CONSOLIDATED MACHINES
HYDRAULICS • HYDRO-PNEUMATICS
CONSTRUCTION EQUIPMENT

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A Comprehensive Data on Plant Equipment For Typical Rebar Cut-Bend Facility, Commonly Known as Ready-Made Steel – RMS Plants

Accomplished European American and Chinese Firms offer Sophisticated Highly Automated Plant Equipment.

Our Approach is to Keep it Simple, Nominal Automation, and Therefore very Cost-Effective. Still Maintain Build Quality, Minimal Labor Engagement to Attain Excellent Production Level.

Power Transmission is Conventional Electro-Hydraulics, Built with Best-In-Class Elements from Bosch Rexroth, Yuken, Siemens. and where Automation is Required is Accomplished with Basic PLCs like ABB Omron or Mitsubishi

With our Equipment the User is More in Comfort Zone

- ✓ Controlled Capital Expenditure
- ✓ Manageable Operations and Maintenance Skills
- ✓ Controlled Operations Expenses – Inventory, High Skill Staff Engagement
- ✓ Less OEM Dependent and Down Time Concerns
- ✓ Indigenous Product – Help is Assured

Our Approach is also Towards Modular Construction, This Facilitates Transportation and Future Relocation with Ease

Equipment Covered Here

- Semi-Automatic and Full-Automatic Rebar Cutting Line
- Semi-Automatic Rebar Bending Line
- Stirrup Forming with Straight Rebars and From Coils
- Arch/Radius Ring Forming Equipment
- Rebar Straightening Plants

CONTINUOUS IMPROVEMENT PROCESS – SPECS MAY CHANGE

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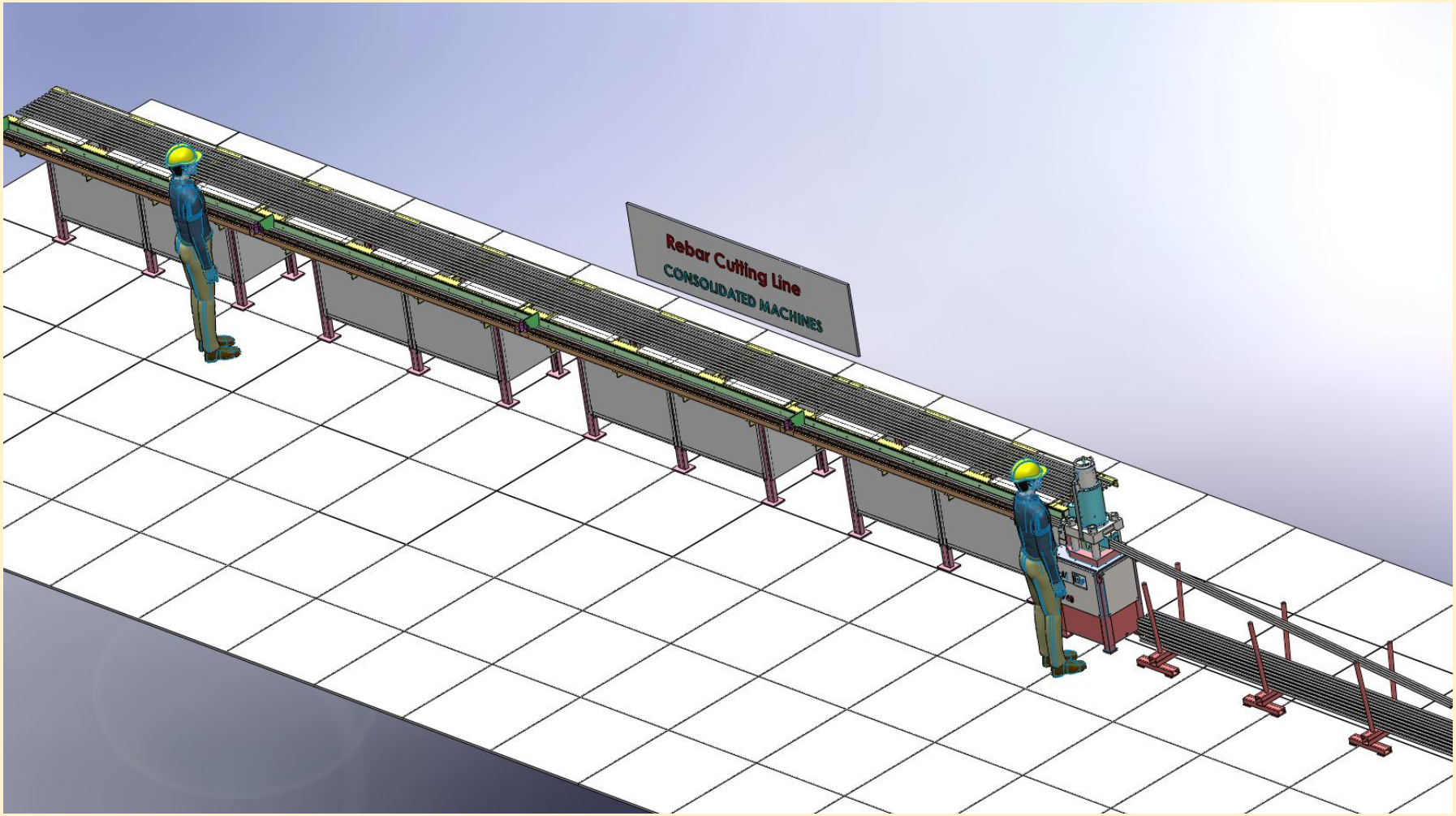
REBAR CUTTING LINE MODEL: SLV40 / SLV45



GENERAL ARRANGEMENT VIEW

General Features

- Available in Two Models – To Suit Maximum Size TMT Bar
  Metric40 Gr500 (SLV40) and Metric40 Gr650 (SLV45)
  Continuous Processing TMT40Gr500 - we Recommend Model SLV45
- Heavy Duty Hydraulic Vertical Action Cutting Machine
- Arrangement For Bar Feeding With Excellent Length Control Illustrated in Pictures
- Production Estimate per Ten Hour Indicative: 40 Tons
- Plant Foot Print: 14M x 2.5M (Plus Cut Length)
- Bars in Conveyor Tray Moves Effortless and Properly Guided
- Modular Design – Easy to Install or Relocate

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Cutting Machine

- Electro-Hydraulic Drive
  Built with Best in Class Like Bosch Rexroth / Yuken / Siemens

- Cutting Blade Length :
  SLV40 100mm SLV45 110mm

- Cutting Capacity Metric TMT Grade Fe500 / Fe550D (Bar Size x No of Bars)

Model SLV40: 40 / 32x1 25x2 20x3 16x5 12X7 10X8 8X10nos -
Model SLV45: 40 / 32x1 25x2 20x4 16x5 12x8 10x9 8x12nos

- Power Installed: Standard Three Phase AC Motors

Model SLV40 : 5Hp (3.8Kw) Model SLV45 : 7.5Hp (5.8Kw)

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Cutting Accuracies

Cutting Accuracy can be +/-2mm – See Picture Illustration

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Bar Support System

1. Bar Receiving Pedestal Integrated with a Roller Conveyor, Bars to Process are Dropped-in Rollers Help the Bar to Progress Smooth with Minimal Effort Pedestal Length 12m – Maximum Weight Capable 4T

2. Cut Bars Collecting Elements – Four Numbers – Arranged As Required

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Materials and Finish

Tooling and Load Bearing Elements of Alloy Steel Toughened, Phosphated for Long Life Panels Powder Coated, Structure Fabrication with Zinc Red-Oxide and Quality Paint Finish

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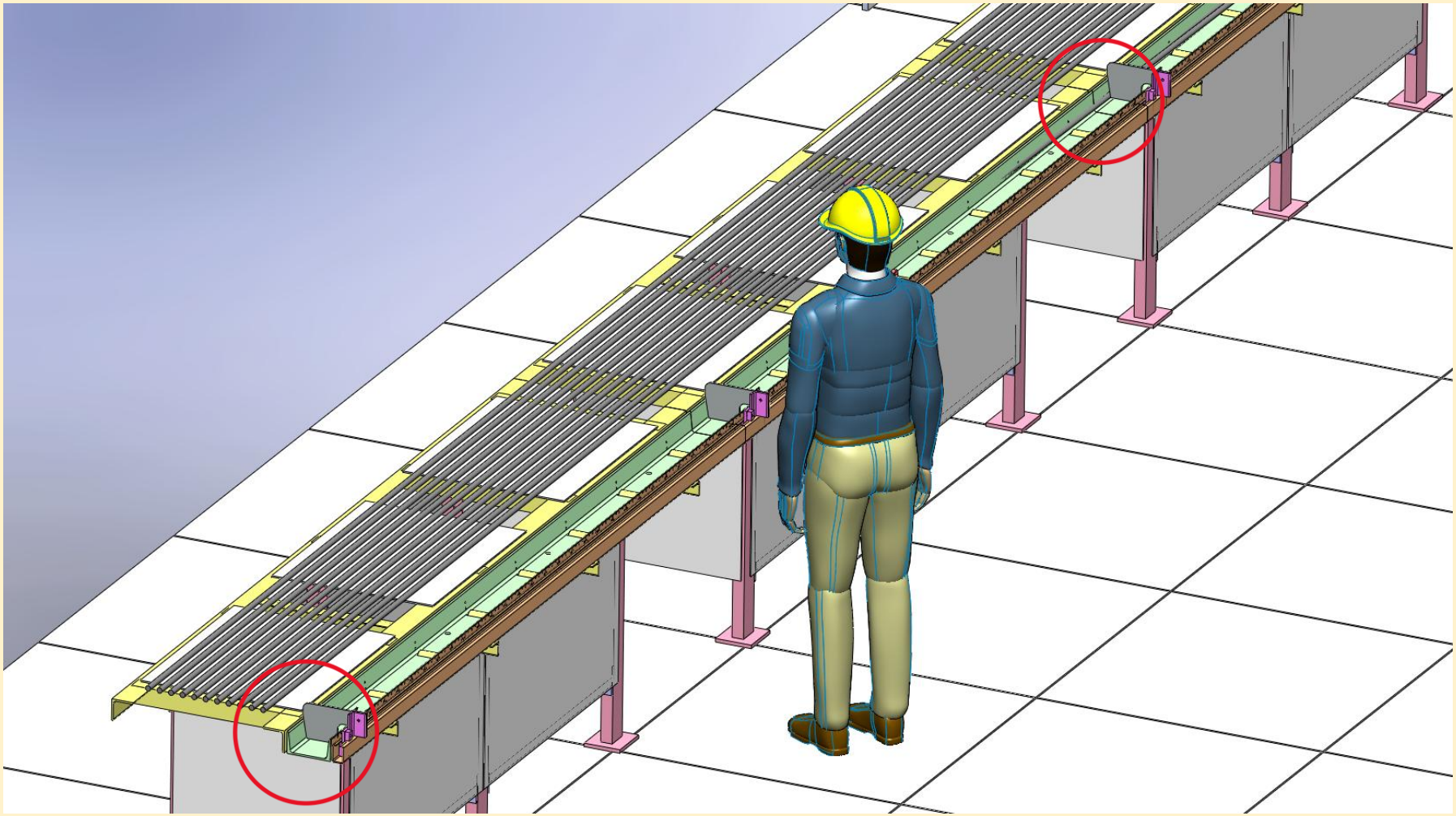
PROCESS ILLUSTION PICTURES



SET STOPPER-FLAGS WITH REFERENCE TO CUT-LENGTH REQUIREMENT
LAST STOPPER-FLAG IS SET FOR REFERENCE CUT – SET AT SAY 11.98M

