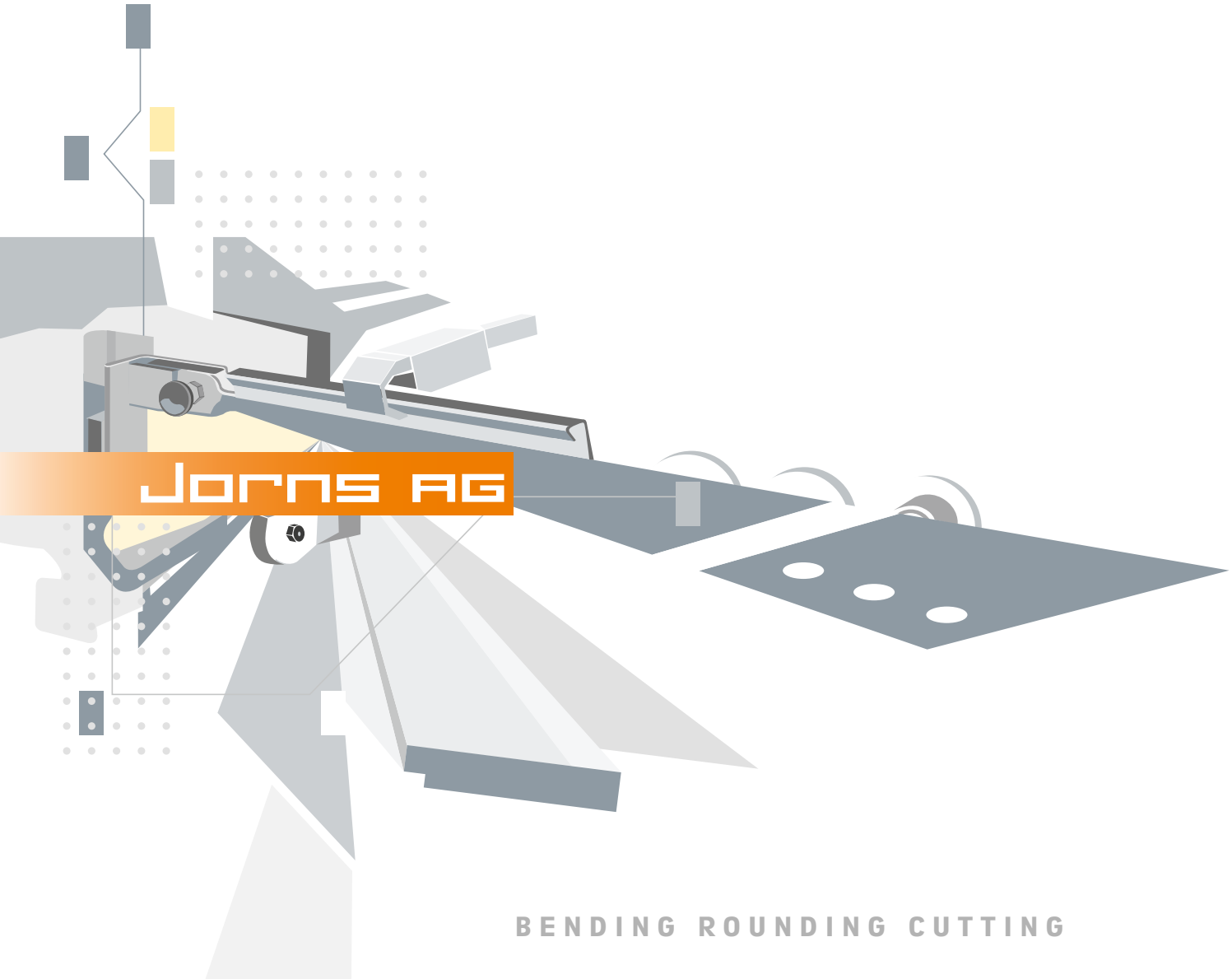
PRODUCT LINES



BENDING ROUNDING CUTTING

“We accept only those orders that we know we can carry out to the full satisfaction of our customers”

Many years’ specialisation in sheet metal processing and mechanical engineering

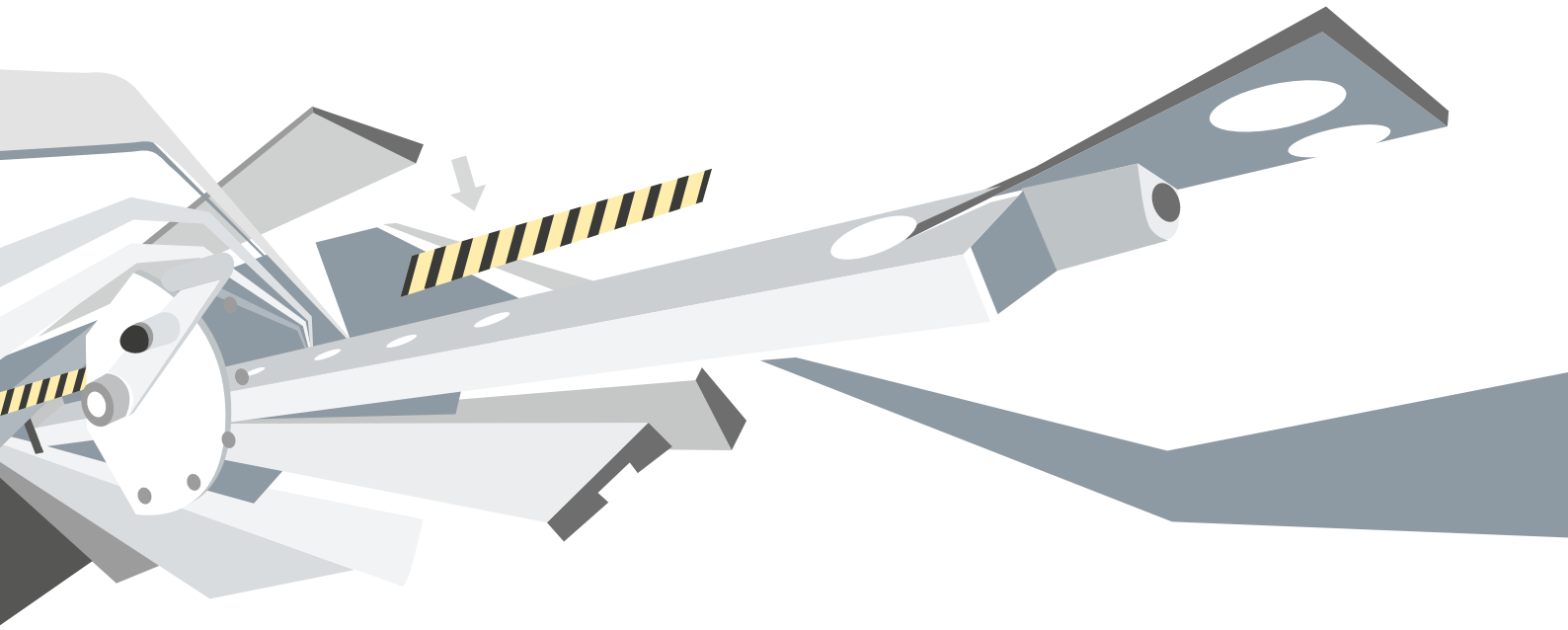
Kurt Jorns founded Jorns AG in 1973. Today Jorns AG employs some 65 people and can look back on a very successful company history. Thanks to many years’ specialisation in sheet metal processing and mechanical engineering, Jorns AG is today a global leader in the development, sale and production of bending machines.

The family-run business is in its second generation under the management of Business Administration graduate Marc Jorns.

In cooperation with our independent agencies, we sell our products around the world.

Our success is founded on our strong focus on quality and innovative power. We are oriented to the needs of our customers. We integrate customer requests into the development of our products. Tinsmiths, roofers and building constructors around the world rely on the quality and cost-effectiveness of our bending machines, gutter machines and cutting systems.

In 2001, Kurt Jorns and our development team introduced the first double bending machines. Thanks to continual development of the TwinPro which is available today, these product lines eliminate the time- and energy-consuming process of rotating and flipping the parts being processed.



