

C - DESCRIPTION OF LINE

1 - ASSISTED UNWINDING STATION (DA03V/06-142):

This is made up of an assisted unwinder with vertical shaft (DA03V/06-142) adapted to the specifications of the customer's coils.

The specifications of the different drums used are as follows:

- Weight of coil: max. 300 kg
- inside Ø of coil: approx. Ø 600mm
- min. outside Ø of coil: approx. Ø 1,200mm

The pressure applied to the pneumatic brake is adjusted via a pneumatic pressure controller on the front panel of the machine.

2 - END OF COIL CONTACT STATION (CFB/06-112):

This is made up of a roller mounted on fixed shaft, a roller mounted on a swivelling roller and an inductive sensor.

When the product is inserted into the machine, the tube should be placed between the 2 rollers.

When the end of the coil is reached, the inductive sensor senses the tipping of the top roller and triggers an emergency stop of the machine.

3 - ROLLER STRAIGHTENING STATION (DRGA/08-012):

This is made up of a set of 5 straightening rollers to pre-straighten the product at the inlet of the machine.

All the rollers are adjustable and fitted with strips preset to the type of product.

4 - FEED STATION (AMEN/01-124):

This is made up of a unit of 4 feed rollers driven by a motor (supplied by EATON) via a reduction gear.

The pressure on the rollers is adjusted via pneumatic pressure controllers on the front panel of the machine (max. 2 bar).

5 - ROLLER STRAIGHTENING STATION:

This is made up of 2 straightening lines each comprising:

- 7 vertical rollers (DRGA/08-046).
- 7 horizontal rollers (DRGA/08-047).

The rollers are dedicated to the specific shape of the profile.

All the rollers are adjustable and fitted with a strip preset to the type of product.

6 - MEASURING STATION (COD/10-059):

This is made up of a lower roller giving the product running height and dedicated to the specific shape of the profile and an upper roller connected to an encoder.

The pressure applied by the roller to the product is obtained by the tension of the spring item 508.

7 - GUIDE STATION (COD/10-054):

This is made up of a vertical support and a guide nozzle allowing for the product to be properly guided between the measuring station and the cutting station.

This assembly is provided to prevent any excessive deformation of the product likely to lead to a product measuring or cutting fault.

8 - WHEEL CUTTING STATION (TMOL/11-023):

This is made up of a wheel type cutting tool and 2 counter rollers. This assembly is driven by a motor thereby allowing the wheel to turn around the tube.

A system comprised of a fork and a cylinder enables the wheel to be fed into the material to be cut.

The infeed of the wheel is adjustable via an adjusting wheel.

9 - LOCKING STATION (BLTR/16-013):

This is made up of a clamp fitted with jaws adapted to the dimensions of the product.

A guide rail and cylinder system provides translation of the clamp in order to free the cut part of the tube.



10 - DISPENSING STATION (DISTR/09-065)

This is made up of a pneumatic linear unit mounted with a clamp provided with a set of jaws adapted to the dimensions of the product.

This assembly is provided to dispense portions of straightened and cut tubes to the EATON shaper.