

1. Technical Documentation

CE identification



Name and address of manufacturer

Fa. Zeman Bauelemente
St. Lorenzen 39
A-8811 Scheifling

Tel.: +433582/2208-0
Fax: +433582/2208-46
E-mail: Zeman@murau.at
www.zebau.com

Name and address of buyer

Stroyindustria LLC, 4A
Plekhanivska str.
Kharkiv 61192
UKRAINE

Place of manufacture

Production plant of the company Fa. Zeman Bauelemente
Schloßfeld 5
A-8811 Scheifling

Machine to which the documentation refers

System for the mechanical production of trapezoidal sheet metal using a continuous process and section shears consisting of the following:

- Moveable 15-t decoiler with loading table and hydraulic pressure roll.
- Base frame with draw-in rollers, lead-in guide, rotary shears, and 6 drive motors.
- Rollformer TR75 with 24 stations for the TR75/750 profile, with change cassettes.
- Rollformer TR107 with 25 stations for the TR107/750 profile, with change cassettes.
- Rollformer TR135 with 30 stations for the TR135/930 profile, with change cassettes.
- Two length adjustment tables to bridge the base frame.
- Flying section shears with integrated belt conveyor and cutter carriages for TR75/TR107/TR135.
- Acceleration conveyor L=8,000 mm.
- Automatic stacking unit. Stack length: min. 1,500 mm
max. 20,000 mm

Type designation

Decoiler unit:	ACM-15
Strip oiler:	SO2-1500
Flat shear:	FS-1500x1,5
Rollforming line:	RFB-30
Length compensation conveyor:	BF-4500
Flying profile cutter:	FPS
Acceleration conveyor:	BF-8000
Stacking unit:	STA-20000

Technical data

General machine data:

Drive power: approx. 120 kW
 Production speed: 0 to 40 m/min
 Operators: 2
 Machine dimensions: *Length:* approx. 70,000 mm
 Width: approx. 6,000 mm
 Height: approx. 2,600 mm

Decoiler:

Type: hydraulic clamping
 Coil weight: 15,000 kg
 Coil width: 1,250 mm / 1,500 mm
 Coil outer diameter: approx. 1,500 mm
 Coil inner diameter: approx. 480 to 620 mm
 Max. Sheet thickness: 1.5 mm
 Drive: Helical bevel geared motor
 GKS07-3 M VBR 100C32
 Driving power: 5.4 kW
 Procession speed: 0-40 m/min
 Pressure roll: *Drive:* hydraulic
 Loading table: *Drive:* hydraulic
 Load bearing capacity: 15,000 kg
Dimensions: *Length:* approx. 1,850 mm
 Width: approx. 5,000 mm
 Height: approx. 2,660 mm
 Weight: 5,760 kg

Base frame:

Drives: 6 geared motors each with 9,7 kW operated at 87 Hz
 Max. number of stations: 30
 Drive: Helical bevel geared motor
 GKS09-3 M HBR 132C12
 Driving power: 9.7 kW
 Procession speed: 0-40 m/min

Feeding device: Rubber coated rolls
 Drive: AC – Gearmotor, frequency controlled
 GKS05-3M HBR 090C12
 Driving power: 2,0 kW
 Processing speed: 0-40m/min
Feed-in device: *Width adjustment:* manual by handwheels
 Lead-in width: 1,500 mm (+/- 10 mm)

Strip oiler:

Type: *Roll type*
 Max. feed in width: *1500 mm*

Flat shear: *Cutting capacity:* Steel plate 0.75 – 1.25 mm (1.5 mm)
Cutting length: 1,500 mm
 Drive: AC – Gear drive
 GST05-2M VBR 071C42
 Driving power: 0.55 kW

Dimensions: *Length:* 500 mm
Width: 2,150 mm
Height: 1,560 mm
Frame height: 247 mm
Weight: 230 kg

Profile boxes TR75/750:

Number of boxes: 4 boxes each with 6 stations
 Distance between stations: 749,3 mm
 Corrugated material: Ck 45
 Blank material: 42 CrMo 4
 Dimensions: *Length:* 4,450 mm
Width: 1,975 mm
Height: 1,600 mm
Weight: ~5,000 kg/box

Profile boxes TR107/750:

Number of boxes: 5 boxes each with 5 stations
 Distance between stations: 901,7 mm
 Corrugated material: Ck 45
 Blank material: 42 CrMo 4
 Dimensions: *Length:* 4,450 mm
Width: 1,975 mm
Height: 1,600 mm
Weight: ~5,500 kg/box

Profile boxes TR135/930:

Number of boxes: 6 boxes each with 5 stations
 Distance between stations: 901,7 mm
 Corrugated material: Ck 45
 Blank material: 42 CrMo 4
 Dimensions: *Length:* 4,450 mm
Width: 1,975 mm
Height: 1,600 mm
Weight: ~6,500 kg/box

Length compensation conveyor:

Quantity:	2 pcs.
Type:	Roller conveyor
Dimensions:	<i>Length:</i> 4,450 mm <i>Width:</i> 1,975 mm <i>Height:</i> 1,000 mm <i>Weight:</i> 1,500 kg

conveyor:

Quantity:	1 pcs.
Type:	Roller conveyor
Dimensions:	<i>Length:</i> 4,450 mm <i>Width:</i> 1,975 mm <i>Height:</i> 1,000 mm

Flying profile cutter:

Type:	Flying type with integrated belt conveyor
Pressing drive:	hydraulic
Cutting drive:	hydraulic
Cutting capacity:	Steel plate 0.75 – 1.25 mm (1.5 mm)
Cutting tools:	One cutting tool each for TR75, TR107, TR135
Synchronizing drive:	Servo geared motor GKR06-2A SBR 17NC41
Driving power:	4,1 kW
Belt drive:	AC – Gear drive GST06-2M VBR 090C12
Belt drive power:	2,0 kW
Feeding drive:	Helical bevel geared motor GKS05-3M HBR 090C12
Feeding drive power:	2,0 kW

<i>Dimensions:</i>	<i>Length:</i> 4,380 mm <i>Width:</i> 3,625 mm <i>Height:</i> 2,000 mm <i>Weight:</i> 5,200 kg
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Acceleration roller bed:

Type:	Belt conveyor
Drive:	AC geared motor GST06-2M VBR 090C32
Driving power:	2,0 kW
Drive:	AC geared motor GKS05-3M HBR 090C32
Dimensions:	<i>Length:</i> 8,000 mm <i>Width:</i> 1,825 mm <i>Height:</i> 1,520 mm <i>Weight:</i> 3,300 kg

Auto stacker:

Production speed:	0 to 60 m/min
Stack lengths:	min: 1,500 mm max: 20,000 mm
Max. package weight:	5 tons
End stop drive:	AC geared motor GST06-2S VBR 12HC35
End stop drive power:	2,8 kW
Lifting table drive:	AC geared motor GKR06-2M VBR 112C31
Lifting table drive power:	5,5 kW
Cross conveyor drive:	AC geared motor GKS07-3M HBR 090C32
Cross conv. Drive power:	1,5 kW
Dimensions:	<i>Length:</i> 21,400 mm <i>Width:</i> 4,780 mm <i>Height:</i> 2,250 mm <i>Weight:</i> 13,000 kg

Control system:

Type:	PLC with visualization
Control voltage:	24 VDC

Unfinished material data

TR75/750

Base material:	STE 280, STE 320 acc. to DIN EN 10147, galvanized or galvanized and coated
Tensile strength:	max. 450 N/mm ²
Strip width:	1,250 mm
Plate thickness:	0.75 mm – 1.25 mm (1,5 mm)

