

Cradle-Straightener-Feeder

CA/VR Series

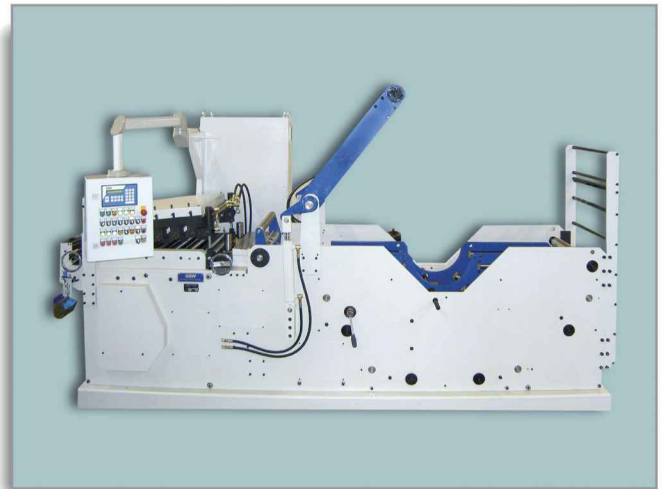
The ability to process even heaviest coil materials with maximum safety and convenience while using minimum floor-space

- self-centering of coils through continuously adjustable coil side guides
- wide-opening alligator type straightening head for easy threading
- from 5 to 21 individually adjustable straightening rollers to serve any demand on the quality of the straightening result
- clock-spring guard
- drive via three-phase servo motor; torque transmission simultaneously to all bottom straightening rollers, pinch rollers and cradle rollers

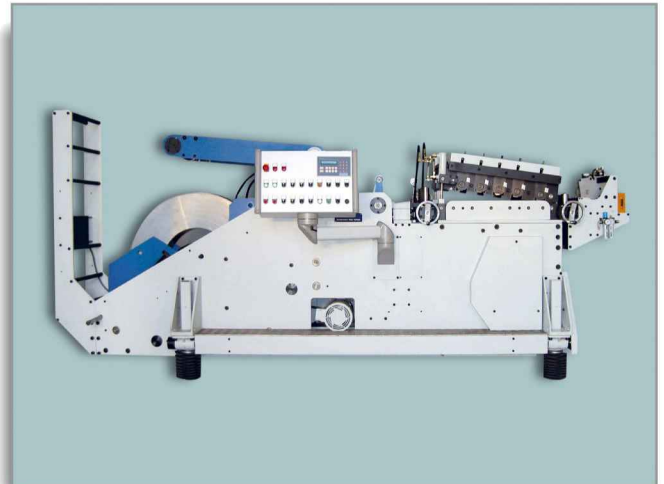
Optional Equipment CA/VR Series

- measuring wheel system for highest feeding accuracy and elimination of shortfeeds
- separate drive unit for cradle with ultrasonic loop control for higher feed rates and weights
- all-roll drive for straightening rollers
- hydraulic hold down arm (optional w powered end-wheel)
- hydraulic threading system with snubber and peeler (optional w powered snubber wheel)
- motorized coil guides
- motorized straightening rollers
- motorized central height adjustment
- hydraulic opening / closing of straightening head
- hydraulic pilote relase
- hard chromed rollers
- edge guides adjustable to center via hand-wheel (optional motorized)
- integrated strip-lubricating systems
- job-memory feature for all motorized functions
- swiveling control panel... etc.

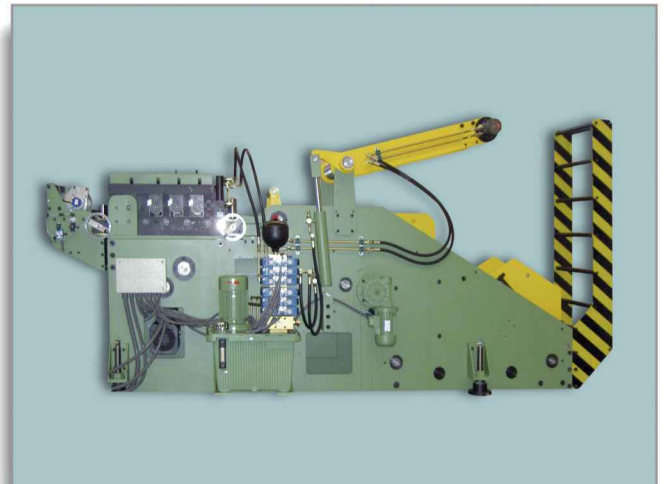
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650 mm wide machine CA650VR118/1600, with 11 straightening rollers and with convenient swiveling control. Moveable via overhead crane.



Almost fully equipped 320 mm wide CA320/VR98/1500 for over 1/4 inch materials. With dual drive system for faster feed rates and motorized height adjustment

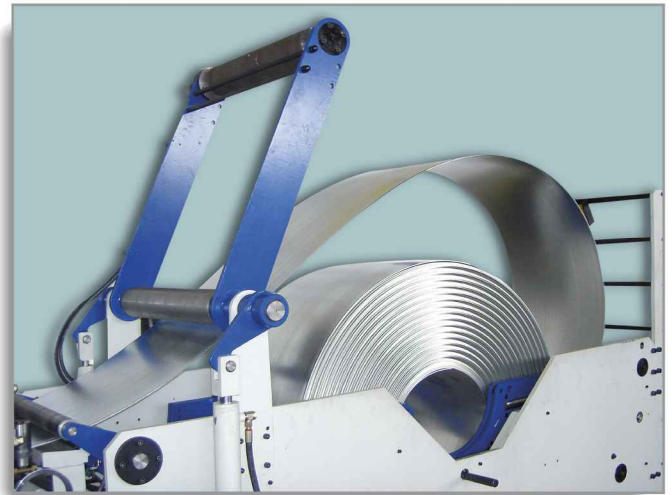


400 mm wide machine CA400/VR78 with powered hold down roller and central edge-guides

GSW Cradle-Straightener-Feeder - CA/VR Series



Coil strip entering the straightening unit. Detail on threading system with bending roller and peeler wedge



Loaded coil cradle with opened hold down arm. Loop sensor as part of the separate drive feature at top of clock spring guard.

The GSW Cradle-Straightener-Feeder Machine - a 3:1 feeding solution ideal for thick, high-strength coil materials

Data sheet CA/VR type Cradle-Straightener-Feeder machine for all roller diameters 40 / 60 / 80 / 100

Series	Material Width max		Material Thickness *		Cross-Section max *		Roller-Ø **		Coil Weight max ***	
	mm	approx. inch	mm	approx. inch	mm ²	approx. inch ²	mm	approx. inch	kg	approx. lbs
CA /VR 16/ ... 4	160	6.3	0.8 - 3.0	0.032 - 0.118	160 x 2.6	6.3 x 0.102	40	1.57	1,500	3,300
CA /VR 25/ ... 4	250	9.8	0.8 - 2.7	0.032 - 0.106	250 x 2.3	9.8 x 0.091	40	1.57	2,000	4,400
CA /VR 32/ ... 4	320	12.6	0.8 - 2.5	0.032 - 0.098	320 x 2.1	12.6 x 0.083	40	1.57	2,500	5,500
CA /VR 16/ ... 6	160	6.3	0.8 - 5.0	0.032 - 0.197	160 x 4.0	6.3 x 0.157	60	2.36	1,500	3,300
CA /VR 25/ ... 6	250	9.8	0.8 - 4.8	0.032 - 0.189	250 x 3.5	9.8 x 0.138	60	2.36	2,000	4,400
CA /VR 32/ ... 6	320	12.6	0.8 - 4.5	0.032 - 0.177	320 x 3.5	12.6 x 0.138	60	2.36	2,500	5,500
CA /VR 40/ ... 6	400	15.7	0.8 - 4.0	0.032 - 0.157	400 x 3.0	15.7 x 0.118	60	2.36	3,500	7,700
CA /VR 50/ ... 6	500	19.7	0.8 - 3.5	0.032 - 0.138	500 x 2.6	19.7 x 0.102	60	2.36	4,000	8,800
CA /VR 65/ ... 6	650	25.6	0.8 - 3.2	0.032 - 0.126	650 x 2.4	25.6 x 0.094	60	2.36	5,500	11,000
CA /VR 16/ ... 8	160	6.3	0.8 - 8.0	0.032 - 0.315	160 x 7.0	6.3 x 0.276	80	3.15	2,500	5,500
CA /VR 25/ ... 8	250	9.8	0.8 - 8.0	0.032 - 0.315	250 x 6.5	9.8 x 0.256	80	3.15	3,500	7,700
CA /VR 32/ ... 8	320	12.6	0.8 - 8.0	0.032 - 0.315	320 x 6.0	12.6 x 0.236	80	3.15	5,000	8,800
CA /VR 40/ ... 8	400	15.7	0.8 - 7.0	0.032 - 0.276	400 x 5.0	15.7 x 0.197	80	3.15	5,000	11,000
CA /VR 50/ ... 8	500	19.7	0.8 - 6.0	0.032 - 0.236	500 x 4.5	19.7 x 0.177	80	3.15	5,000	11,000
CA /VR 65/ ... 8	650	25.6	0.8 - 6.0	0.032 - 0.236	650 x 4.5	25.6 x 0.177	80	3.15	6,000	13,200
CA /VR 80/ ... 8	800	31.6	0.8 - 6.0	0.032 - 0.236	800 x 4.0	31.5 x 0.157	80	3.15	6,000	13,200
CA /VR 32/ ... 10	320	12.6	0.8 - 12.0	0.032 - 0.470	320 x 10.0	12.6 x 0.394	100	3.93	5,000	11,000
CA /VR 40/ ... 10	400	15.7	0.8 - 12.0	0.032 - 0.470	400 x 9.0	15.7 x 0.354	100	3.93	5,000	11,000
CA /VR 50/ ... 10	500	19.7	0.8 - 12.0	0.032 - 0.470	500 x 8.0	19.7 x 0.315	100	3.93	5,000	11,000
CA /VR 65/ ... 10	650	25.6	0.8 - 10.0	0.032 - 0.394	650 x 7.0	25.6 x 0.276	100	3.93	6,000	13,200
CA /VR 80/ ... 10	800	31.5	0.8 - 9.0	0.032 - 0.354	800 x 6.0	31.5 x 0.236	100	3.93	6,000	13,200

Available Coil OD mm (inch): 1,250 (49.2) / 1,400 (55.1) / 1,500 (59.0) / 1,600 (63.0) / 1,825 (72.0) / 2,000 (78.7)

Different widths and cross-sections on request * @ 400 N/mm² (58 KSI) yield strength

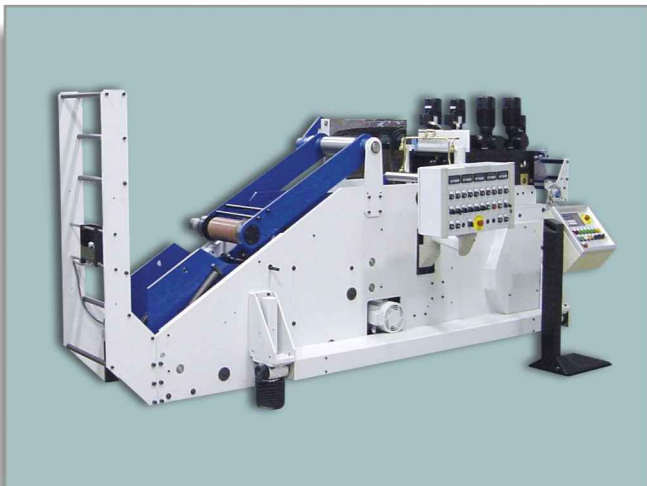
** Number of straightening rollers 5 / 7 / 9 / 11 / ... / 21 upon customer choice *** Different coil weights on request



3:1 Line with 11 straightening rollers for excellent straightening results. With special frame for pickup of complete line via fork lift or crane



Detailed view of a large cradle (for max 6,000 kg) with hold down arm, as part of a 700 mm wide System



Heavy 320 mm wide machine with motorized straightening rollers w job memory function and mot. height adjustment. Operator interface on swing away panel to allow watching the press / die during threading

3:1 Feeding Systems

Cradle-Straightener-Feeder

Common Applications:

- feeding solution for extremely tight floor spaces
- safe and fast handling of even toughest materials
- processing of less surface-critical materials
- usage with multiple presses as complete line is movable

Typical Configuration:

- fully enclosed Coil Cradle with coverage of approx. 2/3 of full-size coil
- cradle indirectly driven via chain drive powered from Straightener-Feeder
- hydraulic threading system for hands-free processing
- combination Straightener-Feeder unit to pull & feed coil strip

Additions & Expansions:

- separate drive with loop control or second servo drive system (for thick materials) for coil cradle to allow faster processing at longer feed progressions
- peripheral guarding with electrical interlock
- special frame design for moving of complete machine via crane or fork lift
- various hydraulic and motorized features and components to enhance capacities and level of automation

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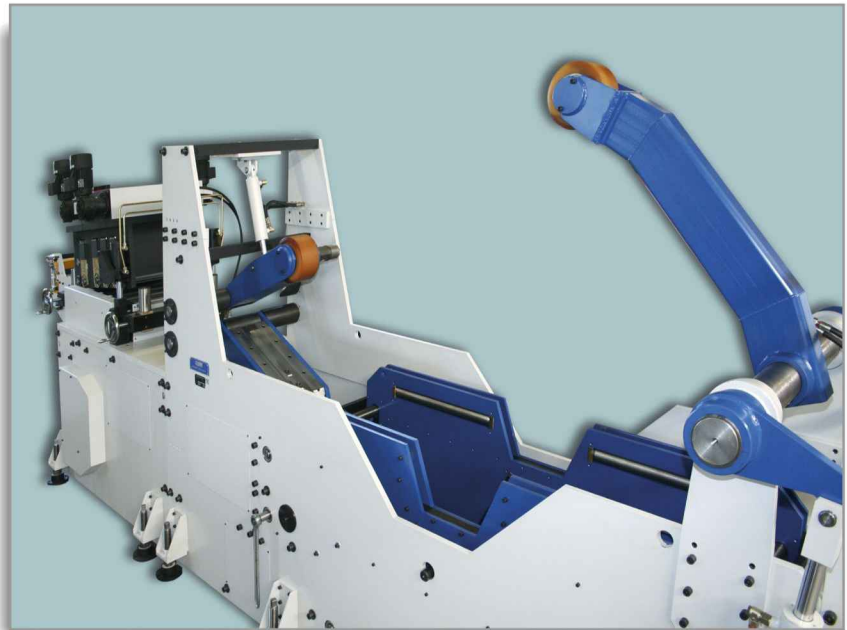
Safe and fast handling of heavy coil materials with minimal use of floor space

Machine Example:

- 500 mm max width
- 14 mm max thickness
- 500 x 13 mm max cross-section
- 1,825 mm max coil OD
- 8,000 kg max coil weight
- Feed rate = 30 SPM @ 150 mm progression

Design & Equipment:

- 7 straightening rollers (3 over 4) and 2 feed rollers with 100 mm diameter
- double back-up top and bottom
- motorized roller adjustment
- hydraulic opening/closing of straightening head
- hydraulic piloting function
- closed loop measuring wheel system
- sandwich style coil side plates
- heavy-duty hydraulic hold down arm with powered end wheel
- heavy-duty hydraulic threading system
- central edge guides with hand crank
- gap between threading system and straightener for install of welding station at customer site
- heavy-duty roller lubricator with pneumatic adjustment



GSW Specialist in Heavy Compact Feeding

Final Auto-CAD layout of above described Cradle-Straightener-Feeder 3:1 Coil Feeding System

