GRM SERIES
Mechanical stamping and forming machines
GRM 80E / GRM 80P
More economical large-scale production

Produce stamped and formed parts in large batches with even higher productivity. Benefit from the high performance and excellent manufacturing quality of the universal GRM machines. These mechanical machines offer cost-effective assembly production with their large processing space for stamping, bending, assembling, welding, thread forming, screw insertion etc.

Innovative quick-change systems and the excellent accessibility to all processing stations guarantee minimum setup and tool changing times. Equipped with the latest control technology you operate the GRM machines easily and comfortably.
Highlights at a glance

- Universal machine system for economical production of stamped and formed parts
- High production speeds of up to 250 l/min.
- Designed for radial and linear processing concepts
- Stable 300 kN two-point eccentric press with large installation capacity
- Large central aperture for variable central mandrel movement
- Accessories fully compatible for the whole GRM series
- Comprehensive control and monitoring functions
- Easy to use VC 1E control with 15" touch screen
Precise material feed
Mechanical standard, traverse and tandem feeds to satisfy the highest requirements for precision and speed. Feed time reduction offers larger head angles for comprehensive processing. Optional the highly dynamic NC radial gripper feed RZV 2.1 can be added.

Stable press for precise cuts
The stable 300 kN two-point eccentric press offers a lot of space for bulky cutting tools. There is plenty of space to fit dies up to 540 mm in length and 230 mm in width. For low cutting pressure a 100 kN eccentric press can be used. Compatibility to units of older machines is ensured. Separate press capacity monitoring is offered as an option for each con-rod.

Central mandrels for additional movements (GRM 80E/P)
The machine has a large opening in the work plate for horizontal control and ejection movements from the rear (length 644 mm, height 200 mm). 10 mounting positions on the rear offer variable mounting options for a maximum of 3 central mandrels. These movements segregate the tools, making them even more accessible and provide new areas of application. Optional: NC controlled central mandrels. This means the entire machine setup can be performed from the front.

Slide units with tool rapid-clamping system (GRM 80E/P)
Depending on the force required and the space available, cam driven, normal, narrow, sub-bed, wide or special design slide units are available with rigid or sprung retraction. To achieve fastest tool-exchange all slide units are equipped with a rapid tool-clamping system. Optional sensor-based protection of the slide unit guarantees maximum production safety.

Easy and fast handling
The punch-holder interlock is quickly and easily released by a pin. After the new tool is inserted it must only be fixed using the clamping pin.
GRM 80P
Stamping and forming machine

Highlights at a glance

- Powerful machining system for extended range of applications (sub-assemblies)
- High production speeds of up to 250 1/min.
- Greater processing room thanks to the spatial division of stamping and forming operations
- More than 2100 mm travel for linear tool applications
- 400 kN two-point eccentric press with large installation capacity for bulky cutting tools
- Integration of several NC axes for easier tooling solutions
- Large central aperture in the work plate for flexible central mandrel movements
- Easy to use VariControl VC 1 with 15” touch screen
Highly dynamic NC material feed

The NC feed RZV 2.1 impresses with high feed speeds and excellent positioning accuracy. Profit from variable feed lengths (zero to infinity) as well as various feeder entry lengths and movements (forwards and backwards) in one working cycle. The RZV 2.1 automatically compensates for thickness tolerances in the material.

The shorter feed angle leaves a greater machining angle for optimum cam plate movement. This results in smoother running and higher production speeds. A mechanical feeder unit with feed time reduction can be installed as an option.

Stable press for long tool service life

The 400 kN two-point eccentric press offers plenty of room for cutting tools with lengths up to 670 mm and widths up to 230 mm. The pretensioned press casing offers high rigidity - for maximum precision of workpieces and long tool service life.

Temperature sensors on the bearing positions and the integrated press capacity monitoring system guarantee maximum tool and process reliability.

Integration of NC axes

Integrate several NC axes in respective manufacturing concepts and simplify your tooling solutions. The compact NC units offer plenty of machining freedom. Working stroke, working location and motion profile are programmed freely over the entire operating range.

Maximum performance can be achieved at any time and in any stroke position. Forming motions can be implemented with constant force transmission. Conversion during tool changes can be performed quickly and easily without additional mechanical elements – simply with the controller.

More space due to separate press module

The clear separation of stamping and forming offers more space for bulky processes. With over 1400 mm travel for linear tool applications a total of more than 2100 mm is available on the work plate, if the press is included. Additional process modules for thread forming, welding, screw insertion, mounting, laser marking, etc. can be integrated with flexibility in different applications.

Highly accurate strip guide

Two drive positions are fitted below the press. Drawing bushings, forming anvils or forming movements can be initiated in the press from below. This means the punch strip does not have to be lifted when processing with the cutting tool. The strip guide is significantly more accurate. Complicated maneuvering in the cutting tool is avoided.

