

COIL TECHNOLOGY  
FOR PROFESSIONALS.

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**FORSTNER**





## Coil Technology

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Forstner has been manufacturing machines for of coils since 1960. ning, ease of handling



developing and manu- professional processing From the very begin- coils and long-term

return in the investment of our systems has been the prime objectives of all development work. The results are perfected, field-proven products in reliable designs ensuring an extended operating life.

Since the mid-eighties, Renato Romagna has been managing Forstner. This high quality company, already well established when Mr. Romagna took over, has since then markedly increased its activities. Additional know-how in the area of mechanical engineering and years of experience particularly in sheet metal processing enterprises in the construction trade have given the company and its products new impetus.

Today, Forstner machines are found on all continents. A dense network of independent representatives ensure the customer optimum support both throughout Europe, North America and in many other locations around the world.

Professional assembly, prompt service and careful maintenance are performances our customer can expect at any time.

Ing. Renato Romagna





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## Cut-to-length lines

### A manually operated or electrically powered shearing system

#### „Custom tailoring“

The ALM cut-to-length lines cut blanks to precise length simply and effortlessly, saving time and valuable material. You tell the system what to do and how to do it. Start with the basic and add the shear and control as it becomes necessary and cost-effective.

#### The ALM-AL m manual shear

for manual shearing with the popular AL m circular shear (page 29).

#### The ALM-AL e electric shear

for power shearing with the popular AL e circular shear (page 30).

#### The ALM-TS electric guillotine

for fast, precise and smooth-edged blanks in large-quantity jobs (page 30).



The right control will make your investment pay off in terms. You can select from:

#### The MV-Forstner electromechanical length gauge

an easy-to-use component for simple measurements to a precision of  $\pm 20,0$  mm per 2000 mm of length (page 35).

#### The MP-Forstner microprocessor control

for pre-programmed length measurement of any desired number of blanks in any sequence to a precision of  $\pm 1,0$  mm per 2000 mm of length (page 35).

#### The PLC with „all the extras“

for fully automated control plus special functions to a precision of  $\pm 0,5$  mm per 2000 mm of length (page 36).

#### The pivoting ALM-TS for oblique cutting

a special version of the ALM-TS shearing machine for cutting at angles up to  $\pm 60^\circ$ . The guillotine is mounted on a turntable and can be pivoted manually or mechanically to any desired angle.



#### ALM-AL 1250 e electric cut-to-length line

MP-Forstner microprocessor control

ARG-BO deroller 300/1,25

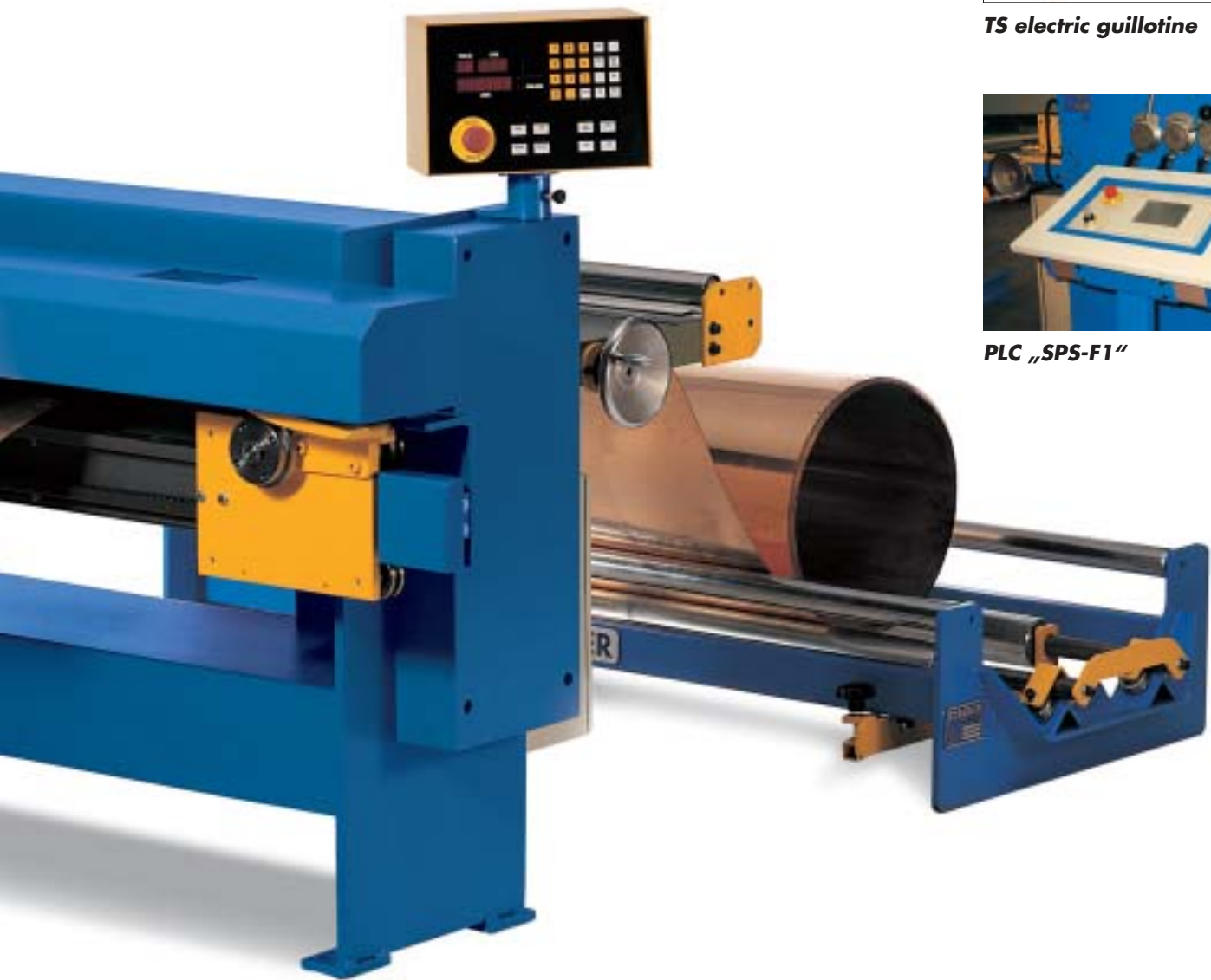
#### Features

- infeed table with one fixed and one adjustable edge guide
- powered 70-mm diameter feed-cylinder set
- AL m manual shear or AL e electric shear or TS electric guillotine
- two-stage three-phase drive

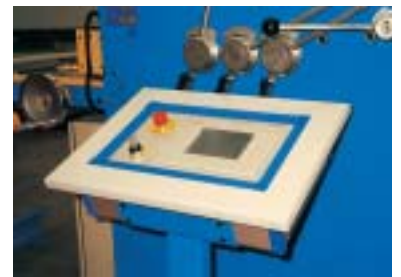
- MV-Forstner electromechanical length gauge  $\pm 20,0$  mm / 2000 mm length or MP-Forstner microprocessor control  $\pm 1,0$  mm / 2000 mm length or PLC with „all the extras“  $\pm 0,5$  mm / 2000 mm length

#### Options

- powered edge stop
- blades for stainless steel
- casters for over-the-floor travel
- special rail-operation undercarriage
- variable-speed drive



**TS electric guillotine**



**PLC „SPS-F1“**

### Specifications

sheet width:	1000, 1250, 1500 and 2000 mm
sheet thickness:	steel up to 1,0 mm with manual shear steel up to 1,5 mm with electric shear steel up to 2,0 mm with electric guillotine
infeed performance:	up to 5000 kg coil weight

# Spalt-o-mat

## Reliable slitting and cut-to-length line

### The „no-frills“ version

The S-O-M's does all the important jobs that any metal roofer would expect a basic slitting and cut-to-length line to do:

- flexible slitting and cutting-to-length
- small footprint
- easy to operate

### This machine is intended for

- regular steels up to 1,0 mm thickness
- stainless steels up to 0,6 mm thickness
- up to 1000 mm coil width

We recommend the Spalt-o-mat both as a first purchase and as a backup for cutting from coils.

