

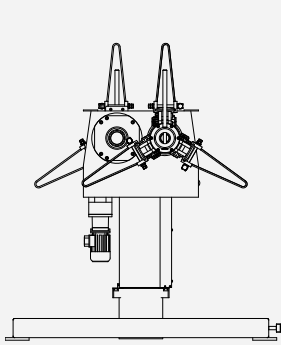


[www.swah.cz](http://www.swah.cz)

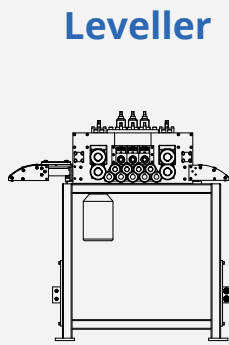


ROLLFORMING  
LINES

# Universal Rollforming Lines



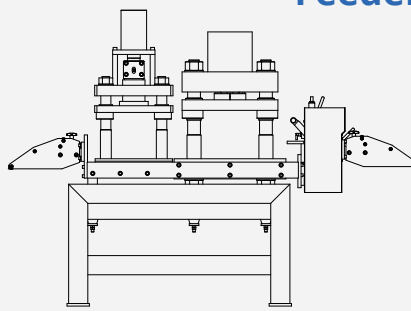
**Decoiler**



**Leveller**



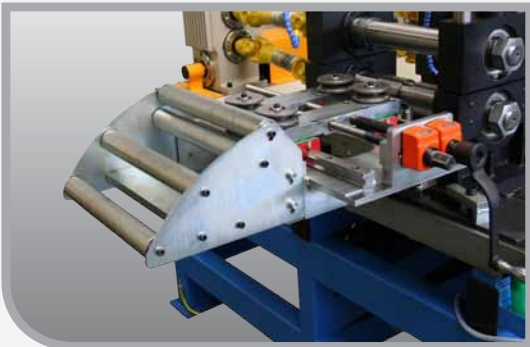
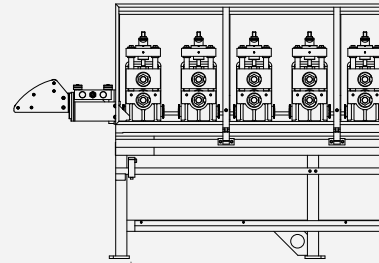
**Feeder**



**Punching press**



**Loop control**



*Guiding vice*

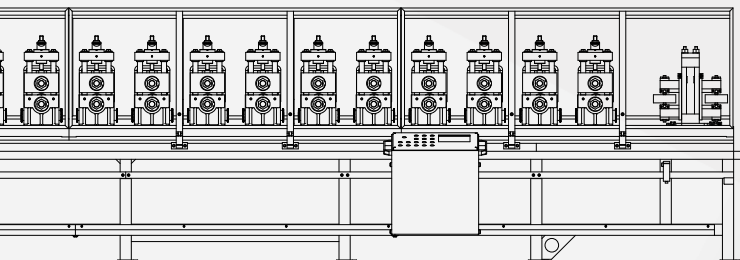


*Quick change cassettes*

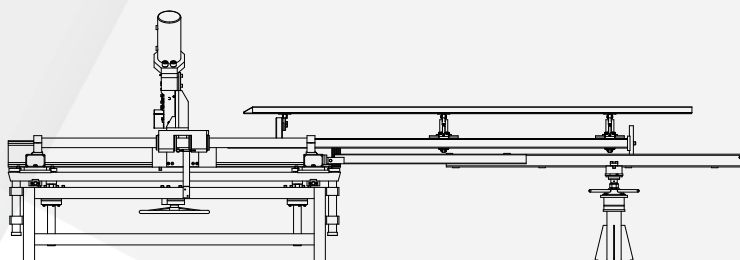


## We design the rollforming line according to your requirements

- Custom design and manufacturing
- Own production of all machine parts
- Connection to a company computer control system
- Quick change cassette system
- Parts production, including holes, cutouts and bends
- Automatic stacking systems
- Speed up to 80 m/min
- Production accuracy  $\pm 0,1$  mm



