

MINI-PROF PLUS Profiling machine

Schlebach
Profile technology for all roofs of the world



Compact profiling machine for blanks, cut lengths or material directly from the coil

The purpose of the profiling machine MINI-PROF PLUS is to produce double standing seam profiles 25 from blanks, cut lengths or directly from the coil. In addition to the profiling unit provided with the basic MINI-PROF machine, the MINI-PROF PLUS version includes an infeed area that is equipped with an electromechanical length measuring device with a scale in centimetres, a driven belt feeder and a hand operated roller shear to execute manual cross-cuts. The basic equipment provided with the machine includes a decoiler type AC and the roller shear LS for longitudinal slitting purposes. On request, the machine can also be supplied without AC and LS.

The infeed width is continuously variable from 240 mm to 850 mm to cater for a wide range of applications. The axial dimension of the profiled panels that are produced by a parallel run of the MINI-PROF ranges from 170 mm to 780 mm, taking into account a seam loss of about 70 mm.

The manual roller shear consists of a cutting head with hardened roller blades which can be sharpened with little effort or even replaced if required. The cutting head is mounted on a maintenance-free linear roller guide. This guarantees a clean and burr-free cut.

A single-sided run can produce conical and oblique panels or infill strips from a centre-to-centre distance of 80 mm. The length of the shortest panel is approx. 500 mm. The production rate is approx. 11 meters per minute.

When the MINI-PROF PLUS is used to produce profiles from a coil, the required length in centimetres is entered first via push buttons on the electromechanical length measuring unit. The material of the strip is fed automatically by means of the driven feed rollers. Upon reaching the programmed length, an electrical impulse is triggered in the main switch. The drive motor gets switched off and stops the profiled rail. The overrun, i.e. the tolerance in length may range from 1-2 cm.

When the cut with the manual shear is completed, the device must be reset to the programmed value or a new length before the drive motor gets restarted. Only single stroke production sequences may be executed. When the last profile strip has been cut, further material may be stopped from being fed in by a clutch lever and the remaining strip can be withdrawn manually from the infeed area.

When standing seam sheets are manufactured from a specific coil width, the cutting position is first marked out on the leading edge of the sheet. The LS is manually moved to the desired location using the width adjustment and the strip is threaded. During slitting, the scrap strip is guided away towards the bottom.

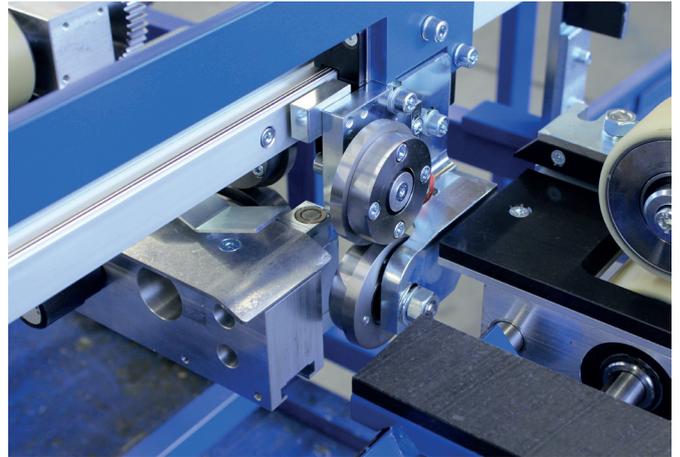
The profiling units (tie-bars) with 7 shaping levels are built on a torsion-proof steel frame. The strip or sheet material is guided by lateral infeed guides on ball-bearings on the fixed, as well as the adjustable side. These are adjustable to set the outer edges of the profile.

The profile rollers are made of high quality special steel and surface treated. This special treatment provides the rollers with a high level of corrosion and wear protection. The bearings of the upper profile rollers have resilient mounts in order to adapt to the material thickness. This ensures an impression-free and low-wear production of the panels.

The profiling machine can be moved on 4 castors. Two of the castors are equipped with brakes to stop the machine from moving unintentionally. The working height of the machine is adjustable from 670 to 870 mm. For this purpose, the two footrests and the castors may be extended and locked in place.

Furthermore, it can also be moved by a crane using the eye-bolts that are supplied as well. This ensures a wide range of applications for the machine during operations and on the construction site.

