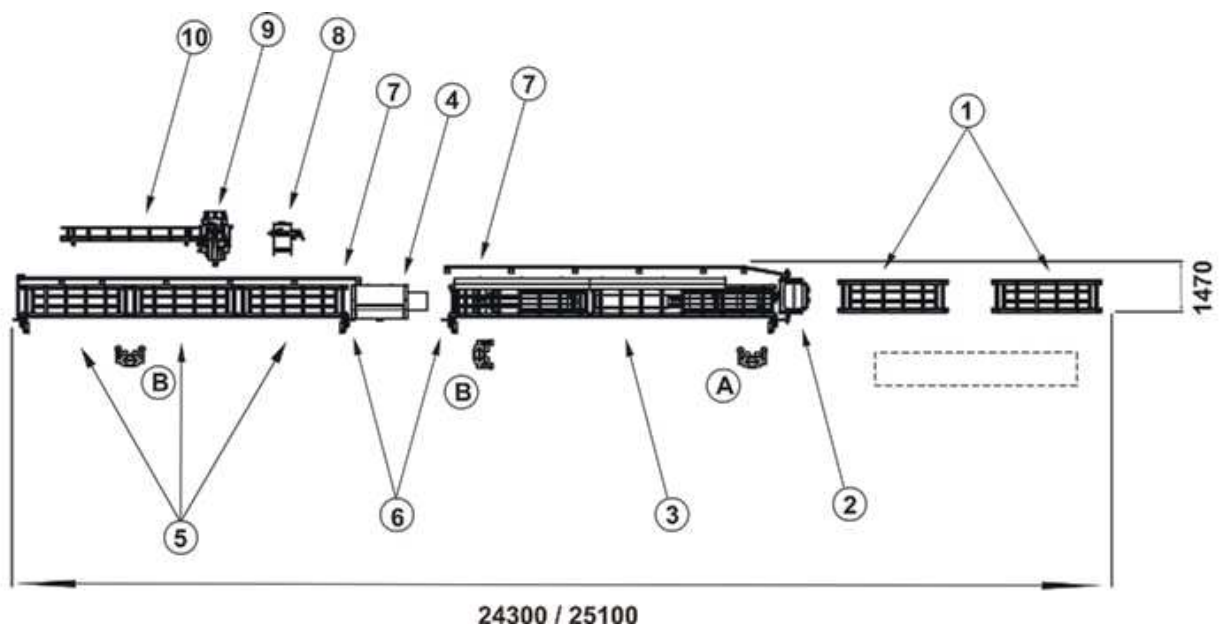


THERMAL BRIDGING PRODUCTION SYSTEM

LAYOUT PRODUCTION IOTA (PA-strips insertion realized during the knurling phase)

This solution is adapted for small-medium production. Using one knurling machine, permit to produce in 2 consecutive phases:

- in the 1st phase the knurling of a profile introducing 2 PA-strips;
- in the 2nd phase the knurling of the 2nd profile in outfeed from the knurling machine which will be assembled to the profile product in the 1st phase; ready for the definitive roll forming.



N° 2 operators

Approx. capacity:

35 bars/h

- Loading roller table 2,4mt
- Knurling machine Grip/Ber
- Unloading roller table for knurling
- Machine with grippers
- Rolling machine Blok T.I./Blok T2
- Unloading roller table 2,4mt
- Vertical photocell barrier kit
- Fencing
- Griptester M
- Single head sawing machine SikaPlus
- Loading roller table 4,2mt

1° PHASE KNURLING AND POLYAMIDE INSERTION

The operation consists:

- in the notching of the grooves which will house the PA-strip;
- in the PA-strip insertion with a particular grippers system housed in outfeed from the knurling machine

2° PHASE ROLL FORMING

The alu-teeth of the upper and lower extrusions are roll-formed through a progressive thrust of the pressure rollers, locking the PA-strip.

3° PHASE SHEAR FORCE TEST

In the order to monitor the quality of the composite profile, a shear force test is run on a sample of 100mm length.