Production and assembly

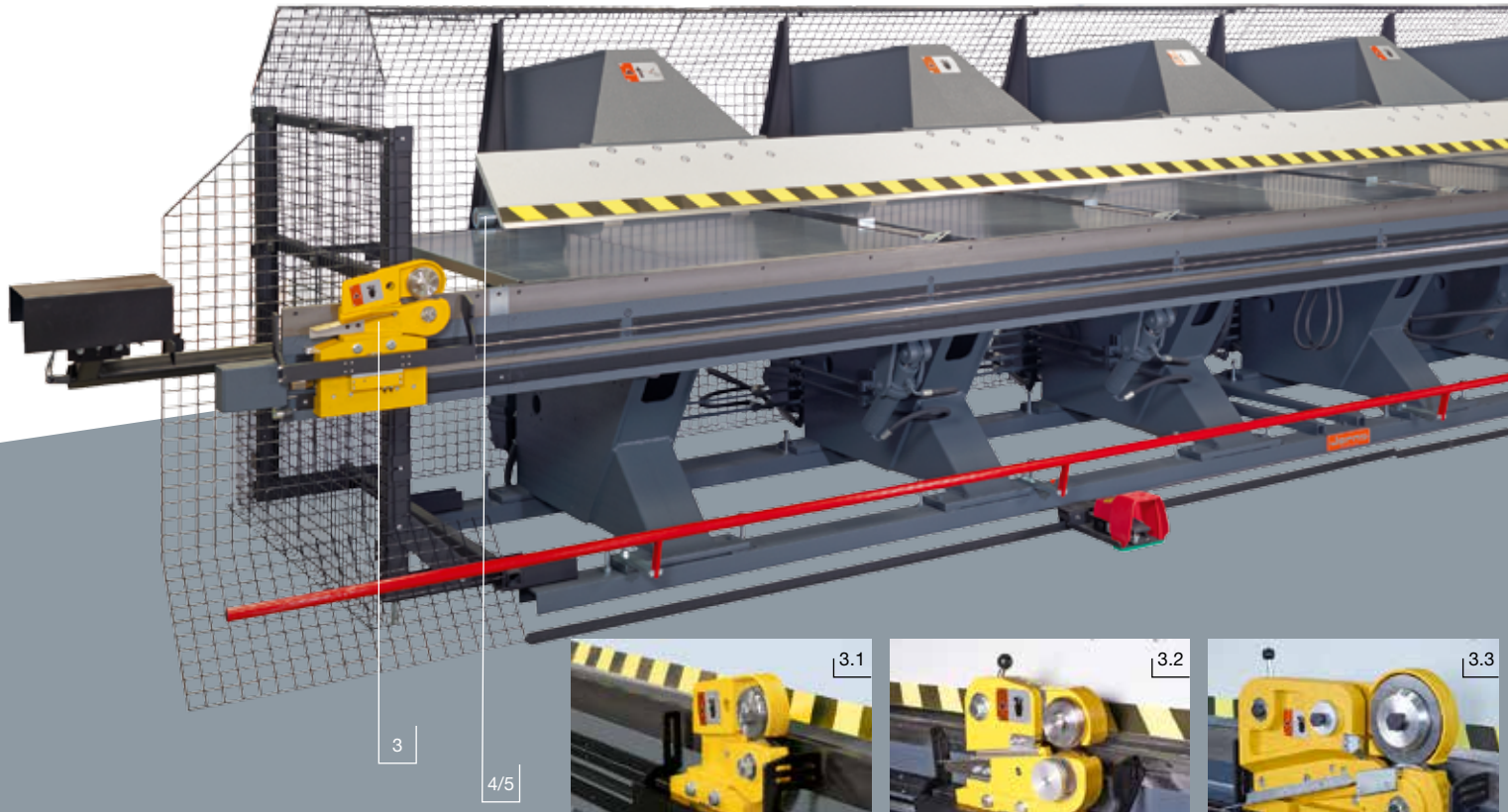
The components manufactured by Jorns AG are assembled and tested in our own assembly hall. Jorns builds and sells between 120 to 150 units of bending machines a year.

To meet our customers' exacting requirements, we use state-of-the art production methods including laser technology, welding robots and CNC machining centres. The result: bending machines with unsurpassed continuous output.

"The Jorns product line unites experience, technical know-how, production versatility and future prospects"

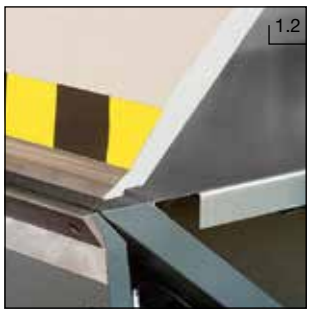
The **Norma-Line, Maxi-Line** and **Super-Line** are innovations of our existing models. Our product development is driven by the ever-increasing demands of our customers. The modular design of the bending machine enables customers to configure the machine to their individual requirements.

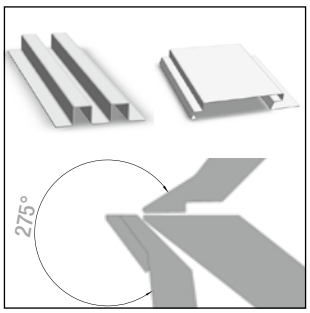
Depending on the demands, the system is equipped with the following options: graphically supported CNC controls unit, depth stop, conical depth stop, shearing system, cutting systems, hydraulic material thickness adjustment, top beam pretensioning or hem pre-tensioning. The machines are available in lengths of 4, 6, 8, 10 and 12.2 m, and the customer can choose between the "S" standard geometry or the "F" geometry, which offers more free space.
They can work steel sheets up to a thickness of 3 mm 400 N/mm^2.
Insertion depth is 1000 / 1250 mm.



3.1 SL shears / 3.2 SLE shears / 3.3 SL3 shears
All bending machines can be equipped with a SL/SLE shearing system for 1.5 mm steel sheets or a SL3 for 3 mm sheets.
With the SLE and SL3, the air gap and the overlap can be set for various steel sheet thicknesses.

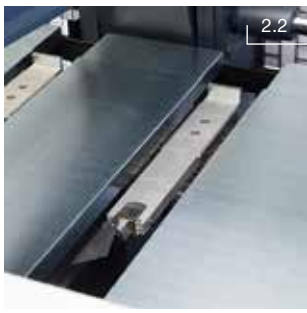
1.1 “S” geometry
Tools with a “S” (standard) bending beam geometry feature a vertically positioned bending beam. There is a maximum free space height of more than 220 mm in the machine to provide the free space to do the work.



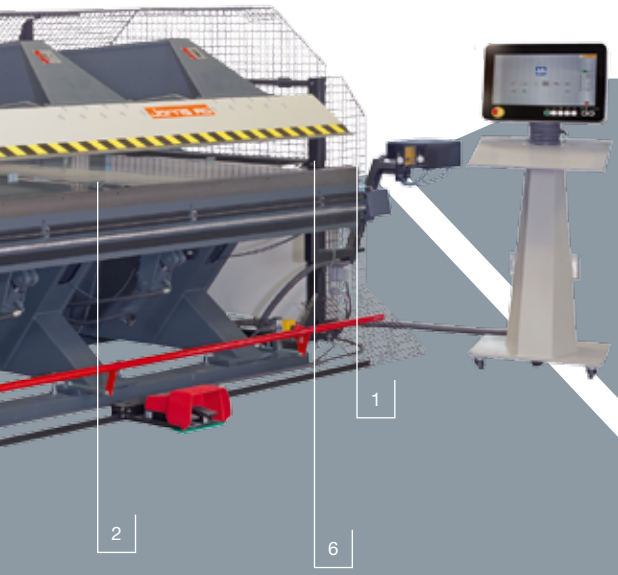


1.2 “F” geometry
Tools with a “F” bending beam geometry increase the amount of free space on the front side of the bending beam to a total of 275°.
The bending beam, which is bent by 37° and runs 6° towards the back, allows the production of dimensionally precise 90° hat profiles (working length up to 15 × 15 mm) and interlocking profiles for facades.

2.1 Stop system Type 11
The automatic stop system Type 11 has standard equipment with stop fingers. The system is fitted with a safety mechanism which lifts up if there is a danger of clamping. Measurement range is 20 to 1000/1250 mm.



2.2 Spring fingers
The standard stop fingers can be easily converted into spring fingers. Measurement range is 10 to 1000/1250 mm.



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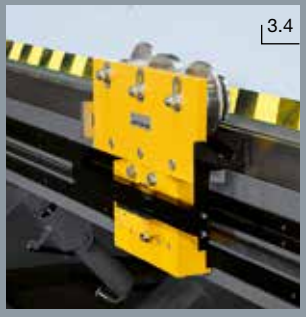
2.3 Stop system Type 11
The additional, independent stop unit with a depth-stop finger enables a maximum degree of conicity from 20 to 1000/1250 mm. Conicity is programmed with the control unit.

2.4 Stop system Type 14
The stop beam is mounted on a pivot point and is ideal for bending small metal strips. Conicity is programmed with the control unit.

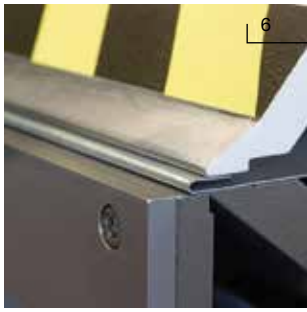


2.3 Profile rollers
The shear carriage also serves as a support for the profile rollers of the roll forming machine. Both horizontal and vertical profile rollers for the roll forming machine are available.

