

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

### **Technical-Commercial Quotation**

*We offer for your consideration this quotation on C channel 50x50, 75x50, 100x50 roll forming line.*

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

### ***C channel 50x50, 75x50, 100x50 roll forming line.***



#### **Raw material requirements:**

- zinc coating to range 100...275 g/m<sup>2</sup>
  - yield strength 280...320 N/mm<sup>2</sup>
  - strip thickness – 0,4 mm...0,6 mm;
  - strip width:  
50x50 – 152 mm ±0,5 mm, 75x50 – 182 mm ±0,5 mm, 100x50 – 203 mm ±0,5 mm.
- Line operating mode – Manual/automatic  
Roll forming speed 20 m/min. (option – 35 – 40 m/min).  
Installed power capacity – 11 kW.

Electrical power network:

- Supply voltage 380 VAC+N, permissible deviation  $\pm 5\%$ , maximum permissible  $\pm 10\%$ ;
  - \*Frequency 50 Hz, permissible deviation  $\pm 0.4$  Hz
- \* **Electrical supply network for countries of North America:** Supply voltage at frequency of 60 Hz, 230V 3 phase

Weight no more than)– 3200 kg.

Dimensions (LxWxH) no more than – 11650x1900x1800 mm.

Required operating personnel: 1- 2 persons

**Equipment configuration:**

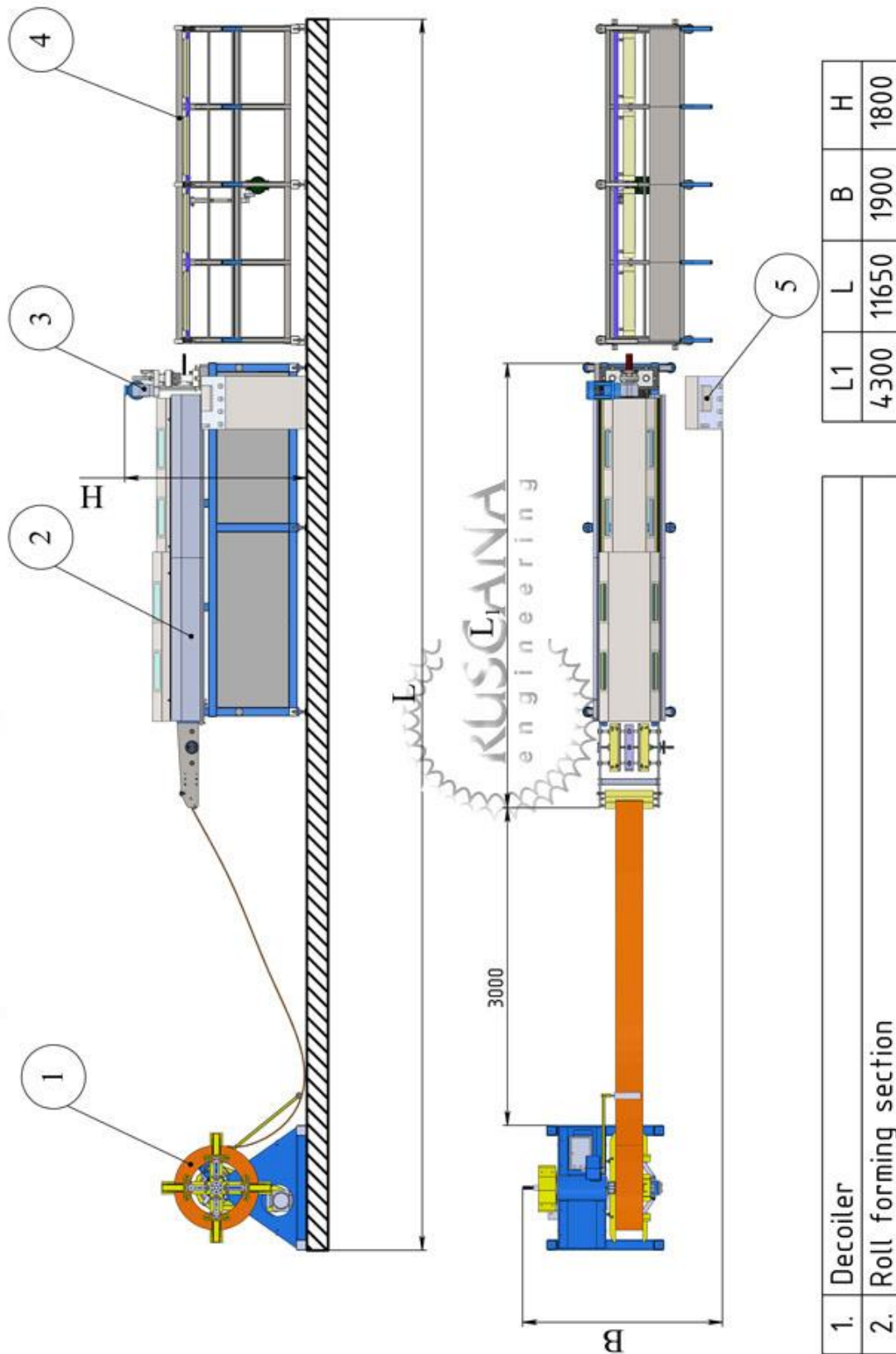
1. Decoiler
2. Roll forming section
3. Guillotine (integrated into roll forming section)
4. Receiving table (stacker)
5. Automatic Control System (ACS)

