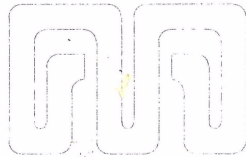


metform



FABRAL CORPORATION

OWNER'S MANUAL

FOR

A ROLL FORMING LINE

METFORM'S WORK ORDER #: MCO 1384

Date: January 1996

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**SECTION
#1**

LINE SPECIFICATIONS

LINE DATA

Material	Commercial Quality Galvanised, Pre Painted, Aluminium and Full Hard (Grade E)
Max Material Width	48"
Material Thickness	.014" Min .0486" Max
Coil Weight	10,000 lbs
Coil Bore	20"
Coil O/Dia	60" Max
Line Speed	30 to 225 FPM
Line Direction	R to L
Electrical Supply	480/3/60
Pass Line Height	43 1/2"
Yield Strength	80,000 PSI Max
Length Accuracy	+/- 1/32"

**SECTION
#2**

EQUIPMENT

EQUIPMENT LIST

ITEM 1	UNCOILER SADDLES-MANDREL
ITEM 2	ROLL FORMER STANDS & SHAFTS LIGHT CURTAIN
ITEM 3	CUT OFF PRESS - 60 TON
ITEM 4	DIE ACCELERATOR
ITEM 5	RUN OUT CONVEYOR
ITEM 6	CUT OFF DIE (LESS BLADES)
ITEM 7	ELECTRICAL PACKAGE

**SECTION
#3**

MACHINERY SPECIFICATIONS

ITEM 1**SINGLE MANDREL UNCOILER**

Mandrel Expansion	Hydraulic
Expansion Range	18 1/2" to 21" with Back Plate (27" Dia) (21 1/2" to 24" with Filler Plates) Coil Keepers 12" High
Drive	Hydraulic Motor via Sonic Loop Control
Hold Down Roll	Included (Undriven)
Base Traverse	± 6"
Traverse Actuation	Hydraulic
Controls	Machine Mounted Payoff Forward/ Reverse, Expand/Contract Also provided at Operator Console

ITEM 2
ROLL FORMER

Type	M3 Universal
Tooling Shaft	4" Dia x 48" Space (Keyway 1/4" x 1/2")
No of Passes	20
Horizontal Centers	16"
Vertical Centers	6 1/4" Min 10 1/4" Max
Base to Lower Shaft Centerline	8 1/4"
Mill Drive	75 HP D.C. Drive
Entry Table	Roller Type - Adjustable for Height
Lubrication Unit	Squeeze Roll Type
Operator's Guard (on operators side)	Light Curtain c/w Transmitter, Receiver and Interlock Control from the Press to the Entry of the Rollformer Interlocked to the Drive
Hold Down Clamps	Clamps on Base of Outboard Stands for Quick Release during Change Over Fabral to Provide Specs. on Clamps
Drive Coupling	Kwikconnect

ITEM 3
CUT OFF PRESS

Type	4 Pillar Undercrank Driven
Capacity	60 Ton @ 1/8" BDC
Stroke	2"
Strokes/Min	50
Crankshaft RPM	260
Lubrication	Auto

ITEM 4
DIE ACCELERATOR

Type	Rack & Pinion with Servo Drive
Die Return	Air Cylinder
Duty	30 Cuts/Minute Max
Accelerator Speed	240 FPM Max

ITEM 5
RUN OUT CONVEYOR

Type	Driven Belt
Conveyor Width	48"
Conveyor Length	30 ft
Belt Drive	Varispeed 60/300 FPM

ITEM 6
CUT-OFF DIE (LESS BLADES)

Fabral shipped set of blades for Metform to match hole pattern on new cut-off die.

ITEM 7
ELECTRICAL PACKAGE

Includes;	Main Operators Console - Located adjacent to Runout Conveyor
	Uncoiler Control Machine Mounted
	Motor Control Centre
	AMS XL 100 CL Length Measuring System with Download Capability.
	Fabral to purchase Remote Terminal and Software from AMS direct
	On Machine Wiring

Fabral to provide incoming electrical service to M.C.C. and all interconnecting wiring.