

**\*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 quotation on U channel 28x27 roll forming line.*

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

### ***U channel 28x27 roll forming line.***



*U channel 28x27 roll forming line*, hereinafter referred to as Equipment, is intended for producing profiles for wall partitions and suspended ceilings. See profile drawing fig.1

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 100...275 g/m<sup>2</sup>
- yield strength 280...320 N/mm<sup>2</sup>
- strip width, mm – 79 ±0,5;
- strip thickness, mm – 0,37...0,7

**Technical characteristics:**

№	Equipment operation requirements and details	Standard	Premium
1	Line operating mode	Manual/automatic	Manual/automatic
2	Roll forming speed (no more than), m/min	20	40
3	Installed power capacity (no more than), kW	7,8	9,3
4	*Supply voltage at frequency of 50 Hz ± 0,4 Hz	220 / 380	220 / 380
5	Dimensions (LxWxH) no more than, mm	11650x1900x1800	11650x1900x1800
6	Weight (no more than), kg	2300	2500
7	Required operating personnel	1 – 2	1 – 2

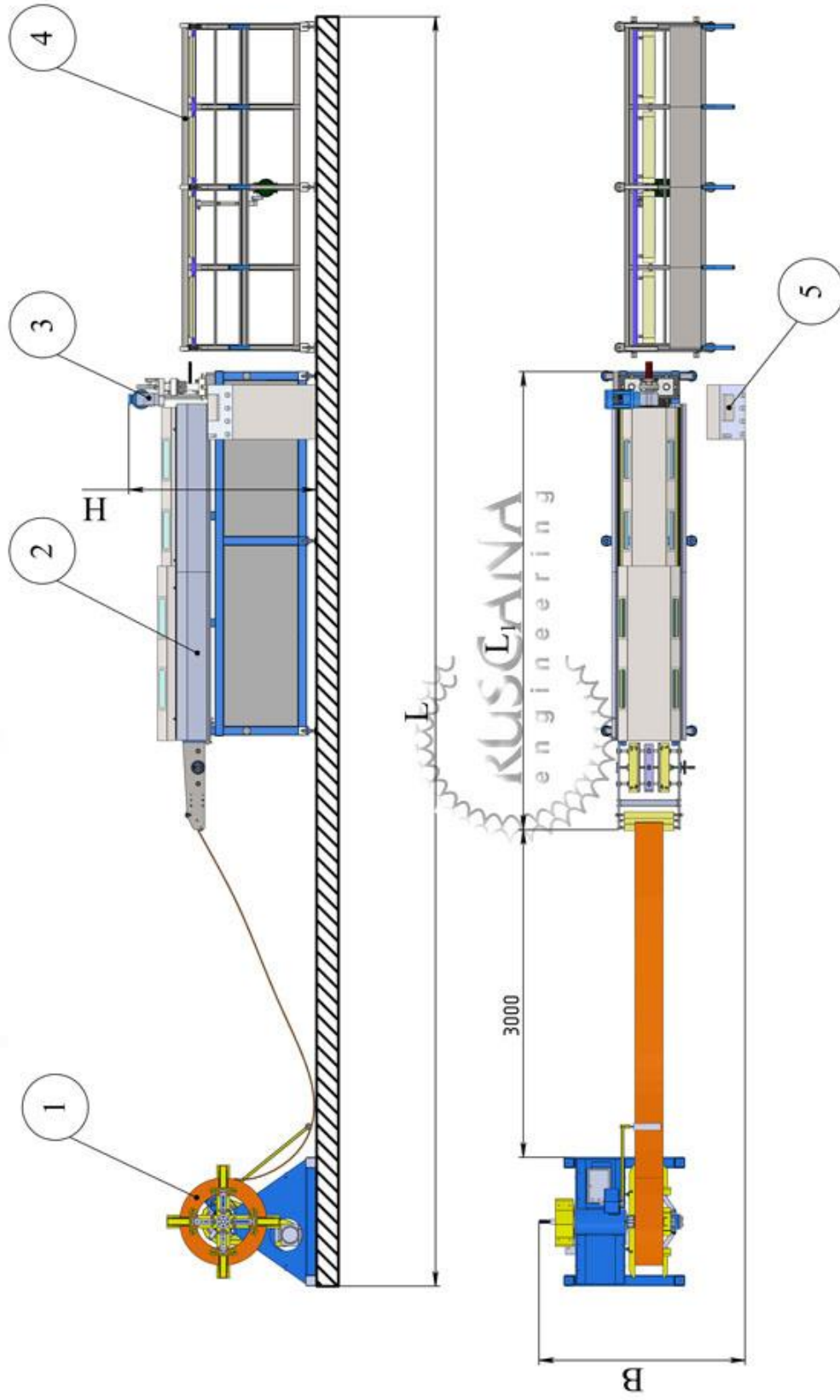
\* Electrical supply network for countries of North America: Supply voltage at frequency of 60 Hz, 230V 3 phase

