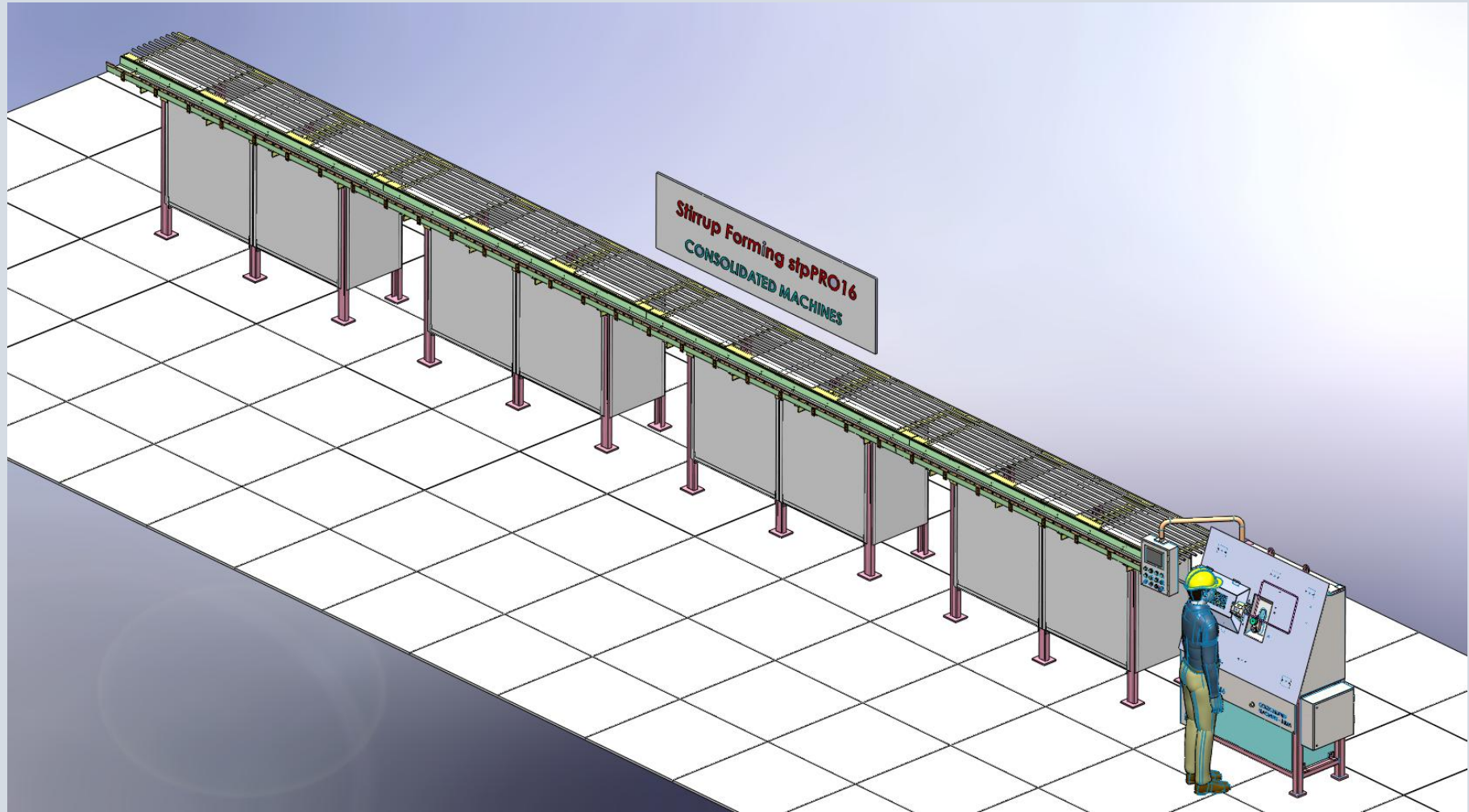


## ***AUTOMATIC STIRRUP LINE MODEL STPPRO16***



***GENERAL ARRANGEMENT VIEW***

## GENERAL FEATURES



CAPABLE MAXIMUM SIZE TMT BAR 16 GR Fe500 / 550D



ELECTRO-HYDRAULIC SYSTEM WITH PLC CONTROLS



BAR SUPPORT PEDESTAL WITH CONVEYOR TRAY TO ASSIST BAR FEEDING



PRODUCTION ESTIMATE PER TEN HOUR INDICATIVE: 2 / 10 TONS



PLANT FOOT PRINT: 14M x 2.5M



FULL AUTOMATIC FUNCTION



MODULAR DESIGN – EASY TO INSTALL / RELOCATE

