SITE MINIMUM REQUIREMENTS 50HZ

MINIMUM REQUIREMENTS BEFORE TECHNICIAN ARRIVES ONSITE

Version 2026.1

SCOTTSDALE

THE TRUSTED STEEL-FRAMING PARTNER

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SITE MINIMUM REQUIREMENTS 50HZ

****Please print following 2 pages, Fill out, Sign and send back to Scottsdale representative once items are purchased and are onsite****

Technicians travel reservations may be delayed if this form is not filled out, Signed and returned with quantities onsite

Machine and Decoiler to be unpacked as per page 21 of this Document.

Machine to be electrically connected as per relevant page 4 to 11 of this document.

By Signing this document you are agreeing the Quantities onsite on page 3 are true and correct

Company Name : _____

Signature : _____

Name (Print) : _____

Date : _____

**** The Following Quantities are for machine commissioning only.****

Quantities may change to suit your needs

Site Minimum	Quantity Req	Qty Onsite
Stands	8 / Machine	
Cordless Drill	1 / Machine	
Hex head tek screws	500	
Hex driver (150 long)	5 Pack	
Compressor	1	
Air lines	2 / Machine	
Air Gun	1 / Machine	
Air or Battery shears	1 / Machine	
Tape Measure	1 / Machine	
Snips	1 set / Machine	
Marker Pen (Sharpie)	5 Pack	
Safety Glasses and gloves	1 set / Person	
Coil	1000M	

Panel C Section 7000 (In addition to Site Minimum)	Quantity Req	Qty Onsite
Rivet Guns	2 / Machine	
Rivets	1000	
Self drilling wafer heads	500	
Philips driver	5 Pack	
5mm dill bit	5 Pack	

Following only required if a 6050 TrussMachine is Purchased		
Top Hat section 6050 (In addition to Site Minimum)	**Quantity Req**	**Qty Onsite**
1/2" Rattle gun	2 / Machine	
Socket	2 / Machine	
Spanners	2 / Machine	
Truss bolts (check page 16 for critical sizes)	1000	
Truss nuts & Couplers	1000 / 100	
Truss spacers	100	

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Panel Machine - 1 Phase 230V 50hz 3 Wire

HIGH RISK ELECTRICAL WORK

All electrical work must be carried out by qualified Electrical person. Installation should only be carried out with an un-livened supply. At no time do these documents supersede the electrical codes/regulations of the country/area in which the rollformer is to be installed. When performing the electrical installation procedures, safety must be the first consideration.

ELECTRICAL POWER REQUIREMENTS:

Voltage	220-240V
Phase	1phase +Neutral +Earth (3wire)
Frequency 50Hz	
Total Load Kilowatts	5.46kW
Full Load current	27.44A

This rollformer is designed for direct connection to Single phase 220-240V 50Hz +Neutral +Earth. (3-wire)

Satisfactory rollformer performance requires that the voltage remains within this range during operation.
The voltage dropping below this parameter can cause Drive error issues and faults.
A step-down transformer may be necessary to achieve this parameter.

The rollformer is designed for direct connection to a clean power supply
NO Power factor correction capacitors
NO Residual current Devices (RCDs)
NO step-up transformers

A 32amp 3Pole D curve motor rated circuit breaker or 3x32amp Motor rated fuses must be used to protect the equipment.

Suitable isolation must be provided when connecting the machine to your power supply.

If using an non-earthed ungrounded distribution system an isolation transformer with the secondary winding earthed is recommended to ensure the Active lines are electrically symmetrical with respect to Earth / Ground.

If the Rollformer is to be installed in such a location where it may come into contact with a metal structure, it must be equipotential bonded to that structure.

SUPPLY CABLE REQUIREMENTS:

IMPORTANT NOTE:
Undersize cable will result in volt-drop issues during operation. Volt-drop issue will result in Drive error issues.
The supply cable from your switchboard to the local wall outlet, plus the lead from that wall outlet to the machine's mains entry box, must be of sufficient cross-sectional diameter (gauge) to provide a constant 32amp supply at the rollformers mains entry box when the machine is operational.

It is necessary for your local Electrical Engineer to complete voltage-drop calculations with ambient temperature considerations to prevent volt-drop issues that can occur due to the overall length of the cable run. These calculations must include the lead from the wall outlet to the machines mains entry box.

In addition to performing this voltage drop calculation, the continuous current rating of the cable must be above 32amp.

Where the calculation indicates a cable size in-between standard cable sizing, it is our recommendation to use the larger size.

