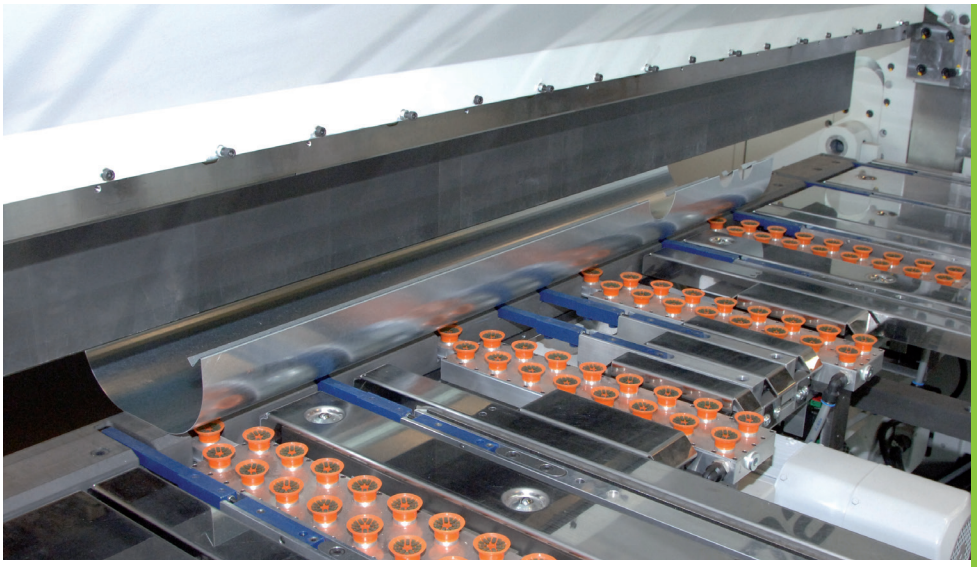
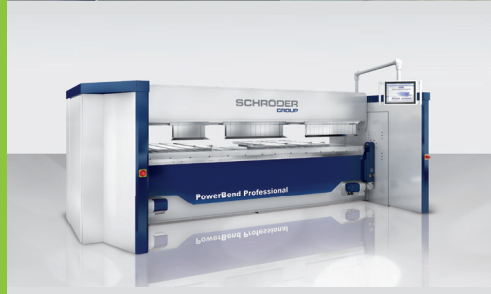
SCHRÖDER GROUP

50 percent time-saving

MAGRA Maile + Grammer GmbH counts on Schröder folding machine





User

The company MAGRA Maile + Grammer GmbH is working highly successful with its distribution systems for heating installations already for decades. A flow manifold and a return collector are combined as a dual compartment distributor in one unit and enable an extremely easy, crossing-free, space- and material saving pripe connection. MAGRA-distributors are produced order-specific and highly efficient in long welding lines and with state of the art plasma cutting systems. Its insulation is located in two-part, easy to install sheet metal shells.
(www.magra-verteiler.de)

Success

The rounded half-shells for insulating the distribution systems had been produced for many years on a rounding machine and a press brake with high manual effort. But at MAGRA they still saw significant potential for further optimization. A fair attendance on the booth of Hans Schröder Maschinenbau led to a solution that simplified processes, increased repaeatability, halved expenditure of time and replaced two old machines with one modern folding machine. The exacting positioning has been solved with a special construction.

Machine used

PowerBend Professional UD

- Folding machine with sheet thickness up to bis 4 mm
- 2500 mm working length
- Up-and-Down-folding beam
- Rotating clamping beam with seconde tool set
- Radius-step-bending with the clamping beam in any number of steps
- Suction gauge with special construction

The MAGRA-distribution systems are a success story. Thanks to the idea of the heating installer Meinrad Grammer, in 1971 a company was founded, where more than 100 employees are producing distribution systems on an area of about 8 000 m². The distributors are sold throughout europe via specialist shops to heating- and sanitary installers. Standard distributors for floor heating, radiator connections and boiler distributors up to 165 kW as well as customer-specific distributors for systems up to 9 100 kW are all insulated in accordance with the EnEV. Whether rigid foam with aluminium sheet metal coating or mineral fibre with galvanized steel sheet coating - the easy to install two-part insultation shells all have a similar construction, but individual dimensions.

Looking for better sheet metal working

The rounded half-shells out of 0,75 mm thick galvanized steel sheet have been produced for a long time with a rounding machine and a press brake. But the manual positioning ran the risk of inaccurate output. Upon visiting the exhibition Blechexpo in Stuttgart together with his collegues, the MAGRA-Technician Martin Ott came on the booth of Schröder Group. Ott remembers: „A Schröder-sales representative spoke to us and we explained to him what Magra is producing out of sheet metal. Thereupon he went to the software control of a folding machine, prepared a folding program with only few entries and spontanously produced a half-shell. Everything I saw afterwards on the booth of other folding specialists, was stone-edged in comparison to a Schröder folding machine."

„At Schröder you see that sheet metal working is really understood and that all employees are taking into account the individual demands of the customer. We did not only get a machine, but a totally individual solution that contributes significantly to a more rational production in the range of insulation shells"

Meinrad Grammer
CEO

Radius-Step-Bending and Up and Down

MAGRA chose the folding machine PowerBend Professional UD. For folding the mounting tabs of the half-shells a Z-fold is necessary – thanks to a Up-and-Down-folding beam this is possible in one step without having to turn over the sheet metal. This machine produces roundings by pressing the sheet step-by-step with the clamping beam against the bottom- and the folding beam that are positioned in a flat angle to each other. The Schröder software POS 2000 Professional makes this possible with any number and fine radius-bending steps – normally being positioned with finger gauges of the back gauge system. But what if there's already a rounding on the side where the sheet has to be gauged? This was a challenge for which the folding specialists from Schröder needed to find a new solution. The answer was a back gauge with suction plates, originally a development for industrial folding machines of the Evolution-Series. However the size of the sheet where suction cups worked was too slim for smaller half-shells. A special construction was the solution: The suction gauge has been extended to the front with some single suction cups and the bottom beam tool has been equipped with cut-outs to make place for these extensions.

Schröder Group

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

Founded in 1949, Hans Schröder Maschinenbau GmbH combines traditional and modern aspects in mechanical engineering. Successfully managed as a quality and customer-oriented family company, Hans Schröder Maschinenbau specialises in the development of modern machine concepts for folding and cutting sheet metal.

Thanks to the 2006 integration of the Fasti Company and its workshops and a global presence, the Schröder Group is now a leading provider of machines for folding, cutting, crimping, beading, and circular bending sheets of all kinds. The diversity of the range of precision machines ranges from proven solutions for trade to innovative, high-performance machines for automated industrial production. The Schröder Group now employs more than 240 workers at various domestic and international locations.

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