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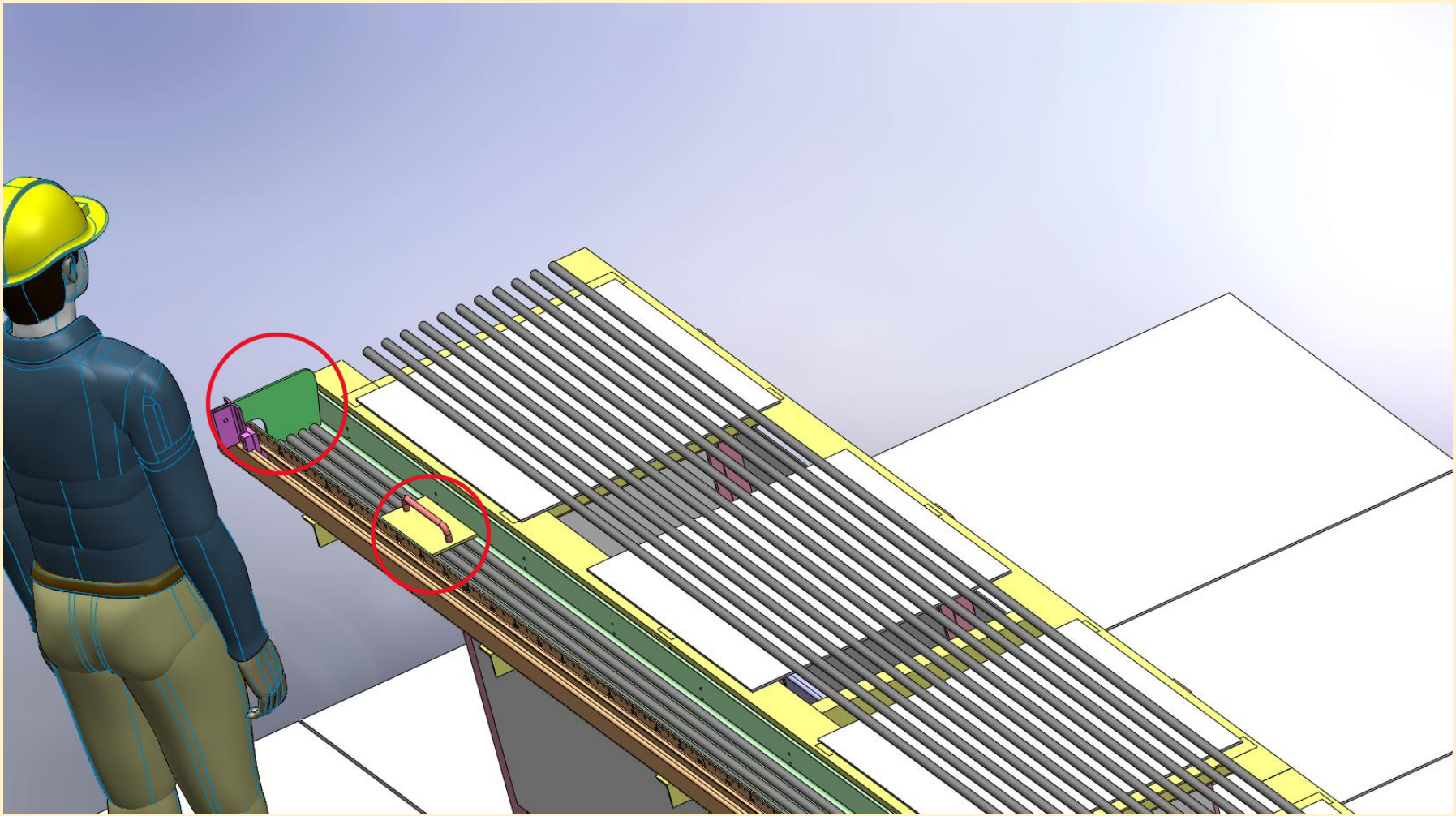
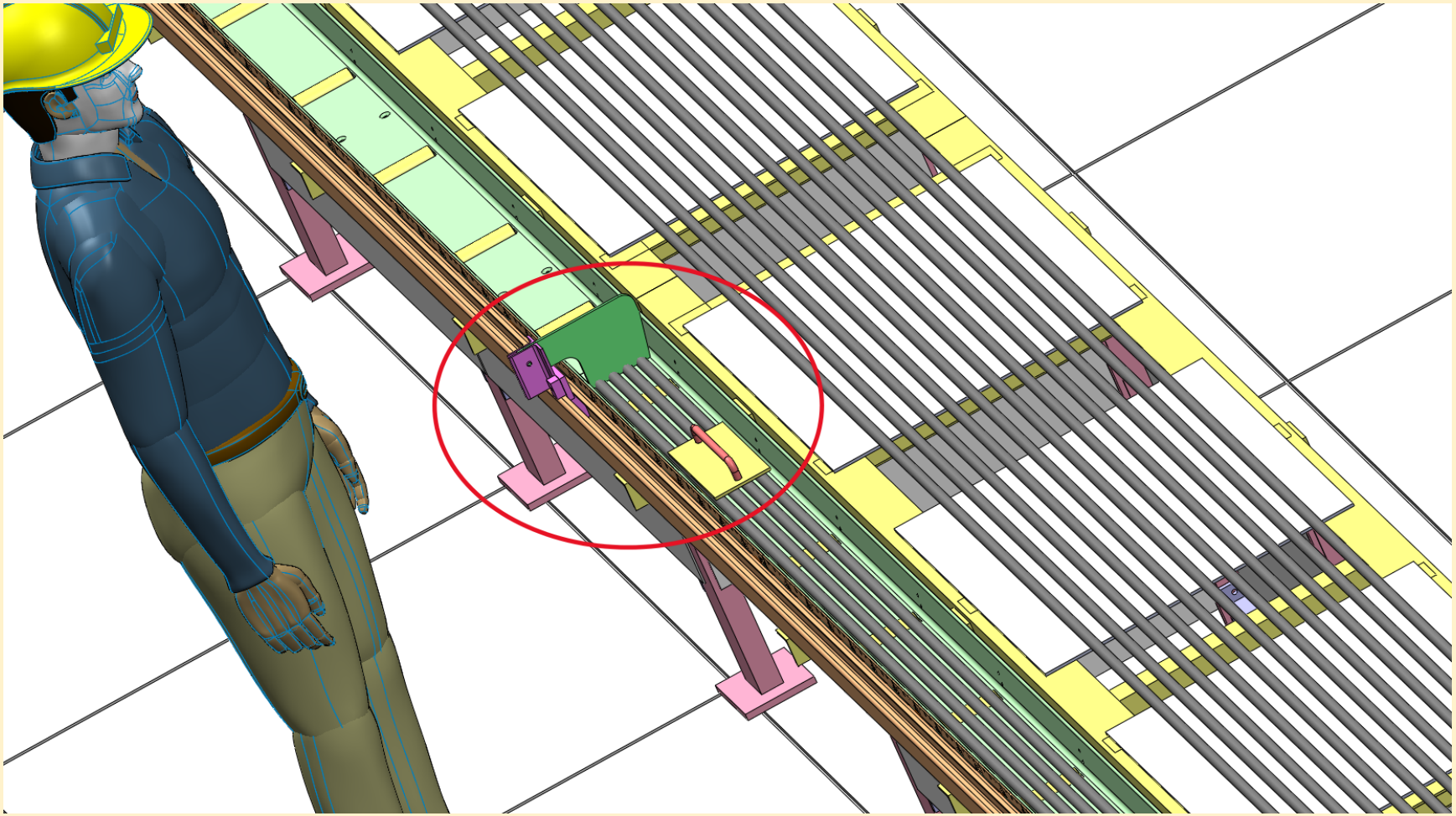


DROP THE BARS TO PROCESS IN THE CONVEYOR CHANNEL AND TAKE REFERENCE CUT
HAND HELP PAD TO MOVE BARS



BARS GLIDE ON ROLLERS – BUTT THE BARS AGAINST THE STOPPER-FLAG

(HAND-HELD PAD TO ASSIST BAR MOVE) OPERATE THE CUT-ACTION

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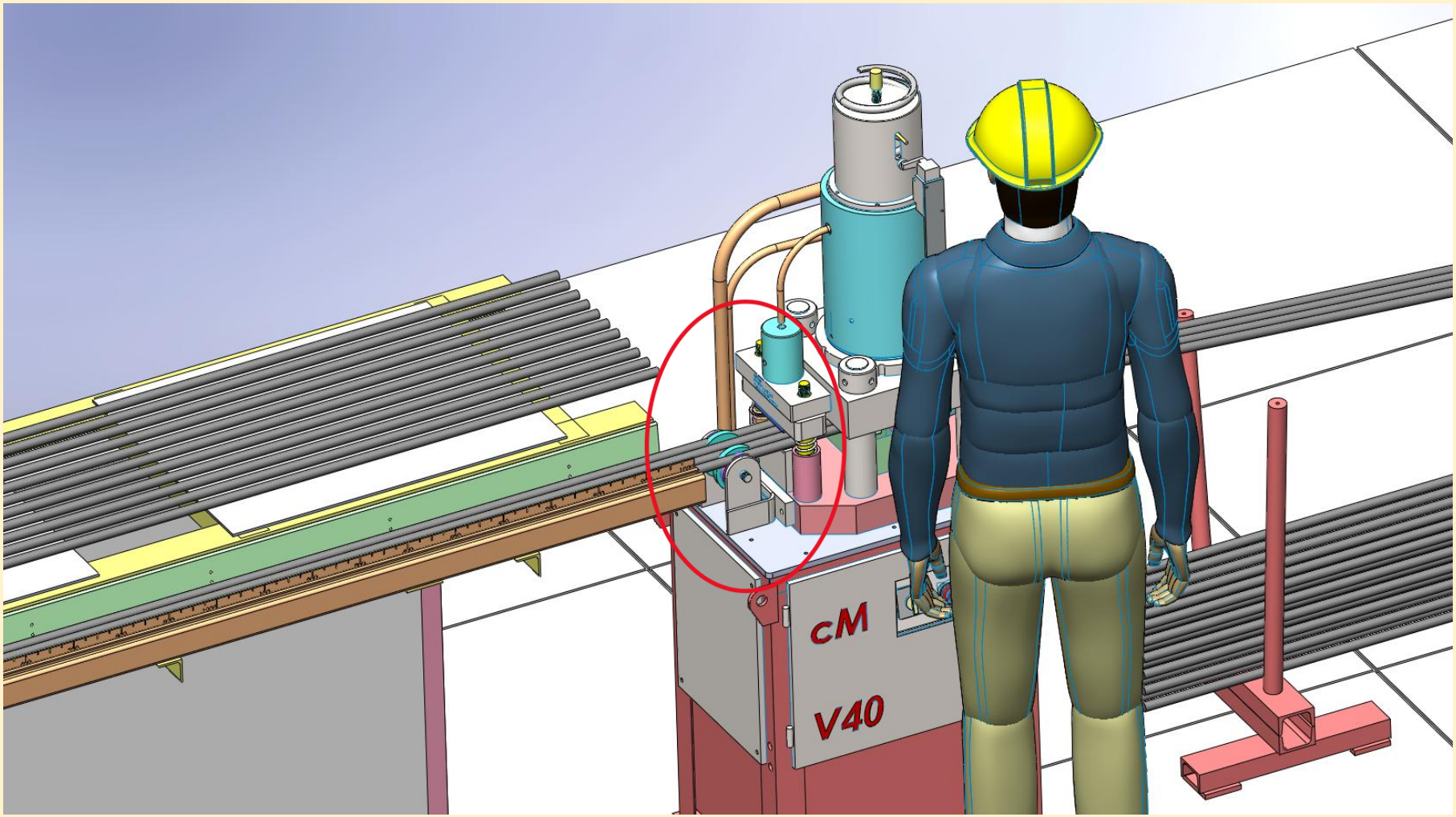

BARS ARE GUIDED IN THE MACHINE

BARS ARE AUTOMATICALLY CLAMPED PRIOR TO CUT ACTION

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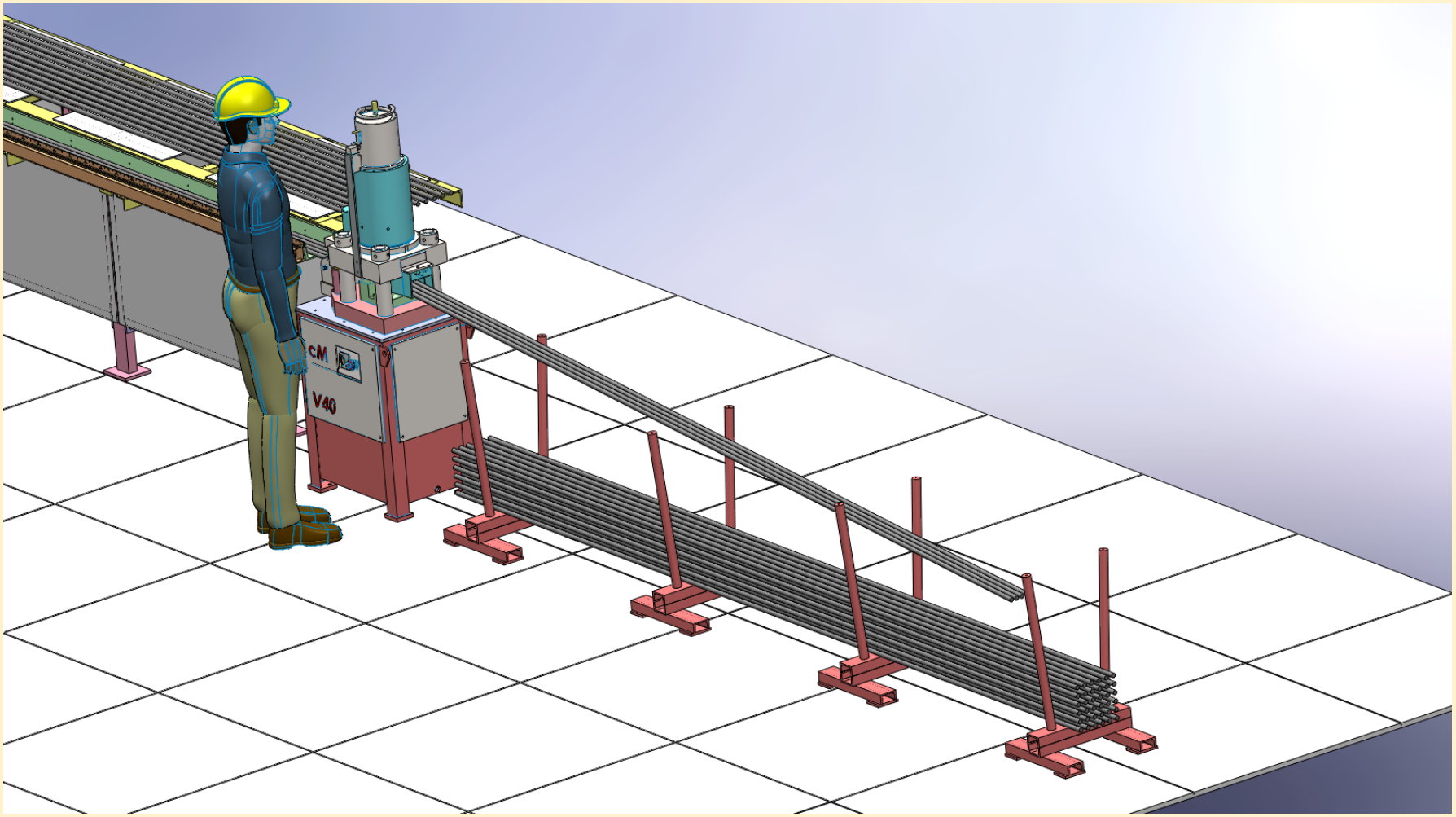