Panel Machine - 3 Phase 400V 50hz 5 Wire

IMPORTANT NOTE TO ELECTRICIAN :
THE 400V PANEL ROLLFORMER IS NOT A BALANCED LOAD, LINE 1 (RED) CARRIES THE DRIVE SERVO MOTOR LOAD

HIGH RISK ELECTRICAL WORK
All electrical work must be carried out by qualified Electrical person.
Installation should only be carried out with an un-livened supply. At no time do these documents supersede the electrical codes/regulations of the country/area in which the rollformer is to be installed. When performing the electrical installation procedures, safety must be the first consideration.

ELECTRICAL POWER REQUIREMENTS:

Voltage		400V
Phase		3phase +Neutral + Earth (5wire)
Frequency	50Hz	
Total Load Kilowatts		5.46kW
Full Load current		15 A

This rollformer is designed for direct connection to Three phase 400V 50Hz +Neutral +Earth. (5-wire)

Satisfactory rollformer performance requires that the voltage remains within this range during operation.
The voltage dropping below this parameter can cause Drive error issues and faults.
A step-down transformer may be necessary to achieve this parameter.

The rollformer is designed for direct connection to a clean power supply
NO Power factor correction capacitors
NO Residual current Devices (RCDs)
NO step-up transformers

A 20amp 3Pole D curve motor rated circuit breaker or 3x20amp Motor rated fuses must be used to protect the equipment.

Suitable isolation must be provided when connecting the machine to your power supply.

If using a non-earthed ungrounded distribution system an isolation transformer with the secondary winding earthed is recommended to ensure the Active lines are electrically symmetrical with respect to Earth / Ground.

If the Rollformer is to be installed in such a location where it may come into contact with a metal structure, it must be equipotential bonded to that structure.

SUPPLY CABLE REQUIREMENTS:

IMPORTANT NOTE:
Undersize cable will result in volt-drop issues during operation. Volt-drop issue will result in Drive error issues.

The supply cable from your switchboard to the local wall outlet, plus the lead from that wall outlet to the machine's mains entry box, must be of sufficient cross-sectional diameter (gauge) to provide a constant 25amp supply at the rollformers mains entry box when the machine is operational.

It is necessary for your local Electrical Engineer to complete voltage-drop calculations with ambient temperature considerations to prevent volt-drop issues that can occur due to the overall length of the cable run. These calculations must include the lead from the wall outlet to the machines mains entry box.

In addition to performing this voltage drop calculation, the continuous current rating of the cable must be above 25amp.

Where the calculation indicates a cable size in-between standard cable sizing, it is our recommendation to use the larger size.

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Truss Machine - 3 Phase 400V 50hz 5 Wire

HIGH RISK ELECTRICAL WORK

All electrical work must be carried out by qualified Electrical person.
Installation should only be carried out with an un-livened supply.

At no time do these documents supersede the electrical codes/regulations of the country/area in which the rollformer is to be installed. When performing the electrical installation procedures, safety must be the first consideration.

ELECTRICAL POWER REQUIREMENTS:

Voltage		400-415V
Phase		3phase +Neutral + Earth (5wire)
Frequency	50Hz	
Total Load	Kilowatts	8.95kW
Full Load current		27.9A

This rollformer is designed for direct connection to Three phase 400V 50Hz +Neutral +Earth. (5-wire)

Satisfactory rollformer performance requires that the voltage remains within this range during operation.
The voltage dropping below this parameter can cause Drive error issues and faults.
A step-down transformer may be necessary to achieve this parameter.

The rollformer is designed for direct connection to a clean power supply
NO Power factor correction capacitors
NO Residual current Devices (RCDs)
NO step-up transformers

A 25amp 3Pole D curve motor rated circuit breaker or 3x25amp Motor rated fuses must be used to protect the equipment.

Suitable isolation must be provided when connecting the machine to your power supply.

If using a non-earthed ungrounded distribution system an isolation transformer with the secondary winding earthed is recommended to ensure the Active lines are electrically symmetrical with respect to Earth / Ground.

If the Rollformer is to be installed in such a location where it may come into contact with a metal
structure, it must be equipotential bonded to that structure.

SUPPLY CABLE REQUIREMENTS:

IMPORTANT NOTE:
Undersize cable will result in volt-drop issues during operation. Volt-drop issue will result in Drive error issues.

The three-phase, Neutral and Earth supply cable from your switchboard to the local wall outlet, plus the lead from that wall outlet to the machine's mains entry box, must be of sufficient cross-sectional diameter (gauge) to provide a constant 25amp supply at the rollformers mains entry box when the machine is operational.

It is necessary for your local Electrical Engineer to complete voltage-drop calculations with ambient temperature considerations to prevent volt-drop issues that can occur due to the overall length of the cable run. These calculations must include the lead from the wall outlet to the machines mains entry box.

