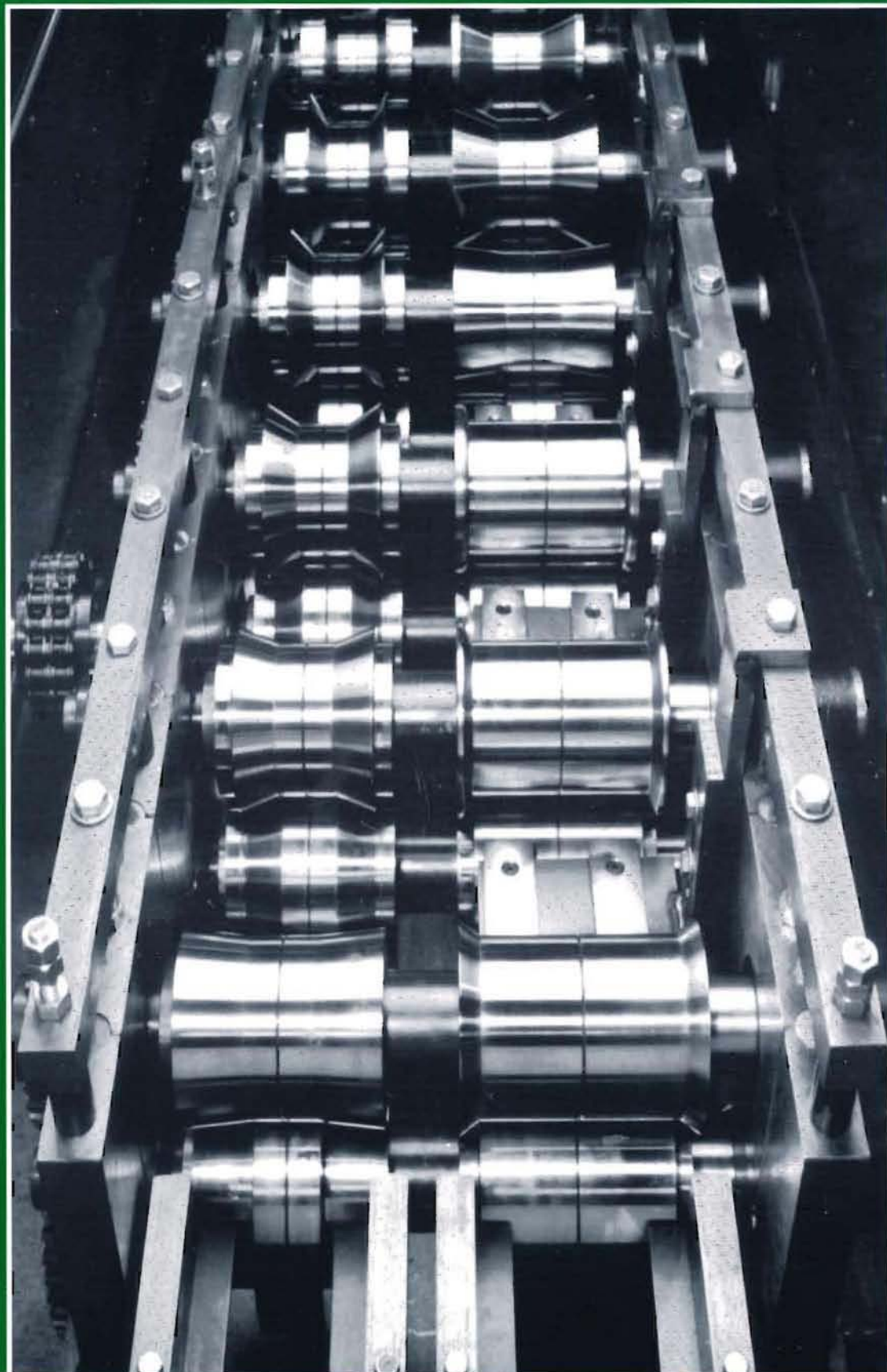


CUSTOM ROLLFORM PRODUCTS, INC.





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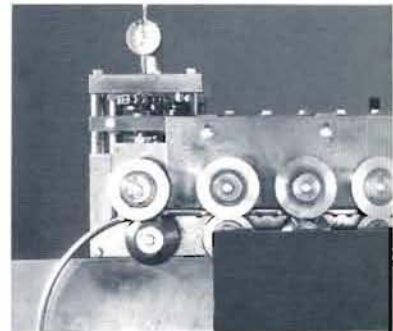
We started Custom Rollform Products, Inc. with the simple idea that quality and satisfaction sells. It really works! Give your customers quality, dependable equipment at fair prices and he will become your best sales tool and come back again and again.

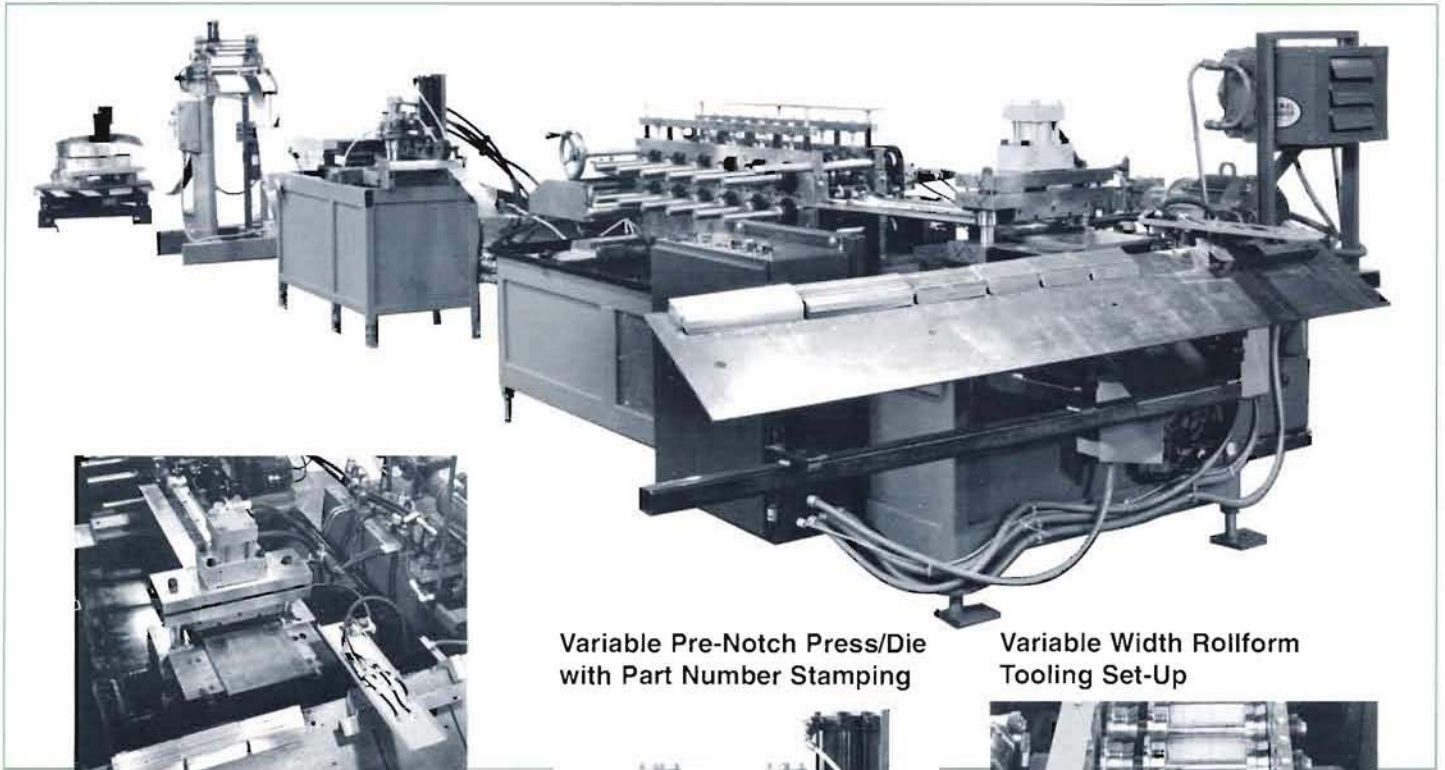
Today's industries are looking for dedicated, pre-tooled systems designed for on-time (just-in-time) production. Systems that utilize the most up-to-date technology to maximize production and minimize set-up, downtime and inventories.

