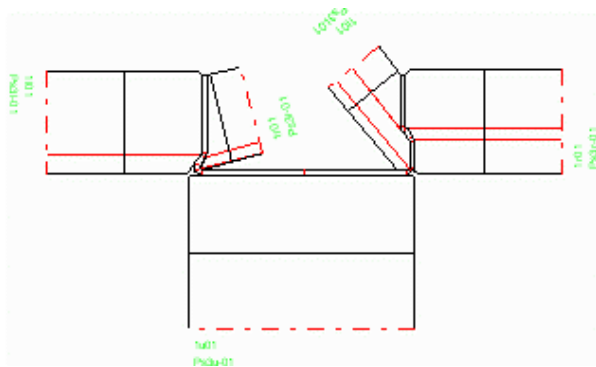


## Multi Axles Machine

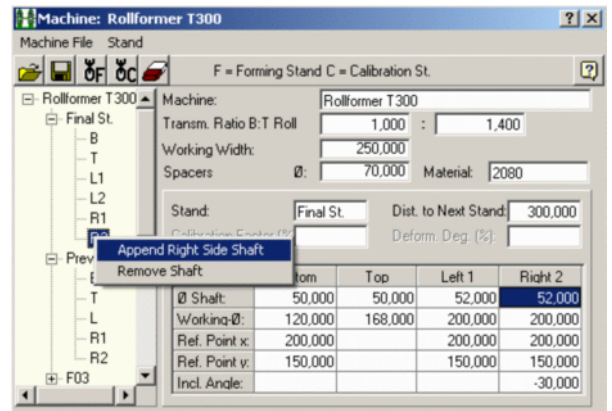
### Additional Side Axles:

In order to form more complex roll formed profiles on a roll forming machine, it often is necessary to have additional side axles with inclined angles that plunge into the open cross-section. This makes it more easy to form the inner radii precisely that are not accessible for horizontal top rolls. For this purpose additional side axles with arbitrary inclination angle can be created in the machine window.



### Operating Instructions:

After right clicking on the side axle symbol (L or R) in the machine window a context menu opens and additional side axles can be defined – and removed again in the same way. The axle can be vertical ( $0^\circ$  = normal position) or inclined with any inclination angle (positive outwards and negative inwards). Any number of additional axles can be defined. During creation of a new axle the data of the previous axle are copied. The inclination angle, however, is modified in order to have the new axle visible in the drawing area and selectable by mouse click. Afterwards the user should set the desired inclination angle.



### Roll Numbering:

In order to enable the automatic numbering of the roll number and the part number, two new variables are provided. They can be used in the number keys input fields (Options, Rolls).

**SSA** consecutive number over all rolls of a certain stand in the order bottom-top-left-right

**STA** consecutive number over all rolls of a certain shaft/axle type (B, T, L, R) of a certain stand. All left side rolls belong to the type L and all right to the type R.