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## **Technical-Commercial Quotation**

*We offer for your consideration this quotation on Rounded ridge cap line.*

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

### ***Rounded ridge cap line***

#### **Designation:**

Rounded ridge cap line, hereinafter referred to as Equipment, is intended for manufacturing Rounded ridge cap from galvanized coil including polymer coating. This type of profile is used for roofing as flashing. See profile drawing in fig.1.

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

zinc coating to range 100...275 g/m<sup>2</sup>

yield strength 280...350 N/mm<sup>2</sup>

coil width – **312 mm ±2 mm;**

coil thickness – **0,45 mm...0,55 mm.**

Line operating mode – adjustable / automatic

Installed power capacity , no more than– 10,2 kW.

Supply voltage at frequency of 60 Hz, 230V 3 phase

Dimensions (LxWxH), no more than – 12000x1900x1400 mm.

Weight no more than – 3900 kg.

Roll forming speed, no more than – 5...7 m/min.

Required operating personnel - 1 person

#### **Equipment configuration:**

1.Decoiler

2.Roll forming section

3.Hydraulic press

4. Hydraulic guillotine

5.Hydraulic system

6. Roller base receiving table (Single roller on three-point structure, 3 pcs.)

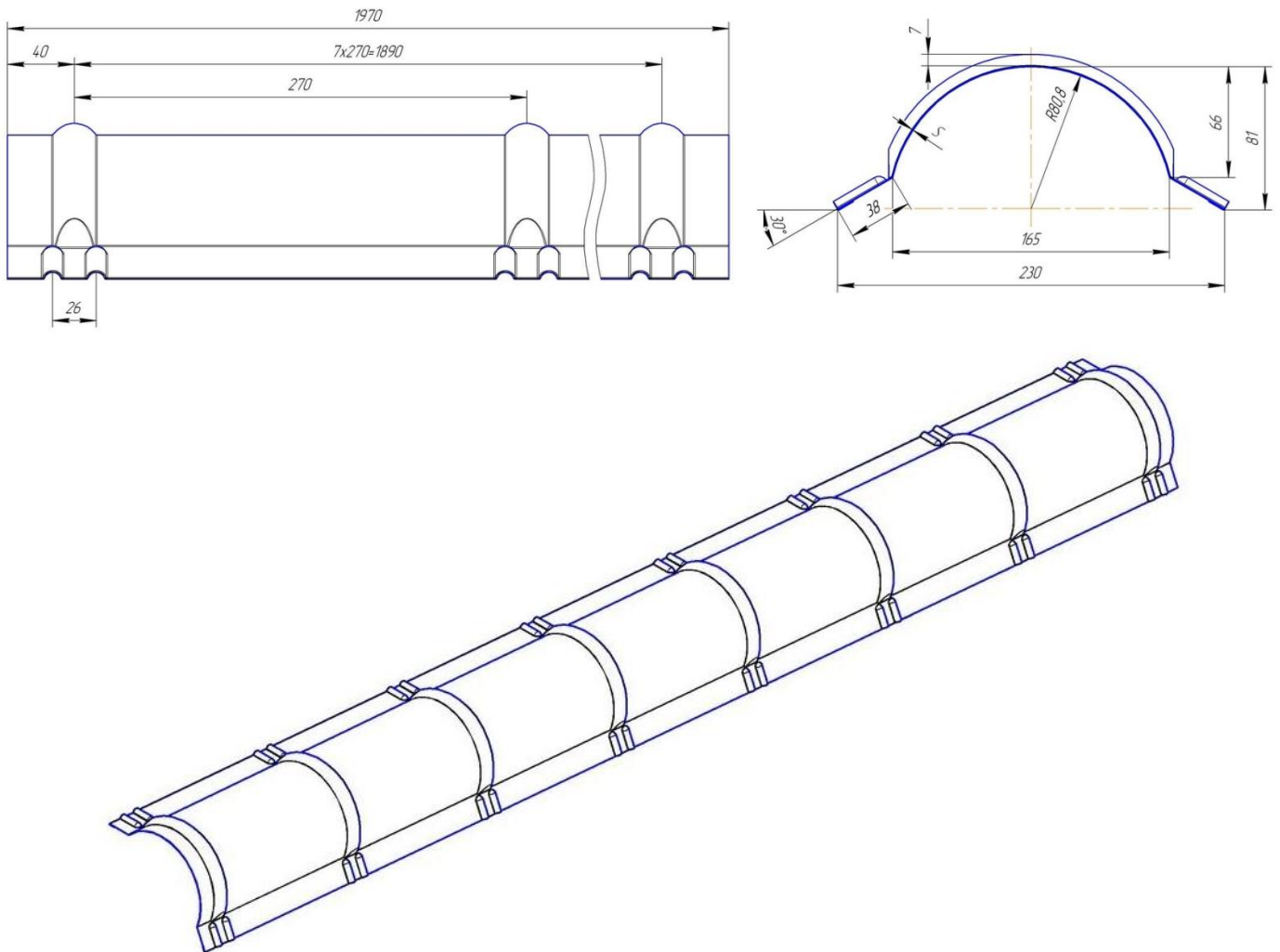
7. Automatic control system (ACS)

