

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

### **Technical-Commercial Quotation**

*We design and manufacture equipment for creating various profiles for light gauge sheet metal, including custom-made profiles.*

*We offer for your consideration this quote on Double-stream line for production Ceiling channel 60x27 and U channel 28x27 (fig. 1, 2).*

*Equipment is fully designed and manufactured by Ruscana Engineering Group.*

### **Double-stream line for production Ceiling channel 60x27 and U channel 28x27**



*Double-stream line for production Ceiling channel 60x27 and U channel 28x27, hereinafter referred to as Equipment, is intended for producing profiles for wall partitions and suspended ceilings. Technical drawings are at fig. 1 and fig. 2.*

Depending on your requirements for technical characteristics and line productivity, we offer you two Equipment configuration options: **Standard and Premium.**

Raw material requirements:

- zinc coating to range at 100...275 g/m<sup>2</sup>; yield strength 280...350 N/mm<sup>2</sup>;
- strip width for ceiling channel 60x27 (fig. 2) – 122 mm ±1,5mm
- strip width for U channel 28x27 (fig. 1) – 73 mm ±1,5mm
- strip thickness – 0,37 mm...0,7 mm

**Technical characteristics:**

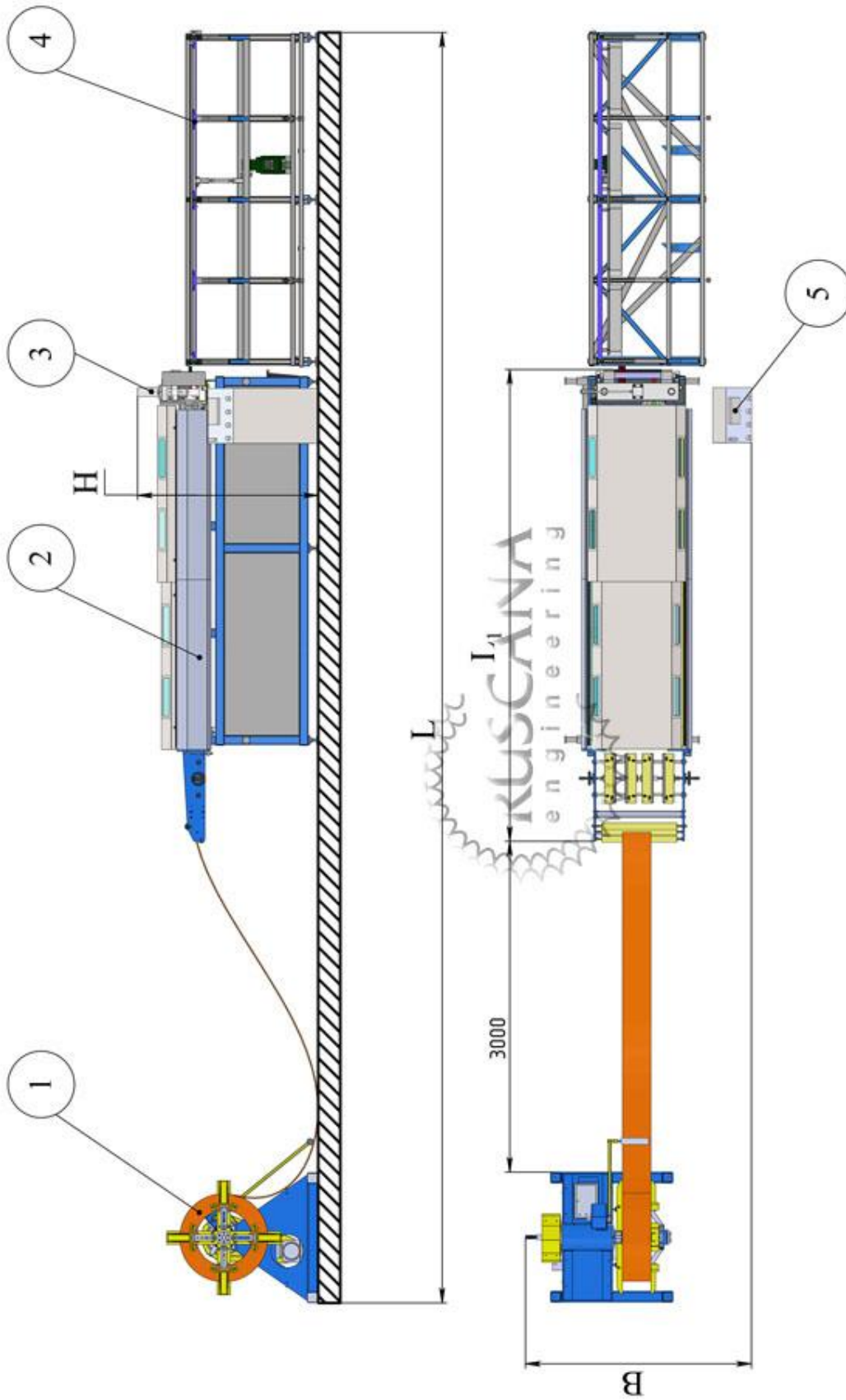
№	Equipment operation requirements and details	Standard	Premium
1	Line operating mode	Manual/automatic	Manual/automatic
2	Roll forming speed (m/min)	20	35...40
3	Installed power capacity, kW	10	11,5
4	Supply voltage, V, at frequency 50 Hz $\pm$ 0.4 Hz	220/380	220/380
5	Dimensions (LxWxH), mm	11600x2100x1700	11600x2100x1700
6	Weight, kg	3400	3600
7	Required operating personnel	1-2	1-2

