

TECHNICAL QUOTATION

Thank you for the interest in CIDAN technology.
We are pleased to offer you CIDAN products as follows

CIDAN FORMA FOLDER



FORMA

Table of content

FORMA.....	3
Technical specifications.....	3
The most important advantages.....	4
Drive system	4
Rotating Combi Beam	4
High divided box tooling.....	5
Straight rail.....	5
Folding beam.....	5
Folding beam tooling	6
Lower beam tooling.....	6
Automatic adjustment of sheet thickness	7
Crowning adjustment.....	7
AGS back gauge.....	8
Small parts gauging	8
Several rows of gauging stops.....	8
Control system ProLink W.....	9
Options.....	10
Multifold.....	10
High divided box tooling.....	10
Automatic stop	10
Safety laser scanner	10
Safety light curtain on gauging side	11
Round straight rails	11
21,5" widescreen ProLink W.....	11
ProLink offline	12
Height adjustable back gauge.....	12
Robot interface	12
Extra foot pedal	12
Moveable foot pedal on rail	13
Tool cart	13
Compressor	13
Cooling package.....	13
Auxiliary outputs	13
Smart factory software.....	14
Discover the smart planning tool for metal trims	14
nuEvolution	14
Terms	15

FORMA

The CIDAN FORMA power folder offers speedy production, easy ergonomics, strong construction, quick tool changes, and simplicity in programming. Reflecting decades of experience in technology and design, the FORMA metal folder is a "cross-over" capable of handling requirements from small series production to proper subcontracting.



Technical specifications

Model	Folding length	Folding capacity			Outer dimensions			Weight
		Steel ¹ mm	Stainless steel ² mm	Aluminum ³ mm	Length mm	Width ⁴ mm	Height mm	
FORMA31 Combi	3100	3,0	1,9	4,5	4465	2370	1980	4500
FORMA31 Multifold	3100	3,0	1,9	4,5	4465	2370	1980	4500
FORMA41 Combi	4100	2,5	1,6	3,7	5465	2370	1980	5400
FORMA41 Multifold	4100	2,5	1,6	3,7	5465	2370	1980	5400

Tensile strength ¹400 N/mm² – ²600 N/mm² – ³200 N/mm² – ⁴with motorized back gauge AGS

Opening height clamping beam..... 195 mm
 Motor clamping beam2 x 1,1 kW
 Motor folding beam.....2 x 1,5 kW
 Clamping pressure 180 kN
 Air pressure 6 bar
 Power 400 V
 Amperage 20 A

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The most important advantages

- ✓ **Combi Beam** as standard - gives you maximum flexibility with high divided box tooling and excellent straight rail geometry.
- ✓ **Height adjustable back gauge with Multifold*** - enables you to take on down-turned flanges anywhere on the back gauge, in any direction.
- ✓ **Limitless back gauge** with many back gauge fingers in many rows, spring fingers for narrow gauging without marks in the folded sheet, moveable rails* for extra flexibility.

**Options*

Drive system

The reinforced sides provides for a solid movement of the upper beam and folding beam. The eccentric driven clamping system eliminates wear and tear during movement and gives the most efficient opening and closing speeds. The eccentric dual driven clamp system removes the need to adjust parameters during life of machine which insures long life on clamping motor. When clamping, the dual motor eccentric clamping enables very high clamping pressure which is a great advantage when closing hems and working with larger tool heights.

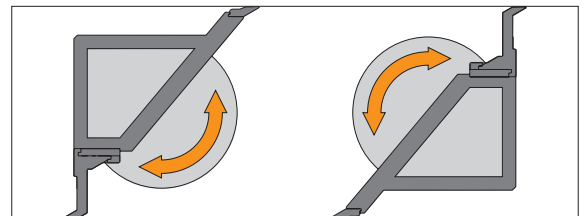
Rotating Combi Beam

FORMA is equipped with Combi Beam as standard, which means you always have access to two different tools. With Combi Beam it only takes 10 seconds to rotate and change from straight rail to high divided box tools. Combi Beam increases the flexibility and you will have the same opening height regardless of tool selection.

