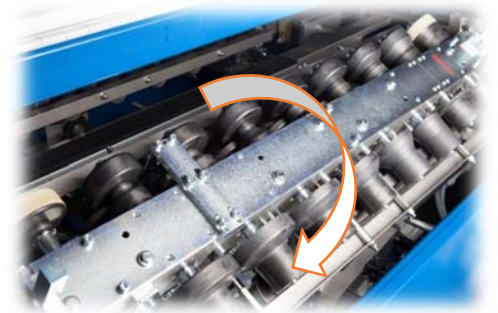


TWIN Profile shaping machine



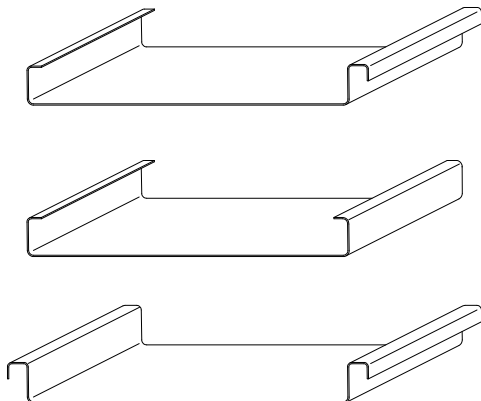
The new
profiling machine

- Equipped with 9 profiling stations and cassettes for pivoting and fast profile changing. In addition to the advanced application area, the increased number of shaping stations allows an even better profile result.

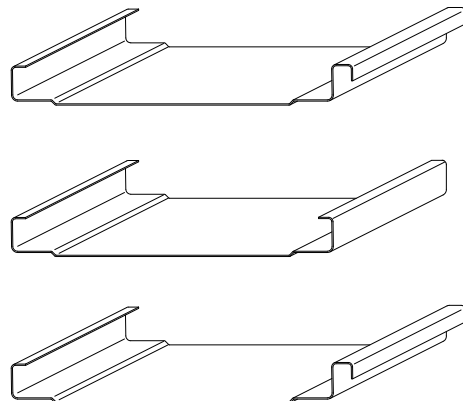


- The cassettes can be installed for the following profile combinations by the Schlebach factory:

2 x double standing seam profile 25 mm for profile shaping two-sided male or female in one work cycle

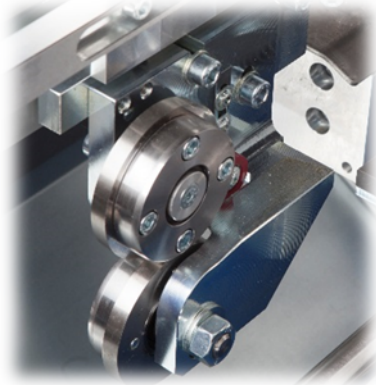
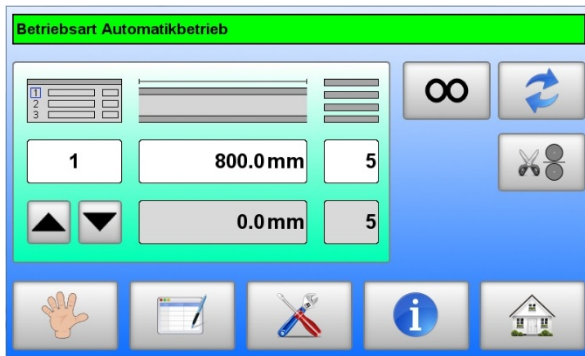


2 x double standing seam profile 25 mm with clip relief for profile shaping two-sided male or female in one work cycle



- Profile combination of double standing seam profile 25 mm with and without clip relief
- Profile combination of double standing seam profile 25 mm and 32 mm with and without clip relief

- Even the basic machine model comes equipped with a PLC touchscreen control in order to provide positioning with millimeter precision and electrically powered roller shears to perform automatic cutting.

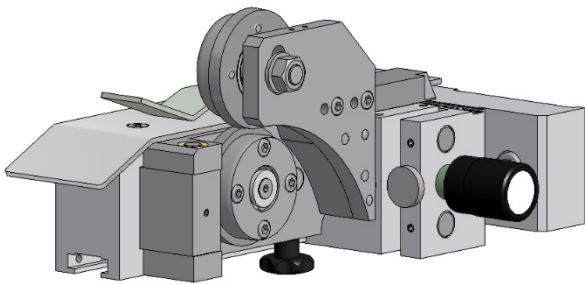


- **The following accessories are available:**

- **The hydraulic shear (HYT)** that is installed in the exit area of the profiling machine consists of hydraulic cylinders that are installed on both sides, case hardened profile guides, an upper cutter bar with a HSS half-section knife system as well as a lower cutter bar with hardened disposable cutting strips that may be used on four sides. The profile guides are set by means of the width adjustment of profiling machine. The cutting waste falls into a bin. Since the panels are cut after the profile has been shaped, it is possible to manufacture strips from a length of about 100mm.



