

ECA141



LEMUTH

IHRE RAHMEN BEKOMMEN FLÜGEL

CORNER CRIMPING MACHINE

The **ECA141** series **4-HEAD CORNER CRIMPAUTOMAT** is offered in two different versions for fundamentally different areas of application.

Corner crimping from "above" for aluminum shells

In this variant, the corners are crimped from above. The aluminum shells mounted with corner brackets are crimped on the inside. The advantage is a damage-free appearance on the outside.

Optionally, the crimped corners can be additionally glued to achieve greater strength.

from above



"Lateral" corner crimping for aluminum elements

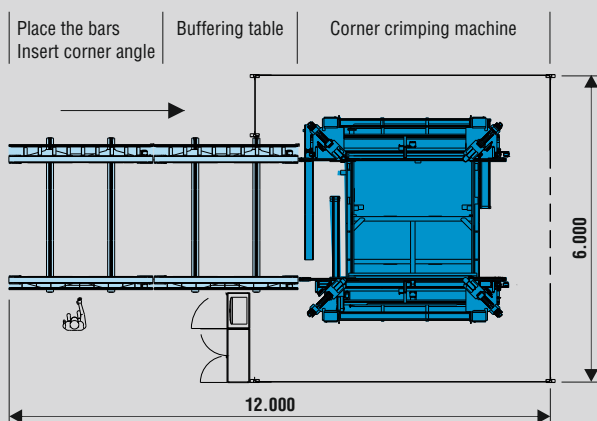
With lateral corner crimping, the corner brackets are crimped from the outside. This variant is suitable for profiles where the corner brackets are inserted into a chamber, e.g. for aluminum window and door profiles. Lateral crimping is possible at different heights thanks to servo-controlled height axes.

lateral



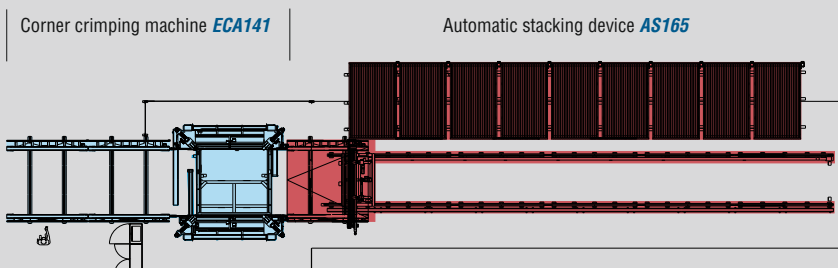
ECA141

Corner crimping machine



Optional equipment

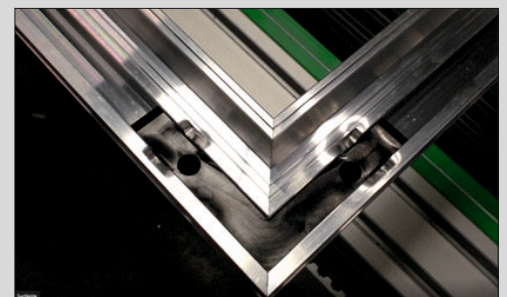
Corner crimping machine with automatic stacking device AS165

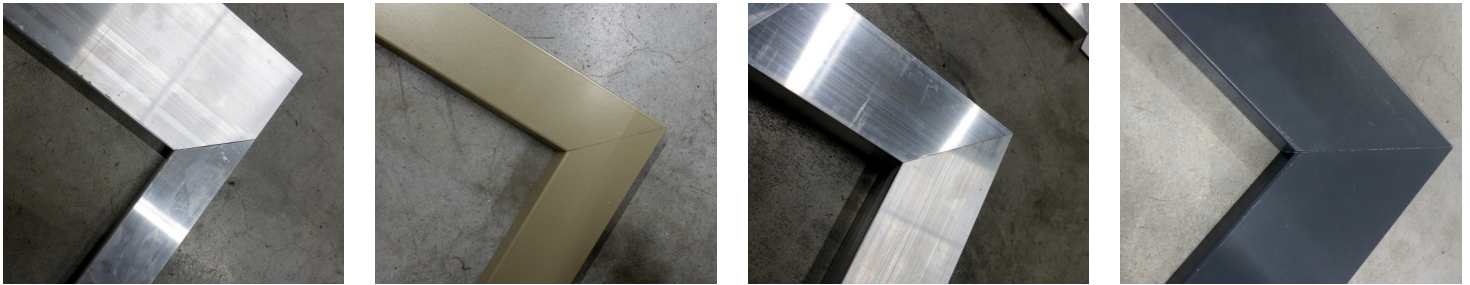


FURTHER HIGHLIGHTS

LEMUTH CORNER CRIMPING MACHINE

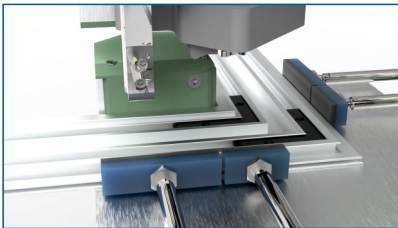
- automatic transport and crimping of open "U-elements" for doors
- additional supports, prevent deflection of large elements
- crimping different profile geometries to one element
- fully automatic stacking in compartment racks or trolleys





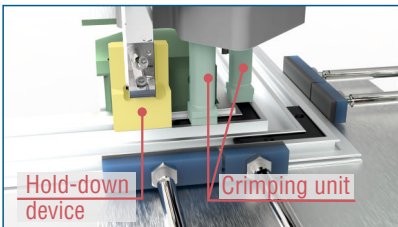
PROCESS OF FULLY AUTOMATIC CORNER CRIMPING

Two driven belts, which can be adjusted to the width of the respective element, are provided as a loading and processing table. After the four bars have been joined together with the corner guide to form a square, the element data is transferred to the machine. Driven belts act as table supports for both the **ECA141** and the downstream outfeed table and automatically adapt to the size of the element to be crimped. As soon as the element has been transported into the **ECA141**, the crimping process begins with the following sequence:



The profile bars are automatically pressed together in the X-Y direction to close the corners without gaps.

- The process sequences here are:
- right-angled alignment
 - determining the position of the element
 - tapping the element into the correct position



Hold-down device

Crimping unit

Measuring probes determine the exact dimensions and check the measured values for compliance with the tolerance limits. The final clamping and simultaneous crimping of all four sides then takes place. During the crimping process, measured values are recorded and analysed to determine the exact positioning of the punching element and the punching depth. All measured values from the punching process are documented in a database for each element.



Unclamping of the finished element and removal.



Adhesive cartridge

Bonding the corner brackets for aluminium shells

- Adhesive application with cartridges
- Servo adjustment of the adhesive outlet above the corner angle hole
- Adhesive application with motorised cartridge press

Optional Upgrade