CUT BARS DROP INTO THE COLLECT BIN AREA

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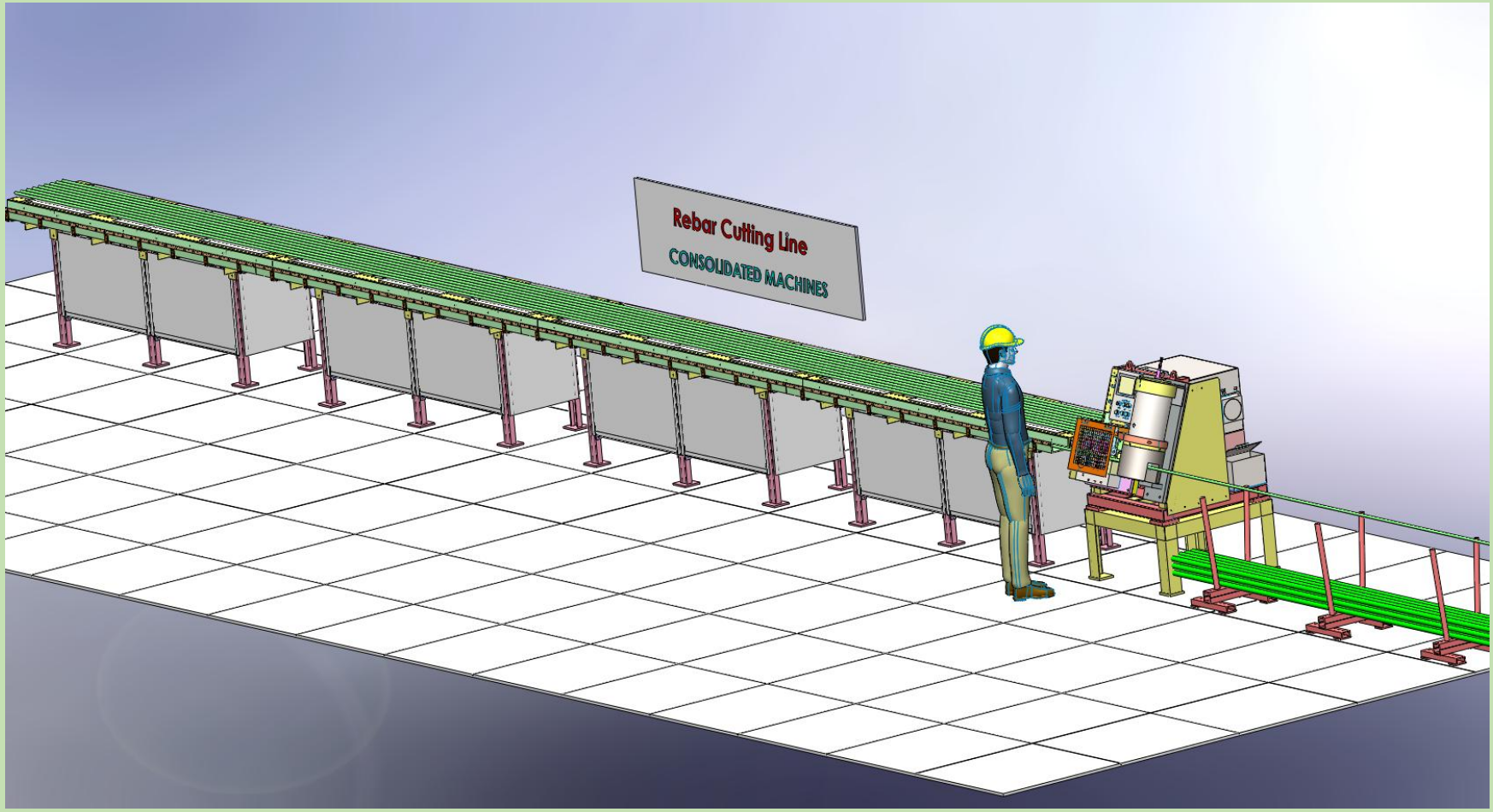
AUTOMATIC REBAR CUTTING LINE
MODEL SL-PRO32 /SL-PRO40



GENERAL ARRANGEMENT VIEW

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General Features

- Available in Two Models – To Suit Maximum Size TMT Bar Fe500
  Metric32 Model SL-PRO32 and Metric40 Model SL-PRO40
- Heavy Duty Hydraulic Cutting Machine with PLC Controls
- Bar Support Pedestal with Conveyor Tray to Assist Bar Feeding
- Production Estimate per Ten Hour Indicative: 45 / 60 Tons
- Plant Foot Print: 13M x 2.5M (Plus Cut Length)
- Full Automatic Function
- Modular Design – Easy to Install or Relocate

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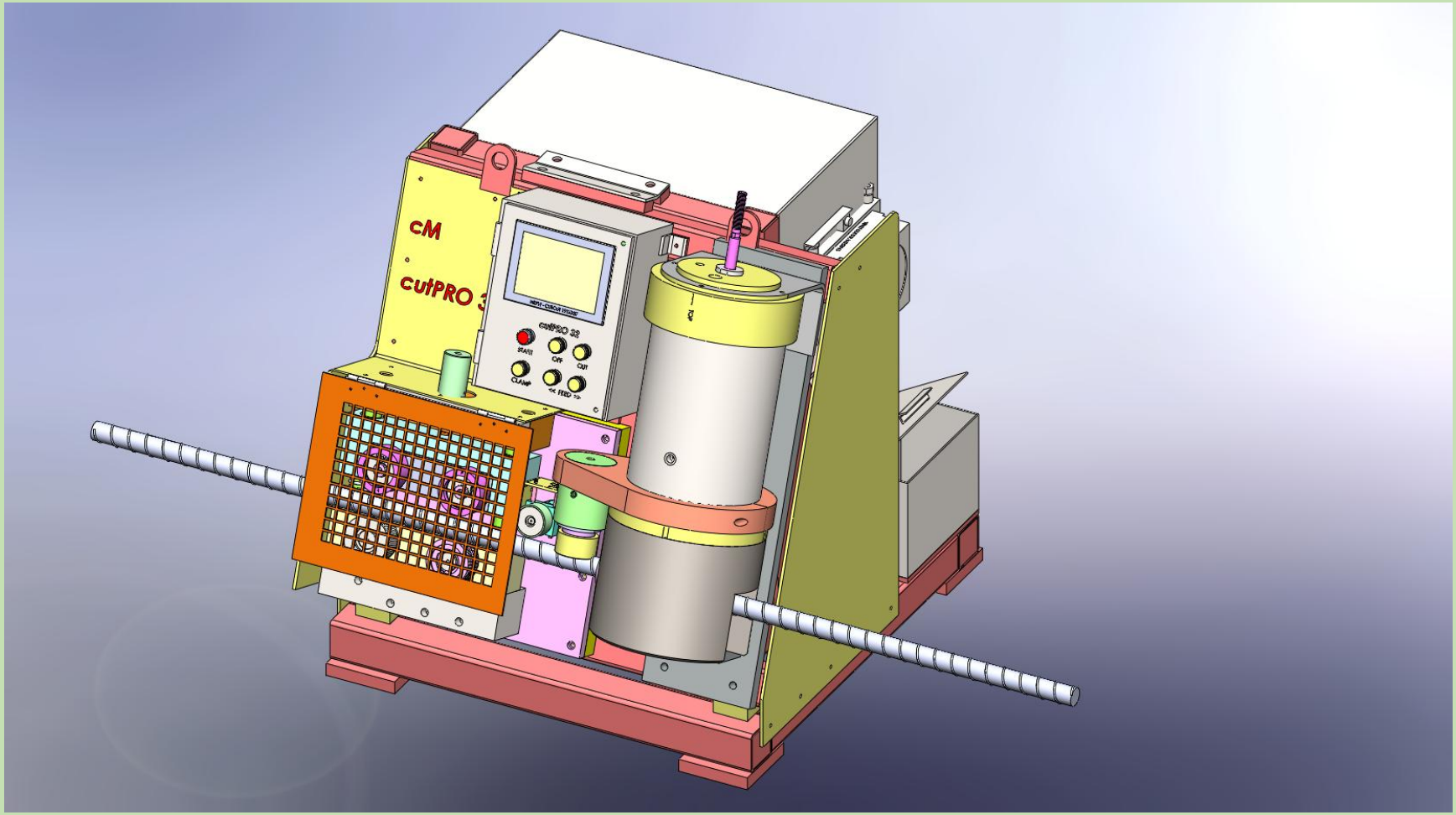
AUTOMATIC CUTTING MACHINE MODEL CUTPRO 32/40

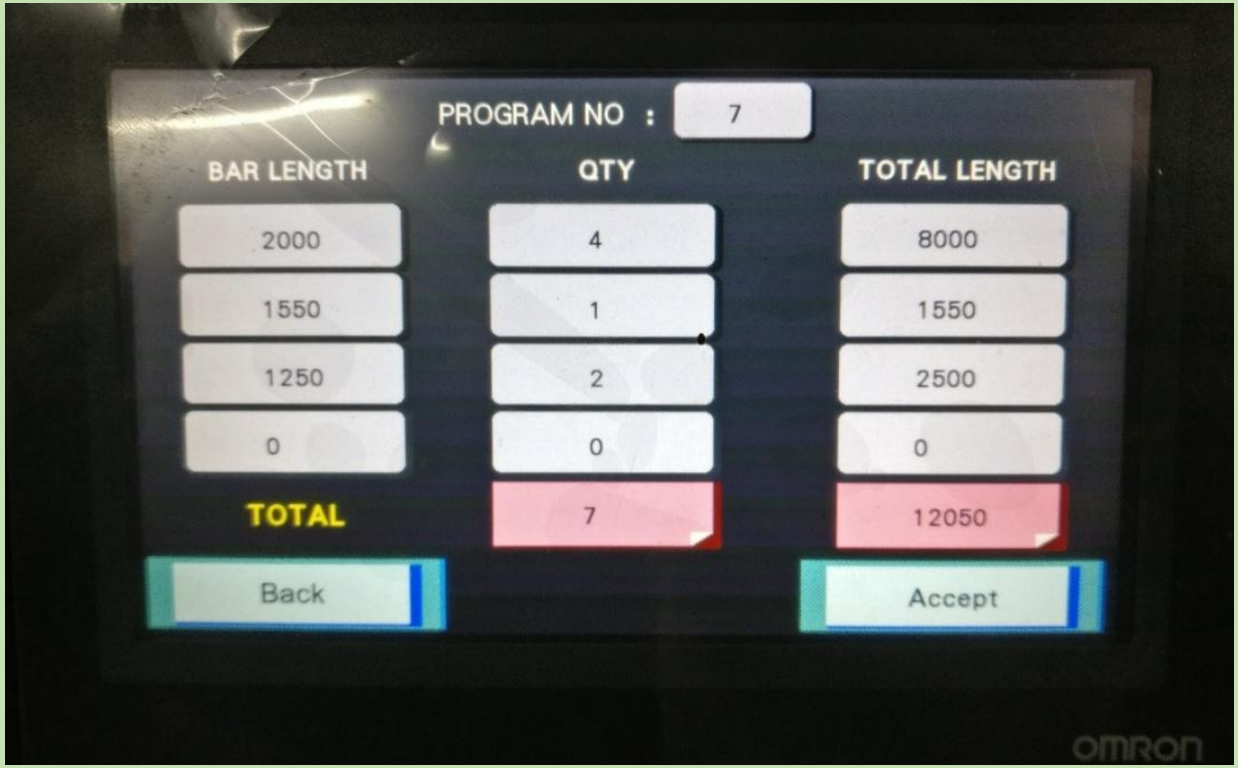


➢ Electro-Hydraulic Drive

Built with Best in Class Like Bosch Rexroth / Yuken / Siemens

➢ PLC Control System

A 12m Stock Bar may be Cut in Various Lengths. the PLC Accepts such Data as a Program. Stored Program is Recalled; Machine is set in Operation



- Cutting Capacity Metric TMT Grade Fe500 / Fe550D (Bar Size x No of Bars)

Model SL-PRO32: 32 / 25 / 20 x 1No 16 x 2 nos

Model SL-PRO40: 40 / 32 / 25 x 1No 20/16 x 2nos

- Protective Cover Provided on Feeder Interlocked with Run Mode

- Compact Electro-Hydraulic Drive is Integrated in the Machine

- Power Installed: Standard Three Phase AC Motors

Model SLPRO32 : 5Hp (3.8Kw) Model SLPRO40 : 7.5Hp (5.8Kw)

Cutting Accuracies

Cutting Accuracy +/-2mm per Meter Length or Better

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Bar Support System

1. Bar Receiving Pedestal Integrated with a Roller Conveyor, Bars to Process are Dropped-in. Rollers Help the Bar to Progress Smoothly
   Pedestal Length 12m – Maximum Weight Capable 4T Distributed

2. Cut Bars Collecting Elements – Four Numbers – Arranged As Required

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Materials and Finish

Tooling and Load Bearing Elements of Alloy Steel Toughened, Phosphate Finish
Panels Powder Coated, Structure Fabrication with Zinc Red-Oxide and Quality Paint Finish

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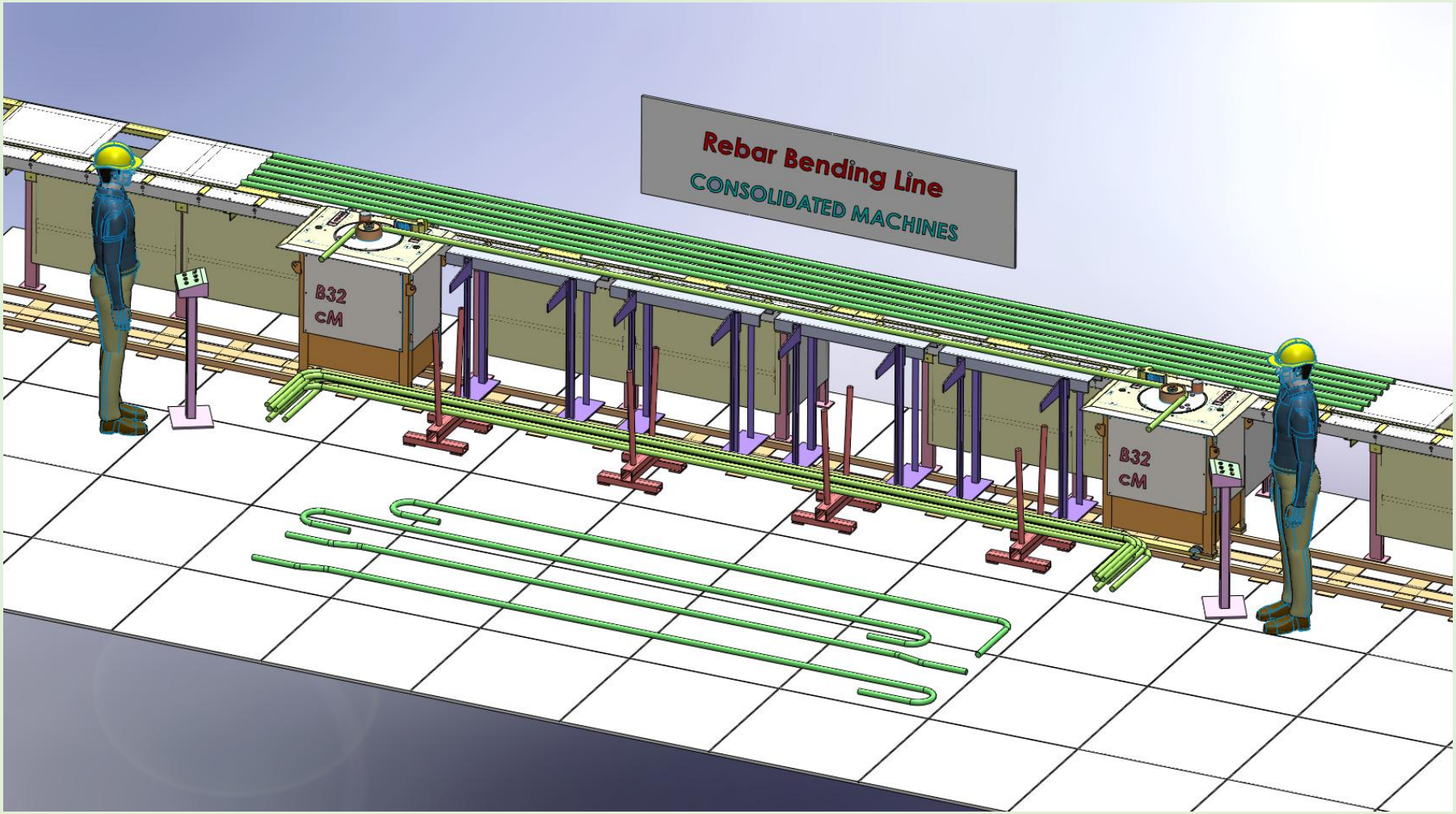
REBAR BENDING LINE MODEL: BL32 / BL40



