

Highway Guard Rail Roll Forming Machine

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Highway guard rail roll former price USD98000/set

Highway rail forming machine technology parameters

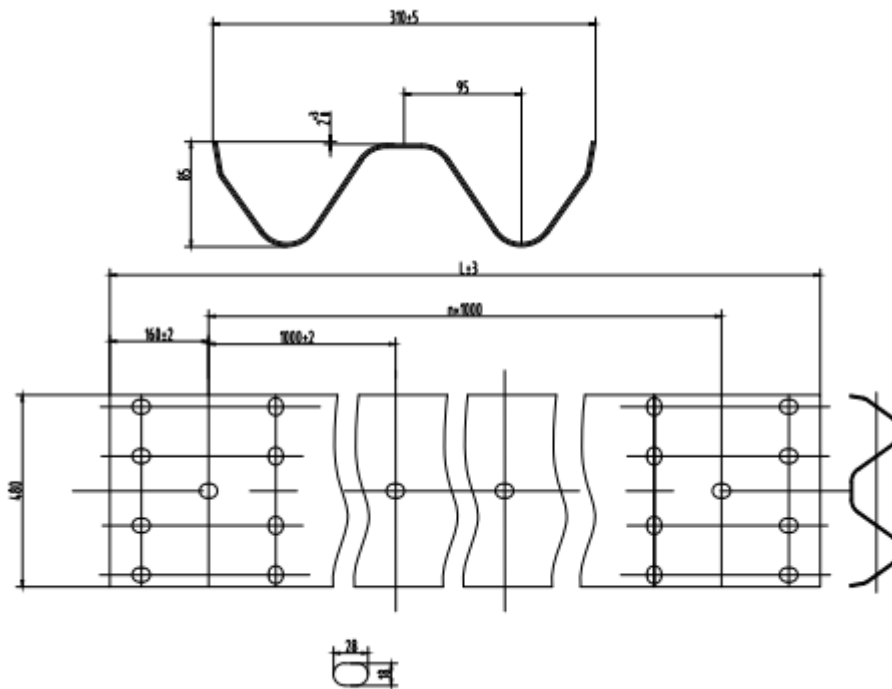
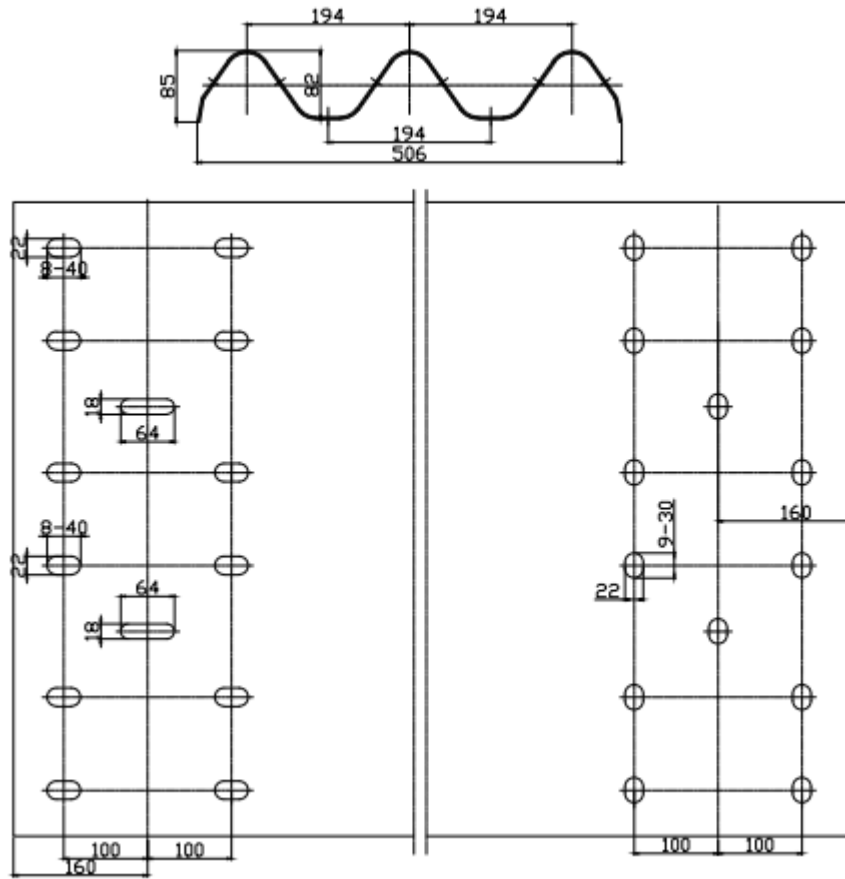
No.	ITEM		PARAMETER	REMARK
1	MATERIAL	Type	Cold-rolled strip steel, galvanized sheet	
		T. (mm)	3.0-4.5mm	
		Yield Strength (Mpa)	Q250-300	
2	Forming product Width		310/506mm	
3	Forming speed (m/min)		8-12m	Including hole
4	Forming main power (KW)		18.5KW*2PCS	FYR
5	Hydraulic power (KW)		30 KW	FYR
6	Voltage		AC380V, 50Hz, 3P	