### There are three models to choose from:

#### The Spalt-o-mat S-O-M 1

- infeed table with one fixed and one adjustable edge guide for unbeatable sheet positioning
- powered feed cylinders for decoiling up to 1000 kg coil weight
- an upper blade shaft that can be lifted out of the way for strictly cutting-to-length
- three pairs of blades for slitting regular steel up to 1,0 mm and stainless steel up to 0,6 mm thickness
- manually operated shears for 90° cuts (page 29)
- an MVForstner electromechanical length gauge with a precision of  $\pm 20,0$  mm per 2000 mm of length (page 35)

#### The Spalt-o-mat S-O-M 2

The S-O-M 2 is similar to the S-O-M 1 but also features

- adjustable manual shears for cutting at angles up to  $\pm 45^\circ$

#### The Spalt-o-mat S-O-M 3

The S-O-M 3 is similar to the S-O-M 1 but fully automatic, featuring

- electrically powered shears for 90° cuts (page 30)
- the MP-Forstner programmable microprocessor control with a precision of 1,0 mm per 2000 mm of length (page 35)

#### Potentials for expansion:

All S-O-M's come with casters for moving over the floor or a special undercarriage for rail.



*AL e electric shear*

### Features

- roller infeed table with two guides
- powered 70-mm diameter feed-cylinder set
- 70-mm diameter blade shaft set and three pairs of blades
- manual shear 90° S-O-M 1 and manual shear  $\pm 45^\circ$  S-O-M 2
- electric shear S-O-M 3

- single-stage three-phase drive S-O-M 1 and S-O-M 2
- two-stage three-phase drive S-O-M 3
- MV-Forstner electromechanical length gauge  $\pm 20,0$  mm / 2000 mm length S-O-M 1 and S-O-M 2 and
- MP-Forstner microprocessor control  $\pm 1,0$  mm / 2000 mm length S-O-M 3

### Options

- casters for over-the-floor travel
- special rail-operation undercarriage
- variable speed drive
- PLC with „all the extras“  $\pm 0,5$  mm / 2000 mm length





**MP-Forstner**



**Spalt-o-mat S-O-M 1**  
with manual shear for 90° cuts  
and electromechanical length gauge

### Specifications

sheet width:	up to 1000 mm
sheet thickness:	steel up to 1,0 mm and stainless steel up to 0,6 mm with 3 pairs of blades
infeed performance:	up to 1000 kg coil weight



## Compact line

### Straightening, slitting and cutting-to-length in a minimum of space

#### „The Compact“

The compact line KA ensures rapid and precise blanks from the coil plus excellent and reproducible straightening in the least possible space. Its components are:

##### Infeed table

Easily adjusted ball-bearing guides ensure ideal feed of the sheet from the coil to the straightener without damage to surface or edges.

##### Four- or six-cylinder straightener

An additional shaft guarantees flat sheet all the way to the center of the coil (page 27).

##### Slitter

The classic slitter has high-stability slitting shafts. The upper blade shaft can be lifted manually or mechanically (option) to optimize scrap removal or to take advantage of a strictly cut-to-length line (page 28).

##### Guillotine or circular shear

The proven guillotine shear ensures accurate and burr-free shearing of steel up to 2,0 mm thickness. Sheetmetal fabricators especially like the AL e electric shears for steel up to 1,5 mm thickness (page 30).

##### PLC with „all the extras“

Users are attracted by the simplicity of PLC. The system includes many special features: scrap-removal optimization, automatic trim cutting, timeclocking etc. as standard (page 36).

##### Add-ons:

Center-punching, notching, surface protection, profiling, labeling, bending, rounding, crimping, perforating etc. plus coil change-over in less than a minute with the coil selector.

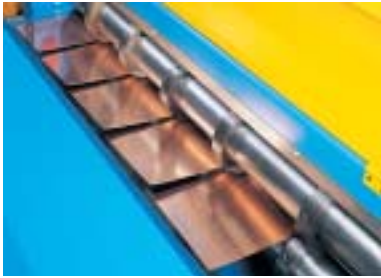
#### Features

- infeed table with one fixed and one adjustable edge guide
- two powered 70-mm diameter feed-cylinder set
- in the KA-4: four 70-mm diameter straightening shafts
- in the KA-6: six 70-mm diameter straightening shafts
- 100-mm diameter blade-shaft set with three pairs of blades for steel

- fixed lower and manually adjustable upper blade shaft
- AL e electric shear or TS electric guillotine
- two-stage three-phase drive
- PLC with „all the extras“
  - ± 0,5 mm / 2000 mm length or
  - MP-Forstner microprocessor control
  - ± 1,0 mm / 2000 mm length

#### Options

- powered edge guide
- automatic straightening-shaft lift
- powered upper blade-shaft adjustment
- special stainless steel blade
- blade-position display
- shedder rings for narrow blanks
- special rail-operation undercarriage
- variable-speed drive



**Slitting**



**Compact line**  
 straightener and slitter  
 with powered edge guide  
 with powered upper blade-shaft adjustment

### Specifications

sheet width: 1000, 1250 and 1500 mm

sheet thickness: straightening, slitting and cutting to length with the KA-6:  
 steel up to 1,5 mm with 3 pairs of blades  
 aluminum up to 2,0 mm with 3 pairs of blades  
 straightening, slitting and cutting to length with the KA-4:  
 steel up to 1,25 mm with 3 pairs of blades  
 aluminum up to 1,5 mm with 3 pairs of blades

shearing capacity: guillotine: steel up to 2,0 mm  
 shears: steel up to 1,5 mm

infeed performance: up to 5000 kg coil weight

tolerance:  $\pm 0,5$  mm / 2000 mm length,  
 reproducible subject to similar conditions

## Slitting and cut-to-length line

### Accurate and adaptable blanks from coils

#### „The Classic“

This combination of traditional Forstner machines perfected over the years has become a classic in the sheetmetal-working industry:

- **The MST slitter** (page 28)
- **The AL e electric shear** (page 30)
- **The MP microprocessor control** (page 35)

Other combinations of Forstner slitters, shears and controls are also available. The entire system can be tailored to individual requirements.



#### Any decoiler can be employed:

No matter which version you choose, the infeed table of the slitting and cut-to-length line will have one fixed and one adjustable edge guide, allowing coils up to 1000, 1250 or 1500 mm width to be handled.

The feed mechanism is strong enough to accommodate sheet from coils up to 5000 kg, even when the decoiler itself is not powered.

#### There are many advantages to cutting from coils:

- **constant quality:** with precisely cut and smooth-edged blanks
- **lower material costs:** large coils are cheaper than small coils or sheets
- **less waste:** coils can be slit more precisely with less trim
- **lower labor costs:** the system can be operated by a single worker
- **greater stock capacity:** only one width is needed for each material
- **less fabrication time:** wider coils considerably accelerate handling different materials

#### Add-ons:

The state-of-the-art design allows a wide range for expansion, even at a later date: straighteners, powered or manual coil selectors and automatic center punching machines. The system can be extended one step at a time, amortizing the investment over several years.



#### Features

- infeed table with one fixed and one adjustable edge guide
- powered 70-mm diameter feed-cylinder set
- 90-mm diameter blade-shaft set with three pairs of blades for steel
- fixed lower and manually adjustable upper blade shaft

- AL e electric shear or TS electric guillotine
- two-stage three-phase drive
- MP-Forstner microprocessor control  $\pm 1,0$  mm / 2000 mm length or PLC with „all the extras“  $\pm 0,5$  mm / 2000 mm length

#### Options

- powered edge guide
- powered upper blade-shaft adjustment
- special stainless steel blade
- blade-position display
- stronger or reinforced blade shafts
- shedder rings for narrow blanks
- special rail-operation undercarriage
- variable speed drive



**Slitting- and cut-to-length line including:**

*MST 1250 slitter*

*AL 1250 e electric shear*

*MP-Forstner microprocessor control*

*AG 1000 b decoiler*

**Specifications**

sheet width: 1000, 1250 and 1500 mm

sheet thickness: slitting and cutting to length:  
 steel up to 0,75 mm with 5 pairs of blades  
 steel up to 1,00 mm with 4 pairs of blades  
 steel up to 1,50 mm with 3 pairs of blades  
 alu up to 1,00 mm with 5 pairs of blades  
 alu up to 1,30 mm with 4 pairs of blades  
 alu up to 2,00 mm with 3 pairs of blades

shearing capacity: shears: steel up to 1,5 mm  
 alu up to 2,0 mm

infeed performance: up to 5000 kg coil weight

tolerance:  $\pm 1,0$  mm / 2000 mm length,  
 reproducible subject to similar conditions



## Multiple decoiling line

### Manual coil selector for rapid sheet change-over

#### Cost-effective, practical and very economical

Sheetmetal fabricators are confronted with so many different types of sheet every day that no well-organized business should be without a multiple decoiling line.

