

ROPER  WHITNEY.



AUTOBRAKE[®]


COMBI, SERIES

AB1212K



USA  MADE

AUTOBRAKE | 1212K

ROPER  WHITNEY has been producing quality folding systems for a variety of markets. Building on that experience, the Autobrake integrates advanced design with the features that have made the Autobrake the choice of professionals.

The Autobrake combines automated bending of angles up to 145 degrees, material clamping, and material support into a single CNC controlled system employing wing bending techniques.

Benefits of the Autobrake system vs. manual or press brake bending are:

- Reduced labor costs
- Improved part accuracy
- Reduced setup time
- Minimized tool changes
- Improved part quality especially on soft and pre-painted material

Construction

The Autobrake 1212K is made using an all steel weldment construction, delivering superior performance and features, in a simplified rigid design. The solid steel plate-type construction brings drive components close together for improved stiffness and performance, thus allowing actuating mechanisms to be more secure in rigid mounts at the outside of the housings, allowing easy maintenance.

The upper beam movement is by eccentric drive which offers quick and precise clamping of materials. Integral to the upper beam are the ways with non-metallic gibing to guide and retain the upper beam within the side frames. The ways of the 1212K are housed in a closed frame design adding to the rigidity of the machine.

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The folding beam is designed using a solid steel plate, offering maximum resistance to bending forces. The machined pocket, of the beam, can receive the standard 1.38" / 35 mm and 0.500 in / 12 mm bending bars. Two linked gear motors allow for quick and easy adjustment of the folding beam for large variations in material thickness. Two gearbox motors, controlled by frequency inverter drives the folding beam into position from both ends of the machine for accurate, torsion free bending of materials.

The lower beam is a welded reinforced structure fabricated of thick steel plate. The lower beam is keyed and pinned in place, and coupled to the end housings for improved rigidity. The advanced design of this beam delivers superior hemming results. Access to the Autobrake's electrical system is located at the right-hand side of the machine through a quick-lock enclosure. This enclosure houses the power and control devices that drive the machine, and extends behind the right-hand cover for reduced machine length. All Autobrake electrical panels are designed and assembled in house.



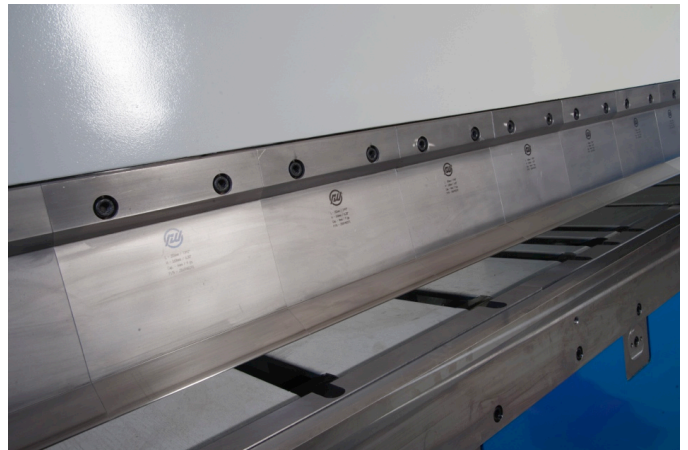
The unique Kombi beam is a fabricated structural prism designed to withstand the forces generated by capacity forming operations. Machined into the Kombi beam 180° from each other are the attachment surfaces for the straight and box and pan tooling. Tools are attached to the Kombi beam with a quick change locking system to secure the tools even while the clamping bars are loosened for adjustment. A brake motor driving a sprocket and roller chain mechanism powers rotation of the Kombi beam.

Material Sensing Clamping

Clamping pressure exerted by the upper beam is variable to accommodate a wide variety of materials, thicknesses and finishes. Clamping and hemming pressures are programmable, so no tool change is required to create open, closed, or tear drop hems. The positioning of the upper beam is controlled by a closed loop circuit. The opening height can be changed throughout the program for improved part handling.

