PRODUCTION LINE FOR GUTTER ELBOW JOINTS	
Production line of laterally seamed elbow joints Ø 80x72° - 80x80 – 100x88°	PRODUCTION LINE FOR GUTTER
54002B 1 DECOILER 2 T Decoiler 2 t - idle - useful width 500 mm	
Deconer 2 t - Idle - Useful width 500 mm   55001 2 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.	General view of the line
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.	Finished product
PN 585 negrappa veitav PN 585 negrappa veitav Via Norsatzin5745058 3000 59 04 157145058 3000 59 04 1571450 5000 59 04 1571450 5000 5000 5000 5000 5000 50000000000	Production line of laterally seamed elbow joints Ø 80x72° - 80x80 – 100x88°
pr.	

### SHEET METAL WORKING MACHINES

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## ER ELBOW JOINTS





Decoiler





# PIEMME

### **PRODUCTION LINE FOR GUTTER ELBOW JOINTS**

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

#### 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 an 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. PIEMME

Detail of dies



Finished product



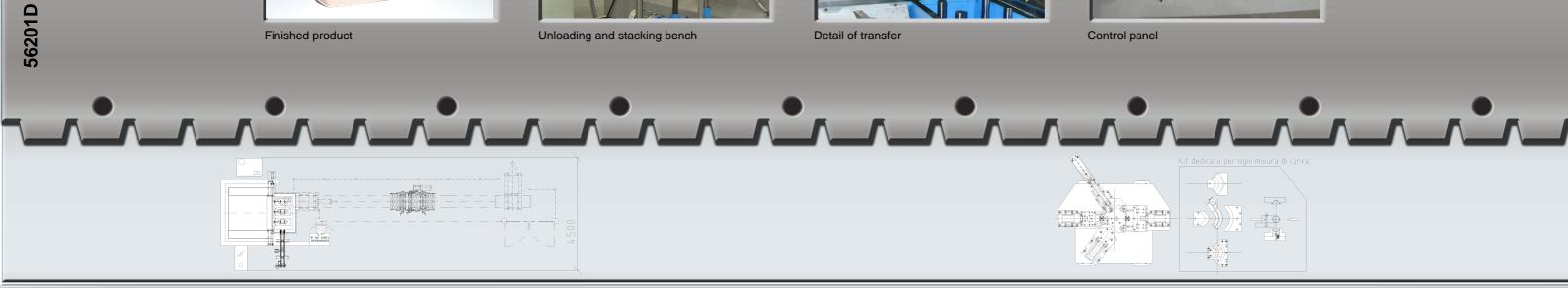
Unloading and stacking bench

Seaming unit for elbow joints





Control panel







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	кw	
Power absorbed by the seaming unit	25	кw	
Line colour:	5015	RAL	
Material: copper, pre-painted, s.s.		_	