

## Bending Device

SinglePowerLine 0812

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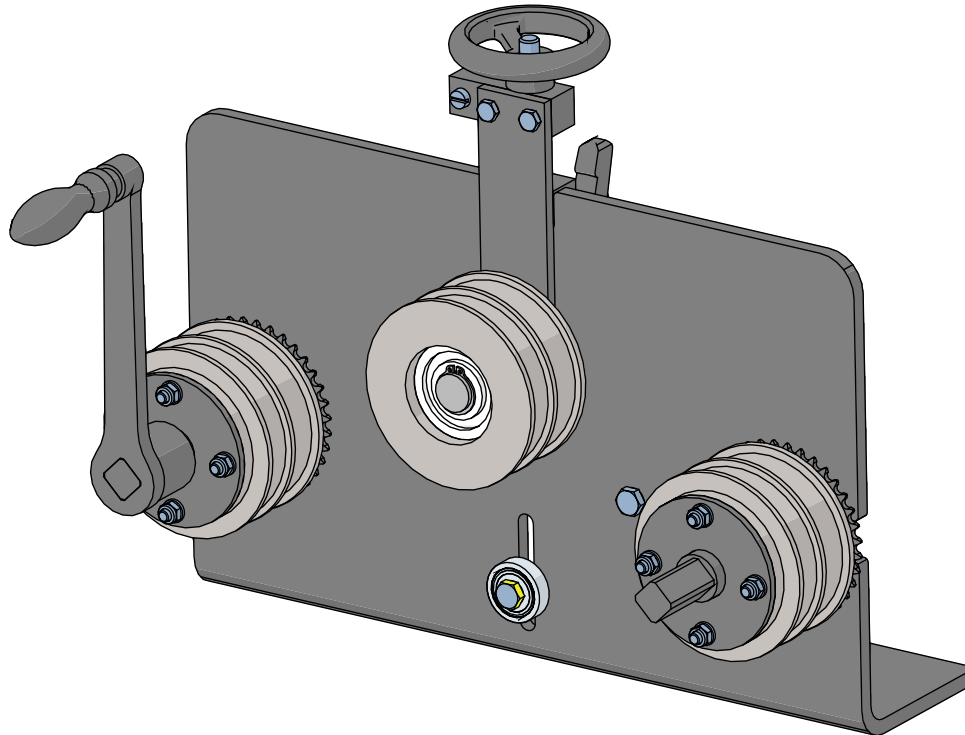
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## Bending Device

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### 1 Function of the bending device

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This bending device can be used to bend power rails horizontally and vertically. In horizontal bends, a maximum radius of  $R = 15\text{ m}$  can be achieved.

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### 2 Notes

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**DANGER!**

#### **Danger of crushing!**

There is a risk that fingers can be crushed if you reach into the machine while it is running.

→ Wear protective clothing (safety gloves, safety boots, etc.).

→ Do not reach into the running machine.



**CAUTION!**

#### **The access opening in the insulation profile must always face away from the machine!**

Be sure when placing it into the machine that the access opening is always facing away from the machine. This will also prevent the slot from being pressed together (due to the play).



**CAUTION!**

#### **Observe safe speed!**

The speed of the crank should not exceed 60 rpm.

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## 3 Producing a radius

Place the power rails in front of the bending device (e.g. on roller stands).

Since the profile is asymmetrical, a slight twisting cannot be entirely ruled out.

Installing the rail bend in the hanger clamp generally orients the rails correctly, so that the passage of the current collector is not impeded.



#### Copper power rails can deform when bent horizontally!

If the profile cross-section is deformed, there is a risk that the sliding contact could be caught.

→ Use the plastic inserts provided (see Fig. 1) to counteract the deformation of the profile cross-section.

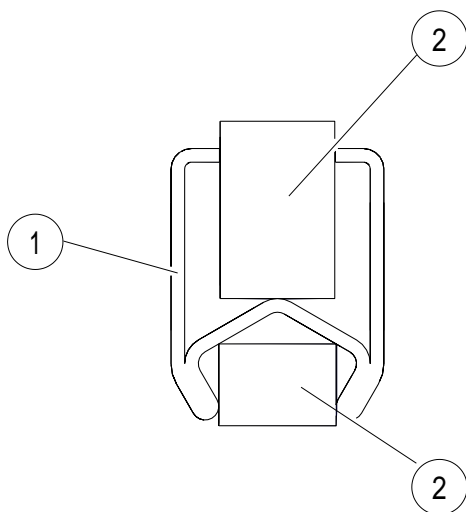


Fig. 1: Plastic insert (included in scope of supply)

Item	Name
1	Copper power rail
2	Plastic insert (material no.: 081011)

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If the adjustable roller is set to 8.6 using the scale, the resulting radius will be about 15 m.

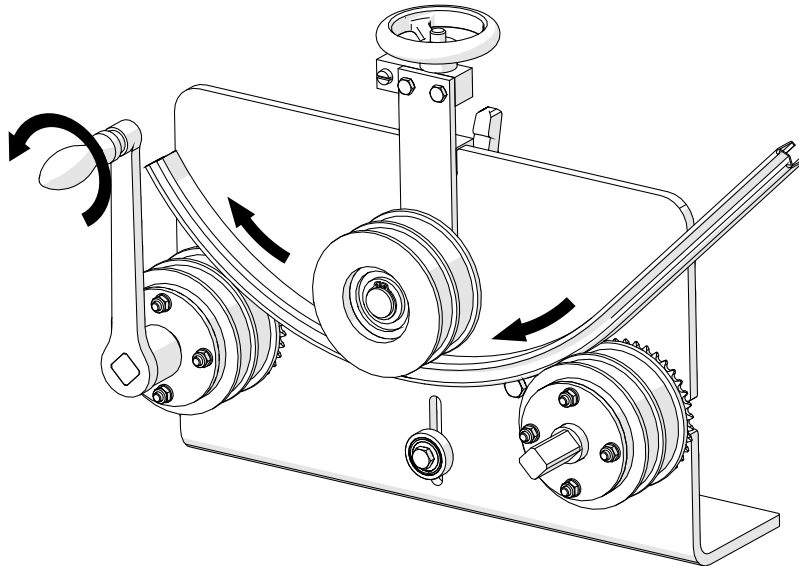


Fig. 2: Producing a horizontal bend with bending device 0812 (material no.: 081010)

