

Control systems

MA, PT-1

Our wide range of control systems is to allow the customers to choose the cost-optimal machine configuration, considering what the customer will produce. Standard machines are supplied with manual folding angle under the name MA, except for the MAXI PLUS machine in which the standard is control system NT1. Other types are like the options that the customer can choose when ordering the machine.



MA

- manually adjust the angle
- normally on the left side of the machine

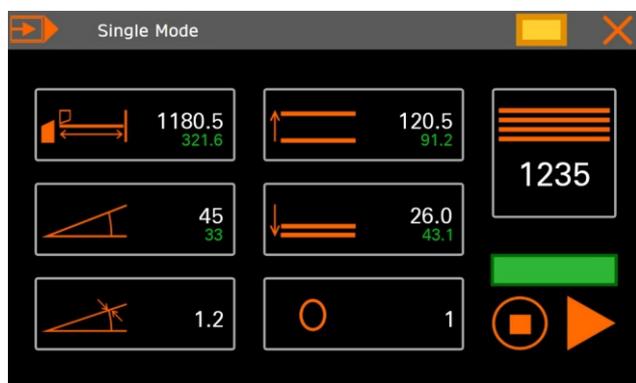


PT-1

- manual angle adjustment via potentiometer
- located on the right side of the machine (convenient for especially longer machines)

Control systems

NT1, NT3, NT5

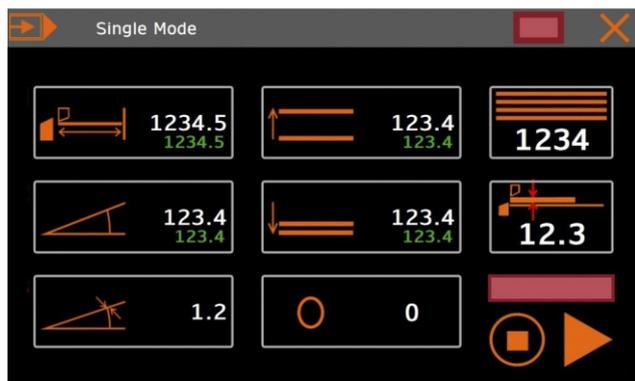


NT1 (Schneider) – one axis control

- 7" colour touch screen
- user-friendly and intuitive operation mainly via icon menu
- entering of the folding angle and correction
- only control system without back gauge
- profile programming with memory for 49 profiles, each with 20 folds
- possibility to extend control with simple steps to 3-axis NT3 control without the need for control system change
- cooperation also with servodrives
- jog mode, manual control of one axis
- profile names (both verbally and numerically)
- work with profiles as well as individual steps in the profile (deleting, inserting steps)
- backup profiles to USB stick

Control systems

NT1, NT3, NT5



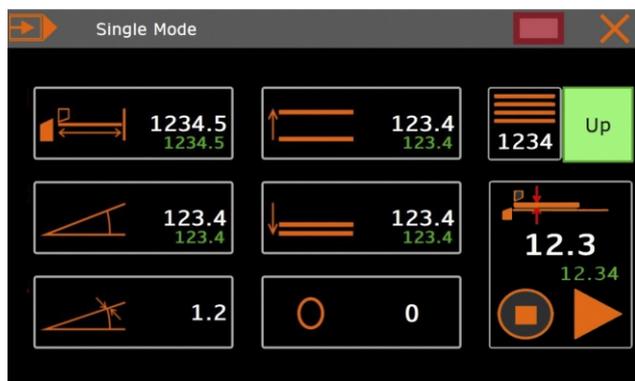
NT3 (Schneider) – three axis control

- 7" colour touch screen
- user-friendly and intuitive operation mainly via icon menu
- entering position of the back gauge, folding angle and correction, position of the clamping beam
- profile programming with memory for 49 profiles, each with 20 folds
- radius function
- hemming function (closed, open or teardrop)
- cooperation also with servodrives in three axes
- jog mode, manual control of three axis
- profile names (both verbally and numerically)
- work with profiles as well as individual steps in the profile (deleting, inserting steps)
- backup profiles to USB stick