**Technical specification:**

<b>1. Decoiler</b>		
1.1	Type	Cantilevered, with electric drive
1.2	Feeding speed, no more than	20 rm/min, automatically controlled
1.3	Operating mode	Automatic, manual, reverse
1.4	Installed power capacity, no more than	2,2 kW
1.5	Lifting capacity, no more than	3000 kg.
1.6	Dimensions (LxWxH), no more than	1600x1900x1400 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	600 kg
<b>2. Roll forming section</b>		
2.1	Roll forming type	In channel bar
2.2	Dimensions (LxWxH), no more than	4500x700x1100 mm
2.3	Installed power capacity, no more than	4 kW
2.4	Roll forming speed, no more	10 rm/min.
2.5	Thickness of the processed metal	0,45 mm...0,55 mm
2.6	Material of rollers	Instrument steel (with heat treatment)
2.7	Quantity of mill stands	10
2.8	Protective sliding shutters	yes
2.9	Weight, no more than	1900 kg
<b>3. Press</b>		
3.1	Type	hydraulic
3.2	Dimensions (LxWxH)	700x700x1700 mm
3.3	Weight, no more than	800 kg
<b>4. Guillotine</b>		
4.1	Drive	hydraulic
4.2	Dimensions (LxWxH), no more than	500x700x1700 mm
4.3	Weight, no more than	250 kg
<b>5. Hydraulic system</b>		
5.1	Dimensions (LxWxH), no more than	800x700x600 mm
5.2	Tank volume, no more than	100 l
5.3	Working pressure, no more than	12 MPa
5.4	Installed power capacity, no more than	4 kW
5.5	Cutting time, stamping time	2 sec.
5.6	Weight, no more than	150 kg
<b>6. Roller base receiving table</b>		
6.1	Type	Single roller on three-point structure - 3 pcs

6.2	Quantity of products	1
6.3	Length of products	1 m....2 m
6.4	Weight, no more than	105 kg. (3 pcs.)
<b>7. Automatic control system (ACS)</b>		
7.1	Hardware base	Omron (Japan)
7.2	Controlled parameters: - Roll forming speed; - Quantity/length of end product; - Adjustment of the pauses of the technological cycle; - Production task - forward - back – stop	+ + + + +
7.3	Interface	English, User-friendly
7.4	Indicators	General settings, error and emergency alarms
7.5	Notification of service intervals	with a list of necessary maintenance service.

**Rounded ridge cap**



**Fig. 1**

### Imported components details

Components kit	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 (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 (Italy)
<ul style="list-style-type: none"> <li>- controllers;</li> <li>- frequency converters;</li> <li>-length 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)

### *Equipment specification*

№	Description	Q-ty	UOM
<b>1</b>	<b>Rounded ridge cap line</b> , consisting of:	<b>1</b>	<b>Set</b>
1.1	Decoiler	1	pcs.
1.2	Roll forming section	1	pcs .
1.3	Hydraulic press	1	pcs .
1.4	Hydraulic guillotine	1	pcs .
1.5	Hydraulic system	1	pcs .
1.6	Roller base receiving table	3	pcs .
1.7	Automatic control system (ACS)	1	pcs .
1.8	Supervised installation and commissioning	1	ea.