**Rollforming line**



**Cutting unit**

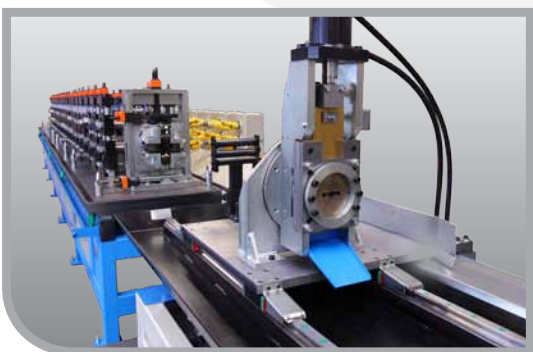
**Run out table**



*Straightener*

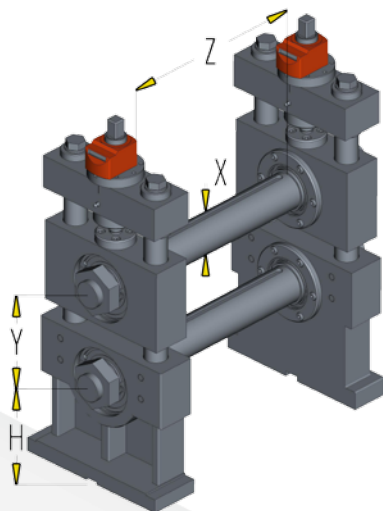


*Machine drive*

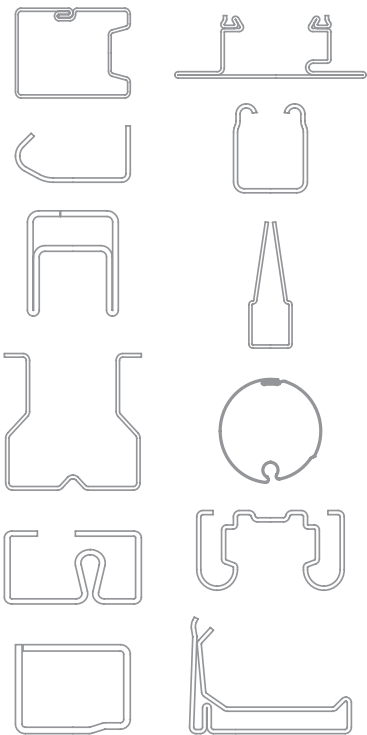


*Flying cutting unit*

| Profiling stand | H   | Y         | X  | Z         |
|-----------------|-----|-----------|----|-----------|
| PZM             | 100 | 97 - 140  | 35 | 160 - 300 |
| PZA             | 120 | 90 - 145  | 44 | 160 - 420 |
| PZB             | 150 | 116 - 176 | 50 | 140 - 730 |
| PZC             | 180 | 140 - 200 | 65 | 160 - 760 |
| PZD             | 220 | 160 - 270 | 80 | 400 - 820 |

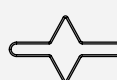
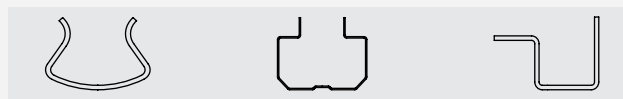


**Examples of use**



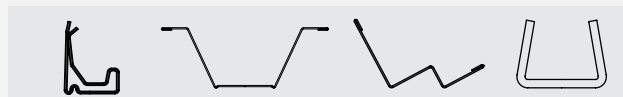
# Compact Rollforming Lines

## VS 7



| Number of stands | Shaft diameter | Material thickness | Material width |
|------------------|----------------|--------------------|----------------|
| 8/16             | Ø 50 mm        | max. 2 mm          | 150 mm         |

## VS 5



| Number of stands | Shaft diameter | Material thickness | Material width |
|------------------|----------------|--------------------|----------------|
| 10/20            | Ø 35 mm        | max. 1,5 mm        | 120 mm         |