In addition to performing this voltage drop calculation, the continuous current rating of the cable must be above 25amp.

Where the calculation indicates a cable size in-between standard cable sizing, it is our recommendation to use the larger size.

Generators

If you cannot establish a permanent stable power supply, an Invertor type Generator is your best alternative.

The Rollformer and Decoiler are the only items to be connected to the Generator while the rollformer is running.

During operational phases, the Rollformer motors can have multiple start-up currents 6x the normal full load current.

Panel Machine - 1 Phase 230V 50hz 3 Wire

You will need to engage a local Generator supplier to complete calculations and recommend a suitably rated unit that can produce constant stable power at 220-240V 50Hz, has a constant running load capacity of 15kVA or above and is capable of sustaining the supply during the large start-up currents that are incurred during operation of the
rollformer.

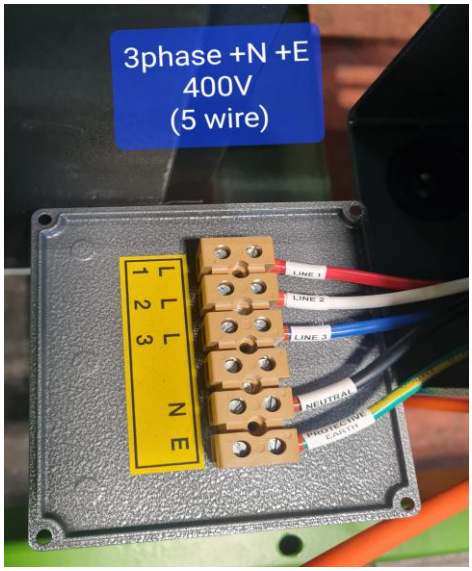
Panel Machine - 3 Phase 400V 50hz 5 Wire

You will need to engage a local Generator supplier to complete calculations and recommend a suitably rated unit that can produce constant stable 3phase 400V 50hz power and has a constant running load capacity of 15kVA or above, and is capable of sustaining the supply during the large start-up currents that are incurred during operation of the rollformer.

Truss Machine - 3 Phase 400V 50hz 5 Wire

You will need to engage a local Generator supplier to complete calculations and recommend a suitably rated unit that can produce constant stable 3phase 400V 50hz power and has a constant running load capacity of 15kVA or above, and is capable of sustaining the supply during the large start-up currents that are incurred during operation of the rollformer.

Electrical Connection



ELECTRICAL WIRING COLOR CODES (NEC & IEC) - 1 & 3 PHASE (AC)

www.electricaltechnology.org

PHASE SUPPLY	WIRE & CABLE	NEC - US / CANADA (120, 208 & 240V)	NEC - US / CANADA (277 & 480 V)	IEC- UK & EU	CHINA & RUSSIA (Old)	AUS & NZ	JAPAN	INDIA, PAK & SA
3-PHASE	LINE 1 "L1"							
	LINE 2 "L2"							
	LINE 3 "L3"							
COMMON	NEUTRAL "N"						*	
GROUND / EARTH "PG" or "PE"		Or						
1-PHASE	LINE "L"							
	NEUTRAL "N"							

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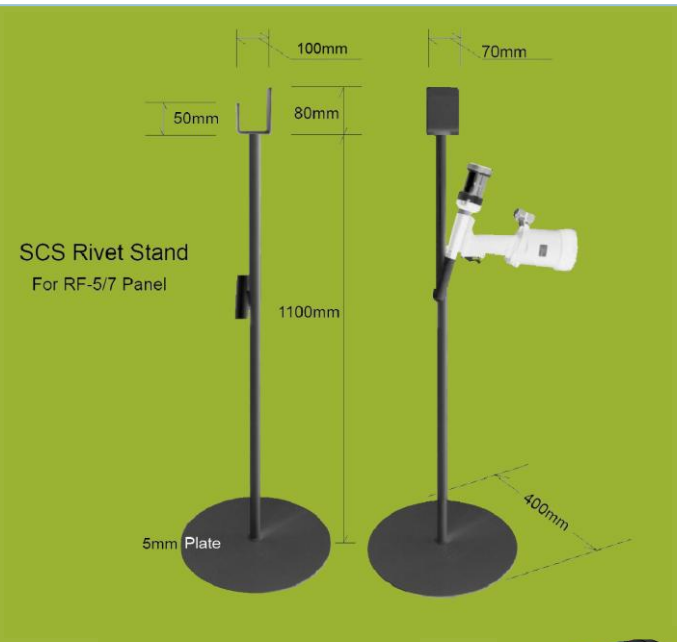
Stands

