



Characteristics of the Luna 8835 CNC rolls

- CNC-control with the capacity to store 200 programs.
- Pre-bending and final bending in one cycle.
- All four rolls are driven.
- All axis are programmable.
- All movements are mechanical for highest accuracy.
- Can bend complicated elliptical shapes.
- Front-roll or back-roll position can be programmed to flexibly vary bend diameter
- Adjustable crowning of the rolls.



The programming of the machine is facilitated by different menus available on the screen. In order to further simplify the programming, the control buttons are of multi-function type, whose functions are automatically changed when changing menus. The CNC has a storage capacity of 200 programs with 50 lines in each program.

The program consists of sections, where each section is provided with a bending value. This enables easy and quick programming of the machine for different bending operations. The CNC system can operate with "interpolation", where the rolls are adjusted simultaneously with the feeding operation.

BENDING ROLLS MBC 8835

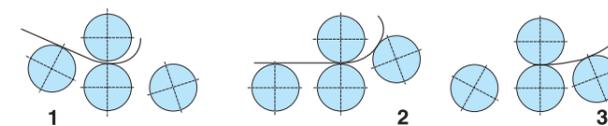
The 8835 is a roll bending machine for the production of small radius louvers and reflectors to meet the demands of the latest small diameter light tubes. The machine is designed with three independent bottom rolls to reduce production time to a minimum. All rolls run in adjustable support bearings to permit easy roll adjustment for materials of different hardness and thickness. The top roll crowning is carried out by means of a crossbeam, which tilts to make room for the bent part. All rolls are hardened and chromium-plated with polished surfaces to avoid marking. All four rolls are driven in order to avoid scratches on easily damaged sheets from slipping rolls. The control system allows programming of constant radius parts as well as parabolic shapes. 200 programs can be stored.

MODEL	8835	
Working length	mm	1890
Max. sheet thickness steel (250 N/mm ²)	mm	0,5
Diameter of rolls	mm	35
Motor output	kW	0,75
Max. working speed	m/min	9,1
Net. weight	kg	900

Accessories:

- Program back up with external computer
- Stacking tables
- Infeed automation
- Outfeed automation
- Online feeding unit 1700

The working principle of bending with four rolls – prebending and bending in one operation.



The unit consists of a driven roller way and a pneumatic pushing device for punching the blanks (Alu-sheets) into the roller. The concept makes it possible to integrate a punching line with Luna 8835/8344. Unit 1700 is equipped with a slave computer connected to the control system of the bending roll. The unit can be installed or removed in about 5 min.

Luna Bending Rolls CNC

Luna

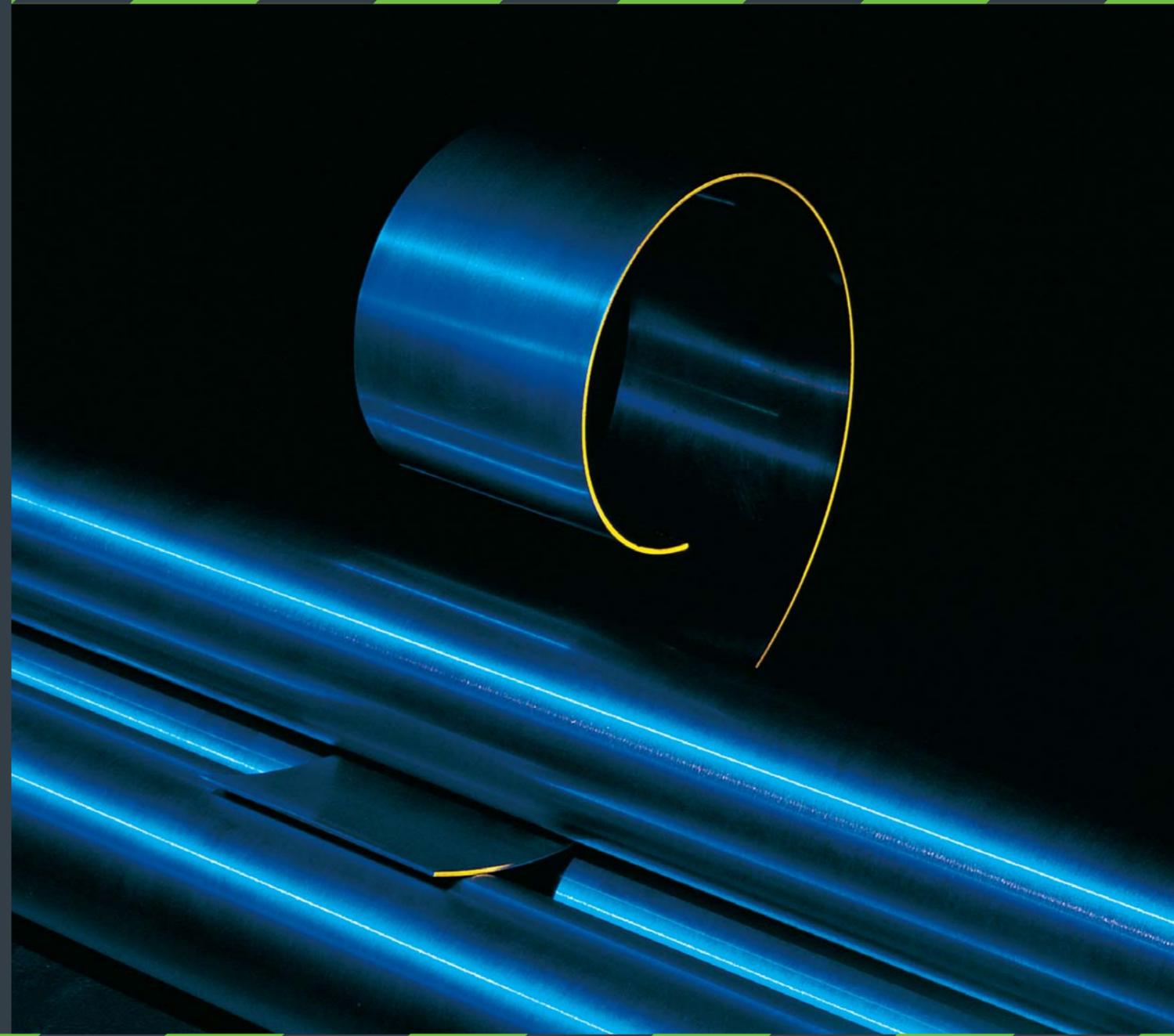
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CNC