## VS 4

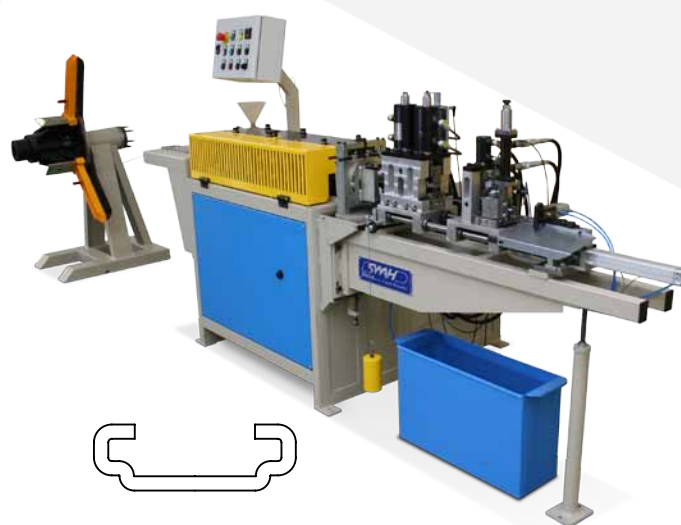


| Number of stands | Shaft diameter | Material thickness | Material width |
|------------------|----------------|--------------------|----------------|
| 8/16             | Ø 35 mm        | max. 1,5 mm        | 120 mm         |



- Simple rollforming lines
- Double sided rollforming
- momentary placement of the rolling tools
- Cost effective machines
- Manual and automatic control
- Parts production from a coil or from the sheet metal strip
- Fixed shafts pitch
- CNC control

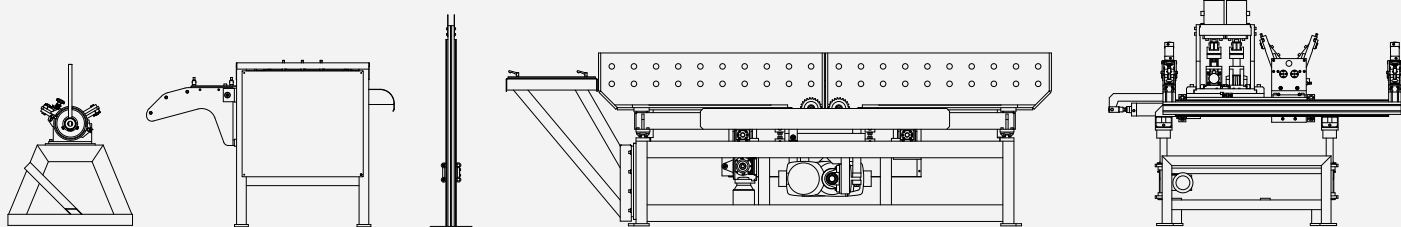
## VS 1, 2, 3



|     | Number of stands | Shaft diameter | Material thickness | Material width |
|-----|------------------|----------------|--------------------|----------------|
| VS1 | 7                | Ø28 mm         | max. 1 mm          | 60 mm          |
| VS2 | 9                | Ø28 mm         | max. 1 mm          | 60 mm          |
| VS3 | 11               | Ø28 mm         | max. 1 mm          | 60 mm          |