Our systems feature the latest state-of-the-art concepts to offer complete fabrication systems designed per your production requirements from a single-source manufacturer. We're a full-service company specializing in sheet metal fabrication systems.

No matter what your requirements are, simple retro-fit, retool, free standing rollformer or a complete, turnkey system, I'm sure we can fulfill your needs.

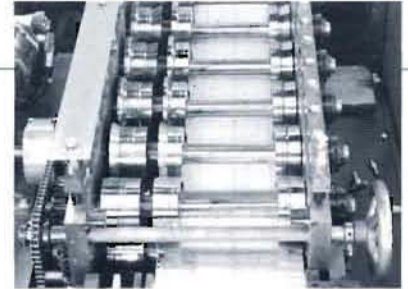
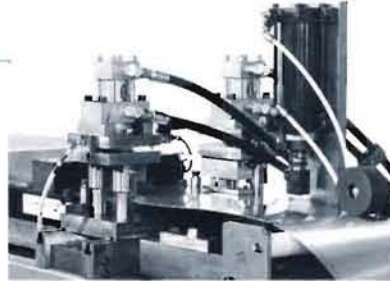
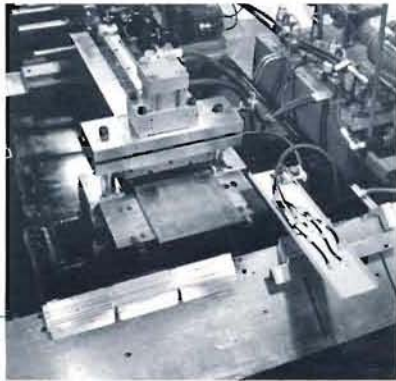
I believe you'll find we're large enough to handle your every production requirement, yet small enough to give every customer and job the personal attention to detail they deserve. Our slogan, "Quality Design Means Production You Can Afford", still holds true. Price doesn't always determine the best. We maintain a constant effort to achieve the best design, the best technology, the best equipment and the best service. Let us show you our best. It may be the best move you ever made.





Variable Pre-Notch Press/Die with Part Number Stamping

Variable Width Rollform Tooling Set-Up



Versatility to minimize downtime & set-up is the key to developing quality production systems.

Anyone can design and build a system to make parts, but the entire justification to automate can be compromised if valuable production time is lost in set-ups, changeovers and/or scrap loss.

Our design concepts are better because we understand the overall needs and requirements of our customers. Over the years we have developed and incorporated features that reduce set-up and downtime, allowing greater flexibility in material and part variations, with greater accuracy and dependability.

This system is just one example of the flexibility we offer. Pallet Decoilers allow you to load a complete skid load of coil strip stock at one time, the Pre Notch utilizes two (2) Hydraulic Edge Notch Presses that adjust for a wide range of strip widths, the Rollform Tooling is variable from a simple hand wheel lead screw adjustment and requires less than a minute to change from one part width to another.

The parts widths are also infinitely variable from 2" to 12" wide.

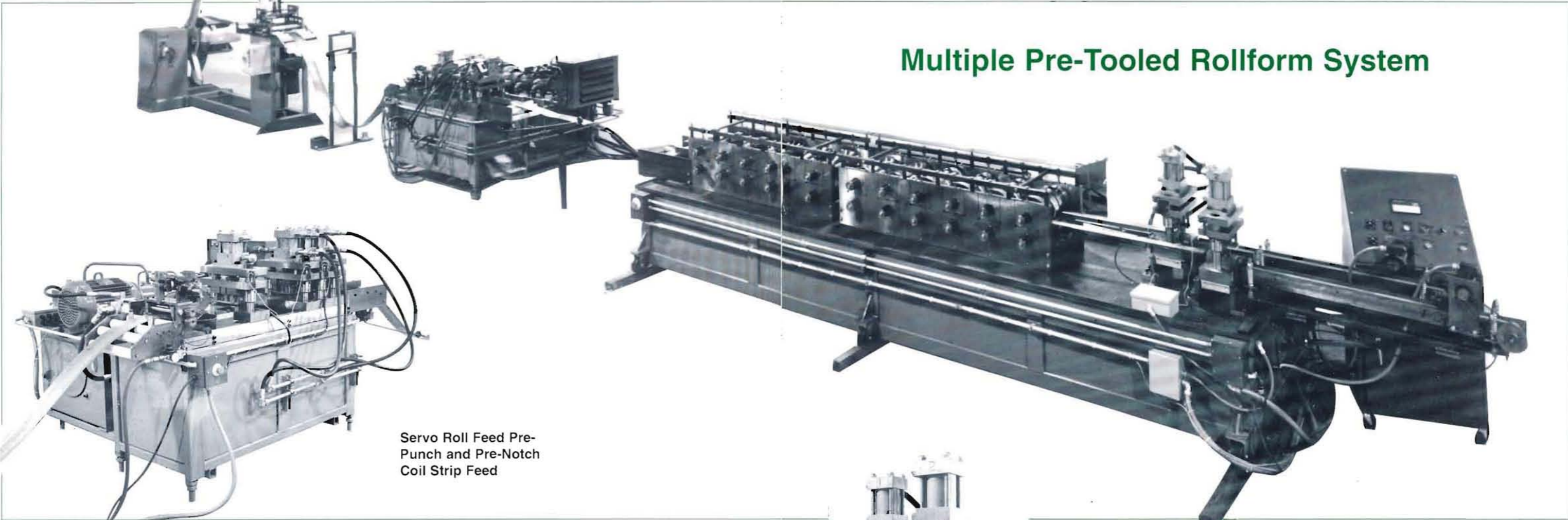
The Rollformer Feed Indexes (starts/stops) the strip through the Cut-Off Press and works totally independent of the Pre-Notch to maximize production.

The Cut-Off Press/Die uses the same die for all the width variations. Minimum set-up or changeover is required for either length or width changes. The parts are individually stacked in groups of 20, then ejected for a continuous pick and place operation.

General Specifications

- Material Formed 040 Aluminum
- Part Length 6 lengths from 1.85 to 11.725
- Part Width 13 widths from 1.833 to 11.778
- Production Rate 20 to 40 parts per minute
- Length Changeover 1 to 2 minutes
- Width Changeover (coil) 10 to 15 minutes

Multiple Pre-Tooled Rollform System



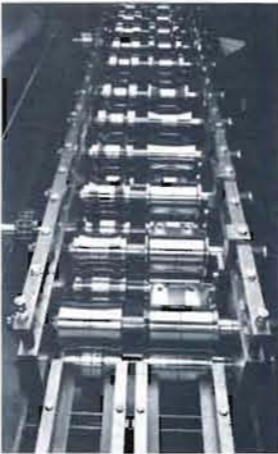
Servo Roll Feed Pre-Punch and Pre-Notch Coil Strip Feed

Pre-tooled for a quick change, on-time production application

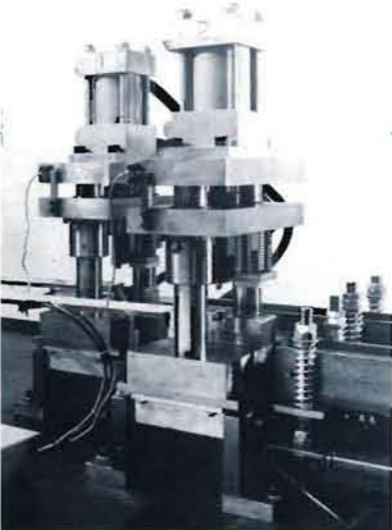
This system shows a wide variety of features combined for maximum production and minimum downtime for set-up and changeover.

The system consists of a Decoiler Feeder Straightener, Servo Roll Feed, Hydraulic Pre-Punch and Notch Presses. Rollformer with Post Cut-Off and Form Press/Dies.

The Feeder Straightener pulls the strip stock from the Decoiler into the free Slack Loop with Sonic Loop Control. The Servo Pinch Feed Roll pulls the strip from the Slack Loop and indexes it through the Pre-Punch and Notch Presses. A programmed Micro Process Controller will sequence the Strip-Feed



Pre-Tooled with Two Sets of Roller Die



and cycle the presses to Pre-Notch and Punch the strip prior to rollforming. The Punch and Notched strip will feed into a second Slack Loop and directly into the Rollformer. The Rollformer will

pull the strip from the Slack Loop, and form the part in a single pass-through operation as it feeds the final formed section through the Post Cut-Off and Form Presses. The Post Cut-Off and Form Presses will sense and pilot off the Pre-Notch and cut the parts to length as it forms the Leading and Trailing ends.

