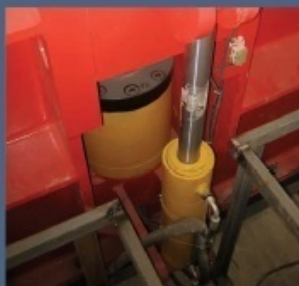




PLATEROLLING

Series W12 NC 4-roller plate rolling machine



Structural characteristics

The machine adopts the four-roller structure with the upper roller as the main drive, proving the plates bending with torque through the engagement between the gear of the moderator and the gear of the upper roller. The bottom roller makes vertical movements and imposes a force on the position through the hydraulic oil in the hydraulic cylinder so as to clamp the plate tight. Side rollers are arranged on the two sides of the sides of the lower roller, and make inclining movement along the guide rail, and provide drive through the screw, the nut, the worm and the lead screw. The advantage of the machine is that the preliminary bending and rolling of the top ends of the plates can be conducted on the same machine.



Technical parameters

specification	Max Thickness of Coiled Plate	Max Width of Coiled Plate	Yield Limit of Sheet Metal	Coiling Speed	Min Full Loading Diameter of Coiled Plate	Diameter of Top Roll	Diameter of Bottom Roll	Diameter of Side Roll	Max stroke of side roll	Side Roll Adjustment Speed	Motor Power
	mm	mm	Mpa	m/min	mm	mm	mm	mm	mm	mm/min	Kw
W12-25 x 2000	25	2000	245	4	80	350	320	280	240	80	22
W12-20 x 2500	20	2500	245	4	640	350	320	280	240	80	30
W12-30 x 2000	30	2000	245	4	1000	400	360	300	240	80	37
W12-25 x 2500	25	2500	245	4	800	400	360	300	210	80	37
W12-35 x 2000	35	2000	245	4	1200	420	380	330	230	80	37
W12-30 x 2500	30	2500	245	4	1000	400	360	320	420	80	37
W12-40 x 2000	40	2000	245	4	1400	480	400	340	420	80	45
W12-45 x 2000	45	2000	245	4	1600	500	450	400	380	80	45
W12-35 x 2500	35	2500	245	4	1200	480	400	340	420	80	45
W12-40 x 2500	40	2500	245	4	1400	500	450	400	380	80	45
W12-45 x 2500	45	2500	245	4	1600	530	480	420	450	80	63
W12-35 x 3000	35	3000	245	4	1200	500	450	400	380	80	45
W12-45 x 3000	45	3000	245	4	1600	560	500	450	450	80	63
W12-55 x 2500	55	2500	245	4	2000	600	550	480	500	78	75
W12-55 x 3000	55	3000	245	4	2000	620	560	490	500	78	75
W12-65 x 3000	65	3000	245	4	2400	670	600	530	550	78	110

Working principle

Ⓜ Description and specifications given in this catalogue are subject to modification without notice





SERIES W11S NC HYDRAULIC UPPER ROLLER UNIVERSAL PLATE ROLLING MACHINE

SMALL-SIZE



End pre-bending of high precision

High Accurate End Pre-bending when bending the end, it can freely set the length of the edge. Top roller presses down, and high accurate end pre-bending is done under a certain pressure.

Different uses with coordinating controlling methods

Three are following controlling methods according to its use.

TNC (Top NC) : for many types but small quantity of production;

T&BNC (Top and Bottom NC) : for few types but large quantity of production;

CNC (CNC) : for many types but large quantity of production.

Excellent product precision

Products Have Superior precision Due to continuous bending and high accurate end pre-bending, products have superior precision. As the top roller is in the shape of drum, with the supporting roller adjusted, it can coil ideal products in the wide range from sheets to plates.

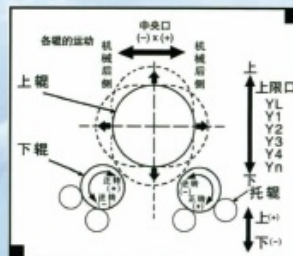
CNC control high producing efficiency

CNC Controls High Production Efficiency One operator, simple operation, and high efficiency.

