

**LINIJA ZA IZRADU OLUKA**

Linija se sastoji od odmotalice, mašine za profilisanje, makaza ili testere za odsecanje, prihvatnog stola i kontrolnog pulta.

Tehnički parametri:

- Kapacitet odmotalice: 2.000kg;
- Max radna širina: 400mm;
- Unutrašnji prečnik rolne: 480-630mm;
- Pogonska snaga linije: 9,5 kw
- Brzina profilisanja: 20m/min;
- Tolerancija dužine: ±1mm.
- Debljina lima: 0,4-0,7mm:
- Broj stanica: 11;
- Prečnik osovina: 50mm;
- Materijal alata: 42CrMo4 nitiran na 64HRC;
- Materijal osovina: 42CrMo4 28 HRC;
- Materijal noževa: X210Cr12 58-60 HRC;
- Vrsta prenosa: lančani prenos;
- Vrsta odsecanja: hidraulične makaze ili kružna testera;
- Kontrola procesa: PLC SCHNEIDER ELECTRIC, SIEMENS.

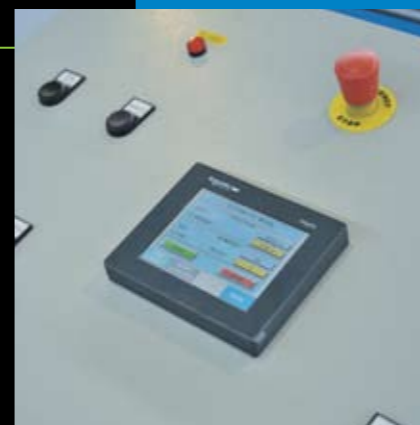
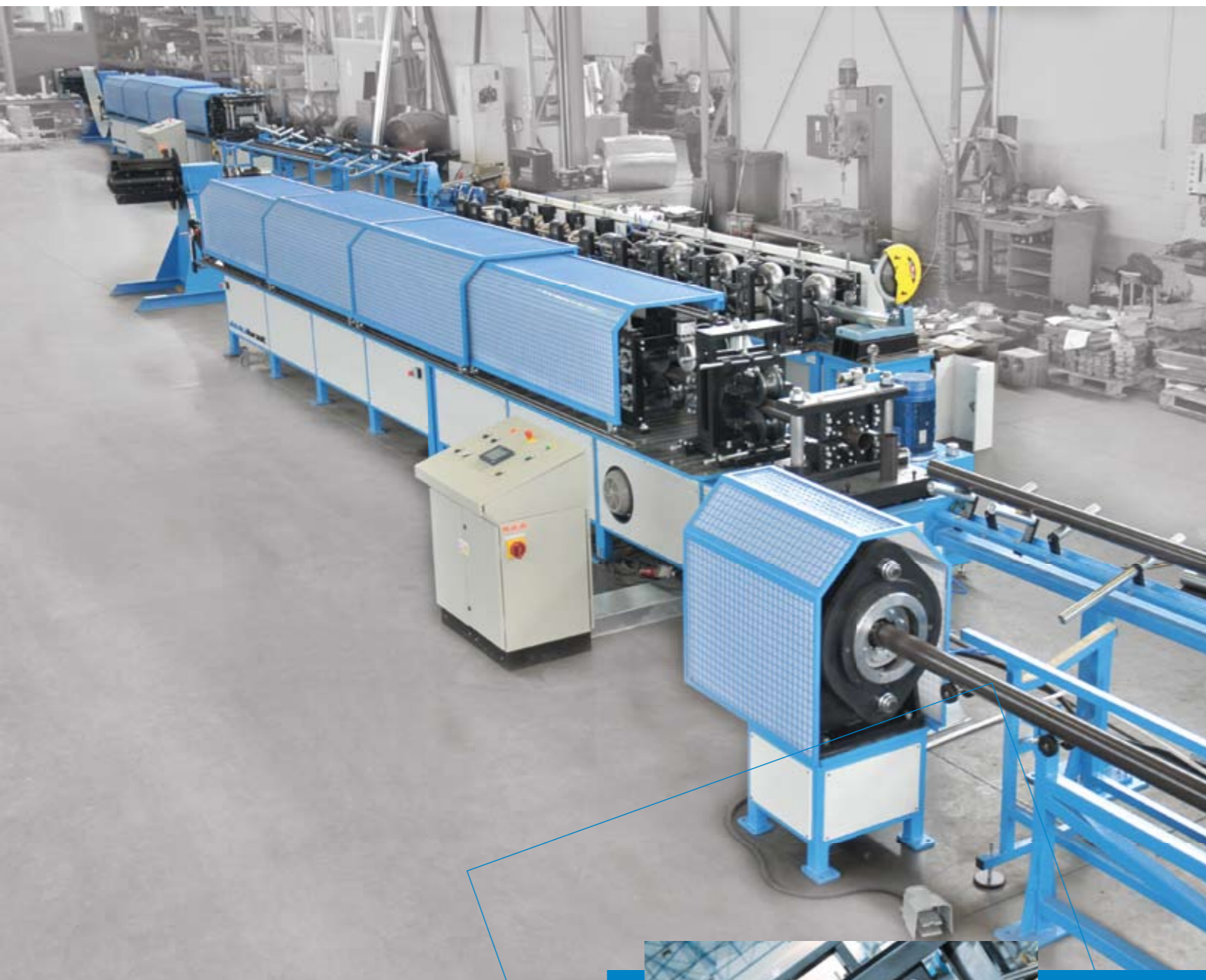
**GUTTER LINE**

