



## Forming and bending in a single operation

The CNC-controlled Wecomatic principle provides the basis for forming

The structure of the CNC bending unit creates  
the process cost-saving combination

Short tubes with form, on the one hand, and max. 20° bend on the other are generated  
in the same operation without material loss (lost ends)

## Technical data

### Forming unit

- Tube diameter 20 – 200 mm \*
- Form length max. 100 mm \*
- Tube wall thickness max. 2 mm \*
- Axial stroke Ø 120 x 150 mm – 25 t
- Forming stroke with 7° max. in Ø 36 mm \*
- Radial stroke 8x oval x 60 mm – 27 t
- Pivoting inner and outer tool 67.5°  
(minimising of segment gap marks)
- Bending angle max. 30°
- Bending radius min. 1.5 x tube diameter
- Mean cycle duration: ~15 s

### Electrical equipment

- PLC Möller XC201
- 10.4" touchscreen
- „ON/OFF“ main switch
- Emergency STOP
- „ON/OFF“ control switch
- „Acknowledge emergency STOP“ illuminated switch
- „Affirm Start“ button
- CNC IO software, freely programmable
- Dataset for tooling and program
- CNC axis with inner and outer control modules
- Analogue absolute position sensor system, inner and outer
- Safety light curtain – Sick
- Foot pedal

### Machine structure

- Welded profile frame
- Bending unit designed as pivoting yoke of heavy profiles, pinned and screwed
- Vertical tool axis guided on precision slides on the yoke sides
- Bearing assembly on yoke saddle for absorbing vertical forces
- Bending cylinder between yoke and machine room, rotary bearing mount
- Low and high-voltage electrical unit
- Hydraulic unit fixed on profile steel frame
- Manually-adjustable bending radius
- CNC IO unit for vertical applications
- Quick-change flange for basic tool
- Quick-change system for expansion mandrel
- Quick-change interface for outer attachment tools
- Oil sump with treadplate
- Dimensions L = 2000; W = 1200; H = 2500 mm
- Emission sound pressure level: 78 dB (A)
- Colour of machine room – Ral 5010 gentian blue
- Colour of control units – Ral 7035 light grey
- Colour of forming unit – black and polished
- Weight approx. 1800 kg
- Controllable central lubricating system for sliding surfaces
- Lubricant level monitoring
- Oil level and oil temperature monitoring
- Filter dirt monitoring
- Grid with safety light curtain
- Foot pedal

### Hydraulic equipment

- Tank capacity 200 L
- Delivery capacity 115 / 80 L/min
- Pressure 220 bar
- Motor 2x 11 kW – connection 400 V / 64 A
- Control valves 24 V Bosch Rexroth
- Oil/Air heat exchanger 0.3 kW/C°
- Pressure accumulator

### Options

- Choice of colour
- Siemens electrical equipment
- Special voltage
- Pressure increase to 300 bar (up to +40% force)
- Connection for robot handling via RS232
- Profibus interface
- Digital absolute position sensor system SSI (up to -20% cycle duration)
- External piece counter (operating hours, quantity)
- Oil/Water heat exchanger
- Oil drip tray
- Pivoting inner and outer tool 60°
- Workplace illumination
- Status display
- Optical weld seam detection
- „Setup/Automatic“ key selector switch
- Foot pedal connected via Harting connector



# WECOBENDER-IO

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