Rich bending shapes

There are such different shapes as O shape, U shapes and multi-section shapes. The method is as follows:

- ◆ O bending: back bending mode
- ◆ U bending: front bending mode
- ◆ Special bending: composition mode



※ Hint: Machine Rhombus product is special, need buy again



Technical parameters for small-size & medium-size top roll universal plate rolling machine

Model	pressure on the top roll Tons	Max plate thickness		plate width mm	Diameter of top roll mm	Diameter of down roll mm	Central distance mm	Motor		
		end bending mm	central mm					Driving Kw	Hydraulic Kw	Shift Kw
		(-) x (+)								
W11S-8 x 1500	25	6	8	1500	175	125	160	3	2.2	0.75
W11S-6 x 2000	25	4.5	6	2000	195	125	160	3	2.2	0.75
W11S-8.5 x 1500	30	6.5	8.5	1500	185	125	160	3	2.2	0.75
W11S-7.5 x 2000	30	5.5	7.5	2000	205	125	160	3	2.2	0.75
W11S-10 x 1500	37	8	10	1500	205	135	180	4	2.2	0.75
W11S-8.5 x 2000	37	6.5	8.5	2000	220	135	180	4	2.2	0.75
W11S-8 x 2500	37	5.7	8	2500	235	135	180	4	2.2	0.75
W11S-11 x 1500	45	9	11	1500	215	135	180	4	2.2	0.75
W11S-10 x 2000	45	7.5	10	2000	235	135	180	4	2.2	0.75
W11S-9 x 2500	45	6.5	9	2500	245	135	180	4	2.2	0.75
W11S-11 x 2000	55	9	11	2000	245	145	200	5.5	4	0.75
W11S-10.5 x 2500	55	8	10.5	2500	255	145	200	5.5	4	0.75
W11S-9.5 x 3000	55	7	9.5	3000	275	145	200	5.5	4	0.75
W11S-12 x 2000	65	10	12	2000	250	145	200	5.5	4	0.75
W11S-11.5 x 2500	65	9	11.5	2500	265	145	200	5.5	4	0.75
W11S-10.5 x 3000	65	8	10.5	3000	280	145	200	5.5	4	0.75
W11STNC-8 x 1500 - W11STNC-10.5 x 3000	ibidem									
W11ST&BNC-8 x 1500 - W11ST&BNC-10.5 x 3000	ibidem									

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MEDIUM-SIZE



Technical parameters for medium-size top roll universal plate rolling machine

Model	pressure on the top roll Tons	Max plate thickness		plate width mm	Diameter of top roll mm	Diameter of down roll mm	Central distance mm	Motor		
		end bending	central					Driving Kw	Hydraulic Kw	Shift Kw
		mm	mm							
W11S-20 x 2500	130	16	20	2500	330	180	300	15	5.5	2.2
W11S-22 x 2500	160	18	22	2500	360	200	330	18.5	7.5	2.2
W11S-24 x 2500	190	20	24	2500	380	220	360	22	7.5	4
W11S-29 x 2500	230	25	29	2500	410	235	380	30	11	4
W11S-25 x 3500	230	21	25	3500	440	235	380	30	11	4
W11S-33 x 2500	270	28	33	2500	430	250	400	30	11	4
W11S-30 x 3000	270	25	30	3000	450	250	400	30	11	4
W11S-28 x 3500	270	23	28	3500	470	250	400	30	11	4
W11S-32 x 3000	320	28	32	3000	480	260	420	37	15	5.5
W11S-28 x 3500	320	25	28	3500	500	260	420	37	15	5.5
W11S-26 x 4000	320	22	26	4000	520	260	420	37	15	5.5
W11S-35 x 3000	380	32	35	3000	500	275	460	45	22	5.5
W11S-32 x 4000	430	28	32	4000	580	290	500	55	22	7.5
W11STNC-15 x 2000 - W11STNC-32 x 4000	ibidem									
W11ST&BNC-15 x 2000 - W11ST&BNC-32 x 4000	ibidem									

