

Machinery Quotation

Prepared by Mr Dean Summerhayes

Email: deansummerhayes@engeleuropa.com

Autofold 516

Full Automated Roll on Flange System



REV A
2022

Address | Engel Europa International Ltd
19c Dorehouse Industrial Estate
Sheffield S13 9NP
United Kingdom

Tel | 0114 275 5433
Fax | 0114 278 6797

Email | sales@engeleuropa.com
Web | www.engeleuropa.com



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The Engel Europa Autofold Duct Transfer line offers customers the flexibility to have a duct machine built according to their exact specifications, ensuring it meets the diverse needs of duct manufacturing worldwide. While customized, the machine still adheres to the standard manufacturing processes that have been proven successful in factories around the globe for over 4 decades.

Having delivered thousands of machines since 1981, the Autofold range has consistently demonstrated its design durability and impressive payback results across the world.

Robust Construction:

Every Autofold machine is constructed using heavy-duty welded frames, incorporating Bosch Rexroth hydraulics. Our machines also feature a proprietary controller and software that can be tailored to meet specific customer requirements.

The Autofold has a remarkable track record of reliability, even in harsh environments, thanks to its design and manufacturing process that enables it to operate effectively in extreme upper and lower temperatures.

The Transfer line has the advantage over straight lines that cannot do the following actions

- 1 drive cleat and tdf can be done on the same machine
- 2 flat sheet for plasma take off is easily done
- 3, multiple ducts are on the machine during full production meaning the production rates are higher
- 4 ,Snaplock and Pittsburgh locks are automatically changed with only software input ,no operator input is required
- 5.Bespoke built to work around your factory flow

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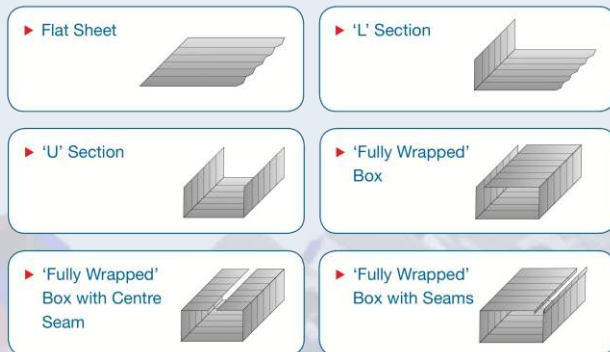
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Autofold Standard Features

All Autofolds have the standard features below

The Autofold fold and Shear Head has 2 blades that are equipped with 4 cutting sides each giving many years of continuous production
The shear operates from the bottom to allow the duct to be wrapped around the fold Beam.

Sections that can be made on an Autofold



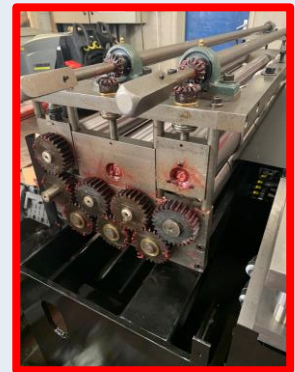
Leveller and Beading

The 7 roll leveller is the drive of the Autofold and is driven direct from the Autofold hydraulic gearbox to eliminate any wear or slack in chains found on other machines.

The leveller and Beader rolls can be operated from either side via direct shaft for added accuracy.

The rolls are s-45 carbon steel machined and ground
And are of solid bar type.

No chains that can stretch are used in our levellers.



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Autofold Standard Features

5 tonne Expandable mandrels

Included with an Autofold are 2 coils



Options Above show “A” frame coil holders and “I” beam coils

All spindles are rated for 5 tonnes maximum weight at 1500 wide
But can accept smaller widths

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Hydraulic Servo Drive System

All Autofolds use the hydraulic drive system that is controlled by our Autofold “v” system this ensures energy efficient motors coupled with compact hydraulic system fitted inside all machines ,there is no air required on any Autofolds.

Control System

At the heart of the Autofold is the advanced solid state control system This has been continuously developed through the Autofold life.

The controller is based around a single board pc running bespoke software with embedded OS having an intuitive and easy to use control interface ,thus making the Autofold easy to learn and operate by multiple employees in the factory environment through a touch screen interface

The controller consistently monitors machine functions and operations In the even of a machine fault or incorrect usage or power supply failure the system will give a clear onscreen feedback to the operator .

If the control system is connected via the optional wifi to the customers network and then via to the our factory diagnostics team who can be called on to assist with any questions or data can be extracted and investigated.

All Machine power is fed through the controller via one power source The Autofold can work from 208v through 480 v this gives the Autofold to be installed anywhere in the world .

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At the core of every Autofold machine lies an advanced control system, offering a range of options to suit different requirements. This system has been specifically developed for the Autofold machine range and has undergone continuous enhancements throughout its 40-year lifespan.

The controller utilizes a custom single board computer running specialized software, resulting in an intuitive and user-friendly control interface.

Unlike many other machine manufacturers who rely on outsourced control systems and generic machine control packages, Autofold maintains full control over its system. This ensures greater reliability and flexibility as third-party suppliers cannot discontinue or alter functionalities without consulting the machine builder. Additionally, Autofold provides comprehensive support and repair services for all control systems, regardless of their age.