Luna





Characteristics of the Luna 8344 CNC rolls

- CNC-control with the capacity to store 200 programs.
- Pre-bending and final bending in one cycle.
- All four rolls are driven.
- All axis are programmable.
- All movements are mechanical for highest accuracy.
- Can bend complicated elliptical shapes.
- Rolls mounted in inter-changeable cassette system.
- Adjustable crowning of the lower roll.



The 8344 machine equipped with cassette for louvers and reflectors

The design of the machine is based on the same principles as the other models of the 8344 series with the exception of the cassette. The rolls are here provided with roller supports along the whole bending length for adjustable crowning of the rolls.

The rolls are hardened and have chromium-plated and polished surfaces in order to avoid marks in the sheet.

The crowning of the top roll is carried out by means of a crossbeam, which tilts 90 degrees to the cradle, to make room for the bent part of the sheet. The machine with 40 mm diameter rolls is only intended to form aluminium. Mild steel can be formed with 60 mm diameter rolls.

Model	8344	10/10-40	12/08-40	15/07-40	17/06-40	20/05-40
Working length	mm	1008	1258	1508	1750	2008
Max. sheet thickness Alu (250 N/mm ²)	mm	1,0	0,8	0,7	0,6	0,5
Diameter of rolls	mm	40	40	40	40	40
Motor output	kW	0,75	0,75	0,75	0,75	0,75
Max. working speed	m/min	4,6	4,6	4,6	4,6	4,6
Net. weight	kg	650	700	750	800	850

The Luna 8344 CNC can bend profiles with variable radii and sections. The design with three lower bending rolls, mounted in a cassette, which is swivelling and adjustable in height, enables bending of very complex profiles in one single operation. The three rolls of the cassette are used as prebending roll, bottom roll and final bending roll. The cassette system also allows exchange of the rolls to other dimensions (standard dimensions dia. 55, 60, 70, 80 alt. 90 mm). The special design of the machine and the location of the four rolls eliminate all intermediate handling of the sheet between the prebending and the final bending. This simplified working method also means that the storage space around the machine can be reduced, a higher repetition accuracy is achieved as well as a higher productivity.

The adjustment of the cassette into the programmed position is carried out by means of ball screws. When bending is finished the lock clamp on the right hand side opens for the removal of the profile, if the profile is not closed, this function can be eliminated in the control program.

As standard the machine is delivered with hardened and ground rolls, motor 3 ph 400V and 24V control voltage.