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LARGE-SIZE



Technical parameters for large-size top roll universal plate rolling machine

Model	pressure on the top roll Tons	Max plate thickness		plate width mm	Diameter of top roll mm	Diameter of down roll mm	Central distance mm	Motor		
		end bending	central					Driving Kw	Hydraulic Kw	Shift Kw
		mm	mm							
W11S-55 x 3000	610	45	55	3000	620	360	650	75	30	15
W11S-60 x 3000	690	50	60	3000	650	380	700	75	30	15
W11S-50 x 4000	690	45	50	4000	700	380	700	75	30	15
W11S-70 x 3000	850	60	70	3000	710	420	780	75	37	15
W11S-55 x 4000	850	50	55	4000	750	420	780	90	37	15
W11S-50 x 5000	850	42	50	5000	790	420	780	90	37	15
W11S-45 x 6000	850	38	45	6000	820	420	780	90	37	15
W11S-75 x 3000	930	65	75	3000	740	440	820	90	37	15
W11S-60 x 4000	930	55	60	4000	780	440	820	90	37	15
W11S-55 x 5000	930	45	55	5000	820	440	820	90	37	18.5
W11S-80 x 3000	1050	70	80	3000	770	460	880	90	37	18.5
W11S-65 x 4000	1050	60	65	4000	810	460	880	90	37	18.5
W11S-85 x 3000	1150	75	85	3000	800	480	920	110	45	18.5
W11S-70 x 4000	1150	65	70	4000	840	480	920	110	45	18.5
W11S-100 x 3000	1350	90	100	3000	860	520	1000	110	45	22
W11S-80 x 4000	1350	75	80	4000	900	520	1000	110	45	22
W11S-65 x 6000	1350	60	65	6000	980	520	1000	110	45	22
W11S-115 x 3000	1600	100	115	3000	900	560	1080	132	55	30
W11S-100 x 4000	1600	85	100	4000	940	560	1080	132	55	30
W11S-125 x 3000	1800	110	125	3000	960	600	1120	160	75	37
W11ST&BNC-45 x 3000 - W11ST&BNC-110 x 4000	ibidem									



PLATEROLLING

Series W11 hydraulic 3-roller symmetrical plate rolling machine



Structural characteristics

specification	Max Thickness of Coiled Plate	Max Width of Coiled Plate	Yield Limit of Sheet Metal	Coiling Speed	Min Full Loading Diameter of Coiled Plate	Diameter of Top Roll	Diameter of Bottom Roll	Central Distance between Bottom rolls	Motor Power	Hydraulic power
	mm	mm	Mpa	m/min	mm	mm	mm	mm	Kw	Kw
W11Y-30 x 2000	30	2000	245	4	1200	360	290	480	22	7.5
W11Y-25 x 2500	25	2500	245	4	1200	370	300	480	22	7.5
W11Y-30 x 2500	30	2500	245	4	1200	420	360	550	30	11
W11Y-25 x 3000	25	3000	245	4	1200	430	370	550	30	11
W11Y-30 x 3000	30	3000	245	4	1200	450	390	600	37	11
W11Y-40 x 2500	40	2500	245	3.5	1400	500	400	600	370	15
W11Y-40 x 3000	40	3000	245	3.5	1600	540	440	600	450	18.5
W11Y-50 x 3000	50	3000	245	3.5	2000	580	480	750	55	22
W11Y-60 x 3000	60	3000	245	3.5	2400	660	560	800	75	30
W11Y-70 x 3000	70	3000	245	3.5	2800	710	620	850	90	37
W11Y-80 x 3000	80	3000	245	3.5	3200	770	680	900	90	37
W11Y-90 x 3000	90	3000	245	3.5	3600	820	730	950	110	45
W11Y-100 x 3000	100	3000	245	3.5	4000	860	770	1000	110	45
W11Y-110 x 3000	110	3000	245	3.5	4400	900	810	1080	132	55
W11Y-120 x 3000	120	3000	245	3.5	4800	950	860	1160	132	55

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Hint: machine Rhombus product is special, need buy again



Structural characteristics

The construction of this machine is in the form of three roller symmetry position over the two bottom rollers, does vertical motion up and down through screw, nut and worm transmission. Decelerator gears bottom rollers providing torsion moment for coiling sheet metal.

