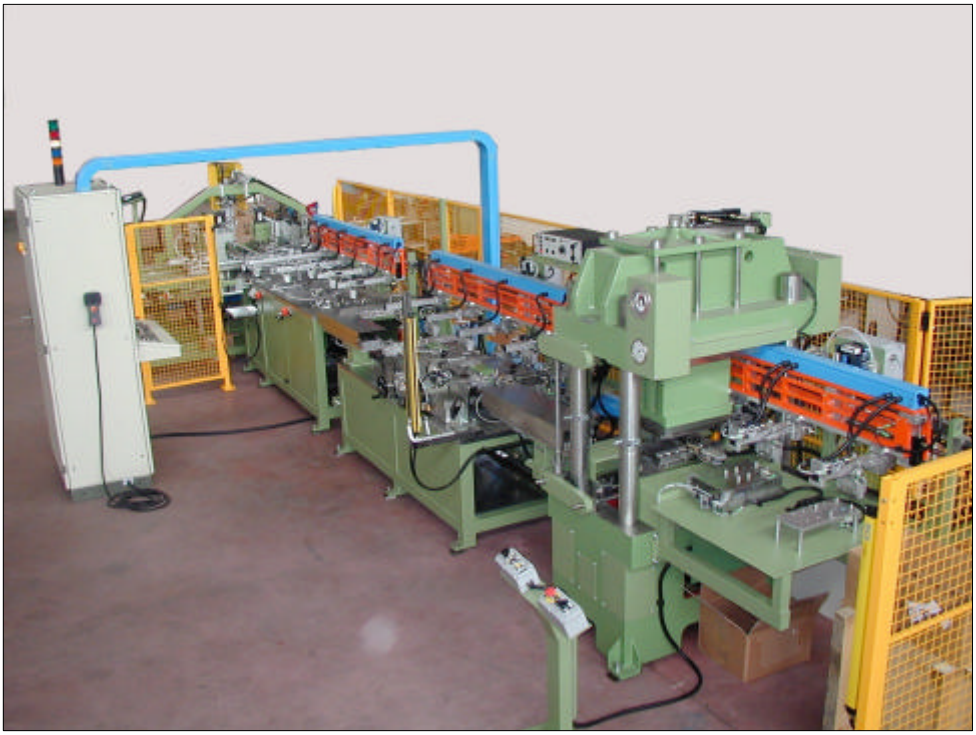
TRANSFER MACHINE FOR M-BENDING OF WASHING MACHINE RESISTORS WITH STRETCHING TO PREDETERMINED LENGTH, CONTROLLED RADIUS BENDING, AND REPRESSING OF INDENTED BENDS



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This machine has been developed from the previous OT-067 model for processing armoured heating elements for washing machines. The products of this process leave the machine as elements bent into an M shape, all of which have the exact same size, with the bends repressed so as to restore solid packing of the magnesium oxide inside the elements themselves. The new system for closing the radii also permits perfect parallelism between the branches of the M bend. Feeding of pieces into the machine is done automatically from a hopper with a pick-up unit, but the machine is also equipped with two intermediate manual loading inlets, so that certain operations can be performed even if the feed line module is not working.

The machine is made up of the following units:

- Hopper feed with a mechanical loading hand and a system for shaking the resistors, so that picking up by the pincers is facilitated.
- Oleo-dynamically operated unit for stretching resistors "to size".
- Oleo-dynamically operated M-bending system which bends the resistor rods in three phases: into a U, an N and then an M.
- Bend radius calibrating unit which has a system of internal and external forms which are interchangeable and can be calibrated according to a given model.
- Set up for the installation of an ohmic testing unit after the calibrating phase.
- Oleo-dynamic press for the repressing phase of the partially indented bends.
- Unloading hand which can be oriented to unload pieces horizontally or vertically.

All the units and their functions can be inactivated from the control panel which allows the operator to control all machine parameters from a visual display terminal. Operational self-diagnosis can also be effected from the control panel.

Possible addition of two end-cutting units placed opposite one other.

GENERAL TECHNICAL SPECIFICATIONS:

Electric power supply	V.	3x400+N, 50 Hz
Installed electric power	kW	20
Pneumatic power supply	bar	6
Average production capacity	pieces/h	550/600
Time required to adjust equipment for different model	min.	20 ÷ 25
Feeder capacity	pieces	about 500
Maximum bend repressing force	Tons	180
Length of straight resistors	mm.	500 ÷ 1300
Length of inside branch of bent resistor	mm.	60 ÷ 200
Resistor diameter	mm.	8 ÷ 8.5 ± 0.1
Thickness of resistor outer layer	mm.	0.4 ÷ 0.6
Maximum camber		0.5 ÷ 0.6 %
Hydraulic system capacity	total lt.	600
Dimensions	mt.	10x3x2,5H
Weight	Kg.	8000

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