

FORMING THE FUTURE



## BLANKING LINES

# BLANKING LINES FROM SCHULER.

## CUSTOMIZED SOLUTIONS FOR YOUR PRODUCTION.

### PERFORMANCE ALONG THE LINE.

Blanking lines from Schuler offer the complete manufacturing process – from coil to the blank stack – all from a single source. They employ cutting-edge safety and control concepts. The modular construction method allows Schuler to offer solutions that exactly meet the customer's needs. All line components have a proven track record of performance in the plant. They are precisely interfaced with one another to guarantee the highest levels of uptime and reliability. Extensions can easily be retrofitted for the processing of aluminum and high-strength steels. And wherever Schuler equipment is in use – our services are available around the world.

**Maximum output with ServoDirect presses.** In addition to conventional presses (mechanical or hydraulic), lines for manufacturing shaped blanks are now increasingly being equipped with servo presses. Thanks to Schuler's ServoDirect Technology, the motion curves of the press can be individually adapted to various blanking dies. This results in significant increases in both output and die service life. Moreover, lines featuring this technology are designed to process a wide variety of materials, such as aluminum or high-strength steels. Even surface-sensitive materials can be processed safely at the highest production rates.



Blanking line with press.

All upstream and downstream automation components, such as the roll feed with servo direct drive or flexible Stop2Drop stacking device, support the press performance and ensure highly dynamic blank production. The high degree of automation ensures fast product changes and smooth operation of the entire process.



Blanking line with cut-to-length shears.

**Blanking with cut-to-length shears – the solution for simple shapes.** For the production of rectangular, trapezoidal or curved blanks, Schuler offers blanking lines equipped with cut-to-length shears. If the manufacturing process is limited to simple shapes, then cut-to-length shears represent the ideal solution – both in terms of purchase price and performance. The shears can be optionally equipped for automated tool changeovers.



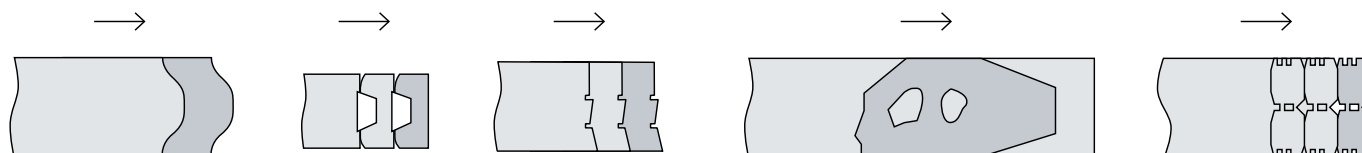
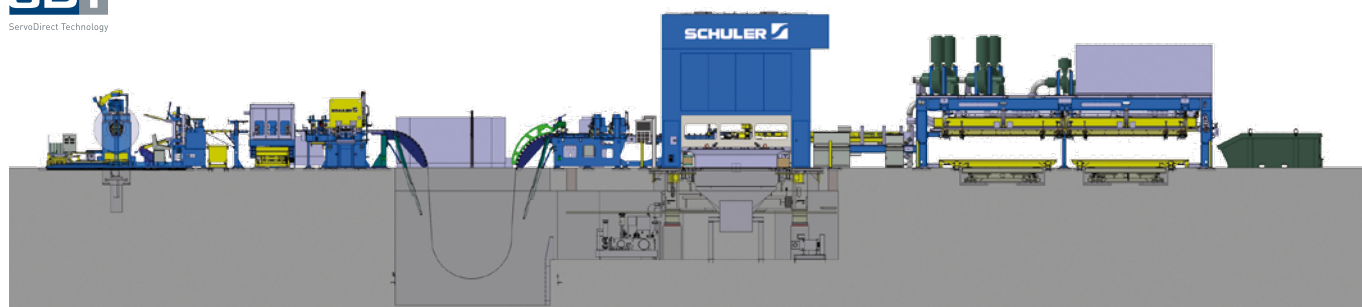
Blanking line with laser cell.

**Flexible and space-saving: laser blanking.** Laser blanking lines are also particularly well suited to production processes with frequent product changes, as no dies are used in laser cutting. There are therefore no investment costs at all for dies, die maintenance or die storage.

Thanks to its compact design, the line can also be used in restricted spaces and low-height production halls. With its innovative DynamicFlow Technology, it offers highly flexible manufacturing conditions at comparatively low costs. Laser blanking lines can process a wide variety of materials – such as aluminum and high-strength steels – and ensure a high degree of productivity even for surface-sensitive outer panels.