#### Our objectives in developing the manual coil selector were:

- to accelerate sheet change-over
- to simplify operation
- to allow retrofitting
- to lower acquisition costs



#### A multiple decoiling line with manual coil selector includes:

##### – up to six AG b decoilers

For companies involved in metal construction, we particularly recommend the AG 1000 b with bearing on one side and brake (page 21).

##### – the U-Bock deflection-roller stands

They protect the sheet as it exits the coil.

##### – the SB manual coil selector

The SB can be used to change the sheet manually and can have up to six feeds (page 25).

#### The advantages of this system are many:

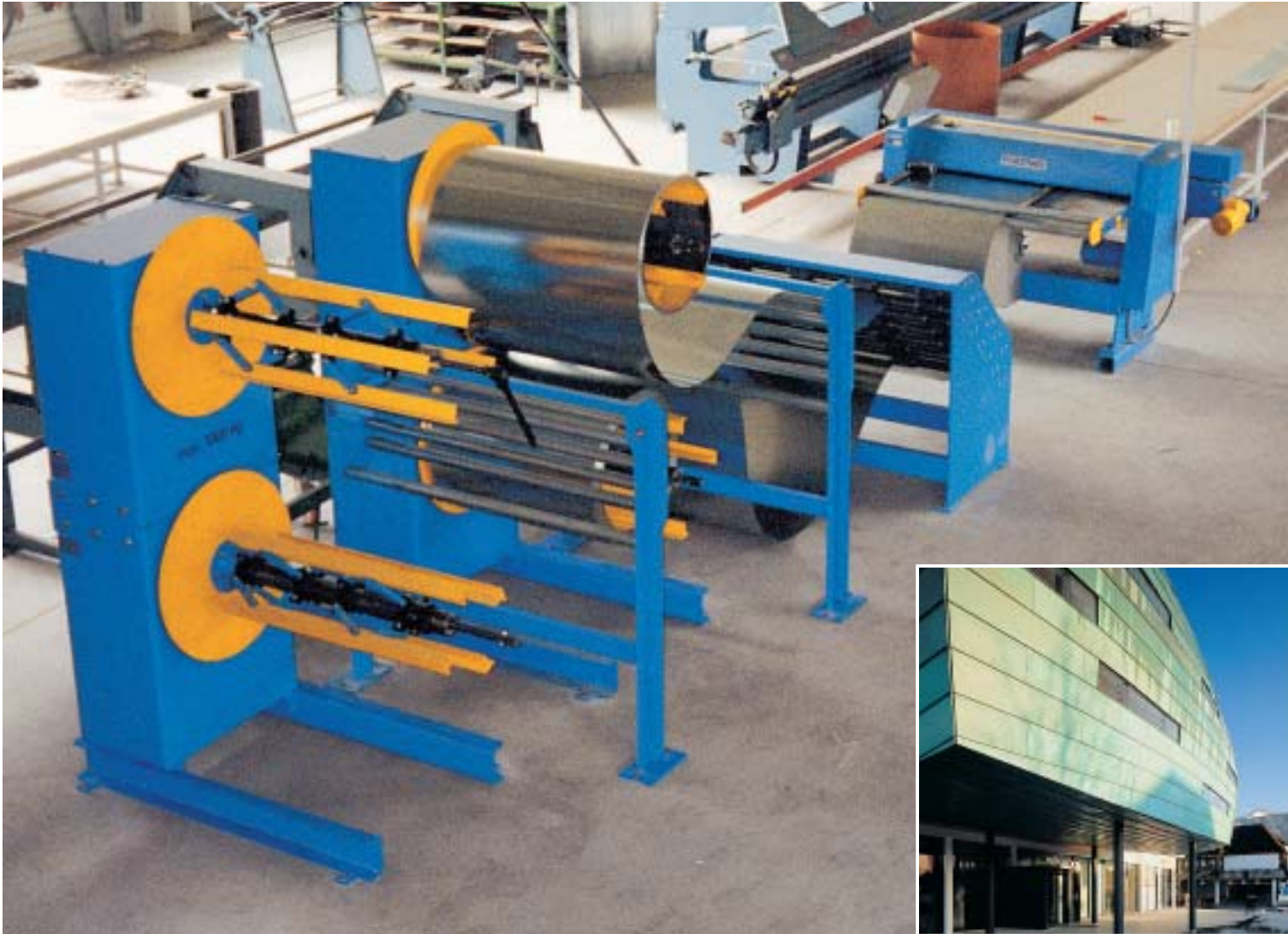
- **The decoiler is easy to load** by inserting the core of the shaft in one bearing, precisely centered by the centering disk.
- **Decoiling is particularly easy** due to the fine-adjustment brake shoes and to the deflection-roller stands, which help protect the surface of the sheet from damage.
- **The system takes up less floor space** because the decoilers can be stacked.
- The manual coil selector upstream of the cutting equipment allows **rapid access to up to six different sheets**. Once all the sheets have been secured by the feed cylinders, a single operator can change from one to another in minimal time.

#### Features

- up to six AG b decoilers with bearing on one side and with brake
- U-Bock deflection-roller stand between the decoilers and the coil selector
- SB manual coil selector with up to six feeds for manual sheet selection

#### Options

- BB guidelanes
- MT powered coil selector
- ALM cut-to-length line
- MST+AL slitting and cut-to-length line
- KA+AL compact straightening, slitting and cut-to-length line



**Fourfold decoiling line including:**

- 4 AG b decoilers with bearing on one side and brake
- 2 U-Bock deflection-roller stands
- SB-4 manual coil selector with 4 feeds
- MST slitter with AL e electric shear
- PLC with „all the extras“

**Specifications**

sheet width: up to 1250 mm

sheet thickness: decoiling and sheet changing: steel up to 1,0 mm  
aluminium up to 1,3 mm

support of decoilers: up to 6 x 1000 kg

number of feeds: up to 6

tolerance:  $\pm 0,5$  mm / 2000 mm length,  
reproducible subject to similar conditions

## Multiple decoiling line

### Automatic sheet change-over in less than a minute

#### Maximum adaptability to both single-piece and efficient long-run fabrication

The efficient production of blanks for structure section requires keeping a wide range of entirely different coils on hand. To allow rapid access to different sheets, we developed a multiple decoiling system featuring automatic sheet change-over.

#### Our objectives in developing the powered coil selector were:

- fully automatic sheet change-over in the shortest possible time
- kid-glove treatment of sensitive sheets
- rapid customer-order processing
- wide-strip cutting-optimized slitting
- the simplest possible programming
- single-worker operation



#### The multiple decoiling line with automatic sheet change-over includes:

##### - up to six decoilers

The AG a decoilers with bearing on one side and powered shaft core are particularly recommended for structural, ventilation-duct and insulating fabrication (page 22).

##### - the BB guidelanes

They protect the sheet while it is being transferred.

##### - the MT powered coil selector

The MT is used for automatic sheet change-over with up to six feeding tables and powered 70-mm feed-cylinder set (page 26).

#### The advantages of this system are many:

- **The decoiler is easy to load** by inserting the core of the shaft in one bearing, precisely centered by the centering disk.
- **Kid-glove decoiling** with powered equipment and guidelanes that facilitate feeding the sheet into the system and prevent damage to the surface.
- **The system takes up less floor space** because the decoilers can be stacked.
- The powered coil selector upstream of the cutting equipment allows **automatic access to up to six different sheets**. Once all the sheets have been secured in the coil selector a single operator can change from one to another in minimal time.



#### Features

- up to six AG a powered decoilers with bearing on one side
- BB guidelanes between the decoilers and the coil selector
- MT powered coil selector with up to six tables for automatic sheet selection

#### Options

- ALM cut-to-length line
- MST+TS slitting and cut-to-length line
- RM+MST+TS straightening, slitting and cut-to-length line
- KA+TS compact straightening, slitting and cut-to-length line





**Sixfold decoiling line including:**

- 6 AG a powered decoilers with bearing on one side
- BB-9 guidelanes
- MT-6 sixfold coil selector
- KA compact line with powered edge stop, automatic center punching and powered upper blade-shaft adjustment
- TS electric guillotine
- PLC with „all the extras“

**Specifications**

sheet width: up to 1500 mm

sheet thickness: decoiling and sheet changing: steel up to 1,25 mm  
aluminium up to 1,50 mm

support of decoilers: up to 6 x 5000 kg

number of tables: up to 6

tolerance:  $\pm 0,5$  mm / 2000 mm length, reproducible  
subject to similar conditions

## Duct line

### Economical production of rectangular ducts

#### For state-of-the-art ventilation operations

We developed the KS duct line to ensure adaptability, high output and precision in the manufacture of straight, rectangular ducts.