Kombi Beam Tooling

The upper beam comes standard with both segmented and sharp rail tooling. The quick-change segmented box tooling has a height of 6.3". The sharp rail tooling comes in sections and is machined to 30 degrees. Each piece is precision ground and laser hardened to 60 on the Rockwell C scale. The individual Box segments are laser etched with the length of each tool for easy box set up. The straight and segmented tools are manufactured exclusively for Roper Whitney in the USA by Wilson Tool.



Manual Crowning System

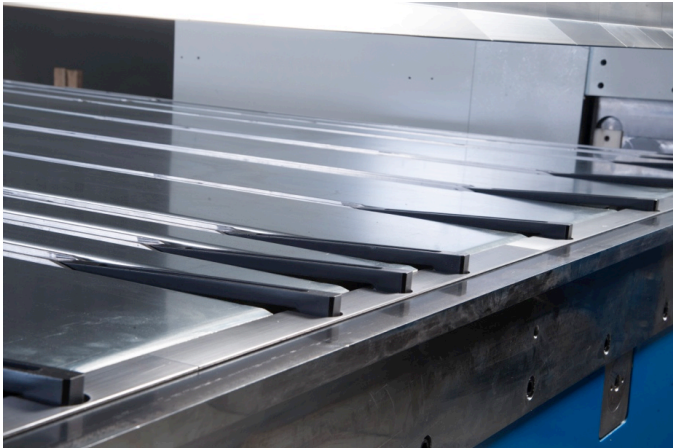
The 1212K comes standard with manual crowning adjustments for fine-tuning the crown of the bending tool and eliminates the need for shimming. The ability to adjust crowning of the tool, improves bend accuracy, material straightness, radius bends, and the forming cornice work. This system consists of crowning cams, actuating tool, and is manually adjusted, and locked in place by the operator.

Automatic Material Thickness Adjustment

The Synergy control automatically adjusts the Folding Beam of the AB1212K for material thickness. The beam is adjusted by two linked gearbox motors. The adjustment range is 0-3.14 in / 80mm.



Integrated Sheet Support and Material Positioning



Work pieces are fully supported by the back gauge table beneath the clamping beam, and automatically positioned to an accuracy of +/- .004". The back gauge is positioned by a servo motor capable of moving 0.250" to 61" in less than 3 seconds.

Nine conveniently spaced fingers provide positive contact with the sheet edge at all times and the fingers will travel down to 0.250" position. Maximum back gauge travel can be reached in less than 3 seconds using a three stage design combining high speed with compact space requirements. The operation of the pop-up back gauge fingers is controlled pneumatically. The back gauge is capable supporting sheets up to 700lb (318kg) with a depth of 61". Optional Ball transfers in the support trays can be added to the AB1212K.



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The Autobrake back gauge can be expanded with the addition of optional left, right or u-shaped extensions. Back gauge extensions provided greater gauging depth, and allow the formation of large work product.

Extension systems attach to the standard back gauge provided with the Autobrake, and utilize the alignment features and accuracies already inherent in the 61" back gauge. The back gauge extension mounts readily to the Autobrake, and can be provided during the initial purchase of the Autobrake or mounted at a later date.



Extensions provided with the initial purchase of the Autobrake are mounted to the machine during the machine installation process. After-market extensions can either be mounted by the purchaser or by Roper Whitney's service technicians as a paid charge.

The U-Shape Back gauge Extension combines the features of the right-hand and left-hand extensions, and joins with the standard 61" back gauge to create a U-shape gauging system with the right and left sections providing material positioning to 122" (3100mm). Each extended portion of the back gauge contains five (5) of the fourteen (14) finger sets. The balance of the back gauge positions to 61" (1550mm).

Maximum 122" (3100mm) back gauge travel in less than 3 seconds is provided by six stage design combining high speed with compact space requirement.