TR107/750

Base material: STE 280, STE 320 acc. to DIN EN 10147, galvanized or galvanized and coated
 Tensile strength: max. 450 N/mm²
 Strip width: 1,250 mm
 Plate thickness: 0.75 mm – 1.25 mm (1,5 mm)

TR135/930

Base material: STE 280, STE 320 acc. to DIN EN 10147, galvanized or galvanized and coated
 Tensile strength: max. 450 N/mm²
 Strip width: 1,500 mm
 Plate thickness: 0.75 mm – 1.25 mm (1,5 mm)

Product data

	<u>TR75/750</u>	<u>TR107/750</u>	<u>TR135/930</u>
Overall width:	750	750	930
Division:	187,5	250	310
Section height:	75	107	135
See also			
Section drawing:	P01	P02	P03

Connection data

Connected rating: 120 kW
 Power supply: 3 x 400 VAC, 50 Hz

Noise, emissions

Noise: below 78 dB (during operation)
 Emissions: none

Installation site

This machine is designed to be operated in roofed, dry, and dust free rooms.

Ambient temperature for trouble free operation of the machine: 10° to 30°C

The floor in the installation area (support points) must have a min. load bearing capacity of 50 kN/m².

Installation and initial startup

Assembly, installation, and initial startup of the machine must be carried out by technicians of the company Zeman or under the supervision and instructions by representatives sent by the company Zeman.

The following are important for assembly and installation:

- Checking the installation site including the foundation
- Checking the load bearing capacity of the floor
- Compliance with local industrial safety rules and regulations
- Compliance with local safety rules and regulations for lifting equipment (hoist, crane, forklift, stacker, etc.)
- Matching the support points of machine parts when pulling one over the other

The following are important for the initial startup:

- Anchoring of the switching cabinet before cabling
- Cabling between switching cabinet and electrical components as per wiring diagram
- Cabling between switching cabinet and control panels as per wiring diagram
- Checking wiring and cabling to match wiring diagram
- Checking cabling for mechanical damage
- Checking wiring for grounding or short-circuit
- Check cross section of feed line
- Check the feed line fuse protection
- Checking supply voltage (3 x 400VAC, 50Hz)
- Checking wiring and cabling to match for conformity with local rules and regulations
- Compliance and observance of the initial startup instructions in the operating manual

Use as intended

This machine is designed for the automatic production of trapezoidal metal sheets with a profile height of up to 220 mm and may not be used for any other purposes.

Specification of the materials to be processed: See base material data

Using materials other than those listed here may damage the machine.

Operators and operator qualification

Number of operators needed to run the machine: 2

Control points:

Control panel 1 (section shears)
Control panel 2 (decoiler)
Control panel 3 (stacking unit)

Workstation operator 1:

Control panel 1 (section shears)

Control panel 2 (decoiler)
Control panel 3 (stacking unit)

Tasks operator 1:

- System start
- Preparing machine for operation
- Preparing machine for production
- Selecting and preparing units required for production (decoiler, stacker)
- Entering production data
- Monitoring lead-in area
- Monitoring production process/steps
- Visually checking product for surface flaws (coating flaws, scratches, etc.)
- When changing coil, operating the decoiler and assisting with threading
- After package end, assisting with removing package from stacking unit

Qualification operator 1:

- The operator must have basic knowledge of the Microsoft Windows environment and be able to enter data using the keyboard.
- The operator must be informed and trained concerning local or machine-specific industrial safety rules and regulations.
- The operator must be able to independently decide and carry out any possibly required mechanical adjustments and settings on the machine effecting the function of the machine.
- The operator must be qualified for his or her assigned range of duties.

Workstation operator 2:

Control panel 3 (stacking unit)

Control panel 2 (decoiler)

Tasks operator 2:

- Monitoring the stacking area and the stacking process
- Visually checking product for surface flaws (coating flaws, scratches, drive, etc.) if possible
- Assisting with coil change and threading
- After package end, assisting with removing package from stacking unit

Qualification operator 2:

- Operator 2 must be able to follow instructions by operator 1 and be able to complete the assigned tasks.
- The operator must be trained for the production processes and steps of the machine.
- The operator must be informed and trained concerning local or machine-specific industrial safety rules and regulation.
- The operator must be qualified for his or her assigned range of duties.