The stand-alone equipment can be made even more efficient by connecting it to a CAD-CAM system.

#### The KS system includes:

##### – up to six AG isf decoilers

the sturdy but economical AG isf decoilers (page 23).

##### – the MT powered coil selector

semi-automatic, with up to six feeding tables and powered 70-mm feed cylinder set (page 26).

##### – an RM-5 straightener

with five straightening shafts to ensure satisfy planarity in even the most stubborn sheet (page 27).

##### – a PM z profiling machine

the simple approach to reinforcing duct blanks (page 32).

##### – a TSBM combination guillotine and bending machine

for rapid and smooth cuts and absolutely straight duct bends.

##### – a PLC with special features for duct programming

the core of the system, outstanding for ease of operation and supreme precision (page 36).

#### The manifold advantages:

- Movable decoilers that can be taken off-line and loaded by cranes or forklifts **facilitate loading fresh coils.**
- The MT powered coil selector allows **rapid access to up to six sheets**, allowing semi-automatic change-over in minimum time.
- The RM-5 straightener with its five straightening shafts ensures **excellent sheet planarity.**
- The sturdy PM z Z-profiling machine with its specially reinforced shafts and hardened tool heads ensures **uniform and attractive duct reinforcement.**
- The especially rigid and stable hydraulic TSBM combination guillotine and bending machine guarantees **smooth edges and clean angles.**

#### Add-ons:

Additional expanding-diameter shaft cores or complete decoilers, slitting line, punches, notchers, CAD-CAM connections etc.



#### Features

- up to six unpowered movable AG isf decoilers with expanding-diameter shafts supported at each end
- MT powered coil selector with up to six tables for semi-automatic sheet change-over
- RM-5 straightener with up to five 110-mm diameter straightening shafts

- shafts 9 or 12 sets of tools in the PM z producing crimps 160 mm apart
- TSBM combination guillotine and bender with a hydraulic sheet holdfast, shear and a pivoting bending machine
- PLC with „all the extras“ for duct programming

#### Options

- extra decoilers and shafts
- a slitter for special lengths
- powered upper profiling shaft
- score and corner notching
- punched reinforcing-pipe accommodations
- interface with external controls



**KS-4 2000 Duct line including:**

- 4 AG isf movable decoilers with expanding diameter shafts
- 4 U-Bock deflection-roller stand
- MT-4 fourfold coil selector
- RM-5 straightener
- PM z profiling machine
- TSBM guillotine and bending machine
- PLC with „all the extras“

**Specifications**

sheet width: 1500, 2000 mm  
 sheet thickness: steel up to 1,25 mm  
 support of decoilers: up to 6 x 5000 kg  
 number of tables: up to 6  
 minimum duct cross-section: 160 x 160 mm

tolerance:  $\pm 0,5$  mm / 2000 mm length, reproducible  
 subject to similar conditions

## Tube line

### Flexible production of insulating tubes

#### For state-of-the-art insulating work

Our automatic RS tube line reduces the large number of steps involved in the manufacture of both blanks and finished tubes.

The system's multiple potential, especially its capacity for storing up to six different type of sheets, will measurably increase productivity.

#### The RS tube line includes:

##### – up to six decoilers

The AG a decoilers with bearing on one side and powered shaft core are particularly recommended for insulating work (page 22).

##### – the BB guidelanes

They protect the sheet while it is being transferred.

##### – the MT powered coil selector

The MT is used for automatic sheet change-over with up to six tables and powered 70-mm feed-cylinder set (page 26).

##### – an RM-3 straightener

with three straightening shafts to guarantee smooth sheet processing (page 27).

##### – a RLST dotting punch

for precise and smooth-edged punching (page 33).

##### – a SM longitudinal crimper

for efficient crimping (page 33).

##### – a TS electric guillotine

for long-term rapid and smooth-edged blanks (page 30).

##### – a PLC with „all the extras“ for tube programming

with software supporting both length and diameter inputs and calculating the overlaps (page 36).

#### The manifold advantages:

- simple decoiler loading
- kid-glove decoiling
- stackable decoilers to save space
- rapid access to up to six different sheets
- excellent straightening
- effective and economical punching and crimping with any hole diameter and crimp form desired
- precise and smooth-edged shearing
- expandable with conveyor belts and radial crimpers into a fully automated tube line



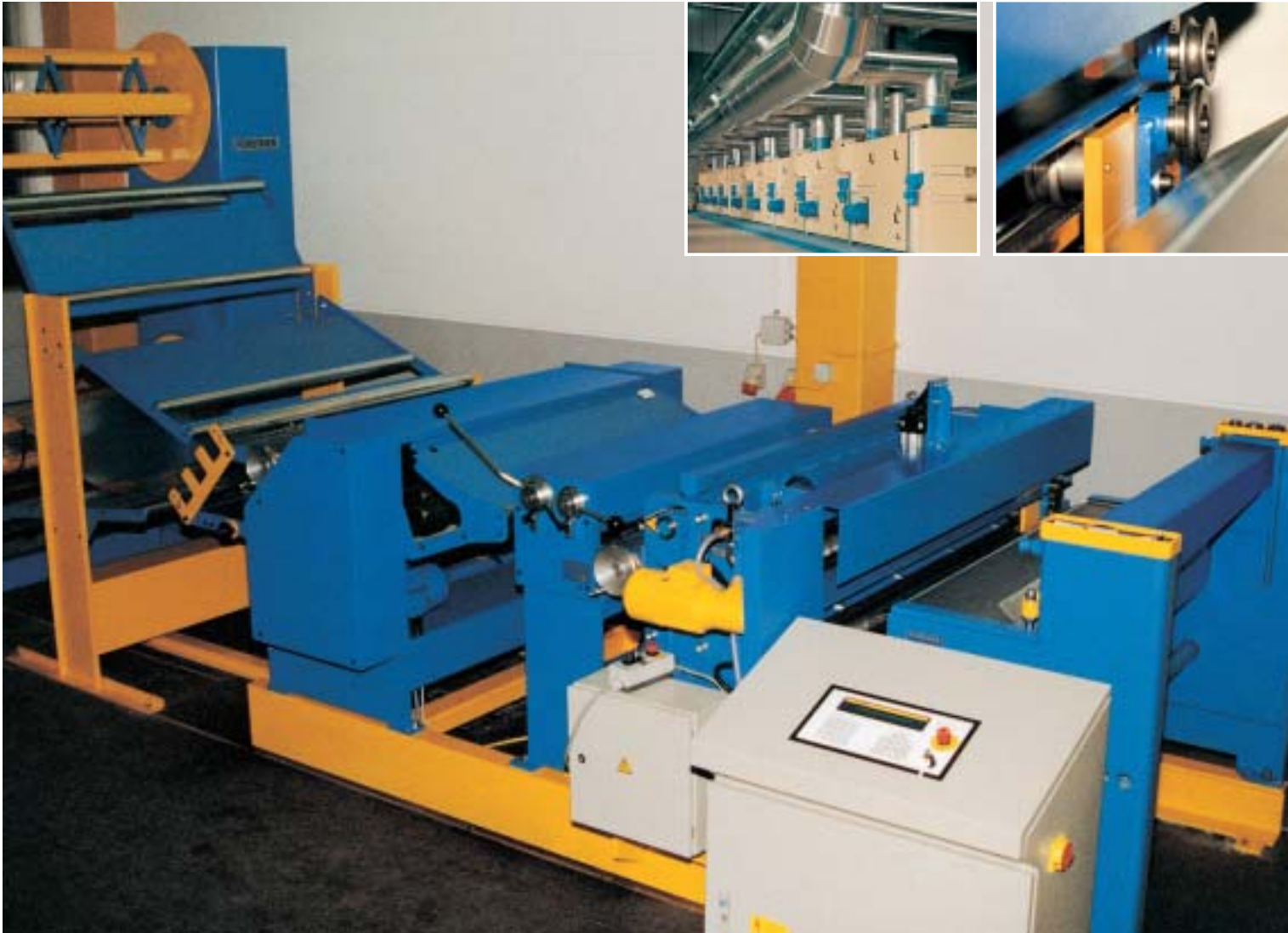
#### Features

- up to six AG a powered decoilers with bearing on one side
- BB guidelanes between the decoilers and the coil selector
- MT powered coil selector with up to six tables for automatic sheet change-over
- RM-3 straightener with 3 straightening shafts 70 mm diameter