The Rollformer is pre-tooled with 2 sets of tooling (side-by-side) to form 2 independent part sections. Each section will have its own, separate Cut-Off and Form Press. The entire unit will be laterally

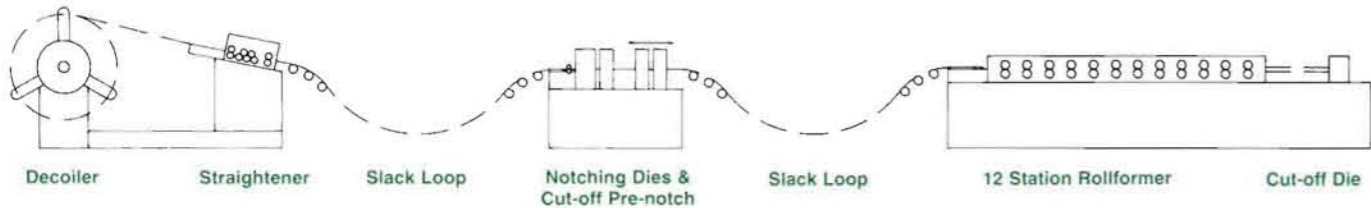
shifted inline with the Coil Strip Feed when changing products.

The Pre-Notch and Punch will Gag and Sequence through the programmable Micro Process Controller for an infinite variety of hole patterns, spacing and part lengths.

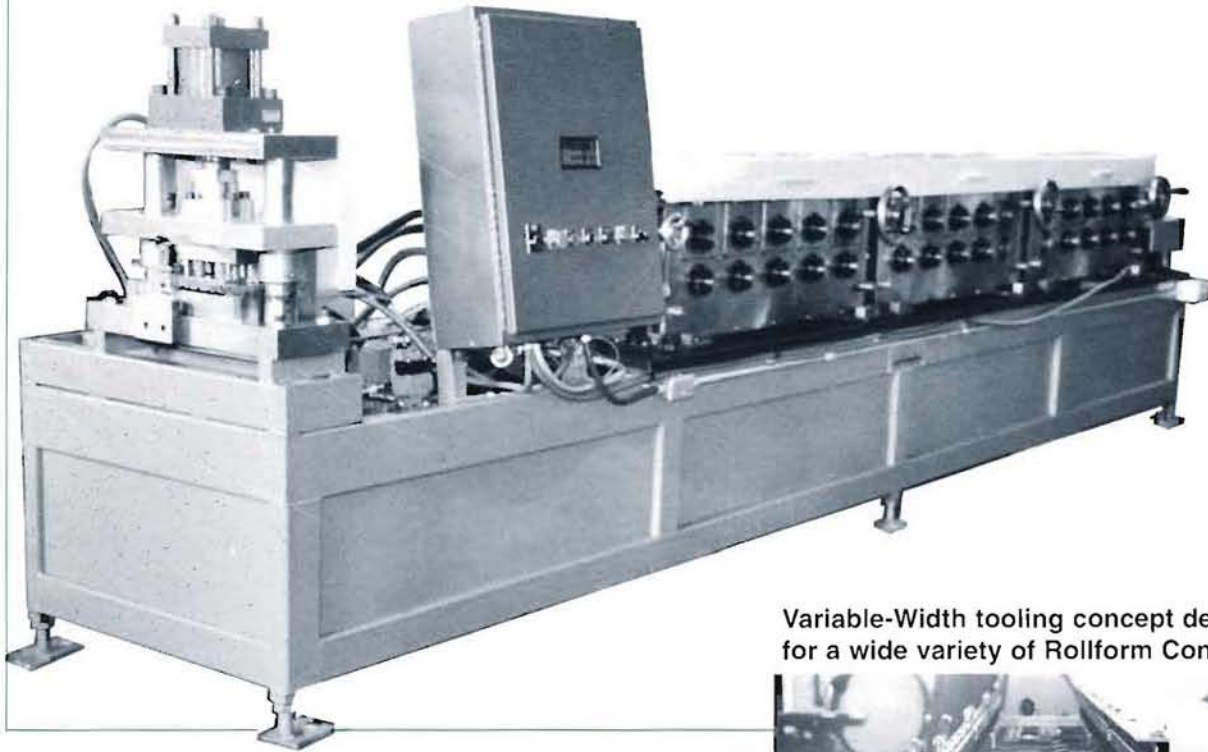
Our systems can be designed in a wide range of Pre-Cut and Post Cut-Off applications. We can pre-tool 1 to 4 sections in the same system depending on production volume and versatility required.

If Length and Punch Pattern Change-Overs are important for low-volume, on-time production, our Programmable Index Feed produces parts with few or no die changes.

High-volume, high-product systems are designed with Pre-Positioned Gang Punch Presses to produce a complete part every cycle.



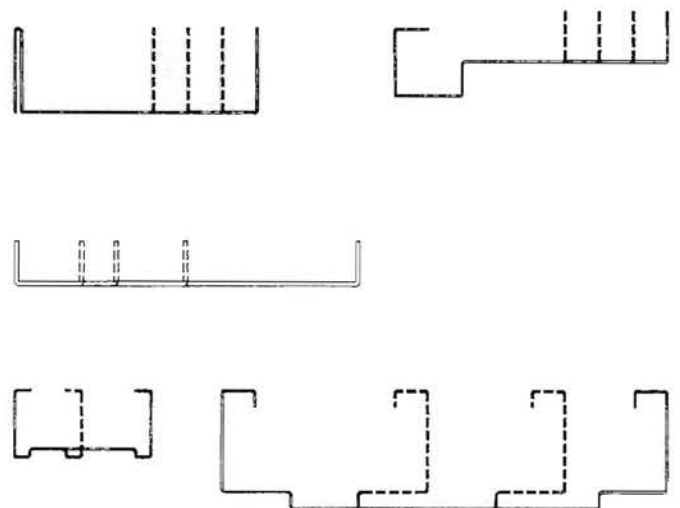
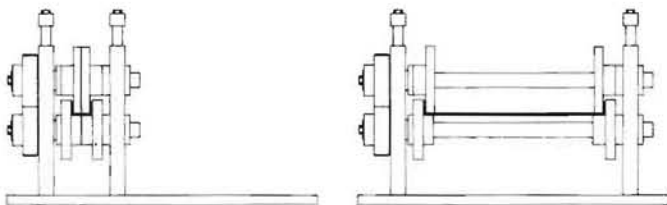
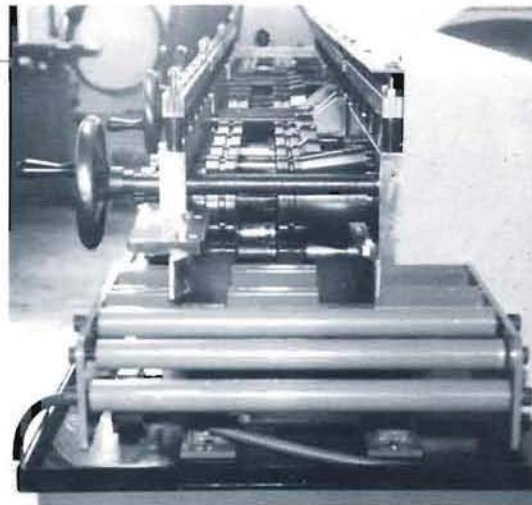
Variable Width Rollforming Set-Up

