



# SERVO PROCESSING MODULES

High-performance processing  
modules for production, assembly  
and processing tasks

**BIHLER**

# Perfect interaction

Material feeding, thread forming, screw insertion, contact welding, parts handling.

Bihler's strength has always been the perfect interaction of the greatest possible number of production processes on one machine. Thanks to their modular design, high-performance Bihler servo processing modules can be flexibly integrated into production concepts on Bihler systems and third-party installations.

For maximum added value in your production.

## High-performance processing modules

Bihler servo processing modules are designed for the extreme conditions in serial production. These environments are characterised by quick cycle speeds and fast signal processing. The servo processing modules generally have to be operated in exact synchronicity with the machine. For maximum reliability, recording of measured values, sensors and monitoring functions are integrated into every process.



## User-friendly operation

The customised menu assists you with all your activities. Simple input screens facilitate quick parameterisation of servo process modules. Clearly structured operating menus are intuitive to use. Each process has customised input fields at different levels. On the second level (advanced) you can make detailed optimisations.

## One-stop shop

Bihler develops, manufactures and assembles all servo processing modules inhouse. You benefit from having one contact person for the process, device and control system. In this way, we even get behind the interfaces. If you have special requests, we modify the modules according to your individual requirements.



## Perfect support

The multimedia diagnostic online assistance system bASSIST integrated in the VC 1 control supports your daily work with info texts and operating instructions. You can quickly and easily store digital files like videos, PDFs or images for your tasks, setup operations etc. and also save time and money with remote maintenance. On receiving your approval, a Bihler specialist will connect to your machine, detect any faults in the control system and resolve operating faults and input errors immediately.



## Extensive process expertise

For more than 50 years, the integration of key technologies in fully automated processes has been one of the key areas of expertise at Bihler. The extensive process expertise gained, in particular in relation to Bihler welding technology, is an important factor in the global success of Bihler's production systems.



## Benefit from our service portfolio

Our sophisticated service portfolio accompanies you from the first feasibility study to the implementation of the production solutions as well as through the entire lifecycle of your machine.

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## Material feed

### Radial gripper form feed RZV 2.1<sup>1</sup>

Safe and precise feeding of strip and wire material at production rates of up to 1,200 strokes/min.<sup>3</sup>

- Freely programmable feed lengths from 0 - ∞
- Achieves faster feed times than mechanical feeds
- Wire and strip do not require setup
- Patented adjustment system that automatically adjusts thickness tolerances on the strip material
- Maximum wire and strip dimensions 9.0 x 300 mm (S, ∅ x B)



## Contact welding

### Contact welding devices D...Q... & servo control<sup>1</sup>

Reliable welding/soldering of contact materials to manufacture contact base components with production rates of up to 800 contact welds/min.<sup>3</sup>

- Different device types for contact sizes up to a max. of 8.5 x 8.5 x 3.5 mm (LxWxH)
- Processing of contact material for semi-finished products in profile shapes round, profile, square and sheet plates
- Rapid changeover system for shortest possible setup times
- Servo control guarantees flexible deployment
- Optional integrated set-back path measurement for quality monitoring



## Contact welding of silver graphite AgC

### Turntable welding device<sup>1</sup>

Reliable welding/soldering of contact materials made from AgC at production rates of up to 180 contact welds/min.<sup>3</sup>

- Complete system with feeding, separating and welding
- Very high electrode durability
- Welding in parallel or perpendicular to the selection area
- Unit designed for sheet plates and/or strips
- Integrated electrode cleaning system
- Optional integrated set-back path measurement for quality monitoring



## Thread forming/tapping

### Thread former unit GSE K/KS<sup>1</sup>

Highly efficient forming and cutting of threads on components at production rates of up to 260 threads/min.<sup>3</sup>

- 6 unit types for thread diameters from 2 to 20 mm
- Freely programmable device and process parameters
- Highly flexible deployment thanks to operation without mechanical pitch leader
- Rapid retooling system for shortest possible setup times
- Integrated process monitoring through control system e.g. detection of tool breakage, thread depth, ...



## Joining screws

### Multiple-use screw insertion unit MSE 2<sup>1</sup>

Quick and reliable joining of bolted connections at up to 180 connection operations/min.<sup>3</sup>

- Modular design: sub-system (for inserting only) or complete system (separating, positioning and inserting)
- Patented torque coupling for constant torque (0.1 - 2.0 Nm)
- Screws with thread diameters up to 8 mm
- Integrated process monitoring through control system e.g. screw check, revolutions, insertion path
- Freely programmable device and process parameters
- Special version can also be used for spring coiling



## Integration of progressive dies

### Servopresses SP 500 and SP 800<sup>2</sup>

Quick and easy integration of progressive dies

#### Technical data SP 500:

|  |                         |
|--|-------------------------|
| Speed:                                 | 400 1/min.              |
| Nominal force:                         | 500 kN                  |
| Stroke range:                          | 15 mm – 63 mm           |
| Infinitely adjustable stroke position: | 0 – 60 mm               |
| Tool mounting plate (L×W):             | 1,000 mm x 560 mm       |
| Opening size in BDC:                   | 287 mm                  |
| Column opening:                        | max. strip width 250 mm |

#### Technical data SP 800:

|                             |                         |
|-----------------------------|-------------------------|
| Speed:                      | 200 1/min.              |
| Nominal force:              | 800 kN                  |
| Stroke range:               | Fixed stroke with 30 mm |
| Stroke position adjustment: | - 8 mm from B.D.C.      |
| Tool mounting plate (L×W):  | 1,000 mm x 510 mm       |
| Opening size in B.D.C.:     | 324.5 mm                |
| Column opening:             | max. strip width 160 mm |