- RLST dotting punch with 6 or more 3,3 mm diameter tool holders
- SM longitudinal crimper with a sheet holdfast and 2 crimping tools
- TS guillotine with an automatic holdfast and shear blades
- PLC with „all the extras“ for tube programming

#### Options

- straightener with more shafts
- stacking table
- 3 m long conveyor belt
- separate machine for radial crimping and rounding or
- radial crimper and rounder integrated downstream of the belt



**RS tube line including:**

- 2 AG a powered decoilers
- BB-3 guidelanes
- MT-2 twofold coil selector
- RM-3 straightener
- RLST dotting punch
- SM longitudinal crimper
- TS electric guillotine
- PLC with „all the extras“

**Specifications**

sheet width: 1000, 1250 mm  
 sheet thickness: stainless steel up to 0,8 mm  
 steel up to 1,0 mm  
 alu up to 1,2 mm

support of decoilers: up to 6 x 1000 kg  
 number of tables: up to 6  
 tubes: down to 100 mm in diameter  
 tolerance:  $\pm 0,5$  mm / 2000 mm length,  
 reproducible subject to similar  
 conditions

## Slitting and recoiling line

### Fabrication of light coils or narrow slits

#### For state-of-the-art sheetmetal sales

We developed a special compact slitting and recoiling line especially for suppliers and for such large-scale sheetmetal operations as structural-section fabricators, punching shops, etc.

Our system has been proven for its adaptability to small jobs.

#### The recoiling line includes:

- an AG a decoiler
- an ALM-AL/ALM-TS cut-to-length line
- a BG m or BG p brake system
- a powered AUG a recoiler

#### The slitting line includes:

- an AG a decoiler
- a MST slitter and AL or TS shear
- a BG m or BG p brake system
- a powered AUG a recoiler

#### The slitting and cut-to-length line includes:

- an AG a decoiler
- a KA+AL or TS compact slitting and cut-to-length line
- a WB or ST sheet stacker
- a BG m or BG p brake system
- a powered AUG a recoiler

#### The manifold advantages:

- perfect recoiling
- compact design
- low acquisition costs
- simple operation
- rapid access to different types of sheets



#### Features recoiling line

- AG a powered decoiler with bearing on one side
- ALM-AL m, ALM-AL e or ALM-TS cut-to-length line
- BG m manual or BG p pneumatic brake system
- AUG a powered recoiler

#### Features slitting line

- AG a powered decoiler with bearing on one side
- MST slitter with AL m or AL e shear or TS guillotine
- BG m manual or BG p pneumatic brake system
- AUG a powered recoiler

#### Features slitting and cut-to-length line

- AG a powered decoiler with bearing on one side
- KA compact line with AL e shear or TS guillotine
- ST or WB sheet stacker
- BG m or BG p brake system
- AUG a powered recoiler



**Slitting- and recoiling line including:**

- AG a powered decoiler with SHT coil-loading chair
- RT feed-roller basket
- MST slitter with AL e electric shear
- MV Forstner electromechanical length gauge
- BT-1 loading table
- BG p pneumatic brake system
- AUG a recoiler with SHT coil-loading chair

**Options**

- SHT coil-loading chair in the form of a scissoring lift
- SHKT coil-removal accessory in the form of a tilting scissoring lift
- RM straightener

**Specifications**

sheet width:	1000, 1250, 1500 mm
sheet thickness recoiling:	alu up to 1,0 mm steel up to 1,0 mm stainless steel up to 0,6 mm
sheet thickness slitting:	steel up to 2,0 mm
sheet thickness cutting-to-length:	steel up to 2,0 mm
support of decoilers:	up to 5000 kg
support of recoilers:	up to 3000 kg

## Coil technology for professionals.

### Forstner multiple decoiling lines rapidly pay for themselves!

Forstner does not sell „off the shelf“. All systems are specifically designed for your particular shop.

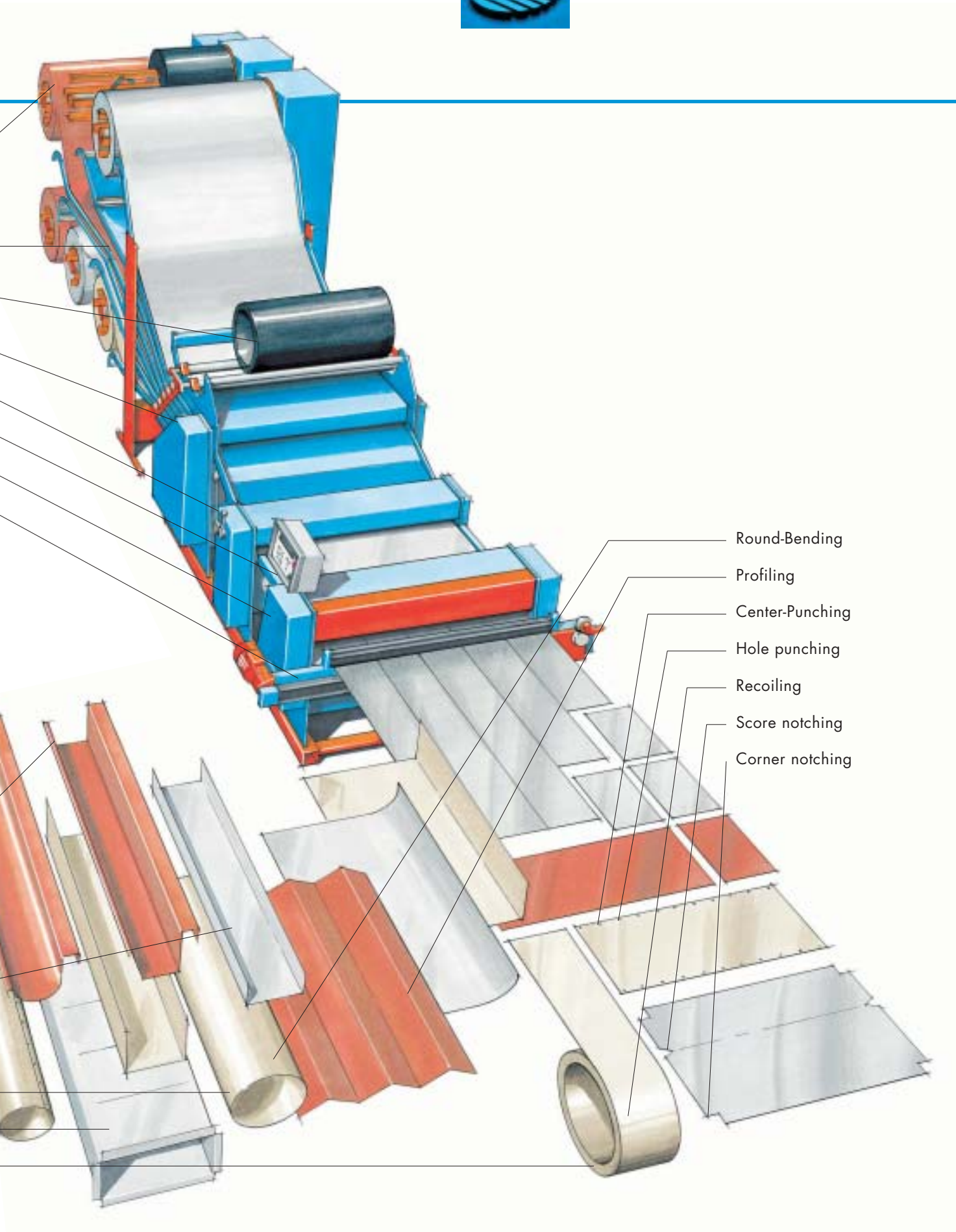
Every machine is individually crafted to customer specifications with careful attention to operation and control, precise edge guidance and even to paint color.

For a rapid and detailed Forstner proposal, just fill out and return the information request at the end of this catalog!

