

**TRANSFER MACHINE TO PREPARE ELEMENTS FOR HOT WATER
WITH LOCAL ANNEALING, DOUBLE BENDING AND PRESSING OF
THE CURVES WITH A 30-TON PRESS**



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Automatic line studied and developed for processing and preparing resistances made of steel or copper with peculiar shapes suitable for electric appliances for producing hot water or heat exchangers.

The automatized multiple station transfer machine is made up of a chain with special holdfasts for holding the piece. Such chain, thanks to a jogging device, transfers the various resistances to the working units.

The loading of the piece is manual for the most complicated shapes, while it is effected by means of a manipulator in the case of resistances that are easy to handle.

The whole unit is made up of the following:

- 1 Supporting bench for transfer machine and all units.
- 4 Electric units for annealing with local resistance; with grasping pliers for the contacts and 50-kVA transformer, arranged on 4 station positions.
- 2 Units for double bending two opposed position.
- 1 Power-pack 30-ton press with hydraulic-pneumatic operation for pressing the double inner bend.
- 1 Power-pack 30-ton press (optional) for repressing the outer double bend.
- 1 Automatic unloading system on conveyor belt into a container.

All units can be quickly positioned when changing the length and the distance between the bending axes.

MAIN TECHNICAL CHARACTERISTICS:

Holdfast manual feed on the plane	no.	5
Wattage of the heating transformers	each KVA	50
Power supply	Volt	3x400-50 Hz
Pneumatic pressure	bar	6
Productivity	pcs/h	450/550
Resistance diameter	mm	6/ 8,5
Machine dimensions	mm	7500x2000x1600
Overall machine weight	Kg.	5800
Tooling time when changing model	min.	20/30

