

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

### **Technical-Commercial Quotation**

*We offer for your consideration this quotation on Double stream Metal Picket fence II- profile and M - profile roll forming line.*

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

## ***Double stream Metal Picket fence II- profile and M - profile roll forming line.***



Double stream Metal Picket fence II- profile and M - profile **roll forming** line, hereinafter referred to as Equipment, is intended for roll forming galvanized light-gauge sheet metal including polymer coating

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

- zinc coating to range 100...275 g/m<sup>2</sup>
- yield strength 280...320 N/mm<sup>2</sup>
- width – 156 mm;
- thickness – 0,45mm...0,7 mm;

**Technical characteristics:**

№	Description	UOM	«Basic»	«Standard»
1	Line operating mode		Manual	Manual/automatic
2	Installed power capacity no more than	kW	4	7
3	Roll forming speed no more than	m/min	20	20
4	<b>*Electrical supply network</b>	V	380	380
5	Dimensions (LxWxH) no more than	mm	11300x2200x1400	11300x2200x1400
6	Weight no more than	kg	2100	2600
7	Required operating personnel	persons	1 - 2	1 - 2

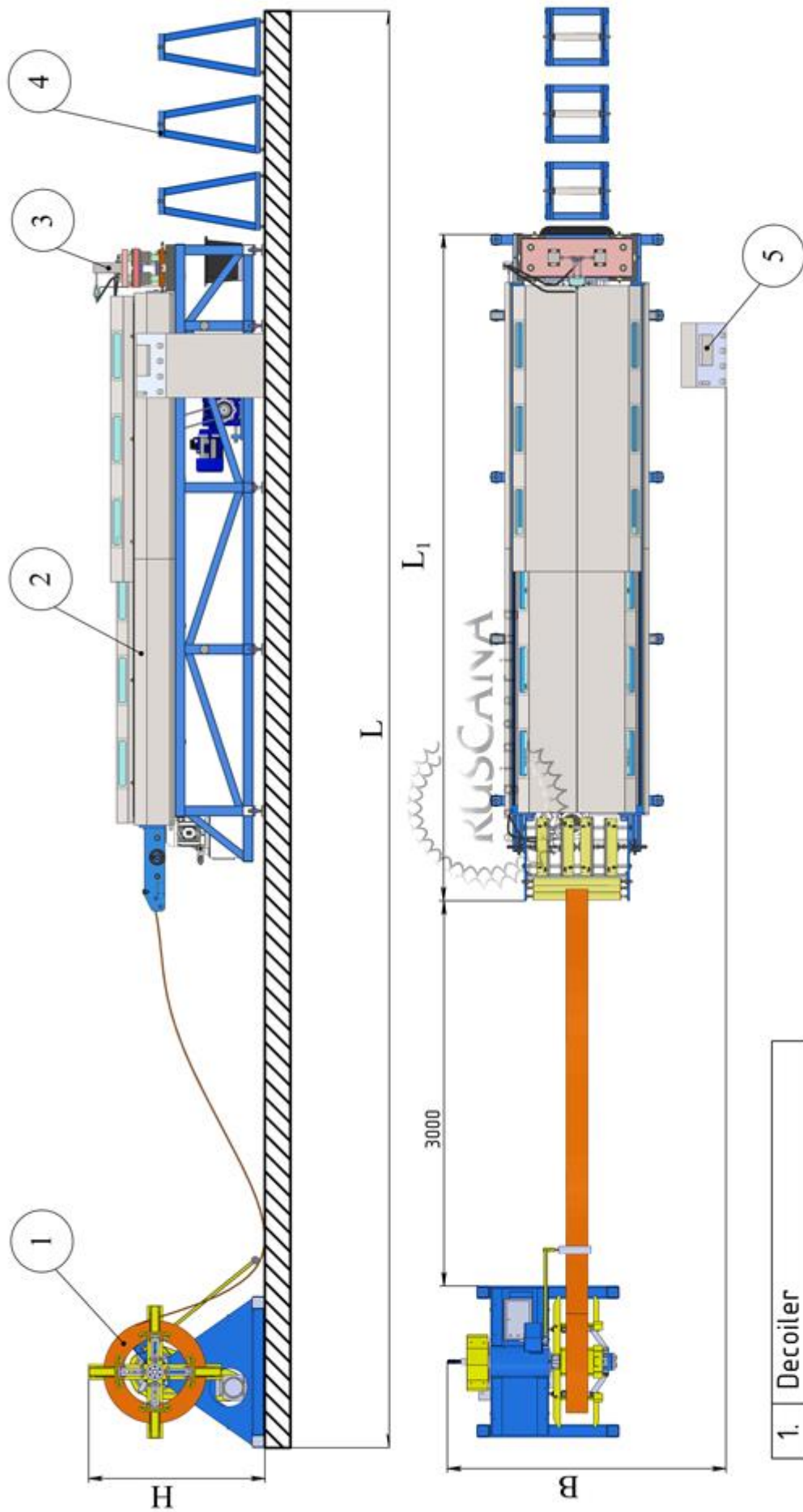
\* **Electrical supply network for countries of North America:** Supply voltage at frequency of 60 Hz, 230V 3 phase