YouTube

Video of control system NT3



NT5 (Schneider) – five axis control

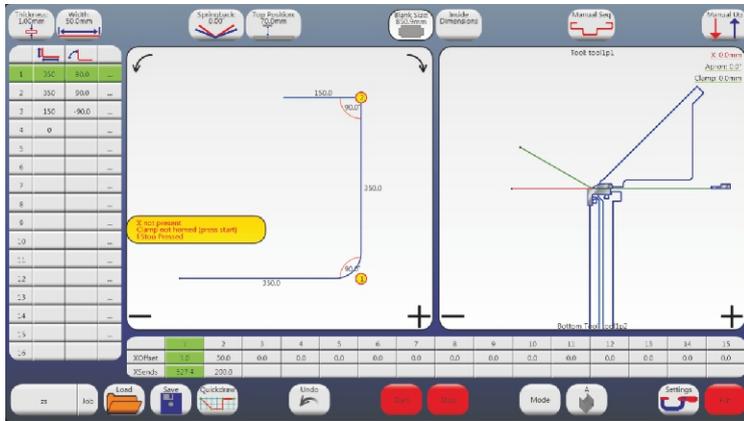
- 7" colour touch screen
- user-friendly and intuitive operation mainly via icon menu
- entering position of the back gauge, folding angle and correction, position of the clamping beam
- control motorized movement of position folding beam depending on thickness of material
- profile programming with memory for 49 profiles, each with 20 folds
- radius function
- hemming function (closed, open or teardrop)
- cooperation also with servodrives in five axes
- jog mode, manual control of all axis
- profile names (both verbally and numerically)
- work with profiles as well as individual steps in the profile (deleting, inserting steps)
- backup profiles to USB stick

NEW

Control systems

FF101

Touch and go



Control system FF101

This universal control system can be used for all kinds of motorized bending machines made by company.

It uses the latest technology in the field of control, resulting in an easily programmable system controlled via the touch screen.

The advantage is its ease of use, ease of preparation of the programme, while the less qualified person may handle the programming and control of the machine after two hours of instruction learning.

PROPERTIES OF THE FF101 SYSTEM:

- 21,5"LCD touch screen colour monitor
- newest Microsoft Windows
- graphics mode
- graphical representation of bending sequences for the selected programme
- graphical display of the position of the material before bending
- verbal and graphical display steps
- correction of the profile by direct contact on the desired part of the profile
- each operator can have their own password to enter their library
- powerful diagnostics
- inserting a different angle corrections for various materials
- correction of the bending angle (suspension) for the entire programme or for each bending angle

- control of the size of the opening of the clamping beam for the entire programme or just some steps
- bending radius
- edging
- linked profiles
- extended length of the profile directly on the main screen
- a list of the bending sequence
- a possibility to draw the profile, measure and change angles and lengths, select the points in the line of folding and visual inspection before folding the profile thanks to the split screen
- USB connection to the conservation and loading programmes
- off-line programming from the office
- search profiles by name, sketches profiles
- the ability to save more than 5,000 programmes in Memory
- optional programme names (names of profiles)
- languages: English as a basis (other languages on request)

The FF101 control system provides for the control of d.c.motors.