Intelligent Controls

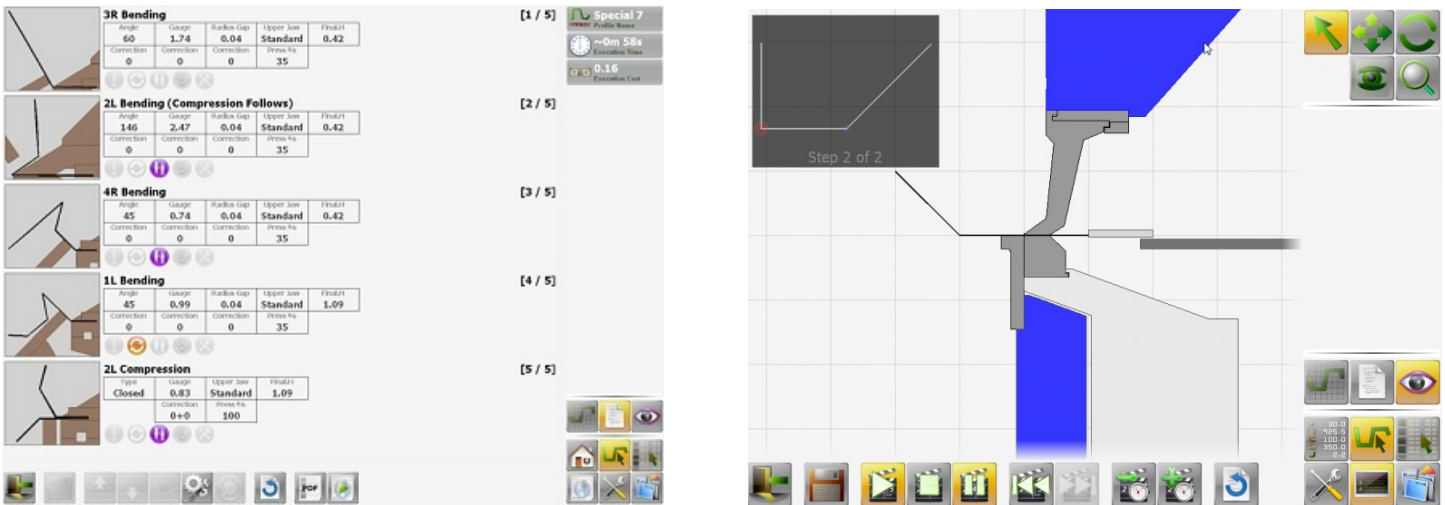
Synergy is the latest software designed for Roper Whitney's line of powered folding machines. It is a highly advanced CNC system that takes the complexity out of programming and running parts. Easily control and view all of the machines motions with the intuitive interface. The full-color, graphic touchscreen makes it simple to draw, store and browse and for parts. The software also brings together information from the office-based Konstruct program and the field-based Konstruct Mobile with Roper Whitney's technical support program Konnect.

- Windows 8.1 imbedded industry pro.
- Automatic sequencing of the part that is drawn.
- Possibility of saving programs in folders and subfolders.
- 3D Part display.
- Part simulation to verify bends sequence, material handling and collisions.
- A search function is used to make it easier to identify a part.
- Export of programs, library materials and back up to USB stick.
- The actual values of the axis are shown on the display, as well as the motion of the machine in real time.
- There are 3 different hems: Open Closed or Tear Drop.
- Capable of importing DXF files.
- Konstruct offline programming
- Konnect online service and operator assistance.

With Synergy you have the option to purchase Konstruct. The Synergy software brings together information from the office-based Konstruct program and the field-based Konstruct Mobile with Roper Whitney's technical support program Konnect.

Automatic Bend Sequence Calculations

The bending sequence is calculated and optimized in relation to the characteristics of the piece and the actual measurements of the machine and the accessories mounted. It is possible to establish and /or modify the bending sequence calculated by the software, once "customized", the software saves the new sequence and uses it as a first option for the following similar profiles. In the illustration of the bending sequence and simulation, there are icons that show how to insert, rotate and flip the sheet.

