



KNOW-HOW SAVES YOU MONEY

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GUARANTEE at least 10% lower price on new roll forming lines in North America

What do you need to know when purchasing a Roll forming machine or a complete Roll forming line.

The following questions are to be asked:

1. What is my yearly turn over steel consumption in linear feet (meters)?

Average consumption in linear feet per year should be around 1,000,000 FT (305,000m) to justify capital investment in a Roll forming line

Different cases require different solutions. You may need to run just few batches per year for certain product and then change it with another one in the same machine.

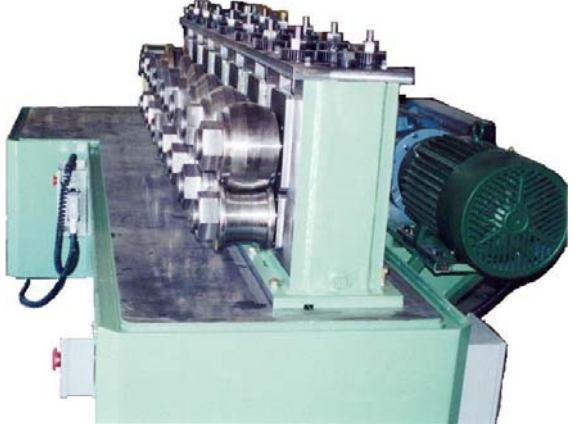
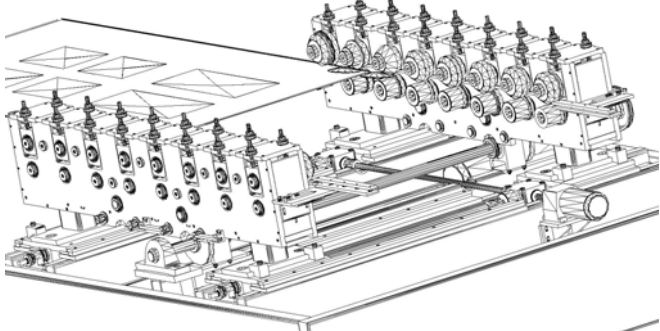

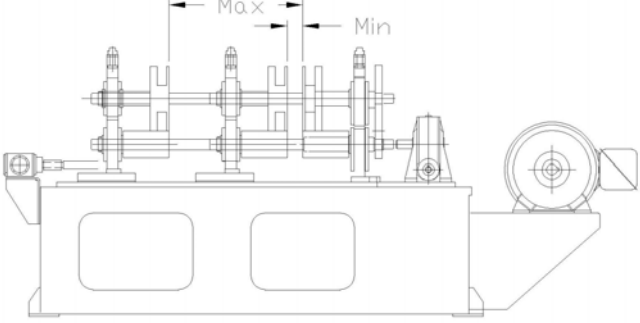

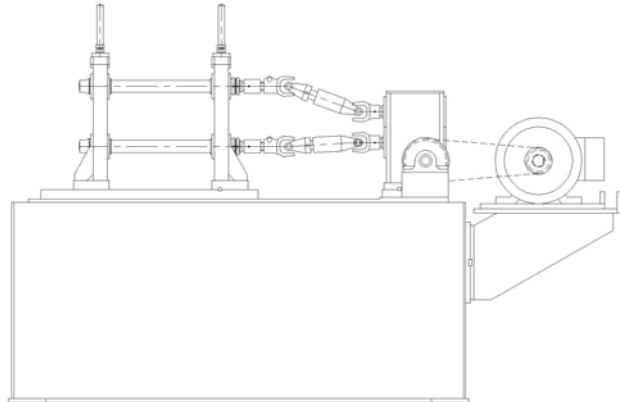

2. Do I need brand new roll forming line or I can put together a used one, integrate it and change only the roll tooling and cut-off Die or blades?

In today's market lots of used roll forming equipment is available for re-use. If you manage to locate the right used machines - entry system, roll former and exit system - cut-off and material handling for your roll formed part, you will realize big saving. If you need assistance call KOLEV @ 905 751 0339 or send us an e-mail: sales@kolev.com . We will help you to put together a used one or we will manufacture a brand new custom roll forming line for you.

3. What type of roll forming machine I need for my part(s)?

There are variable of roll forming machines design. Generally you should recognize the following types of roll forming machines:

| Roll former type | Features | View | Profiles |
|-----------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|----------------------------|
| a. Standard Universal | <ul style="list-style-type: none"> Fixed Roll tooling space Shafts both ends supported Bottom Driven shaft Inboard and Outboard stands with bearing housing, sliding top bearing block and elevating mechanism Bottom to top shaft gears transmission (as required) | | <p>Variety of profiles</p> |

| | | | |
|-------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p>b. Cantilevered</p> | <ul style="list-style-type: none"> • Single cluster gears box with cantilevered roll forming shafts • For multiple roll tooling change over • Easy Rolls access |  | <p>For profiles with small width, which strip width can be accommodated within the roll tooling space cantilevered limitations. For Panels, where only one side requires forming.</p> |
| <p>c. Cantilevered Duplex</p> | <ul style="list-style-type: none"> • Both sides adjustable towards the center (center compatible) • or one side only |  | <p>For profiles with variable width such as studs, C Z, Σ, wide panels – metal doors, wall, shelving etc.</p>  |
| <p>d. Shaft-Tru Duplex</p> | <ul style="list-style-type: none"> • Used in duplex type roll forming machines, • Provides ability to slight through the stand's bearing block. • Keeps the rigidity of the roll forming section and handle different parts width • Less expensive version of Cantilevered Duplex |  | <p>For profiles with variable width – panels, trays, studs etc.</p>  |
| <p>e. Cassettes</p> | <ul style="list-style-type: none"> • One Cassette consists of 4 to 7 roll forming sections (passes) • One set of cassettes (2 to 5 cassettes) is complete with its roll tooling – loaded, set up and ready to use for a specific profile. • Quick change over from one set of roll tooling to another by changing the cassettes only. |  | <p>For roll forming different profiles in the same roll former without roll tooling change over – Cassettes change only.</p>  |

4. What do I need to complete my entry system
5. What do I need to complete my exit system
6. What Roll forming line configuration I need for my product after all?

For technical expertise - call KOLEV @ 905 751 0339 or send us an e-mail: sales@kolev.com .
We will help you to put together your custom roll forming line.

Zdravko Georgiev P.Eng (Dako)