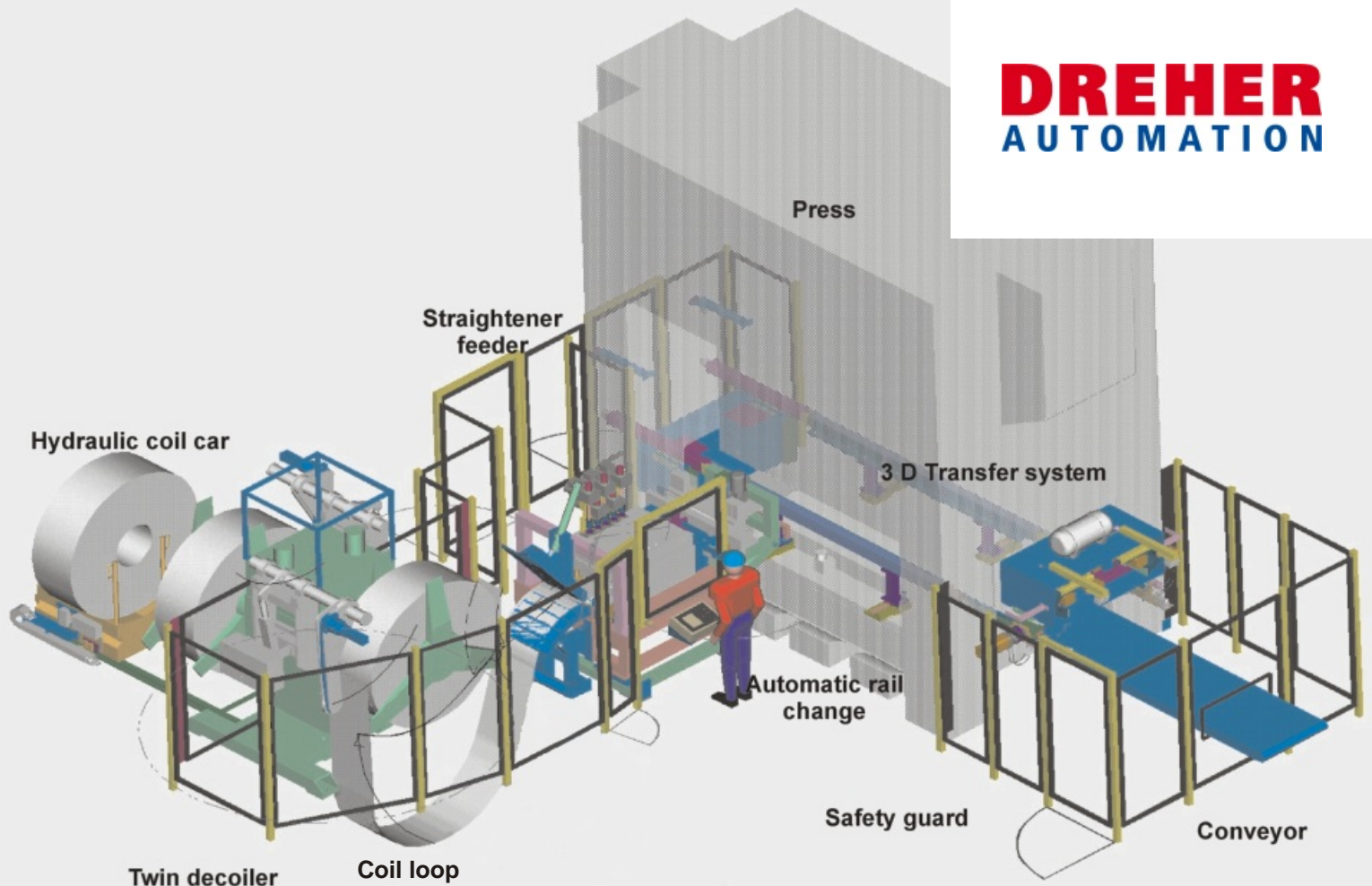




# COIL HANDLING LINE & 3 D - TRANSFER SYSTEM

WITH AUTOMATIC GRIPPER RAIL CHANGING



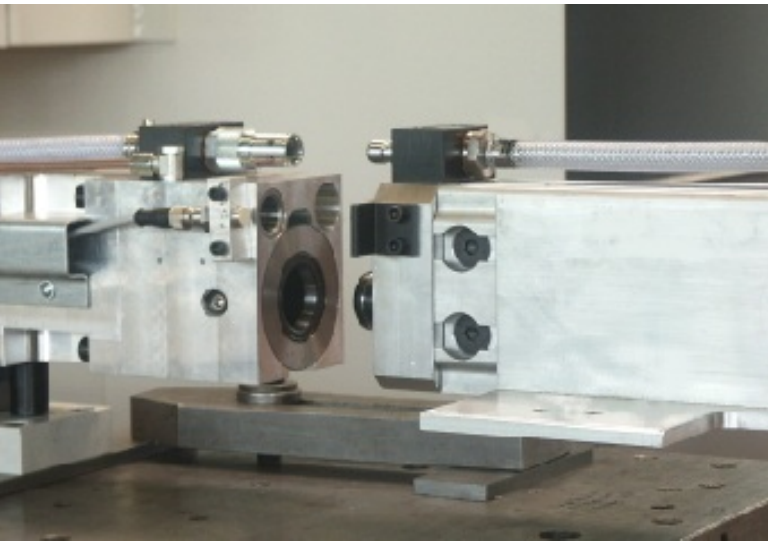
In the automotive supply industry plays fast and economical production by the often large quantities particular importance. A key factor for the economic profitability is the process stability and thus the availability of the machines and the equipment. Therefore it is necessary, to minimize the number of the interfaces. Therefore, the trend in the press automation is also, to purchase all components from a single source.

The Automatic-Systeme Dreher GmbH, specialized on the automation of processes in the metal forming, covering with its product range almost all sectors of the press automation.

Coil handling equipments in the short and normal design belong to its product range, just as transfer systems for sheet metal forming as well as for cold warm and hot forging. Further core business area of Dreher includes cut-to-lengths lines, destackers and feeder. The product range is complemented with hydraulic decoilers, pneumatic feeders, lubricating units, quick-die-changing systems and flexible punching and bending machines. Additional customer-specific components, such as robotics, welding equipment, marking units, etc. can be integrated in to the production lines.

In a concrete requirement, Dreher GmbH provided a coil handling equipment and transfer system in combination to an automotive supplier.





### Coil handling equipment

The coil handling equipment in short design is fitted with a twin decoiler with 2 x 45 kN load capacity and a coil width up to 665 mm. In addition, with a hydraulic coil car equipped, the times of coil exchange is minimized. A hydraulically adjustable coil feed in aid makes the load of the coil material easy for the operator. In addition, a rest coil driver unit provides an optimum utilization of the coil material.