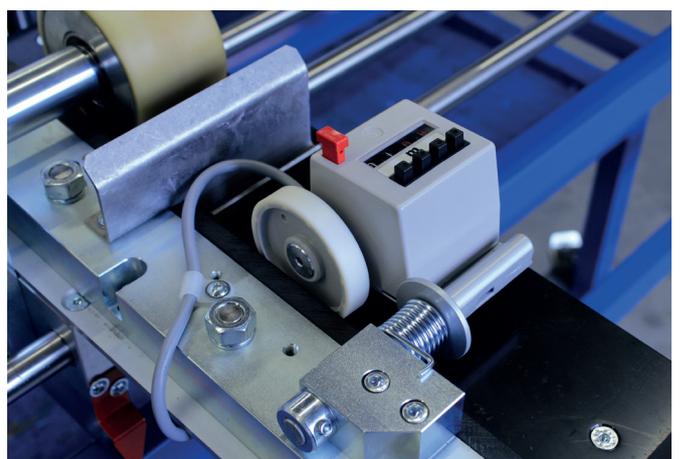
Roller shear:



Longitudinal cutting unit LS:



Electromechanical length measuring device:

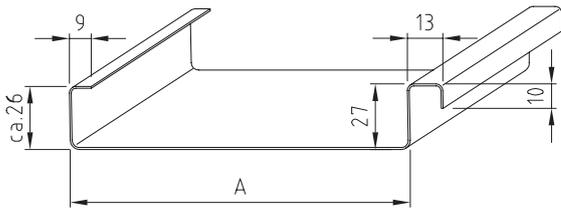


Technical specifications

| | |
|-------------------------------|---|
| Supply voltage | 230 V / 50 Hz / 1 Ph. 115 V / 50 Hz / 1 Ph. 115 V / 60 Hz / 1 Ph. |
| Drive power | 1.1 kW |
| Operating speed | 11 m/min |
| Forming stages | 7 stations |
| Shortest panel length | 500 mm |
| Infeed width | 240 - 850 mm |
| Axial dimension | approx. 170 - 780 mm (depending on the material) |
| Infeed height | 670 - 870 mm (continuously variable) |
| Processable materials | Titanium zinc up to 0.8 mm Copper up to 0.8 mm Aluminium up to 0.8 mm Sheet steel (galvanized and coated) up to 0.7 mm Stainless steel up to 0.5 mm |
| Dimensions (L x W x H) | 1,600 mm x 1,370 mm x 850 - 1,050 mm |
| Weight | 315 kg |

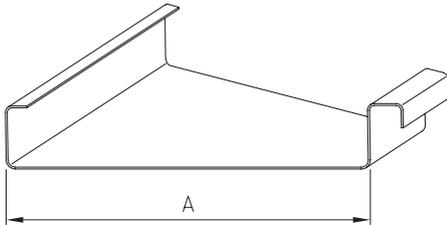


Possible profiles



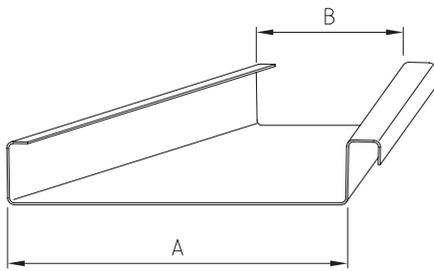
Standing seam 25

Width dimension "A" approx. 170 - 780 mm (parallel) - One run
 Width dimension "A" approx. 80 - 160 mm (seperately) - Two runs
 1st run "male" / 2nd run "female"



Standing seam 25 angled

Width dimension "A" approx. 170 - 780 mm (parallel) - One run
 Width dimension "A" approx. 80 - 160 mm (seperately) - Two runs
 1st run "male" / 2nd run "female"



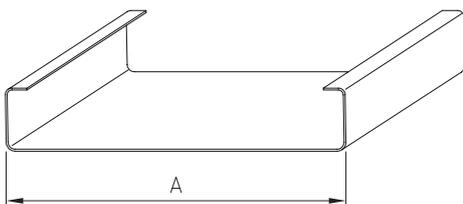
Standing seam 25 conical

Width dimension "A" approx. 80 - 700 mm /
 Width dimension "B" approx. 80 - 700 mm (seperately) - Two runs
 1st run "male" / 2nd run "female"



