



® for sheet metal
and profiles

ECKOLD Kraftformer KF 675

Universal machines
for chipless coldforming
of sheet metal and profiles



The new generation of Kraftformer

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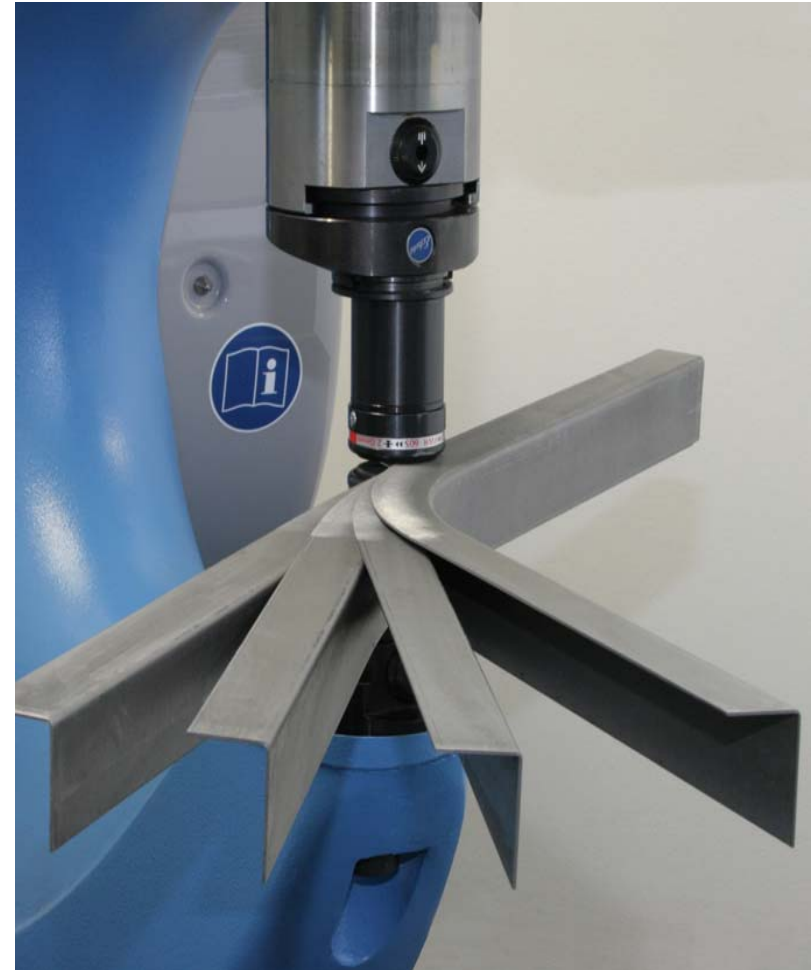


Kraftformer KF 675

ECKOLD Forming Technique

ECKOLD Forming Technique means:

- Forming of sheet metal and profiles without any impact of heat
- Precise and chipless
- One and the same machine is used for bending profiles and forming sheet metal, for manufacturing new parts as well as for doing repairs and most precise adjustments
- Tools can be mounted and changed within seconds
- Optimal utilization of the machines
- Intelligent ECKOLD technology is unique throughout the world
- Extreme robustness and longevity
- High pressure combined with a very sensitive control
- Variable due to the wide range of appropriate tools





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Views





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Characteristic features and advantages

The most important are:

- free choice of stroke speed from 150 up to 600 strokes/min.
- adjustable reverse position
- 25 storable processing programs
- repeatable results realised by storable processing programs
- repeating accuracy of 0,1 mm
- monitoring of tools
- electronic fault tracing
- new, contemporary design





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Modern user interface

The most important features and advantages:

1 Free choice of stroke speed

This can individually be entered and/or saved.
Factory setting is 150, 300 and 600 strokes/min.





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Modern user interface

The most important features and advantages:

2 Adjustable reverse position

Opens the ram e.g. for a better removal of components.

