



FACTORY FOR FENCE PANELS

MACHINE FOR BENDING PANELS – AUTOMATIC PRESS
ATP-10



Operational units of the machine

1. Preparation table
2. Working part (press)
3. Trolley for drawing panels

Welded panels need to be stored on the preparation table in front of the machine. Panels are taken from the table and carried to bending.

Welded reinforcement mesh is carried to the press for bending. Panel is mechanically fixed by its ribbing in its previously specified parts. The press consists of upper and lower beam. The lower beam is stable and anchored to the base. In front of the press is located stock with prepared welded panels. Inlet and positioning of the panels on the boundary delimiter is manual. Further process runs automatically, following the given program.

At the beams ends are positioned the carriers - guides for the upper beam vertical movement, propelled by hydro-cylinders. The bending tool – presser is positioned on the upper beam, and the other part of the tool is on the lower beam. Welded panel is manually inserted in the press when the upper beam is in the starting position i.e. when the press is open.



Bending is done by the mean of three wires (which are identified by their axial distance which is less than the others). Middle of those three wires is positioned in the tool using the guide and then the upper beam lowers down. Command for bending is given by the foot pedal.



Bending cycle runs according to the given program until the whole panel processing is finished. The press function is based on hydraulic principle. It is powered by the 5.5 kW hydro-aggregate. Raising and lowering of the beam is propelled by hydro-cylinders $\Phi 125 \times 120$ that are positioned at the beam ends.



Operation is, also, controlled by the computer that is placed in the electro cabinet.



Machine operation and maintenance is simple and safe. For reliable and safe machine operation, consider the following recommendations:

- Check the machine before start and clean the working surfaces by blowing with compressed air
- Strict attention that command for starting of panels bending should be given only after precise placing of panel in the tool and removing the operator away from the bending zone.
- Start the machine only when the panel is placed in the bending position.
- All the adjustments are allowed only when the machine is at rest.
- Machine has to be properly settled on the horizontally plane concrete surface
- Properly train the professional operator