- Decoiling
- Sheet guiding
- Derolling
- Automatic sheet change-over
- Straightening
- Programming
- Slitting
- Cutting-to-length

- Gutters
- Covering
- Insulating tubes
- Flues
- Ventilation ducts
- Sheetmetal coils





Round-Bending

Profiling

Center-Punching

Hole punching

Recoiling

Score notching

Corner notching

## Decoiling

### AG b decoilers with bearing on one side and brake

#### Quick and simple coil loading

The decoilers with bearing on one side can be rapidly loaded with cranes or forklifts, the low-slung versions with four-wheelers. The practicality of coil selection, the valuable time savings and the well controlled decoiling procedure make for efficient fabrication. The long guidelanes contribute considerably to adaptability.



**AG b decoiler with bearing on one side and brake**  
in the low-slung, movable version for coils up to 1000 kg



**Stacked AG b decoilers**  
two coils weighing up to 1000 kg

#### Stackable decoilers up to 5 tons

Two or even three decoilers from 1000 kg up to 5000 kg can be stacked, saving floor space and allowing rapid access to several types of sheet. Second and third decoiler can easily be added later.

#### Features

- bearing shaft on one side
- stable and precise centering disks
- smoothly rounded strip accommodations
- adjustable brake shoes
- shaft expansion with manually operated spindles

#### Options

- pneumatic riders
- electric or hydraulic expansion mechanism
- expansions to accommodate longer inside diameters
- coil-loading chair in the form of a scissoring lift
- built-in wrapping-paper dispenser
- castors to AG 1000 b
- deflection-roller stands

#### Specifications

- |                   |                            |
|-------------------|----------------------------|
| coil weight:      | 1000, 2000, 3000, 5000 kg  |
| coil width:       | 1000, 1250, 1500 mm        |
| expansion ranges: | up to 1 ton: 280 - 520 mm  |
|                   | up to 3 tons: 360 - 520 mm |
|                   | up to 5 tons: 460 - 620 mm |

## Decoiling

### AG a powered decoilers with bearing on one side

#### Kid-glove treatment

Powered decoilers provide every advantage for efficient loading and guarantee thorough protection of valuable sheet. Even highly sensitive types will be unwound from the coil unscratched.

#### Rapid access to different types of sheet

The economical advantage provided by a series of stacked decoilers in tandem will be particularly evident in conjunction with the MT powered coil selector (page 26). The sheet is channeled on its way to the selector by guidelanes, several versions of which are available.



**AG a decoilers stacked**  
two coils weighing up to 3000 kg



**AG a powered decoiler**  
with coil-loading chair up to 5000 kg

#### Features

- basic decoiler with expanding-diameter shaft similar to the AG b
- single-stage three-phase drive with gradual start-up or frequency converter
- loop controls

#### Options

- pneumatic riders
- electric or hydraulic expansion mechanism
- expansions to accommodate longer inside diameters
- coil-loading chair in the form of a scissoring lift
- built-in wrapping-paper dispenser
- guidelanes available in different versions

#### Specifications

- |                   |   |
|-------------------|---|
| coil weight:      | 1000, 2000,<br>3000, 5000 kg  |
| coil width:       | 1000, 1250, 1500 mm   |
| expansion ranges: | up to 1 ton: 280 - 520 mm<br>up to 3 tons: 360 - 520 mm<br>up to 5 tons: 460 - 620 mm |

## Decoiling

### AG is twin-bearing expanding-diameter shaft

#### Stable design at the right price

This sturdy twin-bearing model allows low-cost but efficient decoiling.

#### Rapid set-up

We suggest additional expanding-diameter shafts to accelerate coil change-over. Keeping the most often used types of sheet ready on the shafts will decrease set-up time considerably.



**AG is decoiler**  
with expanding diameter shaft  
up to 5 tons coil weight and 1500 mm coil width



**AG isf decoiler movable**  
with expanding diameter shaft  
up to 5 tons coil weight and 2000 mm coil width

#### Stationary or movable version

Both stationary and movable (rail-based) versions that can manage coils weighing between 1000 and 8000 kg are available. The movable versions can be moved at a right angle to the rest of the equipment to accelerate coil change. The AG isf decoiler is particularly recommended for use with the MT powered coil selector.

#### Stacking the decoilers

Working with various types of sheets and coils of different weight in limited space often demands stacking one decoiler over another.

#### Features

- twin-bearing expanding-diameter shafts
- centering guides at the feed slots
- adjustable disk brakes
- powered-roller multiple stands
- auxiliary drive mechanisms

#### Options

- pneumatic riders
- deflection-roller stands
- speed drive

#### Specifications

- |                  |                              |
|------------------|------------------------------|
| coil weight:     | 1000, 3000,<br>5000, 8000 kg |
| coil width:      | 1000, 1250,<br>1500, 2000 mm |
| expansion range: | 460 - 620 mm                 |

## Derolling

### ARG, AR, CL derollers for small coils

#### The ARG-BO and ARG-MT deroller

- the stationary ARG-BO rests on the floor or is assembled on the MT powered coil selector or SB manual coil selector.
- rapid access to all coils weighing up to 300 kg
- free-floating bearing for 1000, 1250, and 1500 mm coil width



**ARG-MT deroller**  
assembled on a coil selector

#### AR deroller

- the ideal way to move and unroll small coils weighing up to 200 kg and up to 1000, 1250, or 1500 mm width
- unbeatable for construction sites or for stationary use with a cut-to-length line
- roller holders and conveyor belts can be provided as accessories for narrow coils



**AR deroller**  
with roller holder and conveyor belt

#### CL coil rack

- a modular system for storing and derolling both slits and coils
- up to four levels for small coils weighing up to 300 kg and 1000 mm width
- loader included



**CL coil rack**  
4 levels loader included

## Sheet selection

### SB manual coil selector

#### A manually operated coil selector for rapid sheet change-over

The SB coil selector is a simple and highly cost-effective approach to rapid sheet change-over.

#### Between two and six sheets accommodated

As many as six types of sheets can be tightly secured in the coil selector. The particular sheet desired fed into the downstream machinery with a manually operated wheel.

#### Can always be added later

The coil selector can always be added as an economical accessory to existing decoilers or upstream of any slitting and cut-to-length line with no need to modify the controls.



#### Features

- from two to six sets of feed cylinders
- upper cylinder cam-adjustable
- handwheel for forwarding the sheet

#### Options

- ARG-MT unroller for small coils up to 300 kg weight

#### Specifications

coil width: 1000, 1250, 1500 mm

## Sheet selection

### MT powered coil selector

#### Automatic sheet change-over in less than a minute

The MT coil selector ensures flexible access to the different types of sheets and coil widths used every day. Change-over is entirely automatic and extremely rapid.

A powered coil selector will add even more measurable efficiency when used with decoilers with bearing on one side.



#### Rapid and flexible access to the most frequently needed types of sheet

Up to six types of sheet can be securely tensioned in the coil selector. Any sheet can be accessed entirely automatically from the controls. Just the touch of a button gently starts the desired sheet into the slitting and cut-to-length line or any other machinery downstream.



**coil selector MT-6**  
with six infeed tables

#### Features

- two to six infeed tables with one fixed and one adjustable edge guide
- one set of feed cylinders per table
- two-stage three-phase drive

#### Options

- ARG-MT unroller for small coils up to 300 kg
- variable speed drive

#### Specifications

- coil width: 1000, 1250, 1500, 2000 mm
- infeed performance: up to 5000 kg coil weight

## Straightening

### RM-3 straightener

#### Features

- two permanently positioned and powered lower straightening shafts
- a cam-adjustable upper shaft, manually adjustable
- powered 70-mm diameter feed-cylinder set
- two-stage three-phase drive

#### Options

- an infeed table that handles the strip gently and without scratching
- the upper shaft automatically lifted in synchronization with machine speed
- variable speed drive

#### Specifications

straightening shafts: 70 mm diameter  
 sheet width: 1000, 1250, 1500 mm  
 sheet thickness: steel up to 1,25 mm  
 feed performance: up to 5000 kg coil weight

The three-cylinder RM-3 straightener ensures smooth further blank processing.



**RM-3 straightener**

### RM-5 straightener

#### Features

- three permanently positioned and powered lower straightening shafts
- two cam-adjustable upper shafts, manually adjustable at each end
- powered 70-mm diameter feed-cylinder set
- two-stage three-phase drive

#### Options

- an infeed table that handles the strip gently and without scratching
- the upper shaft automatically lifted in synchronization with machine speed
- extra straightening shafts
- variable speed drive

#### Specifications

straightening shafts: 110 mm diameter  
 sheet width: 1000, 1250, 1500, 2000 mm  
 sheet thickness: steel up to 2,0 mm  
 infeed performance: up to 5000 kg coil weight

The five-cylinder RM-5 straightener ensures excellent planarity in even the most demanding applications.



