

3 in 1 Coil Processing Unit

High Quality Product for Coil-Feeding in Press-Room



Better Accuracy

The Straightener Feeder is Motorised through one brushless servo motor & precision gear box.



Easy Cleaning

The large access apertures on the top & bottom make it easy to clean the work rolls, which effectively helps prevent scratch-marks on the material.



Equipment Performance:

- For 3-ton coils in 400 mm wide.
- Strip thickness from 0.5mm to 3mm.
- Feeding Rate up to 100Spm.
- Pitch accuracy: $\pm 0.15\text{mm}$.

Advantages:

- 2.5 meter long one piece base.
- Easy and quick to start up.
- Transferable to another press.



Easy Adjustments

The passline height can be easily adjusted by using the hydraulic jack, & contributes to shorter setup times & better quality.

Easy Handling

The straightener feeder entrance is equipped with Cascade Rollers & side width guides

The straightener feeder exit is equipped with side width guides

The uncoiler is equipped with slide-type side guides & pneumatic hold down





PRESS ROOM AUTOMATION releases its first “3 in 1”, which combines a decoiler and a straightener-feeder driven via servo motor. It targets manufacturers seeking a simple, robust and safe press feeding line with decent performances.

Features:

Decoiler

- Decoiler with variable drive & loop control system.
- 3 or 4 jaw self-centring manual expanding mandrel of welded and stabilized steel.
- Rotation jog mode from main control box.
- Pneumatic Hold-down (Optional snubber and peeler assembly for threading is available on request).
- 6 quick removable coil retaining arm-keepers, adjustable depending on the strip width.

NC Servo Straightener Cum Feeder

- Stabilized Steel frame construction.
- Cascade Rollers @ Entry.
- Gear driven feed roll to ensure non-slip positive feeding.
- Straightener Head consisting of 7 nos Straightening Rollers, 1 Pair of Pitch Roller & 1 Pair of Feeder rollers are provided at entry & exit respectively.

- All upper rolls are individually adjusted with mechanical leadscrews and bevel gearings. The level of upper rolls penetration is shown by position indicators.
- Power transmission to the other straightening rolls via precision spur gears.
- Pneumatic actuated lifting of the set of upper rolls in synchronism with the forming machine to allow entry & self-centring of the strip when working with dies with automatic centering devices (pilot release).
- Exit Width Guide Assembly.
- Permanently sealed precision roll bearings, no lubrication required.
- Motorisation through one brushless servo motor & precision gear box.
- Crocodile opening of the head by lever, for safe & easy roll cleaning, and easy strip insertion.
- Manual height adjustment by hydraulic jack +/- 50 mm of pass-line.

Specifications

Parameters	Model	A-300	A-400	B-400
Width (mm)		300 mm	400 mm	400 mm
Thickness (mm)		0.5 - 2.0 mm	0.5 - 1.8 mm	0.7 - 3.0 mm
Max Coil Weight		1000 Kg	2500 Kg	3000 Kg
Straightening Capacity / Width		2.0 x 300 mm	1.8 x 400 mm	3.0 x 400 mm
Coil OD		1200 mm	1200 mm	1500 mm
Coil ID		430 - 480	508	508
Line Speed (Max)		18	18	15

Features of Control Panel

- Feed Length : 0 to 99999.999 mm
- Speed : 1 to 50 mpm
- Acceleration / Deceleration : 1 to 100%
- Part number : 1 to 99
- Length setting adjustment (from -0.1 mm to +0.1 mm) with 0.01 mm increment
- Servo motor with built in resolver for feed measurement
- Press mode : single stroke or continuous operation
- Feeder before Press (F-P) or Press before Feeder (P-F) selection
- Main switch / Manual operation button / Emergency Stop
- Manual jog programmed feed length for easier tool setting
- Potentiometer for speed regulation of Decoiler
- Diagnosis and display of error messages

Highend Fully Automatic Models with Coil Car, Hydraulic Jaw Expansion, Snubber, Peeler, Pre-Pinch, Auto Side Guide etc are available on request.

The above parameters are for the material having tensile strength 40kgf/mm² max. Models of higher capacity or higher or lower line speeds are available on request.

Technical specifications are indicative and subject to change to suit end application.

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