- Quantity, 8 x stands per team
- Height 1100mm or adjustable
- Round base preferred

Supplier

- Manufacture in house
- Local engineering company



Cordless Drill and Driver

- Max Torque: 150Nm
- Speed: 1,800 + RPM
- Weight: 2.6kgs
- Battery: 2.4 - 3Ah

Hex Head Tek Screw

- Self Drilling Metal Screw
- Full Thread
- Gauge 10, 16 tpi, 16mm length
- Hexagonal Driver Bit 7.9mm
- Finish: Galvanised

Hexagonal Driver

- 7.9mm (5/16)
- Short driver 50mm(2")
- Long driver 152mm (6")

Air Compressor

Specifications:

- Single phase 3 hp
- 250L tank or larger
- Fitted with regulator, outlet and tank pressure gauges
- Dryer is also recommended for longevity of rivet guns

Air Line Hose

- In-line oil filter fitted if available

Air Gun

- Use:
  Blow fine metallic particles away from tooling

Air or Battery Shear

- 6.7 CFM @ 90 PSI
- 3 lbs (1.36 Kilograms)
- Max cutting gauge 1.15mm
- 3 Jaw are best

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Tape measure

- Sturdy quality is best
- 5M—10M

Steel Tin Snips

- Length: 254mm
- Red and Green at minimum
- Brand Wiss Snips is highly recommended

Permanent Marker

- Used to write on steel elements
- Also comes in Chisel Tip

Gloves

- Used for loading coil
- Protects forearm from being cut

Safety Glasses

- Clear
- Comfortable

Frame Grommets

- 28mm Dia
- Hard plastic

Supplier

Sisa Industries

- 2/58 Loftus St, Riverstone NSW 2765

Coil

- Minimum 1000M
- 0.55, 0.75 or 0.95

Rivet Gun

- Rivet size: 3/16
- Stroke Length: 14mm
- Air Consumption: 4cfm
- Working pressure: 90PSI
- Net Weight: 0.8kg
- Air Inlet: 1/4"
- Air Hose: 3/8"
- Please ensure rivet gun has vacuum feature to hold rivets and eject the stem (Apex SR-2)

Supplier

- ToolFix (www.toolfix.com.au)

Rivet

Steel Body / Steel Mandrel

- SS 6-2 1.6 ~ 3.2mm grip range
- SS 6-3 3.2 ~ 4.8mm grip range

Supplier

- ARS (www.ausriveting.com.au)

Self Drilling Wafer Head

- Gauge 10, 16 tpi,
- Length: 16mm
- Full Thread
- Finish: Galvanised

Twin Head Magnetic Philips driver

- Double Ended
- Diameter 6mm
- 65mm length

Double ended Drill Bit

- Size : 5mm
- Used to drill out rivets
- Double ended for ease of use

Pneumatic Impact Wrench
Or Battery Impact Wrench

- Built-in torque regulator
- Socket: 1/2 inch

Spanner

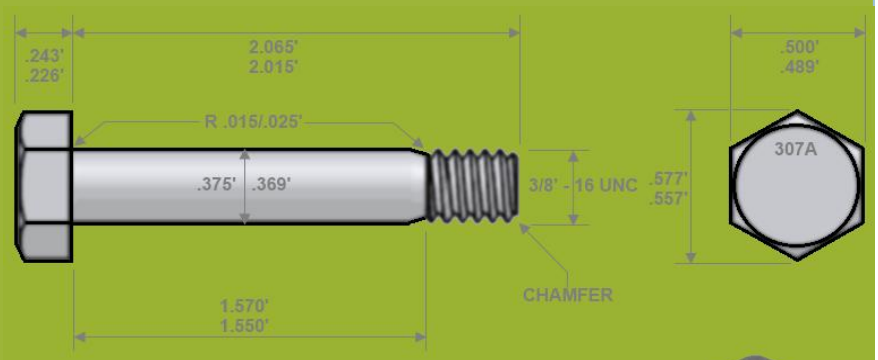
- Open end spanner
- Size: 9/16

Truss Bolt

- Model NC382AS
- Size: 3/8 – 16 X 2.065 hex
- Nyloc 3/8 – 16 Nut assembly

Supplier

- Fuji Fasteners



Truss Nut

- Nyloc 3/8 – 16 Nut assembly

Truss Coupler

- For making double trusses

Truss Spacer

- Compression tested material
- Material: Nylon

Supplier

- Fuji Fasteners
  (www.fujifasteners.com.au)