The Combi beam offers flexibility like no other tooling system. With a simple rotation of the upper beam, you can switch between the straight rail and box tooling in a matter of seconds. This gives the ability to form a larger variety of parts with little or no tool changing.



Straight rail and high divided tool in the sama machine.



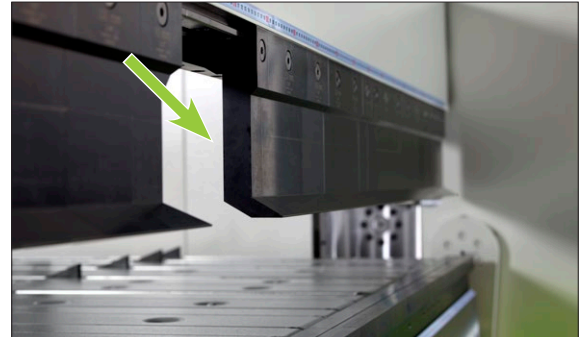
Rotation of Combi Beam, the change takes 10 seconds.

FORMA

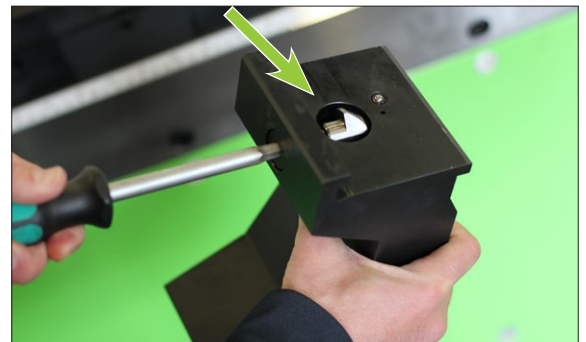
High divided box tooling

FORMA offers high divided box tooling in 125, 150 or 200 mm high, with quick change. These are available with two different nose radius. There are also divided C-shaped tools 125 or 150 mm high, that can fold deeper profiles than standard tools or straight rail. With high divided tools you gain more free space and can fold profiles with very fine measurement.

All high divided box tools are equipped with Quick Change, which makes changing and re-positioning very easy.



Box tooling in different heights and shapes.



Box tooling with Quick Change, easy to move.

Straight rail

In the upper beam you choose a straight rail for your needs. Available with different angles and nose radiuses.



Straight rail 30°, also available in hardened steel.

Folding beam

The folding beam is dual driven by two 1,5 kW motors, it is exceptionally rigid and stable but at the same time so narrow that the operator needn't step back when folding.

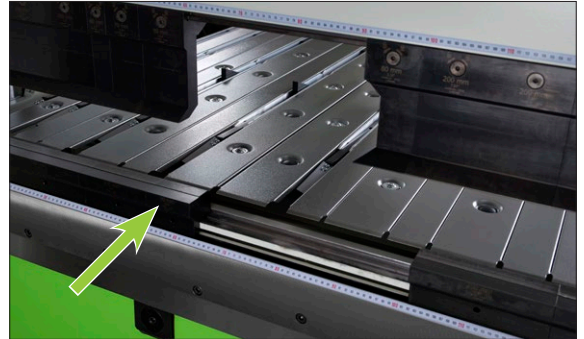


Powerful but yet short folding beam.

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Folding beam tooling

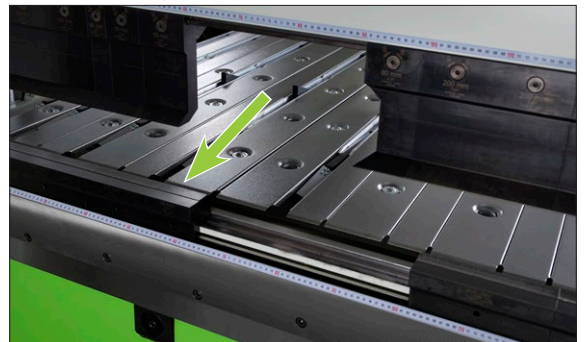
Folding beam tools are available in several dimensions from 7 mm up to 30 mm. If you want a FORMA with Multifold execution you chose divided fodling beam tools. The have the same dimensions as the standard folding beam tools.



