

ACE Group

WHEEL- and Rim Line



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For wheels Dimensions	12" – 14"
Width	3,5" – 7"
Min. diameter	265 mm
Max. diameter	470 mm
Output approx.	5.000 wheels per shift

1 A: Decoiler

1 Single Arm Decoiler, Opener and Feeder and Straightener

Manufacturer	PULCH
Control	PLC SIEMENS S 7
Coil car	
Load	14 ton

Single arm Decoiler and Opener PULCH AFHA 15/500, S/N 1000-1182

Coil Diameter	1500 mm
Max. Coil Width	200 – 500 mm
Plate Thickness Max.	2,0 – 6,0 mm
Max. Coil Load	14 ton

Straightening Machine – Crop shear BVRM 13-90-500, S/N 1000-1182

No. of Straightening Rolls	13
Strip Width	200 - 600 mm
Strip Thickness Max.	2 -6 mm
Speed	0 – 85 m/s

1 B: Bowl forming

2000Ton 7 Station Die Press

Manufacturer	SCHULER
Model	PSt – 2000/7/600
Year of Manufacture	2000
Control	PLC SIEMENS S 7

Total Capacity	2000 ton
No. of working stations	7
Speed	9 – 18 SPM
Draw Depth Max.	120 mm
Cutting Ram Capacity	250 ton
Main Ram with 5 Stations total Capacity	1200 ton
Sizing Station Capacity	500 ton

Max. Capacity in:	Station 2	200 ton
	Station 3	500 ton
	Station 4	500 ton
	Station 5	200 ton
	Station 6	200 ton

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Pneumatic Die cushion in Table:	
Capacity	22 ton
Stroke	120 mm
Stroke:	
Cutting Ram	
Sizing Ram	
Adjustment:	
Cutting Ram	20 mm
Tool Holder	60 mm
Bed Size approx.	3400 x 1000 mm
Bed size Sizing station approx.	1000 x 1000 mm
Bed Cutting station approx.	900 x 1000 mm
Windows in columns	1400 mm
Die Height	850 - 1015 mm
Distance Transport Rail	400- 550- 700 mm
Opening Transport Grabs	125 mm
Main Motor	170 kW
With:	Chip Conveyor BUERENER MASCHINENFABRIK

1 C: Bowl Calibration, Deburring

Various Transport Conveyors, Cleaning and Drying, Control and Test Station

CLAYS Horizontal Bowl Calibration Press

Press type	FO 2100
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2: Wheel Ring Bending, Welding and Rim Profiling

(1) WEAN DAMIRAY-SIEMAG Decoiler

Width max. approx.	350 mm
Straightener	5 rolls
Roll Bending Machine	3

(1) EXPERT 6 arm round table with:

2 WEAN DAMIRAY Ring Welding Machines

3 Stations for different work on the Rings

(3) WEAN DAMIRAY Profiling Rolling Stands for Rims

(1) WEAN DAMIRAY Horizontal Toggle Joint Press for Calibration Rim

3: Assembling Bowl and Rim, Welding and Calibration

OTTENSER EISENWERKE and SCIAKY Bowl and Rim Grouting Press and Point Spot Welding Stations

Spot Welding Machine for Repair after Control

(2) Ram Hydraulic Test Press for Wheels

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4: Cleaning, Phosphating, Painting

DUERR Cleaning and Degreasing Line, length approx. 20 m with AWARE control

DUERR Phosphating Line, with Washing and Passivating

DUERR Phosphate Tank

ASLTOM GEC Air Industrie System Dryer

DUERR Electro Static Coating Cabine

E-Cot Tank HEEBERTS SKM 64J42-A ½, 39 m³ for AQUA EC 1000 ATL black

CFC - Transport Chain for the entire Cleaning and Coating Plant

5: Packing

Various Power-Driven Conveyors for Rims

(2) Hoists

(2) KUKA Robots KR 2 125-2 for Handling and Packing

CYKLOP Band Packing Machine

DORST Foil Palletizer

TOLEDO Balance, Table 2500 x 1500 mm, max. 5000 kg

Pallet Conveyors with Sensors

Production: Ring – Rim

W7-211	Decoiler
W7-212	Straightener
W7-213	Cropping Shear
W4-214	Blank Transport, Feed and Bending
FK 12264	6 station Round Table with 5 Working Places for Welding, Punching etc, W1-221 and W1-222 Ring Spot Welding, W4- 223, 224, 225
W3-229	Various Conveyors

Production: Bowl

W5-200	2000 ton 7-Station Die Press with Decoiler and Straightener
W3-295, W44-270, 272, 273	Various Conveyors
W6-203	CLAYS Horizontal Calibration Press for Bowls
W7-231, 232, 233	3 Profiling Stands
W7-235	Horizontal Calibration Press for Profiled Rims
W3-274	Various Conveyors
C5-950	Cleaner and Dryer for Bowls
FK 15660	Various Test and Working Stations
W4-270, 271, 272, 273	6- station Turn Table with 5 Working Stations
W3-295, 297, 236, 237	Various Conveyors
W4-259	Pressing Station for Bowl and Rim
W3-259	Run-Out Conveyor
W6-164	Testing Press with 2 Rams
W1-500	Welding Machine for Repair etc.