**RM-5 straightener**



## Slitting

### MST multiple slitter

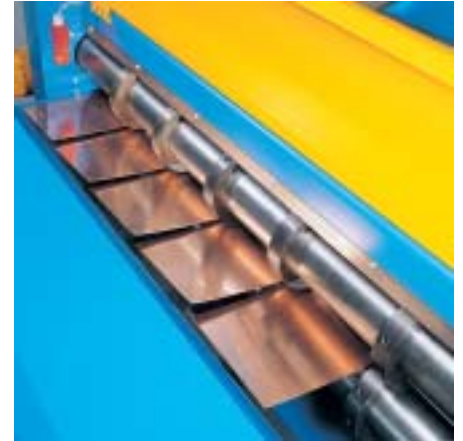
#### Precise and adaptable slitting from the coil

The MST multiple slitter allows rapid fabrication of individual blanks from coils. Precisely cut blanks from the particular sheet required reduces waste to a minimum and measurably increases productivity. The adjustable upper blade-shaft permits all special widths to be handled without waste. The blades can be reversed and sharpened.

#### Different machine outputs

The standard MST is intended for everyday metal-working and equipped with three pairs of blades. It can handle steel as thick as 1.5 mm and as wide as 1250 mm.

The augmented version can accommodate as many as 10 pairs and can handle steel as thick as 2.0 mm and as wide as 2000 mm.



**MST multiple slitter**



**MST-V slitter**

*with 10 pairs of blades in the reinforced version for steel up to 1,5 mm thickness*

#### Features

- infeed table with one fixed and one adjustable edge guide
- powered 70-mm diameter feed-cylinder set
- 90-mm diameter blade-shaft set with three pairs of blades for steel
- fixed lower and manually adjustable upper blade shaft
- two-stage three-phase drive

#### Options

- powered edge guide
- powered upper blade-shaft adjustment
- special stainless steel blade
- blade-position display
- stronger or reinforced blade shafts
- shedder rings for narrow blanks
- special rail-operation undercarriage
- variable speed drive

#### Specifications

- sheet width: 1000, 1250, 1500, 2000 mm
- sheet thickness: from steel 0,40 mm up to 2,0 mm
- infeed performance: up to 5000 kg coil weight

## Cutting-to-length

### ALL m manual shear

The ALL m manual shears are impressive for their light-weight but sturdy design.

Simple sheet tensioning and reliable shears-carrier guidance guarantee precisely cut and smooth-edged blanks.

#### Features

- manual lever-operated holdfast
- clamped by operator-controlled cams
- high-quality tool heads

#### Options

- special blades for stainless steel up to 0,6 mm thickness
- undercarriage
- adaptor for workbench mounting

#### Specifications

sheet width: 1000, 1250, 1500 mm  
sheet thickness: steel up to 1,0 mm



**ALL m manual shear**

### AL m manual shear

The manually operated AL m shears can be integrated on free-standing or mounted on a bench.

Circular shears and multiple slitters together create a proven and highly popular total slitting and cut-to-length line.

#### Features

- automatic holdfast
- shears carrier with screw-on shearing head
- two regrindable circular blades

#### Options

- special blades for stainless steel up to 0,6 mm thickness
- undercarriage
- adaptor for workbench mounting

#### Specifications

sheet width: 1000, 1250, 1500 mm  
sheet thickness: steel up to 1,0 mm



**AL m manual shear**

## Cutting-to-length

### AL e electric shear

This system is universally applicable either on its own stand, mounted on a bench or combined with any other Forstner machinery as the MT, the RM, the MST etc.

The proven circular shears guarantee precise and smooth-edged blanks. This machine is outstanding for saving floor space and low investment costs.

#### Features

- automatic holdfast
- shears carrier with screw-on shearing head
- two regrindable circular blades
- single-stage three-phase-drive

#### Options

- special blades for stainless steel up to 1,0 mm thickness
- two-stage three-phase-drive
- undercarriage
- adaptor for workbench mounting

#### Specifications

sheet width: 1000, 1250, 1500 mm

sheet thickness: steel up to 1,5 mm



*AL e electric shear*

### TS electric guillotine

This device is the „classic“ of shearing equipment, known for rapid, precise and smooth-edged blanks.

This guillotine can be used on its own or combined with other equipment.

#### Features

- solid, all-steel construction
- flat and maintenance-free blade rail
- automatic holdfast
- single-stage three-phase-drive

#### Options

- special blades for stainless steel up to 1,2 mm thickness
- stronger versions up to 2,5/3,0/3,5 mm

#### Specifications

sheet width: 1000, 1250, 1500, 2000 mm

sheet thickness: steel up to 3,5 mm



*TS electric guillotine*

## Notching

### KL automatic notcher

The KL notcher is a time-saving component that can be integrated into any slitting and cut-to-length line to provide automatic notching and punching.

#### Features

- hardened and hydraulically actuated components with polished tool heads
- manual or powered notching- or punching- strap adjustment

#### Options

- corner notching for coffer blanks
- cullis notching for eaves gutters
- corner notching for ventilating ducts

#### Specifications

designed to customer specifications



*KL automatic notcher*

## Center-punching

### KST automatic center-punch station

As an integrated system component the KST will eliminate time-consuming and imprecise manual bend center-punching. It is all done automatically.

#### Features

- powered punching tool alignment

#### Options

- no options

#### Specifications

- parallel or converging punching
- positioned with three-phase drive mechanism with frequency converter to  $\pm 0,5$  mm at 30 – 40 m per minute
- punching at upper or lower edge or at the center of the blank
- up to 50 center punchings per sheet width
- sheet width: 1000, 1250, 1500, 2000 mm
- sheet thickness: steel up to 1,5 mm



*KST center-punching*

*integrated into a slitting and cut-to-length line*

## Profiling

### PM z profiling machine

Integrated into a cut-to-length line the PM z is an unbeatable approach to reinforcing ventilation-duct blanks.

#### Features

- reinforced shafts
- hardened tool heads
- lower shafts stationary and upper shafts manually adjustable

#### Options

- powered upper blade-shaft adjustment

#### Specifications

sheet width: 1000, 1250, 1500, 2000 mm  
 sheet thickness: steel up to 1,25 mm  
 Crimps: 160 mm apart and 10 mm deep



*profiling tool heads of the PM z*

### PM t profiling machine

As an integrated component of a cut-to-length line, the PM t is an ideal solution for trapezoidal reinforcement and decorative crimping.

#### Features

- reinforced shafts
- hardened tool heads
- lower shafts stationary and upper shafts manually adjustable

#### Options

- powered upper blade-shaft adjustment

#### Specifications

sheet width: 1000, 1250, 1500, 2000 mm  
 Information about sheet thickness, quantities and crimp shape, width and height on request.



*PM t profiling machine*

## Punching

### RLST dotting punch

As an integrated component of a cut-to-length line for insulating, the RLST will considerably facilitate the production of blanks from regular steel, stainless steel and aluminum.

#### Features

- hardened and polished tool heads with shadders
- single-stage three-phase drive
- waste container
- 6 tool holders

#### Options

- extra tool sets
- different cutout diameters

#### Specifications

- sheet width: 1000, 1250 mm  
 sheet thickness: stainless steel up to 0,8 mm  
 steel up to 1,0 mm  
 alu up to 1,2 mm  
 cutout diameter: 3,3 mm



**RLST dotting punch**

## Axial crimping

### SM axial crimper

As an integrated component of tube line for insulating the SM is an unbeatable approach to efficient axial crimping.

#### Features

- pneumatic holdfast
- single-stage three-phase drive
- profiling carriage with permanently mounted tools
- hardened tool heads

#### Options

- different crimp geometries
- variable speed drive

#### Specifications

- sheet width: 1000, 1250 mm  
 sheet thickness: stainless steel up to 0,8 mm  
 steel up to 1,0 mm  
 alu up to 1,2 mm



**SM axial crimper**

## Radial crimping

### RSM radial crimper

#### From blank to finished insulation tube in a single step!

The RSM will save any insulating fabrication shop huge amounts of time. A single-step operation forms a simple blank into a finished and crimped tube of the desired diameter with all the necessary crimps.

