

# GSW Press Automation, Inc.

1601 McKinley Road · PO Box 605 St Marys, Ohio 45885  
Ph: 419-394-5751 Fax: 419-394-8645

## Questionnaire Conventional Line

Company/Address

..... Phone .....  
..... Fax .....  
..... Ext. ....  
..... E-mail: .....

Customer no. (if known)

..... Responsible .....  
..... Mechanical Dept. ....  
..... Electrical Dept. ....  
..... Purchase Dept. ....

I am indicating **US** or **metric** measurements (please circle once here)

### General:

Material Width	max.	.....	"/mm	Thickness at full Width	.....
	min.	.....	"/mm	Thickness at Width min.	.....
Mat. Thickness	max.	.....	"/mm	Max. Cross-Section	.....
	min.	.....	"/mm	Min. Cross-Section	.....

Type of Mat. ....

Mat. Surface .....

Yield .....

Special Aspects .....

Machine direction left/right  right/left

Color: Standard (grey/blue)   
other .....

Type of Line

Short design:

compact  (Reel-Straightener-Feeder)  
super compact  (Cradle-Straightener-Feeder)

Long design:

Reel-Straightener-AirFeed-Shear  
 Reel-Straightener-RollFeed-Shear

Total Line consisting of:

- Line/mechanical Press/Shear
- Line/hydraulic Press/Shear
- Cut-To-Length-Line
- Slitting Line
- Slitting- and Cut-To-Length Line
- Roll Former with Pre-Stamping Bracket with Bolster
- Roll Former with Press
- Special Line (Please describe and give sketch)

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## Section I - Reel:

Outside Coil diameter largest ..... " / mm smallest ..... " / mm

Inside Coil diameter 16 - 20 "  20 - 24 "

Coil weight max. .... lbs / Kg

If hold down roll is needed -  
at which width is holding required? width = " / mm .....  
Cross Section: .....

Time to max. speed ..... sec

Press: ..... sec

Roll Form: ..... sec

## Reel Layout:

Drive  without  Auxilliary  start/stop

Variable Speed Drive

Loop  none  
 in front of Coil  
 behind Coil  
 under Coil

Loop Control  none  
 Initiator start/stop  
 Ultra Sonic variable speed drive  
 Lever Arm start/stop  
 Lever Arm variable speed drive

Coil guidance:  6 Keeper Arms  3 Keeper Arms  Back Plate  
Conical keeper arms:  1 pc.  2 pc.  3 pc.  
 1 Arm as adjustable catch

## Equipment:

Brakes:  manually controlled  electropneumatic fail safe  
 hydraulic

Expansion:  manually  hydraulic (beginning with type MH)

Hold down arm:  pneumatic  hydraulic  
 other roll width than standard (= 60 x 150 or 100 x 300 mm / 2.36 x 5.91 " or 3.94 x 11.81")?  
..... " / mm (possibly needed in case of very narrow material)  
 driven roll

Reel movable:  only for centering (on tracks with base frame)  with Coil Lift

Coil Car:   
Lifting Height:  300 mm / 11.81 " (Standard)  
 400 mm / 15.75 "  
 500 mm / 19.68 "

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## Section II - Snubber and Peeler:

- S & P with extending wedge   
only swiveling bridge   
for largest Coil diameter of ..... " / mm  
for smallest Coil diameter of ..... " / mm  
Standard wedge stroke: 11.81" (300 mm)   
  
Pre-Bending Roll   
Pre-Bending Roll driven   
(only for very thick material)

## Section IIIa - Straightener:

- Number of straightening rolls:  5  7  9  11  13  
Space for Loop approx. .... " / mm

### Equipment:

- Rollers  hard chrome  polyurethane  
 motorized adjustment  
 memory for Roller position  
  
Drive  start/stop  variable speed  
  
Stock Roller Guides  single adjustment  Entrance  Exit  
 central adjustment  Entrance  Exit  
  
Catenary rolls  Entrance  Exit

## Section IIIb - Straightener-Feeder:

- Height Adjustment: single, manually (4 spindles)   
central, manually   
central, motorized  Memory for motorized adjustment   
Height : + 3.94 " (100 mm)  5.91 " (150 mm)  7.87 " (200 mm)   
  
Catenary entrance   
Rollers hard chrome  polyurethane   
Measuring wheel   
Head opening hydraulic   
Pilot release  max. no. of spm .....
- Motorized adjustment straightening rollers   
Memory for mot. adj. straightening rollers   
  
Adj. contact pressure upper exit roll manually   
Adj. contact pressure upper exit roll via servo valve from control panel   
  
Feeding accuracy: .039" (1 mm)  .019" (.5 mm)  .0079" (.2 mm)   
.0059" (.15 mm)  .0039" (.1 mm)  .0019" (.05 mm)   
  
Free feeding angles:  90°  180°  240°  270°  
Time for feeding (hydraulic press) from ..... msec. to ..... msec.  
  
Number of strokes mechanical press: min. spm ..... at feeding length max. .... " / mm  
max. spm ..... at feeding length max. .... " / mm  
max. spm ..... at feeding length min. .... " / mm

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## Section IV - Roll Feed:

Height adjustment of Bracket:

- up to ..... " / mm
- only slotted hole
  - with adaptor plate and central screw
  - with adaptor plate and hydr. cylinder
  - with handpump
  - or with hydraulic power unit

- At large widths (from approx. .... " / mm:
- single stand with 4 spindles
  - with crank manually operated
  - with crank motorized
- Adjustment of height:    3.94 " (100 mm)  5.9" (150 mm)
- 7.87 " (200 mm)
- Memory for height adjustment

### Equipment:

- Measuring wheel
- Hydraulic lifting of upper roll
- Adjustment contact pressure via servo valve from control panel

Max. no. spm: .....

- Roller guides entrance:
- single adjustment
  - central adjustment
  - central/decentral adjustment

- Roller guides exit also
- Slim material guide at entrance
- Strip lubricator exit
- Strip guidance to tool by customer

I wish to discuss this

- Feeding Accuracy    .008 " (0.2 mm)  .006 " (0.15 mm)  .004 " (0.1 mm)  .002 " (0.05 mm)
- .04 " (1.0 mm)  .02 " (0.5 mm)

- Free feeding angle mechanical press:     90 °     180 °     210 °     240 °     270 °

Time for feeding (hydraulic press)    from ..... msec.    to ..... msec.

- Number of strokes mechanical press:
- min. spm ..... at feeding length max. ...." / mm
  - max. spm ..... at feeding length max. ...." / mm
  - max. spm ..... at feeding length min. ...." / mm

Other special features: .....

.....

.....

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**Feed Line and Single Machine - Electrical Control:**

System Voltage i.e.: 3 x 400 V / 3 x 500 V please state .....

Power Frequency i.e.: 50 Hz / 60 Hz please state .....

Separate Cabinet yes  no

Components: GSW Standard

Special components (Siemens, Allen Bradley...)

please state requirements and hand documents, if possible

Electrical Control: GSW Standard

Special Control (Siemens, Allen Bradley...)

please state requirements and hand documents, if possible

Functional Specification: yes  please hand

no

Contact interfacial clarification: for Electrics .....

for Mechanics .....

Control Cabinet: central  several

Operation from: Own Operation Unit

External Installation

Other special features: .....

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