

Title (en)
Method and apparatus for automatic bending of metal sheets

Title (de)
Verfahren und Maschine zum automatischen Biegen von Blechteilen

Title (fr)
Procédé et machine pour le cintrage automatique de tôles métalliques

Publication
EP 0914879 B1 20040512 (EN)

Application
EP 98119190 A 19981012

Priority
IT MI972453 A 19971031

Abstract (en)
[origin: EP0914879A1] A method and apparatus for automatic bending of metal sheets. The apparatus comprises a support frame (23) provided with longitudinal guides (21) parallel to the front side of a bending press (10) for relative movement of a first and second manipulators (19, 20). By means of the first manipulator (19) a metal sheet (50) is taken from a loading zone (36), and positioned between the mould members (13, 14) of the press (10). A first step of the bending cycle is performed on the sheet (50) by means of the first manipulator (19), while the second manipulator (20) remains on stand-by. After the first bending step has been performed, the partially bent sheet (50) is taken by the second manipulator (20) to complete the bending operations on the same sheet (50) which at the end of the working is released in an unloading zone (37), while the first manipulator (19) picks up a new sheet (51) to be bent. Dead times for the press (10) are in this way eliminated in that the operations for picking up and releasing a bent sheet by the two manipulators (19, 20) take place in a masked fashion. <IMAGE>

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Cited by
CN110167718A; EP1681111A1; NL1028129C2; US11278951B2; US6938454B2; CN114206522A; US2022314298A1; JP2022543096A; CN114502295A; JP2023502316A; WO2018121838A1; WO03095125A3; WO2012019220A1; WO2021016646A1

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