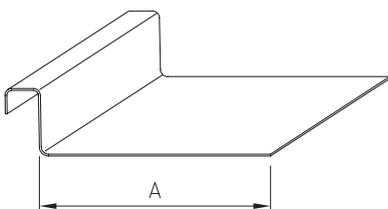
Standing seam 25 both sides "female"

Width dimension "A" approx. 80 - 700 mm (seperately) - Two runs



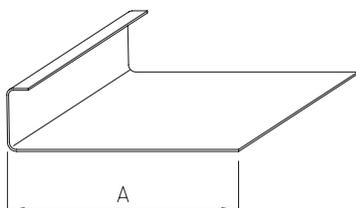
Standing seam 25 both sides "male"

Width dimension "A" approx. 90 - 700 mm (seperately) - Two runs



Standing seam 25 one side "female"

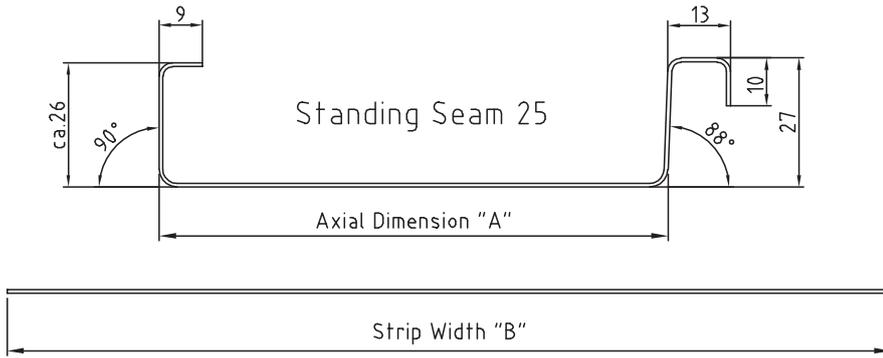
Width dimension "A" approx. 50 - 750 mm - One run



Standing seam 25 one side "male"

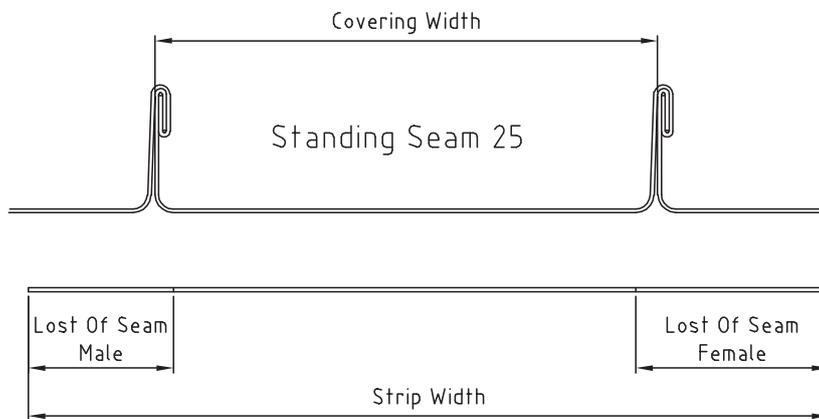
Width dimension "A" approx. 60 - 700 mm - One run

Strip width



| Strip width „B“ | Axial dimension „A“ |
|-----------------|---------------------|
| 300 mm | approx. 226 mm |
| 400 mm | approx. 326 mm |
| 500 mm | approx. 426 mm |
| 600 mm | approx. 526 mm |
| 700 mm | approx. 626 mm |

Covering width



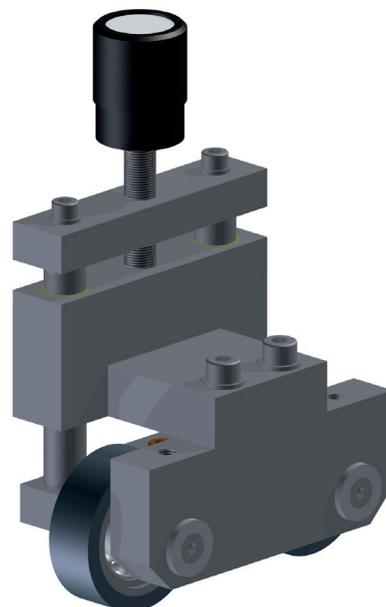
| Strip width | Loss of seam (approx.) | Covering width (approx.) |
|-------------|------------------------|--------------------------|
| 300 mm | 70 mm | 230 mm |
| 400 mm | 70 mm | 330 mm |
| 500 mm | 70 mm | 430 mm |
| 600 mm | 70 mm | 530 mm |
| 700 mm | 70 mm | 630 mm |

Accessoires

Guideboy

Additional material guide for single-sided profile shaping of panels. The installation of the guideboy on any of the Schlebach profile shaping machine infeed guides requires little effort.

