



KS-1622

SPECIFICATIONS

Effective: 03/01/10

Stud and Track Roll Forming Machine and Accessories

Profile Specifications

- **Profile Sizes:**
 - Studs:
 - Web: 3.50, 4.00, 5.50, 6.00, and 8.00-in
 - Flange: 1.625, 2.00 and 2.50-in
 - Lip: up to 0.75-in
 - Track:
 - Web: 3.58, 4.08, 5.58, 6.08, and 8.08-in
 - Flange: 2.50-in Maximum
 - Lip: N/A
- **Profile Dimensions:** Refer to Knudson Engineering Data or Knudson Profile Drawing for details
- **Material Types:** Steel: Galvanized, Painted, Pre-Finished, or Bare
- **Material Thickness:** Steel: 0.021 to 0.060-in/ 22-16ga
- **Material Strength:** Steel: Max Tensile Strength = 52-ksi
Max Yield Strength = 48-ksi
- **Material Strip Width:**
 - Minimum: 7.25-in
 - Maximum: 12.75-in

Machine Specifications

- **Mechanical Systems**
 - **Dimensions:**
 - Length: 166.00-in (4220-mm)
 - Width: 32.00-in (820-mm)
 - Height: 50.00-in (1270-mm)
 - Weight: 4000-lbs (1820-kg)
 - **Production Speed:** 75-ft/min Nominal Throughput (+/- 2-ft/min)
 - **Roll-Forming:** Ten (10) Powered Roll-Forming Station
 - **Drive Train:**
 - Power Source: Electric Motor/Hydraulic Pump
 - Power Take-Off: Hydraulic Actuators: hydraulic Motor and Cylinder(s)
 - Drive/Forming Rollers: Gear/Sprocket/Roller Chain Drive
 - Main Drive Speed: 61 rpm @ 3.75-in Drive Diameter
 - **Shear Assembly:** Hydraulic Cylinder Actuated
Exit-End Mounted
 - **Coil Handling Equip.:**
 - Spool: 13.25-in wide, 20-in ID, and 5,000-lbs max (optional)
 - Spool Stand: Traveling – 5,000-lbs max (optional)
 - **Noise Emissions:** Equivalent continuous A-weighted sound pressure level = less than 70 dB (A)



KS-1420

SPECIFICATIONS

Effective: 03/01/10

Stud and Track Roll Forming Machine and Accessories

➤ **Electrical Systems**

- **Electrical Power:**
 - Line Voltage = 230 VAC (+/- 10%)
 - Line Current = 40 Amps recommended
 - Line Frequency = 60 Hz (+/- 1%)
 - Line Phase = three phase (3 Ph)
 - Full Load Current = 20.8 Amps (230 VAC)
 - Electrical Drawing = See drawing provided by AMS included with documents

- **Control System:**
 - Digital Batch Controller, Operational Interface
 - Jog Forward, Reverse Selector Switch
 - Shear Manual Pushbutton
 - Punch Manual Pushbutton

- **Safety Features:**
 - E-Stop Switch (2)
 - Safety Circuit
 - Covers: Lids, Sides

➤ **Operational Environment**

- **Ambient Air Temperature:** +41 to +131-degree Fahrenheit (+5 to +55-degree Celsius)
Up to 24 hours at +122-degrees Fahrenheit (+50-degrees Celsius)
- **Humidity Range:** No Restrictions
- **Altitude Range:** No Restrictions
- **Vibration Shock and Bump:** Minimal vehicular transport on maintained roads
Off-road transportation not recommended
- **Transportation and Storage:** -13 to +131-degrees Fahrenheit (-25 to +55-degrees Celsius)
Up to 24 hours at +158-degree Fahrenheit (+70-degree Celsius)
- **Explosive Atmosphere:** Should not be operated in any kind of explosive atmosphere