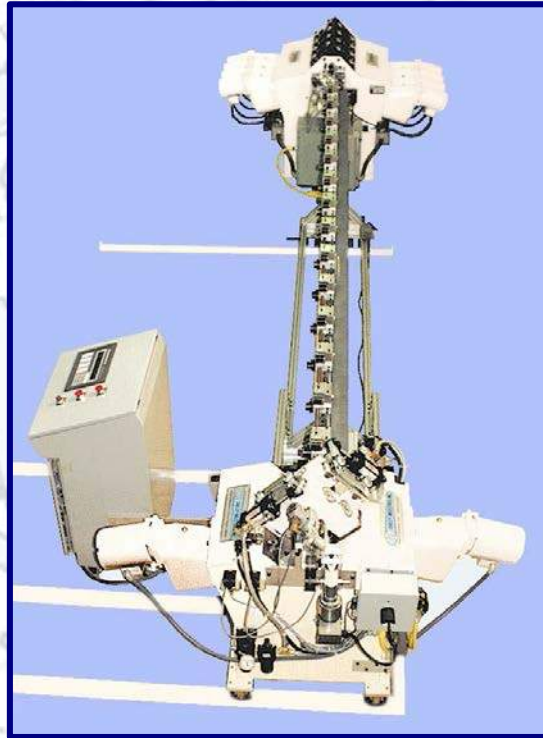
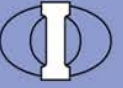


Machine Features

- CONTINUOUS PROCESS FOR LENGTH CONTROL ELIMINATES SECONDARY OPERATIONS
- **CLOSE LENGTH TOLERANCE: +/- 1.5mm (.062")** FOR MOST ELEMENTS
- LENGTH CHANGE IN LESS THAN 30 SECONDS
- CAN ACCOMODATE ELEMENTS AS SHORT AS 400mm (15.75")
- PROVIDES A MAJOR COST SAVING IN BOTH MATERIAL AND LABOR
- SPECIAL DESIGN ELIMINATES THE NEED FOR COSTLY AND MESSY HYDRAULICS



The **Oakley Roll to Length Machine** is designed to produce elements of a consistent length. The length of each element is precisely measured as it exits from the roll reducer, and then the elements are elongated in the Roll to Length Machine to the preset length.

Elongation is accomplished by additionally reducing the diameter of the elements from 0.05mm to 0.18mm (.002" to .007"). The Roll to Length reducing rolls close on the element approximately 229mm (9") from the leading edge and then remain in contact with the element until the desired length is achieved. However, the rolls are always released at least 150mm (6") from the trailing end of the element. The section that is additionally reduced will vary from element to element depending upon the elongation required.

Both the transfer system and the Roll to Length Machine are mounted on tracks so they can easily be rolled away from the reducer. This allows for independent operation of either the reducer or the Roll to Length Machine.

Our control system features a standard programmable controller that aids in trouble-shooting and simplifies the replacement of parts. The desired length and the upper and lower acceptable limits are programmed into a message center that can store up to 20 different programs. This eliminates the need to reprogram the machine for every new element. Diagnostic information is also provided to further simplify trouble-shooting.

Signals are provided to indicate any elements that exit from the reducer already too long or any elements that cannot be elongated to the preset minimum length. An alarm is supplied to signal either of these conditions.

These signals can also be used to operate an optional sorting device. There are two major cost advantages to the use of this machine. Costly operations such as re-rolling short elements and trimming back long elements are eliminated. Secondly, because the starting tube length for elements used with the Roll to Length Machine must be shortened to ensure all the elements will be shorter than the targeted rolled length, there is a considerable savings in material as well.

The length tolerance held by the Roll to Length Machine is normally +/- 1.5mm (.062") for most elements. For the best results, a new set of rolls should be installed on the roll reducer when the Roll to Length Machine is installed.

Machine Specifications

Length:	Max. Element Length +1168mm (46") from the exit end of the reducer to the exit end of the RTL
Width:	2159mm (85")
Height:	1104mm (43.5")
Weight:	545 kg. (1200 lbs.)
Electric Supply:	220/380/440v—3ph 50/60hz
Air Supply:	5.6 bar (80 psi)
Min. Diameter:	6mm (.238")
Max. Diameter:	12.7mm (.500")
Min. Length:	400mm (15.75")
Max. Length:	4500mm (15 ft.)