Repeatable results by defined working position.

Repeating accuracy of 0,1 mm





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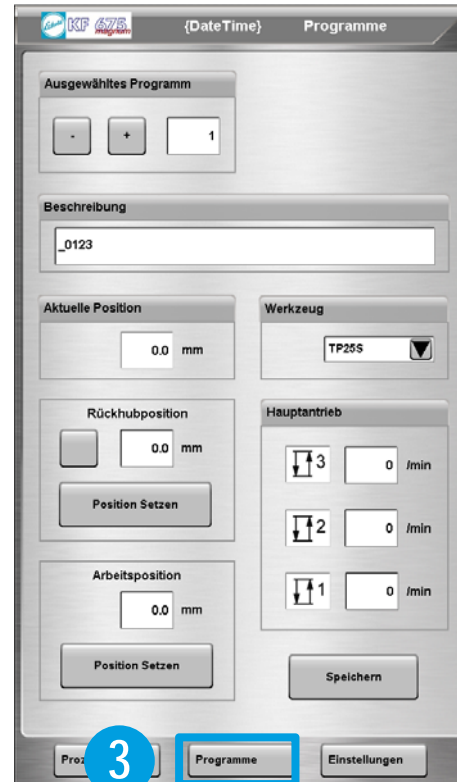
Modern user interface

The most important features and advantages:

3 25 storable processing programs

Repeatable results by storable processing programs

- selected program
- description
- tool
- return stroke position
- speed
- working position





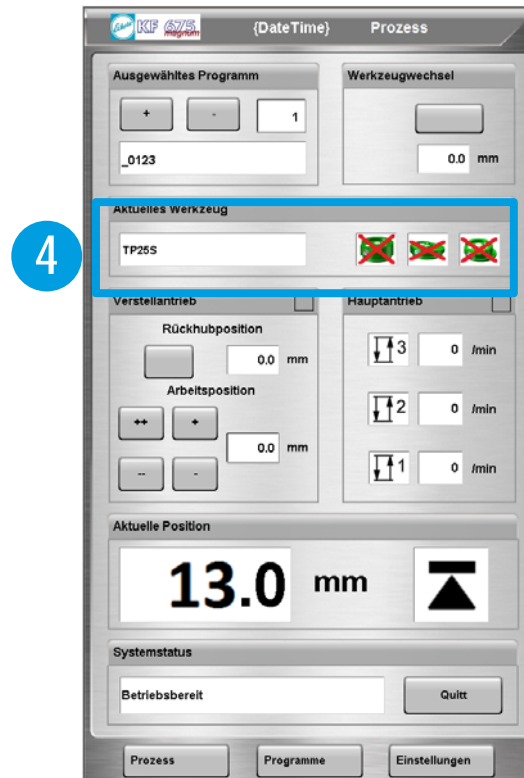
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Modern user interface

The most important features and advantages:

4 Monitoring of tools

Display on shortlist.
Mounting instruction for
required spacers and/or
reducing adapters.





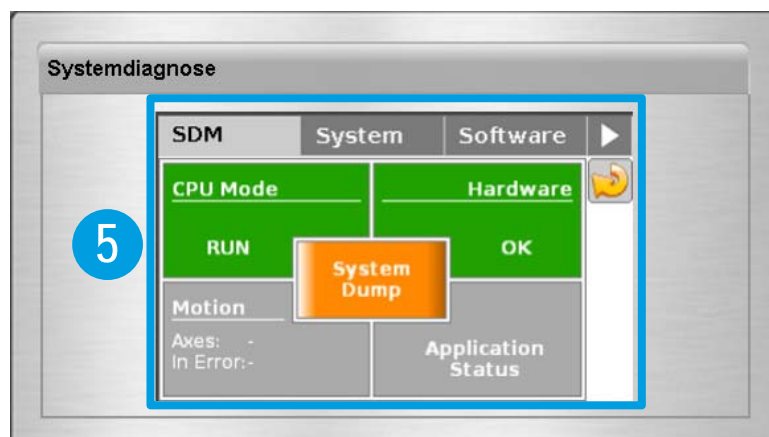
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Modern user interface