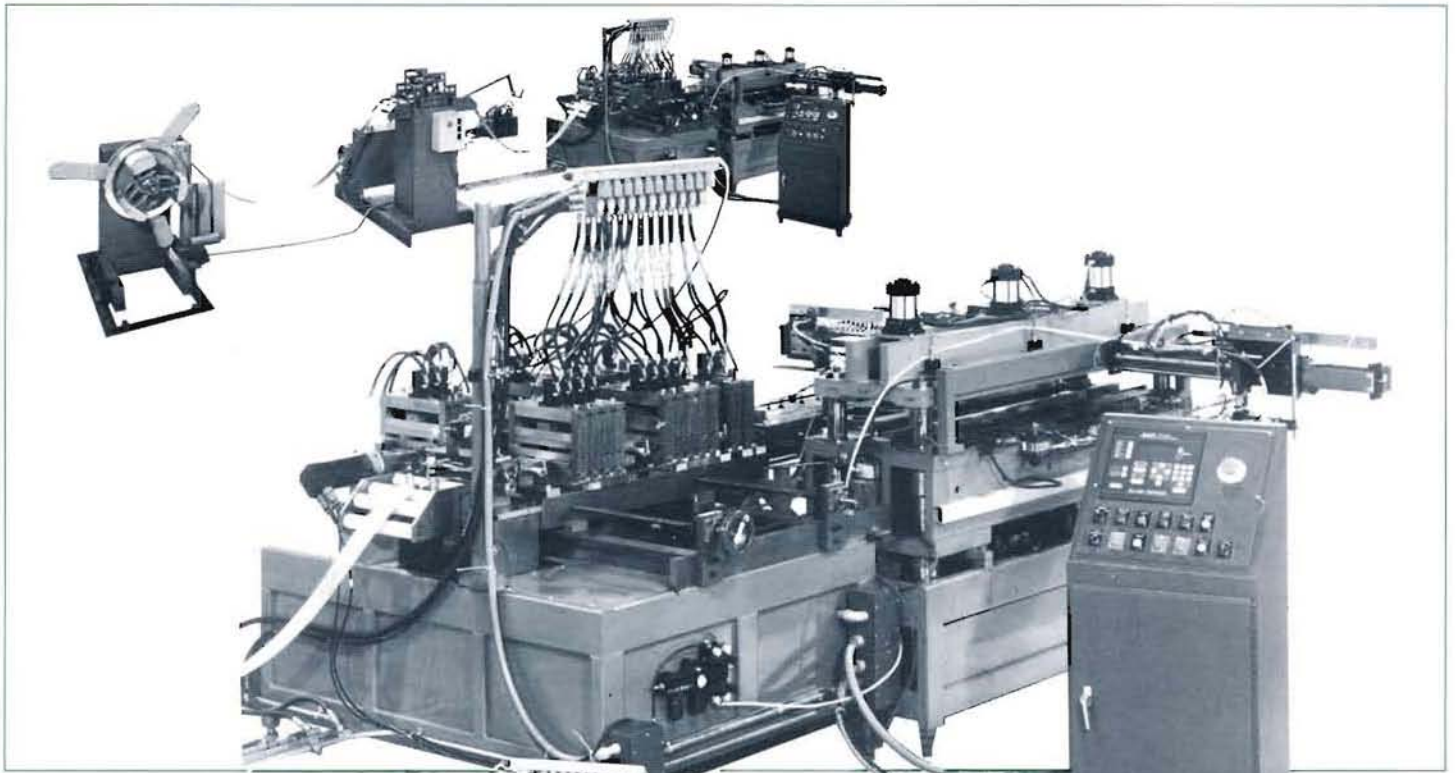


Variable-Width tooling concept designed for a wide variety of Rollform Configurations

We take great pride in the technical designs and concepts we have introduced over the years to increase the productivity and accuracy of our Rollform Systems. We have led the field for over 20 years developing programmable Index Feeds, Multiple Pre-Tooled Rollformers, Variable-Width Rollform Tooling and a wide variety of quick-change tooling and set-up concepts.

The system shown incorporates our Variable-Width Roll Tooling and Programmable Index Feed Drive. The width of the tooling or part is varied with a simple Handwheel Lead Screw Setting. Roll width set-up can be performed in less than a minute.





1-1/2" & 3" Light Diffuser System

System produces the Linear and Lateral Diffuser Blades and Outer Frame Sections for 1-1/2" and 3" deep light defusers.

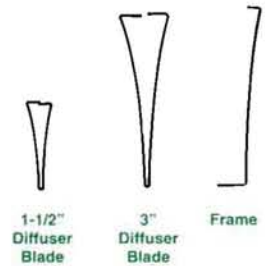
Utilizing a Servo Feed and high-speed Hydraulic Presses, the system pre-notches the sections for the interlocking notches and tabs using a combination of Gang and Gag Sequences.

The pre-cut and notched parts are then fed directly into a specially designed Hydraulic Forming Press. The press positions the parts within the Die, forms the part in a two-stage sequence, then ejects the part from the opposite side.

The Controller allows the operator the choice of pre-positioning or spacing the Individual Notch Dies to run a High-Volume Gang Punch and Gagged Sequenced production or lower-volume parts can be run in a variety of cell configurations using the Index Feed (no set-up required). The

Notch, Punch and Tab Presses are mounted on two separate Die Beds which allows the operator to set-up for the next run while running product on the other set-up.

The Form Press also includes hydraulic clamping and built-in stops to minimize downtime for changeovers and set-ups. Lengths and patterns can be set up in minutes and complete changeovers from the 1-1/2" to 3" Diffusers can be completed in 15 to 20 minutes.



1-1/2"
Diffuser
Blade

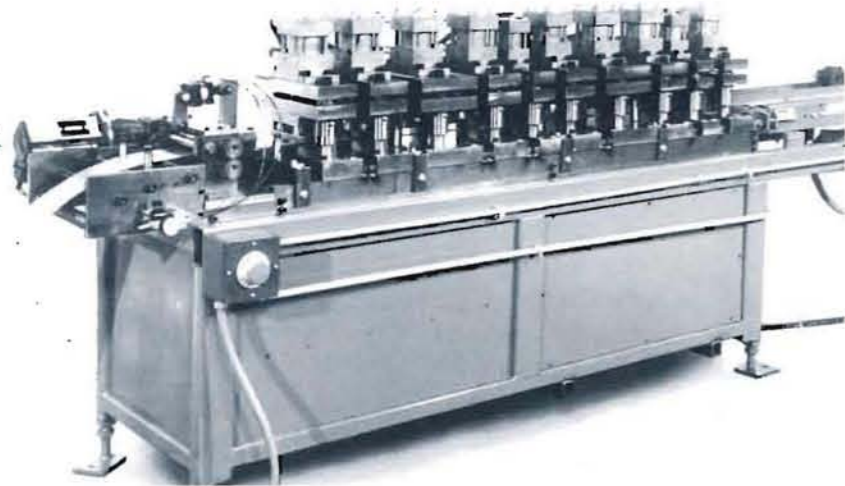
3"
Diffuser
Blade

Frame



Programmable Feed and Pre-Tooled Dies Eliminate Set-Ups

This total On-Time Production System allows you to run individual parts with a wide variety of lengths and patterns, eliminating set-ups, downtime and/or scrap loss.



Many companies tend to overlook automation for rollforming due to the wide range of lengths, punch patterns and end-notching configurations required in their product. Our engineers are solving these and many other production problems every day. Vast and dramatic changes and improvements have been made in all fields of electronics, including types of feeds and index drives along with major developments in hydraulic and pneumatic controls. The options are almost endless to any company aggressive enough to understand and utilize what's available today for the equipment of tomorrow.

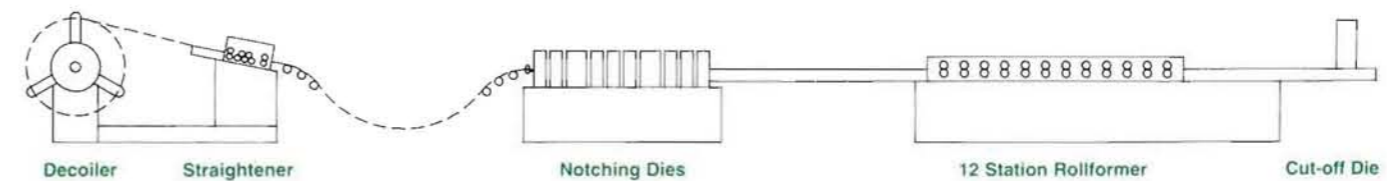
The system shown uses a combination of Servo Index Feed, Individual Hydraulic Press/Dies with a wide variety of Punch, Notch, Gag and Nibble Dies using a Special Applied Micro Controller. It virtually eliminates all the set-up previously required to produce these parts.