The controller actively monitors machine commands and responses, promptly notifying the user in the event of any machine faults, providing clear feedback.

Order Description

Cust Order Description

Piece Customer

Quar Piece Description

Sect Quantity to Make 10

Size Section Standard U Section

Lock Size 350.0 mm x 400.0 mm x 150.0 mm

Fold Lock No lock allowance

Fabr Fold (Fold on Autofold)

Punc Fabriflange (Fold on Fabriflange)

Driv Punch

Tie F Drive Cleat

Gau Tie Rod: Sides 1+3 0 2+4 0

Part Gauge 22g Galvanised Coil

Part Name 350x400x150, NONE

F1 Make

F2 New Job

F3 Delete Part

F4 Promote Part

F5 Insert Part

F6/Escape Main Menu

Job Description

Name BOX 450x450, LPITTS 0 of 1 20g Galva.

L 350x400, NONE 0 of 4 20g Galva.

350x400x150, NONE 0 of 10 22g Galva.

Name 350x400x150, NONE

Quantity 10

Section Standard U Section

Size 350.0 mm x 400.0 mm...

Fold Yes

Notch No

Drive Cleat No

Fabriflange No

Gauge 22g Galvanised Coil

Jobs (Sorted by Name)

Job 1 Rat sheet (20g Galvanised Coil)

Job 2 L - Section (20g Galvanised Coil)

Job 3 Rat sheet (20g Galvanised Coil)

Job 4 U - Section (20g Galvanised Coil)

Job 5 Duct 450 (22g Galvanised Coil)

Job 6 Duct 450

Job 7 L - Section

Job 8 U - Section

Job 9 Rat sheet

Parts (Sorted by Name)

Part 1 Duct 450

Part 2 L - Section

Part 3 U - Section

Part 4 Rat sheet

Parts and Jobs Library

Total Jobs : 3

Total Parts : 5

Sort Jobs

Sort by Name

Sort by Date

Sort Parts

Sort by Name

Sort by Size

Sort by Section

Press the Left arrow key to Hide all jobs in the library

F1 Delete Jobs

F2 New Job

F3 MAP

F4/Escape Main Menu

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Autofold Options

Tie Rod Hole punch Optional

Gang punch of 3 or 4 holes for tie rods CNC controlled via software
Hole diameter from 6mm-12 mm hole can be tuned off/on via tap on piston if less holes are needed



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Autofold Options

Selector station

All Autofolds can be fitted with a selector station these aids the operator in selecting a sheet that is held in the station ,increasing sheet gauge swapping for increasing production speeds
Options are

4 sheet selector
6 sheet selector (shown)
8 sheet selector

included
Optional
Optional



Hydraulic power coil drive

included

The hydraulic power coil drive uses a hydraulic motor and gearbox on a track that slides up and down the coils to assist in the operator to unwind the coil to load the machine



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Autofold Options Continued

Side Eject system

Pittsburgh only

Included

Snaplock only Including male punch

Optional

Combination pittsburgh and Snaplock combination

The side eject can go left or right to suit the factory flow

Large Pittsburgh max thickness 1.6mm

Medium Pittsburgh thickness 1.0mm

Snaplock maximum Thickness 1.0mm



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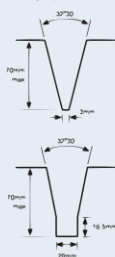
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Autofold Options

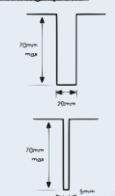
Notching included

2 pair of Notching stations
both sides for Notching
TDF/ TDC or drive
cleated duct bottom set
for TDF
Included

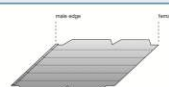
Notching Option 1



Notching Option 2



► 'L' Section
Notch Pattern



► 'U' Section
Notch Pattern



► 'Fully Wrapped'
Notch Pattern



Dual Head Drive Cleat

optional

Inline drive cleat roll formers
driven in line with the leveler
motors

No Minimum or maximum size
restriction.

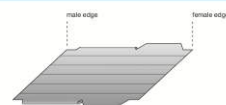
Cleats can be on
Sides 1+3
2+4 or all sides



► Cleat Profile



► 'L' Section Drive Cleat
on side 1



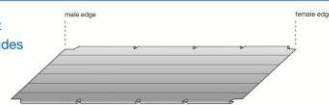
► 'U' Section Drive Cleat
on sides 1&3



► 'Fully Wrapped'
Section Drive Cleat
on sides 1&3 or 2&4
as required



► The Programmer can put
Drive Cleats on all four sides
of the duct if required



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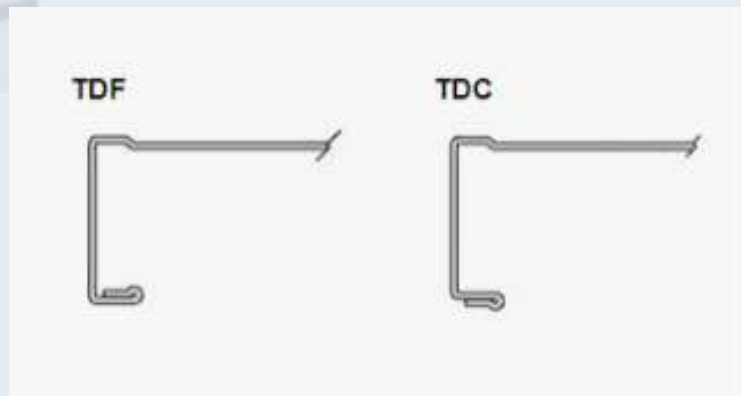
Sealant injection for Pittsburgh