2.4 Shearing safety
The shearing and roll forming systems are equipped with a multibeam monitoring system and a safety mechanism.

3 RH material thickness adjustment
The material thickness adjustment compensates for different sheet thicknesses. The sheet thickness can be programmed in the control unit. The adjustment is hydraulically driven.

4 Top beam pretension
The top beam pretension makes it possible to move each arm of the bending machine manually. This eliminates any torsion over and above the profile length.

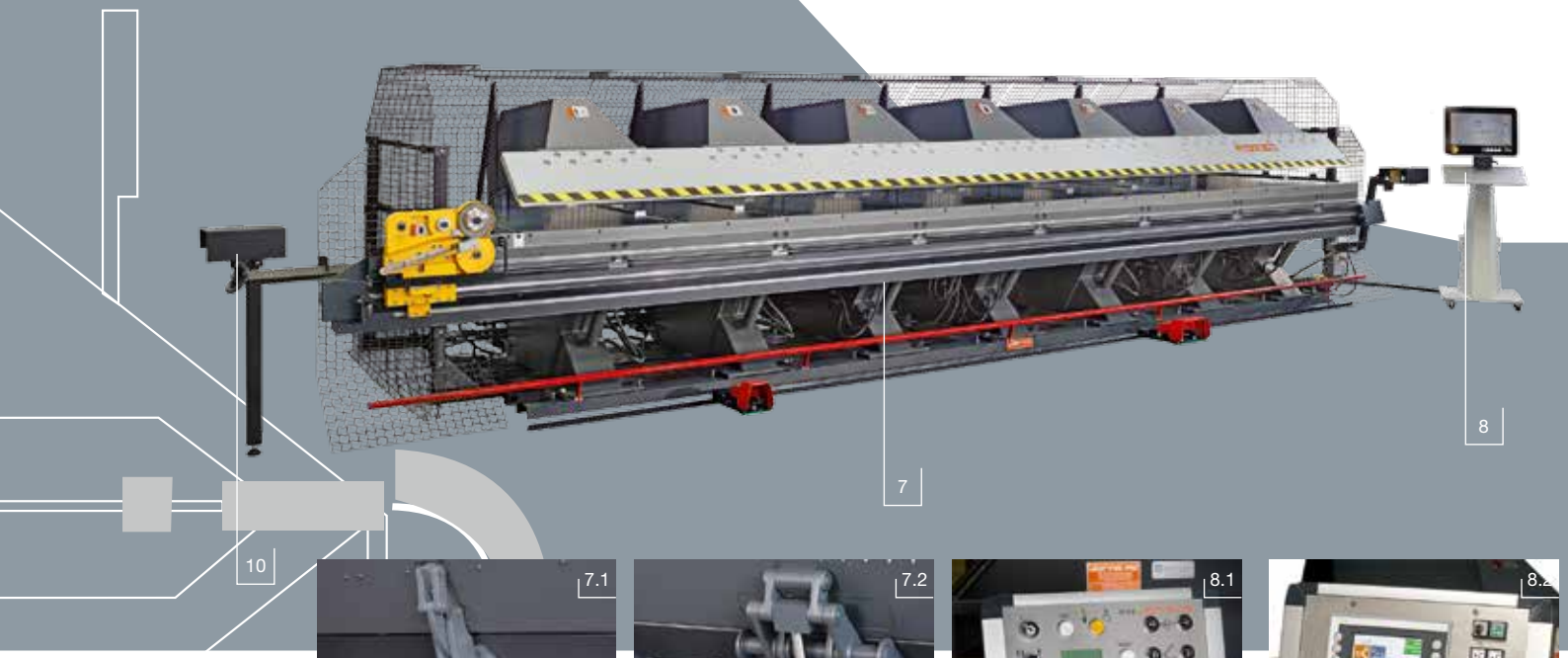


5 Hem pretension
The hem pretension allows uniform closing of a hem along the entire length of the machine. The pretension can be programmed via the controls.

"Tight tolerances guarantee that all individual parts are easily replaceable"

Our bending machines are mounted on a frame and equipped with all necessary levelling and fastening devices. They are driven by a modern hydraulic unit. Key terms such as proportionally controlled speeds, top beam with load relief, hydraulic cylinder with a ramp control and pipe-break safety devices have long been part of our standard design vocabulary.

Stands and arms are designed in sturdy, box-type welded construction. Our bending machines come with user-friendly controls mounted on a mobile console. To meet their specific requirements, customers can have their machines equipped with a simple OP3100 2-axis control unit, a CP50 pure numeric unit up through to the very latest CP100 graphical touchscreen control unit.



7.1 / 7.2 Coupling joint
The bending beam is bearing-mounted on coupling joints. The size depends on the assembly. Elegant radii and scratch-free sheet surfaces are the result of perfect lever ratios.

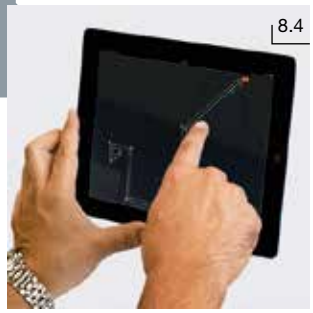
8.1 OP 3100 2-axis control unit
Simple controller with nine angle-memory slots for systems with or without a manual depth stop system.

8.2 CP50 touchscreen control unit with a 5.7" TFT colour display enables pure numeric programming, without graphics support.

Assembly	Type	Working length	Bending capacity Steel St-40 400 N/mm²	V2A 600 N/mm²	Alu m. ½-hard 220 N/mm²	Stands	Coupling	Bending cylinders	Weight (version 1250 mm insertion)
		mm	mm	mm	mm	Piece / Type	Piece	Quantity	approx. kg
Norma-Line	125L	6400	1.25	0.80	2.00	4/L	4	2	3800
	125L	8000	1.25	0.80	2.00	6/L	7	3	5200
	125	4000	1.25	0.80	2.00	3/L	5	2	3700
	125	6400	1.25	0.80	2.00	5/L	5	3	4400
	125	8000	1.25	0.80	2.00	7/L	7	4	6500
	125	10000	1.25	0.80	2.00	8/L	9	5	7500
	125	12200	1.25	0.80	2.00	10/L	11	6	8700
	150	4000	1.50	1.00	2.50	4/L	5	3	4300
	150	6400	1.50	1.00	2.50	6/L	7	4	5300
	150	8000	1.50	1.00	2.50	8/L	9	5	6200
	150	10000	1.50	1.00	2.50	10/L	11	6	8600
	150	12200	1.50	1.00	2.50	12/L	13	7	10800
Maxi-Line	200	3000	2.00	1.50	3.00	3/M	5	3	3700
	200	4000	2.00	1.50	3.00	4/M	6	4	5100
	200	6400	2.00	1.50	3.00	6/M	7	5	6200
	200	8000	2.00	1.50	3.00	8/M	9	7	9300
	200	10000	2.00	1.50	3.00	10/M	11	9	11700
	200	12200	2.00	1.50	3.00	12/M	13	11	13700
Super-Line	300	3000	3.00	2.00	4.00	4/S	4	4	5700
	300	4000	3.00	2.00	4.00	5/S	5	5	6800
	300	6400	3.00	2.00	4.00	7/S	7	7	9800
	300	8000	3.00	2.00	4.00	10/S	10	10	12500
	300	10000	3.00	2.00	4.00	12/S	12	12	15100
	300	12200	3.00	2.00	4.00	15/S	15	15	18000

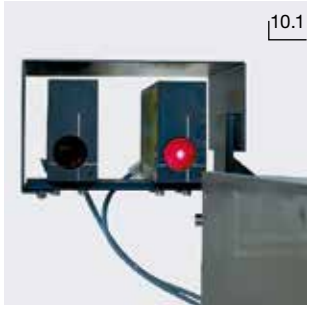
Versions and functions subject to alterations and additions!
Insertion depth 1000/1250 mm.

8.3 CP100 multi-touchscreen control unit
with a 20.5" TFT colour display, graphics software, automatic bending-sequence calculations, net-work enabled for remote diagnostics with the Diagnostics Manager from B&R. Additional information is on page 11.



8.4 Mobile programming
Mobile programming enables you to define requirements such as profile shape, material quality, colour, amount, etc. on the job site. The data is sent directly to the machine or to a defined server at the push of a button.
Now also available as an app for iOS or Android.

9 Hydraulic system
The hydraulic system is equipped with a position-monitored safety valve. Optionally, the machine can be equipped with the 20 % faster Super-High-Speed hydraulic system.



