1 complete hyd.cutting unit for draining grate mm 127 x 21



- N1 complete hyd.cutting unit for draining grate base 198



- N1 complete hyd.cutting unit for draining grate mm 101 x 12