Model	8344	7/15	7/20	10/10	12/08	10/20	12/15	15/10	17/07
Working length	mm	740	740	1020	1250	1040	1290	1540	1790
Max. sheet thickness steel (400 N/mm ²)	mm	1,5	2,0	1,0	0,8	2,0	1,5	1,0	0,7
Diameter of rolls	mm	55	60	60	60	70	70	70	70
Motor output	kW	0,75	0,75	0,75	0,75	0,75	0,75	0,75	0,75
Max. working speed	m/min	6,3	6,9	6,9	6,9	8,1	8,1	8,1	8,1
Net. weight	kg	650	650	650	700	650	700	750	800

Model	8344	10/25	12/20	15/15	17/12	20/10	10/30	12/25	15/20	17/16	20/15
Working length	mm	1040	1290	1540	1790	2040	1040	1290	1540	1790	2040
Max. sheet thickness steel (400 N/mm ²)	mm	2,5	2,0	1,5	1,2	1,0	3,0	2,5	2,0	1,6	1,5
Diameter of rolls	mm	80	80	80	80	80	90	90	90	90	90
Motor output	kW	0,75	0,75	0,75	0,75	0,75	0,75	0,75	0,75	0,75	0,75
Max. working speed	m/min	9,2	9,2	9,2	9,2	9,2	10,4	10,4	10,4	10,4	10,4
Net. weight	kg	700	750	800	825	850	750	800	850	875	900

The prebending value is ca 70% of the indicated material.

The programming of the machine is facilitated by different menus available on the screen. In order to further simplify the programming, the control buttons are of multi-function type, whose functions are automatically changed when changing menus. The CNC has a storage capacity of 200 programs with 50 lines in each program.



The program consists of sections, where each section is provided with a bending value. This enables easy and quick programming of the machine for different bending operations. The CNC system can operate with "interpolation", where the rolls are adjusted simultaneously with the feeding operation.

Accessories and optional equipment

- Adjustable crowning support
- Chromium-plated rolls
- Adiprene-coated rolls or rolls with grooves
- Program back up with external computer
- Stacking tables
- Programmable support arm
- Additional safety equipment
- Infeed and outfeed equipment.

Product applications such as:

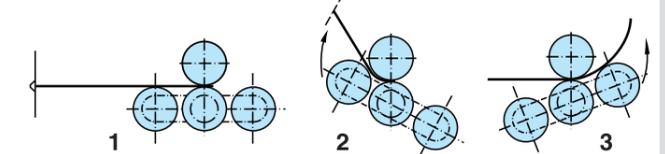


Tubes



Elliptical shapes

The working principle of bending with four rolls – prebending and bending in one operation.