Five different widths of folding beam tools.

Lower beam tooling

The solid lower beam tool will prevent any sensitive or light gauge material from getting damaged, scratched or indentations during clamping. For a FORMA with Multifold execution, chose a divided lower beam tool.



FORMA Multifold with divided lower beam tool.

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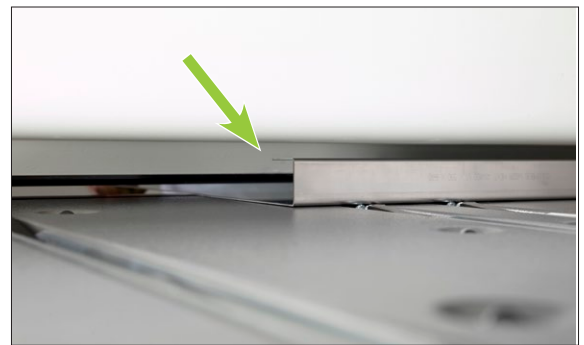
Upper beam clearance

FORMA is generously designed with opening height of 195 mm and the large recesses in the clamping beam, 60 mm high and 64 mm wide, allowing greater flexibility.



Large recesses in the clamping beam.

The height behind the straight rail is also well sized to make room for already folded details.



Ample height behind the straight rail.

Automatic adjustment of sheet thickness

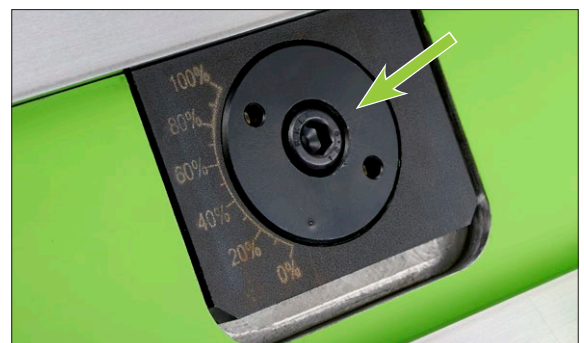
Via the ProLink W control, automatic adjustment of sheet thickness from 0-4 mm and manually 4 - 20 mm allows for more accurate and a tighter radius.



Adjustment of sheet thickness via ProLink W.

Crowning adjustment

Folding beam has crowning adjustment for forming various material types and thicknesses without compromising straightness of parts. Range of adjustment is 0 - 1,5 mm. Great for bump radius bending on cornice work!



Easy crowning adjustment.

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AGS back gauge

The base unit is U-shaped and spans over the length of the machine and has a depth of 1550/1050/1550 mm. AGS back gauge is equipped with ball screw, linear guides and servo motor for highest precision and repeatability. The back gauge speed enables the productivity to increase and at the same time, decreases the costs of your forming operation. Front stop units are made of spring steel as standard. The stop units can be dropped down automatically in every program row, which prevents any collision with the stop units when the sheet needs to be rotated. Back gauge panels can be moved backwards when folded details requires free space behind the lower beam tool.

Design your own back gauge after your needs with different modules. You can install additional modules to the right or left up to a total depth of 4300 mm and add in the middle section as well. For large applications like panels, doors and cabinets, we recommend a J-shaped or U-shaped back gauge. The operator can choose to work either at the folding or gauging side of the machine. Even 3 and 4 m parts can easily be handled by one operator.



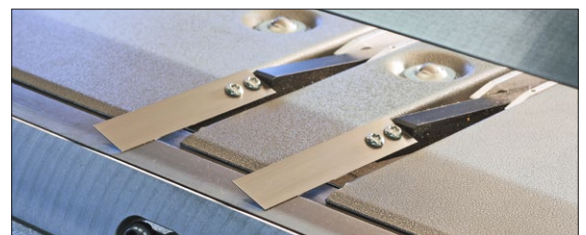
AGS back gauge 1550/1050/1550 mm as standard.