**Equipment Specification:**

1	Decoiler (without drive)	UOM	«Basic»	«Standard»
1.1	Type		-	Cantilevered
1.2	Installed power capacity no more than	kW	-	-
1.3	Lifting capacity, no more than	kg	-	2000
1.4	Dimensions (LxWxH) no more than	mm	-	1300x1400x1400
1.5	Mandrel expansion range, mm Coil ID Ø	mm	-	480...620 500/600
1.6	Mandrel expansion / clamping mechanism		-	Mechanical (by handle)
1.7	Weight no more than	kg	-	450
1.8	Motion set (rails- 2 m, wheel supports - 4 pcs.)		-	+
2	Roll forming section	UOM	«Basic»	«Standard»
2.1	Quantity of mill stands	pcs	6	6
2.2	Dimensions (LxWxH) no more than	mm	4000x1000x1200	4000x1000x1200
2.3	Installed power capacity no more than	kW	4	4
2.4	Roll forming speed	m/min	20	20
2.5	Rollers material		Instrument steel with heat treatment	Instrument steel with heat treatment
2.6	Protective sliding shutters		-	-
2.7	Weight no more than	kg	2100	2100
3	Guillotine	UOM	«Basic»	«Standard»
3.1	Type		-	hydraulic
3.2	Installed power capacity	kW	-	2,2
3.3	Cutting time	sec	-	2
3.4	Set of knives for straight cut	pcs	-	-
3.5	Set of knives for 3D cut	pcs	-	1
4	Receiving table	UOM	«Basic»	«Standard»
4.1	Type		-	Roller base receiving table
4.2	Quantity	pcs	-	3
4.3	Dimensions (LxWxH) no more than	mm	-	490x455x865

4.4	Automatic stacking		-	-
4.5	Weight no more than	kg	-	30
<b>5</b>	<b>Control System</b>	<b>UOM</b>	<b>«Basic»</b>	<b>«Standard»</b>
5.1	Type		Control unit (CU)	Automatic Control System (ACS)
5.2	Hardware		Omron (Japan)	Omron (Japan)
5.3	Controlled parameters: roll forming speed, quantity/length of end products, technical cycle downtime control, production task		- - - - +	+ + + + +
5.4	Interface: English, User-friendly		-	+
5.5	Indicators: General settings, error and emergency alarms		-	+

*Layout of the Double stream Metal Picket fence Roll forming line*



1.	Decoiler
2.	Roll forming section
3.	Guillotine
4.	Receiving table
5.	Automatic control system

Configuration of roll forming line	L1	L	B	H
Double stream	5300	11300	2200	1400

### Metal Picket fence « II- profile »

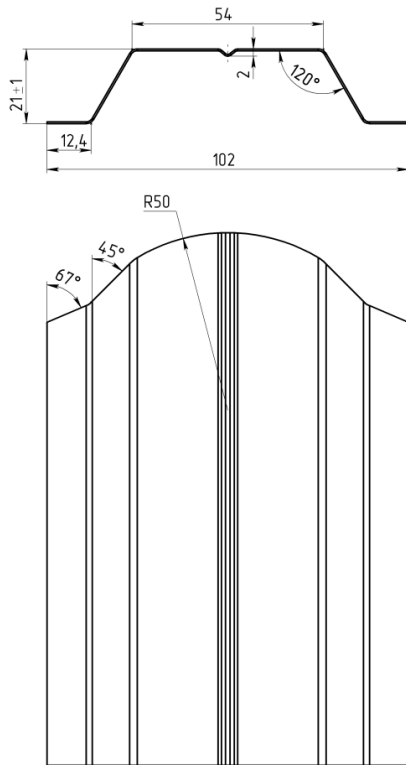


Fig. 1

### Metal Picket fence « M - profile »

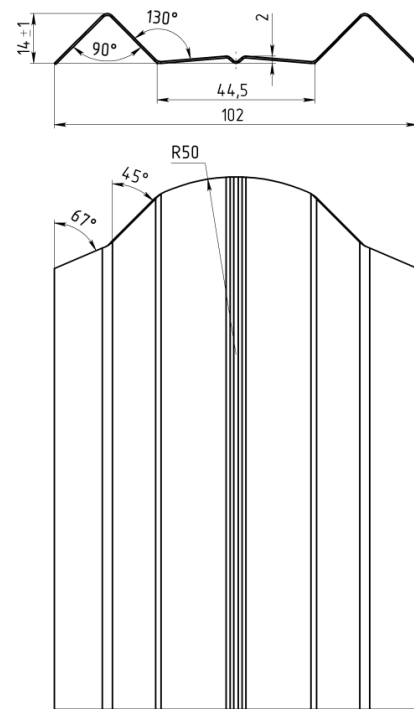


Fig. 2

### Equipment Specification

№	Description	UOM	«Basic»	«Standard»
			QTY	QTY
1	<b>Double stream Metal Picket fence II- profile and M - profile roll forming line, consisting of:</b>	Set		
1.1	Decoiler (without drive) - with motion set (rails 2m and wheel supports 4pcs)	pcs.	-	1
1.2	Roll forming section	pcs.	1	1
1.3	Heat treatment of profiling rollers	ea	-	1
1.4	Guillotine with set of knives for 3D cut	pcs.	-	1
1.5	Receiving table	pcs..	-	1
1.6	Control Unit (CU)	pcs.	1	-
1.7	Automatic Control System (ACS)	pcs.	-	1
1.8	Supervised installation and commissioning	ea	1	1

**Options:**

1	Additional payment for decoiler with drive 1,5 kW
2	Roller base receiving table – 1 pcs.
3	Receiving table (for automatic product stacking) – 1 pcs
4	Protective sliding shutters
5	Set of knives for straight cut – 1set.