**Configuration specifications:**

1.	Dcoiler	Standard	Premium
1.1	Type	Cantilevered	Cantilevered
1.2	Feeding speed, m/min (automatically adjusted)	20	40
1.3	Installed power capacity, kW	2,2	2,2
1.4	Operating mode	manual / automatic / reverse	manual / automatic / reverse
1.5	Lifting capacity, kg	2000	2000
1.6	Mandrel expansion range, mm	480...620	480...620
1.7	Mandrel expansion mechanism	Manual, via handle	Manual, via handle
1.9	Dimensions (LxWxH), mm	1300x1400x1400	1300x1400x1400
1.10	Weight, kg	500	500
1.11	Guide rails (2 m ) with 4-wheel supports	+	+
2.	Roll forming section	Standard	Premium
2.1	Feeding speed, m/min (automatically adjusted).	20	35...40
2.2	Installed power capacity, kW	4	4
2.3	Profiling roller die sets	10	10
2.4	Tooling	Instrument steel with heat treatment	Instrument steel with heat treatment
2.5	Protective sliding shutters	+	+
2.6	Dimensions (LxWxH), mm	4300x1000x1500	4300x1000x1500
2.7	Weight, kg	2600	2600
3.	Guillotine	Standard	Premium
3.1	Drive type	Hydraulic	Hydraulic
3.2	Installed power capacity, kW	2,2	2,2
3.3	Flying cut-off	-	+
3.4	Cutting time, seconds	2	1

3.5	Dimensions (LxWxH), mm	450x1000x1700	1300x1000x1700
3.6	Weight, kg	250	400
<b>4.</b>	<b>Receiving table</b>	<b>Standard</b>	<b>Premium</b>
4.1	Type	Stacker	Stacker
4.2	Length of end product, m	1...3	1...3
4.3	Drive type	Electromechanical	Electromechanical
4.4	Installed power capacity, kW	0,55	0,55
4.5	Dimensions (LxWxH), mm	3000x1100x1300	3000x1100x1300
4.6	Weight, kg	250	250
<b>5.</b>	<b>Automatic Control System (ACS)</b>	<b>Standard</b>	<b>Premium</b>
5.1	Hardware	Omron (Japan)	Omron (Japan)
5.2	Controlled parameters: feeding speed, quantity/length of end products, technical cycle downtime control, production task	+	+
5.3	User-friendly interface	+	+
5.4	Indicators: general technical settings, emergency and error alarms	+	+

