

## 32 Pass Rollforming Line for the Production of Lighting Trunking



### Performance

Line speed : 4 components / min  
: subject to punching.  
Max component length : 6 metres

Coil - 2000kg x 150mm x 0.7mm Painted Mild Steel

### (P)CD2000.300 DOUBLE SIDED DECOILER

With hydraulic mandrel expansion, scaled mandrel segments to assist in coil positioning, Pneumatic tension and safety brake, Threading drive, Twin motorised pneumatic snubbers and powered rotation. A coil loading car is also employed to load coils in a safe manner.



### PEELER THREADER UNIT

A peeler threader unit is fitted to aid safe loading of the strip. The peeler blade catches the leading edge of the strip and diverts it into the straightener.

### MS59.300 MOTORISED STRAIGHTENER

With integral infeed pinch rolls, 3 over 4 straightening rolls and ingoing self centring guides.

### FRF100-300 SERVO ROLLFEED

Servo rollfeed unit for feeding punch station with accurate lengths for punching operations carried out periodically along components.



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### HYDRAULIC PUNCH SYSTEM

These punch stations are individually actuated via a hydraulic cylinder above each of the 16 stations on the punching system. Specially designed tooling for the desired features in the product are positioned and punched into the flat material as it flows through this station. The parts are then cut to length to travel from the punching rig to the rollforming process.

### AUTOMATIC SLUG / SCRAP REMOVAL

Scrap conveyors remove slugs from the all punch stations within the punching system into suitable receptacles.

### SOUND INSULATED GUARD BOOTH

A noise level attenuating guarding booth is placed over the punching system. The system shown offers 30 dB at noise level attenuation utilising Rockwool filled perforated panels on the internal guarding.



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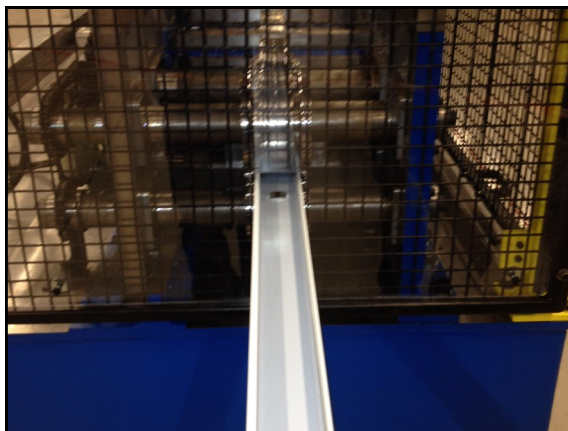
### F1(1.5")-32-ROLLFORMER

A 32 pass rollforming mill with 1.5" diameter shafts. Variable speed low inertia servo drive, with drive transmitted to the forming heads via suitable drive couplings.

The top rolls are all adjustable and the rolling pressure is set at each station via a gauged screw onto a ground setting block. This eliminates the need for lengthy operator intervention periods setting each pass individually when running different gauge materials.

An adjustable entry guide assembly with digital readout is mounted prior to the rollforming head section. This guides notched strip coming from the loop and ensures it is presented correctly to the forming passes.

On the exit of the rollformer there is De-twist unit mounted, to take out any bow or twist which may be induced into the product during the forming process.



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**EXIT CONVEYOR WITH SIDE EJECT**

The roller conveyor is positioned after the rollformer and will consist of an integral take away roll assembly to ensure that the cut component is separated from the following component.

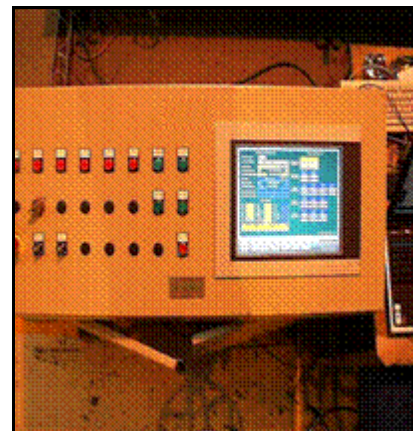
All components below 500mm in length will be diverted to a stillage positioned at the end of the conveyor. Longer products are taken and then side ejected towards the operator assembly jigs.

Scrap components less than 500mm long will be dropped into the stillage with longer scrap components being ejected to the rear of the conveyor system.