Series W11 mechanical 3-roller symmetrical plate rolling machine



Technical parameters

specification	Max Thickness of Coiled Plate	Max Width of Coiled Plate	Yield Limit of Sheet Metal	Coiling Speed	Min Full Loading Diameter of Coiled Plate	Diameter of Top Roll	Diameter of Bottom Roll	Central Distance between Bottom rolls	Motor Power	Overall Dimensions
	mm	mm	Mpa	m/min	mm	mm	mm	mm	Kw	mm
W11-4 x 1500	4	1500	245	5	300	150	140	185	3	2900 x 720 x 1000
W11-6 x 1500	6	1500	245	5	380	160	140	220	4	2900 x 720 x 1000
W11-6 x 2000	6	2000	245	4.5	380	170	160	260	5.5	3650 x 820 x 1050
W11-8 x 2000	8	2000	245	4.5	400	185	170	260	5.5	3700 x 820 x 1050
W11-8 x 2500	8	2500	245	4.5	550	240	180	280	7.5	4150 x 1100 x 1100
W11-12 x 2500	12	2500	245	4.5	600	260	220	320	11	4200 x 920 x 1200
W11-12 x 3000	12	3000	245	4	700	280	240	360	11	4900 x 1300 x 1300
W11-16 x 2500	16	2500	245	4	700	280	240	360	11	4400 x 1300 x 1300
W11-16 x 3200	16	3200	245	4	850	340	260	430	15	5300 x 1400 x 1400
W11-20 x 2000	20	2000	245	4	700	280	240	360	11	3900 x 1300 x 1300
W11-20 x 2500	20	2500	245	4	850	340	260	430	15	4600 x 1400 x 1400
W11-25 x 2000	25	2000	245	4	850	330	270	430	15	4100 x 1400 x 1400
W11-30 x 2500	30	2500	245	4	1200	420	360	550	30	5760 x 1700 x 2110
W11-30 x 3000	30	3000	245	4	1200	450	390	600	37	5400 x 1700 x 2210

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Working principle



Structural characteristics

The machine adopts 3-roller symmetrical structure with the upper roller moving vertically in the center between the two lower rollers, which is achieved through the drive of the screw, the nut, the worm and the lead screw. The two lower rollers rotate, and provides the plate materials with torque through the engagement of the output gear of the moderator with the gear of the lower rollers. The disadvantage of the machine is that the ends of the plate materials need to have the help from other equipment for pre-bending.

Series W11 mechanical 3-roller asymmetrical plate rolling machine



Technical parameters

specification	Max Thickness of Coiled Plate	Max Width of Coiled Plate	Yield Limit of Sheet Metal	Coiling Speed	Min Full Loading Diameter of Coiled Plate	Diameter of Top Roll	Diameter of Bottom Roll	Central Distance between Bottom rolls	Motor Power
	mm	mm	Mpa	m/min	mm	mm	mm	mm	Kw
W11-2 x 1000	2	1000	245	6	250	120	120	120	2.2
W11-2 x 1200	2	1200	245	6.1	250	120	120	120	2.2
W11-2 x 1500	2	1500	245	6	250	130	130	130	2.2
W11-2 x 2000	2	2000	245	6.1	250	130	130	130	2.2
W11-4 x 1000	4	1000	245	5.4	300	140	140	140	3
W11-4 x 1200	4	1200	245	5.4	300	140	140	140	3
W11-4 x 2000	4	2000	245	5.4	350	150	150	150	3
W11-6 x 1000	6	1000	245	5.4	350	140	140	140	3
W11-6 x 1500	6	1500	245	5.4	400	150	150	150	4
W11-6 x 2000	6	2000	245	5.4	400	160	160	160	4

※Description and specifications given in this catalogue are subject to modification without notice

Structural characteristics

The machine adopts the 3-roller asymmetrical structure with the upper roller as the main drive and the lower roller making vertical movement so as to clamp the plate materials tight. The main drive comes from the engagement between the gear of the lower roller and the gear of the upper roller. The side roller makes elevating movements and has the function of preliminary bending and rolling. The machine is characterized with compact structure and convenient operation and maintenance.

Working principle