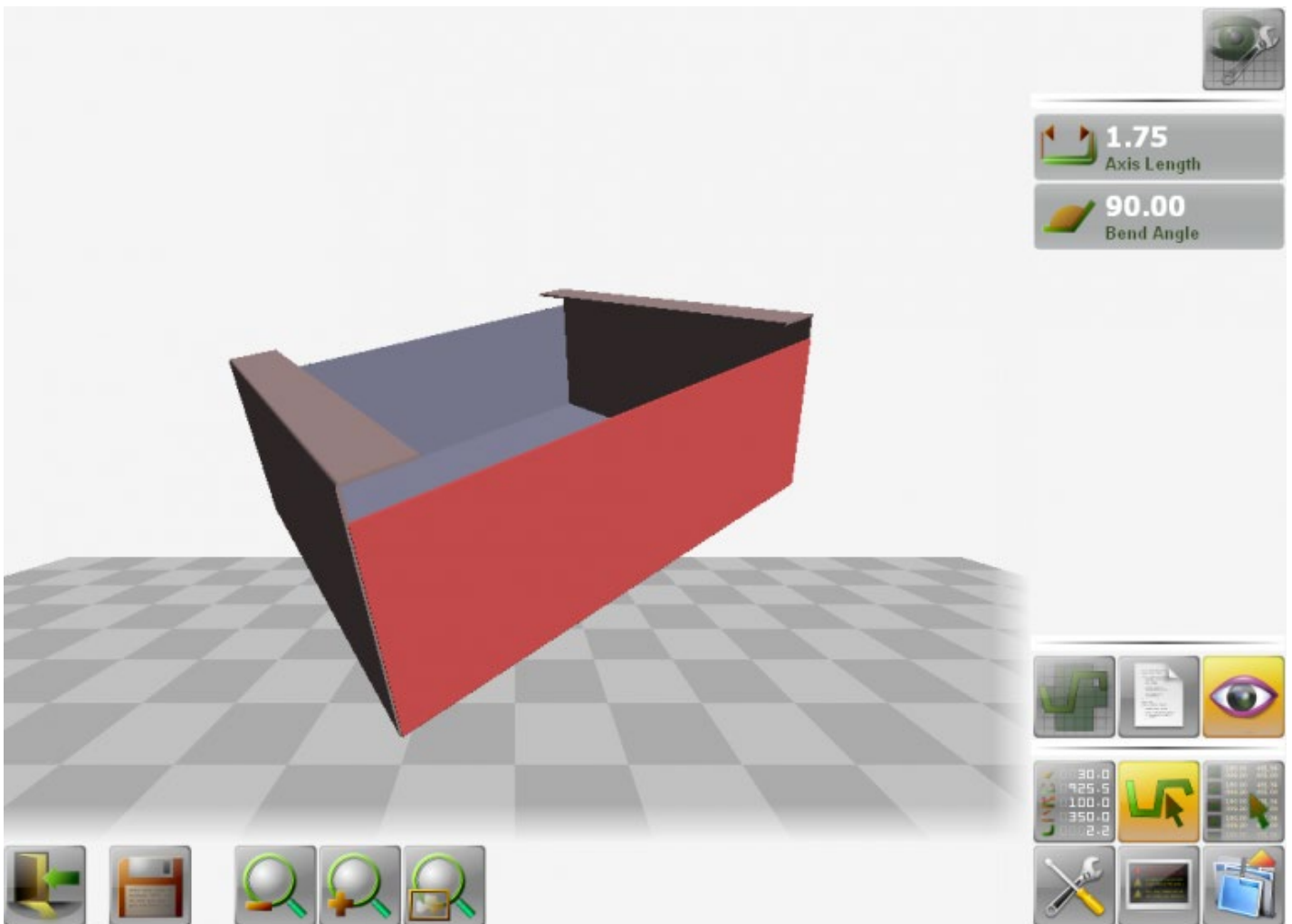


The Synergy control calculates the stretch out of the part as well as the notch pattern of boxes.



Simple, reliable, intuitive and precise. Entering data directly on the screen, if errors occur, you cancel your choice with a click (button "undo" or "redo"). The profile can be drawn, edited and saved directly on the screen (touch screen mode) and data, such as length; angle and radius can also be entered manually, by selecting the affected side.