The Controller is pre-programmed for over 100 different combinations and requires just simple part number and quantity inputs to produce a wide variety of pattern configurations. New parts can be entered directly from the user-friendly keyboard with simple data entries. This eliminates extensive programming and cost to add or change parts. It also allows the company to run the parts as needed and eliminate extensive inventory and part storage.

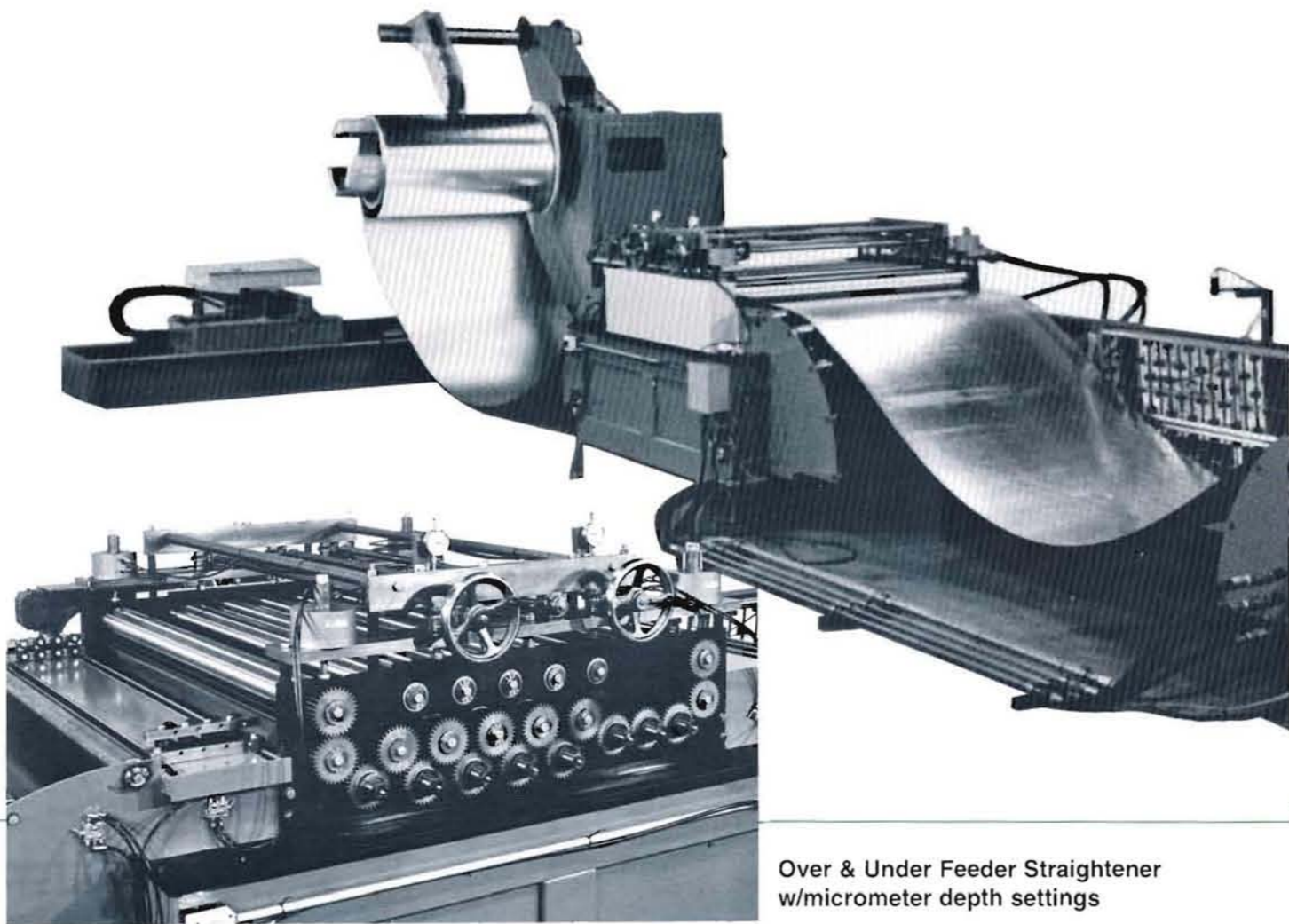


Programmable Servo Feed Index Drive

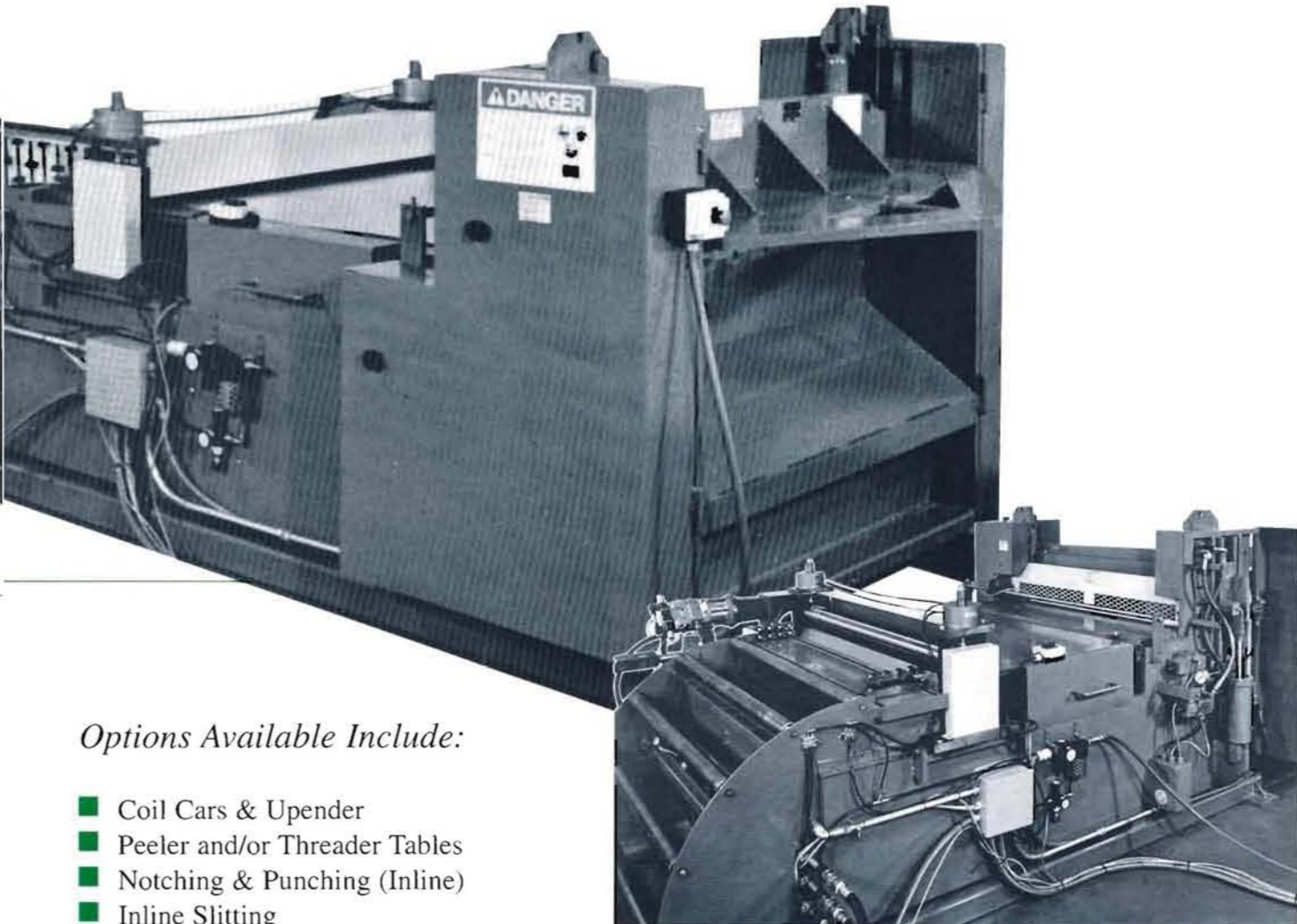
This system not only eliminates all the set-up and inventory problems, it also incorporates an Inline Endforming Press directly after the Rollformer that eliminates a secondary endform operation and set-up. It's our goal to supply our customer with the best, most complete systems available and to solve as many of your production problems as economically feasible.



