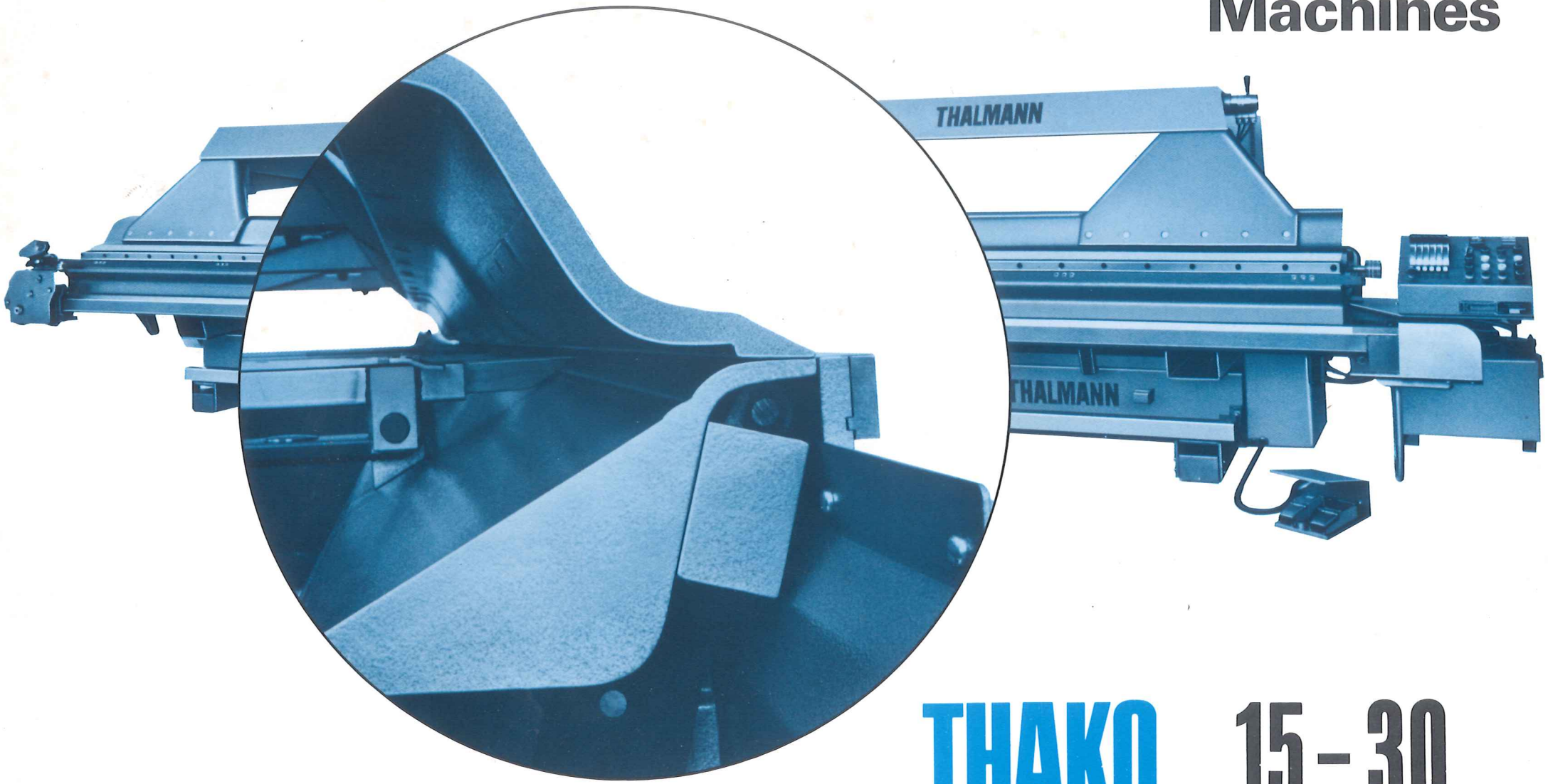
THALMANN

Combination Long Length Cutting and Bending Machines



THAKO 15 - 30

Features and Description

General

The machines are of neat welded construction, sand-blasted, primed and finished with two-component hammered enamel, colour blue. The heavy, stable base of the machine with built-in levelling device, enables the entire machine to be re-adjusted at any time.

Controlled bending apron and upper clamp beam

The bending apron as well as the upper clamp beam are operated hydraulically via separate shafts, which ensures that the tasks of clamping and bending are correctly performed. This mechanical control system opens and closes the upper clamp beam exactly parallel at all times, the bending apron being stabilized to prevent twisting, so that even short lengths can be produced without any difference in the angle of bend.

Shaping of profiles

The unique combination of supporting beam, bending apron and clamp beam, as well as their design suitable for profiles, enables complicated shapes to be manufactured.

