216 – the universal solution

The 216 Schröder-Fasti folding machine is a universal solution to heavy forming needs.

216 series heavy duty hydraulic folding machine

Automatic adjustment of folding beam and bending center position relative to material for accurate control over bending radius. Automated crowning completes the settings needed for accurate, repeatable forms.

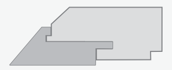
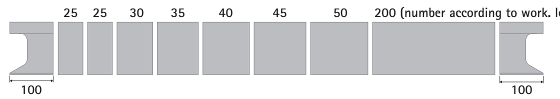
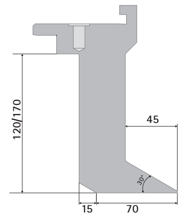
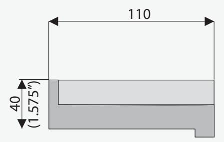
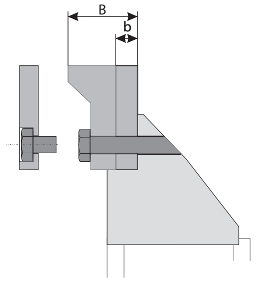
The 216 – a universal solution to heavy forming needs:

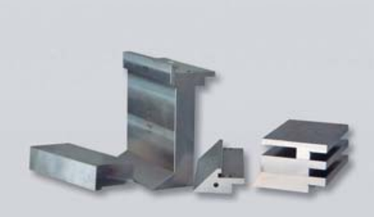
- Universal tooling allows for the full thickness range to be formed with a single tool set
- Quick change over between parts with precision ground segmented tooling
- 240 tons of clamping pressure increases capabilities and hemming capacity
- Compact and efficient hydraulic drive system
- High level of flexibility and productivity through the use of
  - Quick release hydraulic clamping of the clamping beam tooling
  - Quick release mechanical clamping of the folding beam tooling
  - CFP120 control system with color touch screen manages all 7 machine axis
  - Material thickness and radius change automatically adjusted via CNC control
  - Crowing system automatically adjusted via CNC control
- Extensive list of standard features, and an available option set to build the machine to match the specific needs of the customer

Technical details:

- All components are engineered using finite element analysis for maximum design control over deflection
- Manifold mounted proportional pressure controlled valves control the clamping and folding beam
- Straddle mounted maintenance free solid lubricant slide elements for the folding beam drive shafts
- Gear drives made of high-strength alloy, surface-hardened for maximum durablility

Standard equipment 216
CFP 120 control with 12" color LCD touch screen
Clamping beam WZS 2000, hydraulic tool clamping
Bottom beam WZS 2000, mechanical tool clamping
Folding beam WZS 1000, mechanical tool clamping
Folding beam adjustment, motorized 60 mm
Bottom beam adjustment, motorized 60 mm
Clamping beam stroke 500 mm

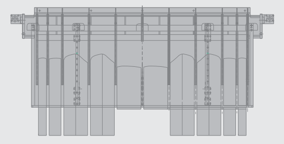
Standard available options 216	
Crowning device manual or motorized	
Additional equipment for 2-man operation	
Foot switch on rail for lateral movement	
Sharp nose blade „SA„ 45°, divided, ca. 1000 N/mm², surface-hardened, r = 8 mm, L = 500 mm (number according to working length + length completion piece) A wide variety of tooling types and geometries are available	
Goat's foot blade „C", H = 120 mm, r = 3 mm, hardend, segmented: -No. 1 - L = 2 x 25, 30, 35, 40, 45, 50 = 225 mm -No. 2 - L = 200 mm (number according to working length) -No. 3 - L = 2 x 100 = 200 mm  A wide variety of tooling types and geometries are available	
Bottom beam blade, ca. 1 000 N/mm²; hardened with or without finger grooves (minimum gauge 30 mm!)	
Folding blade ca. 1 000 N/mm², hardened, b = 18 mm or rather 70 mm A wide variety of tooling types and geometries are available	
MAH 25 - Motorized back gauge, steel balls in sheet support table (see picture on the right)	
Standard "R" shape gauge with 1 600 mm gauging depth	
"L" shape gauge extension	
"U" shape gauge extension	
Left and right side squaring arms	
Other gauging systems and features are also available	



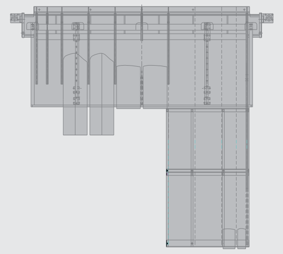
Tools of clamping beam, bottom beam and folding beam

Sharp nose blade, hydraulic clamping

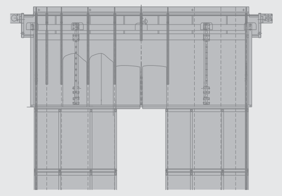
CFP-control



MAH 25 R (Standard)



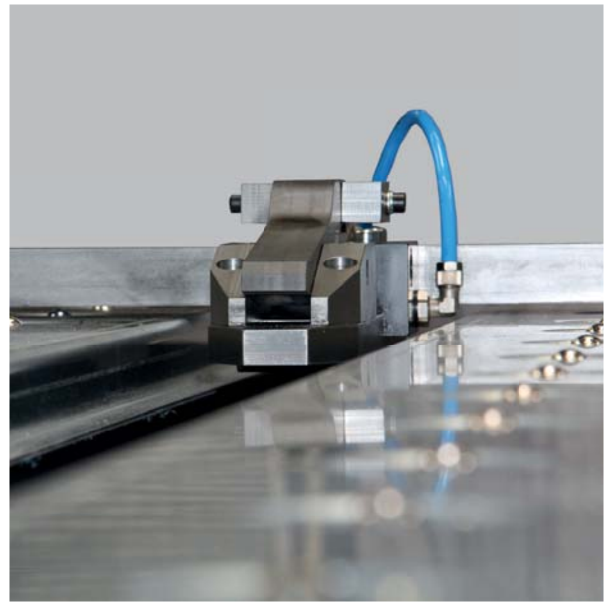
MAH 25 L (Optional)



MAH 25 U (Optional)

Equipment options of the 216

The 216 heavy duty hydraulic folding machine is designed to bend up to 16 mm (5/8") thick. Many standard options are available for specific applications, as are custom engineered options.