AGS back gauge designed after your needs.

Small parts gauging

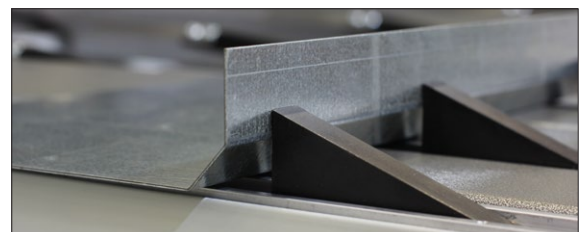
Staggered gauging across the length of the machine makes small parts gauging possible on either side and in the middle of the back gauge. The solid lower beam and spring steel fingers allow closer gauging to the bend line as well.



Spring steel fingers for close gauging.

Several rows of gauging stops

With several rows of gauging finger positions with "stops" at every 500 mm, any position on the back gauge can be reached in 2 seconds, speeding up the process between bends.



High solid fingers.

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Control system ProLink W

The ProLink W program is developed specifically for CIDAN folding machines and offers unlimited possibilities. From start to finish, ProLink W is designed for even an inexperienced operator to comfortably navigate, program, proof, and easily form parts.

Interactive graphic pictures are shown to the operator with instructions like rotate or flip the part, a condition to correctly being able to produce complicated details. In the control memory you can store a large amount of programs and you can also store programs on a USB stick as well. Every program can be saved with a graphical icon, with name and information.

The ProLink W calculates cut size and automatically creates a program. The finished part is shown with its actual folding sequence. The touch screen is mounted on a rotating bracket for optimal viewing. With the offline-software option, programming can be completed in the office away from the machine.



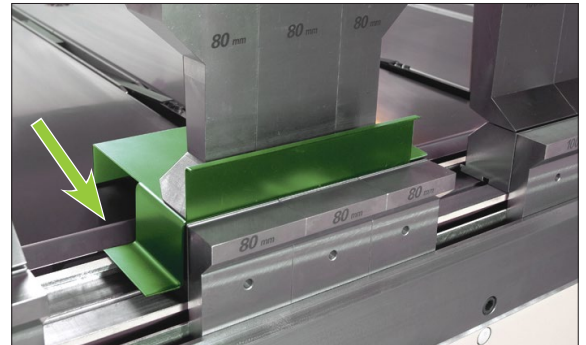
FORMA is as standard equipped with ProLink W with 18.5" screen on pendant arm.

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Options

Multifold

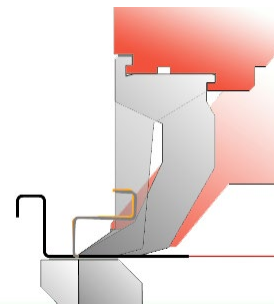
Divided tooling for maximum flexibility in every situation! FORMA with Multifold execution needs segmented tools in the lower beam and folding beam. This caters to parts that have flanges facing downward into the machine. This allows the operator to bend weld tabs and parts with interrupted bend lines. Multifold in combination with a height adjustable back gauge (option) increases the benefits and flexibility even more.



Multifold with divided tooling in the lower beam and folding beam.

High divided box tooling

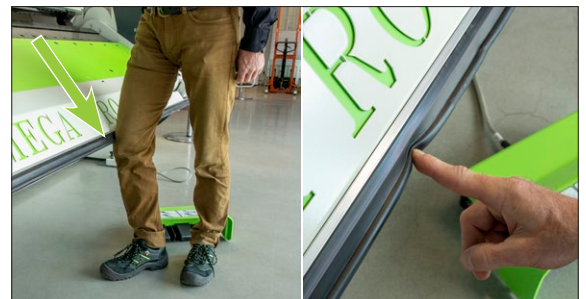
For FORMA there are several different box tools to choose between, 125, 150 or 200 mm high, with quick change. All with two different nose radii. We offer also two different C-shaped high divided tools, 125 or 150 mm high, allowing folding of deeper profiles than with standard tools or straight rail. With high divided tools you gain more free space and can fold profiles with very fine measurement.