|     |  |
|-----|--|
| VS1 |  |
| VS2 |  |
| VS3 |  |

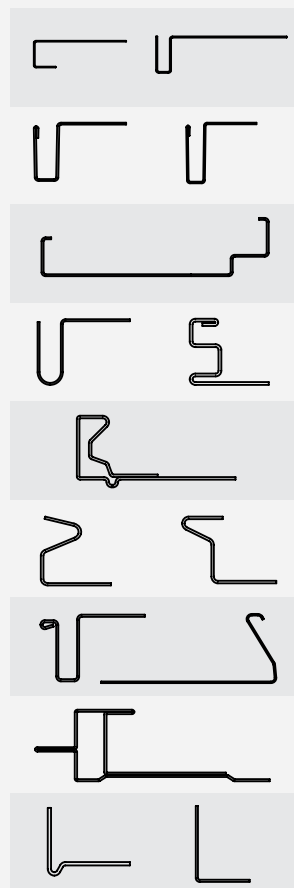
# Duplex Rollforming Lines



## Machine details



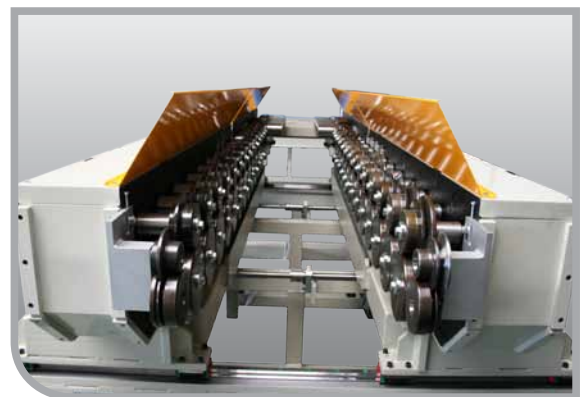
## Profiles samples



- Parts production with a variable width
- Quick change cassettes system
- Parts production from a coil or from sheet metal strips
- Manual and automatic control
- Main rollforming gearbox in oil bath



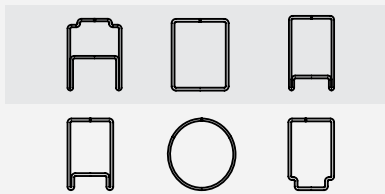
- Complete production of shelves, panels and other similar parts
- Precutting, punching, rollforming, cutting and cross bending
- Machines custom design and construction



# Longitudinal Welding



Profiles samples



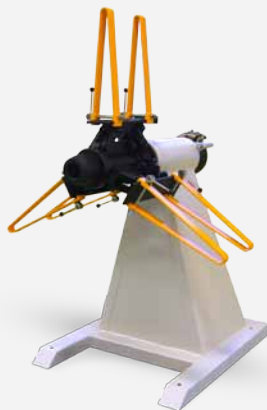
- HF, laser or TIG
- up to 70m/min
- Material thickness 0,6-4mm
- Fully automatic CNC control

## Decoilers



### 1t

- Mechanical brake
- Mechanical expansion



### 2t

- Pneumatic brake
- Mechanical expansion
- Pushing arm (optional)
- Drive (optional)



### 2x2t turning

- Pneumatic brake
- Mechanical expansion
- Electric turning (optional)
- Pushing arm (optional)
- Drive (optional)



### 5t vertical

- Pneumatic brake
- Hydraulic expansion
- Drive (JOG or full drive)
- Pushing arm (optional)
- Loading car (optional)

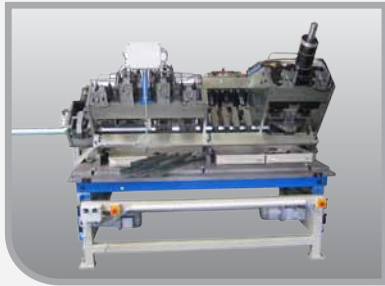


### 5t horizontal

- Mechanical brake
- Mechanical expansion
- Strip width up to 1500mm



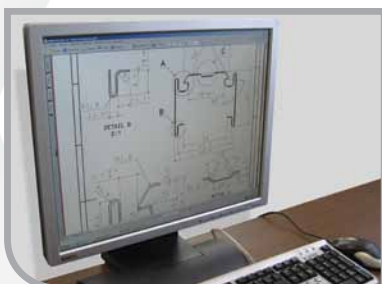
# Punching and Forming Presses



- Up to 400 strokes/min
- Punching and profiling up to 60 m/min.
- Multi punching and forming
- Hydraulic drive
- Link to the automatic line
- Pre-punching prior to rollforming
- Punching and forming after rollforming

## Sets of forming rolls

- Our own design and production
- Rolls machining after heat treatment
- Heat treatment
- Calibration tests
- Universal rollforming sets for various profiles
- Production of forming rolls for rollforming machines of other producers



