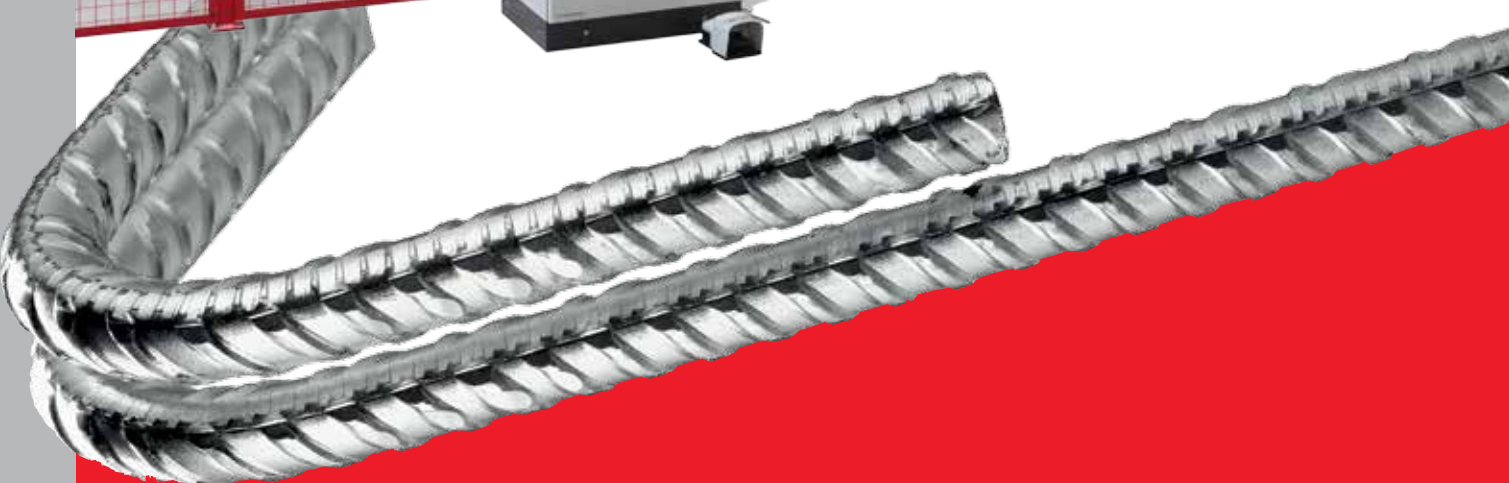




Stirrup bending machine

# F8-F13

*Stirrup bending machine*



# **MIEP**

the history of innovation



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# F8-F13

## A NEW GENERATION

F8 and F13 represents the ultimate solution in the field of automatic coil stirrup benders for its ease of use and high performance.

Flexibility, productivity and product quality are always guaranteed.



## FLEXIBILITY

Small or large stirrups, straightened or bent bars, as well as circles and spirals are fabricated thanks to a complete array of accessories, able to satisfy the widest range of productive requirements.





## QUALITY AND PRODUCTIVITY

The **F8** and **13** are a user friendly automatic stirrup bender that provides **superior quality of finished products**.

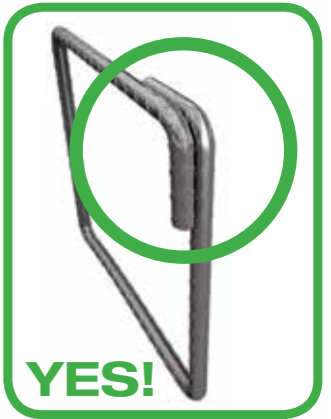
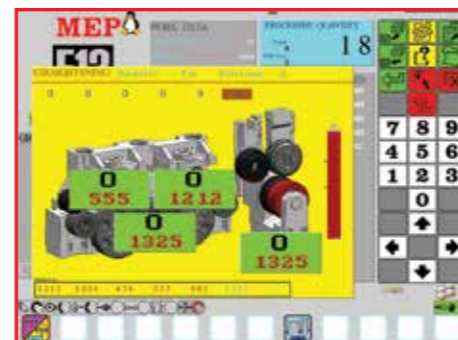
The combined action of an exclusive series of **patented devices** minimizes the time for setup adjustments and **drastically reduces the amount of discarded products**. A drive and control system, based on the latest generation technology, grants to reach **unparalleled levels of productivity** per hour.



The twisting of the wire during the pulling phase creates open stirrups.

## CONTROLLED STRAIGHTENING

The combined functions of the **AFS<sub>2</sub>** system and the dynamic visualization of infeed rollers, allows a simple management of two wires single straightening.



The **AFS<sub>2</sub>** system guarantees perfect straightening with flat stirrups.

patented

## AFS<sub>2</sub>: AN INNOVATIVE SOLUTION FOR COIL

**AFS<sub>2</sub>** (advance feeding system 2) is a straightening system able to control **the effect of wire rotation on its own axis**, that has origin during the pulling phase. Therefore, **closed stirrups and straight bars can always be produced**.

