

PRODUCTION LINE FOR GUTTER ELBOW JOINTS

Production line of laterally seamed elbow joints \varnothing 80x72° - 80x80 - 100x88°

- 54002B 1 **DECOILER 2 T**
Decoiler 2 t - idle - useful width 500 mm
- 55001 2 **STRAIGHTENER USEFUL WIDTH 300 mm**
Straightener w. useful width 300 mm max. thickness 4 mm and 7 straightening rolls.
- 10003 3 **PNEUMATIC FEEDER**
Pneumatic feeder with useful width 400 mm - stroke 400 mm
- 44006 4 **MECHANICAL PRESS 200 t**
- 5 5 **UNLOADING AND STACKING BENCH**
Unloading and stacking bench of pressed pieces with suction cups and bench with automatic descent
- 12101 6 **ELECTRONIC TRANSFER FOR PRESSES**
- 28103 7 **CONTROL DESK**
Control desk with electrical installation.
- A8B 8 **INCLINED CUTTING DIE**
- 9 9 **GROUP OF DIES (FOR ONE MEASURE)**
Group of drawing dies (for one measure) and trimming right-left
- 56201A 10 **SEAMER FOR ELBOW JOINTS**
- 11A 11 **SERIES OF KNIVES, INTERNAL PIECES, VICES**
Series of knives, int. pieces vices f. seaming f. 1 meas.



General view of the line



Finished product



Decoiler



56201D

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The line is made up of two parts. The first one is a pressing line starting with strip where the right or left parts of the joint are executed. The strip is inserted in the press where a suitable mobile die cuts the piece before forming. This cut has a conical form to allow the saving of material. Transfer with 3 arms to pass from the cut to the forming and then trimming (with scrap) and then unloading/stacking. Unloading with automatic descent and automatic displacement of the package. The second part is a seam folding machine to assemble the two parts (right-left) of the elbow. With a hydraulic sequencing the seaming of the two pieces is executed, prepared in the adjacent press.



Detail of dies



Seaming unit for elbow joints

Pressed half-elbow joints on transfer	10-14	pz./min.
Prod. of elbow joints on seaming unit	5	pz./min.
Direction pressing operation:left-right		
Power absorbed by the press	25	KW
Power absorbed by the seaming unit	25	KW
Line colour:	5015	RAL
Material: copper, pre-painted, s.s.		



Finished product



Unloading and stacking bench



Detail of transfer



Control panel

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