# Profiles Cutting



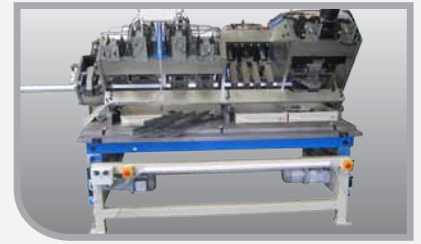
## Flying Cutting With Linear Motor

- The highest speed
- The highest load
- Robust construction
- Travel length of 2000/3000mm



## Flying Cutting Unit with Servo Drive and Ball-screw

- Lighter construction of cutting adaptors
- Travel length 1200mm



## START-STOP Cutting

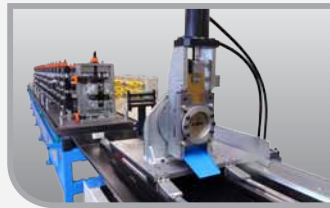
- Cost effective
- High accuracy of positioning
- Suitable for multi punching and forming

# Cutting Adaptors



## Adaptor for cutting without scrap

- High productivity
- Simple profiles
- Simple tools



## Adaptor for cutting with scrap

- Mid-high productivity
- Complex profiles



## Adaptor for cutting closed profiles

- Middle productivity
- Very complex profiles
- Complex tools



## Sawing adaptor

- Medium and low productivity
- The most complex profiles
- Highspeed and low-speed version

# Run-out Tables



## Fixed Table

- For profiles in the range of 2500-6000mm
- Hydraulically tilting
- Single side or double side version



## Towed Table

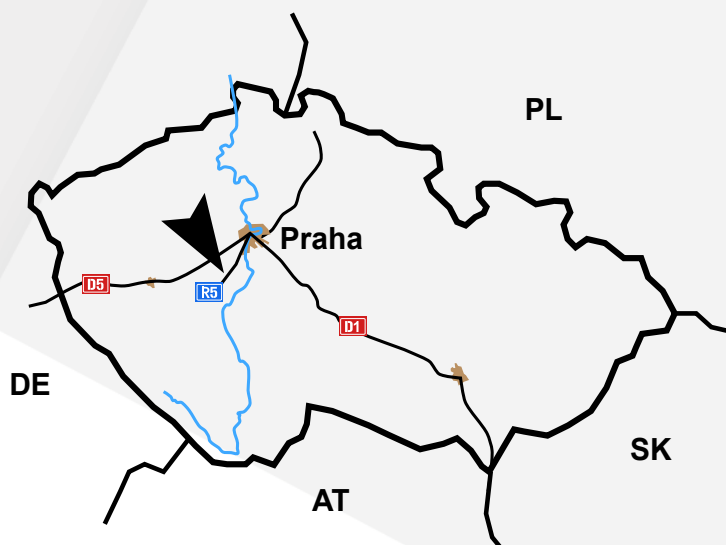
- For profiles 20-3000mm
- Suitable for short profiles
- Pulled by cutting unit
- Pneumatically tilting



## Chain and Fork Stacking Equipment

- Accessories for stacking
- Suitable for fluent production
- Simple stacking to a package

# About the company



## History

Beginnings of the SWAH company reach back to 1988 when a small single-purpose machine manufacturing plant came into being. After ten years of successful operations, new manufacturing premises were established with an area of 3000 m<sup>2</sup>, only 30 minutes away from Prague airport. The production is focused on roll-forming lines and machines manufacturing HVAC duct.

## Current production

Nowadays, the company is present on a global scale and has a strong position in the production of roll-forming lines. Constant improvement and development of machines brings significant success and many loyal customers.

## People

SWAH was established and built by three partners supported by their families. People working in the company are professionals in their branches and most of them have been working here since the company's establishment. People are the most important part of our company.

## SWAH s.r.o.

Pražská 354

252 29 Dobřichovice - Lety

GPS: 49°55'28.301"N, 14°15'43.140"E

## Production

Design, selection of suitable material, technology, manufacturing precision and mostly experienced people are the prime mainstays



of our company. Thanks to the most modern production technology and ongoing renewal of our machinery, we manufacture high-quality, productive machines with a long lifespan.





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