Protected all around

With the standard full machine enclosure you are fully protected. Two sliding doors on the front and back offer maximum personal and noise protection.
Intuitive handling

The GRM series is equipped with the machine and process control VariControl VC 1(E). The control system ensures simple handling and monitoring of complex production and assembly processes via a 15” touch display and a multifunctional keyboard.

Easy programming

Direct and easy programming of NC process modules (feeding unit, thread forming unit, screw insertion unit) via a simple input screen.

Support at the touch of a button

The extremely versatile remote maintenance solution fulfills the exacting support requirements. The portal provides full access to the machine’s control and all networked components. At the touch of a button on the control cabinet the secure connection is established.
**Technical data / Dimensions**

### GRM SERIES

#### 2106
- **Bar weight**: 2,220 mm; approx. 3,000 kg depending on equipment (without tooling)

#### 2406
- **Dimensions and Safety equipment**: EC Machinery Directive 98/37/EC, 2 sliding doors
- **Straightening**: Full enclosure for personnel and noise protection in accordance with the machine directive
- **Accessories**: Possible widths of strip and wire diameters are available

#### 3081,5
- **Central mandrel stroke system**
  - **Integration of NC units as option**
  - **Enlarged slide units**, max. stroke 50 mm, nominal force 45 kN
  - **Bottom slide units**, max. stroke 25 mm, nominal force 30 kN

#### GRM 80E
- **System concept**: Housing with single processing side; 22 drive positions for radial and linear manufacturing; rear side with 10 drive positions for central mandrel movements; centre aperture (length 644, height 200 mm)
- **Stroke rate**: Infinitely variable from approximately 5 to a max. of 250 rpm
- **Drive**: Infinitely adjustable drive; nominal drive power 17 kW
- **Control**: VanControl VC 1 process control in separate, stand-alone control cabinet 700x700x1100 mm with power supply unit and electronic control and monitoring system; operating panel with 15” TFT touch screen, keyboard and control elements; 1 machine-controller with I/O bus modules for the entire machine control; 1 tool-controller with I/O bus modules; standard are 2 freely-programmable modules, each of which is equipped with 8 channels programmable as input or output; 1 bus module 1 bus module programmable with 16 inputs and 16 outputs; 1 press force monitor as option, slide force monitor as option

#### 80P
- **System concept**: Housing with single processing side; 26 drive positions for radial and linear manufacturing; rear side with 10 drive positions for central mandrel movements; centre aperture (length 644, height 200 mm)
- **Stroke rate**: Infinitely variable from approximately 5 to a max. of 250 rpm
- **Drive**: Infinitely adjustable drive; nominal drive power 17 kW
- **Control**: VanControl VC 1 process control in separate, stand-alone control cabinet 700x700x1100 mm with power supply unit and electronic control and monitoring system; operating panel with 15” TFT touch screen, keyboard and control elements; 1 machine-controller with I/O bus modules for the entire machine control; 1 tool-controller with I/O bus modules; standard are 2 freely-programmable modules, each of which is equipped with 8 channels programmable as input or output; 1 bus module 1 bus module programmable with 16 inputs and 16 outputs; 1 press force monitor, slide force monitor as option

#### Pneumatic system
- **Hydraulic system**: Single-line central oil lubrication system for machine and system modules, optionally available with integrated oil recovery and/or oil disposal system; air-pressure activated pump, 4.5 litre capacity; function monitoring; 17 free quick-release couplings

#### Central lubrication system
- **Central mandrel stroke**: Installation of a maximum of 3 side-by-side positively-controlled or spring-return central mandrels possible, max. stroke 60 mm, max. nominal force 20 kN; max. 1 standard central mandrel, stroke 80 mm, nominal force 35 kN, as option: NC central mandrels

#### Feed
- **Press**: Two-point eccentric press; nominal capacity 400 kN; stroke 20 mm, fit to height at BDC 127 mm, stroke position adjustment +4 mm, mounting space for die sets up to 670 mm length and 230 mm width; max. strip width 80 mm (larger strip widths on request possible); electronic feed monitoring

#### Slide units
- **Accessories**: Bellcrank lever units, double slide units, coiling slide units, tie rod control units, etc. available upon request

#### Straightener
- **Safety equipment**: Full enclosure for personnel and noise protection in accordance with the EC Machinery Directive 98/37/EC, 2 sliding doors

#### Dimensions and weight
- **With full enclosure**: width 3,140 mm × depth 1,595 mm × height 2,220 mm; approx. 3,000 kg depending on equipment (without tooling)
- **With rapid release of straightening roller**, various versions for all admissible widths of strip and wire diameters are available
- **Full enclosure for personnel and noise protection in accordance with the EC Machinery Directive 98/37/EC, 2 sliding doors**
- **With full enclosure**: width 3,300 mm × depth 1,595 mm × height 2,220 mm, 4,500 kg subject to equipment (without tools)

*Additional versions can be used subject to application (subject to change without notice 10/16)*