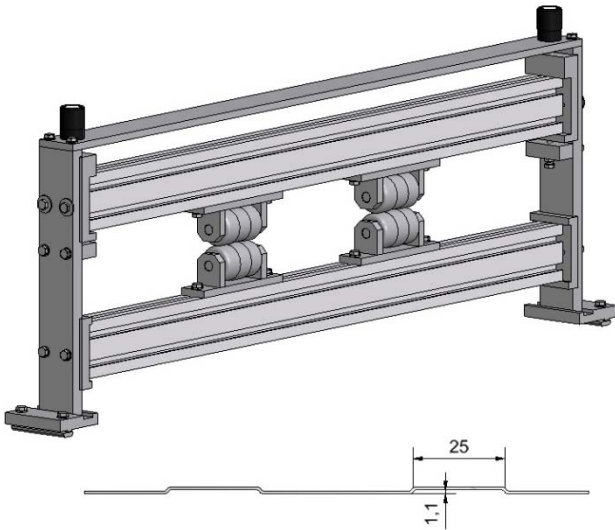
- **Cross-cutting assembly QA-60** for oblique cuts on profiled panels is made of non-ferrous metals. The assembly consists of a stable welded base frame, a swivelling table with carriage and a high-quality circular saw made by Bosch that is supplied with special blades for copper (type SBC with a hard chrome finish) or alternatively aluminium and titanium zinc (type SBS with steam-treated surface). The cutting angle across the profile shaping direction is continuously adjustable from 0° to $+ / - 60^\circ$. The connecting components required to flange the assembly to a profile shaping machine are delivered with the QA. The cross-cutting assembly can be installed after the profile shaping unit.



- **Slitting device LS** for burr-free slitting of coil material before profile shaping. It can save time, especially when long standing seam sheets are being profiled from existing coil widths. This will also dramatically reduce the variety of coil widths that have to be carried in stock, which also results in a reduction in storage costs. The cutting head is adjustable across the profiling direction to permit edge trimming of the infeed material to the required width. The blades of the cutting head are made of high quality tool steel to provide maximum service life. Because of the maintenance-friendly design, the cutting discs may be replaced or reground with very little effort when they have worn down.

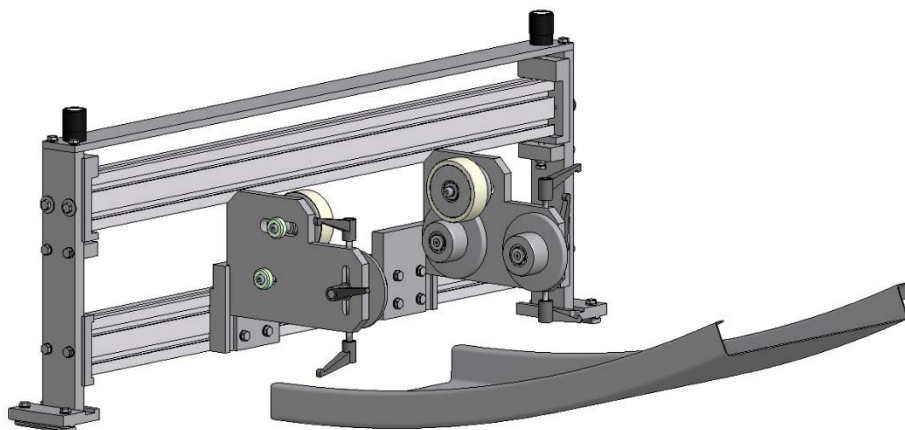
- **A decoiler** for metal coils with a max. weight of 1000 kg and a max. coil width of 1250 mm. The decoiler consists of a welded frame and a continuously adjustable mandrel on ball bearings with centre adjustment. The clamping range of the mandrel ranges from a min. of 280 mm to a max. of 530 mm inner coil diameter (optionally up to 650 mm). The manual braking assembly prevents metal coil overtravel. The decoiler is mobile because it is equipped with four swivelling castors. Extendable supports may be used to clamp the decoiler on site.