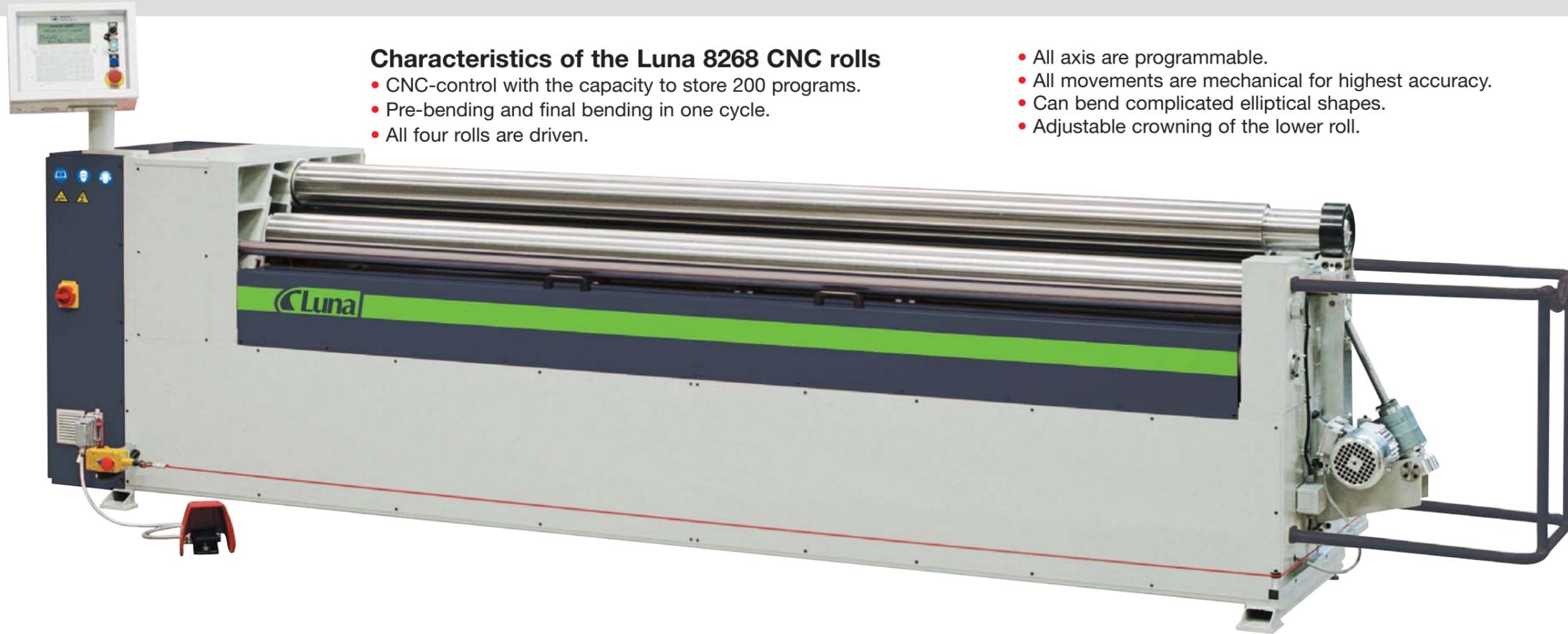




Characteristics of the Luna 8268 CNC rolls

- CNC-control with the capacity to store 200 programs.
- Pre-bending and final bending in one cycle.
- All four rolls are driven.

- All axis are programmable.
- All movements are mechanical for highest accuracy.
- Can bend complicated elliptical shapes.
- Adjustable crowning of the lower roll.



The programming of the machine is facilitated by different menus available on the screen. In order to further simplify the programming, the control buttons are of multi-function type, whose functions are automatically changed when changing menus. The CNC has a storage capacity of 200 programs with 50 lines in each program. The program consists of sections, where each section is provided with a bending value. This enables easy and quick programming of the machine for different bending operations. The CNC system can operate with "interpolation", where the rolls are adjusted simultaneously with the feeding operation.

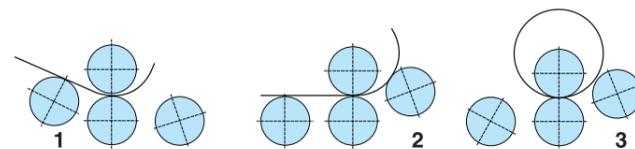
BENDING ROLLS MBC 8268

The 8268 rolls are designed to meet the requirements for longer CNC rolls for tight radius bending. A welded steel frame and cast guides provide the necessary rigidity. The design with three rolls (pre-bending, bottom and bending roll) mounted independently in separate guides enables high productivity and easy adjustment of the rolls. The top roll is mounted above the middle roll making this machine a four-roll bender with symmetrically placed rolls. In order to control the bending result over the working length, the machine can be equipped with hydraulic crowning supports for the lower roll. This is carried out by three support blocks with four pressure bearings. The crowning is adjusted with a hand pump.

All four rolls are driven in order to prevent scratches on easily damaged sheets from slipping rolls. The movement of the three lower rolls is carried out by lead screws.

The four-roll system eliminates the need for any intermediate handling of the sheet between pre-bending and final bending. This ensures high repetition accuracy as well as a rapid and rational production. When the bending is finished the lock clamp on the right hand side opens to allow removal of the bent profile. This function can be eliminated in the program. As standard the machine is delivered with hardened and ground rolls, motor 3ph 400V and 24V control voltage

The working principle of bending with four rolls – prebending and bending in one operation.



Accessories and optional equipment

- Adjustable crowning support
- Chromium-plated rolls
- Adiprene-coated rolls
- Rolls with grooves.
- Program back up with external computer
- Stacking tables
- Programmable support arm
- Additional safety equipment
- Infeed and outfeed equipment.

Product applications such as:



Tubes



Elliptical shapes

Model	8268	15/45	20/30	25/20	30/10	15/50	20/35	25/25	30/15	15/55	20/40	25/30	30/20
Working length	mm	1540	2040	2540	3040	1540	2040	2540	3040	1540	2040	2540	3040
Max. sheet thickness (400 N/mm ²)	mm	4,5	3,0	2,0	1,0	5,0	3,5	2,5	1,5	5,5	4,0	3,0	2,0
Diameter of rolls	mm	120	120	120	120	130	130	130	130	140	140	140	140
Motor output feeding motor	kW	2,2	2,2	2,2	2,2	2,2	2,2	2,2	2,2	2,2	2,2	2,2	2,2
Net. weight	kg	1800	2100	2400	2700	2100	2400	2700	3000	2400	2700	3000	3300

The prebending value is ca 70% of the indicated thickness of the material.