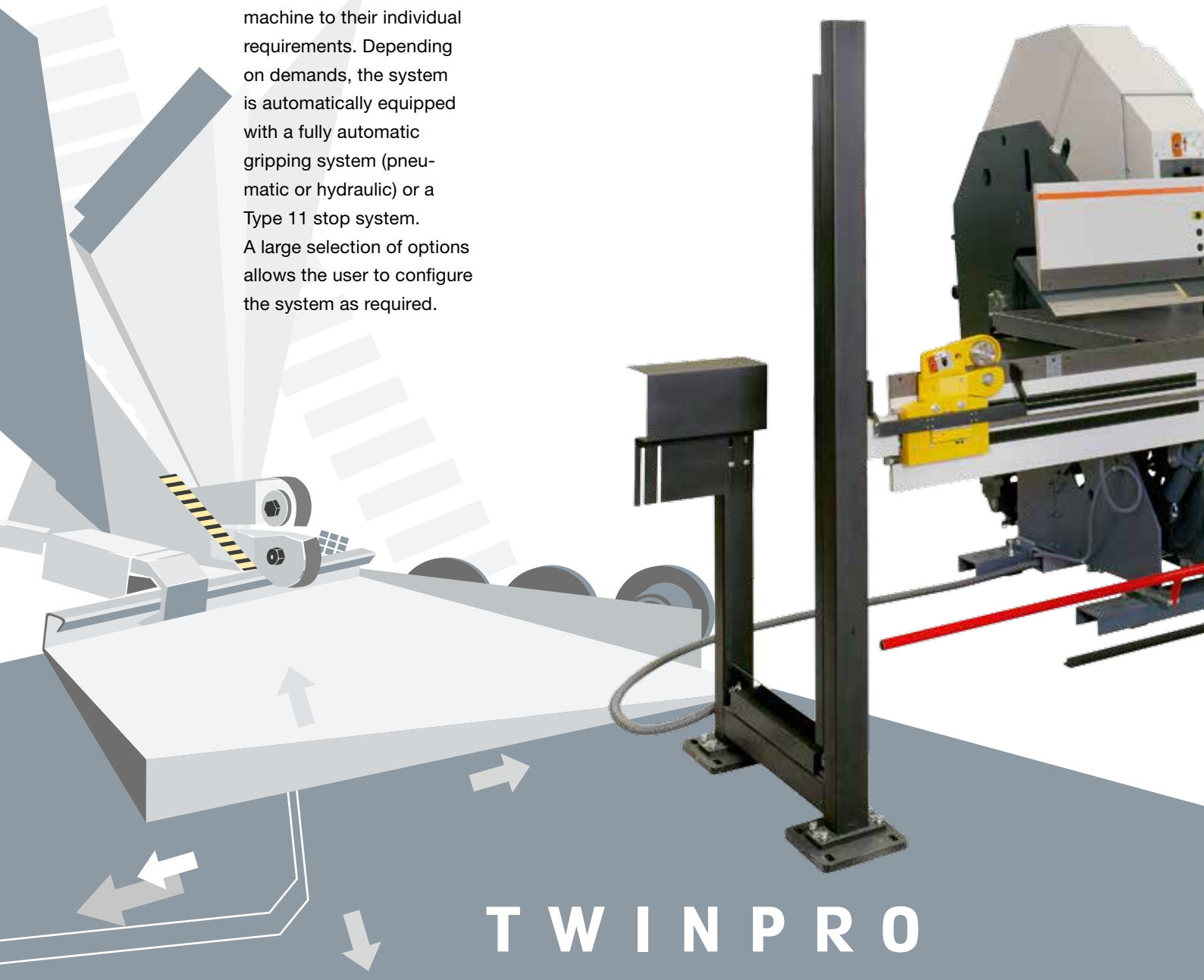
10.1 Machine safety
All machines are equipped with a multi-beam laser system which detects potential danger when closing, even before the hazard zone is reached. Machines are also equipped with a continuous emergency-off rail.

10.2 Dual-pedal foot control
with dual function allows very fast and convenient operation over the length of the machine. The confirmation pedal for the second operator is a safety standard at Jorns.

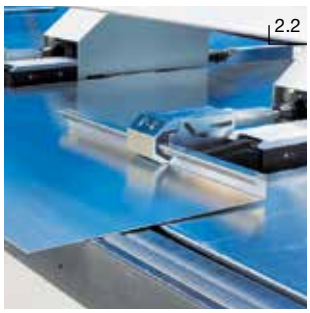
1 Pneumatic clamping finger
Each unit includes a pneumatic combination clamping finger. Flat sheets can be automatically stopped up to a minimum stop position of 15 mm (fully automatic) or 11 mm (semi-automatic). Folded sheets with a shank height of up to 25 mm can be gripped. In addition to the short stop dimensions, the system boasts a maximum stop length of 1200/1350 mm at a speed of 250 mm/s.
Special clamping fingers or other stop system available on request.

"The TwinPro guarantees cost-effective, flexible and safe operation"

Double bending is the cost-effective trend in sheet metal processing. The TwinPro operates using an innovative, pioneering bending technology capable of coping with the most exacting requirements. The modular design of the TwinPro concept enables customers to configure the machine to their individual requirements. Depending on demands, the system is automatically equipped with a fully automatic gripping system (pneumatic or hydraulic) or a Type 11 stop system. A large selection of options allows the user to configure the system as required.



TWINPRO

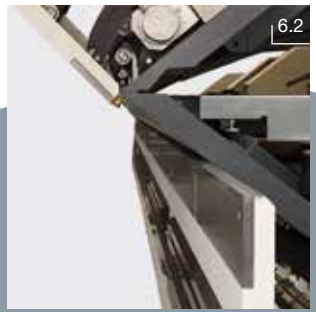


2 Hydraulic clamping finger
Every unit contains a hydraulic clamping finger and overgripping clamping finger. Flat sheets can be automatically stopped up to a minimum stop position of 25 mm (fully automatic) or 17 mm (semi-automatic). Folded sheets with a shank height of up to 40 mm can be gripped. The system boasts a maximum stop dimension of 1150/1300 mm and travels at 250 mm/s.

3 Stop system Type 11
Using the stop system Type 11, the double bending machine can be used as a semi-automatic system. The stop fingers can be moved along the entire working length. Travel path 25 to 1150/1300 mm (with spring finger, 10 to 1150/1300 mm).

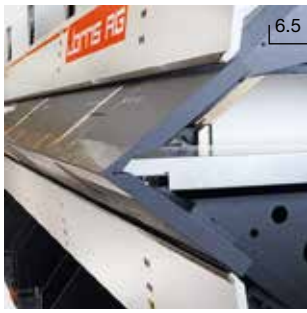
4 Short-piece clamping finger
Makes it possible to right-angle clamp short sheets that are 70 mm (hydraulic) or 132 mm (pneumatic) in length.

5 Conical stop
Independent of the selected stop and clamping system, the system can be equipped with an additional stop to create conical profiles either semi- or fully automatically.



6.1 “S” geometry
Tools with a “S” (standard) bending beam geometry feature a vertically positioned bending beam.

6.3 “G” geometry
Tools with a “G” bending beam geometry increase the amount of free space on the front side of the bending beam to a total of 269°. The bending beam, which is bent by 37°, allows the production of dimensionally precise 90° hat profiles and interlocking profiles for facades.



6.5 Free space
While one bending beam is working, the other beam can be moved out of the bending area by up to 295 mm. There is a maximum free space height of more than 220 mm in the machine to provide the free space to do the work.

COST-EFFECTIVENESS IN DOUBLE BENDING

"The CP100Twin control system is simple to program and adds considerably to the overall appeal of the machines"

With positive-negative bending using two bending beams, the TwinPro is more adaptable and many times faster than conventional bending machines. There is no longer any need for auxiliary personnel. Unit costs are crucial, especially in industrial bending. High employment costs often seriously impact lucrative orders. Long, heavy workpieces, in particular, with many reverse-bending operations also entail considerable added expense.

It is specifically in this area of operation that the **fully automatic TwinMatic-Pro** and the **semi-automatic TwinBend-Pro** come into their own. Both machines are available in lengths of 4, 6.4, 8, 10 and 12.2 m. They can work steel sheets up to a thickness of 3 mm (400 N/mm²). The insertion depth is 1200/1350 mm.

