

Quotation and technology parameter

Feed bin roll forming line

NO.	DESCRIPTION	QTY	TOTAL PRICE FOB	STOCK DETAILS
1	FEED BIN ROLL FORMING LINE WITH HYDRAULIC DECOILER ,CURING MACHINE	1	90000 USD	50 WORKING DAYS
	FINAL PRICE		90000 USD	

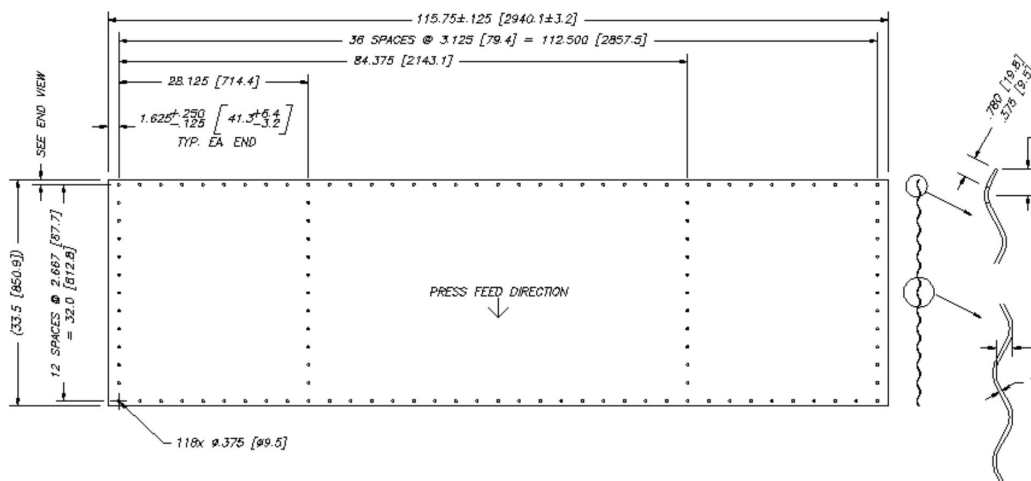


1.The line include: 10 tons Hydraulic decoiler .main roll forming machine. Punch hole machine . With new manual curving machine

2.The new manual machine is free for your company.

3.The punch is Integral punching machine. To make sure the punching position is accurate.

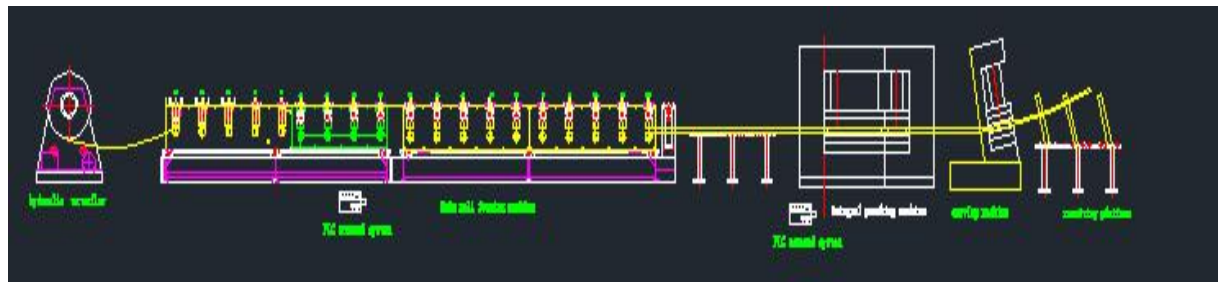
Drawings



Processes and components

10 tons de-coiler with lift truck	x1 set
Main roll forming machine	x1 set
Hydraulic cutting system	x1 set
Integral punching machine	x1 set
New manual adjust Curving machine	x1 set
Hydraulic station	x2 sets
PLC Control system	x2 set
Receive table	x1 set

Working Process (the curving machine is different)



Business remarks:

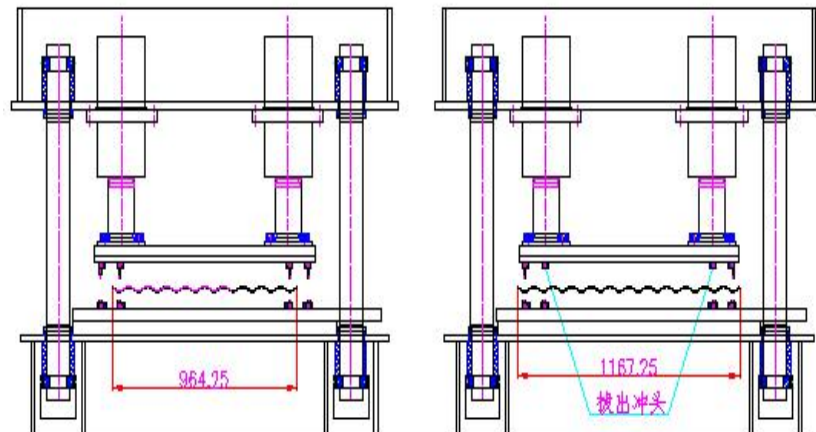
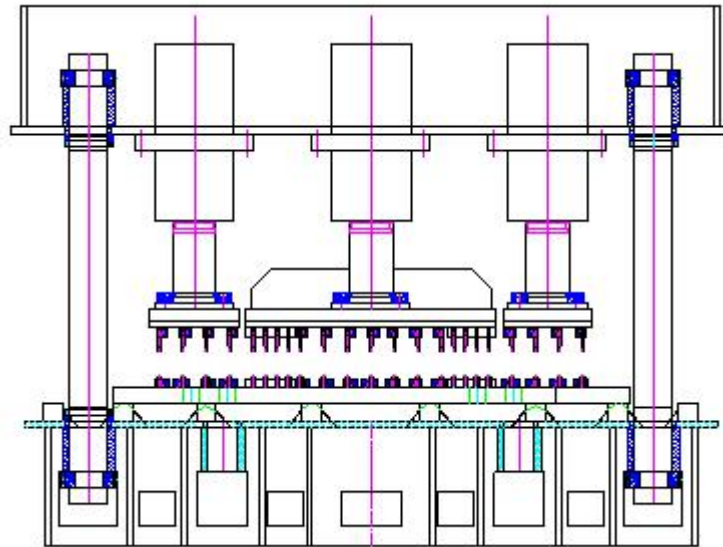
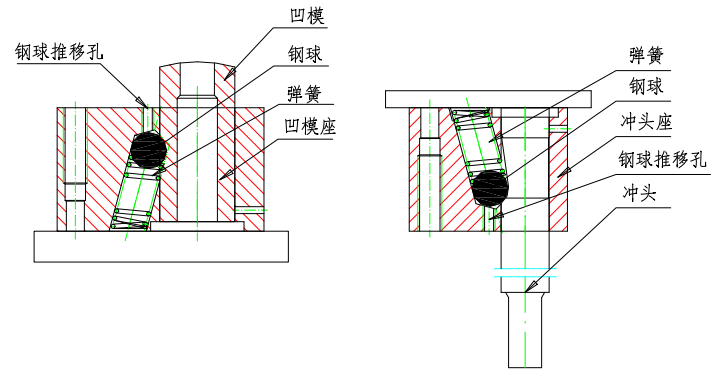
1. Warranty: 12 months since delivery.
2. Payment term: 30% deposit, 70% balance before shipping.
3. Offer validity: 35 days.
4. Producing time: 50 days.
5. Installation locally policy: purchase takes in charge of the cost for installation.
Included: round-trip air tickets, The fee of VISA, accommodation and salary as \$100/day for each engineer.

Technical parameters

10 tons hydraulic Decoiler	1: Max width of raw material :1220mm 2: Capacity: 10kgs 3: Inner diameter of coil: 500-620mm 4. With lift truck
main roll forming machine	1. Material thickness range: 0.91-2.54mm GI 300MPa. 2. Main motor power : 45kw 3. Forming speed about :2-9m/min(not include cutting,punch) 4. Quantity of rollers:20 5. Shaft Material and diameter: \varnothing 120mm, material is 45#steel. Hardening and tempering treatment. 6.Tolerance: 10m+-1.5mm 7.Way Of Drive: Gear box 8.Material of forming rollers: GCrls 9.Material of cutter blade: Cr 12 mould steel 10.: Voltage: 380V/ 3phase/ 50 Hz (as customer require) 11. Receive table 12.H steel foundation with Side plate .

Cutting (hydraulic guide)	<ol style="list-style-type: none"> 1.Cutting motion: The main machine automatically stops and then cutting. After the cutting, the main machine will automatically start. 2.Material of blade: CR12with heat treatment 3.Length measuring: Automatic length measuring 4.Tolerance of length: 10+/- 1.5mm
PLC control system	<ol style="list-style-type: none"> 1. Voltage, Frequency, Phase: 380 V, 50 Hz, 3Phase (or customized) 2. Automatic length measurement: 3. Automatic quantity measurement 4. Computer used to control length & quantity. Machine will automatically cut to length and stop when required quantity is achieved 5. Length inaccuracy can be amended easily 6. Control panel: Button-type switch and touch screen 7. Unit of length: millimeter (switched on the control panel) 8. In the whole line, there will be one control master to control all units. 9.Siemens PLC +DELTA Converter+ Omron Encoder
Integral punching machine	<ol style="list-style-type: none"> 1.Multi-column, gantry structure. Size: 4.5m*2.5m 2.Hydraulic jack*6pcs. Diameter of jack is $\varnothing 160$. 3.Punch Concave die*1pc.Convex die*3pcs. The distance between concave and convex die :1-2mm,2-3mm,3-4.5mm.3 type 4.Punching die in the upper stroke position, can be self-locking, no downtime after the phenomenon of downtime 5.Punching include 3 steps. 6.The use of Japanese-funded enterprises to produce the ball lock standard die technology (see diagram) 7.The die material is SKH51 OR DC53 (same as SKD11) , heat treatment HRC58-62° 8.The die clude be remove repair and fitted back. 9.The punch die could be adjust to punch different hole as drawing. 10.The punch is Integral punch. Side punch first then middle part.this type make sure the hole position accurate. 11.The hydraulic system include filtrating equipment. 12.PLC control punch system.

Integral
punching
machine drawing



New manual
ajust curving
machine

1. Appearance size (mm) : 1020
2. Install method: vertical
3. Angle range: 0~90 degree
4. Speed: 90 degree / 5min
5. Shaft: 5
6. the shaft dia is 120mm , 45#steel
7. Thickness: 0.91mm-2.54 mm
8. Radius min: 1800mm
9. Power: 11KW
10. Rolling material : forging steel 45#

	Coated chromed
	11. Manual adjust curving diameter .

Reference photo:





