



# Roll Forming Services

Roll Forming Equipment , Engineering & Consulting

*From Dedicated lines, to quick changeover production lines, complete with all of the latest features., including custom electronics, servo drives, in-line secondary processes, etc...*

Roll Forming Lines  
Roll Forming Tooling  
Robotics and Packaging  
Coil Handling Equipment  
Uncoilers, Coil Cars  
Flatteners, Servo Feeders  
Pre-piercing Systems  
Hydraulic Presses  
Cut-off Dies and Presses  
Servo Die Accelerators  
In-line Curving and Welding  
In-Line Embossing, Louvering  
In-Line Quality Control



- Universal
- Rafted
- Duplex
- Triplex
- Cantilevered
- Pre-cut
- Post-cut
- Stop & Go
- Flying
- Just-in-Time
- On-Demand

Complete Roll Forming Lines

info@rollformingservices.com    www.rollformingservices.com  
Tel: (905) 831-4045    Fax: (866) 722-2296

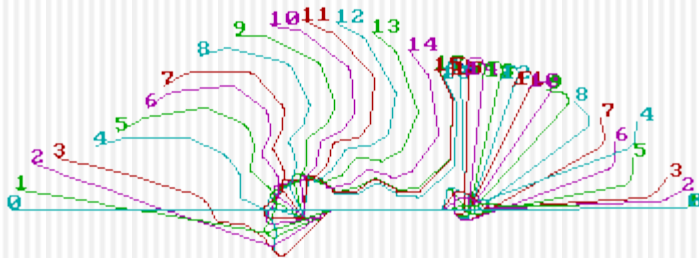
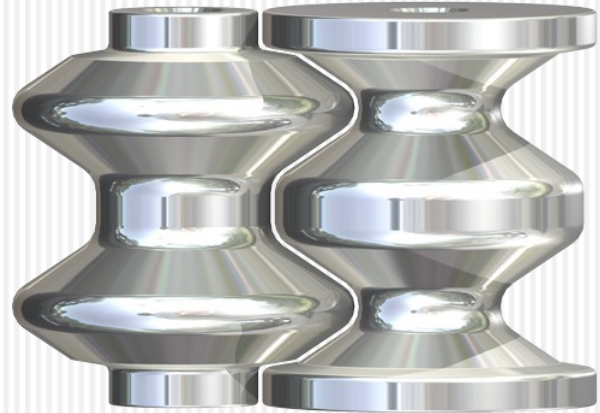


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Roll Forming Equipment , Engineering & Consulting

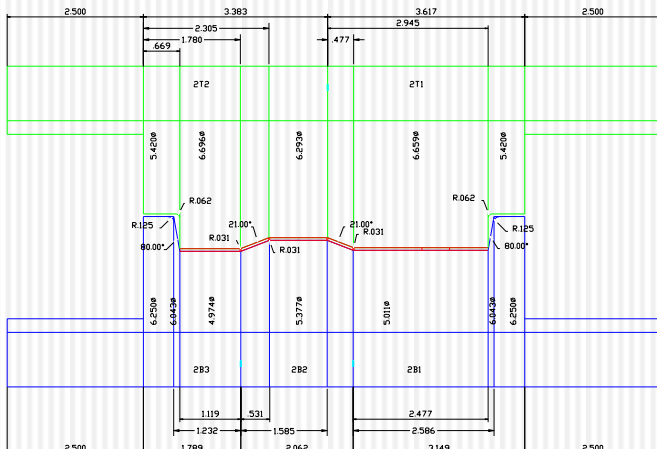
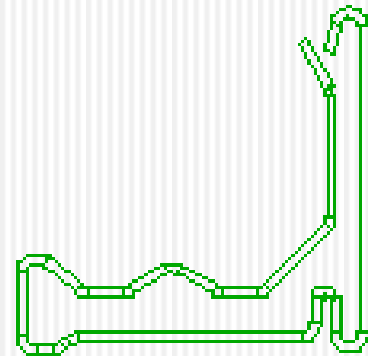
*Every tool is Computer designed as part of a complete system. We use the highest quality Tool Steel and Vacuum heat treat it for long tool life.*

*Each set of tools is tested to ensure the highest quality standards.*



*Our expertise covers almost any industry and profile:*

- Automotive:** bumpers, impact beams, trims, radiators
- Construction:** stud, track, siding, roofing, decking
- Appliance:** refrigerator & microwave boxes
- Doors:** garage, steel entry, residential, custom
- Shelving & Storage:** shelves, storage beams, up-rights
- Furniture:** partition components, curtain rails, ceilings
- Metal Framing:** house and industrial framing



Roll Forming Tooling

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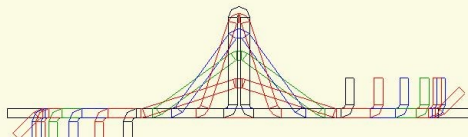


# Roll Forming Services

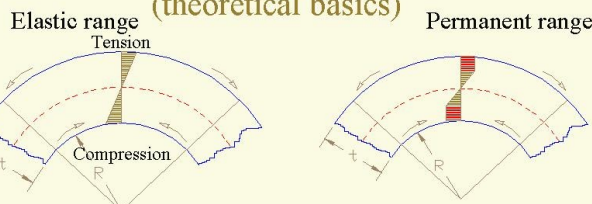
Roll Forming Equipment , Engineering & Consulting

RFS Offers complete in-house or off-site roll forming training. These custom tailored courses can be geared to every level of interest and need. Every person involved with Roll Forming, from entry level operator to engineer, purchasing manager through to seasoned set-up man will benefit from the information offered in these training sessions.

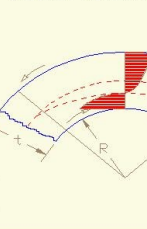
## Establishing the Driving Diameter



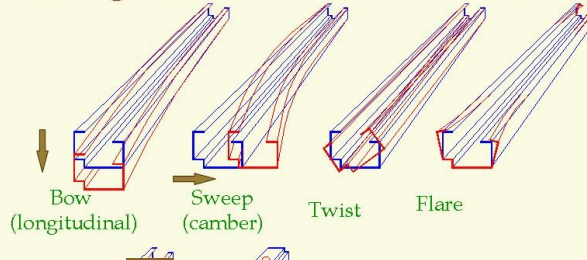
## Bending (theoretical basics)



Actual stress c



## Straightness and Flatness Tolerances



Wavy edges

Classroom and **hands-on** training at your plant. Training incorporates roll forming concepts, equipment, tooling, roll installation, material, set-up, troubleshooting, safety, maintenance and other subjects.

### Roll Design Courses

Troubleshooting and Tooling Set-Up  
Principles of Roll Forming  
Product Design for Manufacturability  
Equipment, Material, Tooling Selection

## Roll Forming - definition

- Bending a **flat** metal strip in the longitudinal direction
- By pairs of **contoured rolls**
- Changing the shape **gradually** from flat to the finished section
- Without changing the **thickness**
- At **room** temperature

Roll Forming Training Courses

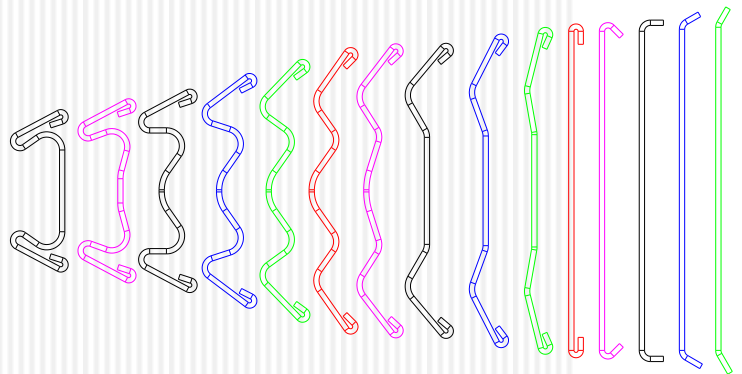
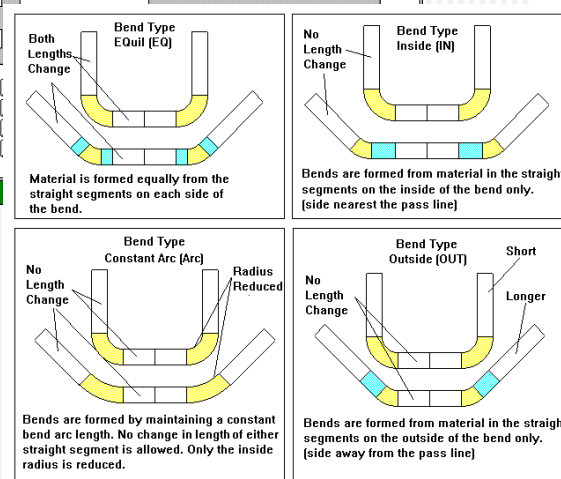
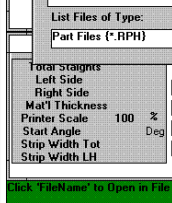
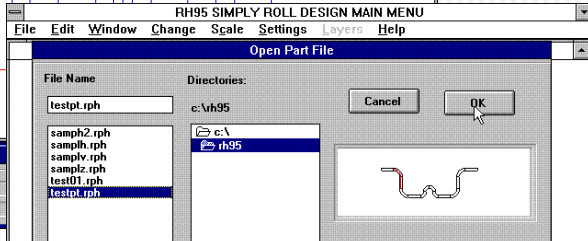
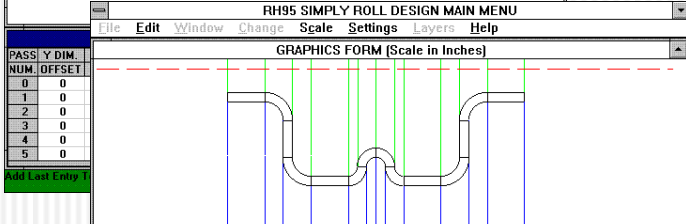
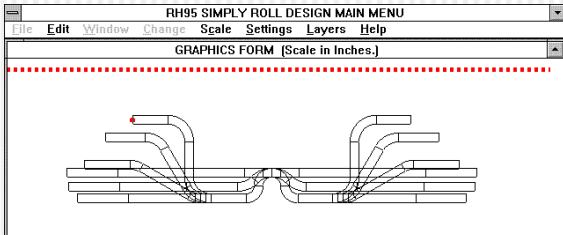
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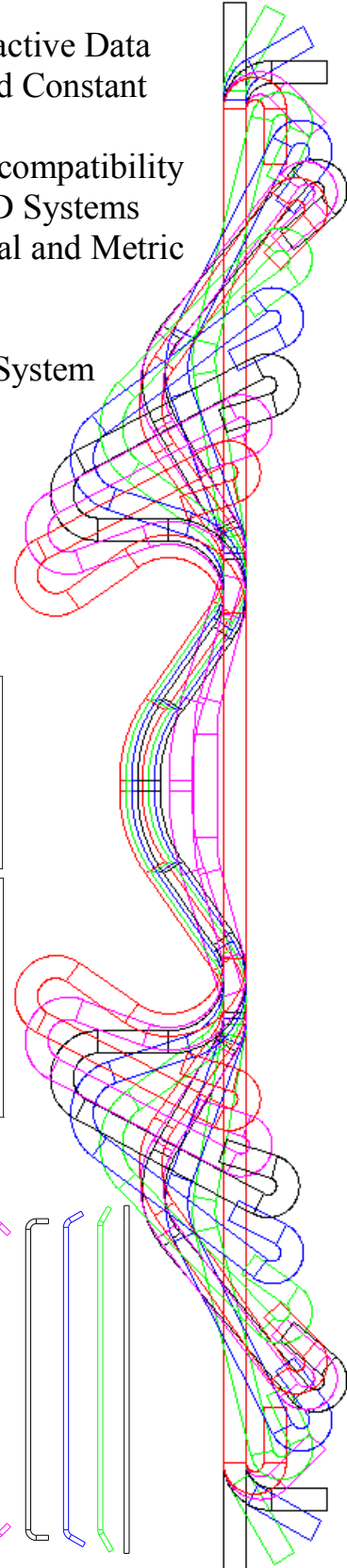


# Roll Forming Services

Roll Forming Equipment , Engineering & Consulting



- Ease of Use
- On Screen Interactive Data
- Constant Arc and Constant Radius design
- DXF output for compatibility with major CAD Systems
- Supports Imperial and Metric Systems
- Windows Based
- Complete Help System



- Change Gauges, Sizes, Angles, Mill Ratio, Number of passes, etc.. at any time during design
- Change Pass Line Diameters
- Calculates Material Edge Stretch
- Designs Side Rolls

'SIMPLY' Roll Design Software

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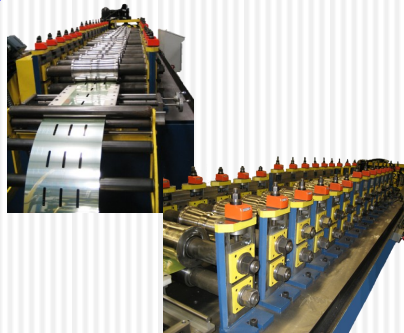
Roll Forming Equipment , Engineering & Consulting

Our expertise in roll forming design and manufacturing covers almost any industry and type of profile

- **Automotive:** bumpers, impact beams, trims, radiator
- **Construction:** studs, tracks., sidings, roofing, scaffolding, decking, window components, garage doors, fences, etc...
- **Appliance:** refrigerators, microwaves, etc... enclosures
- **Shelving & Storage:** shelves, storage beams, up-rights, cross members
- **Furniture:** partition components, curtain rails, ceilings
- **Metal Framing:** house and industrial framing
- **Lighting:** luminescent reflectors
- **Highway safety:** guardrails, sign posts

## Roll Forming Machines

- Universal
- Rafted
- Duplex
- Triplex
- Cantilevered
- Pre-cut
- Post-cut
- Stop & Go
- Flying
- Just-in-Time
- On-Demand



*Luminescent reflector  
Roll Forming Line*

*Roof truss Roll Former*

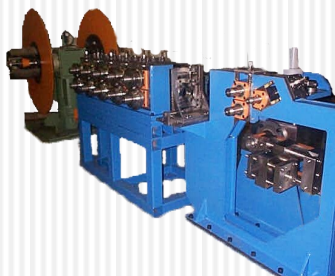


*HVAC panel Roll Former*



*Floor decking line*

*Roll Forming Line with  
in-line curving*



*Welded Storage step  
beam line*

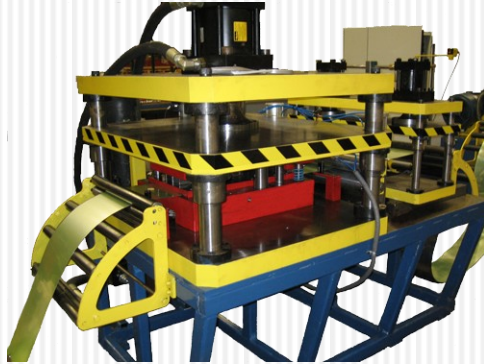
Roll Forming by Industry

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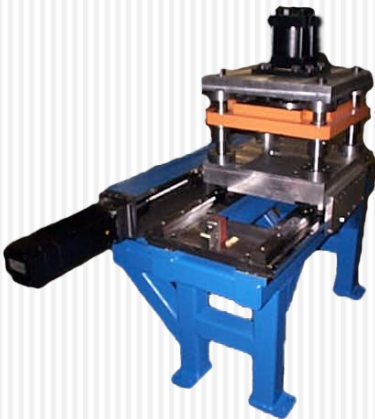
# Roll Forming Services

Roll Forming Equipment , Engineering & Consulting



## Dedicated Roll Forming Presses and Shears

- Pre-piercing and cut-off
- Hydraulic, pneumatic or air-over-oil powered
- Compacted designs mounted on linear bearings
- Equipped with precision servo die accelerators
- Dedicated mid punching and in-line punching fixtures



## Dies

- Flying Pre-piercing dies
- Flying Cut-Off Dies
- Cut-Off Saws
- Rotary Dies
- Louvering Dies

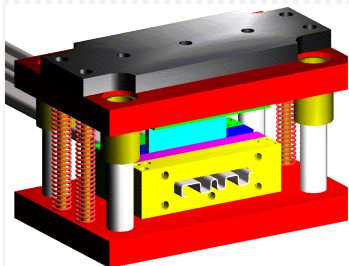


- Servo Die Accelerators
- Pick-Up Systems
- Servo, Pneumatic or Hydraulic
- Dies to fit your existing press
- Air-over-oil powered dies
- Dedicated Die/Press Systems
- Self Powered Dies

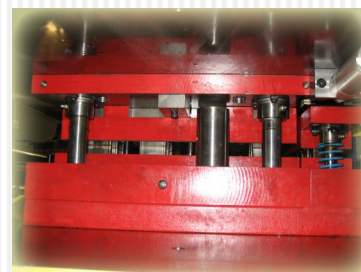


## Precision Rotary Dies

3D Design



Reality



Every Die is **designed in 3D** solid modeling for interference checks and error prevention

Roll Forming Presses and Dies

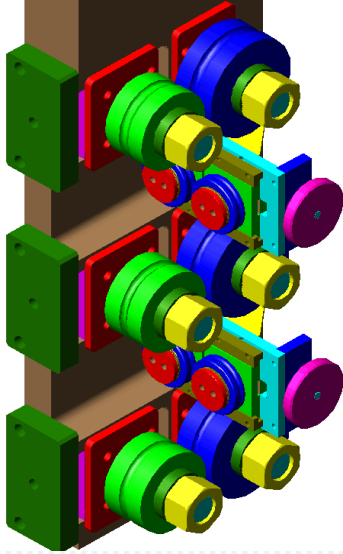
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Vertical arrangement for Gravity-dependant products



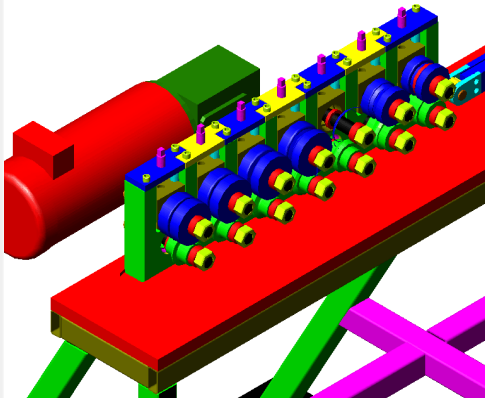
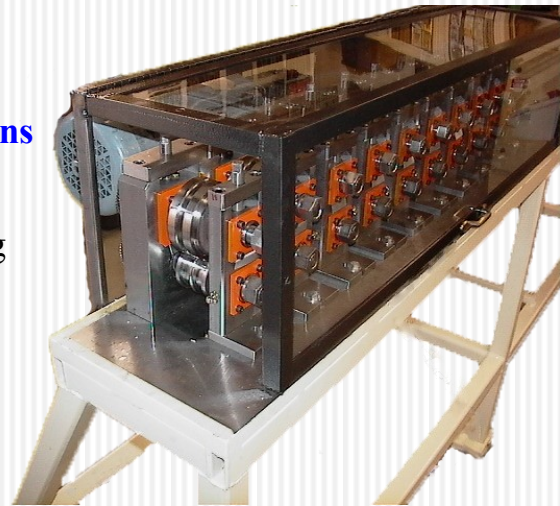
- Tube Forming Micro Lines
- Tube diameter .020"
- In-line diameter reduction
- Introducing filler agents in-line
- In-line Laser tube welding

*Our Micro Production Lines are dedicated Roll Forming Systems, which are capable of handling delicate materials with very high speed and precision. Every feature available on our regular lines can be applied to these cost effective Micro Lines. They are capable of processing exotic metals as thin as .002" within precise tolerances.*

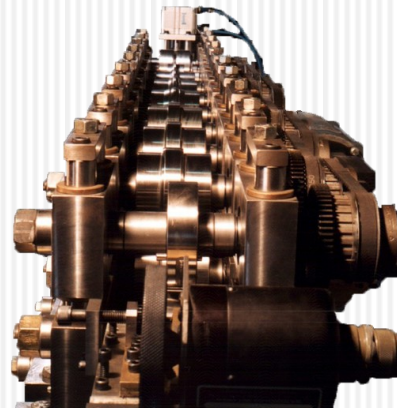
- Special purpose machines for roll forming **thin and extra thin materials**
- Material thickness **down to .002"**
- Forming exotic materials: **Lead, Beryllium, Cooper, Zirconium**
- Tube Formers for .020" diameter tubes

## Typical Applications

- Metal Tear Strips
- Computer shielding
- Mirror frames



Modular designs that can be assembled to run in:  
**Pre-cut & Post-Cut**  
modes of operation:



Micro Production Lines

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