Not only the common industrial-scale crimp (50 mm), but any 6-, 8-, and 10-gauge U-section and V-section

crimps can be produced with this compact combination of rounding and crimping machine. The two-part tool heads are easy to change. The tools are aligned visually with a gauge.

The rounding cylinder is easy to adjust from a scale and shapes the sheet uniformly into a ready-to-install tube.



*RSM radial crimper*

#### Features

- powered feed cylinder set
- pneumatic edge guide to facilitate positioning
- rough-out rollers
- 3-cylinder rounder with crimping rollers
- variable-speed drive
- 6-, 8-, and 10-gauge crimping heads
- 50 mm industrial-scale head

#### Options

- heads of different geometries

#### Specifications

- |                  |  |
|------------------|--|
| sheet width:     | 1000, 1250 mm  |
| sheet thickness: | stainless steel up to 0,8 mm<br>steel up to 1,0 mm<br>alu up to 1,2 mm |

## Programming

### MV-Forstner mechanical length gauge

The MV-Forstner is recommended for applications where the individual blank lengths are measured in centimeters.

This positioning device is outstanding as a profitable investment and for its simple operation.

The instrument is particularly in demand for use with the Spalt-o-mat S-O-M 1 slitting and cut-to-length line.



*MV-Forstner mechanical length gauge*

#### Specifications

length in cm: up to 99.99

tolerance:  $\pm 20$  mm / 2000 mm length

### MP-Forstner microprocessor control

The very cost-effective MP-Forstner control was specially developed for use with our slitting and cut-to-length lines: the Spalt-o-mat S-O-M 3, the MST multiple slitter and the ALM shears.

Any desired quantity and length can be entered and produced at the touch of a button.

The standard MP-Forstner also features optimal slitting-waste management and other extras.



*MP-Forstner microprocessor control*

#### Specifications

routine-storage capacity: up to 99

length in mm: up to 999999

quantity: up to 999

tolerance:  $\pm 1,0$  mm / 2000 mm length



## Programming

### Programmable logic controls SPS-F1

#### PLC is the wave of the future.

PLC makes operating any system a pleasure.

The advanced SPS-F1 version is outstanding not only for reliability, flexibility and precision but especially for ease of operation and unbeatable results.

When the controls are employed with a coil selector up to 99 different programs can be stored, each prescribing a particular quantity, length in mm and sheet selection. One or more programs can be carried out in sequence or interchanged within a single run.

Extras like optimal waste management (important for slitting), baseline cuts, reverse, timeclock, and maintenance-due signals are standard. Baseline cuts are not absolutely required. Options like diagonal-cutting and blade-inclination settings and scoring, notching, punching etc. subroutines can be supplied on request.



**SPS-F1 programmable logic controls**



**PLC „console-mounted“**

#### Features

- time sharing
- rotary transducer
- control panel machine or console-mounted
- top-of-the-line electronic components
- keypad on right or left
- symbolic description of functions

#### Options

- CAD-CAM interface
- connections to downstream machinery
- sheet advancing tolerance:  $\pm 0,2$  mm

#### Specifications

- routine-storage capacity: up to 99
- length in mm: up to 999999
- quantity: up to 999
- table number: up to 9
- tolerance:  $\pm 0,5$  mm / 2000 mm length

## The full potential

### Peripherals

Every system can be precisely adapted to individual needs. A number of accessories are available for direct integration.

The following peripherals will help automate production. We can also provide many other features.



#### Stacking table

**ST**

A useful component for laying off blanks. Size and weight to order.



#### Layoff belt

**BA**

The ideal kid-glove approach for moving finished blanks. The powered belt is synchronized with the overall system.



#### Scissored coil lift

**SHT**

A useful accessory for decoilers with bearing on one side. It ascends and descends hydraulically and can be moved around manually on rails.

#### Tilting scissored coil lift

**SHKT**

Specially designed for transferring narrow coils from the recoiler to pallets.

#### Workbench

**WB**

Features a high-stability base, an inlaid scale and an adjustable edge guide.

#### Trim coiler

**B-AUG**

A simple means of neatly coiling trimmed-off edges.

#### Shredder

**ZH**

Chops leftover trim for convenient disposal.

#### Plastic-sheet dispenser

**FAG**

For applying surface-protecting sheet.

#### Paper recoiler

**P-AUG**

A space-saving device for recoiling wrapping paper around a cardboard core.



Please complete and return

# Request for further information

## Our primary objective is system flexibility

### I would like more information about Forstner products and request

- a proposal in accordance with the following specifications
- a telephone call as soon as possible
- .....

### Please provide us with detailed information about your company:

Company name, address, telephone no. and fax no.:

Company stamp

.....

.....

.....

Contact person and position: .....

Line of business: .....

### Please provide us with the most important data about the sheets to be processed:

materials / widths / thicknesses steel and stainless steel:

.....

.....



### Please provide us with your potential requirements:

- |  |   |   |   |  |   |
|--|---|---|---|--|---|
| <input type="checkbox"/> <b>Decoiling</b>          | maximum coil weight:                            | <input type="checkbox"/> 1000 kg          | <input type="checkbox"/> 3000 kg            | <input type="checkbox"/> 5000 kg         | <input type="checkbox"/> .....                |
|  | Number of decoilers:                            | <input type="checkbox"/> two              | <input type="checkbox"/> four               | <input type="checkbox"/> six             | <input type="checkbox"/> .....                |
|  | Decoilers will be loaded with:                  | <input type="checkbox"/> Forklift         | <input type="checkbox"/> Coil-loading chair | <input type="checkbox"/> Crane           | <input type="checkbox"/> .....                |
| <input type="checkbox"/> <b>Sheet selection</b>    | Number of infeed tables:                        | <input type="checkbox"/> two              | <input type="checkbox"/> four               | <input type="checkbox"/> six             | <input type="checkbox"/> .....                |
|  | Sheet changeover method:                        | <input type="checkbox"/> automatic        | <input type="checkbox"/> manual             |  |   |
| <input type="checkbox"/> <b>Straightening</b>      | Number of straightening shafts:                 | <input type="checkbox"/> three            | <input type="checkbox"/> five               | <input type="checkbox"/> six             | <input type="checkbox"/> .....                |
| <input type="checkbox"/> <b>Slitting</b>           | Number of pair of blades:                       | <input type="checkbox"/> three            | <input type="checkbox"/> four               | <input type="checkbox"/> five            | <input type="checkbox"/> .....                |
| <input type="checkbox"/> <b>Cutting-to-length</b>  | Cutting method:                                 | <input type="checkbox"/> Circular blades  | <input type="checkbox"/> Guillotine         |  |   |
| <input type="checkbox"/> <b>Stacking</b>           | Length of blanks:                               | <input type="checkbox"/> 2000 mm          | <input type="checkbox"/> 2500 mm            | <input type="checkbox"/> 3000 mm         | <input type="checkbox"/> .....                |
|  | maximum stack weight:                           | <input type="checkbox"/> 500 kg           | <input type="checkbox"/> 1000 kg            | <input type="checkbox"/> 2000 kg         | <input type="checkbox"/> .....                |
| <input type="checkbox"/> <b>Recoiling</b>          | maximum coil weight:                            | <input type="checkbox"/> 500 kg           | <input type="checkbox"/> 1000 kg            | <input type="checkbox"/> 2000 kg         | <input type="checkbox"/> .....                |
| <input type="checkbox"/> <b>Programming</b>        | longitudinal tolerance:                         | <input type="checkbox"/> ±0,5 mm          | <input type="checkbox"/> ±1,0 mm            | <input type="checkbox"/> ±20,0 mm        | <input type="checkbox"/> .....                |
| <input type="checkbox"/> <b>Notching</b>           | <input type="checkbox"/> <b>Center-punching</b> | <input type="checkbox"/> <b>Profiling</b> | <input type="checkbox"/> <b>Punching</b>    | <input type="checkbox"/> <b>Crimping</b> | <input type="checkbox"/> <b>Round-bending</b> |
| <input type="checkbox"/> <b>Surface protection</b> | <input type="checkbox"/> <b>Other:</b>          | .....                                     |   |  |   |

# Coil technology from Forstner



Multiple decoiling lines

Cut-to-length lines

Straightening, slitting and cut-to-length lines

Slitting and recoiling lines

Duct lines for rectangular ducts

Tube lines for insulating

Custom-made special machines for sheet processing



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