ARRANGEMENT FOR BOTH END SIMULTANEOUS FORMING

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General Features

- Available in Two Models – To Suit Maximum Size TMT Bar
  Metric32 (BL-32) and Metric40 (BL-40)
- Machines with Electric Control or with PLC Control (Discussed Later)
- Arrange the Plant for: Both Ends Simultaneous Bending or One Side Bending
  Illustrated in Pictures
- Production Estimate per Ten Hour Indicative:
  Model BL32 35 Tons Model BL40 50 Tons
- Plant Foot Print: 14M x 3M
- Machines Move on Rails – Effortless Accurate Positioning and Lock Position
  with Push Button Track Rail Length 14M
- Modular Construction – Easy to Install or Relocate

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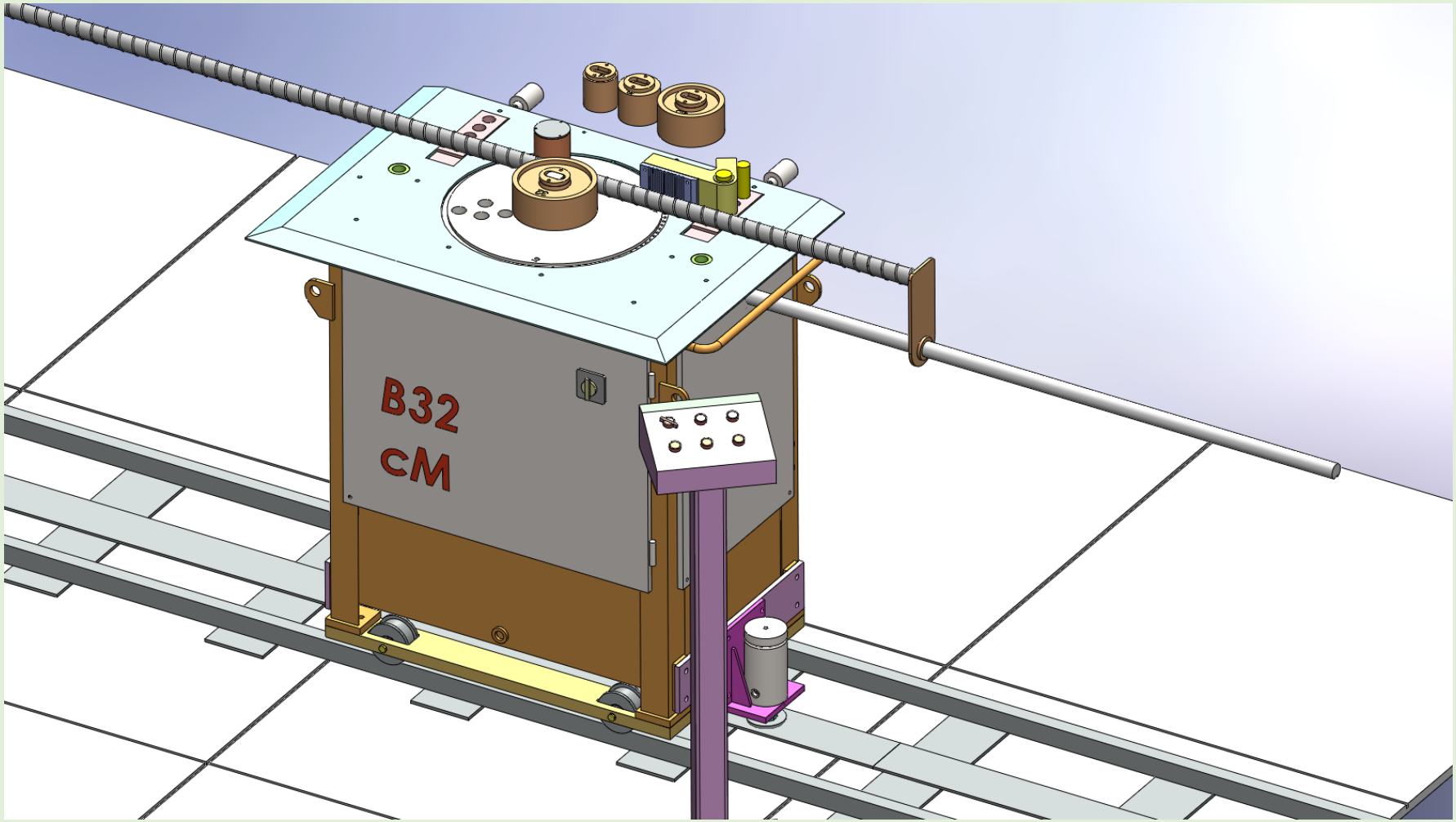
BENDING MACHINES



BAR BENDING MACHINE FOR BENDING LINE APPLICATION

- In General, The Bending Machine Design is More Elaborate to Suit Such Bending Line Application
  - Boosted Bending Speed – Higher Power Installed
  - Machine Design Facilitates Simultaneous Bending on Both Machines Inline
  - Bend Table and Tooling to Suit Proper IS1786 Specs
  - Wheels and Brakes Incorporated to Move the Machine on Track Rails and Lock Position

- Electro-Hydraulic Drive
  Built with Best in Class Elements Like Bosch Rexroth / Yuken / Siemens

- Bi-Directional Bending Capable

- Bending Speed Near Five RPM

- Tooling Specs : Mandrels and Bending Table to Suit IS1786 Specs for Bar Grades Fe500 / Fe550D.

➢ Bending Capacity Metric TMT Grade Fe500 / Fe550D (Bar Size x No of Bars)

Model BL32: 32x1 25x1 20x2 16x3 - Lap Joint Forming Max Bar size 20

Model BL40: 40 / 32x1 25x2 20x3 16x4 Lap Joint Forming Max Bar size 25

➢ Power Installed: Standard Three Phase AC Motors – On Each Machine

Model BL32 : 5Hp (3.8Kw) Model BL40 : 7.5Hp (5.8Kw)

(Brakes are Air-Operated. 1hp x 6bar Air-Compressor be Installed by the User)

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Bending Accuracies

Angle Setting Resolution 3 Deg – Means Target Value Deviation Max +/- 1.5Deg which is Within the Acceptable Deviation Limits

Optional PLC Controlled machines

Angle Setting Resolution 1 Deg – Means Target Value Deviation Max +/- 0.5 Deg

Note that Repeat Accuracy Depends on Fine Machine Setting and Rebar Material Elasticity.

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Forming Limitation for Both End Forming

Minimum Distance of Bending Heads – 1.2 m

Maximum Distance of Bending Heads – 11.5 m

Bar Support System

1. Bar Receiving Pedestal - Pedestal Length 12m – Maximum Weight Capable 4T Distributed
2. Intermediate Bar Support – This Arrangement is Integrated with Main Pedestals. Activate the Segment as Required – Picture Illustrated
   Or OPTIONAL Bar Kick-IN Kick-Out Modules – Six Units
3. Bar Position Reference Flags
4. Formed Bars Collecting Elements – Eight Numbers – Arranged As Required

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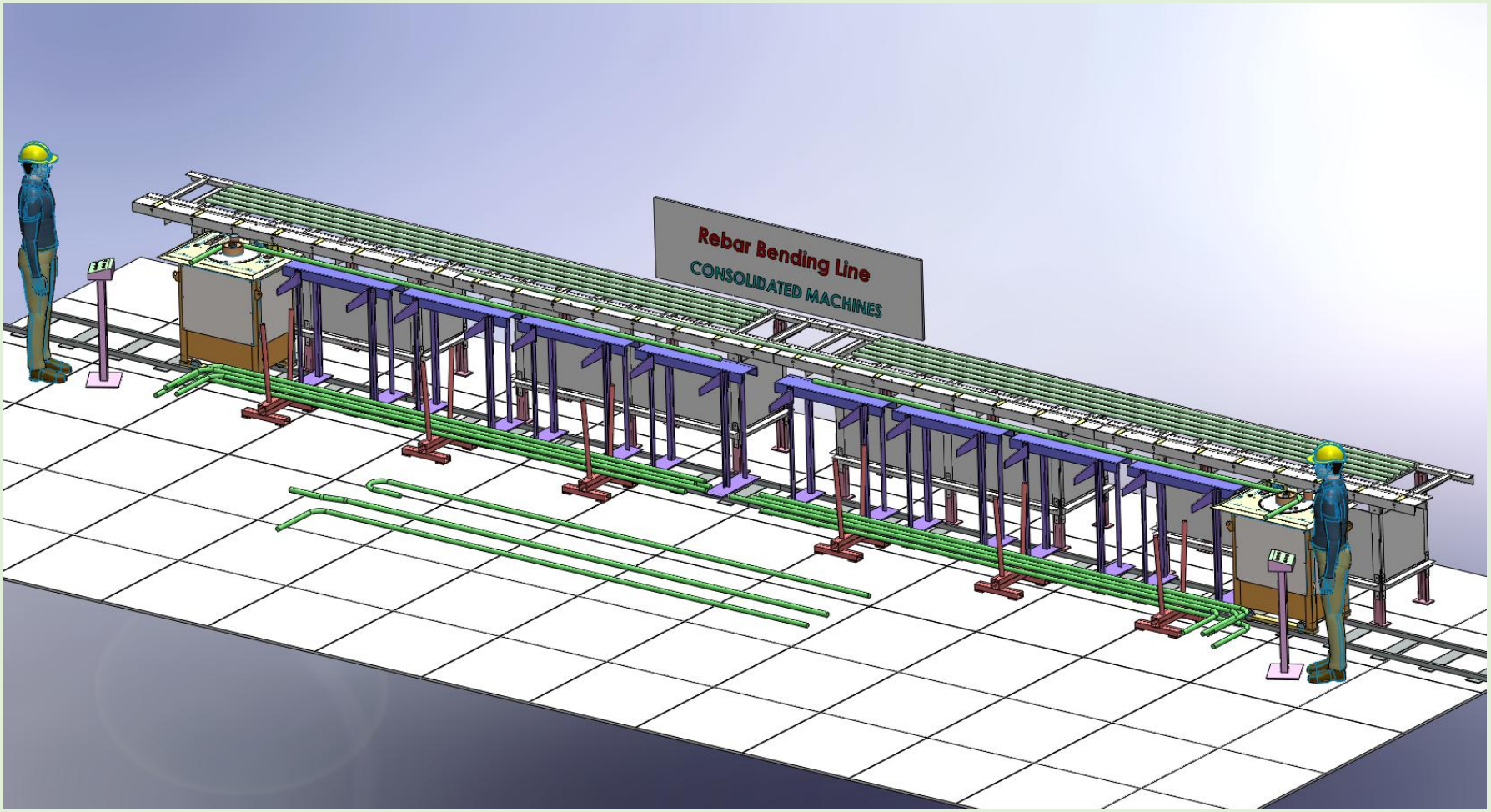
Materials and Finish

Tooling and Load Bearing Elements of Alloy Steel Toughened, Phosphate Finish

Panels Powder Coated, Structure Fabrication with Zinc Red-Oxide and Quality Paint Finish



ARRANGEMENT FOR ONE END FORMING – BOTH MACHINES UTILIZED

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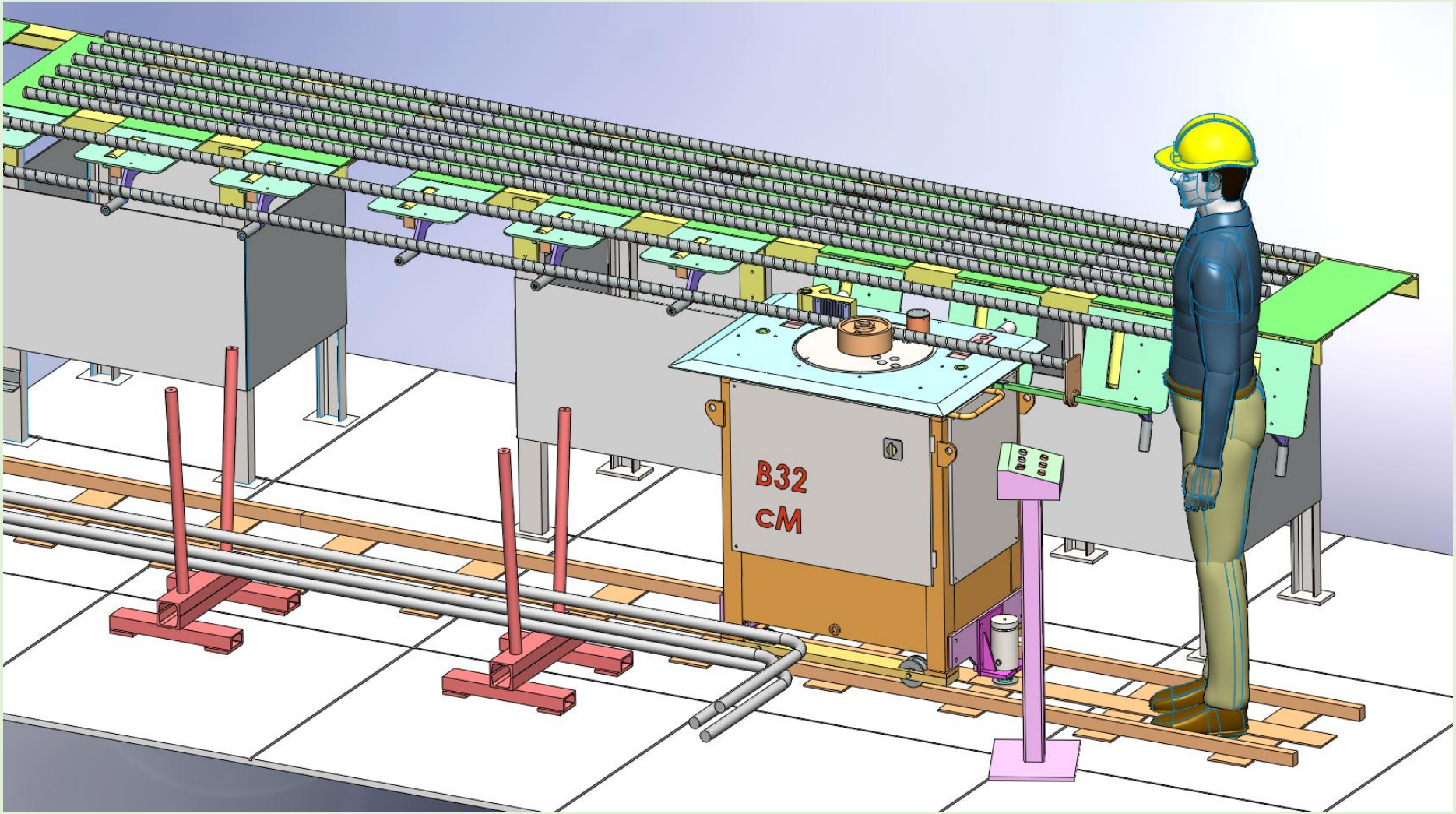
PLANT SETUP AND PRODUCTION