- **Ribbing attachment assembly** to shape longitudinal ribs with a width of 25 mm (alternatively 58 mm or pencil ribbing) and a depth of approximately 1.1 mm into the visible surface of profiled panels. The ribbing attachment assembly consists of a guide unit, upper and lower ribbing rollers with brackets. The ribbing attachments assemblies are equipped with high-quality ribbing rollers on ball-bearings to ensure maximum protection of the panel surface being profiled. The ribbing attachments are continuously adjustable across the profile shaping direction. This ensures that the distance of the ribs that are pressed into the panels may be adjusted as required.
- **Note:** The profiling of ribs is not possible on conical shapes.

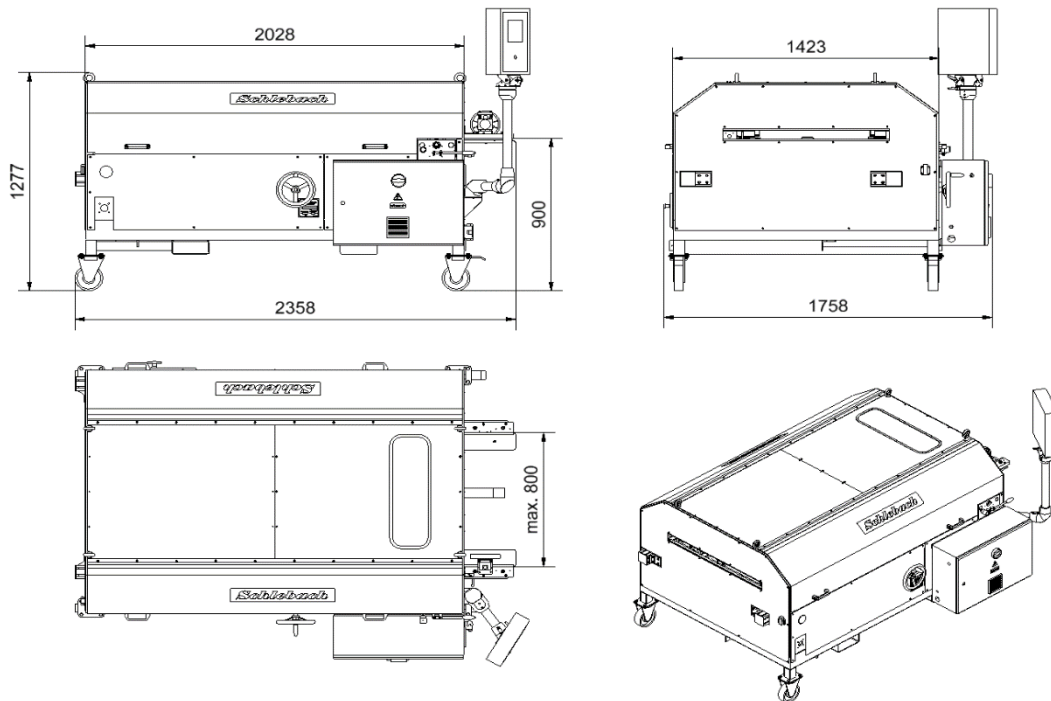
- **Concave curving attachment** for the production of concave folded profile panels with a maximum height of 25 mm and a minimum bending radius of 3000 mm. The concave curving attachment is attached to the exit area of the profiling machine and is suitable for retrofitting. The folded profiles produced by means of the profiling machine is automatically fed to the concave curving attachment and bent to the desired radius by adjustable pressure rollers. It consists of two bending assemblies, one for the side lacking overlap as well as one for the overlapping side of the profile.
- **Note:** Concave curving is only possible at parallel profiled shapes.



➤ **Technical specifications**

Supply voltage	230 V / 50 Hz / 1 Ph.
	Alternatively: 115 V / 50 Hz / 1 Ph. 115 V / 60 Hz / 1 Ph.
Drive power	1.1 kW
Operating speed	11 m/min
Forming stages	9 stations
Length of the shortest panel	500 mm
Adjustment range	260 mm – 740 mm infeed width
Infeed height	900 mm
Dimensions (L x W x H)	2358 mm x 1758 mm x 1277 mm
Weight	1030 kg

Processable materials	Titanium zinc up to 0.8 mm
	Copper up to 0.8 mm
	Aluminum up to 0.8 mm
	Sheet steel (galvanized and coated) up to 0.7 mm
	Stainless steel up to 0.5 mm



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