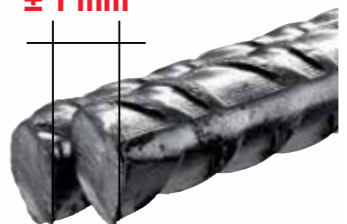
The exclusive design of the innovative straightening group **AFS<sub>2</sub>** prominently increase the meeting point between infeed rollers and the two wires, so the correct traction is guaranteed.

**The coil ribs deformity are reduced at the least without modify the mechanical characteristics of wires**, typical in traditional straightening systems.



\* OPTIONAL

± 1 mm \*



## SAFETY AND ERGONOMICS



With the **AFS<sub>2</sub>** system it is **always** granted to obtain **closed stirrups**, thus **eliminating** the typical and dangerous **manual operation** during the bending process by operator. It is possible to produce straight bars or bent at one end, in total security.

## WORLD SYSTEM: TOTAL CONTROL



- **MEP Industrial PC "World System" operator control panel is comprised of:**
  - LCD "Touch Screen" for the user friendly graphical visualization of all data.
  - Compact, "embedded" microprocessor with low power consumption and a compact flash disk with no moving parts (diskless).
  - Linux operating system.
  - Automatic backup saving system in case of accidental power interruption for safeguarding files and memory support integrity.
- **The custom software developed by MEP allows:**
  - Data input with graphic visualization of programmed and pre-memorized shapes with feasibility checks via a "dynamic simulation".
  - Control of all speed parameters in execution via a potentiometer.
  - Saving and archiving of data relative to work cycles and generation of daily production statistics (positions, diameters, times, weights, etc.).
  - "Active diagnostic" system for a constant efficiency check of all machine devices.
  - Automatic activation of the scheduled maintenance program.
  - Interface compatible with optical bar code reader through RS 232 port.
  - USB connection port
  - Possible to connect to Company Network through RJ45 Ethernet port (LAN port) or RS 232 port.
  - VPN Connection-ready for remote assistance via Internet (through Company Network).

## QUALITY DECOILING



- **Decoilers** equipped with an automatic braking system monitored by the control panel according to the work cycle.



- **Spacer** for the use of spooled or rewind coils. (OPTIONAL)

## ACCESSORIES



- Winch equipped with clamping device for the wire end to be pulled. (OPTIONAL)



- The cutting unit utilize universal mobile blade suitable for any wire diameter and provided with four cutting edges. Fixed blade guide dedicated by diameter.



- F8-F13 is equipped with single block bending pins with self-locking device. They are made in accordance with the international regulations and allowing fast change at the same time as the diameter change a fast production restart.



- Supporting and collecting unit for the production of straight bars and bars bent at one end. (OPTIONAL)













- Bar code. (OPTIONAL)



- Photocells for "stop&go" purpose with consequent reinstatement of production disrupt. (OPTIONAL)

## TECHNICAL AND PRODUCTION CHARACTERISTICS

			
		F8	F13
	<b>SINGLE STRAND PROCESSING WIRE DIAMETER</b>		
	cold drawn, hot rolled, smooth or ribbed wire fy = 600 N/mm <sup>2</sup> - ft = 700 N/mm <sup>2</sup> (other loads upon request)	Ø 4" - Ø 8 mm #2 - #3	Ø 4" - Ø 13 mm #2 - #4
	<b>DOUBLE STRAND PROCESSING WIRE DIAMETER</b>		
	cold drawn, hot rolled, smooth or ribbed wire fy = 600 N/mm <sup>2</sup> - ft = 700 N/mm <sup>2</sup> (other loads upon request)	Ø 4" - Ø 8 mm #2 - #3	Ø 4" - Ø 10 mm #2 - #3
	<b>SQUARE STIRRUP DIMENSIONS</b>		
	minimum with Ø 6 mm wire (optional bending pin)	50 mm x 50 mm - 2" x 2"	
	maximum if clockwise	900 mm x 900 mm - 2'-95" x 2'-95"	
	maximum if counterclockwise (with eventual optional cover extension)	1000 mm x 1000 mm - 3'-3" x 3'-3"	
	<b>LENGTH OF STRAIGHTENED AND CUT-TO-LENGTH BAR</b>		
	minimum	5 mm - 3/16"	
	maximum (if equipped with optional supporting guide; other sizes upon request)	12000 mm - 39'-4"	
	<b>CENTRE FORMING TOOLS DIAMETER</b>		
	minimum	12 mm - 1/2"	
	maximum (other sizes upon request)	60 mm - 2 3/8"	
	<b>MAXIMUM DISTANCE BETWEEN CENTRAL BENDING PIN AND THE GROUND</b>		
	standard	1300 mm - 4 3"	
	optional upon request	> 1300 mm - > 4 3"	
	<b>OPERATING TEMPERATURE</b>		
	standard	-5° C / +40° C - 23° F / 104° F	
	optional upon request	-15° C / +55° C - 5° F / 131° F	
	<b>INSTALLED POWER</b>		
	maximum (other sizes upon request)	24,5 kW 32,84 hp	34,5 kW 46,24 hp

THE PLANT DOES NOT REQUIRE COMPRESSED AIR

fy: Max. unit yield point - ft: Max. Tensile strength

\* diameter 4 mm processing kit on request



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