*Layout of the Double stream roll forming line*

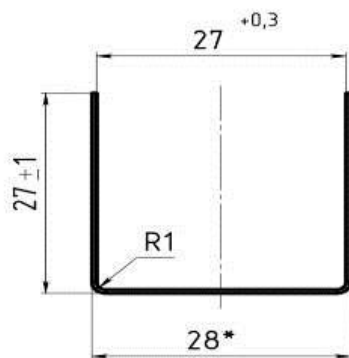


1.	Decoiler			
2.	Double stream roll forming section			
3.	Hydraulic guillotine integrated into the roll forming section			
4.	Receiving table			
5.	Automatic control system (ACS)			

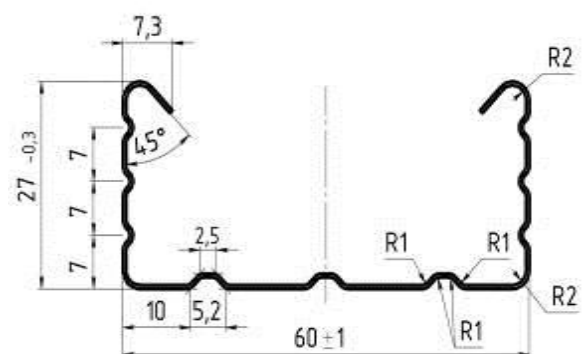
L1	L	B	H
4300	11600	2100	1700



**U channel 28x27**



**Ceiling channel 60x27**



**Fig. 1.**

**Fig. 2.**

**Equipment Specifications**

№	Description	UOM	Equipment Configuration	
			Standard	Premium
			QTY	QTY
<b>1</b>	<b>Double-stream line for production Ceiling channel 60x27 and U channel 28x27, consisting of:</b>	<b>Set</b>	<b>1</b>	<b>1</b>
1.1	Decoiler With 2 m guide rails (with 4-wheel supports)	pcs	1	1
1.2	Roll forming section	pcs	1	1
1.3	Guillotine	pcs	1	1
1.4	Gillotine with drive Flying cut-off	pcs	-	1
1.5	Receiving table	pcs	1	1
1.6	Automatic Control System (ACS)	Ea	1	1

1.7	Supervised installation and commissioning	Ea	1	1
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### List of Imported Components

Components	Manufacturer
<ul style="list-style-type: none"> <li>- Hydraulic pumps;</li> <li>- Control units (distributors, consumption regulators, pressure control valves);</li> <li>- Proportional technology;</li> <li>- Safety valves;</li> <li>- Sealing elements;</li> </ul>	Hydro components, made in Italy
<ul style="list-style-type: none"> <li>- Cylinders;</li> <li>- Distributors;</li> <li>- Service units (filters, moisture separators, lubricators, pressure regulators);</li> <li>- Pneumatic hoses and connectors</li> </ul>	Pneumatic components, made in Italy
<ul style="list-style-type: none"> <li>- Controllers;</li> <li>- Frequency converters;</li> <li>- Encoders;</li> <li>- Inductive proximity sensors;</li> <li>- Control panels;</li> <li>- Relay</li> </ul>	Industrial automation components "OMRON" (Japan)
<ul style="list-style-type: none"> <li>- Shaft bearing units</li> </ul>	"ASKUBAL" (Germany)

### Options:

1	Embossing unit for Ceiling channel 60x27
2	Protective film application module

### Example of relief embossing (optional)

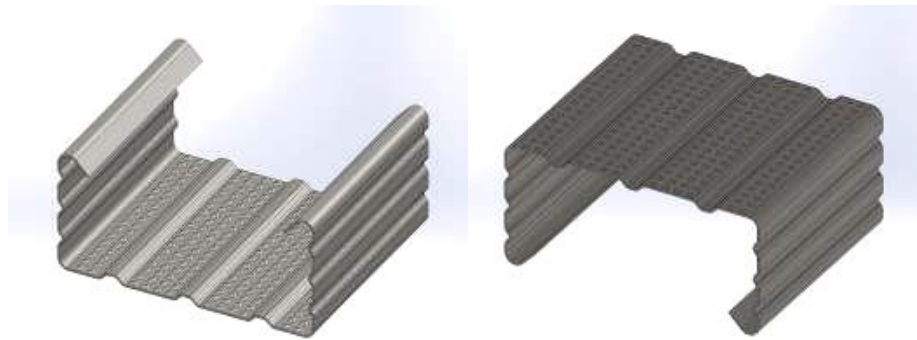


Fig. 3.