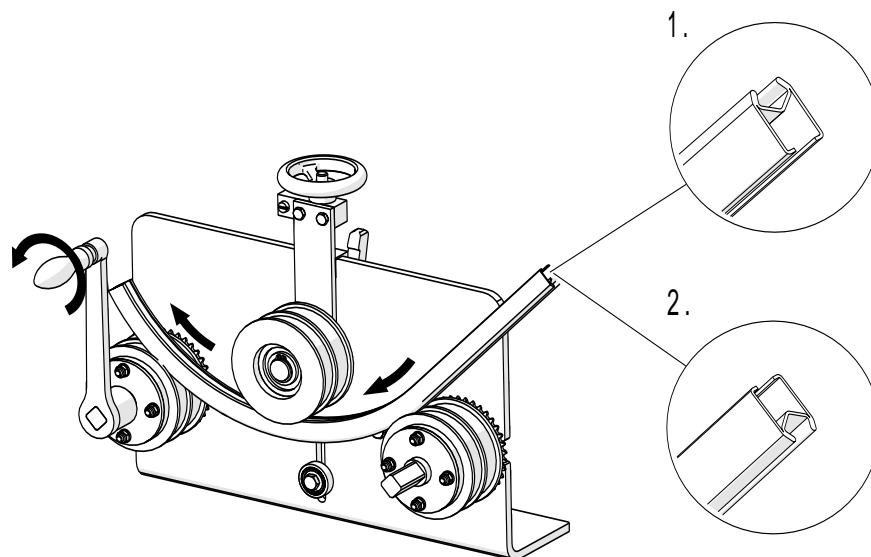


Fig. 3: Producing a vertical bend with bending device 0812 (material no.: 081010)

1 = Inside bend

2 = Outside bend

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#### 4 Cutter on the back of the bending device

If radii less than 1,500 mm will be bent (only possible for outside bends), then the pack of the insulation profile must be cut using the cutter on the back of the bending device. This reduces the IP protection to IP 20. The permissible bending radii depend on the type of bend and the materials of the power rail and the insulation profile.

To do this, pull the power rail and its insulation profile by hand through the opening with the blade. The "noses" located inside the insulation profile will continue to provide contact protection despite the slit on the back.

After slitting the insulation profile, you can bend the power rail step by step into smaller radii. This bending should always be carried out in the same direction, that is, after achieving an intermediate radius, the power rail should be pulled back and only then pushed through again.

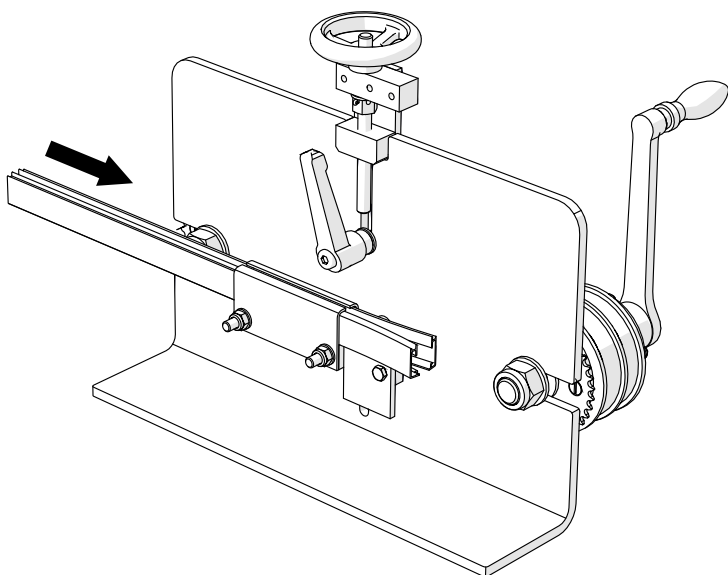


Fig. 4: Cutter 0812

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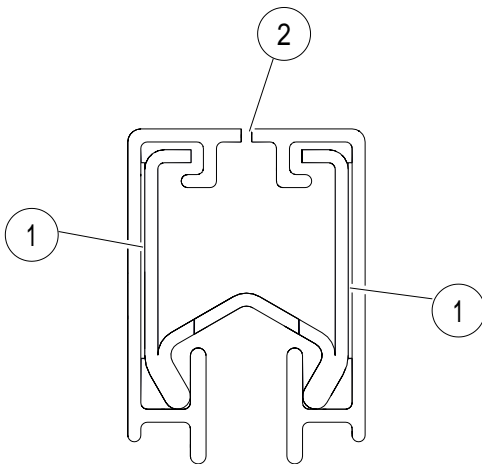
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## 5 Preventing stripping/clamping of the sliding contact of the carbon insulation on the insulation profile

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To prevent the carbon insulation from being stripped off, the following procedure can also be used for larger radii: Before inserting the insulation profile, first stick a layer of packing tape (1) into the inner side of the insulation profile. Then insert the power rail into the insulation profile.



Item	Name
1	Packing tape (15x07 mm)
2	Cut

Fig. 5: Packing tape

Bends with a radius > 1,500 mm should preferably be the goal.

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