Coil Feed Cut-To-Length Systems



Over & Under Feeder Straightener w/micrometer depth settings



Roll Feed and Shear with Proportional Hydraulic Feed Drive

Coil Cut-To-Length

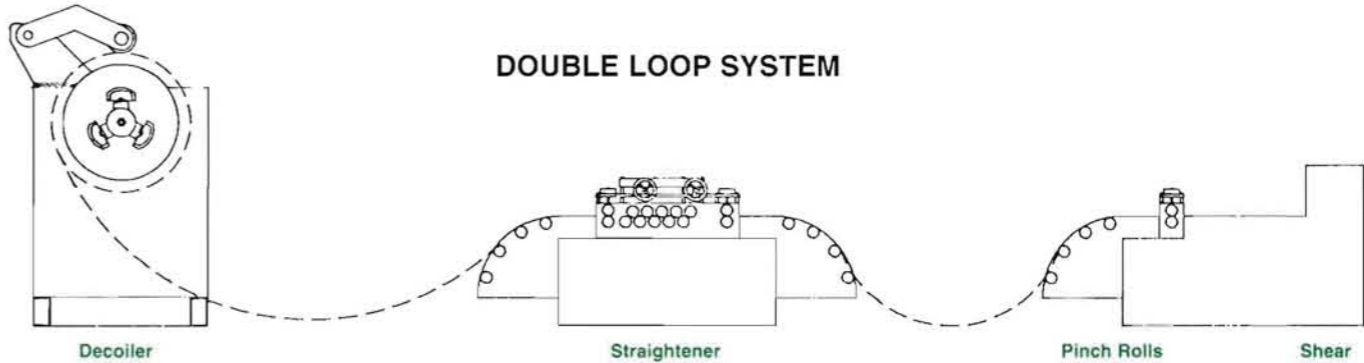
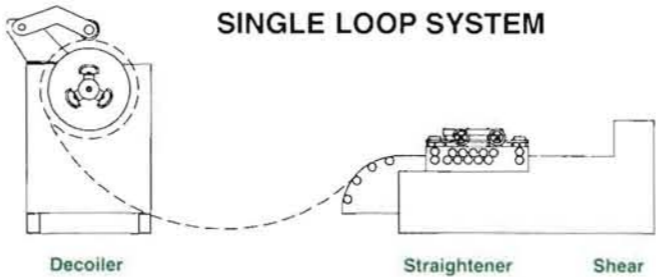
This is just one example of the wide variety of Coil Cut-To-Length Systems we manufacture. We offer a full range of Drives, Controls and Line Configurations to fit your production requirements and every application. Our systems are designed to straighten and cut-to-length 10 to 30 GA. mild steel, aluminum or stainless steel in widths up to 72".

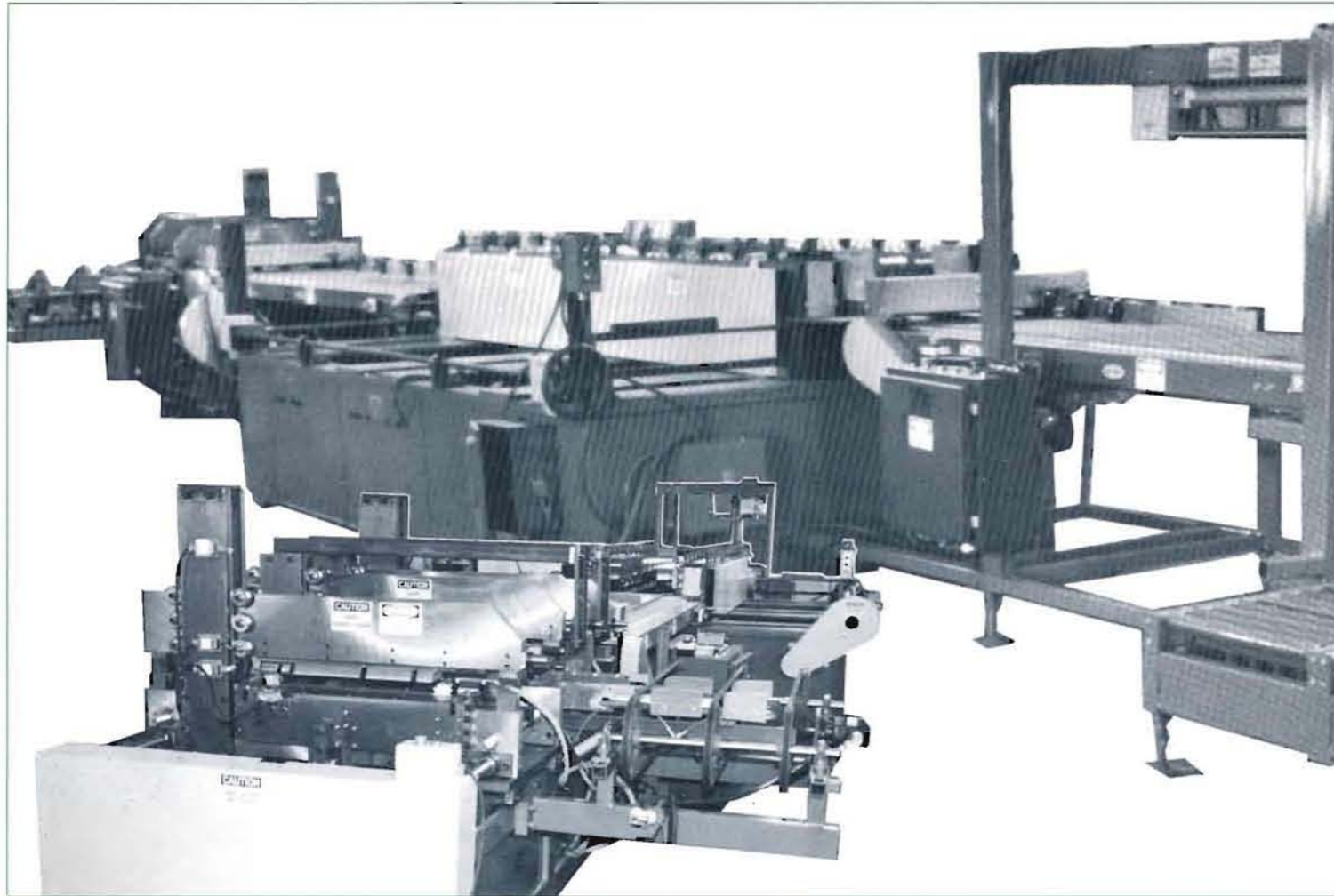
Standard Features Include:

- Programmable Length & Batch Controls
- Sonic Loop Control Sensors
- Full Hardened Feed & Straightener Rolls
- Over & Under Coil Fed Decoilers & Straighteners
- Micrometer Setting (Straightener Rolls)
- Pneumatic Clamping (All Pinch Rolls)
- Hardened Roller Infeed Guides
- Entrance & Exit Cascade Rolls

Options Available Include:

- Coil Cars & Upender
- Peeler and/or Threader Tables
- Notching & Punching (Inline)
- Inline Slitting
- Sheet Stackers
- Rollforming
- Tangent or Endforming





Pre-Painted Cabinets Rollformed and Tangent Bent Into 3-Sided Wrappers

We offer a complete line of Sheet Stackers and Destack/Feed Systems.