YouTube

Video of control system FF-101



H.M. Transtech spol. s.r.o.
Volgogradská 13/B, 080 01 Prešov, Slovakia
tel.: +421 51 7718 516
e-mail: sales@hmtranstech.com



Control system

Standard position



The standard position of the control panel

- on the right side of machine
- ergonomically placed control touch panel
- fixed position of control system



Control panel on the console

- suitable for lengths over 2 m (optional)
- positioning of control system according to the needs of machine operator
- optional for control systems NT1, NT3, NT5 and standard for FF-101

Adjustment of folding beam



Manual adjustment of folding beam

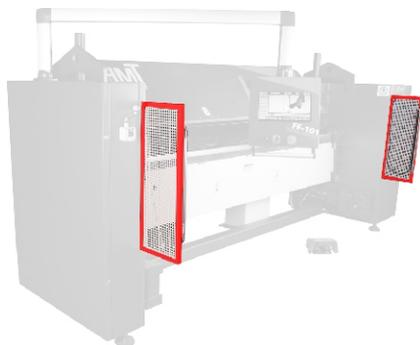
- change position of folding beam by the adjustment screw
- cost-effective solution, suitable for operations when it is not often change the position of folding beam



Motorized adjustment of folding beam

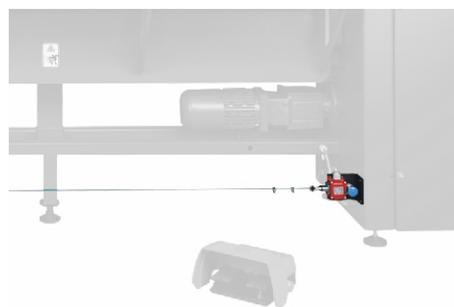
- change position of folding beam by the motors
- speeds up work with different thicknesses of material
- available for TVM, MAXI a MAXI PLUS model with control system NT5

Extra safety systems



Safety light barrier

- machine automatically stops if person moves into the safety area of the machine
- with control system FF101 as special equipment for everyone machine



Safety wire barrier

- security wire attached under folding beams
- folding beam will be stop immediatly after operator touch the wire

Manual back gauge

A cost-effective solution for simple applications that do not require frequent readjustment. Hand stops are equipped with the rack - pinion system and the position indicator, which the operator can adjust



MPD

- manual back gauge with the transfer rack - pinion system and counter, complete with thumbs and grooves in the table
- range of motion of 10 mm - 760 mm, or 10mm - 1,000 mm or 10 mm - 1200 mm

MOD

- manual back gauge with the transfer rack pinion system, counter and stop rail
- range of motion of 80mm - 760mm, or 80mm - 1000mm or 80mm - 1200mm

Motorized back gauge

Standard full table



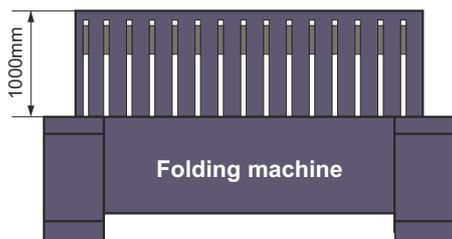
MZD

Motorized back gauge is used for positioning the material in the correct position without being held by the operator. The back gauge drive is provided by one or two ball screws and accurate control. The front abutment surface (fingers) are optional depending on the thickness of fold and customer requirements They can be supplied as folding fingers or twisted fingers made of spring steel.

The storage area of the back gauge can be equipped as needed by ball nests, side guides left or right. For machines with the MZD is use of one of controls is required NT3, NT5 or FF 101.

Standard back gauge with 1m range, machine operated only from front side.

Range 1,5m, 2m, 2,5m and 3m as special accesories.



MZD SP

Motorized back gauge with standard folding fingers. Range of motion 6 to 1000mm (1500mm, 2000mm, 2500mm, 3000mm)



MZD OP

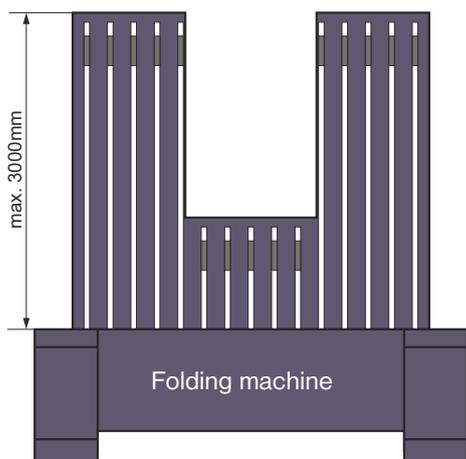
Motorized back gauge with twisted steel plate fingers. Range of motion 2 to 1000mm, 1500mm, 2000mm, 2500mm, 3000mm.

