

# ROLL FORMING MACHINES TO PRODUCE SHELVES AND POSTS FOR SHELVING SYSTEMS

## ROLL FORMING MACHINE OP1,0 – 16/700/50/40/1PB TO PRODUCE SHELVES

The machine is designed to produce shelves made of cold rolled strip or galvanized strip for bolted and bolt free shelving systems. The strip is supplied in coils. It starts from uncoiler AOZ 40 and passes through pull compensator into a side bending section where the lateral straightness is stabilized. Then the semi finished product enters punching section integrated with roll forming machine working in freely programmable "START-STOP" regime. The punches cut side openings and notches in the long side of the shelf to be. Behind the punching section follows dividing into full length of the shelf and bending the short ends 90°. Conveyer transports the shelf into a position in between operations and the shelf is transversely pushed onto a table which can hold maximum 15 shelves at a time. From there the operator manually places the shelves into a transport box.

## ROLL FORMING MACHINE OP1,2 – 8/120/7,5/40/1PB TO PRODUCE VERTICAL POSTS

The machine is designed to produce vertical posts/legs for both the bolted and bolt free shelving systems. The posts are made of either cold rolled or galvanized strip and can be fitted into each other. The strip is supplied in coils. From uncoiler AOZ 10 the strip passes through a pushing unit and a compensation loop into a punching section. The amount of remaining coil is monitored. The punching press is followed by roll forming section. Posts are divided by means of a flying shear integrated with with post end-forming in lengths which are multiples of the perforated length.

### TECHNICAL PARAMETERS

Entry material:	Shelves making machine	Posts making machine
Strip in coils DX51 + DC01	EN 10025+A1, EN 10130+A1, EN 10139	EN 10025+A1, EN 10130+A1, EN 10139
Strip width	280 ÷ 680 mm	50 ÷ 120 mm
Strip thickness	0.5÷0.8 mm ± 0.1 mm (FeZn)	0.6÷1.2 mm ± 0.1 mm (FeZn)
Coil mass	max. 4000 kg	max. 1000 kg
Finished product	Shelves for bolted/bolt free systems	Shelves' posts for bolted/bolt free systems
Width / length of product	300 ÷ 600 / 300 ÷ 1200 mm	35.4 ÷ 35.4 mm / 500 ÷ 2500 mm
Basic parameters of machines		
Total installed input	Max. 50 kW	Max. 40 kW
Tolerance of dividing	± 0.5 mm	± 0.5 mm
Dividing system shelves/posts	start / stop	flying shear
Peak short time capacity	type 300×750 mm - 14 pcs/min ±1 pc	length 1500 mm – 18 pcs/min ± 1 pc
machine foot print	18.0 m × 4.0 m × 1.8 m	15.0 m × 2.0 m × 1.8 m

Control of the mills is designed with PLC programmable automaton Siemens. The operator selects the number of pieces of the shelves or posts on the control panel. When this number is reached or when the strip coil is finished, machine stops automatically.