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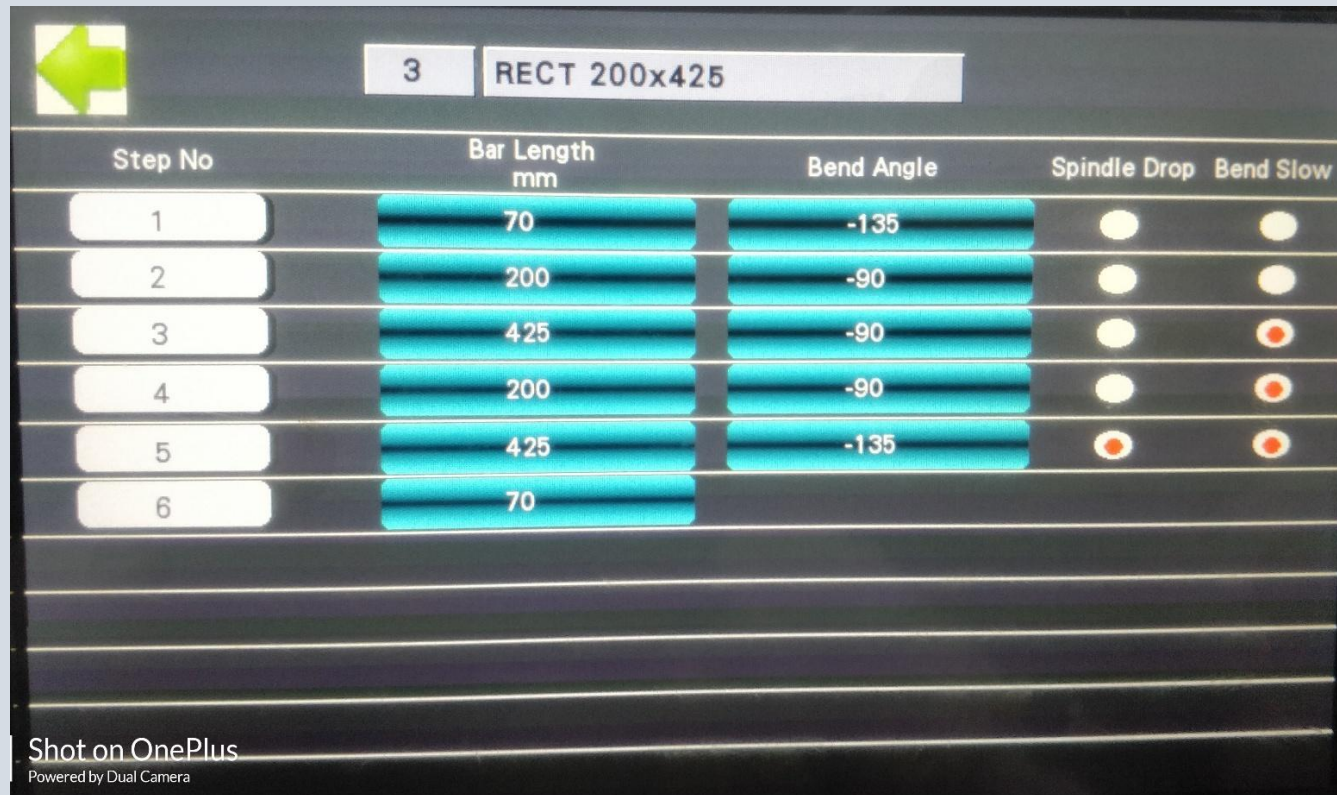
## MACHINE - AUTOMATIC STIRRUP BENDER STPPRO16



➤ **ELECTRO-HYDRAULIC DRIVE**

BUILT WITH BEST IN CLASS LIKE BOSCH REXROTH / YUKEN / SIEMENS

- **PLC CONTROL SYSTEM - A 12M STOCK BAR MAY BE FORMED IN VARIOUS STIRRUP SHAPES. SUCH DATA IS STORED AS A PROGRAM. A PROGRAM IS RECALLED AND MACHINE SET IN MOTION**



Step No	Bar Length mm	Bend Angle	Spindle Drop	Bend Slow
1	70	-135	●	●
2	200	-90	●	●
3	425	-90	●	●
4	200	-90	●	●
5	425	-135	●	●
6	70			

