

Custom C.N.C. 3 – Roll “Specialized” Tube Forming System



WORKING PRINCIPLE:

Our heavy duty 3 roll machine is a symmetrical roll design. The material is entered into the pinch point between the top and lower pinch roll. The entry side form roll is then placed into position for pre-forming the leading edge of the part. The part is then fed into the machine forming the leading edge. After the leading edge is formed the entry side form roll is lowered and the exit side form roll is placed into position to finish forming the part. The total process is one entry one pass forming.

STANDARD FEATURES INCLUDE:

- Top Roll Driven by AC Servo Motor/ Planetary Transmission
- Forming Rolls Positioned via AC Servo motor driving linear actuators
- Pneumatic Drop End For Part Removal
- Remote Control Pedestal
- Variable Speed Adjustment of Rolls
- Roller / Ball Bearings
- Electrical Disconnect
- Welded Steel Construction
- 1040/1045 Solid Steel Rolls
- Safety Cut-off Switch
- Enclosed Drive
- Form Roll Position Indicators
- Top Roll Quick Change System

OPTIONAL INCLUDED:

- Remote Control Variable Speed
- CNC Control System
- Digital Roll Position Indicator
- Surface Harden Rolls 50-54 HRC



FEATURES OF CNC CONTROL SYSTEM

The CNC control system consists of a SIEMENS S7 series PLC configured for closed loop position control via AC servo motors for the material feed and forming operations. The control system is very flexible in programming to form many variations of round and non-round parts. The operator interface is a Touch Screen HMI. The touch screen is capable of storing over 100 part programs of up to 50 forming steps per programs.



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