

GENERAL TECHNICAL SPECIFICATIONS

DALLAN D610M PRODUCTION SYSTEM FOR ROLLING SHUTTER PROFILES

The DALLAN D610M line is the most flexible automatic system for the production of aluminum roller shutter profiles with polyurethane foam. Profiles are cut to size and ventilation slots are produced directly in line. The base is suitable to bear 36 rollforming station and can assemble combi groups for the production of rolling shutter profiles up to height 77mm. The DALLAN D610M line is suitable for production up to a speed of 60 m/min and 22 cuts per minute for profiles up to H55, and up to 20 m/min for profiles up to height 77mm. System composed of:

- 1 DOUBLE DECOILER ASD520**
Double idle decoiler with manual opening, loads 2000+2000kg. Acts as a raw material storage. The rotation for the coil changing is motorized; it is possible to load a new coil while the machine is working.
- 2 PRE-HEATING BENCH**
It brings the belt to the correct temperature for the insertion of the polyurethane foam
- 3 STRIP CUTTING UNIT**
Used when changing the production.
- 4 T4R-36WI-300 ROLLFORMER**
Complete with the following machines or equipment.
 - 4.1 BASE B4R-36-300**
Base suitable to bear n° 36 rollforming stations, complete with drives.
 - 4.2 N.1 COMBI GROUP G4N-12-260-IR**
Combi group having N.12 rollforming stations. It is assembled on an aluminium base with centering system for quick production changeover. It includes the transmission to the rollforming shafts. The band introducing unit and the straightener are assembled on the base plate.
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 - 4.4 SET OF ROLLERS S4-24**
Suitable to produce the profile H43. Set of rollers in hardened steel, complete with 24 stations and possible accessories.

- 5 CONTROL PANEL**
Integrating the electronic controls and power electric components.
- 6 POLYMERIZATION BENCHES WITH ACTIVATOR**
It includes special lamps accelerating and stabilizing the polyurethane reaction.
- 7 SIMPLE POLYMERIZATION BENCHES**
- 8 PROFILE EXTRACTION UNIT**
For the extraction of the shutter out of the polymerization bench. It allows the collection of the material left in the machine approximately up to the 100%.
- 9 CUTTING SYSTEM FOR ROLLING SHUTTERS WITH SAW**
Electronically controlled mobile unit equipped with disk saw suitable to the cutting of the required profiles and connected to the rollformer by completely automatic cycle. Unit supplied with measuring group and encoder acting on the profile and controlled to follow the profiles checking the cutting directly by microprocessor. Up to 20 cuts per minute, supplied with N. 1 sucker and protection cabinet.
- 10 CUTTING CLAMPS**
- 11 SOUNDPROOFING AND PROTECTION CABIN**
- 12 BELT CONVEYOR**
Length 7 mt, positioned after the shutter cutting system to convey the profile to the ventilation slots punching machine.
- 13 ELECTRONIC PUNCHING MACHINE 600 mm D6P600**
Suitable to perforate different shape rolling shutter profiles after cutting. Profile feeding performed by c.c. motor and controlled by the relevant control panel. Multiple hydraulic presses control the die. The machine punches the profile in accordance with a preset sequence. Supplied with protection cabinet.
- 13.1 SHAPED ROLLERS FOR PROFILE TOWING**
- 13.2 DIE FOR SLOTS 600**
Die for the perforation after cut. Length 600mm.
- 14 SOUNDPROOFING AND PROTECTION CABIN**
- 15 HYDRAULIC UNIT**
Brings the oil to the suitable pressure for the correct functioning of the machine.

16 CONTROL PANEL

Integrating the electronic controls and power electric components.

17 2 TANKS STANDARD FOAMING MACHINE

Complete with mixing head, shell and tube heat exchanger, control panel 1 tank for polyol, 1 tank for isocyanate, cleaning device. Automatic machine with automatic regulation of the components flow. The machine is connected to the rollforming speed and the air mixing through a proportional valve. The system includes also the connections and the pumps for the automatic re-filling of the tanks.

18 FIX UNLOADING BENCH

Length 6 m.

19 SOFTWARE FOR ROLLFORMING LINE SERIE D6

The equipped software allows the programming of different jobs in sequence: from the production of bars up to the production of curtains cut-to length, with pre-set sequences of perforated and non-perforated slats. The system also allows the adjustment of the speed according to the profile length, in order to get the maximum productivity from the line.

20 STACKING BENCH D6-STACK 7M

Automatic stacking system for roller shutters up to 55mm height. With possibility to stack from 4 to 6 rolling shutter sections up to 10 layers (programmable). It permits to produce complete curtains, starting from pre-cut sections.