CP100Twin control unit

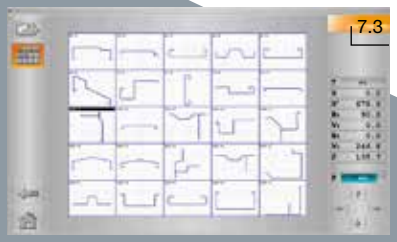
- With 21.5" multi-touchscreen
- Full HD (16:9) and 3.0-GHz processor
- 9 CNC-controlled axes (top beam, top and bottom bending beam, top and bottom bending beam displacement, material-reinforcement adjustment, stop, conical stop, shears)
- External programming software
- Remote maintenance with the Diagnostics Manager from B&R.
- USB flash memory
- 1 GB main memory and 32 GB solid-state drive
- State-of-the-art Ethernet technology
- B&R hardware components

7.1 Preparing drawings
Our drawing software lets you create profiles very easily: the workpiece is designed step by step on the screen or on an external PC. The software automatically prompts you forkey data-e.g. flange length, bending angle, radius, stop, sheet thickness, and sheet quality.

								TwinMatic-Pro	TwinBend-Pro
Type TwinPro	Working length	Bending capacity Steel St-40 400 N/mm²	Inox V2A 600 N/mm²	Alu m. ½-hard 220 N/mm²	Stands/ arm	Bending cylinders	Weight	Clamping fingers (recommended)	Stop finger incl. spring finger (recommended)
	mm	mm	mm	mm	Quantity	Quantity	kg	Quantity	Quantity
125	3200	1.25	0.80	1.50*	2	4	3700	2	4
125	6400	1.25	0.80	1.50*	4	8	6900	4	4
125	8000	1.25	0.80	1.50*	5	10	9250	5	4
125	10000	1.25	0.80	1.50*	6	12	11100	6	6
125	12200	1.25	0.80	1.50*	8	16	14800	8	6
150	4000	1.50	1.00	2.00*	3	6	5900	3	4
150	6400	1.50	1.00	2.00*	5	10	8400	4	4
150	8000	1.50	1.00	2.00*	7	14	10950	5	4
150	10000	1.50	1.00	2.00*	8	16	13500	8	6
150	12200	1.50	1.00	2.00*	10	20	18500	9	6
200	4000	2.00	1.50	3.00	4	8	8300	3	4
200	6400	2.00	1.50	3.00	6	12	10300	5	4
200	8000	2.00	1.50	3.00	8	16	12200	6	4
200	10000	2.00	1.50	3.00	9	18	15300	8	6
200	12200	2.00	1.50	3.00	12	24	18300	11	6
300	4310	3.00	2.00	4.00	4	8	13000	3	4
300	6410	3.00	2.00	4.00	6	12	18000	5	4
300	8510	3.00	2.00	4.00	8	16	24500	7	4
300	10610	3.00	2.00	4.00	10	20	30000	9	6
300	12710	3.00	2.00	4.00	12	24	36000	11	6

*Bending performance in aluminium can be increased by +0.5 mm through the use of the material thickness adjustment (optional).
Versions and functions subject to alterations and additions!

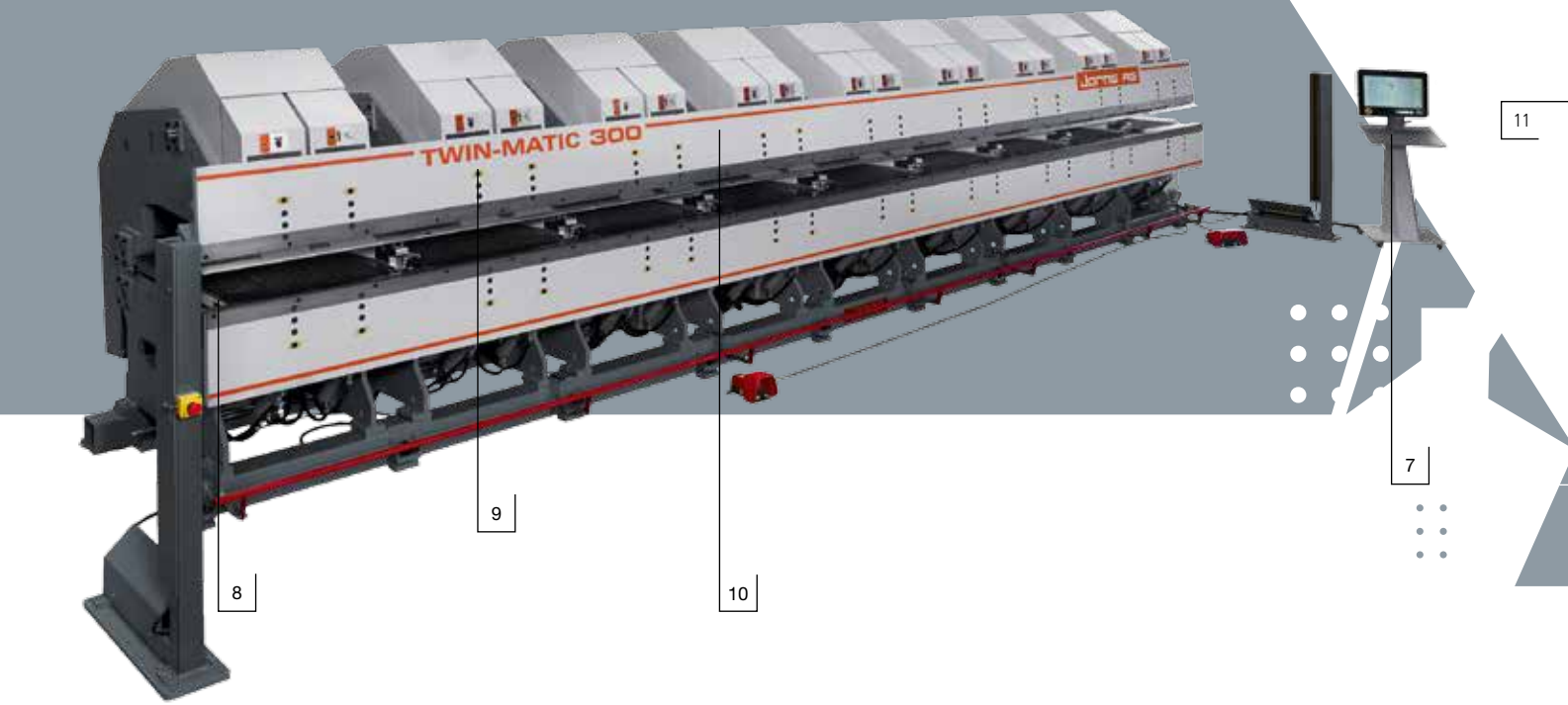
7.2 Automatic mode / process simulation
After the profile has been created, the defined bending sequence is automatically simulated using the bending-sequence calculations. Possible collisions are displayed.



7.3 Folder storage
The CP100Twin touch control system is Windows-based, which means you can store profiles in a customised folder structure. The program also allows you to search for and open profiles using predefined criteria.

7.4 Sketching mode
The sketching mode makes it even easier to create profiles by working directly on the touchscreen control system.

7.5 Mobile programming
Mobile programming enables you to define requirements such as profile shape, material quality, colour, amount, etc. on site. The data are sent directly to the machine or to a defined server at the push of a button.
Now also available as an app for iOS or Android.



8 Hem pretension
The hem pretension allows uniform closing of a hem along the entire length of the machine. The pretension can be programmed via the controls.

9 Bending beam pretension
Bending beam pretension makes it possible to individually adjust each bending beam section in the bending machine as needed. In this way, twisting can be eliminated over the total length of the profile.

