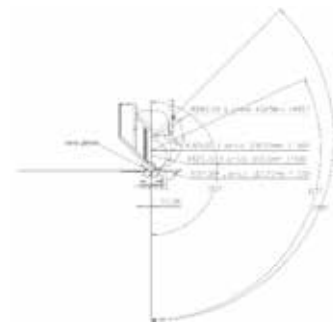


ROLLING BENDING MACHINE

DOUBLE BASCULE
POSITIVE AND
NEGATIVE BEND

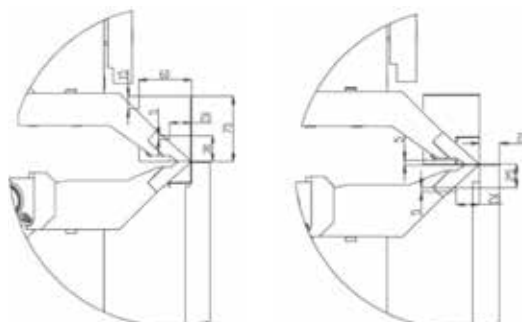
Production of various materials	Zinc, copper, zinc-coated and painted steel, painted aluminium, stainless steel
Worked thickness	From 0,4 mm up to 2,0 mm (based on the used material)
	On request thickness up to 4 mm
	1,2 mm max. for stainless steel
Size finished pieces	200÷12000 mm
Length machine	4, 6, 9 e 12 m
Opening in height of the blade	500 mm
Max. length for bending and rolling	12000 mm
Min. length for bending and rolling	200 mm
Standard bending width	600 e 900 mm
Special max. bending width	1250 mm
Max. total power motorization	22 kw
Max. power main hydraulic unit	22 kw

Calendering radius



Regulation system of roundness and of metal sheet thickness with mechanic indicator of precision.

Specification of bending



Bending phase

Positive and/or negative bend



Calendering phase

Calendering min. \varnothing 60 mm. max. infinity



Precision and repeatability (measures makeable on every straight section of the piece realized):

Length between two bend, length edge-bend (external measures) and length calendering arc			
Field of nominal length	0-100 mm	101-500 mm	>500 mm
Allowed tolerance	$\pm 1 \%$	$\pm 1 \text{ mm}$	$\pm 1,5 \text{ mm}$
Bending angle		Calendering radius	
Allowed tolerance	$\pm 1^\circ$	Allowed tolerance	$\pm 1 \%$

In no case is allowed that the machine makes abrasion, dents, or any other kind of superficial esthetic defects, even in the absence of removable protective film, on the metal sheet under processing (pre-painted or not and any kind).



