

LINIJA ZA PROFILISANJE SA KARDANSKIM PRENOSOM

ROLLFORMING LINE WITH CARDAN SYSTEMS



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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: 10-50m/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 EMERSON CONTROL TECHNIQUES.

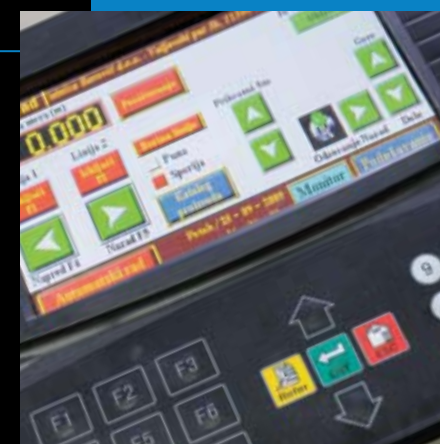
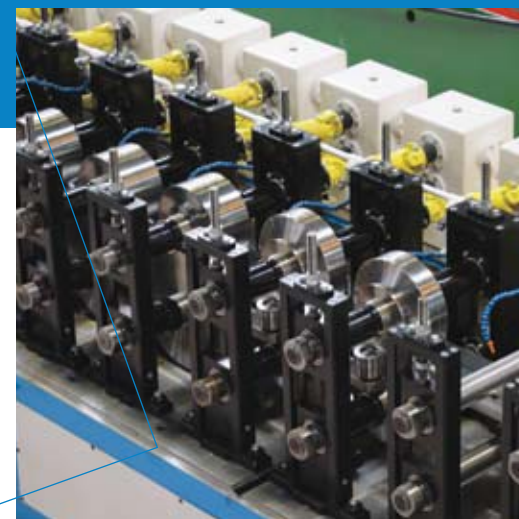


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The line is consist from decoiler, straightening machine, punching for holes, rollforming machine with colding-emulsion section, hydraulic shear, drop table and operation control panel.

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;
- Longitudinal cutoff tolerance: ± 1 mm;
- Sheet thickness: 0,5-3 mm;
- 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 EMERSON CONTROL TECHNIQUES.



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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-28x26,5 s=1,2mm		HOP-30x27 s=1,5mm s=2mm		HOP-40x50 s=2mm	
HOP-20x35 s=2mm		Tip Σ s=2mm		U-34x34,5 s=1,5mm		f 84 s=0,7mm	
HOP-30x30 s=1,2mm s=1,5mm s=2mm		HOP-40x45 s=2mm		HOP-40x40 s=2mm		U-33x27/6 s=1,2mm s=1,5mm	
Tip C s=1,5-2,5mm H=140-210mm		Tip Z s=1,5-2,5mm H=140-210mm		Tip Σ 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		U-35x50 s=1,8mm		O-30x35 s=1,5mm		U-32x30/14 s=1,2mm s=1,5mm s=2mm	
HOP-31,5x30 s=1,5mm		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-30x28,5 s=1,25mm s=1,5mm	
O-20x38 s=1,5mm s=2mm		U-40x25/16 s=1,5mm		U-32x26/12,5 s=1,2mm		U-38x38/16 s=1,5mm	
U-30x26,5 s=1,5mm		U-43x27,5 s=1,2mm s=1,5mm		U-33x29 s=1,5mm		U-33x27x4 s=1,2mm	
U-39x28/16 s=1,5mm		U-25x24 s=1,5mm		U-31x26 s=1,2mm s=1,5mm		O-30x38 s=1,2mm s=1,5mm	

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