



*Schlebach*

Quadro and  
Associated Panel Machines

## The smart, all-round profile shaping system

Swivelling cartridges each with 10 roller stations ensure rapid retooling times. The Quadro is equipped with a touch-panel controlled PLC and an electric cross cut shear to process given lengths and quantities automatically.



Very short retooling times by swivelling or replacing the exchangeable cartridges.



Exchangeable cartridges with 10 roller stations may be swivelled:

- Standing seam profiles with and without Clip-Relief  
Profile heights of 25+ 32 + 38 mm
- SNAP-folded profile with and without Clip-Relief  
Profile heights of 25 and 38 mm
- NAIL Strip system for profile heights of 25 and 38 mm
- U - profile with a turn-up height of up to 38 mm



Exchangeable cartridges with 12 roller stations , can not be swivelled:

- Soffit Panel
- Stepped tile panel
- 44,5 mm snap-profile

Exchangeable cartridges with 10 roller stations , can not be swivelled:

- 50 mm standing seam profile
- 50 mm folded profile with clip-relief

### Technical Data

Strip run-in width:	from 300 mm to 800 mm
Gauges:	non-ferrous metals , 0,6 mm-0,8 mm
Sheet steel:	0,5 mm - 0,7 mm
Stainless steel:	0,4 mm - 0,5 mm
Dimensions:	L x W x H 3,120 x 1,720 x 1,250 mm
Weight:	app. 1.260 kg
Feed rate:	14 m/min.
Drive:	2,2 kw, 400 volt, 3-ph

### Available Accessories

- Seam rolling system
- 50 mm standing seam profile set of header rollers for concave plates from 3 m
- 50 mm folded profile radius for 25 mm standing seam profiles with Clip-Relief
- Slitting for locating panels
- Exchangeable cartridge with 10 or 12 roller stations for special profiles
- Decoiler AH 1250A1
- Decoiler AH 1250K5

\*Please ask for our special Quadro brochure for more detailed information

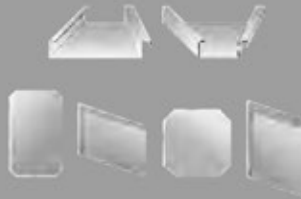
## Notching Unit

### Profile shaping system QUADRO-KS

The profile shaping system QUADRO-KS has all the features of the QUADRO system. The Unit Uses the same cartridges to produce the desired profiles. This system is equipped with a slit for longitudinal cuts. The adjustable side of the machine can be set to the angle required for Slanted panels or Standing seam sheets. The required angle is calculated by means of the touch-panel. For this purpose the 3 dimensions of the plate are required, i.e. narrow - wide - long. Irrespective of the form of the profile, a single operation feeds the strip, cuts it obliquely and shapes the profile.



Possible Shapes



Quadro roof profiles with profiled surface. A special profile shaping system in combination with the QUADRO can produce different forms of surface profiling to stabilise the surfaces for increased rafter distances.



### Notching unit AK-QUAD

Electro hydraulic operation, for mounting on the QUADRO profile shaping machine. The notching unit is installed in front of the QUADRO profile shaping machine. The notching operation is programmed into the controller of the profile shaping System and included in the production process. Tool Supports are mounted on a flanged Unit with a hydraulic Subassembly that is connected to the QUADRO controller. The basic configuration contains a tool set to notch Soffit panels (reveal panels). Tool sets are available and may be exchanged for other, specified forms and profiles. Tool sets can be produced in accordance with customer requirements. For special notching processes the AK-QUAD can also be operated as a Stand-alone notching machine. With the appropriate tool sets, applications range from rhombuses, shingles or coffered roof slabs.

Max, notching size:	50 x 100 mm	Stainless steel:	up to 0.5 mm
Non-ferrous metal	up to 1.0 mm	Dimensions:	L X W X H 1,120 x 1,670 x 1,300 mm
Sheet Steel:	up to 0.8 mm	Electrical connections:	400 Volt, 50 Hz

### Oblique cutting machine

The STA is mounted in the out-feed area of the QUADRO. Profiled strips that were previously notched by an AKQUAD in the profile area may be cut at angles ranging from -60° to +60° When the profiled and notched strip reaches the programmed final position, the table is manually tilted to the respective angle and the profiled Strip is clamped by means of the manually operated hold-down. Next the strip is cut with a manually operated roller shear.