C-shaped tools allowing deeper foldings.

Automatic stop

On the outer edge of the folding beam a rubber with built-in optical sensor is mounted. In the event of a collision with an operator, the machine stops immediately.



Automatic stop of folding beam.

Safety laser scanner

The safety scanner provides extra safety with two modes when operating machine from folding side or gauging side. The scanner prohibits any person to enter the working area where a collision with the folding beam is possible.



Laser scanner on the folding side.

Safety light curtain on gauging side

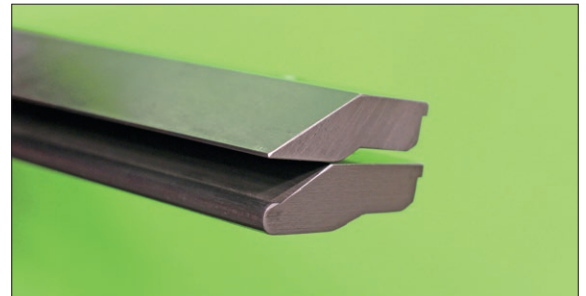
Safety light curtain on the gauging side protects the operator from any collisions with the rotating Combi Beam.



Safety light curtain on the gauging side.

Round straight rails

We offer a number of straight rails with different radius and angles. Straight rail 30° with radius 1, 1,75 or 2,5 mm. Straight rail 24° with radius 4,0 mm. Straight rails with larger radius is suitable when folding zinc and aluminum.



Round straight rails.

21,5" widescreen ProLink W

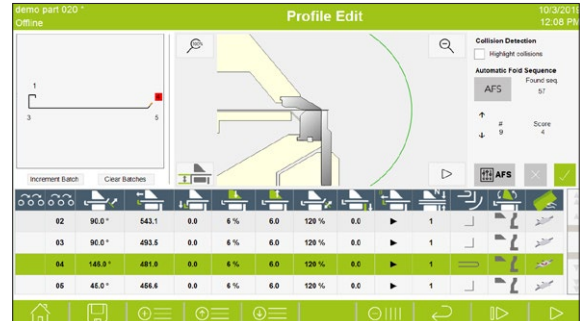
For even better overview and readability you can equip FORMA with a 21,5" touch screen.



ProLink W with a 21,5" screen.

ProLink offline

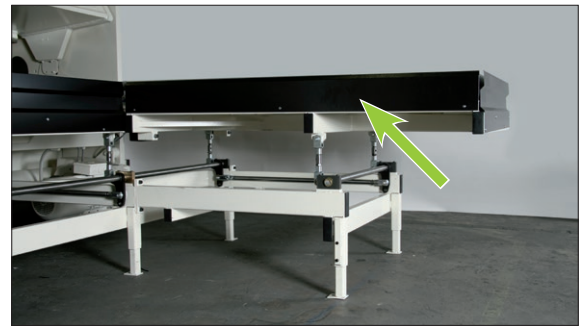
With the offline-software option on ProLink W, programming can be completed in the office away from the machine.



ProLink W off-line programming.

Height adjustable back gauge

Height adjustable back gauge is an option for FORMA with Multifold execution. Height adjustable between 0-36 mm, perfect for gauging reverse z-flanges on the back gauge.



Height adjustable back gauge for Multifold.

Robot interface

Prepared for robot. With robot you get a fully automatic production unit.



Folding machine served by a robot.

Extra foot pedal

Extra foot pedal with key switch. Suitable when you need to operate the machine from the rear.



Extra foot pedal with key switch.

Moveable foot pedal on rail

Allows the operator to move the foot pedal quickly and smoothly along the folding area. Appropriate when folding is done with several folding stations. This option is considered a great safety feature when bolted to the floor. When operator engages foot pedal, they are away from the upcoming folding beam.



Rail for moveable foot pedal, increases safety.

Tool cart

Safely store the divided tooling for your CIDAN folder. The tool cart is recommended to decrease the risk of damaging tools and misplacing tools during tool changing. It is possible to store divided rails on the cart and there is room for hand tools for the operators and machine instruction manual. The cart is equipped with lockable wheels and pull handles. A given accessory for machines equipped with Multifold.



