

A family-owned company with over 30 years of industry experience. WRAZIDŁO specializes in designing and manufacturing of tools and machines for various metalworking applications. We also offer machining services with the support of an experienced Design & Development department.



Our company is proud to own an exceptionally versatile and modern machine park. We continue to develop our workshop with new cutting-edge solutions - CNC machining centres, measuring machines and others, in order to maintain the highest quality standards of our products and services.

Electrical tube & profile end calibrating machines

Line of innovative machines for precise forming and dimensional calibration of tube and profile ends. With the use of specialized, custom-designed tools the machine is capable of performing operations such as:

- expanding,
- diameter reduction,
- simultaneous inner- and outer calibration (KRIO),
- forming to a given end shape (e.g. "bicon" forming),
- hole punching, groove piercing, etc.

The machines are available in both single- and double-head configurations and can be equipped with a **digitally controlled matrix rotation system** which provides higher dimensional precision of the calibrated workpiece and improves the efficiency of the production process.

All **ELECTRA WR-K** machines are based completely on electrical drive systems. This guarantees better energy efficiency, reliability, quiet and comfortable operation, and most of all - **much higher precision and repeatability** of the calibration process when compared to solutions based on hydraulic components offered by our competitors.

Our calibrating machines are offered in a variety of configurations and can be equipped with additional features or accessorized with external tooling, for example:

- data matrix code reader (QR) for the calibrating tooling sets simplifying the tooling setup and serial production process,
- automated coordinate tables with digital position readout and innovative, customdesigned tube insertion fixtures for improving the repeatability and performance of production processes,
- additional optical scanners and safety barriers,
- integration with a robotic arm,
- **Punch & Cut** expansion - a set of special tools for tube end-cutting and groove piercing

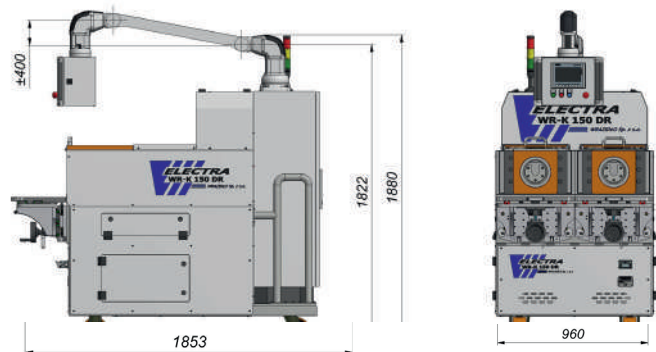


ELECTRA WR-K 150DR

Dimensional capabilities for forming & calibrating	<ul style="list-style-type: none"> • diameters up to 150 mm • wall thickness up to 4,2 mm • calibration length up to 150 mm
Electrical tool rotation	<ul style="list-style-type: none"> • continuous 360° rotation • 0.1° resolution
Configuration	<ul style="list-style-type: none"> • double-head • also available in a single-head configuration as ELECTRA WR-K 150R

ELECTRA WR-K 150DR

Placement configuration	Free-standing, on wheels
Construction	Integrated, modular
Power supply (voltage)	3x400VAC 50Hz
Control system voltage	24VDC
Nominal power consumption	Depending on the workpieces being produced
Work cycles	<ul style="list-style-type: none"> • manual (I or O) • auto (IOOI, OIIO, IOIO, OIOI, etc. with the capability of incremental calibration in given number of steps) • cycle start via foot pedal switch
Max. power consumption	max. 32A
Power	5kW
Supply data	<ul style="list-style-type: none"> • power supply cable - recommended cross-section 5x2.5mm² • power supply socket 32A • 6 bar air supply
Dimensional forming capabilities	<ul style="list-style-type: none"> • diameters up to 150mm, • max. wall thickness 4.2mm for calibration length not exceeding 50mm (material Rm ≤ 500 MPa) • max. calibration length 150mm with wall thickness not exceeding 2,0mm (material Rm ≤ 500MPa)
Matrix rotation	<ul style="list-style-type: none"> • rotation range 0-360° • 0.1° rotation resolution
Interface	<ul style="list-style-type: none"> • HMI Siemens TP700 7" touch panel • controls installed on a swiveling arm • easy, clear and user friendly
Weight	ca. 2300 kg (without tooling)



Special features

Tube cutting tools



Groove piercing tools

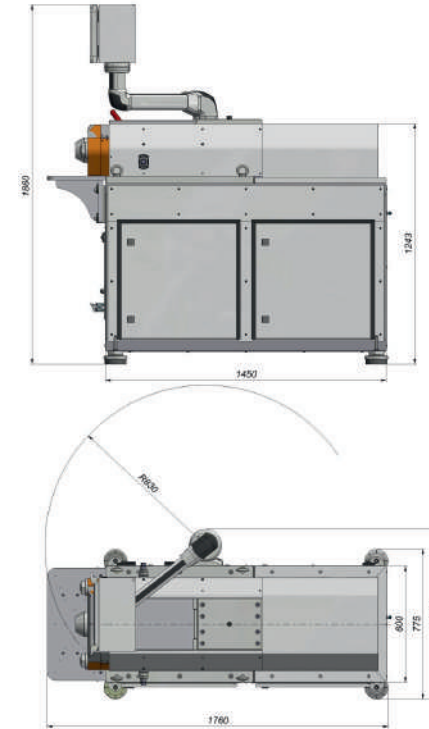


Robotic arm integration

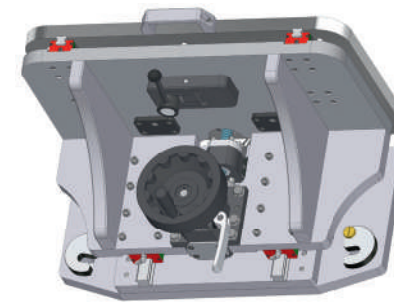


ELECTRA WR-K 75R

Technical overview



Coordinate table



ELECTRA WR-K 75R

Same specification as ELECTRA WR-K 150DR, with the exception of:	
Placement configuration	Free-standing on rugged floor
Dimensional forming capabilities	<ul style="list-style-type: none"> • diameters up to 75mm, • max. wall thickness 4.2mm for calibration length not exceeding 50mm (material Rm ≤ 500 MPa) • max. calibration length 150mm with wall thickness not exceeding 2,0mm (material Rm ≤ 500MPa)
Matrix rotation	<ul style="list-style-type: none"> • rotation range 0-30° • pneumatic rotation
Weight	ca. 1100 kg (without tooling)

Tools



ELECTRA WR-K 150R

Dimensional capabilities for forming & calibrating	<ul style="list-style-type: none"> • diameters up to 150 mm • wall thickness up to 4,2 mm • calibration length up to 150 mm
Electrical tool rotation	<ul style="list-style-type: none"> • continuous 360° rotation • 0.1° resolution
Configuration	<ul style="list-style-type: none"> • single-head

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