

## Electrical cabinet 9 fold roll forming machine production line

Machine parameter and technology

[9 fold profile forming machine](#) photo



[9 fold profile production](#) process

Uncoiler → Leveling → Automatic feeding → Punching →

Forming → Cutting → Collect

Production speed: 0 -- 6 m / min

1, China standard 9 fold profile detail

Material thickness: 1.2 - 1.5mm

Material: 235MPa yield strength cold rolled sheet

Formed 9 fold profile photo by [roll forming production line](#)



2, Cabinet frame 9 fold production line parameters

1), Uncoiler

3 tons of passive uncoiler

Steel coil for inner diameter: 350 - 450mm

Maximum load of steel coil: 3 tons,

tensioning method: manual tensioning

2), leveling machine

Leveling equipment: 7-roll leveling motor power: 3KW

Thickness adjustment method: screw adjustment and flattening shaft

diameter: 40mm

3), automatic feeding system

Automatic feeding system motor power: about 2KW

4. Hydraulic press

Hydraulic Punch: Hydraulic Punch

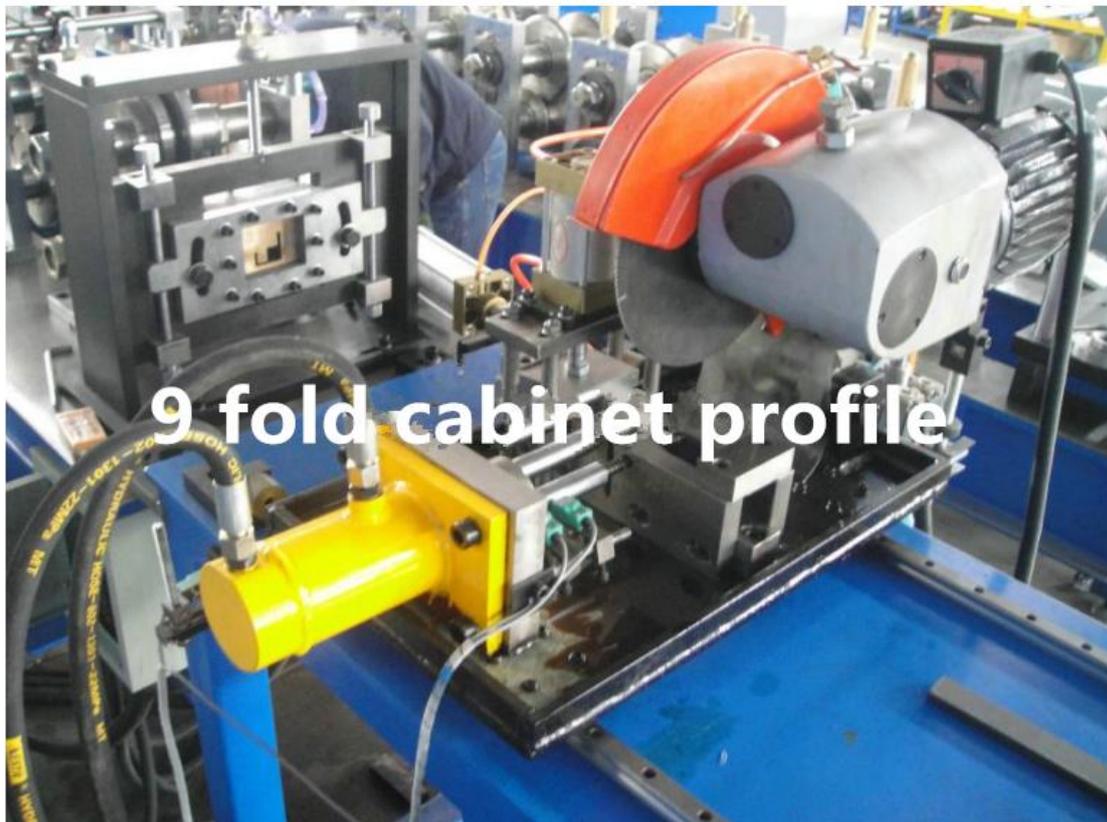
Hydraulic station power: 7.5KW

Number of cylinders: 1 set

Number of die: 1 set

Punching pin material: GCr12mov

Limit: Light sense



5, [Cabinet frame roll forming system](#) parameter

The base is welded by a square tube

Number of roller station: 28 station

Roller shaft diameter: 65mm

Roller shaft material 45#

Roller material: GCr15 fine turning process with quenching

Two sets of 11 KW motors

Forming machine structure: wall panel structure

Transmission mode: industrial drive chain

6, cut off

Cutting method: cut off the flying saw with water cooling

7, Electronic control system,

Speed control: inverter

PLC uses Panasonic brand

Encoder uses Omron brand

Touch screen adopts China Brand Touch Screen

The control system has its own power protection, overload protection, short circuit protection, and its own emergency stop button. (This button can be pressed if an accident occurs, and the device stops.)