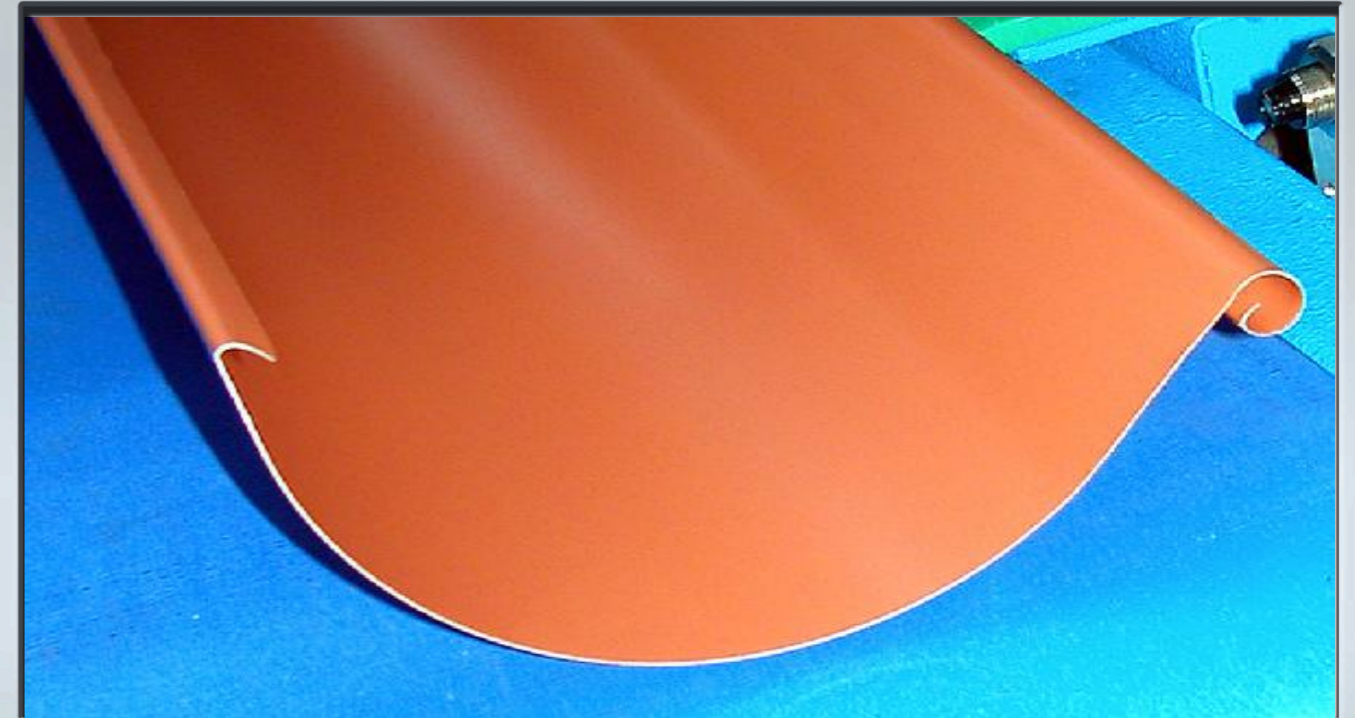


Roll forming line for gutters

54002F	1	DECOILER 3t
M2	2	LOOP CONTROL PROXIMITY TYPE <i>Loop control with proximity coan-pro type</i>
L4	3	GROUP OF PNEUMATIC PRESSURE-ROLLS <i>Group of motorized pneumatic pressure-rolls with free wheel</i>
I5	4	STRIP INTRODUCER
6H	5	HYDRAULIC HEADING SHEAR <i>Hydraulic sheet-heading shear and cutting</i>
I7	6	STRIP INTRODUCER FOR PMD ROLL FORMER
8P	7	ROLL FORMING LINE PMD50/600/16 <i>Roll forming line PMD 50/600/16 12,4 kW</i>
9T	8	INTERMEDIATE CONVEYOR
24001	9	SERIES OF FORMING ROLLS
14B	10	MOTORIZED CONVEYOR 8 m <i>Motorized conveyor 8 m with lateral traslators for sheet insertion in gutter-bending unit</i>
15A	11	GUTTER -BENDING UNIT GR65AP(STILMEC C90)
16A	12	EXTRACTOR FOR GUTTER-BENDING-UNIT
17A	13	FINAL TRANSPORT ROLLS
251-252A	14	CONTROL DESK - ELECTRICAL INSTALLATION

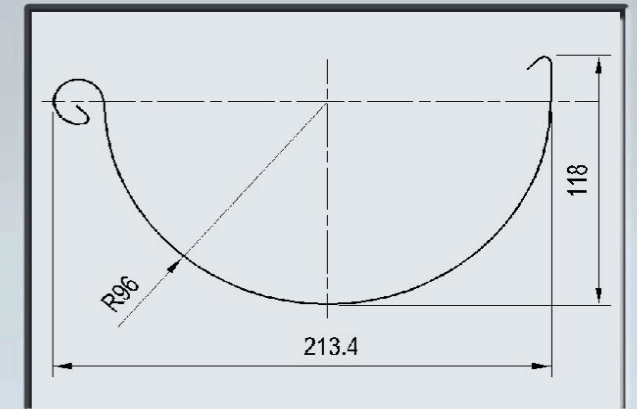
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PRODUCTION LINE Z TYPE GUTTERS


Finished product



Gutter-bending unit



Section of finished product

Roll forming line for gutters

PRODUCTION LINE Z TYPE GUTTERS

Roll forming line for gutters



The production line of Z type gutters is a line expressly dedicated for the production of gutters, with thickness from 0,5 to 0,8 mm, made from various materials.

In the first part of the line we have a decoiler 3 t feeding a roll forming line PMD50/600/16 passages, which makes the flat gutter, on which curls have been formed. A second phase foresees the transport of the semi-finished product to the gutter-bending unit, which terminates the processings of the product. A transport conveyor brings the finished gutters out from the line.



View of the line

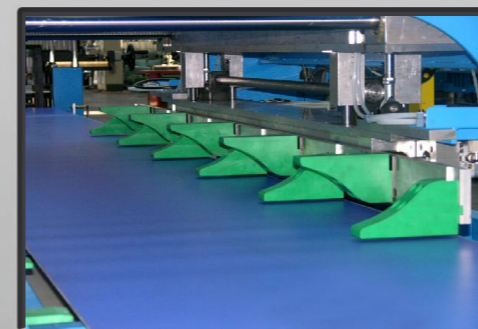
Useful width	600	mm
Decoiler capacity	3	t
Roll forming line max. speed	10	m/min.
Material: pre-painted, copper, zinc titan		
Thickness	0,5-0,8	mm
Gutters with 4 different curl diameters		
Diameter of curls	16-18-20-22	mm
Lengths	4-6	m
Installed power:	30	kW
Absorbed power	24	kW
Air consumption:	300	NI/1



Detail of gutter before the calendering



Detail of roll forming line



Detail of gutter-bending unit



Control desk

56001F