PLANT SETUP – REFER FOLLOWING NOTES

Setup : a Near Ten-Minute Process

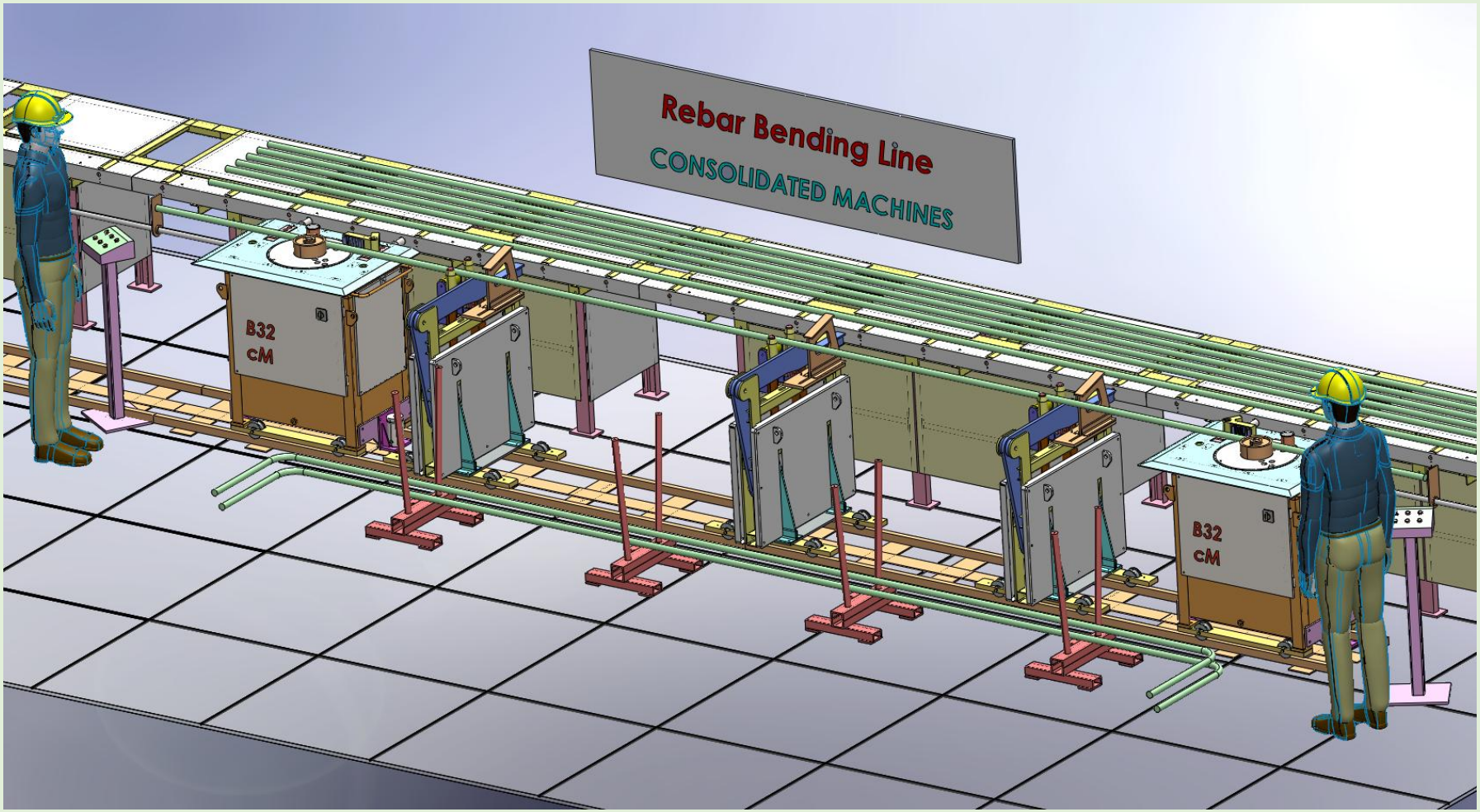
1. Suitable Mandrel Rollers are Installed on the Machine Bending Head
2. Both Machines are Positioned as Required and Locked (Length Setting)
3. The In-Between Bar Support Elements are Activated
4. The Bar Linear Position Reference Flag is set
5. Formed Bar Collecting Bin Elements are Adequately Positioned

Plant is now Ready for Production

1. Operator Rolls the Bar to Drop onto the Bending Table, Tangent to the Bending Roller
2. Bar Position Reference Flag is Activated and the Bar is Positioned, Flag is then Deactivated
3. Bending is Activated - Bend Angle is Achieved as per the Setting
4. Bending Table Returns to Home Position
5. Bar is Disengaged from the Center and Pushed Off the Table to Drop into the Collecting Bin.
6. Next Bar is Rolled into the Position and Process Continues

Cycle time Less than A Minute

OPTIONAL FEATURES: BAR KICK-IN / KICK-OUT



ARRANGEMENT WITH BARS KICK-IN KICK-OUT SYSTEM

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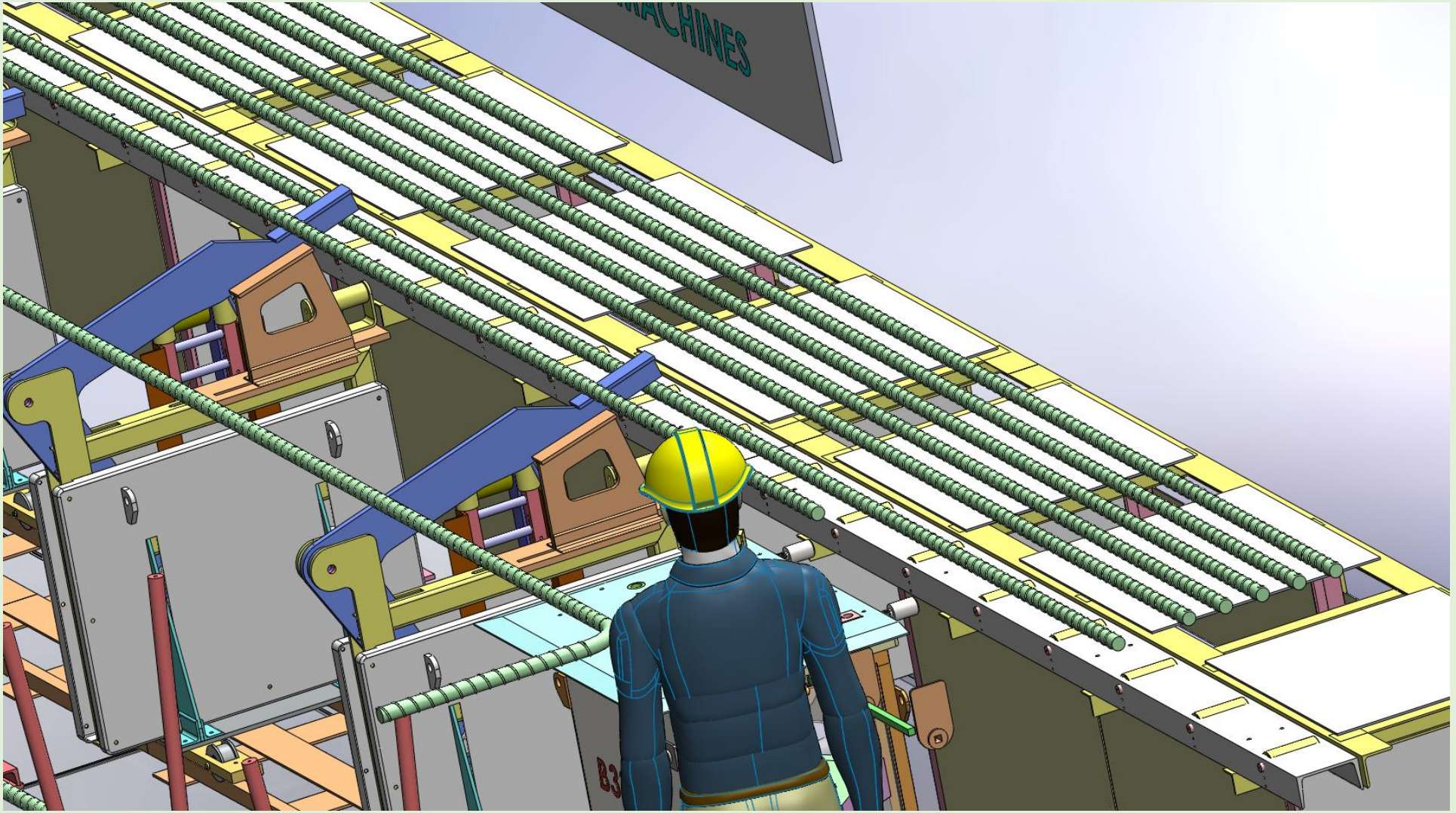

CLOSEUP VIEW OF KICK-IN KICK-OUT SYSTEM - IN ACTION

- Kick-In / Kick-Out Six Modules are Provided
- Modules are Supported on the Common Track Rail – Position the Modules As Required
- Modules are Air-Operated – User will Provide Compressed air Facility. A common Air Compressor 5hp (10 to 12 CFM at 8 bar) would be Sufficient
- Working – The Incoming Bar is Rolled onto the Pads. When Operated (with a Push Button) the Formed Bar is Kicked-out into the Bin and the Fresh Bar is Loaded onto the Bending Table.

Caution

- Bars Kicked-In will Be in Straight form Only
- Some Critically formed Bars Like U-Bend may Resist a Kick-out Action, Operators Support may be Required
- Carefully Evaluate Optional Features Later Upgrades may be Difficult

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NOTES ON PLANT INSTALLATION

THE PLANT FOOT PRINT FLOOR AREA MUST BE GOOD QUALITY INDUSTRIAL FLOORING

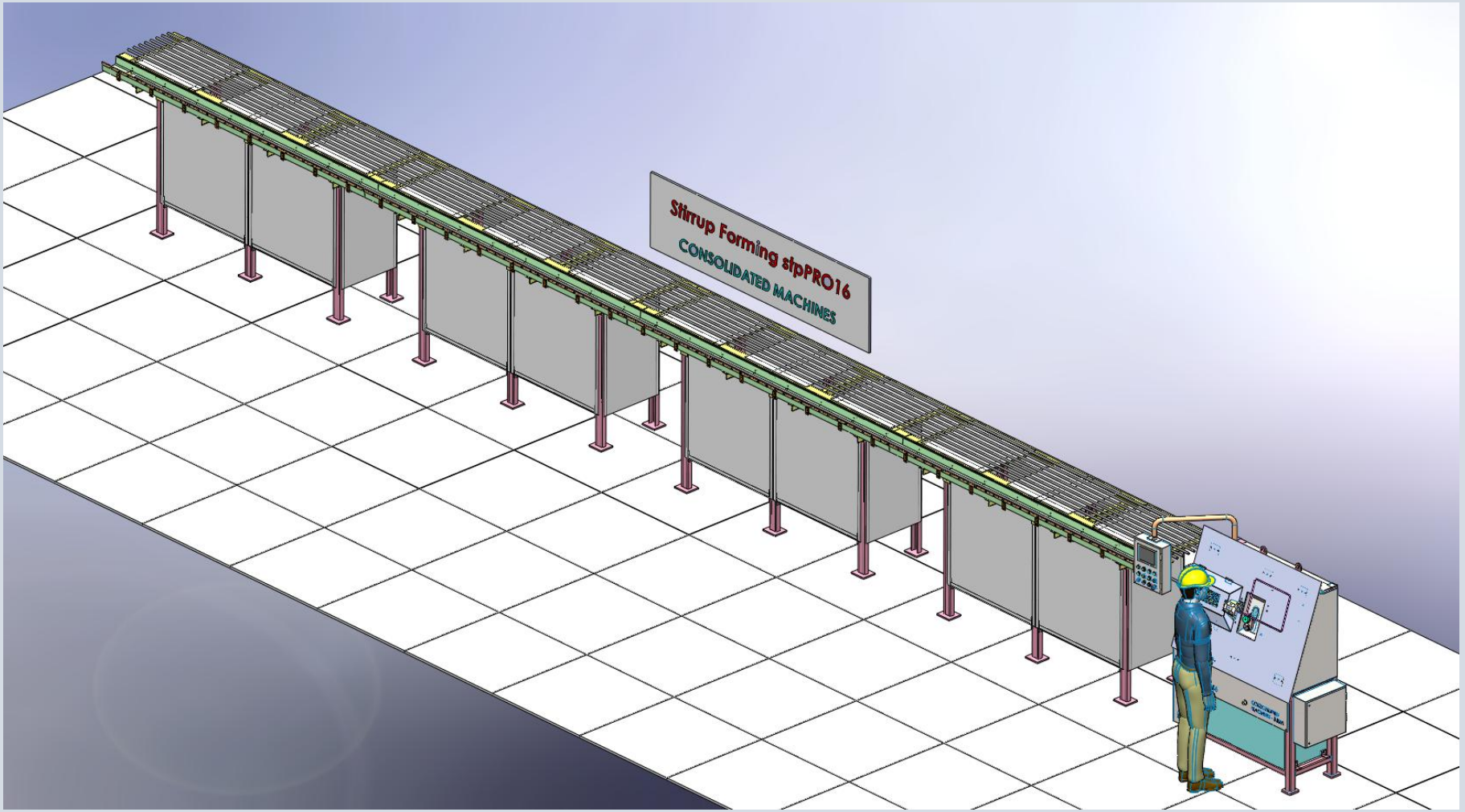
TRACK RAILS REQUIRED TO BE MILDLY GROUTED, DETAIL DRAWINGS WILL BE FURNISHED THE USER WILL ACCOMPLISH THIS AS A PART OF CIVIL WORK

PEDESTALS ARE SUPPLIED IN MODULAR FORM, ASSEMBLY INSTRUCTIONS WILL BE FURNISHED, PEDESTALS ARE FREE-STANDING

MACHINES ARE SUPPLIED IN FULLY ASSEMBLED STATE

KICK MODULES (OPTIONAL) AND BIN ELEMENTS ARE ARRANGED AS REQUIRED.

AUTOMATIC STIRRUP LINE MODEL STPPRO16



GENERAL ARRANGEMENT VIEW

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General Features

- Capable Maximum Size TMT Bar 16 Gr Fe500 / 550D
- Electro-Hydraulic System with PLC Controls
- Bar Support Pedestal with Conveyor Tray to Assist Bar Feeding
- Production Estimate per Ten Hour Indicative: 2 / 10 Tons
- Plant Foot Print: 14M x 2.5M
- Full Automatic Function
- Modular Design – Easy to Install / Relocate

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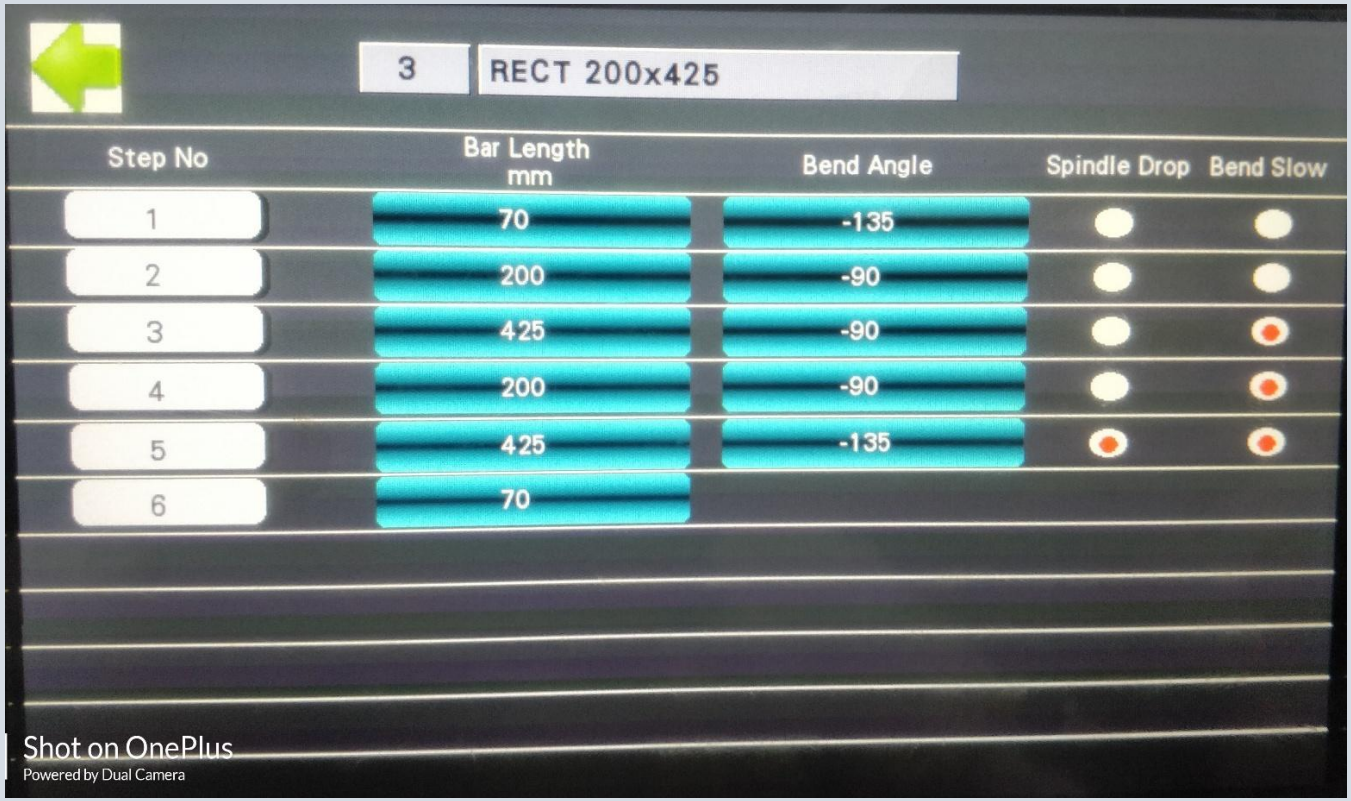
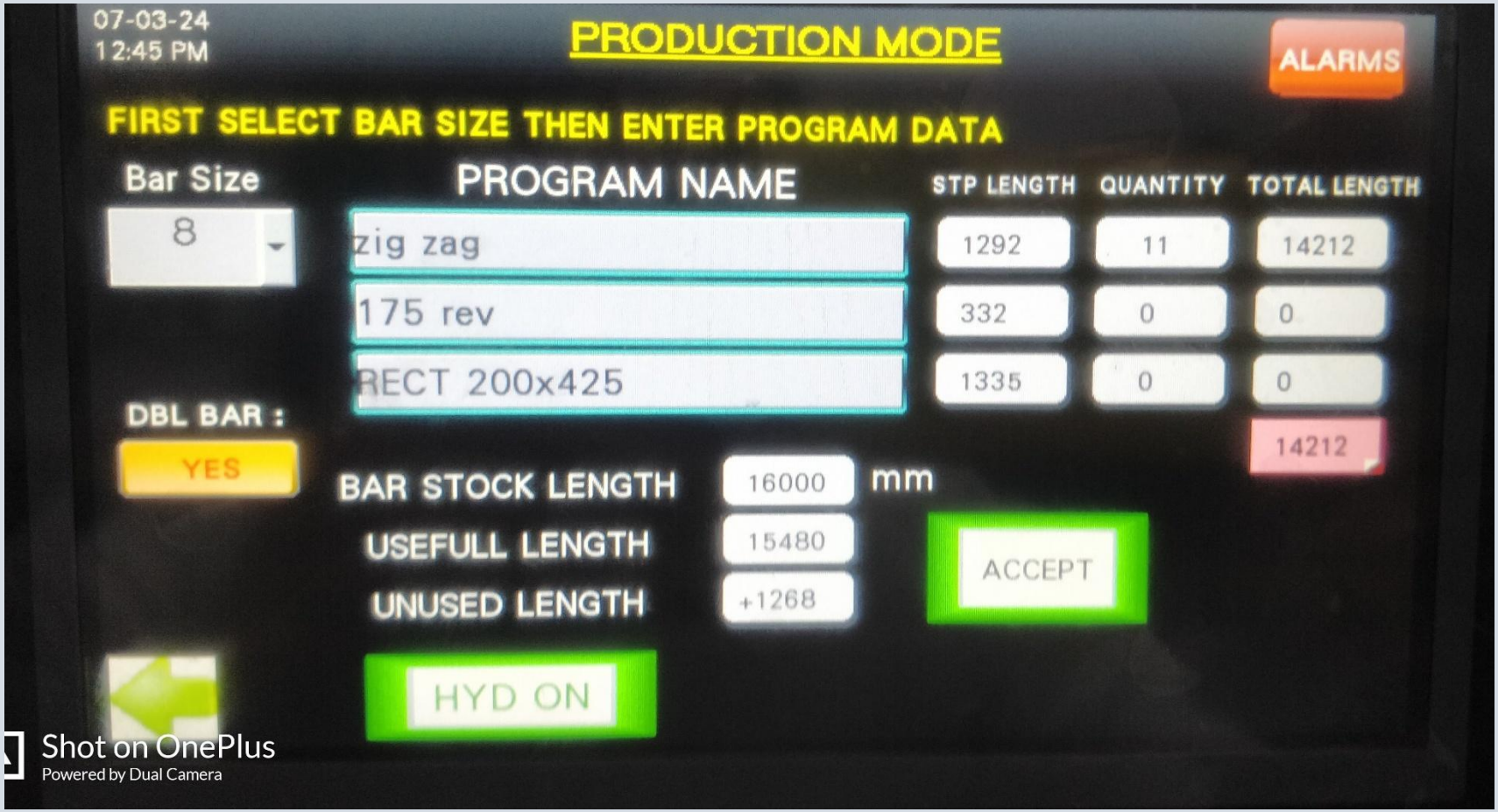
MACHINE - AUTOMATIC STIRRUP BENDER STPPRO16

- Electro-Hydraulic Drive
  Built with Best in Class Like Bosch Rexroth / Yuken / Siemens

- PLC Control System - A 12m Stock Bar may be Formed in Various Stirrup Shapes. Such Data is Stored as a PROGRAM. A Program is Recalled and Machine Set in Motion





FOR CONVENIENCE OR OPTIMIZE BAR WASTAGE – WE CAN RUN A CYCLE WHERE THE 12M STOCK BAR CAN BE FORMED IN DIFFERENT SHAPES WITH DEFINED QUANTILES.

- Bending Capable – Metric TMT Size 16/12/10 x 1 no. Size 8 x 2nos
  Bend Tooling to Suit Inner Bend Radius Near 2xD
- Protective Cover Provided on Feeder Interlocked with Run Mode

- Compact Electro-Hydraulic Drive is Integrated in the Machine

- Power Installed: Standard Three Phase AC Motors 5hp (3.8Kw)

- Bending Speed Near 40rpm (Variable Control) – Ideal for Large Shapes

- Pull Speed Near 600 mm/sec

Performance Accuracies

Bending Accuracy +/- 1.5 Deg or Better

Length Accuracy +/- 2mm per Meter Length or Better

Caution – Bending Accuracy Repeatability Also Depends on Bar Material Elasticity

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Caution Notes

In General in any Automatic Process, the Material Consistency is Important
In this case the Bar Quality Matters for A Smooth Operation
Mill Bars Good Straightness – Uniform Dimensions and Roundness – Bar Ribs Uniform and Linear.

If the Uniformity is Not so Good, Bars when Pulled Tend to Rotate which Distorts the Plane of the Product. However, Operators Mild Support can Control this Issue Effectively.

Also the Machine has the Option to Engage "Semi-Auto Mode" where the Plane of the Forming Product can be Corrected Before the Following "BEND Action"

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Bar Support System

1. Bar Receiving Pedestal Integrated with a Roller Conveyor, Bars to Process are Dropped-in. Rollers Help the Bar to Progress Smoothly
   Pedestal Length 12m – Maximum Weight Capable 4T Distributed

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Materials and Finish

Tooling and Load Bearing Elements of Alloy Steel Toughened, Phosphate Finish
Panels Powder Coated, Structure Fabrication with Zinc Red-Oxide and Quality Paint Finish

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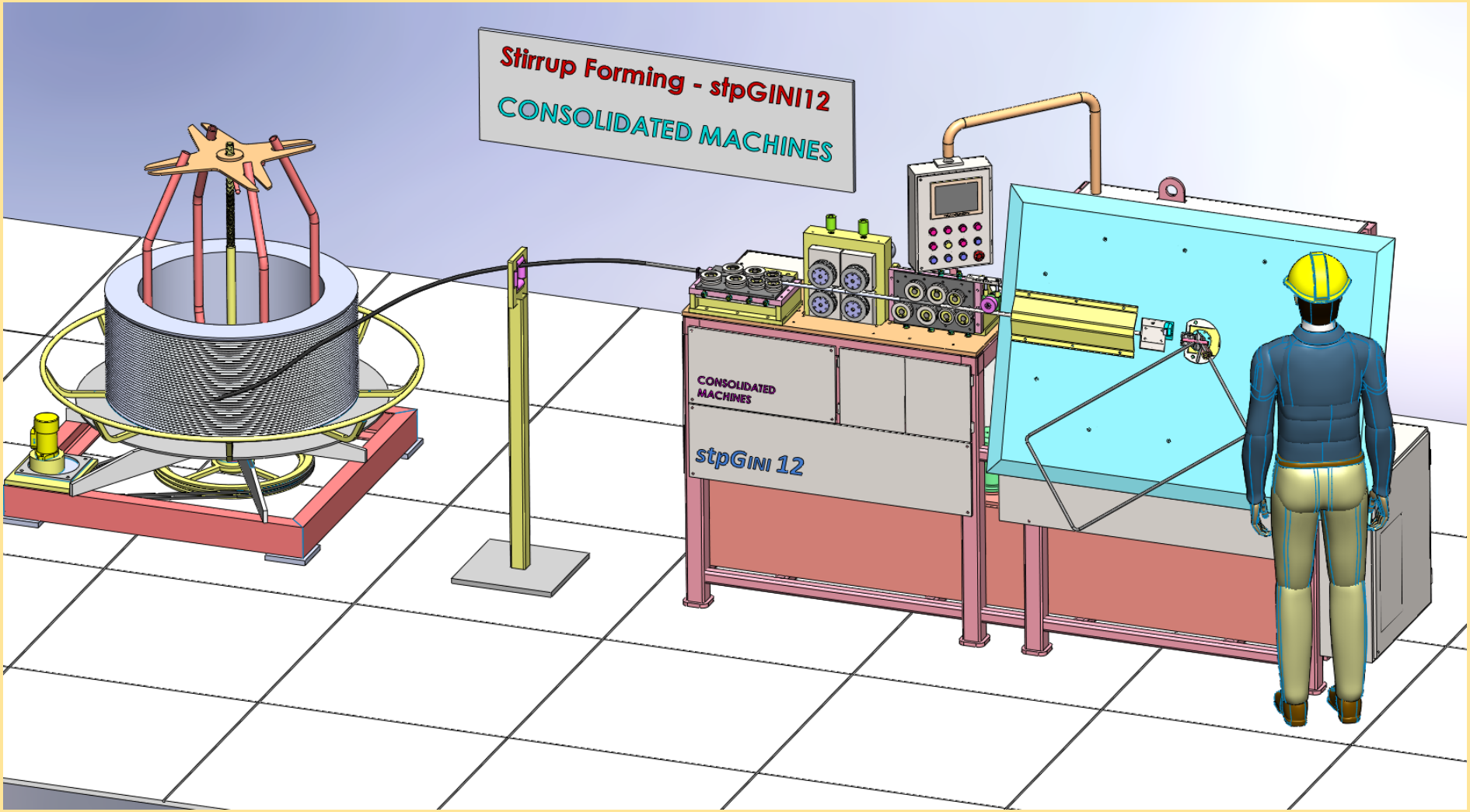
Fully Automatic Stirrup Bender - stpGini12