Freedom from wear

The bearings of the drive shafts are made of bronze. The other bearings, exposed to wear, are case-hardened and ground. Lubrication is by means of oil atomizers.

Operating mechanism

The machines are operated by reliable BOSCH hydraulic equipment. Two-stage solenoid valves ensure that the upper clamp beam and the bending apron are operated almost entirely free from impact.

Parallel stop

The multi-purpose parallel stop can be augmented by self-made graduation stops, as desired.

Setting the upper clamp beam

For processing sheets of different thickness or for bending different radii, the upper clamp beam can be rapidly and accurately positioned over the entire working length by means of levers.

Operating the upper beam

The upper beam is operated by a pedal switch, the position of which can be varied to suit the operator. This leaves both hands free for shifting and measuring the sheet.

Operating the bending apron

The bending apron is operated by pressing a button on the control unit. Automatic lowering of the bending apron down to the zero mark, as well as the adjustable opening of the upper beam, are selected by means of a rotary switch.

Automatic cutting

The automatic longitudinal cutting head runs along the bending apron, its guide rail being recessed therein. No time for resetting is required for either cutting or bending. Just as for bending, the sheet to be cut is clamped in the machine and the cutting operation is performed when the button is pressed. The head returns to its initial position and stops there automatically. The cutting blades are of special highgrade steel and have a long useful life.

Programme of the bending apron

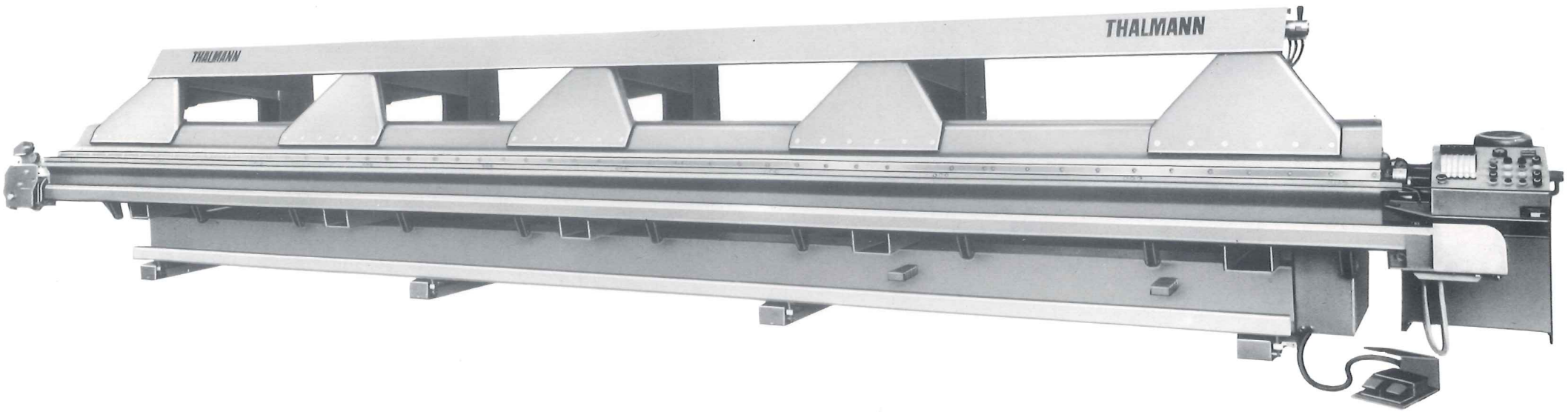
The operating system for the bending programme, which can be switched on and off in six stages, allows various programmed angular settings of the bending apron to be obtained, and with the coupling to the automatic opening controls of the upper clamp beam, is a feature which enables identical sheet profiles to be produced rationally. No tools are needed for setting the multiple programme.

Electrical equipment

The electrical equipment with contactor control, conforming to EURO standards, in accomodated in an easily accessible cabinet at one side.

Safety precautions

The accent is definitely on safety in THAKO bending and cutting machines. The machine has to be switched «on» and «off» by a key-switch. A main switch disconnects all phases of the supply from the machine. On the control unit there is a mushroom-head emergency stop, while down the entire length of the working side of the machine there is an emergency foot-bar, provided as standard, which immediately stops the machine. Electrical interlocks to prevent maloperation of the machine and its movements are completely and comprehensively provided in the interest of workshop safety.