Ferrous metals:	< 400 N/mm <sup>2</sup> 0,5-0,7	Dimensions:	L X W X H 1,700 X 2,100 X 1,300 mm
Non-ferrous metals:	< 400 N/mm <sup>2</sup> 0,6-0,8	Weight:	app. 285 kg (STA) app. 315 kg (STA-M)
Stainless Steel:	< 700 N/mm <sup>2</sup> 0,4-0,5		

### Oblique cutting machine STA-M

Same construction as the basic machine STA, however, this is equipped with a motorised roller shear.

### Oblique cutting machine STA-MS

Same construction as the basic machine STA, however, this is equipped with a motorised roller shear and a fully automatic pivoting device.

## Round arch moulding machine

To produce arched profile panels from double standing seam profiles for Use as dormers, round arches, domes, barrel-vault roofs, etc. for adjustable radii, starting from a radius of 300 mm, depending on material. Equipped with an infinitely variable speed controller for 0 - 12 m/min this may be used to produce a variety of radii. Separately powered bending units for upper and the lower folds. This may be used to control the operating Speed. Leading plates with 2 Underfolds can be shaped in a single operation. The infinitely variable width adjustment ranging from 300 - 800 mm is geared to match the manufacturing capabilities of the standing seam profiles produced by the MiniProf, SPM 30/80, PMC and Quadro.



### Technical Data

Adjustment range:	Axial dimensions 300 – 810 mm
Smallest radii:	Non-ferrous metals from a radius of 300 mm
Sheet Steel:	from a radius of 1,500 mm
Stainless Steel:	from a radius of 1.500 mm
Gauges:	Non-ferrous metals up to 0.8 mm
Sheet Steel:	up to 0.7 mm
Stainless Steel:	up to 0.5 mm
Operating speed:	Infinitely adjustable from 0 - 12 m/min
Dimensions:	L X W X H 1,000 x 1,000 x 1,700 mm
Weight:	230 kg
Drive:	2 x 0,55 kW, 230 Volt, 1-ph

#### Versions:

RBM32 for a profile height of 32 mm  
 RBM 25/32 for a profile height of 25 und 32 mm  
 RBM 25/38 for a profile height of 25 und 38 mm  
 RBM 32/38 for a profile height of 32 und 38 mm



The RBM may also be used for other profile heights of 25 - 40 mm by replacing pressure rollers.

## Round arch shaping machine

The round arch moulding machine RBM 50 is used to shape profile panels from double standing seam profile material with a profile height of 50-mm. Applications include dormers, round arcs, domes or barrel-vault roofs. A table provides the respective contact pressure, depending on the radius, and it is entered via the operating panel. Motors generate the selected pressure. The feed speed is adjusted by means of a speed regulator. Separately powered bending units for Upper and the lower folds. Differently shaped profiles are available by exchanging rollers.



## Technical Data

Adjustment range:	Axial dimensions 330 – 660 mm
Smallest radii:	Non-ferrous metals from a radius of 300 mm
Sheet Steel:	from a radius of 5,000 mm
Stainless Steel:	from a radius of 5.000 mm
Gauges:	Non-ferrous metals up to 0.8 mm
Sheet Steel:	up to 0.7 mm
Stainless Steel:	up to 0.5 mm
Operating speed:	Infinitely adjustable from 0 - 12 m/min
Dimensions:	L X W X H 1,000 x 1,000 x 1,930 mm
Weight:	870 kg
Drive:	1 x 0,75 kW, 230 Volt, 1-ph. 2 x 0.37 kW, 230 Volt, 1-ph.

### Versions:

RBM 50/38 for profile heights of 50 and 38 mm



Possible shapes