**Equipment Specification:**

<b>1. Decoiler</b>		
1.1	Type	Cantilevered
1.2	Feeding speed no more than, m/min	20 m/min. (automatically adjusted)
1.3	Intended capacity	2,2 kW
1.4	Operating mode	manual /automatic /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 mechanism	Mechanical (by handle)
1.9	Weight (no more than), kg	500 kg
<b>2. Roll forming section</b>		
2.1	Dimensions (LxWxH) no more, mm	4300x1000x1800 mm
2.2	Installed power capacity, no more than	4 kW
2.3	Roll forming speed, no more than	20 m/min (as na option – 35 - 40 m/min).
2.4	Quantity of mill stands	10
2.5	Set of spacers	for 3 (three) profile sizes
2.6	Rollers material	Instrument steel <b>with heat treatment</b>
2.7	Protective sliding shutters, serves for protection against the ingress of objects and dust into the roll forming section	option
2.8	Emergency stop cable around of the perimeter of roll forming section	yes
2.9	Weight, no more than	2400 kg
<b>3. Guillotine (integrated into roll forming section)</b>		
3.1	Cutting time	1 second
3.2	Installed power capacity, no more than	4 kW

3.3	Drive type	electromechanical
3.4	Cut of stamp	for3 (three) profile sizes
<b>4. Receiving table</b>		
4.1	Type	stacker
4.2	Dimensions (LxWxH) no more than	3000x800x1800 mm
4.3	Length of end product	1 m....3 m
4.4	Installed power capacity, no more than	0,55 kW
4.5	Drive type	hydraulic
4.6	Weight, no more than	250 kg
<b>5. Automatic Control System (ACS)</b>		
5.1	Hardware	Omron (Japan)
5.2	Controlled parameters	feeding speed, quantity/length of end products, technical cycle downtime control, production task
5.3	Interface	English, User-friendly
5.4	Indicators	General settings, error and emergency alarms

*Layout of the Single stream roll forming line*



- |    |   |
|----|---|
| 1. | Decoiler  |
| 2. | Roll forming section  |
| 3. | Hydraulic guillotine integrated into the roll forming section |
| 4. | Receiving table   |
| 5. | Automatic control system (ACS)                                |

## *C channel 50x50, 75x50, 100x50*

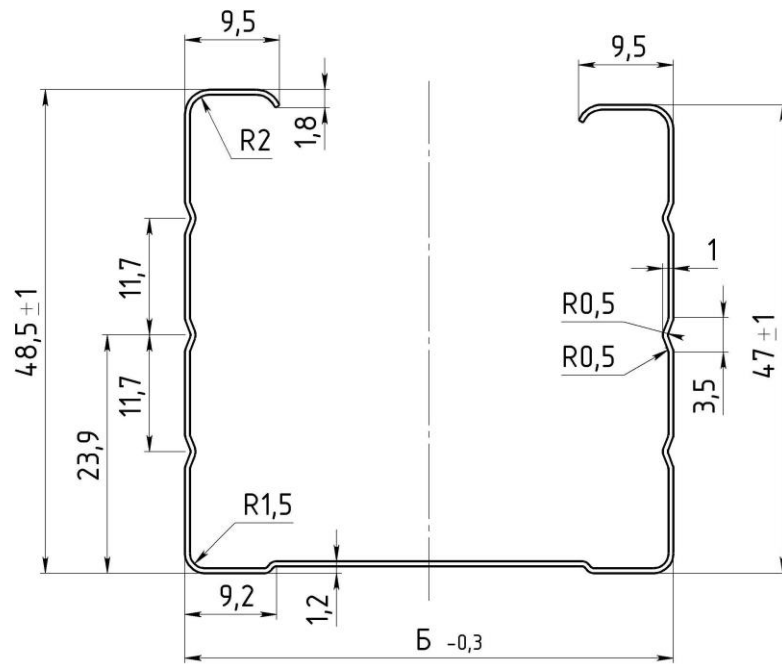


Table 2. Dimensions in mm

B	Flat pattern
48	160,5
73	185,5
98	210,5

Fig. 1.

## Equipment Specification

<b>Nº</b>	<b>Description</b>	<b>QTY</b>	<b>UOM</b>
<b>1</b>	<b><i>C channel 50x50, 75x50, 100x50 roll forming line,</i></b> consisting of :	<b>1</b>	<b>Set</b>
1.1	Decoiler	1	pcs.
1.2	Roll forming section	1	pcs.
1.3	Guillotine (integrated into roll forming section)	1	pcs.
1.4	Receiving table (stacker)	1	pcs.
1.5	Automatic Control System (ACS)	1	pcs.
1.6	Supervised installation and commissioning	1	ea.

### Options:

1	<i>Flying cut-off (for increasing roll forming speed)</i>
2	<i>Punching module Ø8 mm for profile (rotary type)</i>
3	<i>Relief embossing module</i>
4	<i>Protective film application module</i>
5	<i>Protective sliding shutters</i>
6	<i>Emergency stop cable around the perimeter of roll forming section</i>