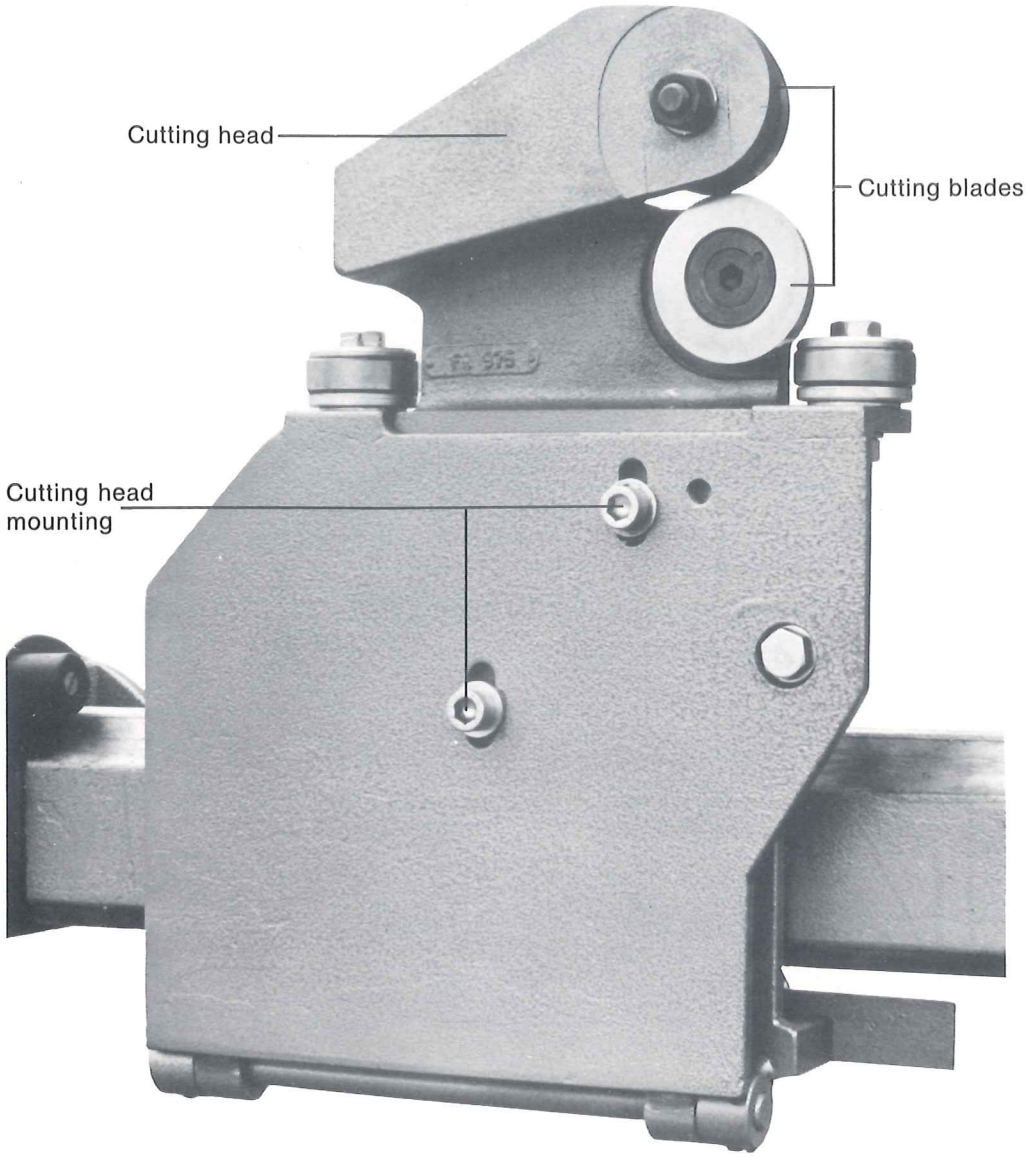
THAKO 15 — 8,20 m

Technical details:

Working length	8200 mm
Projection	1060 mm
Width of bending apron	15 mm + extra rail
Opening of upper beam	max. 135 mm
Bending capacity	1,5 mm mild steel sheet / 2,0 mm Al
Cutting capacity	1,5 mm mild steel sheet / 2,0 mm Al
Supply voltage	3 phase A.C. supply
Control voltage	24 volts d.c.
Weight of machine	5150 kg
Floor space occupied	10,0 x 1,8 m