二、 process

(A) Uncoiler → Guide device → Straightening → Hydraulic press breach device → roll forming machine → hydraulic punch → shear device (including knife) → finished product rack

三、 Plate drawing as below:

Section part Drawing:



四, Machines List

一) Uncoiler

1、 Type: Manual Expansion

2、 Parameter

1) Passive discharge

2) Coil weight: < 7T

3) Coil inner D. : ϕ 508mm- ϕ 600mm

4) Max. Width. 800mm

5) Thickness .1.0-5.0mm



三), Hydraulic hole punching system

3.1 Function: Hydraulic punch breach (Mould 1 set)

3.2 Structure: set the length, automatic length measurement, automatic positioning reaches the set distance stop action , hydraulic cylinder driven punching die, stamping automatic shutdown.

3.3 Hydraulic system working pressure: 16MPa

3.4 Hydraulic station: 30KW (Hydraulic punch hole/shear use same station)

四) Guide device

五) Main Forming machines (for panel width 310/506mm)

- 6.1 Forming Roller: 19 stations, and add Rub-roll, To make sure the surface profile no scratches.
- 6.2 Gateway Panel: T.50mm steel, Heavy duty .
- 6.3 Rolling speeding: **8-12 m/min**.
- 6.4 Roller material: GCr15, overall quenching, hardness HRC56-62 °C.
- 6.5 Motor power: 18.5KW*2PCS.
- 6.6 Main Roller : $\varnothing 95\text{mm}$, 45 #.
- 6.7 Equipment base: 45 # H type using welded steel plate.
- 6.8 Transmission: Gearbox drive.
- 6.9 Security: across the board with emergency stop buttons, easy to handle emergencies, to ensure that equipment and operator safety. And other gear in the chain and the staff could easily lead to injury transmission section covered with protective cover, to ensure the safety of workers.

Photo just for reference





六)、 Hydraulic **Punch Machine** /Follow shear

6.1 Hydraulic Punch machine

6.2 Follow shear (Cut style): Hydraulic cut (No blanking), Machine non-stop can cut product.

Knife material: Cr12, quenching hardness of up to HRC56-58 degrees.

八)、 Flat collect rack , 2m*2pcs

十)、 Electrical control system

The entire line imported PLC control, LCD touch screen, man-machine interface. People interact with the PLC. Operator setting the program to run automatically (programmable control) and

control process monitoring, production line operator control and modify the control parameters, and real-time monitoring the equipment status & parameters and fault indication. Workpiece length digital setting, adjustable length can be adjustable as well. Real-time monitoring of equipment operating status and fault indication.

Operation manual / automatic two styles. With manual and automatic switching function: In the manual mode, can be stand-alone operation, easy maintenance; In automatic mode, carry out full production run, in order to start; across the board with emergency stop buttons, easy to handle emergencies, to ensure that equipment and operating personnel Safety.

** The main components of the brand:

PLC control system: **Siemens**

Inverter: Taiwan Shilin

Encoder: Omron

Touch screen: Siemens

Some components are Schneider brand devices.

Devices:

No.	Machine name	QTY	REMARK
1	Uncoiler	1	
2	Hydraulic machine	1	With mould
3	Guide device	1	
4	Forming machine	1	

5	Hydraulic machine	1	With mould
6	Follow Shear	1	Including knife
7	Collect rack	1	
8	Control system	1	

Brand

No.	Name	Manufacturer
1	Motor & Reducer	Domestic brands
2	The main key bearing	Domestic brands
3	Inverter	Shilin
4	PLC Systems	Siemens
5	Low-voltage electrical	Schneider
6	Encoder	Omron
7	touch screen	Siemens
8	Hydraulic system	Domestic brands