The Guideboy prevents the sheet material from shifting towards the centre of the machine during single-sided profile shaping operations. The required lateral force across the profiling direction may be adjusted by means of the directional angle, as well as an increase of the contact pressure on the sheet metal.



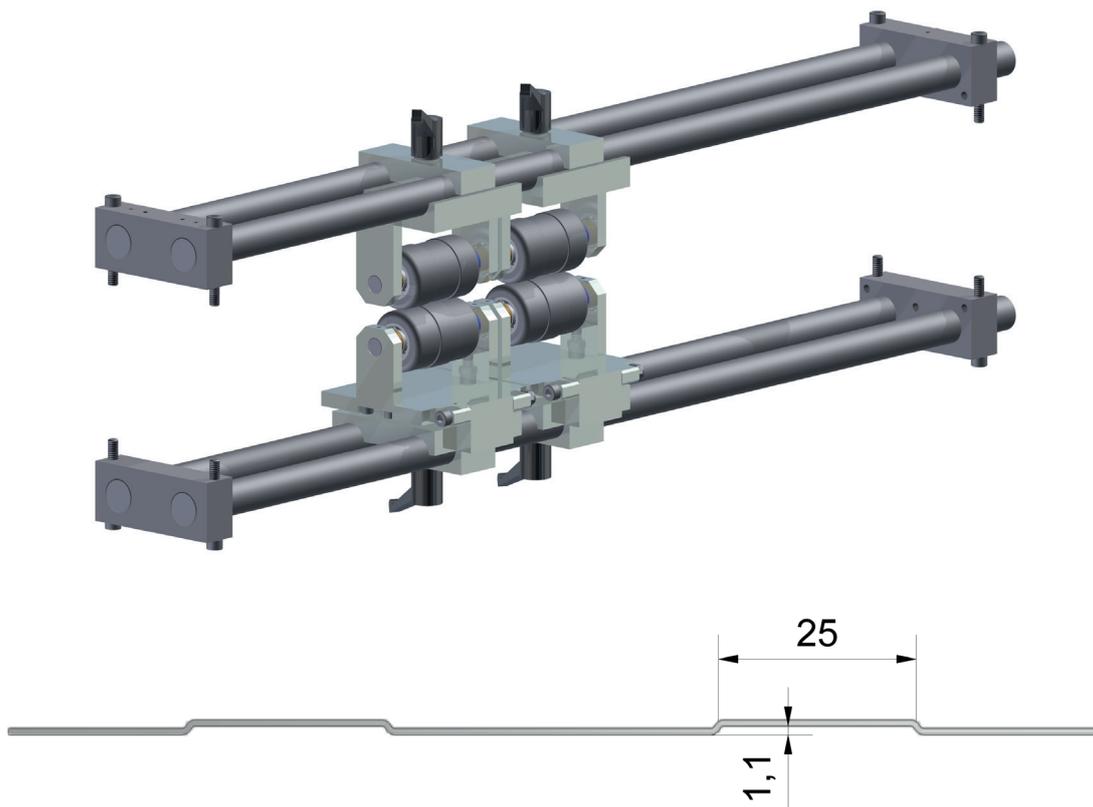
Damage to the material surface is ruled out by the use of high quality pressure rollers with a special rubber coating.

Ribbing attachment 25 mm

Ribbing attachment assembly to shape longitudinal ribs with a width of 25 mm 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.

Note: The profiling of ribs is not possible on conical shapes.

The ribbing attachment assemblies are equipped with high-quality ribbing rollers on ball-bearings to ensure maximum protection of the surface from the panels being profiled. The ribbing attachments are continuously adjustable across the profile shaping direction to ensure that the distance of the ribs that are pressed into the panels may be designed as required.



Schlebach-Maschinen GmbH
Nisterberger Weg 13
D – 57520 Friedewald
Phone: +49 (0) 27 43 / 92 07-0
Telefax: +49 (0) 27 43 / 43 02
Email: info@schlebach.de
Web: www.schlebach.de