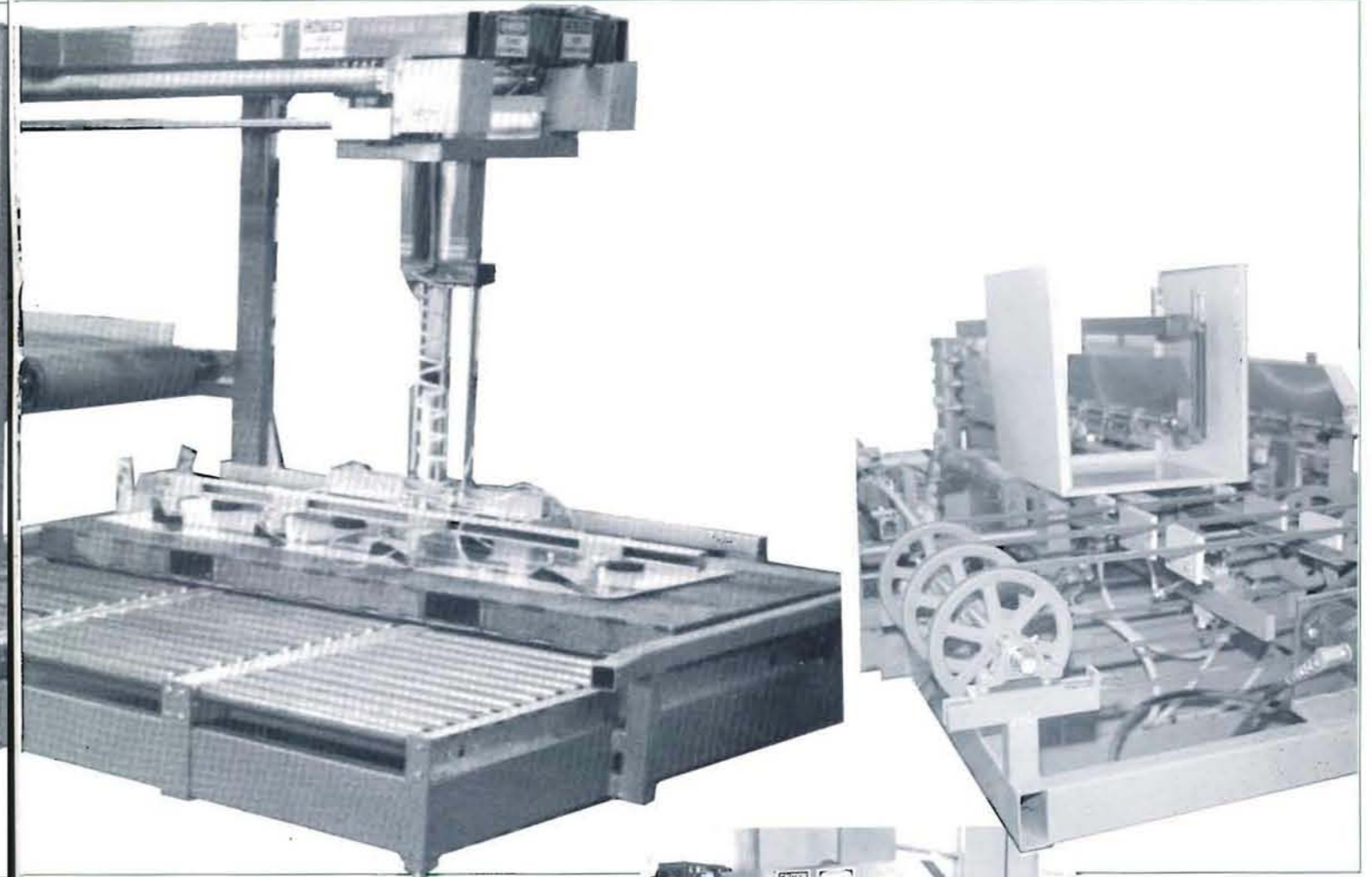
This system was designed and built for a major manufacturer of furnace and air conditioning equipment.

Starting from Pre-Punched and Notch Blanks, we developed an On-Time Production Cell to feed and form the Pre-Painted Cabinet Shells directly onto the Infeed Conveyor. Utilizing a Destack and Feed, Rollformer and Four Ram Tangent Endformer, the blanks are fed and formed and staged to operate as a Just-In-Time Part Callup System.

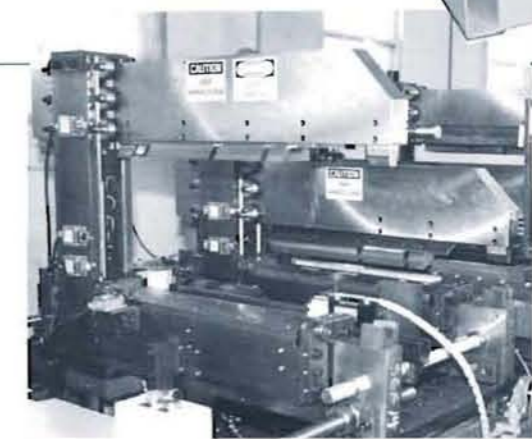
The Destacker picks up the entire pre-notched and punched part from the skid and places it onto the Feed Conveyor. Sheet Fanners, Rotary Vacuum Cups and a double Part Detector are all used to ensure a single part feed into the Rollformer. A part will always be staged on the Feed Conveyor. Upon demand, the conveyor will feed the blank into the Rollformer and the Destacker will feed another in its place.

The Rollformer will form both edges at the same time and is variable for five different widths. The part will be fed out of the Rollformer onto another Feed Conveyor and Staging Area.

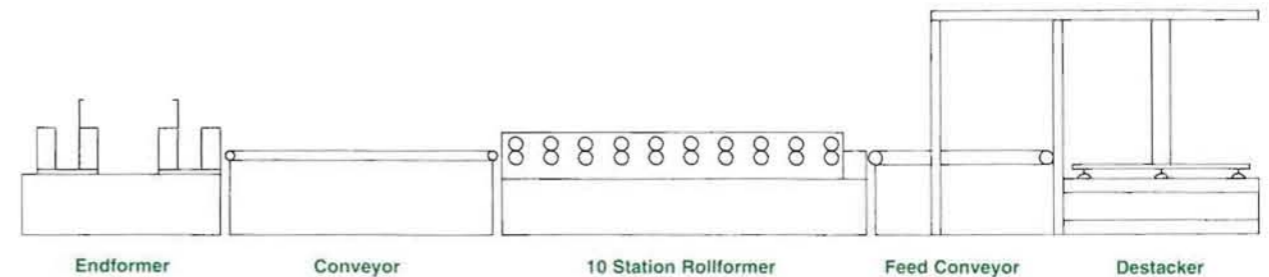
This conveyor will hold a Rollformed part and feed it directly into the four Ram Endform/Tangent Bender as required.

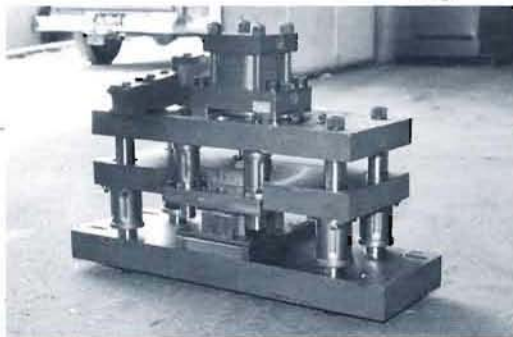
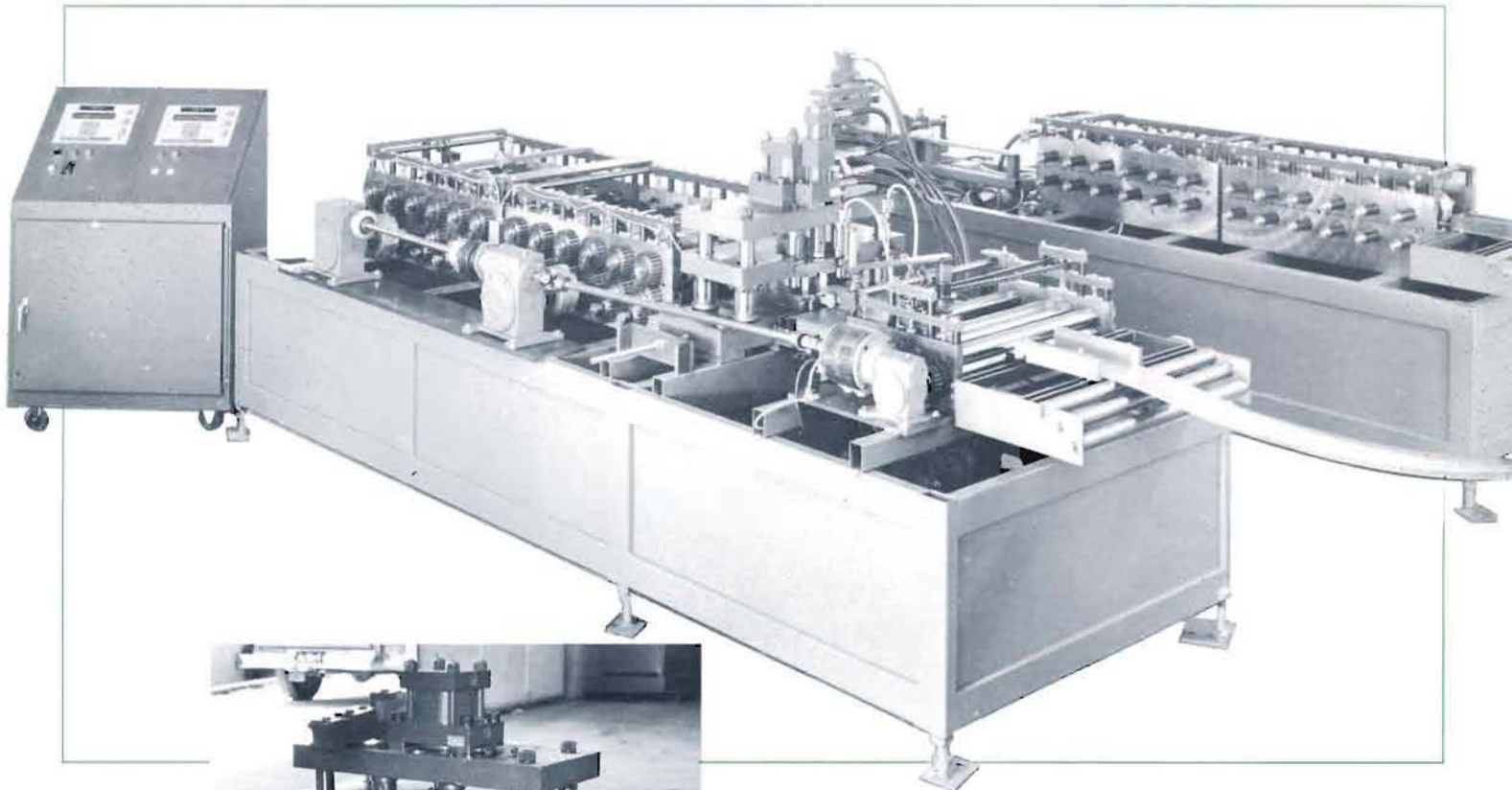


