STUD ROLL FORMING

1. Equipment technique requirement
   1.1 Equipment technique requirement:
   1.1.1 Equipment floor space: 15×2.0×2.5（L×W×H）meter³.
   1.1.2 Equipment feeding material the orientation: the left side enter and right leave.
   1.1.3 Voltage: 380V, 50Hz, 3phase.
   1.1.4 Hydraulic oil: NO: 46#.
   1.1.5 Gear oil: 18# Hypoid gear oil.

2. Equipment main technical parameters
   2.1 Raw material width:
   2.2 Material thickness: 0.45-0.6mm
   2.3 Material: galvanized steel
   2.4 Production speed: around 0-10M/min
   2.5 Production length: ≥4000mm
   2.6 Equipment total installed capacity: around 8KW.

2. Rollforming production scope
   2.1 This rollforming machine can be make the thickness from 0.45 to 0.6mm
   2.2 Product drawing
According to the requirements of the A, B1, B2 size, the use of a movable sleeve type moving wall panels and roll, the overall lateral adjustment of the manual screw, the structure of the 1-5 group on both sides of the B1 B2 size, 6-15 group of unilateral mobile wall panels to adjust the size of A.
3. Production line of the Composition

3.1 The provisions of the contract equipment in the scope of supply

<table>
<thead>
<tr>
<th>ITEM</th>
<th>MACHINE NAME</th>
<th>EXPLAIN</th>
<th>QTY</th>
<th>MOTOR(KW)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Manual Decoiler</td>
<td>1 TONS</td>
<td>1 set</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Main rollforming machine Can be change the width of profile</td>
<td>15 group</td>
<td>1 set</td>
<td>5.5</td>
</tr>
<tr>
<td>3</td>
<td>After forming and then will punching &amp; cutting</td>
<td>Punching and cutting by HYD</td>
<td>1 set</td>
<td>3</td>
</tr>
</tbody>
</table>

4. The equipment structure, capability overview

4.1 The production process equipment for forming

Uncoil → rollforming → punching the hole(Φ33) → cutting

5.2 Parameters of main equipment

5.2.1 Hydraulic Decoiler
- Material width : ≤150 mm ; material thickness ≤1.0mm ;
- Inner diameter : φ480-520 mm ;
- Outer diamete:φ1200mm;
- Max. load capacity : ≤1T

5.2.2 Main rollforming machine
- Model : LD15
- Forming steps : 15 group
- Forming profile : Forming framework: use the wall type side plate, gear drive.
  side wall thickness : 30mm
- Max material width: mm
- Min material thickness : 0.45mm
- The roll shaft diameter : φ45 mm
- Roller material : Cr12MoV, the quenching hardness, HRC58-62°
- Bearing type 6208
- The main drive motor uses 5.5kw motor.

5.2.5 Cutting system
  a. Modality : Hydraulic cutting
  b. Design feature : after cutting system design in the forming machine, the cutting length can be set.
5.2.6 Run-out table

Framework: platform type, without power

5.3 Electrical control system

5.3.1 The whole line adopts Industrial PC control, LCD touch screen display, man-machine interface. Interaction between workers and Computer. The operator the setting program (Computer) and monitoring the control process, the operator to control production line and modify the control parameters, and the running state real-time monitoring equipment, operation parameters and fault indication. The length of the workpiece digital setting, the length of the workpiece can be adjusted. Running state real-time monitoring equipment and fault indication.

5.3.2 Mode of operation: manual / auto two. With manual, automatic switching function: in the manual mode, can be stand-alone operation, convenient repair; in the automatic mode, all production and operation, the start up sequence; along with the emergency stop button, easy to handle emergencies, to ensure the safety of equipment and personnel.

5.3.3 Machine is equipped with the manual operation panel for easy operation.

5.3.4 Monitoring function across the board: running real-time monitoring of the status of the production line, to monitor the production status of each station;