Optional

The Pittsburgh rollformer can have sealant injection fed into the lock
As it seams the Pittsburgh



Common Flange options



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Transfer line Fabriflange

A "U" or a "Z" shape either left or right direction as per customers flow

Ending with the Fabriflange form and fold into

"L" Shape Duct

"U" Shape duct

Fully wrapped duct



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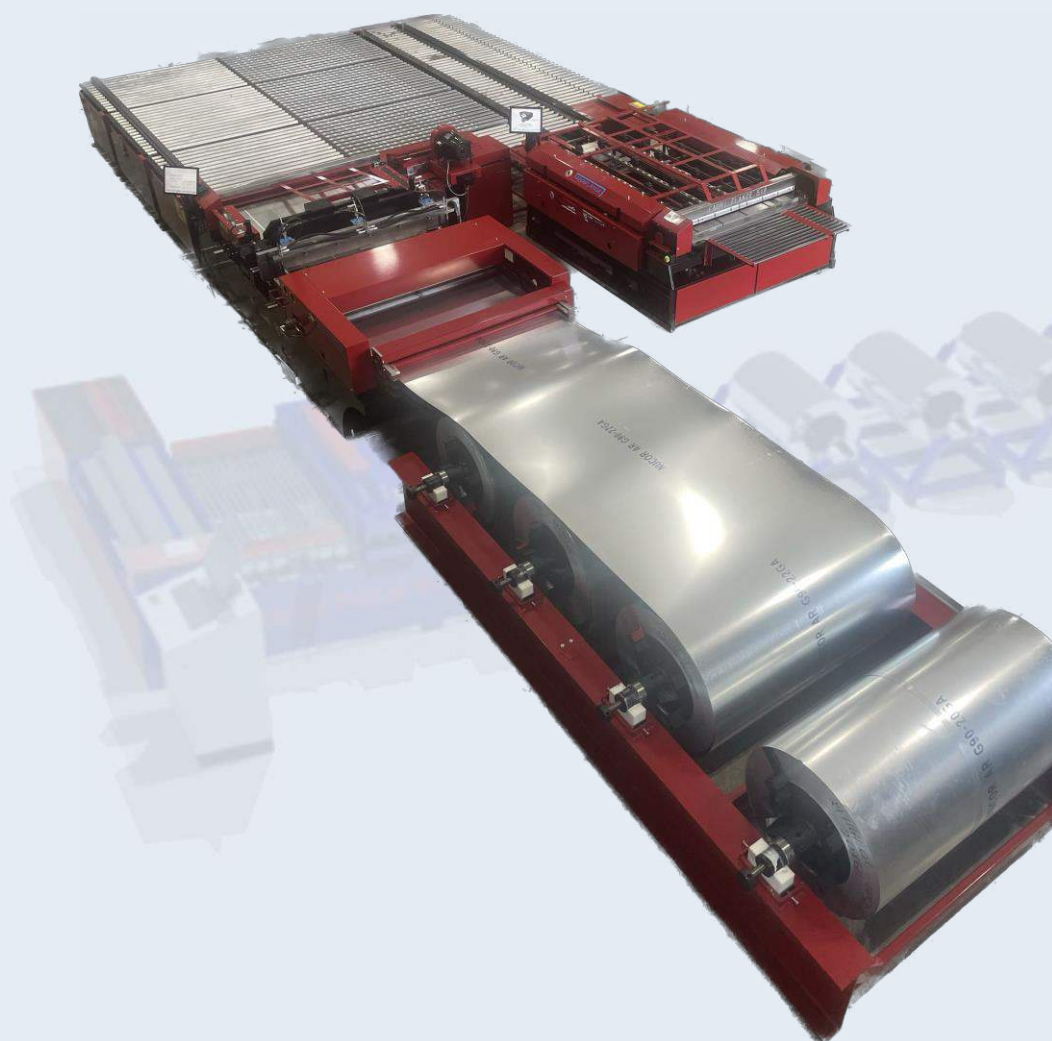
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Z line Shown here



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Specifications

Machine weight starts at 3.500 kgs

Sizes dependent on spec

Power supply 208-480 multi tap transformer
3 phase 25 amp supply required (no air)

Maximum duct size – not restricted
Minimum duct size -120mmx120mm

Maximum gauge 1.6mm (1mm stainless steel)
Minimum gauge 0.5mm

Oil type -ISO 46

Blade specification –high carbon high chrome 4 cutting sides top/bottom

Warranty 1year warranty on parts and labor

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