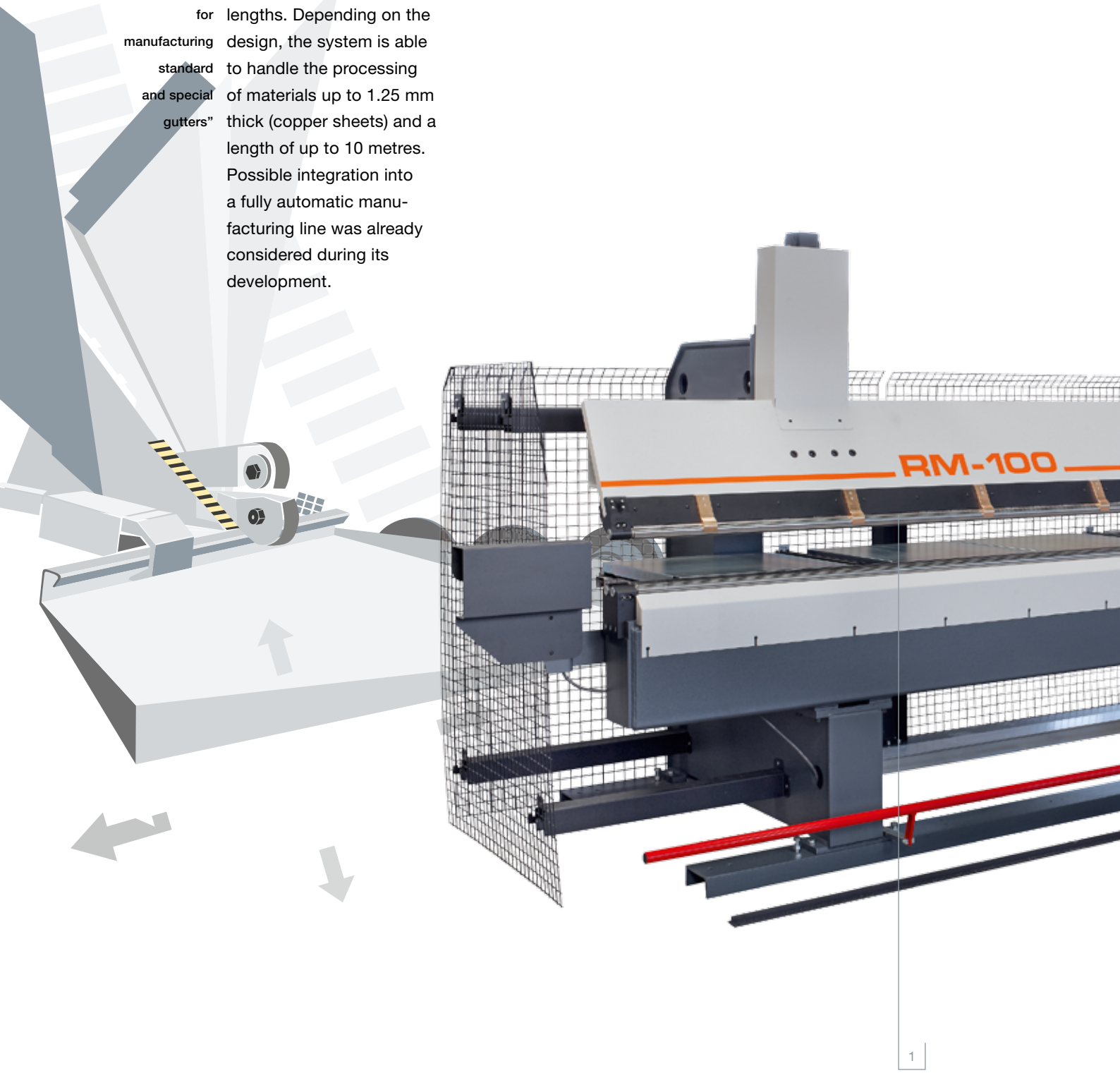
10 Material thickness adjustment RH
The material thickness adjustment compensates for different sheet thicknesses. Sheet thickness can be programmed with the controls. The adjustment is hydraulically driven. With aluminium, bending performance increases by +0.5 mm. Standard from Twin-Pro-200/300.

11 SL, SLE and SL3 shears
All systems can be equipped with a SL/SLE shearing system for 1.5 mm steel sheets or a SL3 for 3 mm sheets. The shear carriage also serves as a support for the profile rollers of the roll forming machine. The systems are equipped with a multi-beam monitoring system and a safety mechanism.

12 Multiproportional hydraulic system
The multiproportional hydraulic system is equipped with multiple proportional hydraulic valves and makes it possible to move multiple hydraulically driven axes simultaneously. In this way, cycle time is reduced by approximately 15 % over the entire profile.

"The cost-effective solution for manufacturing standard and special gutters"

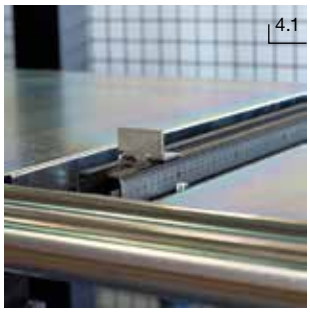
The gutter machine from Jorns AG is the optimal solution for manufacturing gutters and curves in a variety of shapes and lengths. Depending on the design, the system is able to handle the processing of materials up to 1.25 mm thick (copper sheets) and a length of up to 10 metres. Possible integration into a fully automatic manufacturing line was already considered during its development.



1 Three rollers
Three synchronously driven rollers with a diameter of 40 mm can produce narrow curves following each other closely.

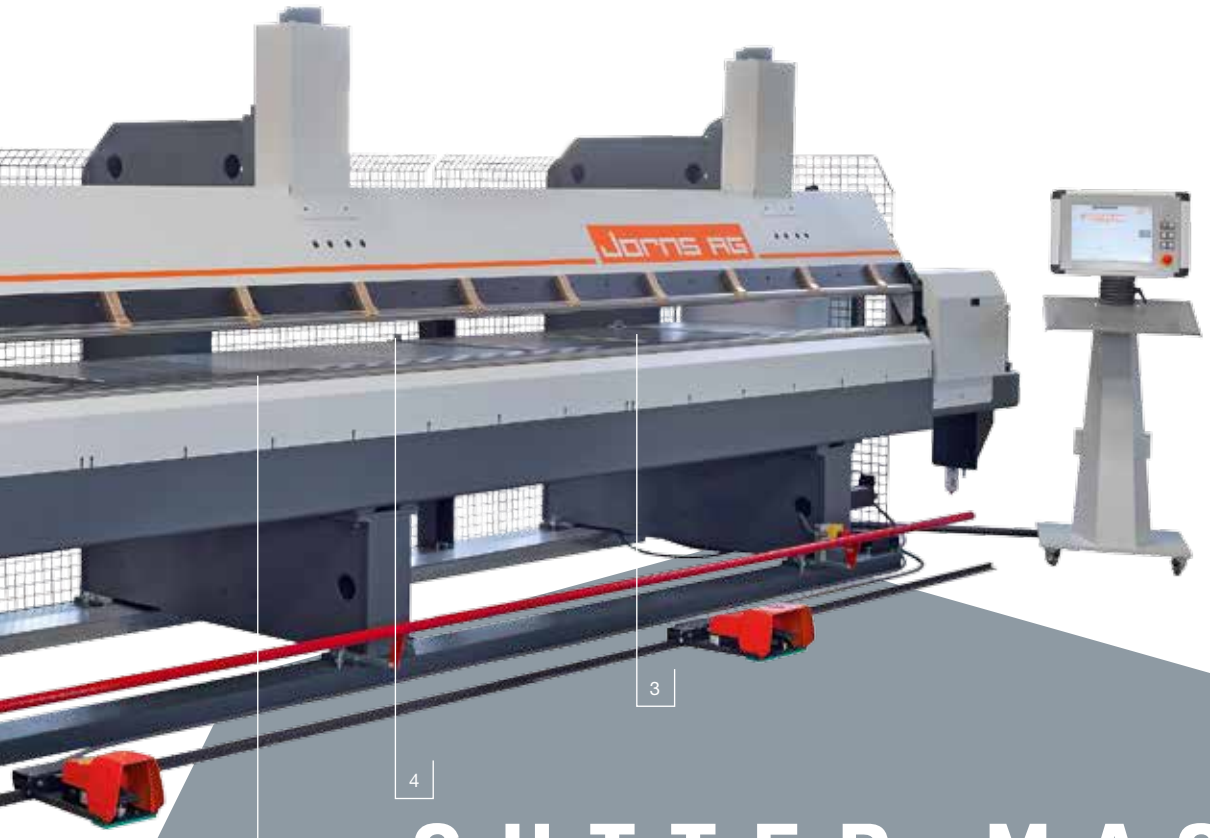
2 Pretension
Roller pretension for each mounting point allows the precise setting of two underlying rollers against the upper roller. The adjustment allows a uniform rounding over the entire length of the working surface.

3 Supporting table
All machines are equipped with removable sheet cassettes.

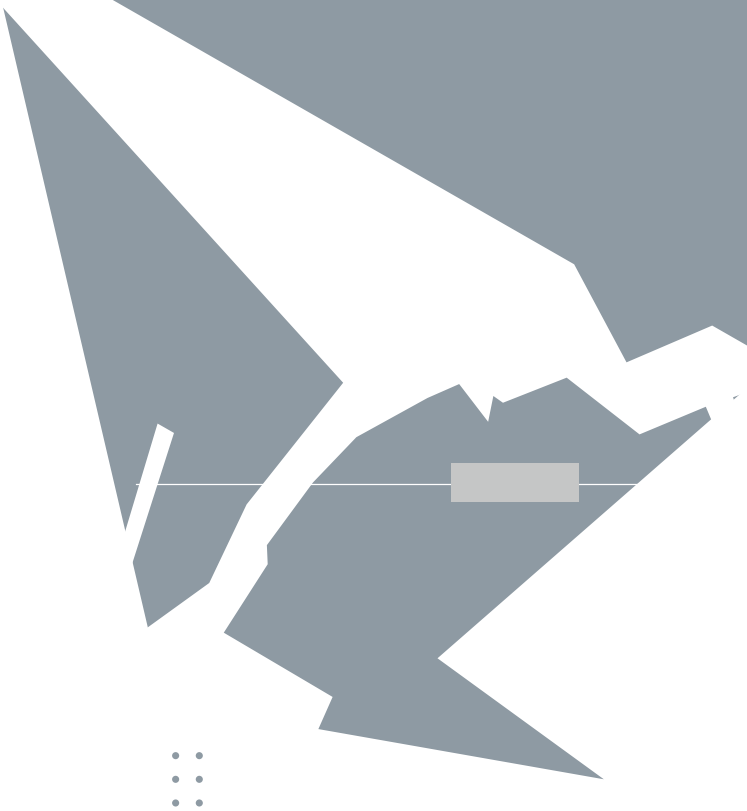


4.1 Stop system Type RM
A simple stop system allows the precise positioning of the raw materials.

4.2 Stop system Type 11
The stop system Type 11 has standard equipment with stop fingers. The system is fitted with a safety mechanism which lifts up if there is a danger of clamping.



