

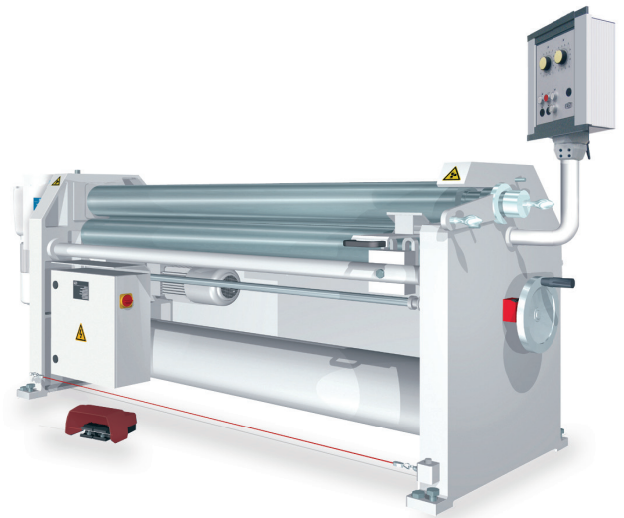
MOTORIZED SLIP BENDING ROLLS
134 / 136

The motorized slip bending rolls 134 and 136

Prerolling and final rolling in one machine – thanks to its special roll concept, wide range of accessories and robust design, this is the machine for truly universal and cost-effective work on single jobs and in series production.



134 with CR 80-control



136 with FM 2-control

The easy way of prerolling and final rolling with the motorized rounding machines of Schröder-Fasti Technologie.

There are many reasons why the „small“ slip bending rolls are one of the top-selling machines in the middle class. With its special roll concept, wide range of accessories and robust design, this is the machine for truly universal and cost-effective work on single jobs and in series production.

Pre- and final rolling in one machine

That saves money, space and working hours. Due to the remarkable asymmetric roll arrangement, the Result is an exceptional part quality over the whole Length thanks to the parabolic geometry at the rolls.

The smallest possible diameter down to 1,25 x top roll diameter shows the quality of these machines.

The parabolic geometry of the rolls is one of the details for a perfect result.

A gear motor flanged on the left side frame is driving the top and lower roll. At the right side you can easily release the locking handle, swing out the top roll and remove the finished part. A highly useful variation of options make it possible to configure the machine exactly to your needs.

Standard equipment

134/136
FM 1 R - control: foot switch, electrical safety control, operating mode single-step control
Rolls, approx. 700 N/mm ² tensile strength
Top- and bottom roll motor driven
Manual back roll adjustment by handwheel and digital position indicator
Manual back roll adjustment by handwheel and digital position indicator
Painting RAL 7035 light grey / RAL 5003 sapphire blue
Power supply 400 V, 50 Hz

Special equipment

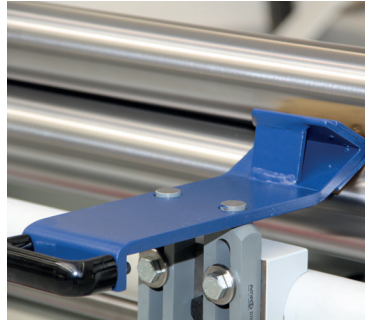
134	136
Rolls hardened and ground, Roll diameter 80 - 120 mm, Special top roll of 68 mm available	Rolls hardened and ground, Roll diameter 130 - 160 mm
Change gear for top roll Interchangeable roll	-
Wiring groove per pc per roll	
Cone guide for cone rolling	
Three roll drive	
Motor-driven bottom roll adjustment, control of bottom roll positioning in connection with control FM 2 and CR 80	
Hydraulic tilting bearing (only up to working length 1250 mm)	
Frequency-controlled drive $V = 1-6 \text{ mm/min}$	
FM 2R - control: foot switch, electrical safety control, operating mode single-step control, preselection of back roll control via potentiometer, incl. geared brake motor	
CR 80 SPS - control: Folding roll positioning incl. collection, frequency-controlled (only in connection with three-roll drive)	

The right accessories for all tasks

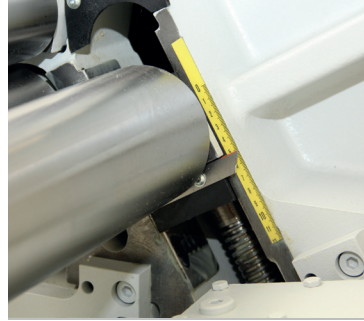
The slip bendings rolls 134 and 136 come extensively equipped to handle most jobs with ease. And for specific requirements, additional options are available.



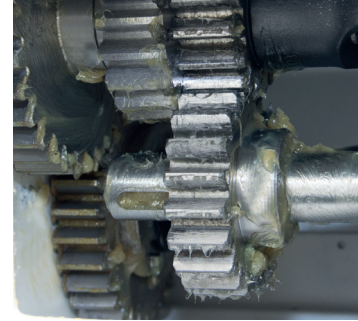
Standard: Pivot bearing for opening the top roll



Option: Cone guide for cone rolling (necessary for funnel production)



Standard: Additional position indicator of back roll via scale. Scale mounted on the left and right side of protection cover.



