

***\*WE WELCOME YOU TO VISIT OUR FACILITY AT ANY CONVENIENT TIME\****

### ***Technical-commercial quotation***

*We offer for your consideration this quotation on Armoring window profile roll forming line of the cassette type.*

*All equipment is designed and manufactured by Ruscana Engineering Group.*

### ***Armoring window profile roll forming line of the cassette type***



***Fig.1 Roll forming section***

#### **Specification:**

Armoring window profile roll forming line, hereinafter referred to as "Equipment", is intended for producing armoring profiles for PVC windows and doors. Armoring profiles are used to reinforce metal-filled plastic products: door and window blocks. Profile drawings are shown in fig. 3.

### **Raw material requirements:**

- cold-rolled galvanized steel for cold rolling with polymer coating
- galvanized steel for cold rolling with zinc coating to range 100...275 g/m<sup>2</sup>
- strip width – according to flat patterns indicated in the table in Fig. 1
- metal thickness – 1,2 - 1,5 mm

Readjusting of the profile sizes is carried out by moving the roll forming rollers along the keyway of the shaft and fixing it with the stop screws.

Operating mode - automatic / semi-automatic.

Roll forming speed 20 m/min. (35 m/min - option)

Installed power capacity, no more than - 11,2 kW.

Electric network - 380 VAC + N.

Weight, approximately - 3050 kg.

Dimensions (LxWxH), approximately - 8600x1400x1800 mm.

Required operating personel 1 - 2 persons.

### ***Equipment configuration:***

**1. Decoiler, with clamping module**

**2. Roll forming section**

**3. Swing saw (integrated into roll forming section)**

**4. Automatic control system (ACS)**



**Fig. 2 Roll forming cassettes**



**Equipment Specifications:**

<b>1. Decoiler</b>		
1.1	Type	Cantilevered, with drive
1.2	Feeding speed, no more than	20 m/min (automatically controlled) 40 m/min-option
1.3	Installed power capacity	2,2 kW
1.4	Operating mode	Automatic, manual, reverse
1.5	Lifting capacity, no more than	2000 kg
1.6	Dimensions (LxWxH), no more than	1300x1400x1400 mm
1.7	Mandrel expansion range	480 mm...620 mm (Coil ID 500 mm/600 mm)
1.8	Mandrel expansion/clamping	mechanical (by handle)
1.9	Clamping module	pneumatic
1.10	Weight, no more than	500 kg
<b>2. Roll forming section</b>		
2.1	Type	<b>In channel bar, cassette type</b>
2.2	Fastening of the rollers	<b>on key with sleeving</b>
2.3	Dimensions (LxWxH)	5600x900x1800 mm
2.4	Installed power capacity	7,5 kW
2.5	Roll forming speed, no more	20 m/min (35 m/min-option)
2.6	Quantity of mill stands	<b>15</b>
2.7	Material of rollers	Instrument steel with heat treatment
2.8	Weight	2300 kg
<b>3. Swing saw for cutting closed channel profiles (integrated into roll forming section)</b>		
3.1	Installed power capacity, no more than	2,2 kW
3.2	Weight, no more than	250 kg
3.3	Drive type	electromechanical
<b>4. Automatic control system (ACS)</b>		
4.1	Hardware base	Omron (Japan)
4.2	Controlled parameters	Roll forming speed, quantity/length of end product, adjustment of the pauses of the technological cycle, production task.
4.3	Interface	English, User-friendly
4.4	Indicators	General settings, error and emergency alarms

**Equipment specification**

№	Description	Quantity	UOM
1	<b>Armoring window profile roll forming line of the cassette type,</b> consist of:	1	Sert
1.1	Decoiler	1	pcs.
1.2	Roll forming section without cassettes	1	pcs.
1.3	Swing saw for cutting closed channel profiles	1	pcs.
1.4	Automatic control system (ACS)	1	pcs.
	Cassette for closed channel profile	1	pcs.
	Cassette for П-shaped profile	4	pcs.
2	Supervised installation and commissioning	1	ea.

**Options:**

№	Description
3	An additional payment for profile cutting device "Flying Cut off" (to increase production speed up to 40 m / min)
4	Receiving table, electromechanical drive, L = 6 meters