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Universal bending machine pdf

The bending machine is a forming machine tool (DIN 8586). Its purpose is to assemble the bend on the workpiece. The bend is made using the bending tool during linear or rotational motion. Detailed classification can be done using kinematics. [1] Universal bending machine for bending CNC bending machines with CNC flat material are developed for high flexibility and low adjustment times. These machines are able to bend individual pieces and small batches with the same accuracy and efficiency as mass-produced parts in an economical way. Universal bending machines – modular designs Universal bending machines consist of a basic machine that can be adjusted and used for various bends with little effort. A simple reusable system supports quick and easy tool change. The basic machine consists of a CNC-operated side stop, work bench, and software for programming and operation. Its modular design offers affordable input into bending technology, as after initial investment the machine can later be adapted and expanded without any conversion. This means that the base machine delivers bending stroke and the tool determines the type of bending. Bending tools 90° bending tool In the case of bending tools are classified by the type of bends generated. They may be designed to adjust the bend angle by reference, stroke measurement or angle measurement. The CNC machine usually abstains from the reference part. They provide high bending accuracy starting with the first workpiece. Standard bends Standard bending with universal bending machine All bends without extraordinary geometry are standard bends. The distance between the bend and the end of the material is quite high and provides a corresponding loading area. Same with one bend to another. Typical tools are so-called bending in combination with prisms with electronic angular measurement or ordinary prism. U-bending U-bends, where tight and narrow bends are required, the bending former is replaced by a bending mande. The bending mandv has a narrow geometry. Offset Bends Offset bends are used to build two bends with a small distance between steps. Edgewise Edgewise Edging Edge bending procrastinating bending tools are used when the bend axis is located parallel to the close side of the workpiece. Edge bending tools may include electronic angular measurements for high bending accuracy. Torsion bending torsion tools are able to rotate the workpiece on the longitudinal axis. Alternatives are complex assembly groups with standard bends. Angular measurement and suspension compensation For the production of individual pieces and small series with the same accuracy and efficiency as mass-produced parts, reverse catch compensation is useful. Bending accuracy +/- 0.2° from the first workpiece is achieved thanks to the calculated spring compensation and the use of electronic tools. Angular measurement Of Bending edge operating mode with electronic angular measurement technology are equipped with two flattened bending fats. That bold rotate when bending gives a signal to measure the angle. The measurement accuracy is about 0.1°. The computer then calculates the desired final stroke and the spring back of each bend is compensated regardless of the material type. With the first workpiece, high angular accuracy of +/- 0.2° is immediately achieved without modification. Compared to the reference treatment, the amount of waste from the material decreases, as irregularities within one piece of material are also automatically adjusted. Operating mode stroke measurement Wherever bending pristles with electronic angular measurement are not suitable, a small distance between bends may be the reason, bending pristles without electronic angle measurement are used. In this case, the control unit can be switched from angular measurement to stroke measurement. This method allows pre-selection of the stroke of the bending ram in mm and thus the depth of immersion of the punch into the prism. The adjustment accuracy is +/- 0.1 mm. The final stroke is usually not required. Further development of the lifting system allows the user to determine the angle from which the stroke is calculated using the stored stroke functions. The bending accuracy in this case depends on material properties such as thickness, hardness, etc., which may vary from workpiece to workpiece. Programming and principle of operation The graphical user interface of the bending machine Programming is carried out on a PC equipped with dedicated software that is part of the machine or connected to an external workstation. To generate a new engineering data program, you can import or paste it to your mouse and keyboard. Through graphical and menu-driven user interface previous CNC programming skills are not required. The software requires all necessary values and checks all images. Inputs can be corrected at any time and minimum distances are checked immediately to protect against incorrect inputs. The software automatically calculates the equal length of the bent part and determines the exact position of the side stop. Part of it appears on the screen. Ideally, each program is stored in a single database, making it easy to restore them with search and sorting features. Networking with the entire production line of networking of CNC machines Great organizational effort and interface management is stored when the CNC bending machine is connected to the previous and subsequent process. Corporate interfaces must be established to connect to other machines and external workstations. One software for programming subsequent production steps at once Using a standard industrial PC, you can easily connect different machines with each other with a shared database easy integration into an existing workflow system and backup on an external server import production data from other systems or construction programs (e.g. DXF files) Network with punching machine If the part is bent, in most cases the previous process tilted the holes for connection to the assembly group. Therefore, punching machine is an option. Some programs allow the operator to program step by step with one software tool. See also Bending Numeric control References ^ M. Weck, p. 112 M. Weck: Werkzeugmaschinen Maschinenarten und Anwendungsbereiche (VDI-Buch) Springer Vieweg Verlag, 6. Aufl. 2005 (2. August 2005), ISBN 3540225048 Taken from Image not available proColor: suitable for bending cold and hot metalsangle scale with the defined end stops up to 120° adjustable bending end stop for high repeat accuracy in the base for fixing the machine on the working table quick fixation system and stopping the end of the workpiece with various inputs to add to the comparison list datasheet Thoman Biegemaschinen ► Machines ► Machines ► Universal bending machines Universal bending machine multibend is capable of multiple bending processes. It can bend pipes and profiles by bending the press, bending the rollers or bending the rotation. All MultiBend bending machines are equipped with a horizontal, straight work platform and hydraulically operated lifting sleds. A precisely guided lifting saar is used to store a wide range of bending tools for pressing, straightening or folding. The powerful roller drive serves as a second workstation. Profiles and tubes can be bent flexibly and with different bending radii here, in the process of bending rollers. The third workstation is a rotary unit. It is possible to connect bending plates, tools for bending pipes and special tools. With the MultiBend universal bending machine, the hydraulic cylinder and all drives are installed below the working level. Optimal machine accessibility is guaranteed, avoid intrusive attachments. MultiBend is the ideal machine for all metal processing organizations that place high value on versatility and flexibility. It is possible to perform almost all bending work required in the field of metal working with one machine. Low investment costs and space requirements, together with high utilizing, are just some of the advantages of multibend universal bending machines. 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