The Endformer will form pre-rollformed panes into final formed three-sided cabinets in five different depths, four widths and two heights. The Outer Rams will form a 90° flange on both ends and the Inner Rams will form the cabinet into a three-sided Wrapper. The parts are threaded directly from the Feed Conveyor, formed then ejected laterally onto the next conveyor to the assembly area.



We build a wide variety of Destack and Stacking Systems and Endform/Tangent Bend Units. Design and application vary to best suit the customer's production requirements.





Special Hydraulic and Pneumatic Presses and Dies Specifically Designed for Your Application Eliminating the Need for Expensive Press Units.

All Dies and Shear Cut-Offs are designed with quality components made of the finest tool steel.

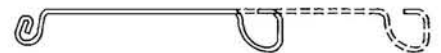
Rollformers

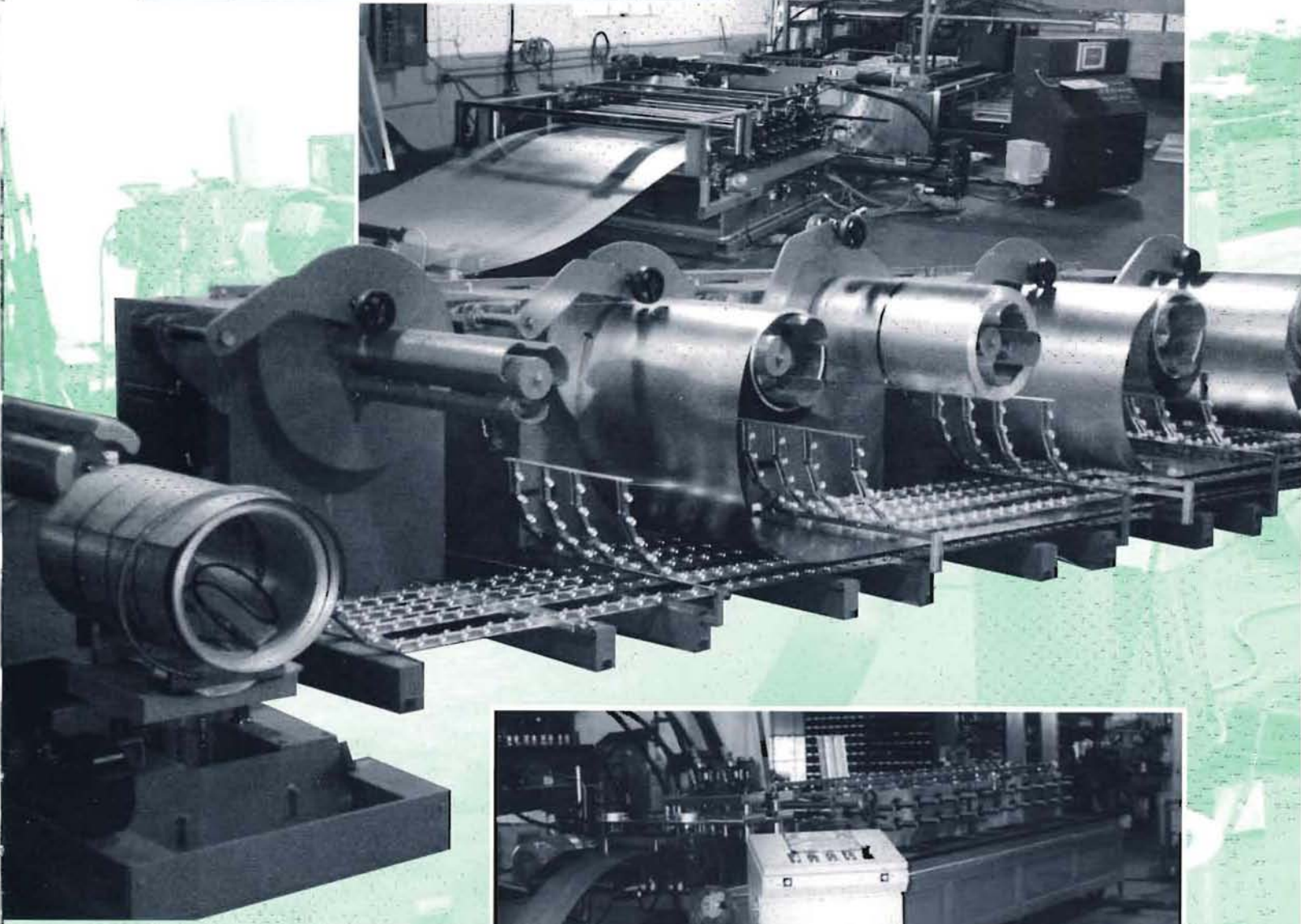
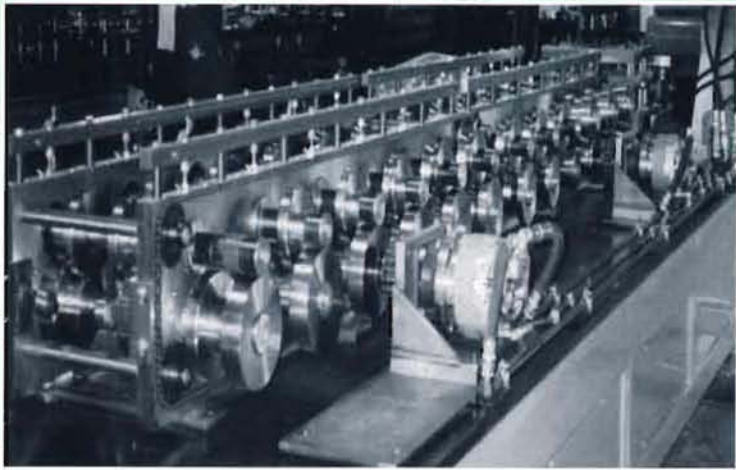
The Latest Concepts In On-Time Production Systems

Two complete rollform lines, using a Combined Control System, to produce Full Wrapper Fire Damper Frames and Corresponding Blades.

The Operator Entry System produces an infinite variety of frame sizes and quantities as it downloads the blade line for a consistent product flow to the assembly area.

We build systems to increase productivity, minimize inventory and handling. Systems tailored to eliminate or minimize changeover of set-up time. Quality systems at a price you can afford.







QUALITY DESIGN MEANS PRODUCTION YOU CAN AFFORD

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St. Louis, MO 63125

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