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General Features

- Stirrup Forming From Rebar Coils
- Forming Capacity : TMT Metric Size 8 / 10 / 12 (USA Equival #2 / #3 / #4)
- Production Estimates : 3 to 6T per 10 Hr shift - Common Stirrup
- Power Installed : 18 HP (14.2 Kw) – AC Electric Motors
- Bending Speed :Near 40Rpm (Variable Control) – Ideal for Large Shapes
- Pull Speed :Near 600 mm/sec
- **Performance Accuracies**

Bending Accuracy +/- 1.5 Deg or Better

Length Accuracy +/- 2mm per Meter Length or Better

Caution – Bending Accuracy Repeatability Also Depends on Bar Material Elasticity

- System : Conventional Electro-Hydraulics – with PLC controls
- Machine Foot Print : 2700 x 700 mm
- Coil Dispenser:

Powered System to Synchronize with Machine Speed – To Ensure Smooth Running
Accepts Coil Size - Minimum ID 650 mm - Maximum OD 1200 mm
Maximum Height 600mm Maximum Weight 2500 Kgs
Coil Dispenser Foot Print 1200 x 1200 mm

Materials and Finish

Tooling and Load Bearing Elements of Alloy Steel Toughened, Phosphate Finish

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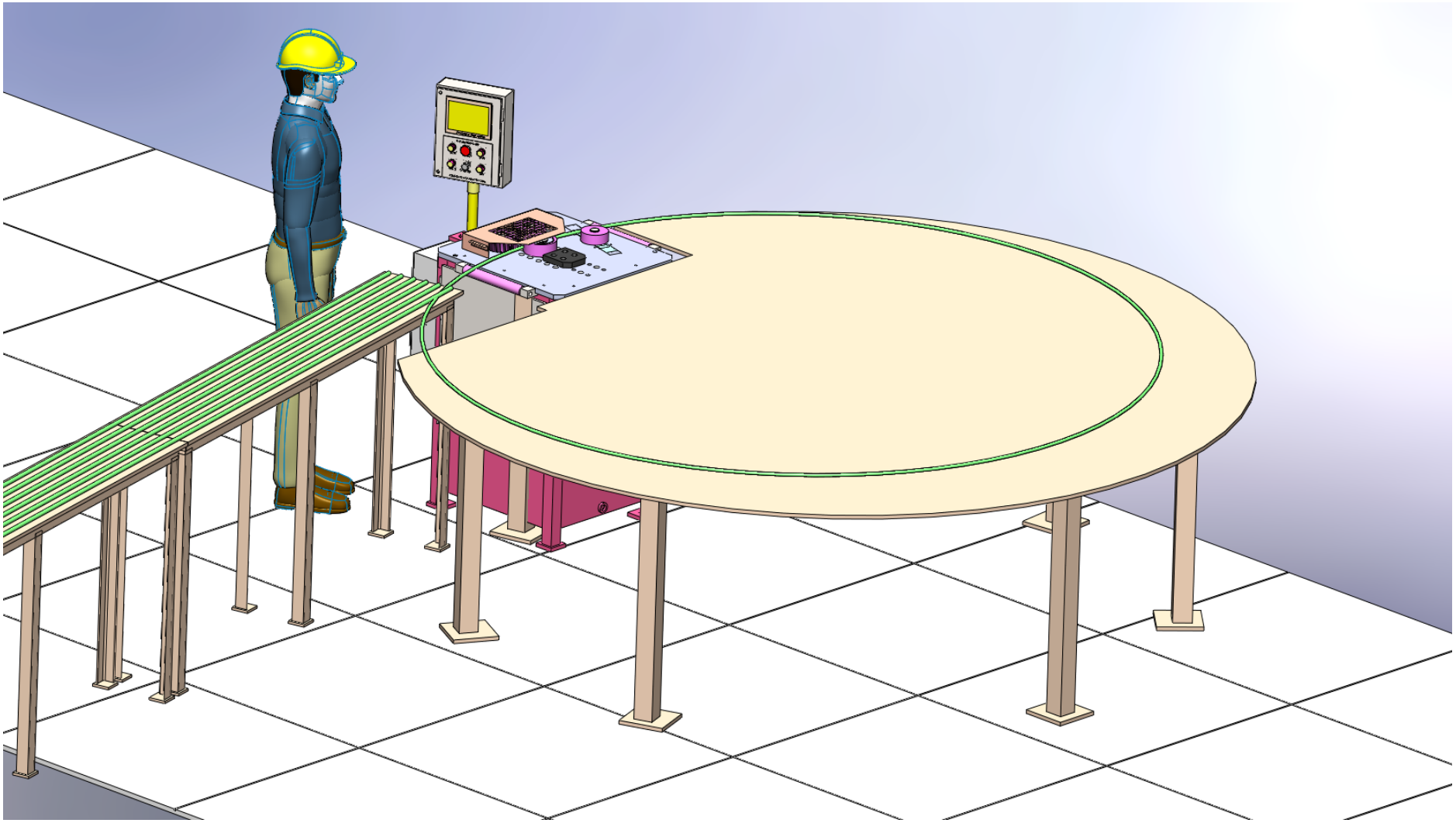
ARCH - RADIUS - RING FORMING



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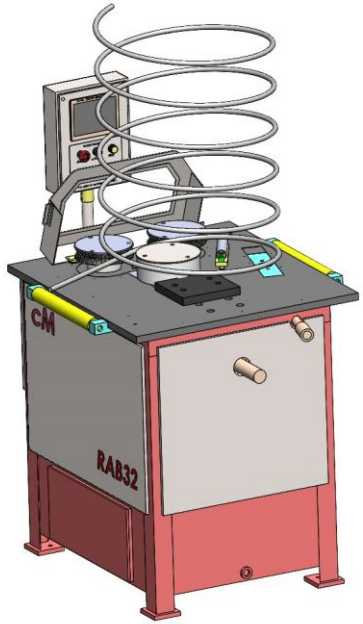
RAB20



RAB32

- An Ideal Equipment when TMT Bars are to be Formed in Large Arc-Radius or Rings.
- The PLC / Numerical Control helps to Set the Machine to Form the Desired Profile.
- It will then Store the Data for future use.
- A robust Electro-Hydraulic Drive Powers the Machine which ensures Excellent Productivity, Lifecycle and Minimal Maintenance.

MACHINE SPECIFICATIONS

Model	Max Bar size	Forming Speed	** Forming Capacity	Power	Machine Size	Machine Weight
	Gr 500	m/min	Bar Size x Min Ring Size	Kw (HP)	(LXBXHt) mm	Kgs
RAB20	Metric TMT-20	10-16	20x1500 / 16x750	3 (2.3)	800x700x1000	375
RAB32	Metric TMT-32	10-17	32x3000 / 25x1250	5.8 (7.5)	1100x800x1000	775

** THE FORMING CAPACITY OF SUCH MACHINE IS DETERMINED BY THE MINIMUM SIZE RING THE MACHINE IS ABLE TO FORM

- ✓ PLC CONTROLS : PLC MAKES THE MACHINE A LOT USER FRIENDLY, HAS SEVERAL WORKING ADVANTAGES, AND IT CAN STORE DATA FOR FUTURE PROCEDURES.
- ✓ DIRECT DRIVE DESIGN WITH RADIAL PISTON HYDRAULIC MOTORS IS SUPER-EFFICIENT AND MINIMAL MAINTENANCE
- ✓ MACHINE WITHOUT PLC AUTOMATION: HERE THE ROLLER POSITION IS SET MANUALLY
- ✓ COVERS AND SAFETY SYSTEMS ENSURES SAFE WORKING CONDITIONS
- ✓ SPIRAL FORMING IS OPTIONAL ATTACHMENT MAX SIZE TMT METRIC 12 RAB20 (16 ON RAB32)

CONSOLIDATED MACHINES
HYDRAULICS • HYDRO-PNEUMATICS
CONSTRUCTION EQUIPMENT

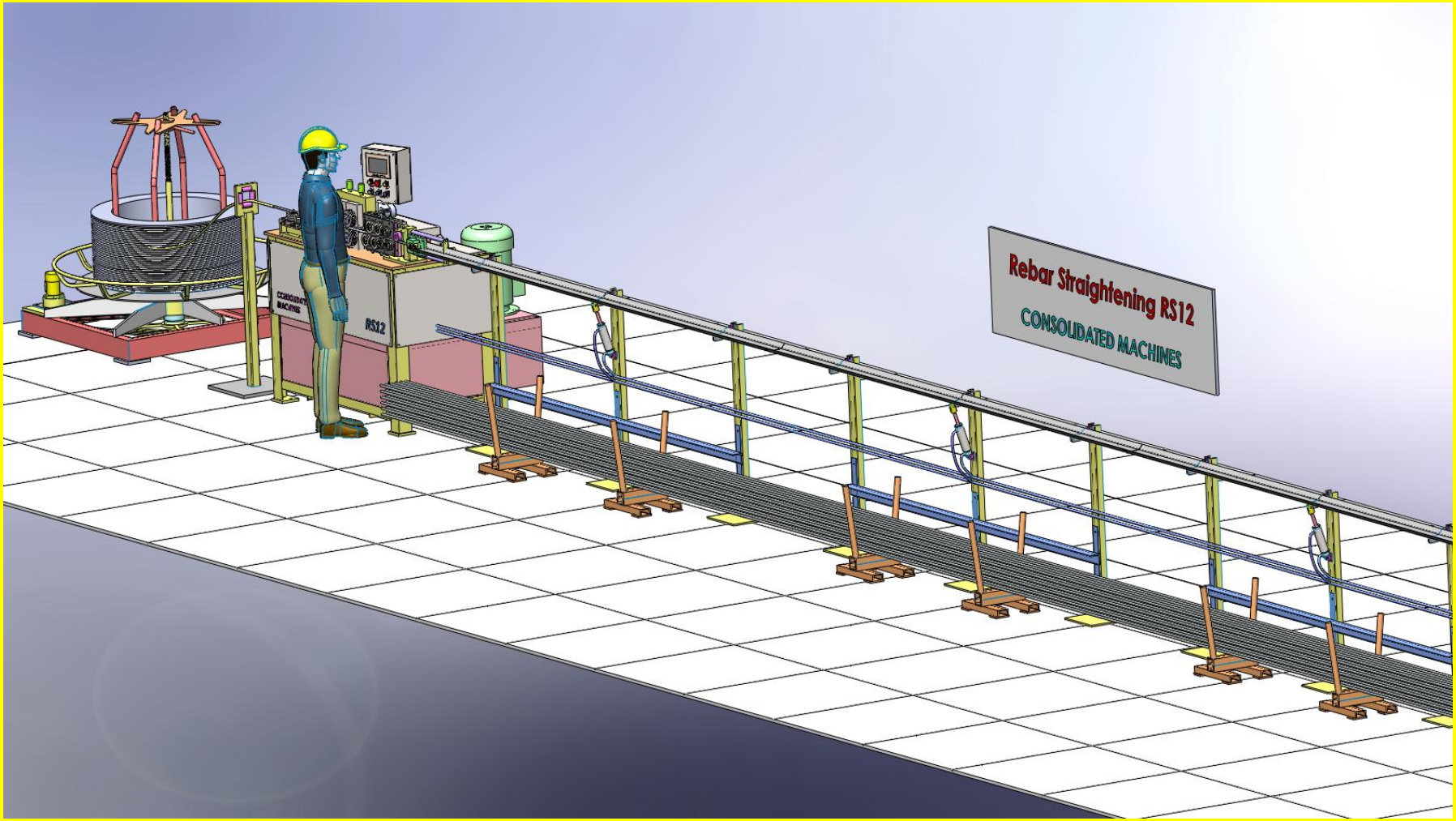
MATERIALS AND FINISH

TOOLING AND LOAD BEARING ELEMENTS OF ALLOY STEEL TOUGHENED, PHOSPHATE FINISH
PANELS POWDER COATED, STRUCTURE FABRICATION WITH ZINC RED-OXIDE AND QUALITY PAINT FINISH

WATCH VIDEO https://youtube.com/shorts/a6SotxlpbXM?si=Oh2HdE8sRkpBBkkV
MACHINE IS AVAILABLE WITH / WITHOUT PLC CONTROLS