Tool cart for safe storing of divided tools.

Compressor

For drive of the back gauge.



Compressor for the back gauge.

Cooling package

Cooling of the electrical cabinet, recommended if ambient temperature $> +35^{\circ}$.

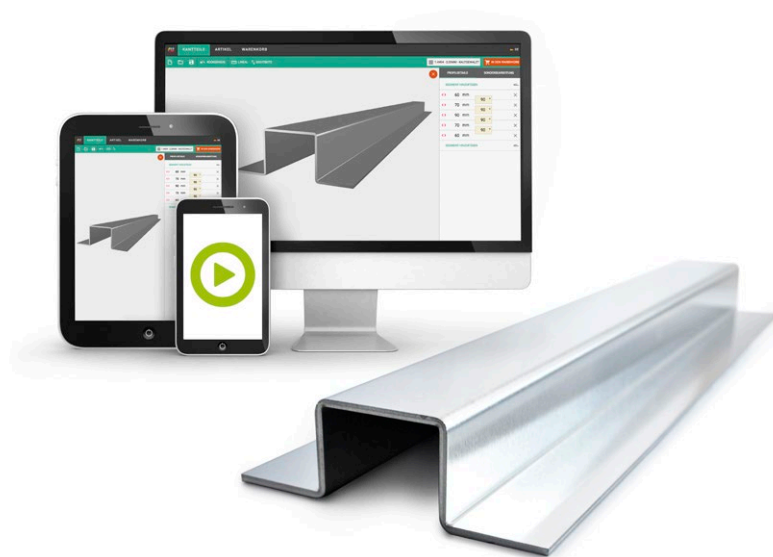
Auxiliary outputs

Auxiliary outputs for external communication (6 outputs).

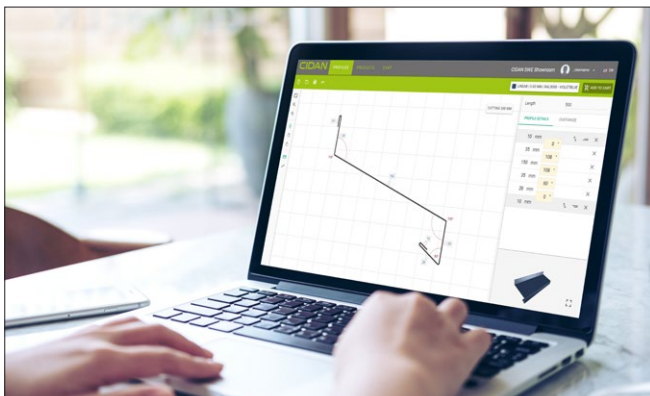
FORMA

Smart factory software

Discover the smart planning tool for metal trims



Efficient sheet metal working begins and ends with nuEvolution from nuIT – the smart planning tool that revolutionizes your entire manufacturing process. Combine nuEvolution with the impressive power and agility of our machines for perfect overview, good results, shorter lead times and increased profitability. All you need is a tablet or laptop and your finger



nuEvolution

nuEvolution is extremely user friendly and can be managed by anyone, anywhere. Draw or enter your desired profiles quickly and easily on the construction site, factory floor or wherever you are. Measure and adjust the angles easily so that your 3D profile matches reality. nuEvolution enables accurate values and makes your work playable easily. Select the color and material from the predefined materials and enter the desired length and number. The program ensures that you always deliver complete drawings, where no measurements or other data are missing.

Terms

Warranty

12 months or 1800 hours, whichever occurs first.

Others

Instructions in English. Service och repairs should be performed by CIDAN Machinerys own service department or by CIDAN Machinery Sweden AB approved service technician.

Changes and additions

If the buyer changes the financing form or for other reasons transfer the order to another buyer after the order is confirmed, CIDAN Machinery Sweden AB has the right to charge the purchaser or the buyer administrative additional costs of 300 EUR. When prepayment invoices are credited and rewritten to another buyer, the original invoice's due date applies.