GUTTER MACHINE

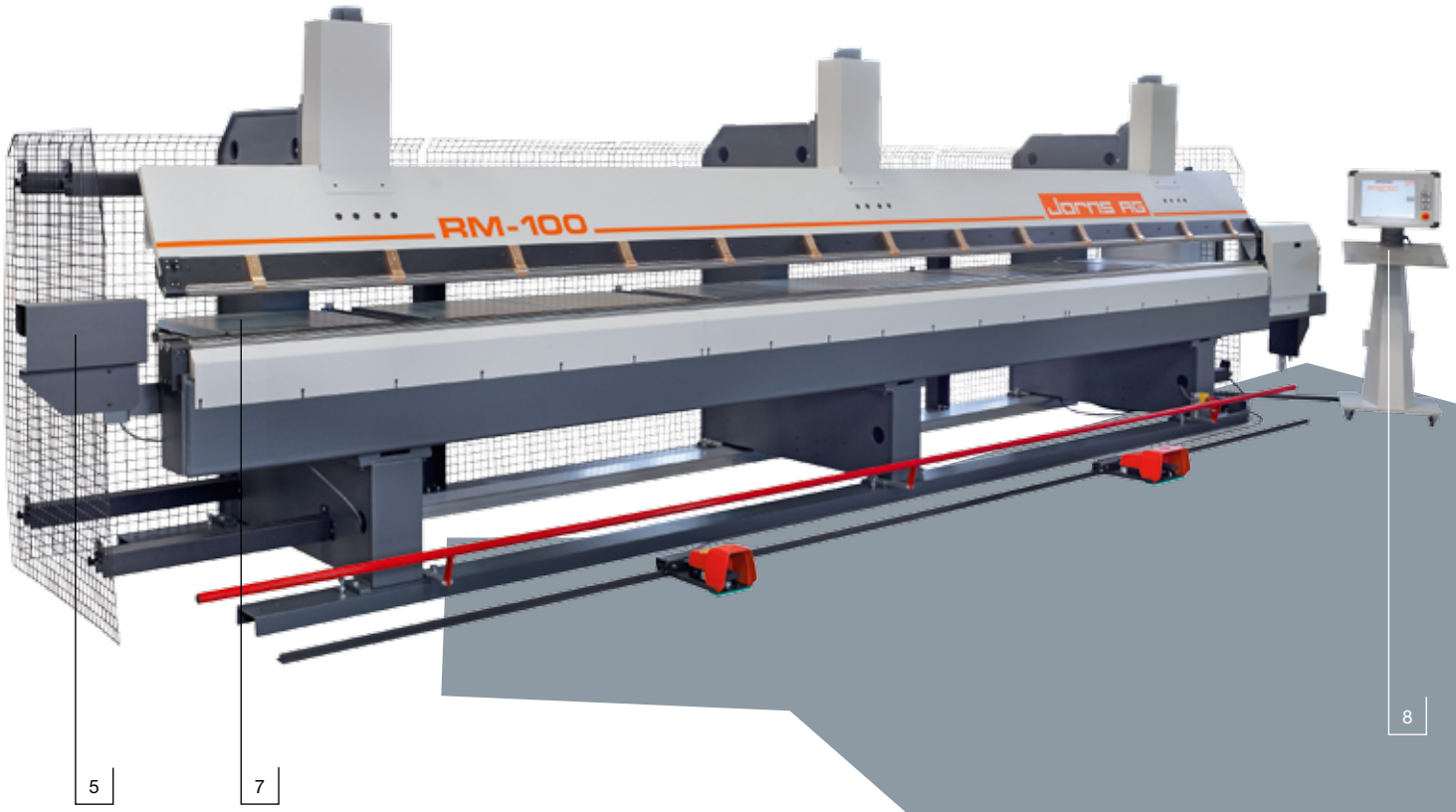


"Meeting the highest demands on rounding thanks to servo drives"

The Jorns RM gutter machine stands out for its precision and high repeat accuracy. The high-precision drive of the top beam adjustment and the rollers is effected with servo motors. Stands and arms are designed in sturdy, box-type welded construction and form the basis for the desired quality. Our gutter machines come with user-friendly CNC800RM controls mounted on a mobile console.

Gutter machine type	Working length	Rounding capacity			Stands	Insertion depth	RM stop fingers
		Copper	Alu m. ½-hard	St-40			
		220 N/mm²	220 N/mm²	400 N/mm²			
	mm	mm	mm	mm	Quantity	mm	Quantity
100	4000	1,00	1,00	0.80	2	750	3
100	6400	1,00	1,00	0.80	3	750	4
100	8000	1,00	1,00	0.80	4	750	4
100	10000	1,00	1,00	0.80	5	750	6
125	4000	1,25	1,25	1,00	3	750	3
125	6400	1,25	1,25	1,00	4	750	4
125	8000	1,25	1,25	1,00	5	750	4
125	10000	1,25	1,25	1,00	6	750	6

Versions and functions subject to alterations and additions!



5 Roller safety
The roller system is equipped with a multi-beam laser system which detects potential danger when closing, even before the hazard zone is reached.

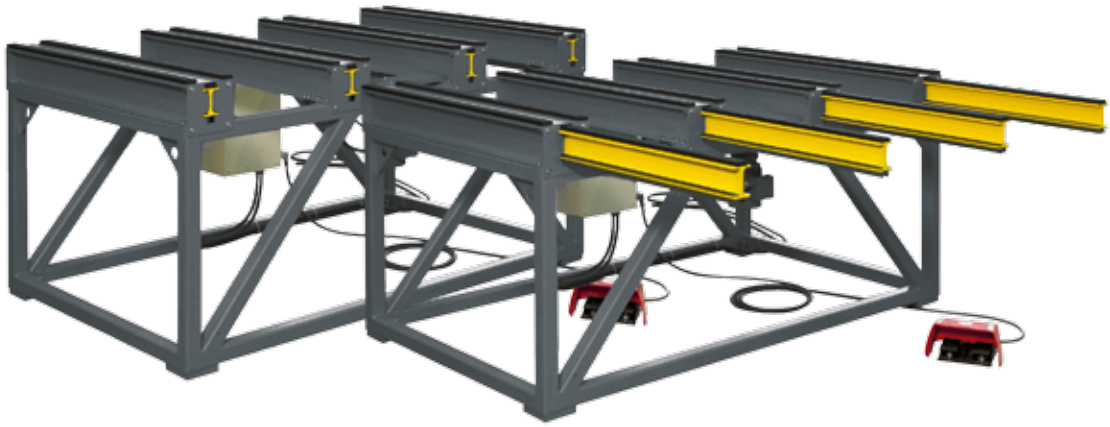
6 2-pedal foot controls
With dual functions, allows very fast and simple operation over the full length of the machine.
The confirmation pedal for the second operator is a safety standard at Jorns.

7 Height-adjustable table
Upon request, the system is equipped with a pneumatic height-adjustable table whereby sheets which have already been shaped below can be laid down and rounded.

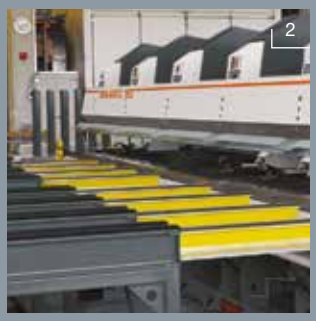
8 CNC800RM Touchscreen control
15" colour TFT display, network-enabled for remote diagnosis, automatic rear stop and graphics software.

"The organisation around the machine is key to ensuring cost-effective work"

Only when the working environment is well organised can the capacity of modern machines be fully utilised and the operator's work made easier. Simplified handling means faster but also safer work on the bending machines.