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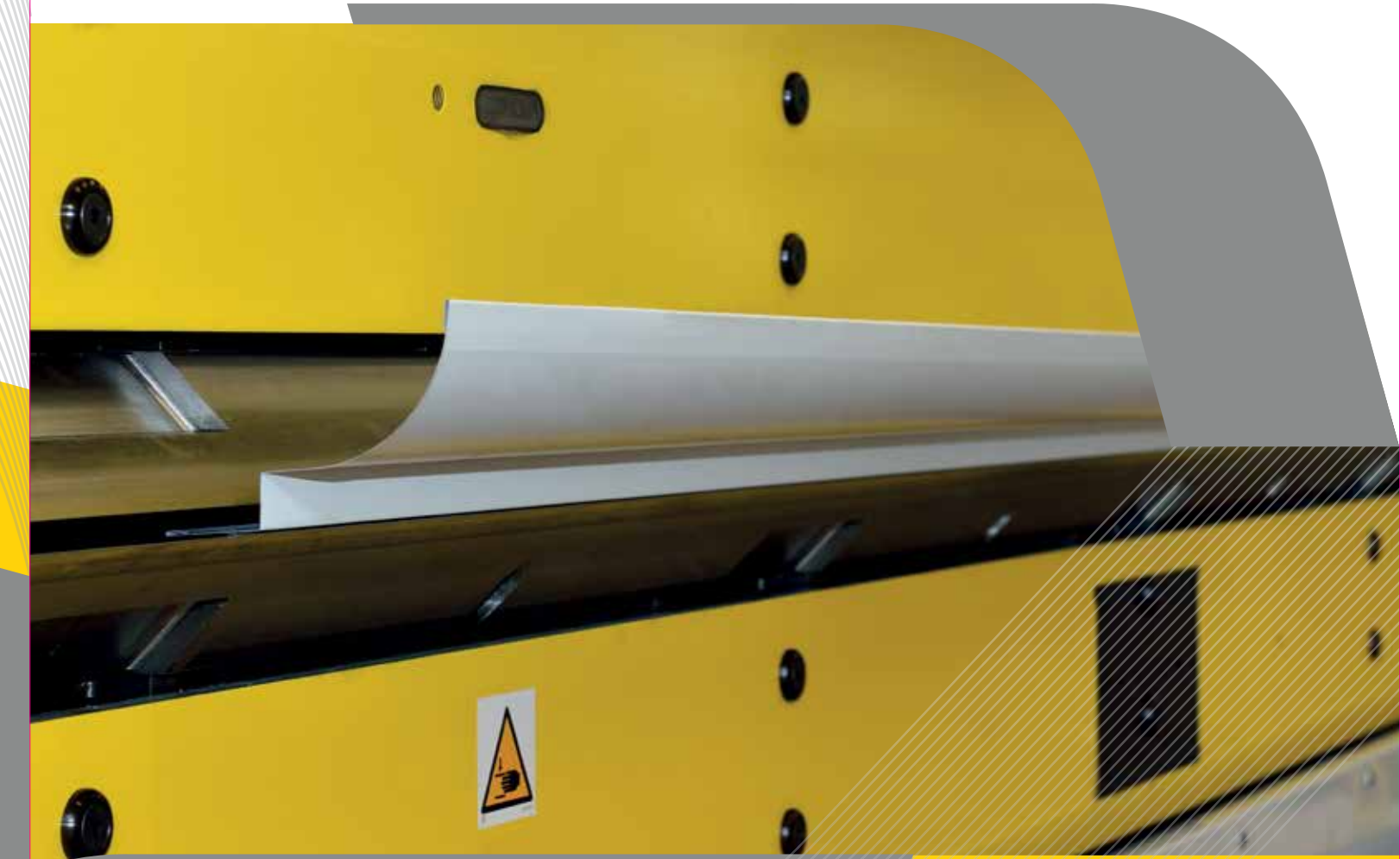
graphic project METROSTIC



ROLLING BENDING MACHINE

DOUBLE BASCULE

PATENTED MACHINE



ROLLING BENDING MACHINE

DOUBLE BASCULE



Plier with automatic positioning



- Automatic elaboration and optimization of calendaring/bend sequences based on the drawing of the piece as well as thickness and nature of material

- Automatic check of collisions and interferences with the machine, with the possibility to "authorize" bends or calendaring not verified

- Modality of management of handmade bends, with possibility to select the wanted bending angle and independently initial position of movable blade, matching parts and back clamps

- Modality of management of handmade calendaring, with possibility to select the radius of bending and length of wanted arc and independently initial position of movable blade, matching parts and back clamps

- Possibility to create a database of materials to automatically manage the elastic returning of bending and calendaring

- Memorization of the working program with all settings included

Machine control panel



Mechanical-welded structure. Metal sheet grasp through pliers with automatic placement for rolling and bending. Brushless motorization, rotation of the lower roller assisted with encoder and idle upper roller. Blade drop through hydraulic cylinder with fixed stroke. Adjustment of the press blade by means of a screw without clearance; the gripping hands are controlled by reducers, brushless motors to perform the taper of the sheets during bending and rolling. Table hold-metal sheet with brushes, steel pliers covered by special materials scratch-resistant to avoid that the metal sheet gets ruined. Hydraulic system with blank-holder on the bending blade. One fixed blade and one rotative blade, bascule type, to realize the bending at 135°. Complete CNC electronic regulation of the bend. Manually loading of the metal sheet from the front of the machine and automatic positioning of the pliers according to the data inserted on the program.



CONTROL PANEL AND PUSH-BUTTON PANEL

Installation with control panel complete with devices for the control of the electro-mechanic power, safety and automation.

- EQUIPPED OF PLC SIEMENS AND OPERATOR INTERFACE PANEL TOUCH SCREEN to visualize and set working parameters, visualization of alarms and machine conditions.
- INTUITIVE PROGRAM, EASY TO USE