Definition of "Qualified Personnel"

Qualified personnel are persons who, because of their training, experience and instruction as well as their knowledge of the relevant standards, regulations, rules of accident prevention and operating instructions, have been authorized by those responsible for safety to perform whatever tasks may be needed, and who are able to recognize and avoid potential dangers associated with these tasks.

Safety notes

This chapter includes a general introduction of the safety notes as well as a description of the meaning and safety information of the safety markings and signs located on the machine. Here you will also find important accident prevention information.

Persons responsible for safety:

Owner-operator

- The owner-operator is any natural or legal entities (persons or companies) using or operating the machine or commissioning or assigning the use or operation of the machine.
- The owner-operator or his or her safety representative must guarantee the following:
 - ✗ Compliance with all relevant rules, notes, information, and laws.
 - ✗ Only qualified persons are working on or with the machine.
 - ✗ Persons working with or on the machine have easy access to the operating manual.
 - ✗ Nonqualified persons are prohibited from working on or with the machine.

General safety notes

- These safety notes do not claim to be complete.
- At the time of delivery, the machine is constructed according to state-of-the-art technology and is safe to operate.
- The machine may pose a hazard if:
 - ✗ nonqualified persons are working on or with the machine.
 - ✗ the machine is used improperly, not as intended, or inappropriately.
 - ✗ specified mandatory safety rules are violated or not observed.
 - ✗ specified mandatory safety elements (e.g. safety grid) are removed.
- Never operate the machine when damaged or defective.
- Constructional modifications or changes of and to the machine are fundamentally prohibited and must always be approved by the company Zeman first.

Safety signs and markings

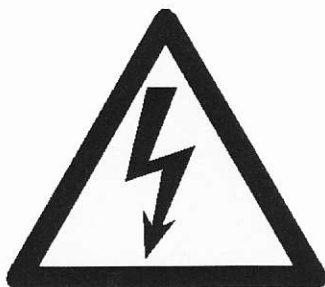
The following signs may be attached to the machine:

Hazard signs

Hazard signs are safety signs warning of objects and conditions that may result in injury or property damage.



Risk of crushing
injury



High voltage warning



Risk of hand injury



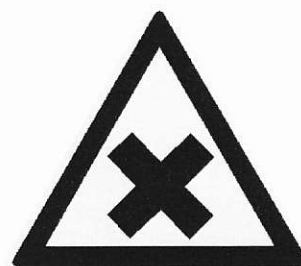
Hazard warning



Personnel may get
dragged into machine



Hot surface warning



Toxic substance warning

Warning signs

Warning signs prescribe a certain behavior that protects from injury or damage. The operating personnel must comply with the safety and health protection signs.



Use gloves



Use helmet



Use hearing
protection

Important information for persons working with or on the machine

- Only authorized, skilled, and trained persons are allowed to operate, maintain, and repair this machine. These persons must have read and understood this documentation and especially the chapter "Operating manual." These persons must also have attended training by the manufacturer (attendance documentation)!
- Always comply with the industrial safety guideline and the accident prevention rules and regulations!
- The machine may only be operated with all safety covers in place and locked or latched!
- The machine may only be operated with the supplies, media, and spare parts provided or approved by the manufacturer!

Important information for the owner-operator of the machine

- Responsibilities for and during operation, repair, and maintenance of the machine must be clearly defined as to prevent misunderstandings affecting safety, responsibility, and competency.
- The machine may be operated only if free of any damage or defects and if all protective equipment has been installed and activated.
- The owner-operator must ensure – insofar as necessary – that all persons working on or with the machine wear protective clothing and gloves.
- The specified mandatory deactivation and switching off procedure of the machine must be observed before any activity conducted on or with the machine.



