

FIRMAC

MDF 1500 System

Data Sheet

Description

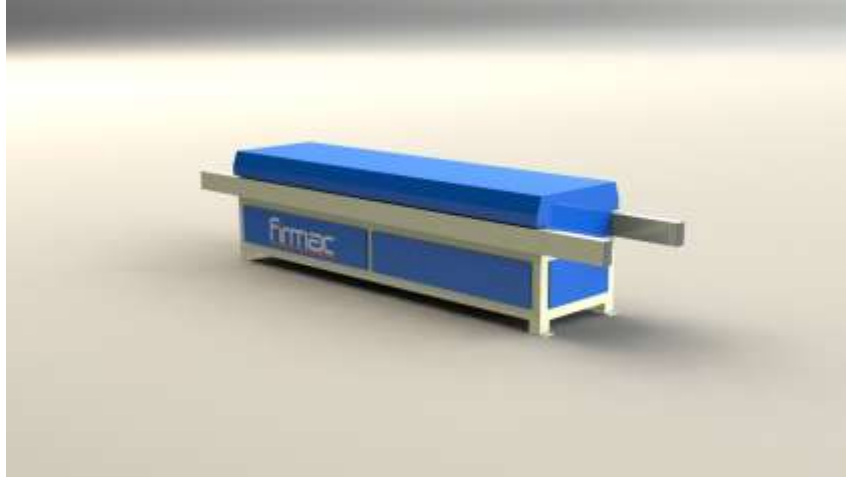
The FIRMAC MDF machine Line is designed to operate in three (3) separate stages, giving the same quality integral flange ductwork as the Firmac Pro-Duct DRS machine, with increased handling but less capital expenditure. The MDF offers either CGF1 or CGF2 integral flanges using a simple three (3) machine process allowing efficient ductwork manufacture for medium to high volume workshops.

The three stages are described below

On Machine 1 creates the ductwork blank direct from coil with, levelling, stiffening and notching for the corner folds, and Pittsburgh seam detail. The added feature of the inline Pittsburgh creates the male and female seam as it cuts through the material. The result of this stage is a flat blank in preparation for rolling the integral flange




Machine 2 is a freestanding Flange former which is identical to the fitting Flange Former offered as part of the Pro-Duct DRS package (refer to CGF1 & CGF2 Flange Rollformer data sheets). This enables straight ducts and fittings to be formed with either the CGF1 or CGF2 flange of your choice. The ductwork blanks are taken from the stage 1 machine and rolled dependant on the Flange size required.



Machine 3 is the final machine in the straight duct forming operation. The sheet with male and female Pittsburgh on the seam edges and CGF1 or CGF2 Flanges on the remaining two sides is placed on the infeed roller table. The duct size is pre-programmed into the folding machine and the duct is folded and seam closed with minimal operator input. **This unique feature designed by FIRMAC allows the Pittsburgh seam to be closed in the duct cycle before being discharged from the machine.**

This feature eliminates the need for a separate closing machine (Whisper-lock etc.) and obviously saves all the extra handling time because when the duct exits from the machine it is already complete with a closed seam.



Products with/without seam allowances		Complete Ducts U-Section with lid U-Section L-Section Flat sheet levelled
Coilholder on tracks		2 to 6 coils in line
Coil Weight		max. 5.000 kg
Coil Width		1000 – 1500mm (2000 mm System also available)
Coil Inside dia		508 mm (610mm option)
Gauges	Galvanized Sheet	0.60 – 1.2 mm
No. of levelling rolls		3
Stiffening		Pleating (Beading optional)
Min. size	Complete Duct	150 mm x 150 mm
Max. size	For handling reasons	2000 x 2000 mm
Speed approx.	Each section has its own speed therefore the actual duct speed depends on the System you choose to use. Our recommendation is to operate batches from Each stage	
Input jobs		Touch screen on the Machine
Controller		Omron
Electrical supply		
Stage 1		380-420 ACV, 25Amps per phase, 50-60Hz
Stage 2		380-420 ACV, 16Amps per phase, 50-60Hz
Stage 3		380-420 ACV, 6Amps per phase, 50-60Hz
Air Pressure	Industry Standard	7 bar
Machinery sizes		
Stage 1		5400 (2 coils) + 1100 per coil x 3500 x 1600
Stage 2		4900 x 1100 x 1100
Stage 3		5000 (includes conveyor) x 2000 x 1100
Colours		Grey and blue
Language Controller / Manual		English