CONSOLIDATED MACHINES
HYDRAULICS • HYDRO-PNEUMATICS
CONSTRUCTION EQUIPMENT

REBAR STRAIGHTENING LINE - RS12



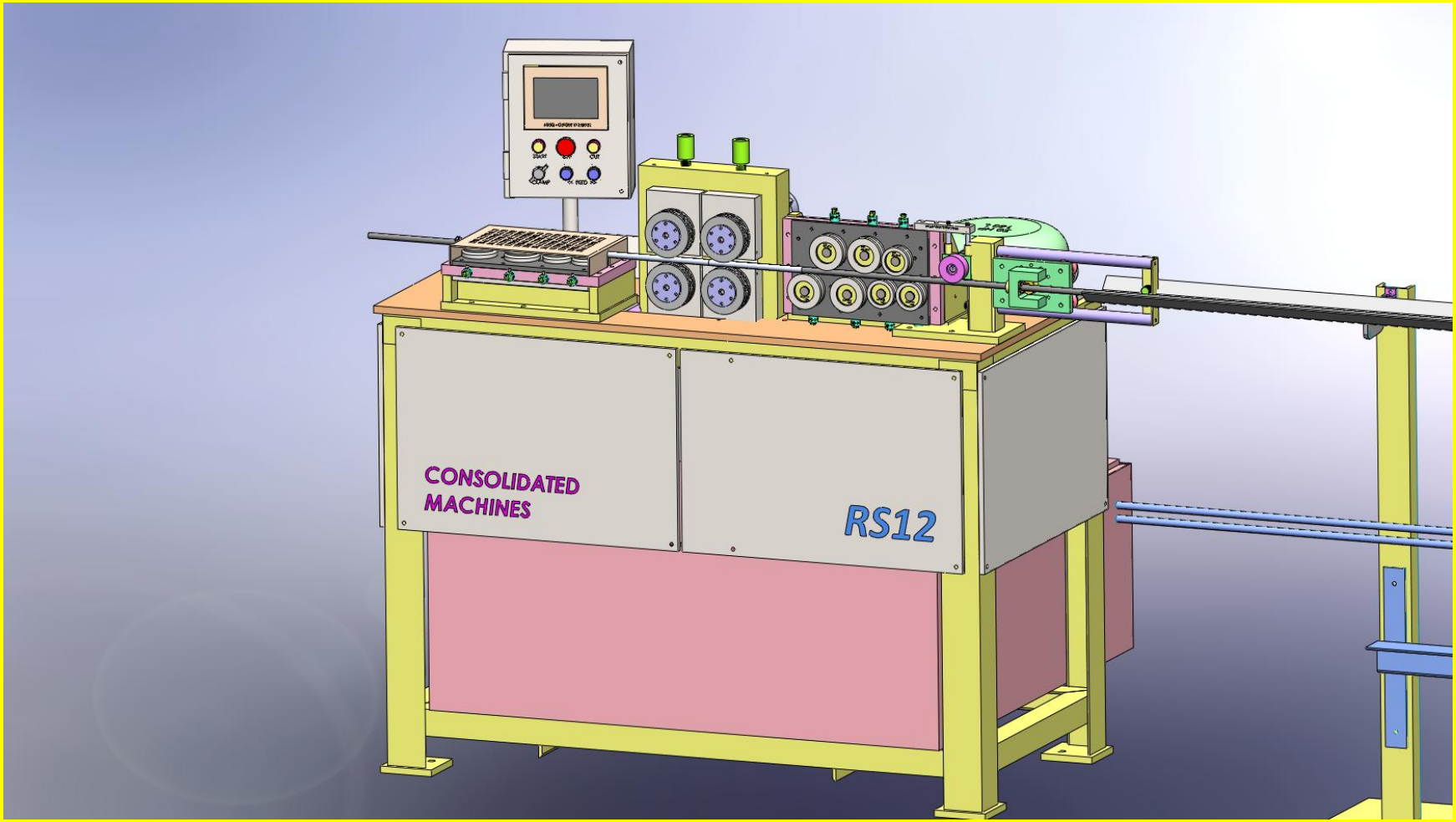
GENERAL ARRANGEMENT WITH 12M COLLECTING SYSTEM

General Features

- Commonly Used by Rebar Distributors to Convert Coil Form to Straightened Product
- Bar Straightening in Two Planes – Progressive with Multiple Roller Arrangement
- Coil Dispenser Unit – Details Provided
- Bar Collecting System – Modular Construction
- Plant Foot Print: 16M x 2.5M
- Modular Construction – Easy to Install or Relocate

CONSOLIDATED MACHINES
HYDRAULICS • HYDRO-PNEUMATICS
CONSTRUCTION EQUIPMENT

STRAIGHTENING MACHINE



CONSOLIDATED MACHINES
HYDRAULICS • HYDRO-PNEUMATICS
CONSTRUCTION EQUIPMENT

SPECIFICATIONS

- Bar Sizes Capable : TMT Metric Size 8 / 10 / 12 (USA Equivalent #2 / #3 / #4)
- Straightening Speed: 48 Meters per Minute
- Power Installed : 20 HP (15.6 Kw) – AC Electric Motors
- Electro-Hydraulic Drive
  Built with Best-in-Class Elements Like Bosch Rexroth / Yuken / Siemens
- PLC Controls : Omron / ABB / Delta

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COIL DISPENSER:

- POWERED SYSTEM TO SYNCHRONIZE WITH MACHINE SPEED – TO ENSURE SMOOTH RUNNING
- ACCEPT COIL SIZES : MINIMUM ID 650 MM - MAXIMUM OD 1200 MM - MAXIMUM HEIGHT MAXIMUM COIL WEIGHT 2500 KGS

BAR RECEIVING SYSTEM:

FOUR METER MODULES – WITH BAR COLLECTING BINS

MATERIALS AND FINISH

TOOLING AND LOAD BEARING ELEMENTS OF ALLOY STEEL TOUGHENED, PHOSPHATE FINISH PANELS POWDER COATED, STRUCTURE FABRICATION WITH ZINC RED-OXIDE AND QUALITY PAINT FINISH

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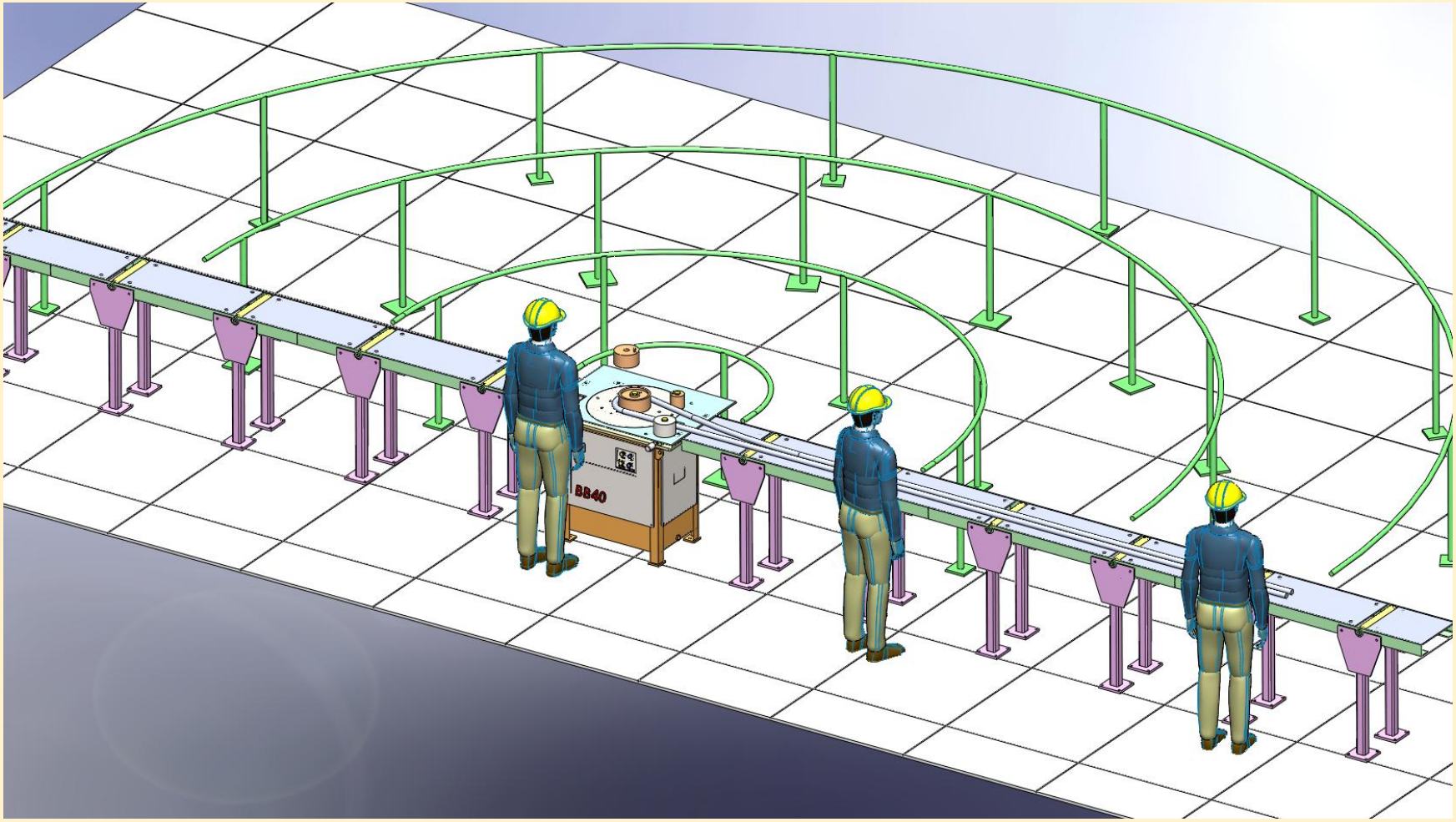
CONSOLIDATED MACHINES
HYDRAULICS • HYDRO-PNEUMATICS
CONSTRUCTION EQUIPMENT

Bar Bundling Plant – BB40



GENERAL ARRANGEMENT FOR A BASIC PLANT

TMT Rolling Mill and TMT Distributors, this Plant comes Handy For Convenience of Transportation Rebars are Folded Half way, Several Bars Bundled Maintaining Reasonable Weight of the Bundle to enable Manual Handling

Machine View

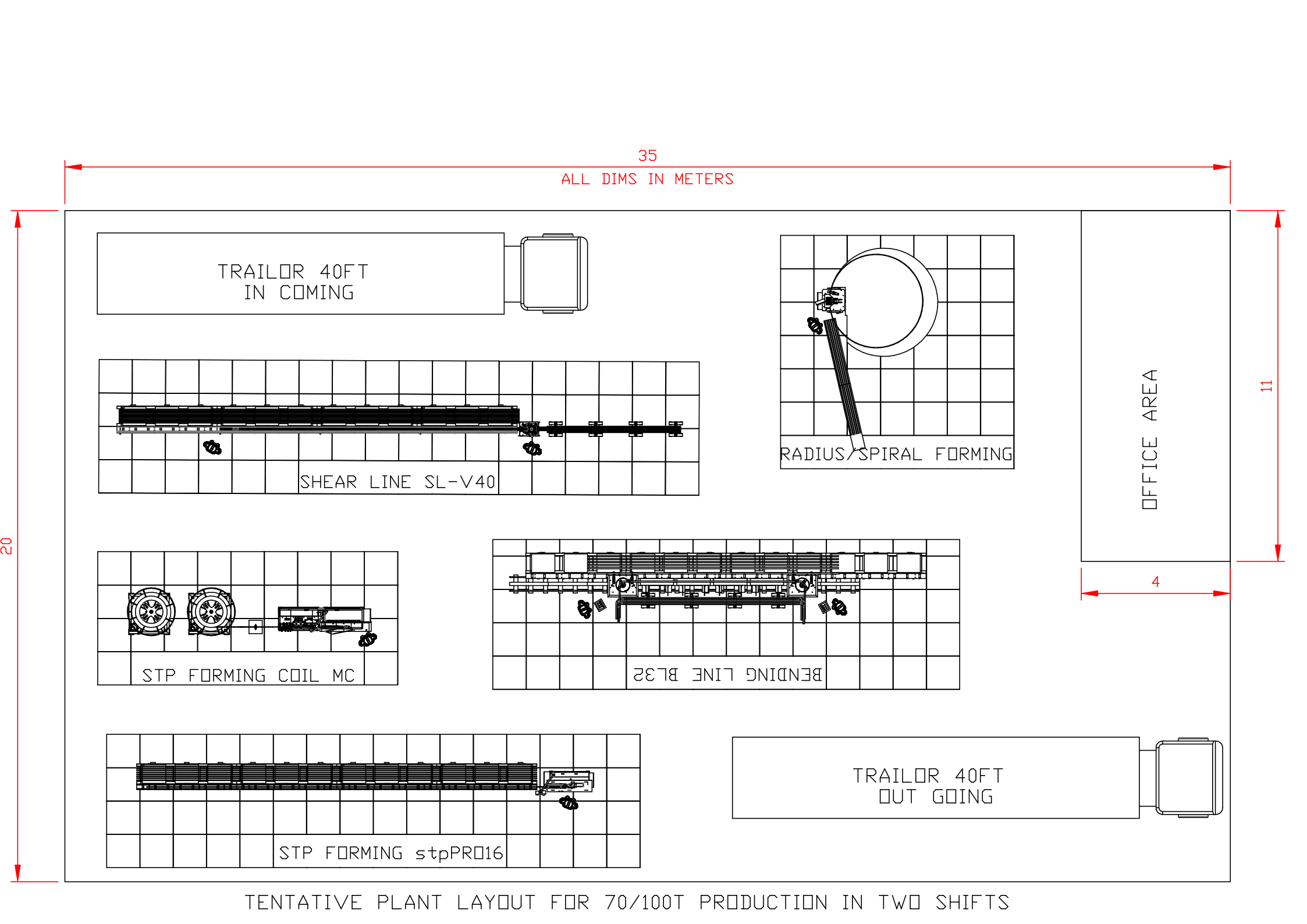
CONSOLIDATED MACHINES
HYDRAULICS • HYDRO-PNEUMATICS CONSTRUCTION EQUIPMENT

General Features

- Electro-Hydraulic Controls : to Suit Semi/Full Automatic Process
- Features : Bi-Directional Bending Operation to Suit Users Setup
- Max Bar size : 40 x 500 Gr (UTS 580) steel
- Multiple Bar Capacity : Size 40/36/32 One Bar, 25x2Bars, 20x3, 16x5, 12x10, 10x14, 8x20 nos
- Typical Bending Speed : Near 7 Secs to form a U Bend.
- Installed Power : 5Hp (3.9Kw) Three Phase Electric Motor
- Size / Weight (Mc only) : 1000x650 – 900 mm height. Weight: 550 Kgs

Materials and Finish

Tooling and Load Bearing Elements of Alloy Steel Toughened, Phosphate Finish
Panels Powder Coated, Structure Fabrication with Zinc Red-Oxide and Quality Paint Finish



TENTATIVE PLANT LAYOUT FOR 70/100T PRODUCTION IN TWO SHIFTS