Shot on OnePlus  
Powered by Dual Camera



07-03-24  
12:45 PM

**PRODUCTION MODE**

**ALARMS**

**FIRST SELECT BAR SIZE THEN ENTER PROGRAM DATA**

Bar Size	PROGRAM NAME	STP LENGTH	QUANTITY	TOTAL LENGTH
8	zig zag	1292	11	14212
	175 rev	332	0	0
	RECT 200x425	1335	0	0
				14212

DBL BAR :  
**YES**

BAR STOCK LENGTH 16000 mm

USEFULL LENGTH 15480

UNUSED LENGTH +1268

**ACCEPT**

**HYD ON**

Shot on OnePlus  
Powered by Dual Camera

**FOR CONVENIENCE OR OPTIMIZE BAR WASTAGE – WE CAN RUN A CYCLE WHERE  
THE 12M STOCK BAR CAN BE FORMED IN DIFFERENT SHAPES WITH DEFINED QUANTILES.**

- BENDING CAPABLE – METRIC TMT SIZE 16/12/10 x 1 NO. SIZE 8 x 2NOS  
BEND TOOLING TO SUIT INNER BEND RADIUS NEAR 2xD
- PROTECTIVE COVER PROVIDED ON FEEDER INTERLOCKED WITH RUN MODE
- COMPACT ELECTRO-HYDRAULIC DRIVE IS INTEGRATED IN THE MACHINE
- POWER INSTALLED: STANDARD THREE PHASE AC MOTORS 5HP (3.8Kw)
- BENDING SPEED NEAR 40RPM (VARIABLE CONTROL) – IDEAL FOR LARGE SHAPES
- PULL SPEED NEAR 600 MM/SEC

### **PERFORMANCE ACCURACIES**

BENDING ACCURACY +/- 1.5 DEG OR BETTER

LENGTH ACCURACY +/- 2MM PER METER LENGTH OR BETTER

CAUTION – BENDING ACCURACY REPEATABILITY ALSO DEPENDS ON BAR MATERIAL ELASTICITY

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## CAUTION NOTES

IN GENERAL IN ANY AUTOMATIC PROCESS, THE MATERIAL CONSISTENCY IS IMPORTANT  
IN THIS CASE THE BAR QUALITY MATTERS FOR A SMOOTH OPERATION  
MILL BARS GOOD STRAIGHTNESS – UNIFORM DIMENSIONS AND ROUNDNESS – BAR RIBS UNIFORM  
AND LINEAR.

IF THE UNIFORMITY IS NOT SO GOOD, BARS WHEN PULLED TEND TO ROTATE WHICH DISTORTS THE  
PLANE OF THE PRODUCT. HOWEVER, OPERATORS MILD SUPPORT CAN CONTROL THIS ISSUE  
EFFECTIVELY.

ALSO THE MACHINE HAS THE OPTION TO ENGAGE “SEMI-AUTO MODE” WHERE THE PLANE OF THE  
FORMING PRODUCT CAN BE CORRECTED BEFORE THE FOLLOWING “BEND ACTION”

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## **BAR SUPPORT SYSTEM**

- 1. BAR RECEIVING PEDESTAL INTEGRATED WITH A ROLLER CONVEYOR, BARS TO PROCESS ARE DROPPED-IN. ROLLERS HELP THE BAR TO PROGRESS SMOOTHLY  
PEDESTAL LENGTH 12M – MAXIMUM WEIGHT CAPABLE 4T DISTRIBUTED**

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## **MATERIALS AND FINISH**

**TOOLING AND LOAD BEARING ELEMENTS OF ALLOY STEEL TOUGHENED, PHOSPHATE FINISH  
PANELS POWDER COATED, STRUCTURE FABRICATION WITH ZINC RED-OXIDE AND QUALITY PAINT  
FINISH**

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## CREDITS

- ✓ **SUITABILITY** : IDEAL FOR MID-LEVEL OPERATIONS LIKE 30/50 TONS PER DAY
- ✓ **DESIGN** : MODULAR DESIGN EASY TO INSTALL AND RELOCATE
- ✓ **CAPEX** : MODERATELY PRICED
- ✓ **PRODUCTIVE** : BALANCED AUTOMATION AND PRODUCTIVE
- ✓ **OPERATING COST**: MINIMAL LABOR
- ✓ **POWER EFFICIENT**: MOTOR RUN INTERMITTENTLY, SAVES POWER
- ✓ **MAINTENANCE** : SIMPLE CONSTRUCTION WITH PLC – WHICH MEANS EASY ON MAINTENANCE AND INVENTORY
- ✓ **SERVICES** : INDIGENOUS BUILT SUPPORT IS PROMPT

PROCESS OF CONTINUOUS IMPROVEMENT – SPECS MAY CHANGE



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