Danger!

Individual components in the switching cabinet may be energized up to 5 minutes after turning off the mains power supply! Before opening the switching cabinet or terminal boxes, the machine must have been disconnected from the mains power for at least 5 minutes.



Danger!

The full supply voltage is maintained at the feed line even after the main switch has been switched off. Disconnect the machine completely from the mains power before commencing any work on the feed line.

Possible malfunctions

See "Operating instructions general"

Liability

- All information contained in this operating manual describes the properties and function of the product without guaranteeing either. Especially changes after this manual was printed cannot be considered.
- The manufacturer does not assume liability for damages incurred due to the following:
 - ✖ Inappropriate or improper use of the machine.
 - ✖ Disregard of the operating manual and instructions.
 - ✖ Unauthorized constructional modifications of the machine.
 - ✖ Improper/incompetent working with or on the machine.
 - ✖ Operation of the machine without the statutory safety elements.
 - ✖ Operation of the machine defective safety elements.
 - ✖ Operation of the machine with nonfunctional, malfunctioning, or improperly attached or installed safety and protective devices and equipment.
 - ✖ Insufficient monitoring of machine components subject to wear and tear.
 - ✖ Improperly/incompetently performed repairs.
 - ✖ Unauthorized, improper, or incompetent change of operational parameters.
 - ✖ Disasters, impact of foreign or external objects, and force majeure.
 - ✖ The manufacturer does not assume liability for consequential damages incurred due to a possible malfunction of the machine.

Warranty

- Warranty terms and conditions: See sales and delivery terms and conditions of the company Zeman and the contractual agreements.
- Warranty claims must be immediately reported to the company Zeman upon detection of the flaw, defect, or nonconformity.
- The warranty always becomes null and void when a cause for liability cannot be claimed.

Copyright

The company Zeman owns the copyright of this operating manual. This operating manual is intended only for the owner-operator and his or her personnel.

The rules and information contained in this operating manual may not be

- changed,
- duplicated or copied,
- distributed, or
- disseminated otherwise, either in part or as a whole.

Type plates

Decoiler:

Stahlbau – Maschinenbau

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St. Lorenzen 39 Tel.: 03582 / 2208-0 e-mail: zeman@murau.at
A-8811 Scheifling Fax: 03582 / 2208-46 www.zebau.com

Machine:	Moveable decoiler
Type:	ACM-15
Serial number:	ACM-15-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Output:	5.4 kW
Year of manufacture:	2012



Strip oiler:

Stahlbau – Maschinenbau

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Machine:	Strip oiler
Type:	SO2-1500
Serial number:	SO2-1500-523.346-2012
Machine number:	523.346
Output:	0,25 kW
Year of manufacture:	2012



Flat shear:



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www.zebau.com

Machine:	Flat shear
Type:	FS-1500x1,5
Serial number:	FS-1500x1,5-523.346-2012
Machine number:	523.346
Output:	0,55 kW
Year of manufacture:	2012



Rollfomer:



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Machine:	Rollfomer
Type:	RFB-30
Serial number:	RFB-30-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Output:	60 kW
Year of manufacture:	2012



Length compensation conveyor-1:



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e-mail: zeman@murau.at
www.zebau.com

Machine:
Type:
Serial number:
Machine number:
Year of manufacture:

Length compensation conveyor
BF-4500-1
BF-4500-1-523.346-2012
523.346
2012



Length compensation conveyor-2:



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Fax: 03582 / 2208-46

e-mail: zeman@murau.at
www.zebau.com

Machine:
Type:
Serial number:
Machine number:
Year of manufacture:

Length compensation conveyor
BF-4500-2
BF-4500-2-523.346-2012
523.346
2012



Length compensation conveyor-3:



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e-mail: zeman@murau.at
www.zebau.com