# OUR BLANKING SOLUTIONS AT A GLANCE.

## BLANKING LINE WITH PRESS.



Blank shapes when using a press with swiveling tools (stroke rate max. 105 min<sup>-1</sup>).

### PERFORMANCE OF BLANKING LINE WITH SERVO PRESS

	Feed length [mm]	300	500	750	1,000	1,500	2,000	2,500	3,000	3,500	4,000
Servo press basic version [spm]		75	71	64	59	51	42	35	30	28	28
Servo press with higher level of automation [spm]		91	79	70	64	51	42	35	30	28	28

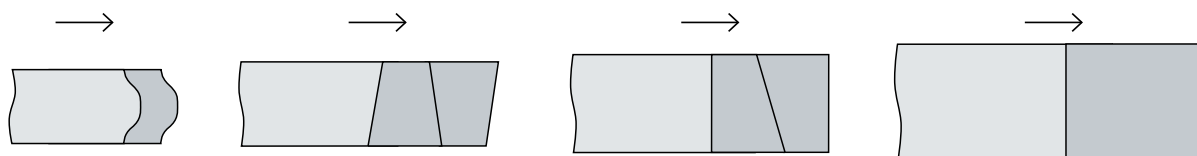
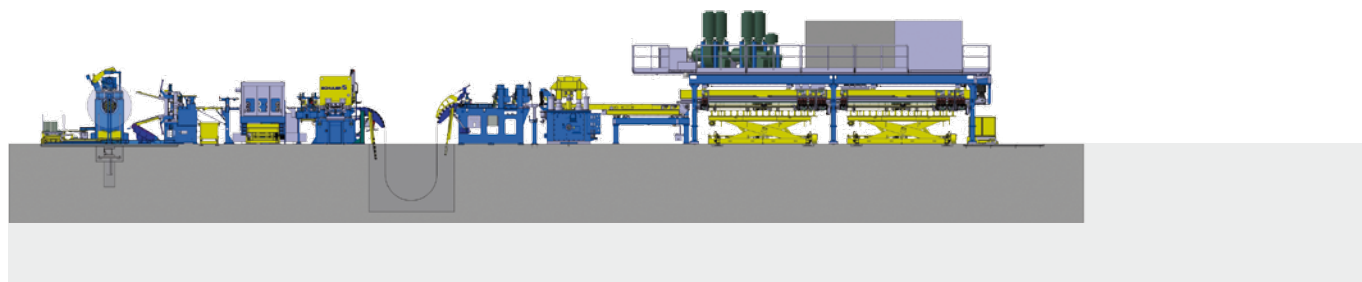
### THE ADVANTAGES

- Ideal for the production of shaped blanks
- High output rates
- High level of automation
- Gentle on the die thanks to ServoDirect Technology
- Proven technology



# OUR BLANKING SOLUTIONS AT A GLANCE.

## BLANKING LINE WITH CUT-TO-LENGTH SHEAR.



Blank shapes when using a cut-to-length shear (stroke rate max. 120 min<sup>-1</sup>).

### PERFORMANCE OF BLANKING LINE WITH 4-COLUMN CUT-TO-LENGTH SHEARS

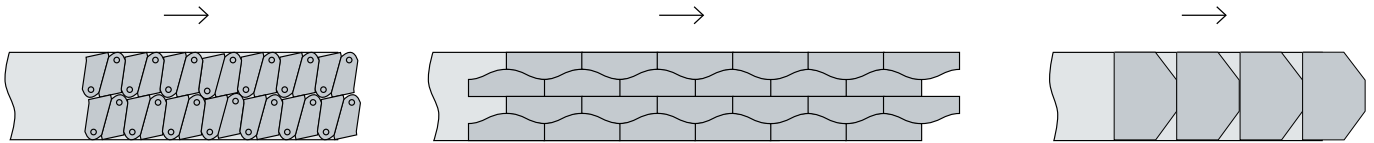
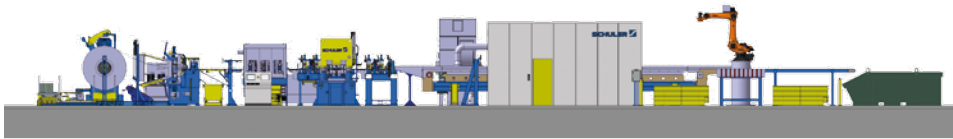
Feed length [mm]	300	500	750	1,000	1,500	2,000	2,500	3,000	3,500	4,000
Cut-to-length shears [spm]	100	80	66	57	47	41	35	30	28	28

### THE ADVANTAGES

- Ideal for the production of rectangular, trapezoidal or curved blanks
- Good value for money
- High output rates
- High level of automation
- Proven technology

# OUR BLANKING SOLUTIONS AT A GLANCE.

## BLANKING LINE WITH LASER CELL.



Blank shapes when using laser cutting heads.