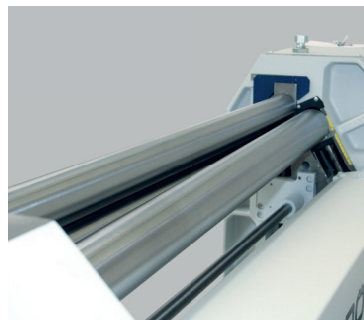
Change gear top roll for interchangeable roll



Option: with interchangeable roll the top roll diameter gets automatically detected by an initiator.



Standard: Digital Siko-display for manual bottom roll adjustment needed for sheet thickness adjustment, optionally also available motorized.



Standard: Inclined position of back roll is already contained in the standard equipment. Optionally this is also available with two back roll motors.



Standard: Coupling to adjust back roll or bottom roll

Prerolling and final rolling in one machine

Take advantage of FASTI's complex knowledge, and you will soon realize that nobody can offer more. Which is why more and more old hands visit our demonstration and consulting center to perform test work on their workpieces – just to make quite sure before deciding to invest.

We have thought of everything when it comes to forming sheets with thicknesses from 1 to 6.5 mm. You can choose between various types with working length from 680 mm to 2540 mm and rolls with 68 to 160 mm diameter. Details can be found in the table on page 6 of this brochure.

Rolls

Thanks to the asymmetric roll position you will get a perfect quality of the product. With its special roll concept, wide range of accessories and robust design, this is the machine for truly universal and cost-effective work on single jobs and in series production.

FM 2R control / CR 80 control

Controls as optional equipment



Option: control FM 2R

The optional control FM 2R offers the basic modes of a modern control with user-friendly and easy setting. The fast adjustment of back roll via potentiometer underlines the capability of the machine.

Standard:

- Control in moveable panel
- Foot switch
- Electrical safety control
- Preselection of back roll control via potentiometer, incl. geared brake motor

Option:

Preselection of bottom roll control with geared brake motor via potentiometer

Products e.g.: Pipes, half-shells and funnels



Option: CR 80 control

Highlights of the CR 80 SPS control

The CR 80 control offers a very comfortably and user-friendly programming. Depending on the program, it is possible to make variable radii without bending marks. The calculation of diameters when producing pipes is done automatically.

The positioning of bending wheels, sheet feeding and back roll adjustment are frequency-controlled (only in combination with three-roll drive).

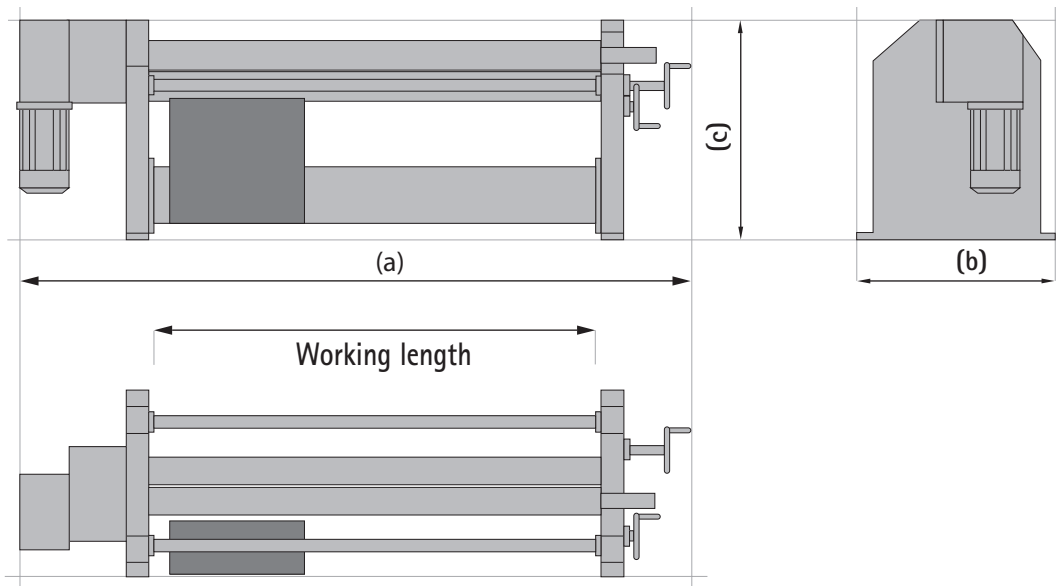
Products e.g.: Pipes, silencers, triangles, squares.

