

# CNC Coiling and Bending Machines for the Production of Two- and Three-Dimensional Parts made of Wire



Series  
B

# Series B

▼ Fixed bend-back clearance



▼ Feed unit including straightening unit



## Our Accomplishments for your Benefit

- Reduced machine concept cuts costs per unit
- High flexibility and safety due to reliable and proven tool concept
- Safe and simple operation due to our WAFIOS Programming System WPS 3.2 EasyWay
- Minimization of set-up times due to *iQ* software functions
- Simple handling of wire, from infeed unit up to bending head

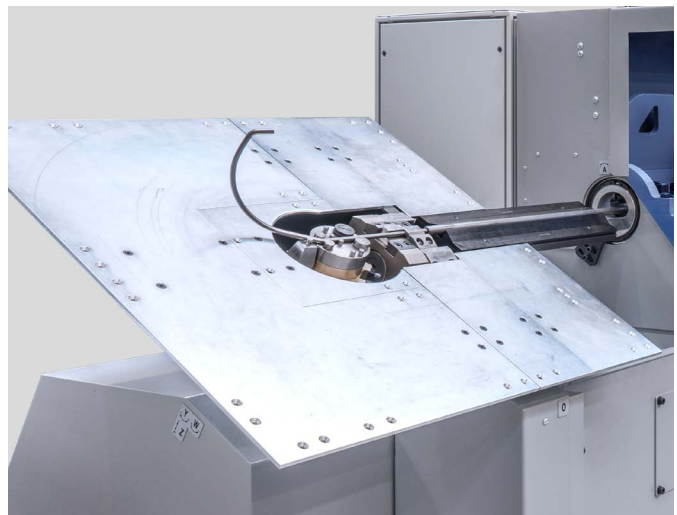
## Design Features

- 6 CNC axes (standard)
- Robust feed unit for advancing and rotating the wire, together with combination roller straightener
- Fast, cycle-time optimized, CNC-controlled cutting unit
- Versatile bending head with large bending space and flexible application possibilities by infinitely rotating bending and mandrel axis as well as large up/down strokes
- Feed and bending tools compatible with BM series as of 2003 (multi-radii and 4-pin bending tool)
- No lateral displacement of the bending head
- Combination roller straighteners cover the entire operating range of the machine
- Hand-held operating device
- Fast, PC-based CNC control
- Electr. M functions, standard
- Optical control for process monitoring (option)

## Operation

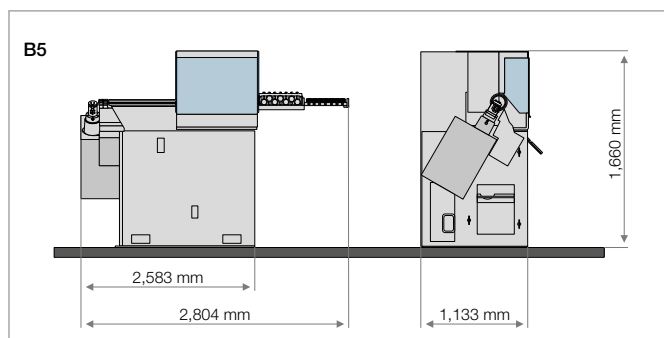
- User-friendly and fast set-up with the hand-held operating device
- Reduced set-up times due to ergonomic access to all tool positions as well as simple and fast programming of tools, material properties and bending programs with WPS 3.2 EasyWay
- *iQbend*: Automatic optimization of CNC program sequences with regard to the geometry of the bent part (option)
- *iQinspect*: Import/export of nominal data or correction data from external measuring systems to WAFIOS Programming System WPS 3.2 EasyWay

▼ Bending head





Technical Data	B4	B5
Operating range, wire Ø: 600 N/mm <sup>2</sup> 1.200 N/mm <sup>2</sup> 1.900 N/mm <sup>2</sup>	3.0 – 8.0 mm 3.0 – 5.0 mm 3.0 – 4.0 mm	4.0 – 10.0 mm 4.0 – 6.0 mm 4.0 – 5.0 mm
Feed rollers	3 Pairs	4 Pairs
Rotary angle, mandrel axis	Infinite	Infinite
Rotary angle, bending axis	Infinite	Infinite
Bending head, up/down stroke	+25 mm / -120 mm	+25 mm / -120 mm
Bend-back clearance	700 mm	700 mm
Bending head positioning	+30° fix	+30° fix
Feed speed	max. 120 m/min	max. 120 m/min
Bending torque	ca. 520 Nm	ca. 1,050 Nm
Number of standard CNC axes	6 fix	6 fix



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