

## FIRMAC ProDuct DRS CGF1



### Data Sheet

#### Description

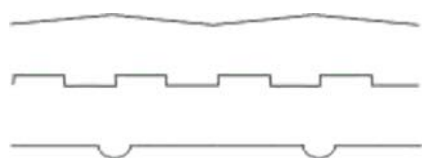

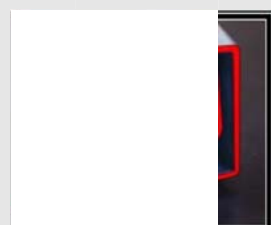
The Pro-Duct CGF1 Integral Flange Line has been designed to make the production of ducting with an integral flange time and space efficient, without compromising on quality or restricting the size of the full box duct.

Production flow is entirely in one direction without the need for transfer tables, thus saving valuable floor space and not restricting the lengths of blanks and full box duct as "U" and "Z" configurations do.

The straight line layout allows folding to begin at the leading end whilst the trailing end is still attached to the coil meaning almost any size of duct can be produced in one piece.

Unlike any other Pittsburgh unit this cross running type slits and rolls the female pocket on the back end of one blank and the male 90 degree edge on the leading edge of the next blank all in one single pass.

The piece then travels through the 19 station Rollformer which is already cut to length, fully notched for seam and folded corners and with the male and female Pittsburgh seams formed on the leading and trailing edges. The parallel sides of the blank are formed into the 20mm or 30mm flanges by the Duplex Rollformer. The flange is complete by station 17 leaving two final stitching unit stations to stitch the flange back to the duct wall.

Duct Products:		Closed box U-Shape with lid U-Shape L-Shape Flat sheet with flange
Coilholder on tracks:		Six (6) in a line or Three (3) over three (3)
Coil weight		Max. 5.000kg
Coil width		1.500 standard – (2.000mm option)
Coil Inside diameter		508mm standard – (610mm option)
Gauges/Material	Galvanized/mild steel	0.60 – 1.2mm
No. of levelling rolls	2 over 2	4
Pleating		Z-Pleating (standard) Parallel pleating (option) Beading (option)
Closing seam		Pittsburgh (and/or Snaplock)
Min. size duct	Min. 500 mm all sides	65 is the shortest duct side from a 500mm blank or 150 x 150mm as minimum square duct
Max. closed box	For safety reasons	2.000 x 2.000mm
Measurements/Shape Flange Allowances		20mm - approx. 55mm per side 30mm - approx. 80mm per side

Productivity	Example: duct approx. 300 x 300 mm	No. 10 ducts in under 10 minutes
Special equipment	Top beam flexible	Finished duct will exit the Product in directly in line with the direction of material flow.
Coil-/Duct measurements	Coil width → Finished duct* *if original Firmac CGF-Flange. All others can be different.	1500mm → 1390mm CGF 20 1500mm → 1340mm CGF 30 2000mm → 1890mm CGF 20 2000mm → 1840mm CGF 30
Manual input of the job		Touchscreen at the machine (download available)
Controller		Omron
Diagnostic system		Via Ethernet or Modem
Electrical supply		10 kW/400 V/3x32 A/50Hz
Air supply	Industrial standard	6 bar / 150 l/min.
Measurements Machine (approx.)	L x W x H with 4 coils L x W x H with 6 coils L x W x H with 3+3 coils	12.0 x 3.0 x 1.6m 14.0 x 3.0 x 1.6m 11.0 x 3.0 x 1.6m
Colours		Grey and blue
Language of operation		English

### Options

Hole notching for tie rod	CNC-controlled
Airtight seal	Mastic in the Pittsburgh or Snaplock unit
Conveying system	Transports finished ducts directly to the corner inserter section
Input of Production data	Connection with production office software