Graphical user interface complete with zoom, rotation, displacement, vertical and horizontal with a simple touch on the screen. Folds, round profiles, hems, and steps are inserted using the appropriate button and touching the screen like a blackboard on which to draw.





You've seen this play out over and over you're on site and you realize you're missing a part. You sketch it out and send a driver to your fabrication shop. The driver makes the trip, waits while your operator fabricates the part, then hustles back to the site. Efficient? Hardly. There is a better way. We call it Konstruct.

Konstruct is an innovative software package created and used exclusively by Roper Whitney. This in-office software package allows the office to communicate directly with the Synergy control on your machine. From the office the administrator can create, manage and monitor the activities on the folding machines.



Greater Control

Parts are created the same way as they would be on the machine. It is as simple as drawing the shape with the correct angles and dimensions and the software does the rest.

The part is then automatically sequenced so that the proper bend order is followed. The type of material, number of pieces and any other information is entered and the job is ready to be run.

The administrator can then see what jobs are waiting to be run, what is in process and what has been completed giving you greater control over your shop processes.

- Create or manage jobs
- Easy Window based navigation
- Create job list for each folder in your shop
- Real time knowledge of what jobs have been completed
- DXF file import capability



Konstruct Mobile is the “in-the-field” version of the Synergy software that operates the Autobrake and Automax folders. Using Konstruct Mobile on a mobile phone, tablet or laptop you can design, price and order parts remotely from anywhere you have an internet connection and communicate that directly back to your Konstruct office software. Its efficiency that you will appreciate, and it’s a selling tool that you as a fabricating contractor, can use over competition in service and sales.



From the job site you can instantly tell the office what type of material, color, thickness and number of pieces you require. Once a part is sent to the office the job will be automatically reviewed to confirm that it can be run on the machine. As parts are created they can be stored and accessed again at a later date. The Konstruct Mobile software package can be used by your customers in place of sending pictures or hand sketched drawings so parts are drawn with accurate angles and dimensions.

Create, Spec and Order Parts from the Field

- Choose parts from a part library or create your own
- Simple part drawing
- Send orders from any mobile device
- Pick color, type of material and number of pieces
- Enter job name or PO#

Real-Time Support with Maximum Up-time

With Konnect you can receive real-time support for your folder directly from our service team. Our technical experts can remotely diagnose and correct most issues that may occur to help you avoid costly down-time.

Features include:

- Live audio and video on your equipment's control system
- Diagnose machine problems quickly to help you avoid down-time
- Eliminate travel costs for onsite, in-person service calls and maintenance
- Share your machine's control system so we can make necessary updates remotely
- Receive follow-up training or programming assistance



Roper Whitney Service Department



Your Machine

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Autobrake AB1212K	
Bending Capacity (Mild Steel)	12 ga / 3,5 mm
Bending Capacity (Stainless)	16 ga / 1.6 mm
Bending Length	150" / 3810 mm
Bending Bars	1.378" (35mm) bending bar x 150" (3810mm) .472" (12mm) bending bar x 150" (3810mm)
Crowning of the Folding Beam	5-Point 0"-0.030" Adjustment
Folding Beam Adjustment	3.14" / 80mm
Clamping Beam Opening Height	7.9" / 200.4mm
Clamping Beam Tooling	30°
Back gauge Depth (Standard)	61" / 1550 mm
Working Height	35" / 889mm
Back Gauge Servo Motor	3/4 hp
Clamping Beam Motor	4 hp / 3 kw
Bending Beam Motor	Dual 4 hp / 3 kw
Maximum Depth of Box (4 Sides)	6.3in / 160mm
Machine Weight	15,600 lbs / 6,136 kg
Machine Dimensions	205 x 128 x 85 in / 5207 x 3251 x 2159 mm
Speeds	
Clamping Beam Speed	3" per second
Folding Beam Speed	80 degrees per second
Back gauge Speed (0.375" to 61")	Less than 3 seconds