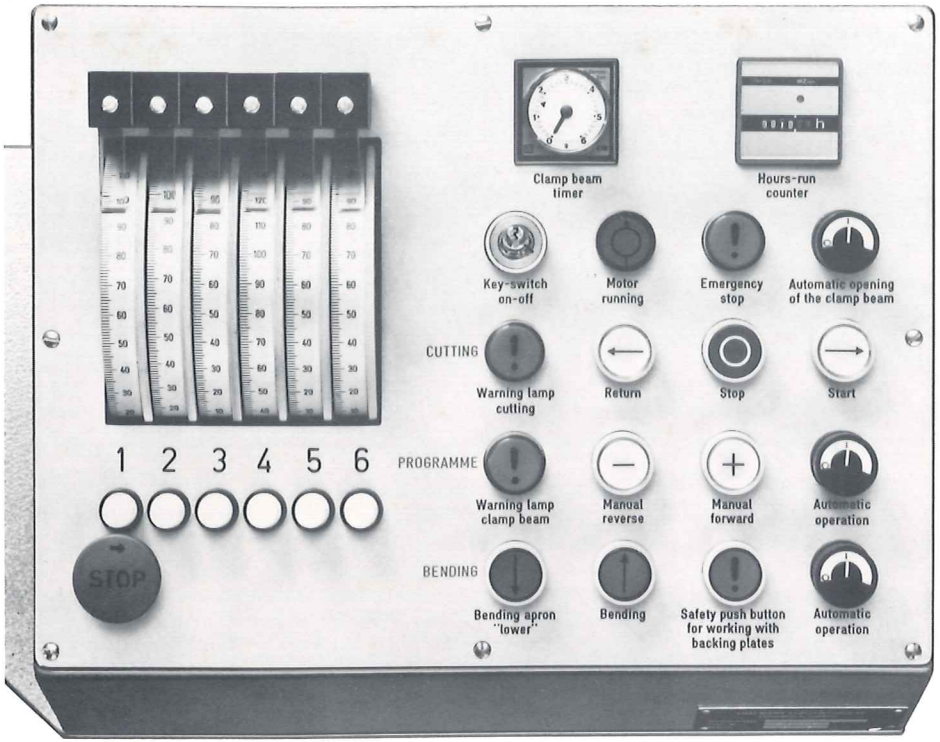
Standard equipment:

- Complete electrical and hydraulic system
- Three-phase main switch
- Automatic cutter mounted on the bending apron
- Parallel stop
- Multiple program (six-stage) for the bending apron
- Automatic operation of bending apron and upper beam
- 12 mm extra rail for the bending apron
- Safety features
- Tool tray containing equipment for maintenance of the machine
- Hydraulic system filled with the required amount of oil
- Operating instructions containing capacity table

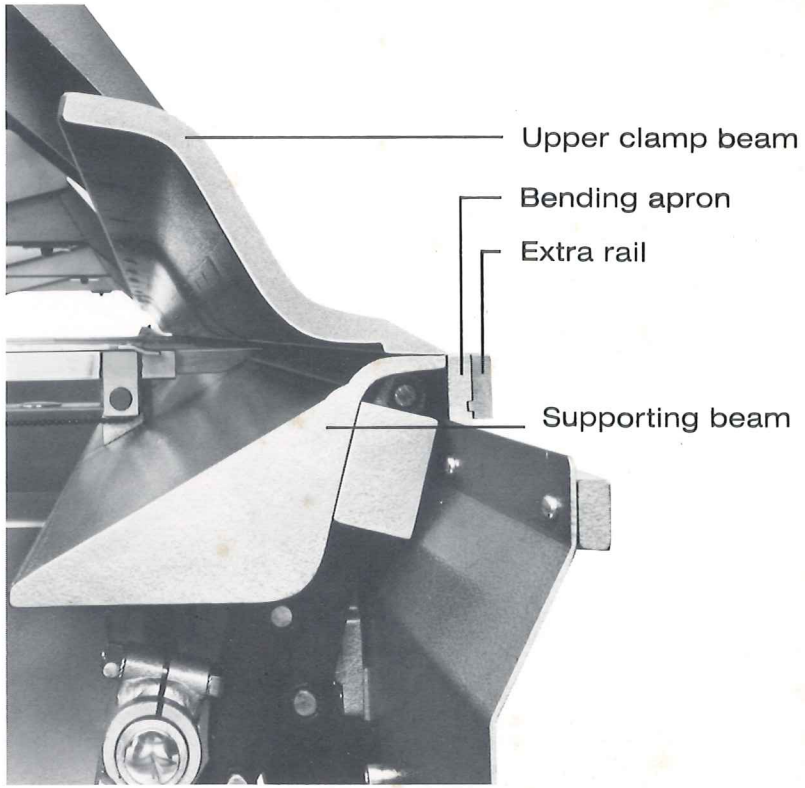


Cutting assembly of the automatic cutter

The assembly is on the left when in its position of rest, i.e. outside the bending range. The cutting head with its blades is attached to the cutter carriage by means of two screws. When the blades are worn, the whole head has to be replaced by the reserve head. The blades are of hardened high-speed steel and have a long working life. All listed materials can be cut with the same blades.



Control unit



Side view

Supporting beam, Upper beam and Bending apron

THALMANN

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