The most important features and advantages:

5 Electronic fault tracing

Display of system messages and fault indications





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New, contemporary design

Further optimizations:

- easy to maintain
- better accessibility of lubrication points





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Control cabinet

For controlling the servo drive

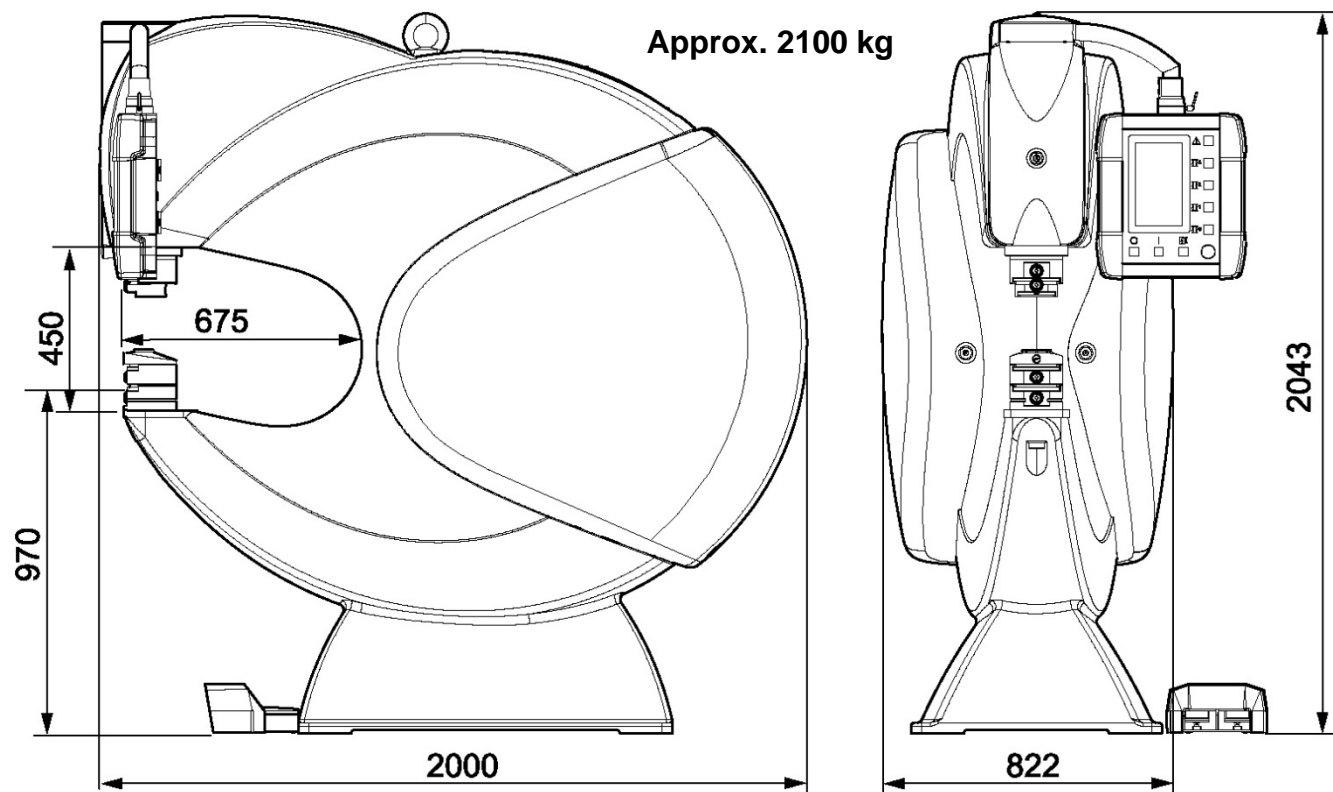
- **easy to maintain**
- **compact construction**





