

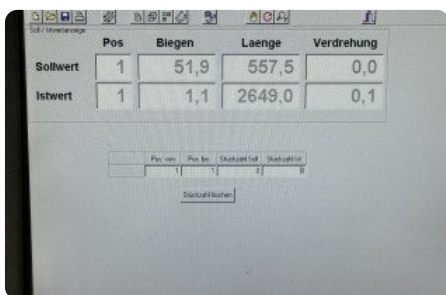
Rohrbiegemaschinen - Transfluid - DB 630 CNC - MACH-ID 8531



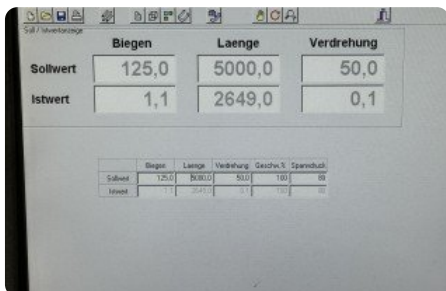
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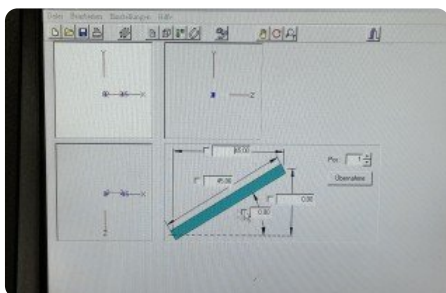
Hersteller Transfluid
 Typ DB 630 CNC
 Baujahr 1997
 Steuerung Transfluid



	Pos	Biegen	Laenge	Verdrehung
Sollwert	1	51,9	557,5	0,0
Istwert	1	1,1	2649,0	0,1



	Biegen	Laenge	Verdrehung
Sollwert	125,0	5000,0	50,0
Istwert	1,1	2649,0	0,1



Spezifikationen

Max. Produkt Ø	30 inch
Max. Wand Stärke	2 inch
Max. Biegeradius	180 inch
Max. Biegelänge	3048 inch
3 D Biegen	360 mm/min.
Min. Produkt Ø	4 inch
Min. Biegeradius	10 inch
Leistung	22 kW

Abmessungen

Länge	185.039 inch
Breite	55.118 inch
Höhe	59.055 inch
Gewicht	5734.6 lbs

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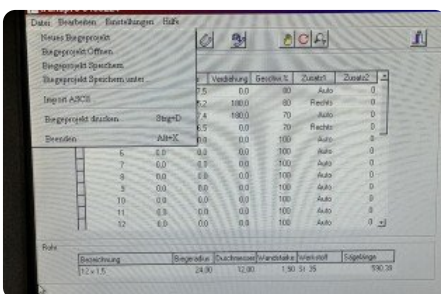
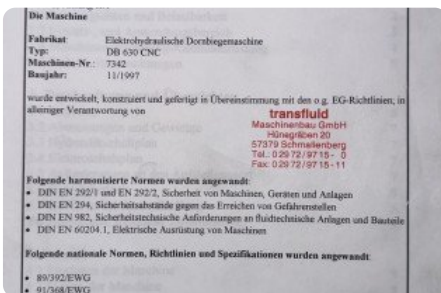
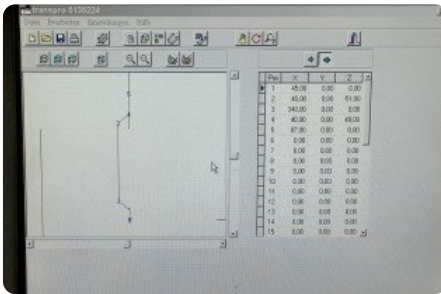
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Capacity:

– Round tubing mild steel	30 x 2,0 mm Ø
– Round tubing stainless steel	30 x 1,5 mm Ø
– Square tubing mild steel	20 x 2,5 mm
– Max. moment of resistance	1,18 cm ³
– Bending angle up to	180° + 10° spring back
– Bending speed	65°/ Sec.
– Speed of front feed	400 mm/sec.
– Speed of rotation	90°/sec.
– Accuracy of the bending axis	+/-0,2°
– Accuracy of the length	+/-0,1 mm
– Accuracy of the rotation	+/-0,1°
– Arbor length/Usable length	3048 mm
– Radii	max. 85 mm
– Bending height	1050 mm
– Power bending axis	electro-hydraulic
– Automatic positioning of the rotation and length	servo-electric
– All other axes (e.g. clamping, mandrel forwards/backwards, etc.)	electro-hydraulic

Machine equipment-/basic accessories:

- Compact, exposed bending head
- Bending direction clockwise
- With hollow shaft for using tooling for small radii
- Include wide opening pressure die, to allow the off set bend device with the long neck clamping to move directly behind the bending tool
- Attention: For each tube-Ø you need a separate collet
- For a correct positioning of the mandrel the machine is equipped with a mandrel support
- the machine is conform to the electric and mechanical security guidelines and the CE norm
- The emergency area in front of the machine is controlled via scanner
- Starting of operation via hand button
- With automatic tool resetting
- Manual operation
- Each function clamping on/off, mandrel forward/back, bending on/off initiated by selection and pressing of respective button (for proto type and sample production)
- Standard-norm-hydraulic components
- Machine stationary
- Colour RAL 3020 red, 7047 grey

Machine data:

- Including connection for external pressured air supply, 6 bar
- Nominal pressure 250 bar, Operating pressure 150 bar
- Operating voltage 400 Volt – 50 Cyl. – 3 Ph. 22 KW
- control voltage: 24 VDC
- Capacity of the hydraulic tank 70 Ltr.
- Length 4700 mm
- Width 1400 mm
- Height 1500 mm
- Weight approx. 2400 kg + control panel 200 kg

Control description:

- Fitted with 3-axis control of the bending angle, the rotation axis and the longitudinal movement in the different planes



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- The bending axis, the rotation axis and the length axis are coupled with each other, it ensues a permanent actual and nominal comparison also the control checks the tolerance and actuates further operations
- Integrated computer – IBM-compatible, current technology
- It ensues a permanent actual and nominal comparison on the screen
- User surface Windows
- Separate control element including Tozchpanel for setup and start of automatic cycle

Standard equipment CNC control:

- With max. 20 different positions of each tube, all positions are controlled in the PC program
- Possibility to store 1 Mio. tubes with 20 positions each under drg. numbers
- After input you can store the tube
- Storage of the drg. numbers according to WIN Standard
- If the control registrates a breakwown or faults, you can see in the screen via text
- The off set bend device moves to the front position for an easy input and output of the tubes

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