

## 6 Pass Rollforming Line for the Production of Palisade Fencing



### Performance

Line speed : 12 components / min  
: subject to punching.  
Max component length : 3350 metres

Coil - 2000kg x 100mm x 4mm Mild Steel

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

With manual mandrel expansion, Adjustable tension and safety brake.

### F2(Ø90mm)-6-RAFTED-ROLLFORMER

A 6 pass rafted rollforming mill with Ø90mm diameter shafts. Variable speed drive, with drive transmitted to the forming heads via suitable drive couplings. Rafts for "D-Pale & W-Pale" configurations can be provided for quick changeovers.

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.

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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### 40T FLYING SHEAR & PUNCH UNIT

A heavy duty Flying Shear Unit that matches the section speed and cuts the material to a point and puts the holes at the top and the bottom of the Pale at the same time automatically whilst the line is running.

### EXIT CONVEYOR WITH SIDE EJECT/SPLAY

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.

The unit then side shifts the cut Pales and automatically splays the end of the components with a hydraulically actuated splaying system.

The finished sections then are presented to the machine operator for packing / banding on a stacking table.

### LINE CONTROLS

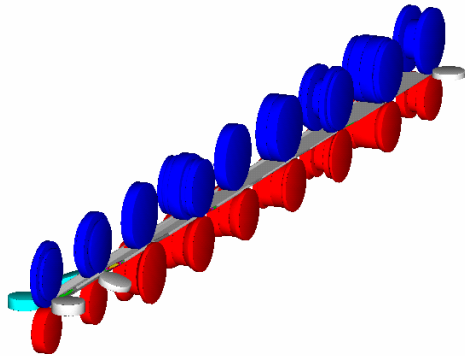
The line control system enables the operator to select the cut lengths and produce the required components in batch quantities controlled by the machine.

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.