### PERFORMANCE OF BLANKING LINE WITH LASER

The performance of a laser line always depends on the coil thickness, blank contours and laser efficiency. We would be happy to calculate the possible output based on your product data..

### THE ADVANTAGES

- Suitable for all blank shapes
- No costs for dies and die storage
- Fast product changes and thus high level of uptime
- Adjustment of blank contours after production launch
- Simultaneous production of varying blank shapes
- Reduced material costs
- High energy efficiency
- Reduced investment volume
- Space-spacing design

# LINE COMPONENTS. THE HIGHLIGHTS.



## COIL LOADING/DECOILER **P S L**

- Coil weights up to 35 metric t per coil
- Coil widths up to 2,150 mm
- Outside diameters up to 2,000 mm
- Various inside diameters possible
- Coil loading with stool or cart
- V-prisms or support rollers
- Single or double decoiler
- Manual or automated loading



## WASHER UNIT **P S L**

- Modular construction
- Easy access to components
- Specialized filter concepts
- 4-roller pair concepts
- Can be used with various washing fluids
- Can be raised or moved out for aluminum processing

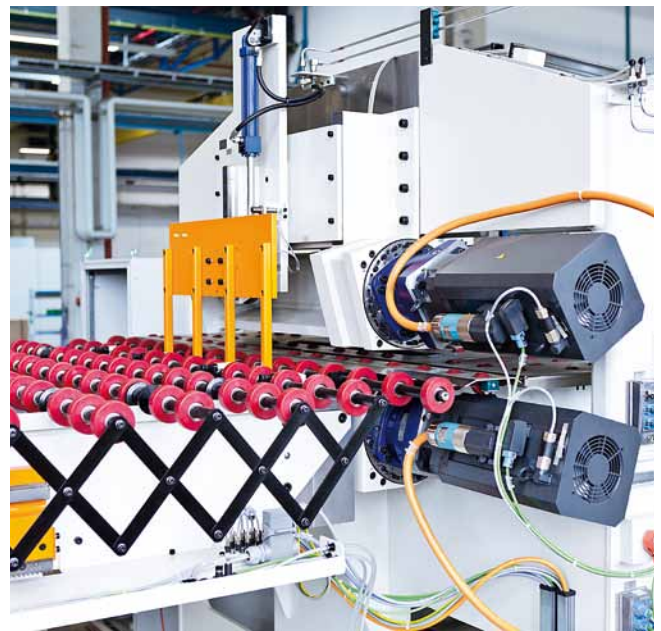
Component/option for blanking line with press **P**, with cut-to-length shear **S**, with laser **L**

# LINE COMPONENTS. THE HIGHLIGHTS.



## LEVELLER **P S L**

- Strip thickness from 0.5 to 3.0 mm
- Six-high block leveling cassette
- Up to 21 leveling rollers
- Last leveling roller independently adjustable
- Manual or automated cassette changeovers
- Draw-in rollers for steel and aluminum
- FEM-calculated construction for superior stability
- Cleaning device



## SERVO ROLL FEED **P S**

- High speed and acceleration thanks to servo direct drive
- Combination of feed for steel and feed for aluminum
- Motorized strip side guiding with off-center adjustment
- Measuring wheel
- Quick lifting
- Weld seam recognition (optical and/or inductive)

Component/option for blanking line with press **P**, with cut-to-length shear **S**, with laser **L**





#### STACKING UNIT **P S**

- Operating modes: continuous, Stop2Drop
- For steel and/or aluminum blanks
- Blank lengths up to 5,000 mm
- Maximum of two stacking stations and place for four stacks
- Advanced air technology for aluminum blanks with high energy savings
- Telescoping conveyors individually adjustable in width and length
- Freely programmable system of stops – adjustments can be stored for every die set
- Side stacking concepts