## Tool movements

### Servo units

Quick and exact execution of tool movements at process speeds of up to 240 1/min.<sup>4</sup>

- Freely programmable stroke movements and movement profiles
- Maximum power can be freely selected across the whole working range, no fixed BDC
- No change of mechanical components during setup
- Different sizes and models depending on the type of use:
  - Servo slide units (NCA) for linear movements
  - Servo lathe mandrel for purely rotational movements
  - Servo lathe mandrel for combined linear/rotational movements

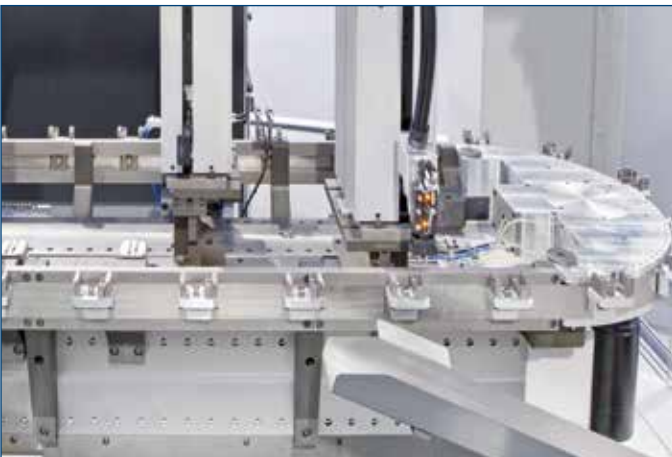


## Cutting and processing tools

### Servo press NCP

Precise punching and cutting of metal strips

- Different sizes for nominal power up to 400 kN
- Mechanical stroke position adjustment
- Fast cycle speeds up to 250 strokes/min.
- Optionally with integrated press power monitoring
- Compatible with presses of mechanical RM and GRM machines



## Parts transport

### Servo transport belt

Quick and reliable transporting and positioning of components at up to 150 cycles/min.<sup>3</sup>

- Freely programmable transport distances up to 100 mm
- Different sizes and variants depending on the type of use
- Very precise positioning of components
- Assembly accessible from all sides
- Horizontal and vertical operation possible
- Work piece carriers with rapid clamping and changeover system



## Parts handling

### Pick & Place unit PPE 1<sup>1</sup>

Quick and flexible parts handling at up to 100 P&P cycles/min.<sup>5</sup>

- Freely programmable axle positions
- Freely definable movement profiles
- Integrated distance measuring system for repetition accuracy of  $\pm 0.01$  mm
- Integrated temperature compensation
- Different gripper systems can be integrated
- Work area: vertical 60 mm, horizontal 150 mm



## Parts handling

### NC lift-rotate unit HDE 2

Versatile and flexible application with independently programmable lift and rotation axis (stroke 0 – 120 mm).

- Pick & Place with swivel arm and gripper, can also be used for sorting
- Increased pulse rate in rotary table mode with several grippers
- Time saving thanks to overlapping lifting and rotary movements
- Sleeve shaft for several pneumatic hoses and sensor lines ( $\varnothing 23$  mm)
- Rotary gland for pneumatic gripper and sensors for continuous rotary motion
- Repeatability (stroke, rotation):  $\pm 0.01$  mm

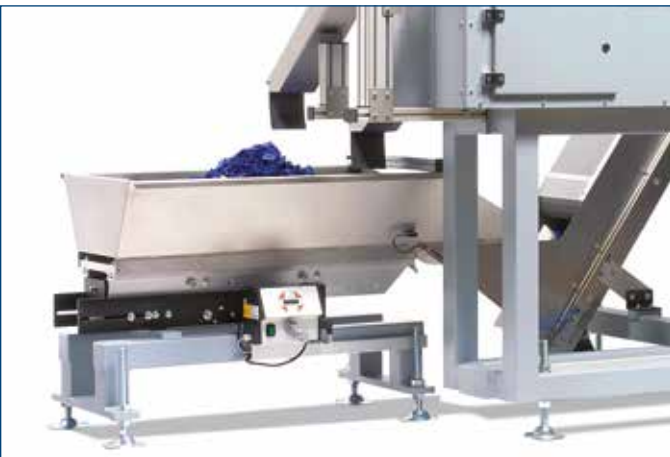


## Calibrating round components

### Servo radial press RP 5000

Surface pressure on component up to 5,000 kN

- Highly dynamic torque motor
- Up to 200 cycles/min.
- Electronic stroke range adjustment
- Rapid retooling system for active tool components



## Parts feed

### Flexible compact feed system ZSK<sup>1</sup>

Feeds parts at feed speeds of up to 30 m/min.<sup>3</sup>

- Complete system for bunkering, pre-separating, sorting and feeding parts
- Multi-lane feeding is possible
- Modular system, fast retooling times thanks to the ease with which parts can be changed
- Max. component size 50 mm<sup>3</sup>, max. part weight 80 g/component

<sup>1</sup> For more information, see flyer or brochure.

<sup>2</sup> By removing the blanking punch in the progressive die, the components can be processed further on the hanging rack on the BIMERIC system. This makes it possible to achieve additional added value.<sup>1</sup>

<sup>3</sup> Dep. on size / dimension / length / measurements

<sup>4</sup> Dep. on stroke length and load

<sup>5</sup> Dep. on gripper reaction times

Otto Bihler Maschinenfabrik GmbH & Co. KG  
Lechbrucker Str. 15  
87642 Halblech  
GERMANY  
Tel.: +49(0)8368/18-0  
Fax: +49(0)8368/18-105  
[info@bihler.de](mailto:info@bihler.de)  
[www.bihler.de](http://www.bihler.de)