

Prod. line for the production of vertically seamed elbow joints $\varnothing 80 \times 72^\circ - \varnothing 80 \times 88^\circ - \varnothing 100 \times 72^\circ - \varnothing 100 \times 88^\circ$

MACHINES

LINE FOR VERTICALLY SEAMED ELBOW JOINT

- 54002B 1 **DECOILER 2 T**
Decoiler 2 t - idle - useful width 500 mm

- 55001B 2 **STRAIGHTENING UNIT USEFUL WIDTH 600 MM**
Straightening unit with useful width 600 mm, maximum 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**

- 251-252 7 **CONTROL DESK W. ELECTRICAL INSTALLATION**

- 8 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**

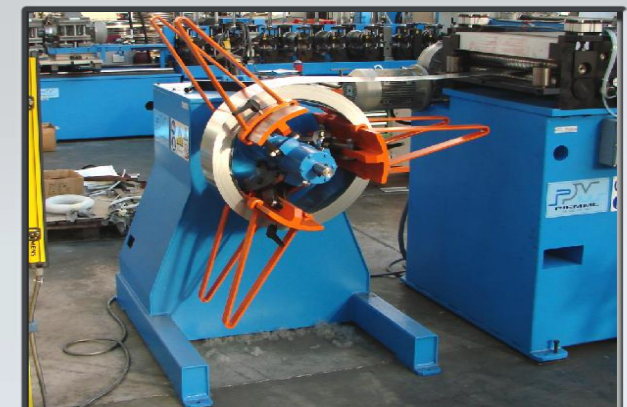
- 11A 11 **SERIES OF KNIVES, INTERNAL PIECES, VICES**
Series of knives, int. pieces vices f. seaming f. 1 meas.



General view of the machine



Finished product



Decoiler



56201B

PM sas
Via Montegrappa, 109
30030 Salzano (Ve) Italy
Tel +39 0415745047
Fax +39 0415745058
www.pm-eng.info
pm@pm-eng.info

Prod. line for the production of vertically seamed elbow joints $\varnothing 80 \times 72^\circ - \varnothing 80 \times 88^\circ - \varnothing 100 \times 72^\circ - \varnothing 100 \times 88^\circ$

LINE FOR VERTICALLY SEAMED ELBOW JOINT

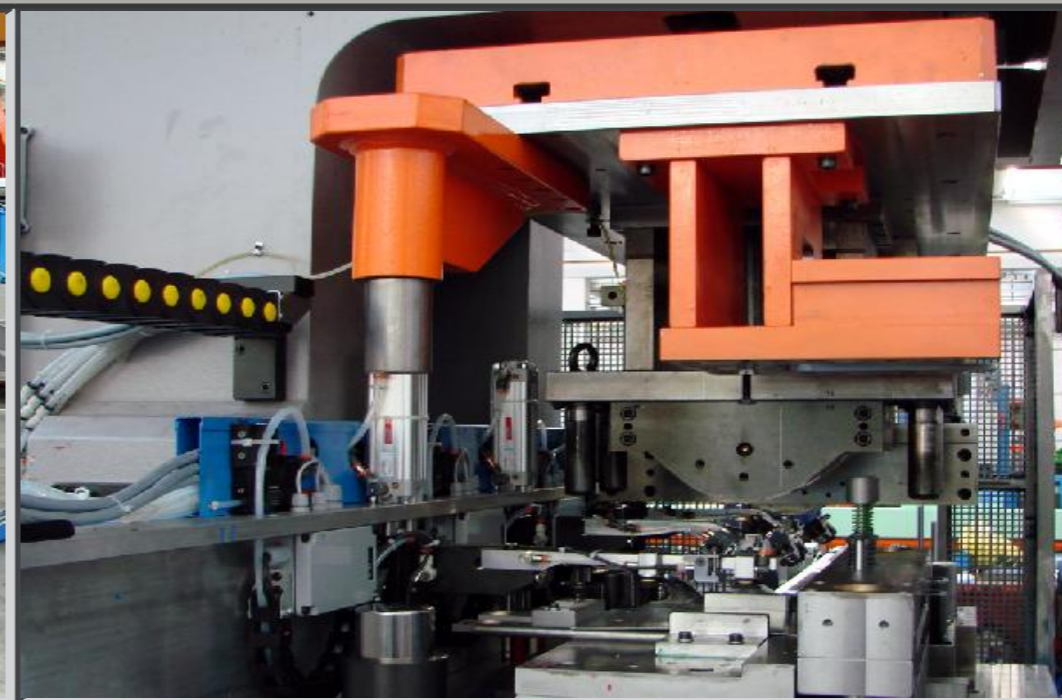
Prod. line for the production of vertically seamed elbow joints $\varnothing 80 \times 72^\circ - \varnothing 80 \times 88^\circ - \varnothing 100 \times 72^\circ - \varnothing 100 \times 88^\circ$



Line made up of two parts.
 The first one is a pressing line starting with a strip to make the right or left part of the elbow. The strip is inserted in the press where a suitable mobile die cuts the piece before forming. Transfer with 3 arms to pass from the cut to the forming and then trimming (with scrap) and then unloading/stacking.
 Unloading stacking with automatic descent and automatic displacement of the package.
 The second part is a seam folding machine for the two parts (right-left) of the elbow. With hydraulic sequencing the seaming of the two pieces is carried out prepared in the adjacent press. This solution as regards to the solution of horizontal seaming of 56201D allows the saving of about 7% of material, and not having seaming on the bottom of the elbow.

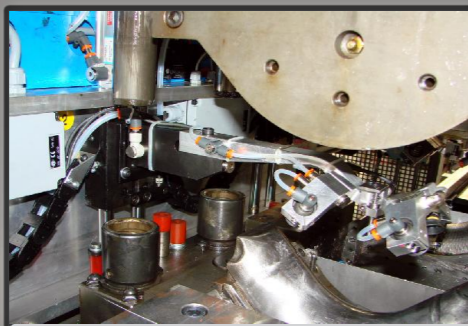


Straightener



View of dies and transfer

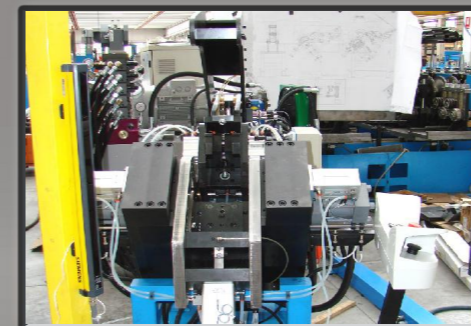
Pressed half-elbow joints on transfer	10-14	pz./min.
Prod. of elbow joints on seaming unit	5	pz./min.
Dir. prod. pressing operation:left-right		
Power absorbed by the press	25	KW
Power absorbed by the seaming unit	25	KW
Line colour:	5015	RAL
Material: copper, pre-painted, aluminium		



Detail of transfer



Detail of dies



Seaming unit



Control panel

56201B