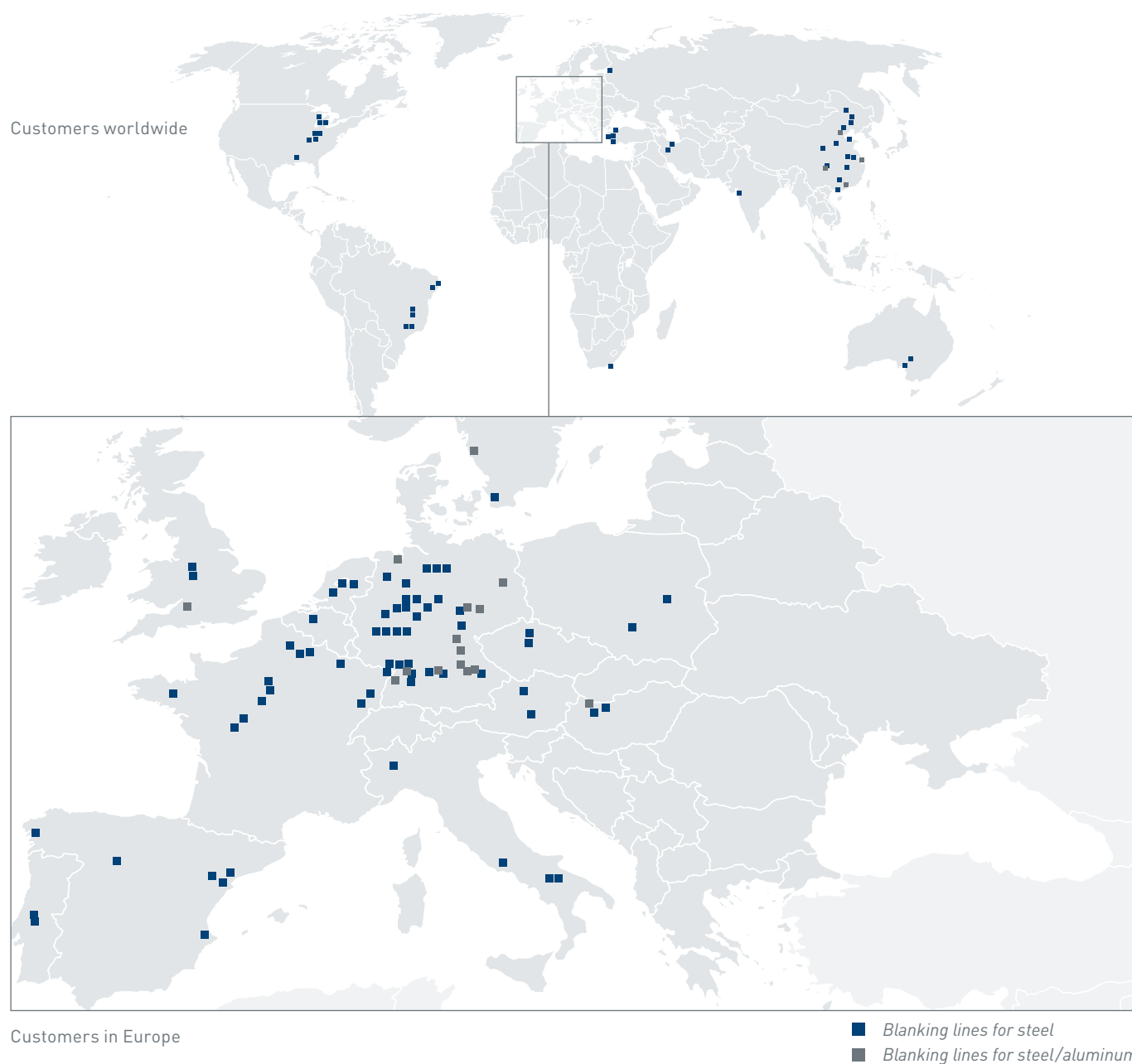
#### EDGE TRIMMING DEVICE **P S L**

- Trimming of strip edges up to 130 mm
- Automatic chopping of separated strip edges with scrap collection

## USED BY CUSTOMERS AROUND THE WORLD. BLANKING LINES FROM SCHULER.

Car manufacturers and their suppliers around the world depend on Schuler know-how. Schuler has so far delivered well over one hundred blanking lines worldwide.

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EXPERTISE

PARTNERSHIP

PRODUCTIVITY

SAFETY

FUTURE

# SCHULER SERVICE.

## OPTIMUM SERVICE FOR MORE PERFORMANCE.

Schuler Service offers a tailored portfolio of services covering the entire life cycle of your equipment.

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Over 900 service employees worldwide provide expert support 24/7 in close cooperation with you – our partners. Our main priority is always to ensure the ultimate productivity and safety of your production equipment in order to secure your company's continued success.

With over 170 years of experience and expertise, we can guarantee the best possible support for the operation of your machines – and not only those supplied by Schuler, but by all other manufacturers. Whatever the situation, Schuler Service has the right solution for your specific needs.



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### SCHULER SERVICE ONLINE



Want to know more about our full range of services?

Simply scan the QR code with the camera of your smartphone or tablet.

[www.schulergroup.com/service](http://www.schulergroup.com/service)

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#### Blanking lines

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