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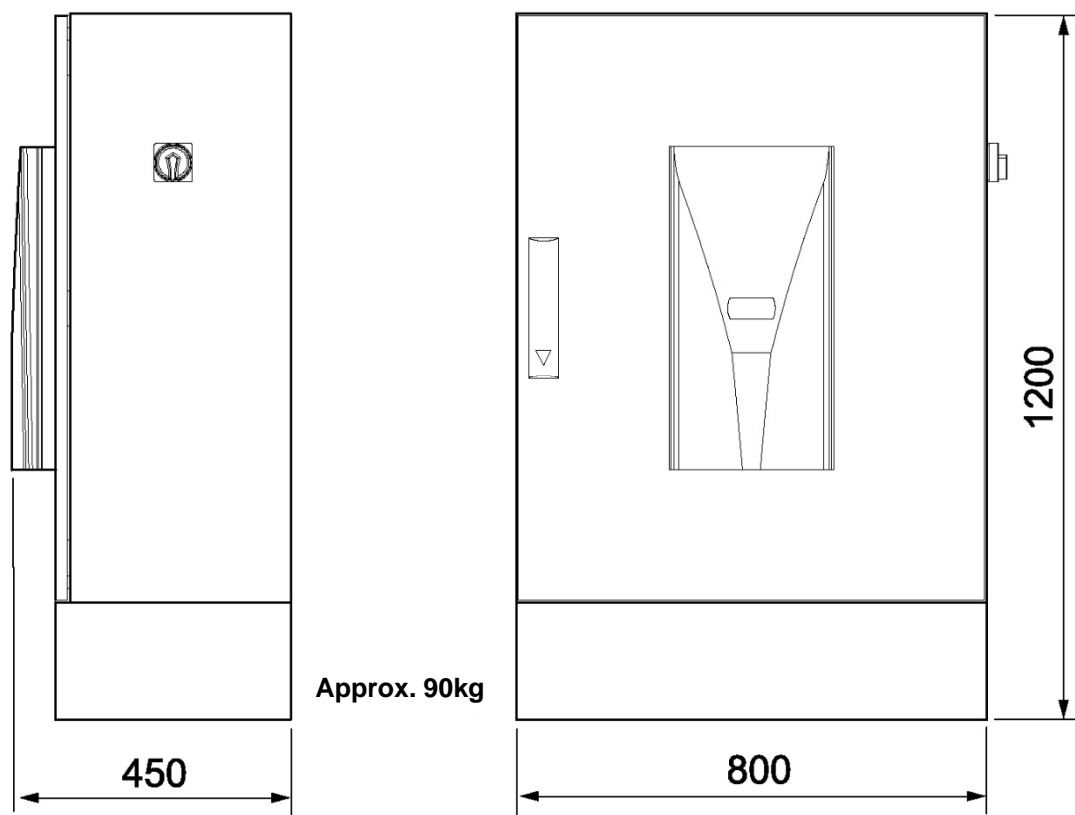
Dimensions of the machine





Kraftformer KF 675

Dimensions of the control cabinet





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Parameters

Parameters		KF 675
Throat horizontal		675 mm
Throat vertical		450 mm
Working stroke		max. 8 mm
Adjustable range of ram adjustment		0 – 80 mm
Working strokes per minute		150 – 600
Mains supply		200 – 240 V / 380 – 500 V / 3 Ph / 50 – 60 Hz
Rated capacity		6,0 kW
Control voltage		24 V DC
Max. fuse protection of supply line		35 A at 380 V / 25 A at 500 V
Weight of Kraftformer, net		~ 2100 kg
Weight of control cabinet, net		~ 90 kg
Steel sheet	(Rm = 400 N/mm ²)	6,0 mm*
Stainless steel	(Rm = 600 N/mm ²)	4,0 mm*
Aluminium	(Rm = 250 N/mm ²)	6,0 mm*

* These specifications refer to sheet metal in deep-drawing quality and with an FWA/FWR tool Ø 80 mm at 80 % material overlap.



