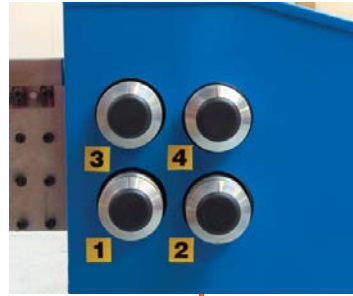


Typical Anatomy of a Firmac Coil Rollforming Line

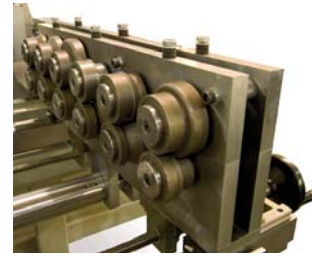
(Example shows the Firmac Drive Cleat Line)

Infeed Drive Selector Stations: 3 to max 6

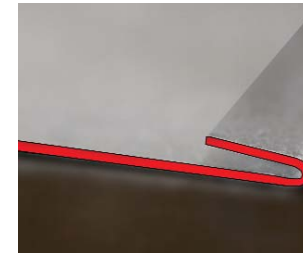


Levelling Rollers

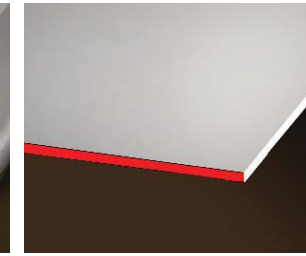
Pleating or Beading Rollers
For stiffening the sheet



Roll Forming Section
for Drive Cleat (Adjustable
for width)



Drive Cleat



Plain Ended Duct

Auto Folding Station For
complete ducts, U or L shapes.

Max duct size: 2000 x 2000mm
Min duct size: 150 x 150mm



Transfer System with Sheet Guidance

Auto Pittsburgh Seam Closing System

Release Support for
Duct Removal



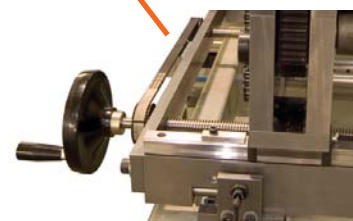
Notching Units for Corners and Seams

Adjustable for width on linear bearing slides
and ball screws



Pittsburgh Unit

Cross running type for slitting the coil
sheet and simultaneously forming the
male and female Pittsburgh seam on
the leading edge of first sheet and
trailing edge of the second sheet.



Linear Bearing Slides

For accuracy and reliability with
precision ground ball screws for
precise adjustment



Pittsburgh
Cut

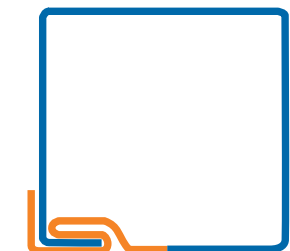
Male Pittsburgh

On leading edge of cut
sheet



Female Pittsburgh

On Trailing Edge of Cut Sheet



Complete Duct in one piece

(Female joint shown Red for clarity ONLY)

All Guards NOT shown for clarity ONLY