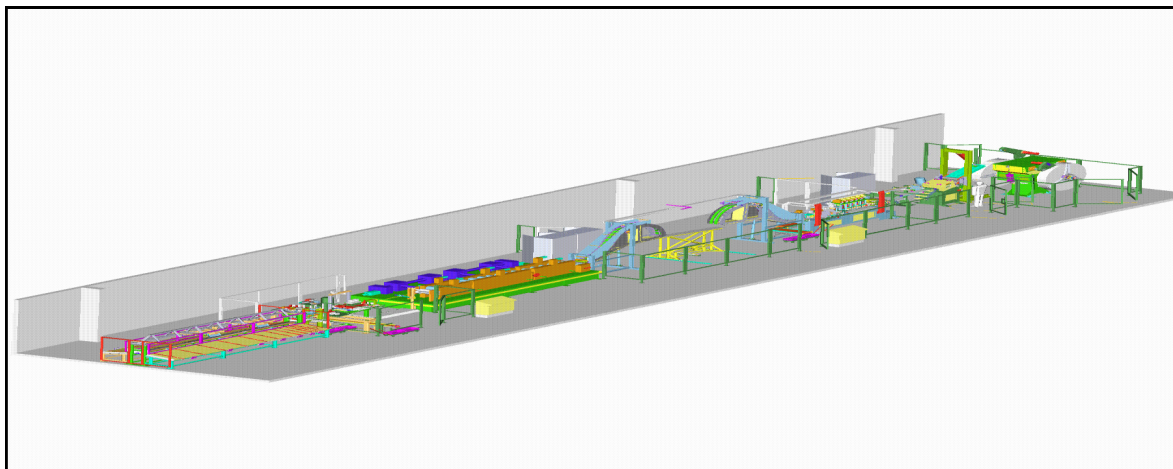
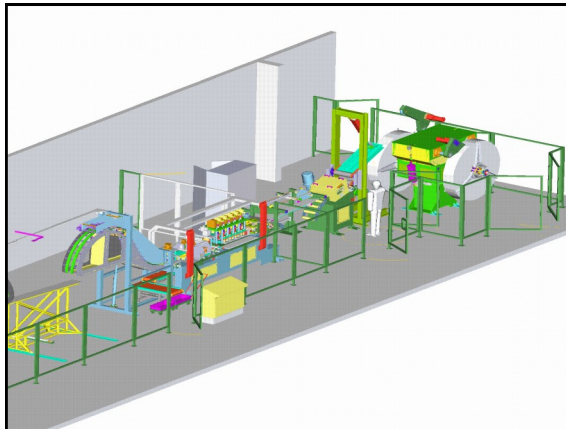
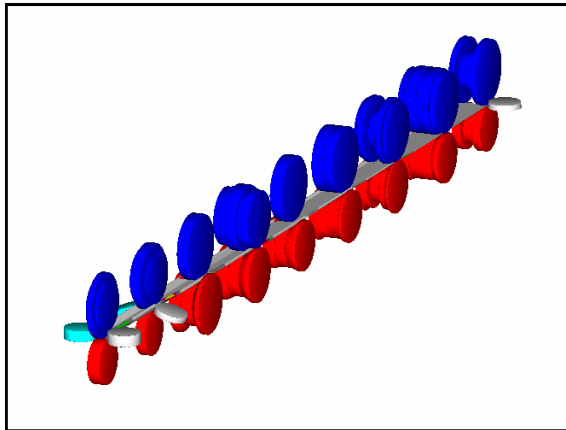
**LINE CONTROLS**

The line control system accepts a list of detail information presented to it by the customers software system, to produce the required components. Controls for the machine are housed in appropriate panel enclosures at the rear of the line, with the main control desk situated at the front of the line.

Wiring between machines and enclosures will be via in-floor trunking.



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### SPECIALISTS IN ROLLFORMING TECHNOLOGY

Formit Ltd is dedicated to meeting your rollforming requirements through the application of the latest CAD Technology.

Since 1989 Formit Ltd has progressed from strength to strength by listening to its customers needs and meeting their expectations in terms of design, delivery and performance.

The strength of engineering skills within Formit give it the ability to supply not only rollforming solutions, but fully integrated turnkey production lines.

Formit will ensure your production line runs to a high quality and provide you with an "on time, on budget" installation.

Formit utilises a full 3D modelling CAD facility and full COPRA rollforming process simulation software by DATA-M. Use of the latest software & the expertise of an in-house "DESIGN AND BUILD TEAM" ensure that all equipment supplied by Formit exactly meets your needs.