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Tools

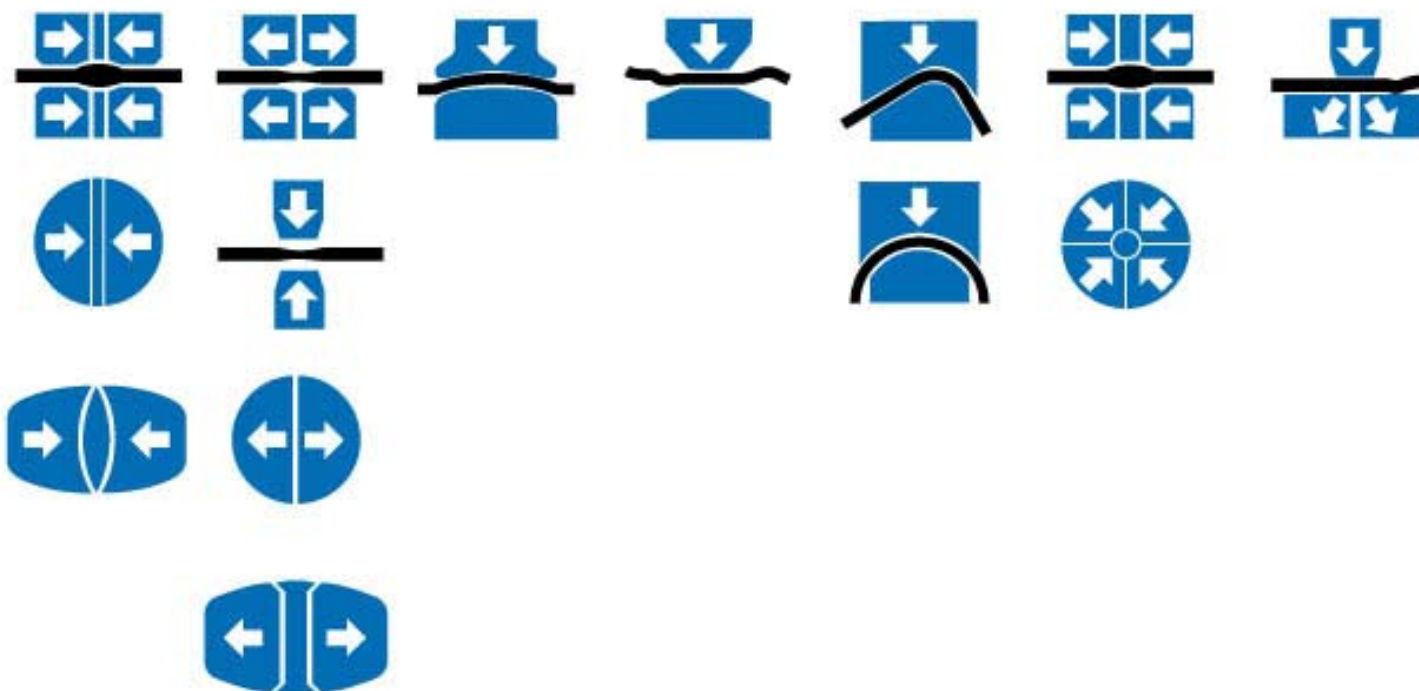




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Tools