Gripper gauge systems effortlessly feed the part through the folding sequence, safely and securely. Ball screw back gauge drives assure precise positioning of the product.

Steel balls transfers are mounted in the gauging surface for easy sheet manipulation. Gauge pans up to 3 mm (11 gauge) in thickness easily support event the heaviest of gauging loads.

Back gauge

The MAH 25 motorized back gauge is engineered to handle huge heavy parts. The gauging table is outfitted with steel ball transfers for ergonomically effortless part manipulation.

Thanks to its modular design, the MAH 25 back gauge can be purchased in a number of different configurations, or updated in the field if your initial needs change.

CFP-control

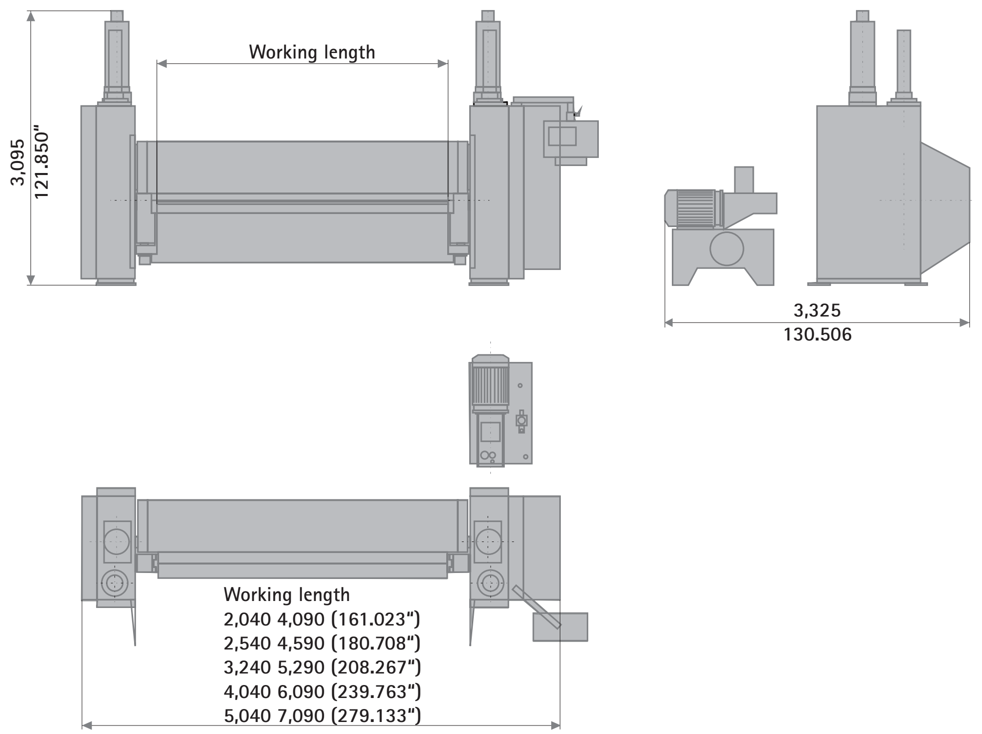
For operating the CFP-control no previous programming experience is needed.

Entries are made only via material thickness, material quality and tool set-up. The calculation of the crowning device is done automatically. In addition to a simple numeric input of folding data, if offers a number of additional program functions. Product matrix, variable programming e.g. for doors and panels, and tool storage for clamping-, bottom-, and folding beam are all part of its standard function.

Technical data and dimensions


Hydraulic cylinder for clamping beam and folding beam drive

Type 216	Sheet thickness [mm]	Working length [mm]	Main drive [kW]
20/10	10.0	2,040	37
20/12	12.0	2,040	37
25/8	8.0	2,540	37
25/10	10.0	2,540	37
25/12	12.0	2,540	37
32/8	8.0	3,240	37
32/10	10.0	3,240	37
32/12	12.0	3,240	37
32/16	16.0	3,240	37
40/6	6.0	4,040	37
40/8	8.0	4,040	37
40/10	10.0	4,040	37
40/12	12.0	4,040	37
50/4	4.0	5,040	37
50/6	6.0	5,040	37
60/4	4.0	6040	37



All dimensions in mm
All specifications are considered as guidelines and may be subject to change at any time.

Standard colour: RAL 7035 light grey, RAL 5003 sapphire blue. Special painting at an extra charge.

SCHRÖDER GROUP

Schröder Group

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

Founded in 1949, Hans Schröder Maschinenbau GmbH unifies traditional and modern approaches in machine building: Successfully managed as a quality and customer-oriented, family-owned company, Hans Schröder Maschinenbau is specialized in the development of modern machine concepts for bending and cutting sheet metal.

The successful integration of the Fasti Company in 2006 and its worldwide presence make the Schröder Group one of today's leading providers of machines for bending, cutting, beading, flanging, and circular bending all types of sheet metal. The company's precision machines range from proven solutions for craftsmen to innovative, high-performance machines for automatic industrial production processes. Overall, the Schröder Group currently employs more than 240 people at various locations at home and abroad.

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FASTI SCHRÖDER

HYDRAULIC FOLDING MACHINE
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