The line is consist from decoiler,rollforming machine, cutting shear or saw,drop table and operation control panel.

Technical parameters:

- Capacity of decoiler: 2.000kg;
- Max sheet width: 400mm;
- Internal diameter of roll: 480-630mm;
- Power input of line: 9,5KW;
- Speed: 20 m/min;
- Longitudal cutoff tolerance: ±1mm;
- Sheet thickness: 0,4-0,7mm;
- Number of stations: 11;
- Diametar of working shafts: 50mm;
- Material of tools: 42CrMo4 nitriding 64HRC;
- Material of working shafts: 42CrMo4 28 HRC;
- Material of blades: X210Cr12 58-60 HRC;
- Power transmission: chains system;
- Type of cutting: hydraulic shear or circular saw;
- Operation Control Panel: PLC SCHNEIDER ELECTRIC, SIEMENS.

H25	s=0,4-0,55mm (celicni pocinkovani,plastificirani)  s=0,5-0,7mm (Al neobojeni i obojeni)  s=0,55mm (Cu)		O 110x91	s=0,4-0,55mm (celicni pocinkovani,plastificirani)  s=0,5-0,7mm (Al neobojeni i obojeni)  s=0,55mm (Cu)	
H33	s=0,4-0,55mm (celicni pocinkovani,plastificirani)  s=0,5-0,7mm (Al neobojeni i obojeni)  s=0,55mm (Cu)		H40	s=0,4-0,55mm (celicni pocinkovani,plastificirani)  s=0,5-0,7mm (Al neobojeni i obojeni)  s=0,55mm (Cu)	



**LINIJA ZA SLIVNIK**

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

Tehnički parametri:

- Kapacitet odmotalice: 2.000kg;
- Max radna širina: 400mm;
- Unutrašnji prečnik rolne: 480-630mm;
- Pogonska snaga linije: 13kW;
- Brzina profilisanja: 20m/min;
- Tolerancija dužine: ±1mm.
- Debljina lima: 0,4-0,7mm;
- Broj stanica: 15;
- Prečnik osovina: 50mm
- Materijal osovina: 42CrMo4 28 HRC;
- Materijal noževa: X210Cr12 58-60 HRC;
- Materijal alata za profilisanje: 42CrMo4 nitriran na 64HRC;
- Vrsta prenosa: lančani prenos;
- Vrsta odsecanja: hidraulične makaze ili testera;
- Kontrola procesa: **PLC SCHNEIDER ELECTRIC, SIEMENS.**

**DOWNPIPE LINE**

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

Technical parameters:

- Capacity of decoiler: 2.000kg;
- Max sheet width: 400mm;
- Internal diameter of roll: 480-630mm;
- Power input of line: 13kW;
- Speed: 20 m/min;
- Longitudal cutoff tolerance: ±1mm;
- Sheet thickness: 0,4-0,7 mm;
- Number of stations: 15;
- Diametar of working shafts: 50mm;
- Material of working shafts: 42CrMo4 28 HRC;
- Material of blades: X210Cr12 58-60 HRC;
- Material of tools: 42CrMo4 nitriding 64HRC;
- Power transmission: chains system;
- Type of cutting: hydraulic shear or circular saw ;
- Operation Control Panel: **PLC SCHNEIDER ELECTRIC, SIEMENS.**

V 7	s=0,4-0,55mm (celicni pocinkovani,plastificirani)  s=0,5-0,7mm (Al neobojeni i obojeni)  s=0,55mm (Cu)		O 92x65	s=0,4-0,55mm (celicni pocinkovani,plastificirani)  s=0,5-0,7mm (Al neobojeni i obojeni)  s=0,55mm (Cu)	
V 9	s=0,4-0,55mm (celicni pocinkovani,plastificirani)  s=0,5-0,7mm (Al neobojeni i obojeni)  s=0,55mm (Cu)		V 10 V 12	s=0,4-0,55mm (celicni pocinkovani,plastificirani)  s=0,5-0,7mm (Al neobojeni i obojeni)  s=0,55mm (Cu)	