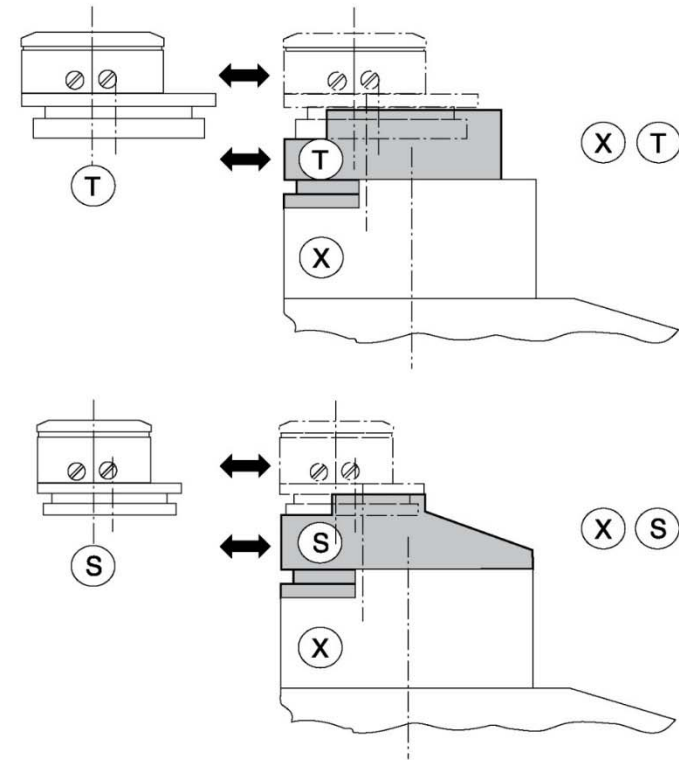
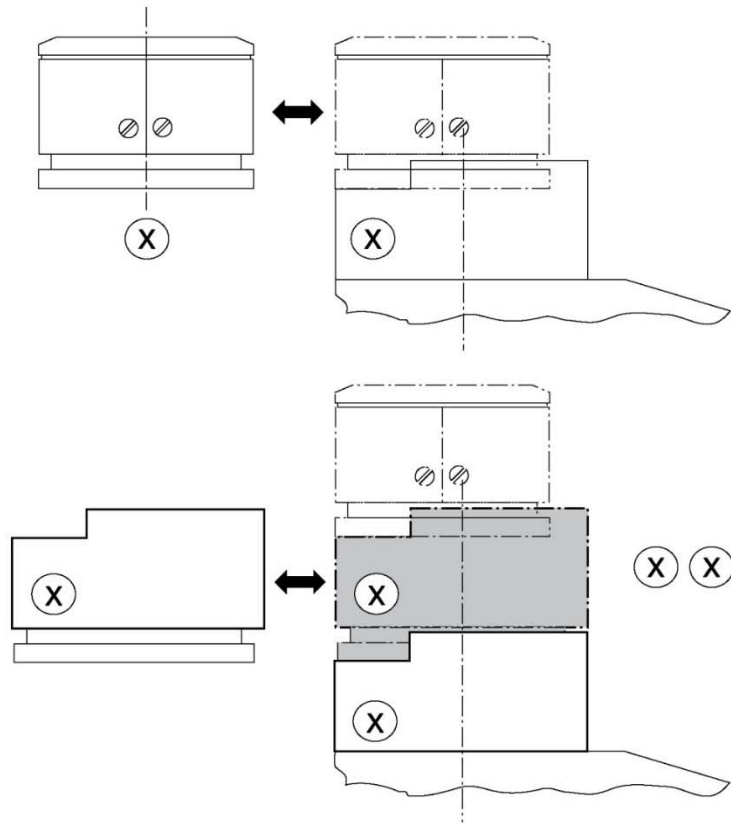
Shrinking Stretching Embossing Planishing Postforming Centering Straightening