Machine:	Length compensation conveyor
Type:	BF-4500-3
Serial number:	BF-4500-3-523.346-2012
Machine number:	523.346
Year of manufacture:	2012



Flying Profile Cutter:



St. Lorenzen 39
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Tel.: 03582 / 2208-0
Fax: 03582 / 2208-46


e-mail: zeman@murau.at
www.zebau.com

Machine:	Flying Profile Cutter
Type:	FPS
Serial number:	FPS-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Output:	8.1 kW
Year of manufacture:	2012




Acceleration conveyor:

Stahlbau – Maschinenbau

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Machine:	Acceleration conveyor
Type:	BF-8000
Serial number:	BF-8000-523.346-2012
Machine number:	523.346
Production speed:	0-60 m/min
Output:	2.0 kW
Year of manufacture:	2012



Auto stacker:

Stahlbau – Maschinenbau

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Machine:	Auto stacker
Type:	STA-20000
Serial number:	STA-20000-523.346-2012
Machine number:	523.346
Production speed:	0-60 m/min
Output:	10.0 kW
Year of manufacture:	2012



Profile box 1 – TR75:

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Machine:	Profile box
Type:	PB-TR75-1
Serial number:	PB-TR75-1-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 2 – TR75:

Stahlbau – Maschinenbau

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Machine:	Profile box
Type:	PB-TR75-2
Serial number:	PB-TR75-2-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 3 – TR75:



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Machine:	Profile box
Type:	PB-TR75-3
Serial number:	PB-TR75-3-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 4 – TR75:



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Tel.: 03582 / 2208-0
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e-mail: zeman@murau.at
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Machine:	Profile box
Type:	PB-TR75-4
Serial number:	PB-TR75-4-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 1 – TR107:

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Machine:	Profile box
Type:	PB-TR107-1
Serial number:	PB-TR107-1-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 2 – TR107:

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Machine:	Profile box
Type:	PB-TR107-2
Serial number:	PB-TR107-2-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 3 – TR107:

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Machine:	Profile box
Type:	PB-TR107-3
Serial number:	PB-TR107-3-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 4 – TR107:

Stahlbau – Maschinenbau

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Machine:	Profile box
Type:	PB-TR107-4
Serial number:	PB-TR107-4-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 5 – TR107:



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Fax: 03582 / 2208-46

e-mail: zeman@murau.at
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Machine:	Profile box
Type:	PB-TR107-5
Serial number:	PB-TR107-5-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 1 – TR135:



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Fax: 03582 / 2208-46

e-mail: zeman@murau.at
www.zebau.com

Machine:	Profile box
Type:	PB-TR135-1
Serial number:	PB-TR135-1-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 2 – TR135:

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Machine:	Profile box
Type:	PB-TR135-2
Serial number:	PB-TR135-2-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 3 – TR135:

Stahlbau – Maschinenbau

**ZEMAN**
Bauelemente
Produktionsgesellschaft m.b.H.

St. Lorenzen 39 Tel.: 03582 / 2208-0 e-mail: zeman@murau.at
A-8811 Scheifling Fax: 03582 / 2208-46 www.zebau.com

Machine:	Profile box
Type:	PB-TR135-3
Serial number:	PB-TR135-3-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 4 – TR135:



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Machine:	Profile box
Type:	PB-TR135-4
Serial number:	PB-TR135-4-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 5 – TR135:



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Fax: 03582 / 2208-46

e-mail: zeman@murau.at
www.zebau.com

Machine:	Profile box
Type:	PB-TR135-5
Serial number:	PB-TR135-5-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012



Profile box 6 – TR135:



St. Lorenzen 39
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Fax: 03582 / 2208-46

e-mail: zeman@murau.at
www.zebau.com

Machine:	Profile box
Type:	PB-TR135-6
Serial number:	PB-TR135-6-523.346-2012
Machine number:	523.346
Production speed:	0-40 m/min
Year of manufacture:	2012