Technical data

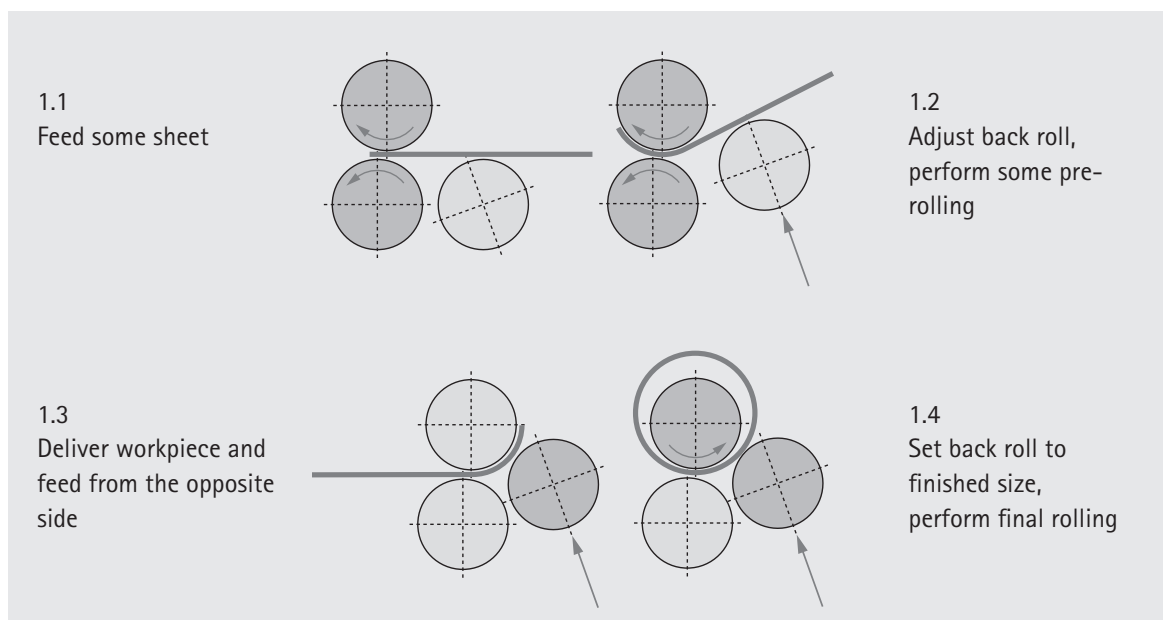
134	1 000				1 250				1 500				2 000						
Working length	1,040 mm				1,290 mm				1,540 mm				2,040 mm						
Sheet thickness (400 N/mm²) (mm)	2.0	3.0	4.0	4.5	1.75	2.5	3.5	4.0	1.5	2.0	3.0	3.5	1.0	1.5	2.0	2.5			
Top roll diameter (mm)	80	100	110	120	80	100	110	120	80	100	110	120	80	100	110	120			
Drive power (kW)	0.75	1.1	1.1	1.5	0.75	1.1	1.1	2.0	0.75	1.1	1.1	2.0	0.75	1.1	1.1	2.0			
Feeding rate	6.0																		
Weight approx.	720	740	750	920	760	910	960	990	870	950	980	1,000	860	980	1,120	1,220			
Outer dimensions																			
Length (a)	2,020				2,270				2,520				3,020						
Width (b)	670				670				670				670						
Height (c)	1,010				1,010				1,010				1,010						
136	1 000				1 250				1 500				2 000				2 500		
Working length	1,040 mm				1,290 mm				1,540 mm				2,040 mm				2,540 mm		
Sheet thickness (400 N/mm²) (mm)	5.0	5.5	6.0	6.5	4.5	5.0	5.5	6.0	4.0	4.5	5.0	5.5	3.0	3.5	4.0	4.5	2.5	3.0	3.5
Top roll diameter (mm)	130	140	150	160	130	140	150	160	130	140	150	160	130	140	150	160	140	150	160
Drive power (kW)	2.2	3.0	4.0	4.0	2.2	3.0	4.0	4.0	2.2	3.0	4.0	4.0	2.2	3.0	4.0	4.0	3.0	4.0	4.0
Feeding rate	6.0																		
Weight approx.	1,270	1,350	1,360	1,530	1,380	1,420	1,520	1,580	1,590	1,620	1,630	1,790	1,740	1,850	1,970	2,110	2,240	2,340	2,380
Äußere Abmaße																			
Length (a)	2,020				2,270				2,520				3,020				3,020		
Width (b)	890				890				890				890				890		
Height (c)	1,070				1,070				1,070				1,070				1,070		

All information provided as a guide only and may be subject to change at any time.

Dimensions: 134 or 136



Prerolling and final rolling in one machine



All dimensions in mm; standard: RAL 7035 light grey, RAL 5003 sapphire blue. Special painting at an extra charge.
Power supply 230/400 Volt, 50 Hertz.



Schröder Group

The Schröder Group consists of Hans Schröder Maschinenbau GmbH, which is located in Wessobrunn, Germany, and SCHRÖDER-FASTI Technologie GmbH, which is located in Wermelskirchen, Germany.

Founded in 1949, Hans Schröder Maschinenbau GmbH unifies traditional and modern approaches in machine building: Successfully managed as a quality and customer-oriented, family-owned company, Hans Schröder Maschinenbau is specialized in the development of modern machine concepts for bending and cutting sheet metal.

The successful integration of the Fasti Company in 2006 and its worldwide presence make the Schröder Group one of today's leading providers of machines for bending, cutting, beading, flanging, and circular bending all types of sheet metal. The company's precision machines range from proven solutions for craftsmen to innovative, high-performance machines for automatic industrial production processes. Overall, the Schröder Group currently employs more than 240 people at various locations at home and abroad.

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