**Equipment Specification:**

1.	Decoiler	Standard	Premium
1.1	Type	Cantilevered	Cantilevered
1.2	Feeding speed, m/min (automatically adjusted, no more than)	20	45
1.3	Installed power capacity (no more than), kW	2,2	2,2
1.4	Operating mode	manual / automatic / reverse	manual / automatic / reverse
1.5	Lifting capacity (no more than), kg	2000	2000
1.6	Mandrel expansion range, mm	480...620	480...620
1.7	Mandrel expansion / clamping mechanism (by handle)	mechanical	mechanical
1.9	Dimensions (LxWxH) no more than, mm	1300x1400x1400	1300x1400x1400
1.10	Weight (no more than), kg	500	500
2.	Roll forming section	Standard	Premium
2.1	Roll forming speed (automatically adjusted), m/min	20	35...40
2.2	Installed power capacity (no more than), kW	3	4
2.3	Quantity of mill stands, pcs.	10	10
2.4	Rollers material	Instrument steel with heat treatment	Instrument steel with heat treatment
2.5	Protective sliding shutters, serves for protection against the ingress of objects and dust into the roll forming section	yes	yes
2.6	Dimensions (LxWxH) no more, mm	4300x900x1500	4300x900x1500
2.7	Weight (no more than), kg	1400	1400

<b>3.</b>	<b>Guillotine</b>	<b>Standard</b>	<b>Premium</b>
3.1	Drive type	electromechanical	electromechanical
3.2	Installed power capacity (no more than), kW	1,5	3,5
3.3	Flying cut-off	—	+
3.4	Cutting time, seconds	2	1
3.5	Dimensions (LxWxH) no more than, mm	450x1000x1800	1300x1000x1800
3.6	Weight (no more than), 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 (no more than), kW	0,55	0,55
4.5	Dimensions (LxWxH) no more than, mm	3000x1100x1300	3000x1100x1300
4.6	Weight (no more than), 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	Interface: English, User-friendly	+	+
5.4	Indicators: General settings, error and emergency alarms	+	+

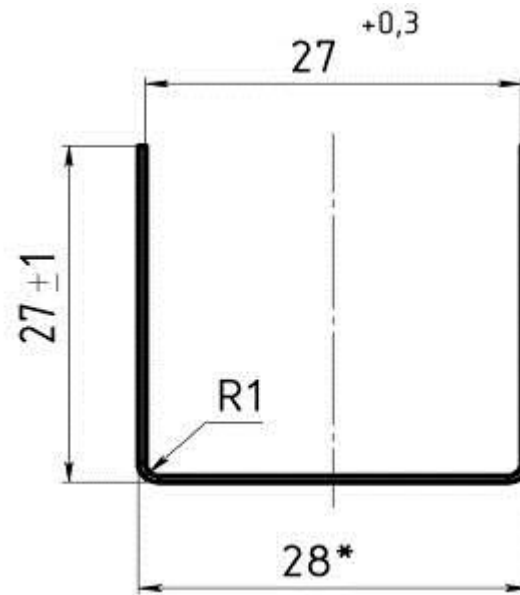
*Layout of the Single stream roll forming line*



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

L1	L	B	H
4300	11650	1900	1800

## *U channel 28x27*



**Fig. 1.**



**Equipment Specification**

№	Description	UOM	Equipment Configuration	
			Standard	Premium
			QTY	QTY
<b>1</b>	<b><i>U channel 28x27 roll forming line</i></b> , consisting of :	<b>Set</b>	<b>1</b>	<b>1</b>
1.1	Decoiler	pcs.	1	1
1.2	Roll forming section	pcs.	1	1
1.3	Guillotine	pcs.	1	—
1.4	Guillotine with drive « Flying cut-off »	pcs.	—	1
1.5	Receiving table ( Electromechanical, stacker)	pcs.	1	1
1.6	Automatic Control System (ACS)	ea.	1	1
1.7	Increase of the roll forming speed up to 35 - 40 m / min	ea.	—	1
1.8	Supervised installation and commissioning	ea.	1	1