Motorized back gauge

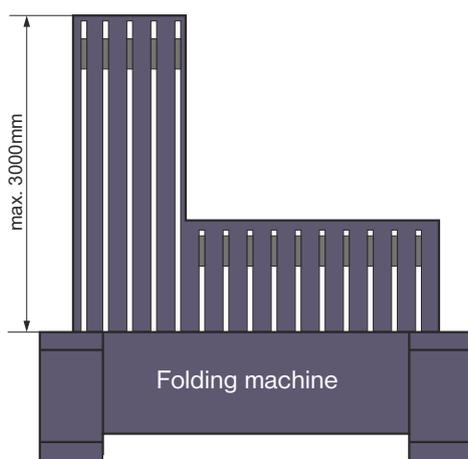
U, L, J, T shape

For handling large-size products such as panels, cabinets, etc. It is appropriate to use rear stops that allow for easy handling and attendance by the machine operator. There are stops of L, U and J types with multiple sections of pneumatically operated fingers.

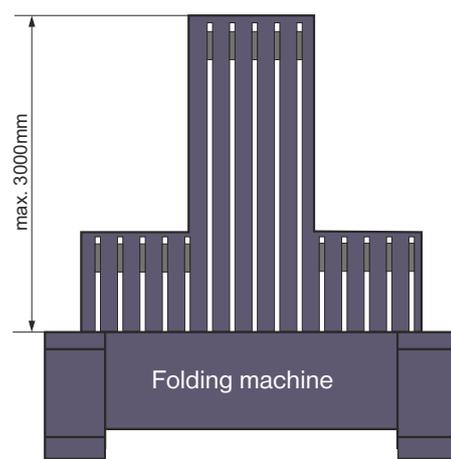
These special stops are supplied according to the customer requirements in the length of max. 3000mm. Motorized back gauge U, L, J, T share are delivered only with FF101 control system.



U shape



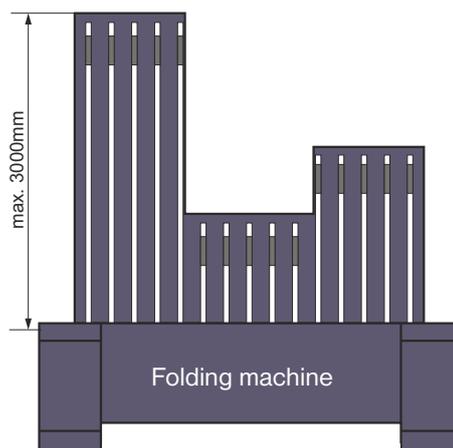
L shape



T shape



Back gauge J shape, with two sections and motorized folding machine Maxi 30/40 DUO FF-101



J shape



Squaring arm (for motorized back gauge)

- mounted on the right, left or both side of the back gauge
- as special accessories



Balls or brush for back gauges

- integrated ball or brush for easy transfer folding material



Foot pedal

- two control pedals with function " STOP production"
- as standard equipment for all machines
- for machines 4m and longer second pedals as standard equipment



Rotary shear K0,8

- rotary shear up to material 400Mpa and thickness 0,8mm
- after lock clamping beam easy manually cut material
- as special equipment only for UNI and UNIM machine with blade on all three beams



Marking of segments

- marking segments with width in mm
- faster and more transparent work with tools



Tool cart

- allows organized storage segments in the case of frequent replacement
- the cart is portable on wheel



Welded frame for transport

- we recommend for transport folding machine with motorized back gauge as one unit on metal pallet with additional price
- simplifies manipulation the machine during transport and installation