Recommended Items

Rivet Pouch

- Easily clipped off to swap from Rivets to nuts and bolts

Supplier

- Bunnings

Ear plugs

- Safety is #1
- Could also use Ear Muffs

Magnetic Broom

- Easy cleaning at the end of the day
- Easy to use and wheel around

Supplier

- Bunnings

Recommended Items

Strap Brace Tensioner

- M6 x30 T Bolt
- Used for tensioning Flat strap bracing

Supplier

- Pryda

Strap Bracing

- 0.75 - 1.15 x 30mm
- Tying down roof, ceilings, walls and connecting hanging ceilings from supports and general use

Supplier

- Coil supplier

Plating coil stock

- Plating lintels and lattice beams
- B250 - B400 Beams
- 1.15 BMT G350

Supplier

- Coil supplier

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Steel Coil Specifications

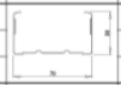
**** Always consult SCS representative before placing first coil order ****

Specification **A.S. 1397 :2001[8]**

Galvanised and Zincalume® coated steel

- **Coating weight & type**
  - **Galvanised** **275g/m² (Z275)**
  - **Zincalume®** **150g/m² (AZ150)**
- **Steel thickness range** **0.55-1.15mm BMT (Galvanised**
  0.55-1.15mm BMT (Zincalume
- **Steel grade range** **G550 for BMT ≤ 1.00mm**
  G300 for BMT > 1.00mm
  wall construction.

SCS Coil Width Chart

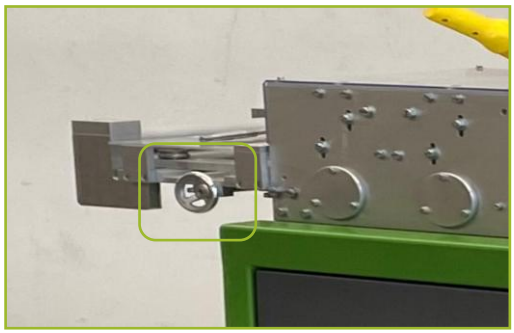
RF Model	Profile Width	BMT Thickness	Coli Width Mm	Kg/metre	Profile Shape	Tensile Strength
5 - Series Panel Rollformers						
5-090	90	.75	190	1.20		G250-G550
5-090	90	.95	190	1.53		G250-G550
5-090	90	1.15	190	1.85		G250-G350
5-140	140	.75	244	1.54		G250-G550
5-140	140	.95	244	1.95		G250-G550
5-140	140	1.15	244	2.36		G250-G350
7-Series Panel Rollformers						
7-063	63	.55	143	.66		G250-G550
7-063	63	.75	143	.91		G250-G550
7-070	70	.55	153	.70		G250-G550
7-070	70	.75	153	.95		G250-G550
7-070	70	.95	153	1.20		G250-G550
7-076	76	.55	156	.72		G250-G550
7-076	76	.75	156	.99		G250-G550
7-076	76	.95	156	1.25		G250-G550
7-090	90	.55	173	.80		G250-G550
7-090	90	.75	173	1.10		G250-G550
7-090	90	.95	173	1.39		G250-G550
7-090	90	1.15	173	1.68		G250-G350
Truss Rollformers						
6-038	38 square	.095	114	.92		G250-G550
6-050		.55	173	.80		G550
6-050		.75	173	1.10		G550
6-050		.95	173	1.39		G250-G550
6-075		.95	224	1.81		G250-G550
6-075		1.15	224	2.19		G250-G550
6-075		1.55	224	2.95		G300

Notes:

- Coil specifications table refers to Base Metal Thickness (BMT). (example: 1.15 BMT + Z275 coating (0.04mm) = approx. 1.20mm
- Material = Zincalume, Galvalume or G-90/275 gms/m² galvanised steel
- Coil must be un-oiled (dry) type
- Decoiler coil weight recommended no to exceed 850kgs, unless larger decoiler stamped with 1,500kg
- High tensile steel: G550 for .55 - 0.95mm thick steel
- Low tensile steel : G250-G350 for 1.15mm thick steel
- Steel Weight calculations: These may differ slightly depending on the supplier
- *Larger images of all profiles on the next page*

Step 1
Unscrew the steel frame from the base then unscrew the top and sides, and remove the plastic wrapping.

Step 2
Remove frame covers from front and back of machine (4in total).



Step 3
Key for frame covers can be found on the infeed adjuster handle.

Step 4
Using a fork lift or overhead crane lift the RF off the base. Being Careful of cables and hydraulic hoses, Machine must be picked up from under roll cage (As Pictured) NOT under bottom cross member of frame. Bolt the castors to the RF legs using the bolts and nuts supplied.