### Transfer system

The 3D CNC transfer system is freely programmable and allows the input of the feed length of 0-650 mm. The input area of the lifting is from 0-100 mm, with additional kneeling of 30 mm. The closing of 0-150 mm can adjustment in the range of 75 mm per side completely asymmetrical.

The customer specific inputs as e.g. die data, lubrication, tool positions, etc., are entered via the visualization on the touch panel.

To secure a production process, in the transfer gripper rails are the pneumatics supply with 8 direct outputs integrated. The selection of the required modules and functions are also on the visualization. Errors and interferences are on the screen with the appropriate die..

### Automatic gripper rail changing

The transfer rail centre pieces can be put down and docked at die change by key press, from one operator. The transfer rails are put down on the press console table via lowering down of the rails and are safely locked. The second die sliding table with the preliminarily put up transfer rails, which are also on the press console table fixed, shortens the tool change to about 10 minutes. Such short die change periods allow several die changes in a day and to produce medium and small quantities in economic terms fully automatic. For the increasing model range in the automotive and supply industries such forward-looking investments are inevitable. These secure and maintain the competitiveness of local companies and guarantee the continued existence of the manufacturing base. In order to produce safety, all couplings on the tools and the transfer system are electronically monitored and enable a safe and trouble-free production.

Another pleasant side effect arises in work safety. The automated and non-contact die changing prevent accidents and provide simultaneously for greater planning reliability.