1 Handling table
The handling table is fitted with plastic rails that prevent scratching the sheet. The table can be loaded with 2 tons of sheet metal, the pullout arms with 50 kg each.



2+3 Handling table
Four arms per table can be operated with machine foot pedal control to feed the sheet metal to the machine. 2000 × 1200 × 1045 mm, draw-out 800 mm. For longer machines, multiple 2-metre tables can be placed next to each other and individually actuated.

ZST cutting table
Sturdy underframe, phenol chip-board, stop and lateral tape measure. The table is mobile and has wheel brakes. Available in lengths of 4, 6, and 8 m and table widths of 1000 and 1250 mm.

HTS manual table shears
Swivel bearings for rotating the shears away from the table surface. Available in widths of 1000 mm and 1250 mm. Cutting capacity:
1.0 mm St-40, 0.6 mm Inox steel,
1.5 mm aluminium.

HTS
ZST


1

1 Operation
The shearing carriage is easily pulled over the table with the extension lever.
A hold-down device prevents the sheet from slipping.


2

2 Models
The 1000 mm and 1250 mm HTS versions can be set up left or right.


3

3 Quality
High-quality materials and precision-produced parts ensure a long service life of the Jorns HTS.

Jorns slitting machines are characterised by short adjustment and retooling times.
The machine can be used for continuously changing production units as well as for series production.
The **Mini Service Centre (MSC)** is the ideal, most cost-effective and professional solution on the market.
The steadily growing number of satisfied customers confirms our concept and represents the reward for our development work.

"Our global customer service with skilled servicing engineers guarantees professional installation, training and maintenance of the equipment"

1 Uncoiler
Frequency-controlled uncoiler for the Mini Service Centre assembly. Designed for strips of 1250 mm and 1500 mm and a load-carrying capacity of 5000 kg.
Ideal for steel sheet thicknesses of up to 1.5 mm (400 N/mm²).
The sheet coil is tensioned by hand using a crank. Two lateral plates permit perfect unwinding of the coil. The standard speed of 35 m/min is regulated by a dancer shaft.

Accessories:
A hydraulic loading block – universally useful for all sizes of coil and a maximum load-carrying capacity of 5000 kg – complements our offer. The block and the height adjustment are operated hydraulically. Thanks to the special design, the overall machine height is low.

2 Slitting machine
The slitting machine of the Mini Service Centre assembly is available in strip widths of 1250 mm and 1500 mm for sheet thicknesses of 1.25 mm and 1.5 mm steel sheet (400 N/mm²).
The slitting machine can be configured either without straightening unit or with 5 or 7 straightening rollers. The machine runs in the middle at a speed of 35 m/min, ensuring that the cutting force is ideally distributed. The slitting blades can be mechanically clamped and are quickly adjusted by hand to the required strip width (minimum slitting width is 70 mm).

Accessories:
Foil holder, additional slitting blades.

3

3

4

3 Recoiler
The recoiler of the Mini Service Centre assembly is available in strip widths of 1250 mm and 1500 mm and for maximum carrying-load capacity of 5000 kg.
The strips are braked using a pneumatic felt brake. A recoiler tightly tensions the strips. The separating discs guarantee that the strips are aligned true when wound. The minimum strip width that can be wound is 75 mm.
The winding speed of 35 m/min is generated by an electric drive and controlled via a dancer shaft. The maximum steel sheet thickness which can be wound with the Jorns recoiler is 1.0 mm for aluminium, 1.0 mm for steel sheets and 0.6 mm for stainless steel.
The best recoiling results are achieved with 3 to 4 strips.

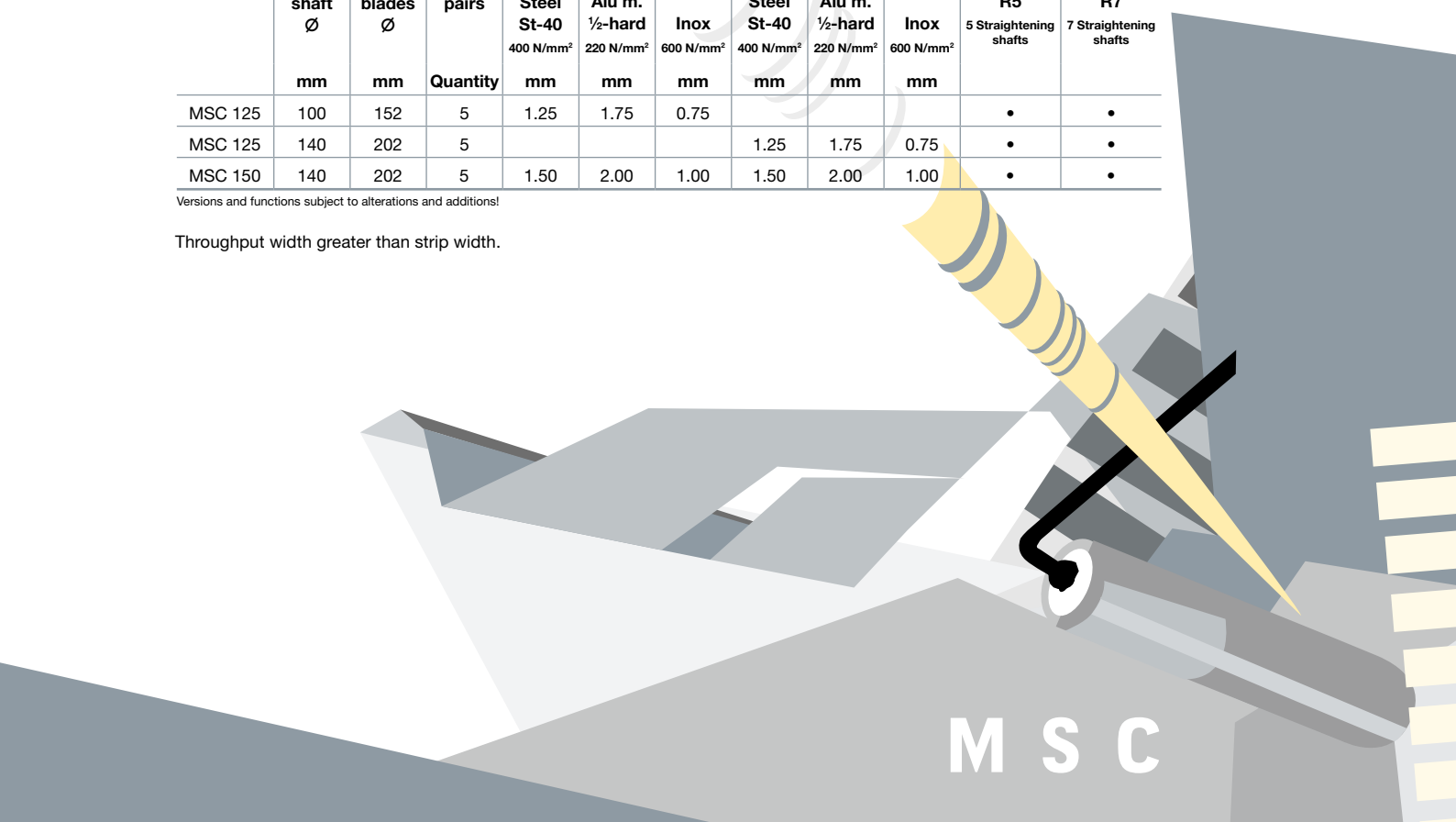
Accessories:
A hydraulic loading block – universally useful for all sizes of coil and a maximum load-carrying capacity of 5000 kg – complements our offer. The block and the height adjustment are operated hydraulically. Thanks to the special design, the overall machine height is low.

4 Scrap coiler
Stepped arrangement with central electric motor.
The finger moves constantly back and forth to distribute the rest of the strip evenly over the mandrel. The maximum strip width is 25 mm.

				Max. processable sheet thickness							
				Strip width 1250			Strip width 1500			Straightening unit	
Size	Slitting shaft Ø	Slitting blades Ø	Blade pairs	Steel St-40 400 N/mm²	Alu m. ½-hard 220 N/mm²	Inox 600 N/mm²	Steel St-40 400 N/mm²	Alu m. ½-hard 220 N/mm²	Inox 600 N/mm²	R5 5 Straightening shafts	R7 7 Straightening shafts
	mm	mm	Quantity	mm	mm	mm	mm	mm	mm		
MSC 125	100	152	5	1.25	1.75	0.75				•	•
MSC 125	140	202	5				1.25	1.75	0.75	•	•
MSC 150	140	202	5	1.50	2.00	1.00	1.50	2.00	1.00	•	•

Versions and functions subject to alterations and additions!

Throughput width greater than strip width.



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