

Semi Automatic G.I. Sheet Cut to Length Line Machine

General Specification

MATERIAL	G.I. COIL (FULL HARD)
COIL WT.	5,000 KGS.
COIL WIDTH	1,000 MM.
SHEET THICKNESS	0.10MM. - .60 MM.
COIL BORE	508MM.
CUTTING LENGTH	1,830MM. - 3,660 MM.
PACKING WT.	3 TON - 5 TON

List of Machinery

DECOILER SHAFT

PINCH ROLL ASSEMBLY

LOOPING DEVICE

FEEDING ROLL CUM SHEAR ASSEMBLY

HEIGHT ADJUSTABLE PILING TABLE

AIR COMPRESSOR

ELECTRICAL CONTROL PANEL

NO. OF SHEETS PER MIN. TO CUT	18 X 1,830 MM. LONG
LENGTH TOLERANCE	± 1.0 MM.

Machine Details

PINCH ROLL ASSEMBLY

FUNCTION	TO FORWARD THE SHEET FROM PAY-OFF REEL TO LOOP PIT
BOTTOM PINCH ROLL SIZE	200 MM. X 1,150 MM.
TOP ROLL SIZE	200 MM. X 1,150 MM.
PINCHING SYSTEM	BY AIR CYLINDER
PINCH ROLL MATERIAL	
BOTTOM ROLL	EN8 ROUND WITH SURFACE HARDENED
TOP ROLL	EN8 ROUND WITH 10MM THICK RUBBER LINING
DRIVE	10 HP V.V.V.F. DRIVE WITH PLANETARY GEAR BOX RATIO 10:1
PINCHING SYSTEM	BY AIR CYLINDER
SIZE OF AIR CYLINDER	125 BORE X 50MM. STROKE, MANUAL CONTROL MANUAL

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DIRECTION CONTROL VALVE AND PR. CONTROLLER PINCH ROLL WILL BE OPERATED BY LOOP PIT SENSOR

LOOPING DEVICE

NO. OF ROLLERS FOR LOOP BRACKET	3 EACH FOR PINCH ROLL EXIT AND FEED ROLL ENTRY SIDE.
SIZE OF ROLLERS	40 DIA. X 1,150 MM. BARREL LENGTH
ROLLER SURFACE COATING	HARD CHROME COATING
BRACKET CONSTRUCTION	SUPPORTING STANDS ARE FABRICATED WITH M.S. PLATE

FEEDING ROLL CUM SHEAR ASSEMBLY

FUNCTION	TO FEED THE SHEET FROM LOOP PIT TO SHEAR
BOTTOM FEED ROLL SIZE	130 MM. X 1,150 MM.
TOP ROLLER SIZE	130 MM. X 1,150 MM.
PINCHING SYSTEM	BY AIR CYLINDER
SIZE OF AIR CYLINDER	125 BORE X 50MM. STROKE, MANUAL CONTROL
BOTTOM ROLLER MATERIAL	EN-8, SURFACE HARDENED AND CRINDING FINISH
TOP ROLLER MATERIAL	EN-8 ROLLER WITH 10 MM. THK NEOPRENE RUBBER LINING
ROLL STAND MATERIAL	C.I.
DRIVE	AC SERVO MOTOR 36NM WITH GEAR BOX RATIO 5:11
MOVEMENT OF TOP ROLL	BY DOUBLE AIR CYLINDER WITH SOLENOID OPERATED VALVE.
CYLINDER BORE & STROKE	125 B X 50 ST
MAX ROLLER SPEED	100 M/MIN
** HOLDING PAD WILL BE PROVIDED TO HOLD THE SHEET WHILE THE TOP FEED ROLL WILL BE IN UPPER POSITION.	
TYPE OF SHEAR M/C	MECHANICAL DOWN CUT SHEAR ACTUATED BY CLUTCH BRAKE MOTOR
BODY MATERIAL	M.S. PLATE STRUCTURE, FABRICATED.
CUTTING RANGE	0.60 MM. X 1,000 MM.(MAX.)
BLADE SIZE	18 MM. THICK X 60 MM. (W) X 1,150MM.
BLADE MATERIAL	HIGH CARBON HIGH CHROMIUM TOOL STEEL
MOTOR INPUT	3.7 KW., A.C. PLANETARY GEARED MOTOR WITH CLUTCH BRAKE COMBINED UNIT.

AFTER ACHIEVING PRE-SELECTED LENGTH THE FEED ROLL WILL STOP AND THE SHEAR WILL CUT THE SHEET. AFTER CUTTING OPERATION WHEN THE UPPER BLADE WILL GO UP AND SENSE THE PROXIMITY SWITCH MOUNTED ON THE SHEAR FRAME, THE FEED ROLL WILL AGAIN START TO FEED THE PRE-SELECTED LENGTH OF SHEET

HEIGHT ADJUSTABLE PILING TABLE

TYPE	STATIONERY TABLE TYPE
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TABLE SIZE	1,000MM. X 3,800MM.(L)
CONSTRUCTION OF THE TABLE	MADE OF 150X75 CHANNEL
HEIGHT ADJUSTMENT	BY MECHANICAL SCREW JACK DRIVEN BY 0.75 KW A.C. PLANETARY GEARED MOTOR.

PILING TABLE HEIGHT WILL BE ADJUSTED WITH THE HELP OF MANUALLY OPERATED LOCAL CONTROL BUTTON.

AIR COMPRESSOR

TYPE	PORTABLE AIR-COOLED SINGLE CYLINDER TYPE.
PRESSURE	MAX. 6-8 KG/SQ. CM.
MOTOR	2.2 KW
AIR LINE IS REQUIRED FOR FOLLOWING MACHINERY :	
HOLDING ROLL UP / DOWN	1 CYL.
FEED ROLL UP / DOWN	2 CYL.
PINCH ROLL	2 CYL.

ELECTRICAL CONTROL PANEL

FUNCTION	TO CONTROL THE LOOP AND CUTTING LENGTH AUTOMATICALLY. IT CONSISTS OF D.O.L. STARTERS FOR HYDRAULIC POWER PACK, COMPRESSOR, A.C. SERVO MOTOR DRIVE AND SENSOR CONTROL.
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LIST OF MOTORS

PINCH ROLL	7.5 KW
FEED ROLL SERVO MOTOR	36 NM.
SHEAR	3.7 KW
CONVEYOR MOTOR	3.7 KW.
PILER	0.75KW.
HYDRAULIC POWER PACK	3.7 KW.
COMPRESSOR	2.2 KW.
BLOWER	3.7 KW

LIST OF SPARE PARTS

SHEAR CLUTCH BRAKE	1 NO.
ENCODER	1 NO.
PROXIMITY SWITCH	1 NO.
SOLENOID OPERATED VALVE	2 NOS.
AIR PRESSURE CONTROLLER	1 NO.

F.R.L.	1 NO.
4KW UNIDRIVE SP WITH PROGRAME MODULE	1 NO.
FEED ROLLER BOTTOM	1 NO.
FEED ROLLER BEARING UCP312	4 NOS.

PICTURES OF Semi Automatic G.I. Sheet Cut to Length Line Machine

