

LINIJA ZA PROFILISANJE SA KARDANSKIM PRENOSOM

Linija se sastoji od odmotalice, ravnalice, prese za probijanje otvora, mašine za profilisanje sa centralnim podmazivanjem, hidrauličnih makaza, prihvatnog stola i kontrolnog pulta.

Tehnički parametri:

- Kapacitet odmotalice: 2.000 – 4.000kg;
- Max radna širina: 500mm;
- Unutrašnji prečnik rolne: 480-620mm;
- Pogonska snaga linije: 10,5-37,5kw;
- Brzina profilisanja: 10,5-37,5m/min;
- Tolerancija dužine: ± 1 mm.
- Debljina lima: 0,5-3mm;
- Broj stanica: 10-20;
- Prečnik osovina: 50-70mm
- Materijal osovina: 42CrMo4 28 HRC;
- Materijal noževa: X210Cr12 58-60 HRC;
- Materijal alata za profilisanje: 42CrMo4 nitriran na 64HRC;
- Vrsta prenosa: kardanski prenos;
- Vrsta odsecanja: hidraulične makaze;
- Kontrola procesa: PLC SCHNEIDER ELECTRIC, SIEMENS.

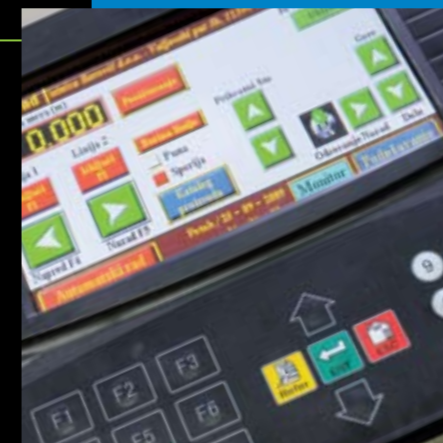


ROLLFORMING LINE FOR PROFILES WITH CARDAN SYSTEMS

The line is consist from decoiler, straightening machine, punching for holes, rollforming machine with colding-emulsion section, hydraulic shear, drop table and operation control panel.

Technical parameters:

- Capacity of decoiler: 2.000-4.000kg;
- Max sheet width: 500mm;
- Internal diameter of roll: 480-620mm;
- Power input of line: 10,5-37,5KW;
- Speed: 10-50 m/min;
- Longitudal cutoff tolerance: ± 1 mm;
- Sheet thickness: 0,5-3mm;
- Number of stations: 10-20;
- Diametar of working shafts: 50-70mm;
- Material of working shafts: 42CrMo4 28 HRC;
- Material of blades: X210Cr12 58-60 HRC;
- Material of tools: 42CrMo4 nitriding 64HRC;
- Power transmission: cardan system;
- Type of cutting: hydraulic shear;
- Operation Control Panel: PLC SCHNEIDER ELECTRIC, SIEMENS.



U-35,3x41	s=1,5mm		U-33x26,5	s=1,5mm		U-36,3x16	s=1,5mm		O-36x27,6	s=2mm	
O-19,5x34,5	s=1,5mm		O-15x30	s=1,5mm		O-28x30	s=1,5mm		U-28,3x22,5	s=1,5mm	
U-41,7x26,3	s=1,5mm		U-35x39	s=1,5mm		U-27x26,5	s=1,5mm		U-38,8x29,6-2	s=1,5mm	
U-30x28	s=1,5mm		U-45x47,9	s=1,2mm		HOP-30x27	s=1,5mm s=2mm		HOP-40x50	s=2mm	
HOP-20x35	s=2mm		B 320x83	s=3mm		U-34x34,5	s=1,5mm		F 84	s=0,7mm	
SV-100x70	s=2mm		HOP-40x45	s=2mm		HOP-40x40	s=2mm		H-32,2	s=0,8mm	
Tip C	s=1,5-2,5mm H=140-210mm		Tip Z	s=1,5-2,5mm H=140-210mm		Tip ••	s=1,5-2,5mm H=175-255mm B=60-70mm		U-30x50	s=1,5mm	
U-41,5x26	s=1,2mm		U-30x28	s=1,5mm		MEC 20	s=0,8mm		MEC 30	s=0,8mm	
U-35x27	s=1,5mm s=2mm		P-30	s=1,5mm		O-30x35	s=1,5mm		S-85x72/52	s=2mm	
Tip C-40	s=1,5mm s=2mm		U-38,8x29,65	s=1,5mm		U-38/33,5x27	s=1,2mm s=1,5mm		U-30,5x27	s=1,5mm	
U-31,5x25/23	s=1,2mm s=1,5mm		U-38,8x17,7	s=1,5mm		O-20x30	s=1,5mm		U-38x25,5	s=1,25mm s=1,5mm	
O-20x38	s=1,5mm s=2mm		U-40x25/16	s=1,5mm		C-41x41	s=2mm s=2,5mm		S-55x69/50	s=2mm	
U-30x26,5	s=1,5mm		U-43x27,5	s=1,2mm s=1,5mm		U-33x29	s=1,5mm		U-30x27x4	s=1,2mm	
U-20x30/5	s=1,5mm		U-25x24	s=1,5mm		SV-86x84	s=2mm		O-30x38	s=1,2mm s=1,5mm	

