

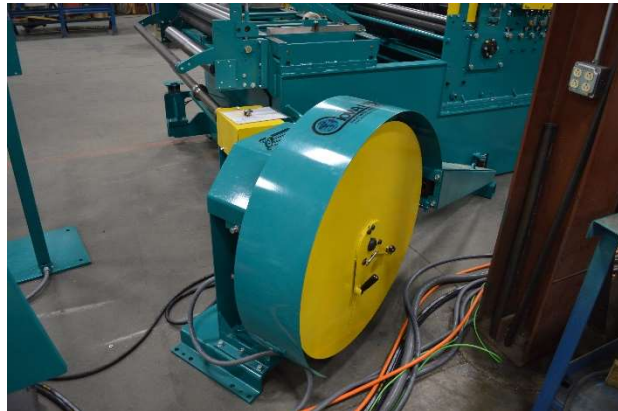
Flexible Fabrication System for Imperial Brown

We recently installed a new flexible fabrication system for Imperial Brown for their Tuscon, Arizona facility to process walk-in coolers and freezers. The system can handle 10,000 lb. coils of CRS, bottom side surface-critical up to 48" wide and ranging in thickness from 0.012" to 0.060".

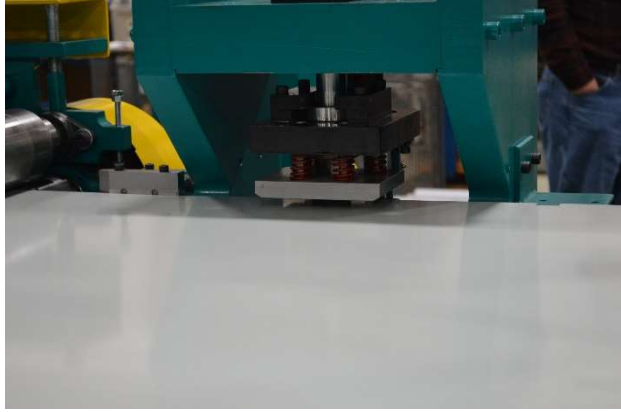
The system includes a 10,000 lb. motorized stock reel and combination upender / coil car to load eye-to-the sky coils and reposition them to load onto the mandrel of the uncoiler.



A vinyl applicator is mounted to the entry side of the CTL unit to apply vinyl to the bottom surface of the material before it is run through the straightener and edge trimmers. The 4-roll straightener removes coilset from the strip and has individually adjusted upper straightener rolls. The unit includes 2 edge trimmer blades that can be manually adjusted on the arbor to the desired distance. An edge trim rewriter is included on the back side of the CTL to collect and remove the edge trim scrap.



The beading roll embosses ridges into the sheet after straightening for rigidity of the finished product. A Dual Head Notcher includes 2 manually-adjusted "C" frame heads, each with a turret die to add a notch to each edge of the material. The notch is used to remove enough material to allow folding or forming of the part without the material buckling.



The roll former is used to form side flanges of the part, bending each side of the strip upward in a 90° bend. The roll former tooling is manually adjusted via a hand crank and ball screw assembly to be able to process material widths from 12" to 50". A hydraulic cutoff shear is positioned at the exit of the roll former.



The line was installed by our Formtek-Maine Service Department and is now running. This is the second system Imperial Brown has purchased from us with a third system in process to be purchased now.