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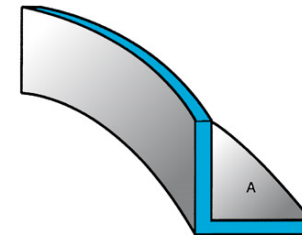
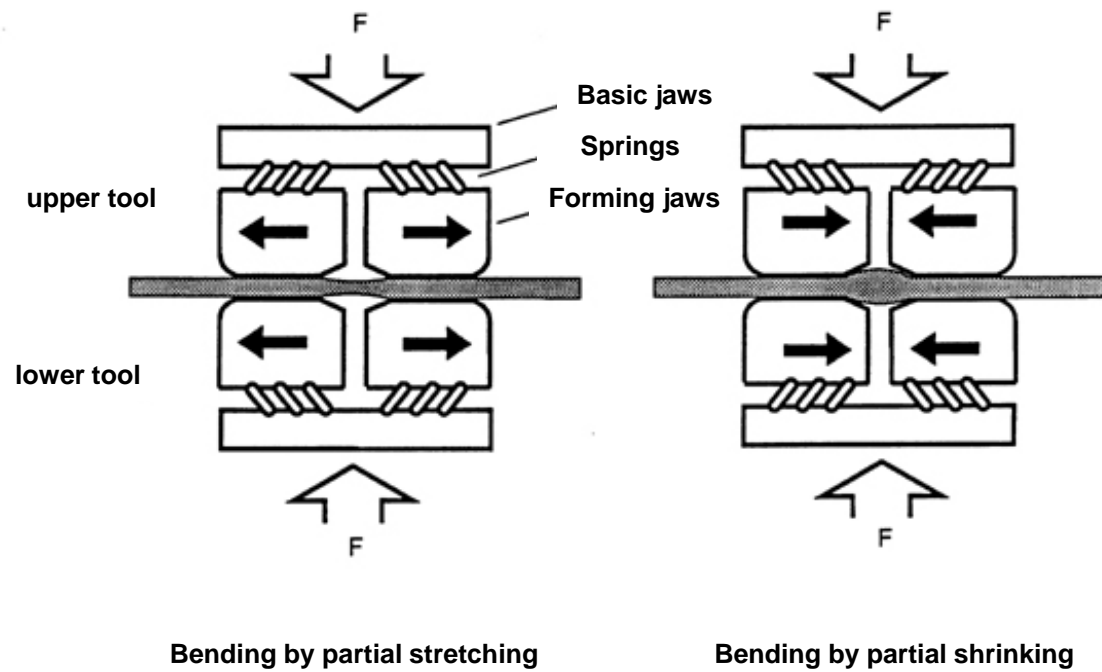
Tool change



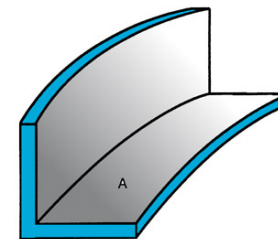


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Working principle stretching and shrinking



Stretching



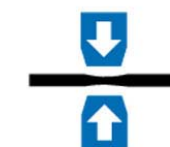
Shrinking



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Range of application

- Forming by precisely controlled stretching (extension) of the working area
- Bending of profiles by radius and curve bending





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Range of application SHRINKING

- Forming profiles, bending sheet metal and removing wrinkles by precisely controlled shrinking of the working area





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Range of application EMBOSSING

- **Doming (embossing) of sheet metal up to 6.0 mm thickness**





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Range of application PLANISHING

- Planishing and polishing of preformed metal parts.
- Rubber-cushioned impact surfaces ensure a low noise level and central working.





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Range of application PLANISHING

- Tools for postforming to planish and calibrate preformed work pieces.





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Range of application TENSIONING

- **Centrical shrinking**
removes tensions and
dents from metal sheets
and pressed parts.
- This is being done quickly
and precisely without any
impact of heat.
- Suitable for steel sheets
up to max. 2,0 mm
thickness and light metal
up to 3,0 mm thickness.





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Range of application STRAIGHTENING

- The straightening tool replaces the manual labour done by the worker regarding the straightening of warped and deformed parts.





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Kraftformer Machines





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Thank you for your attention

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