



# GRM SERIES

Mechanical stamping  
and forming machines  
GRM 80E / GRM 80P

**BIHLER**



### Highly productive mass production

Now you can manufacture your stamped and formed parts and assemblies even more efficiently and economically. Benefit from the high performance and high dynamics of the universally applicable GRM stamping and forming machines.

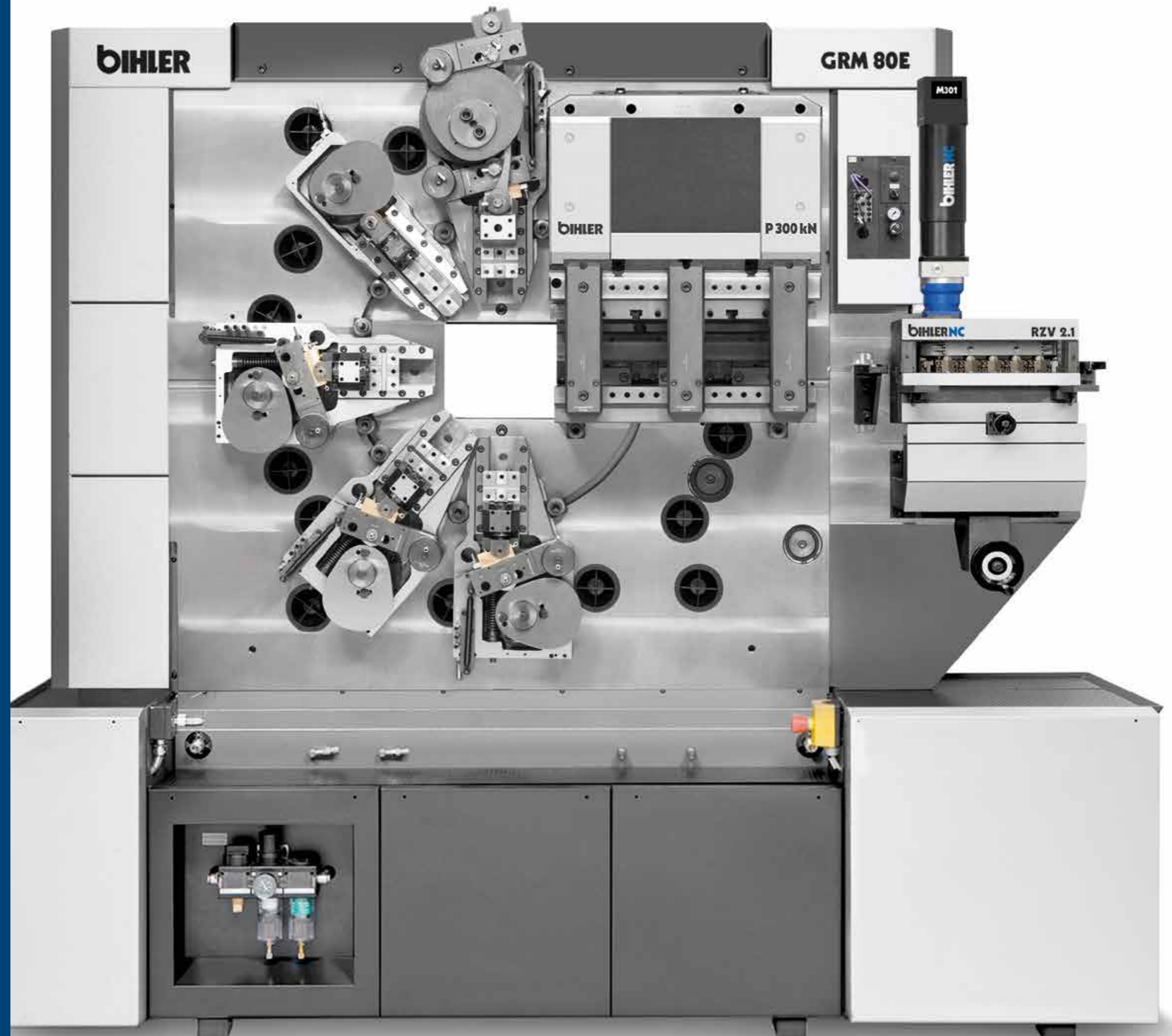
Designed for radial and linear tooling concepts, the two mechanical machines offer you consistently high precision and quality. Free access to all processing stations and quick-change systems guarantee the shortest possible changeover and tool change times. With its separate press module, the GRM 80P offers you a particularly large amount of machining space for additional processes such as welding, thread forming, screw joining and assembly. Equipped with state-of-the-art control technology, you operate the GRM machines easily and safely.

# GRM 80E

Stamping and forming machine

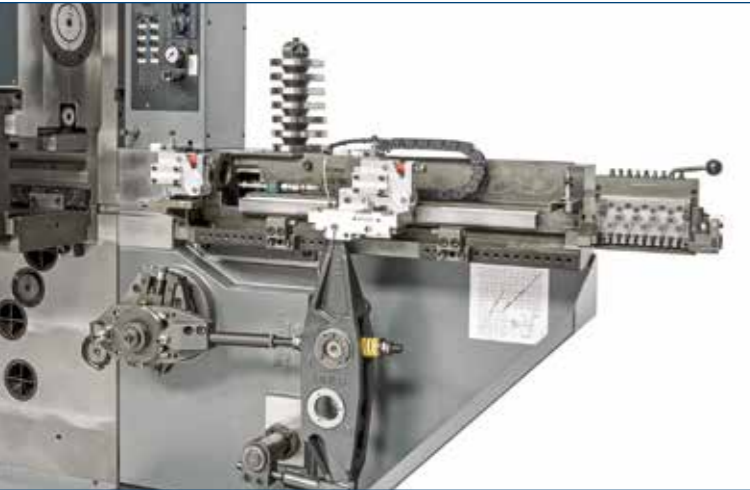
## Highlights at a glance

- Universal machine system for economical production of stamped and formed parts
- High production speeds of up to 250 1/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



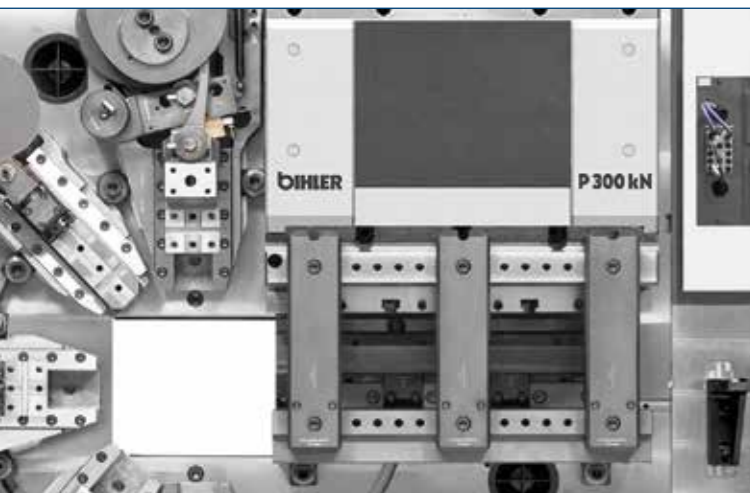
# GRM 80E

Stamping and forming machine



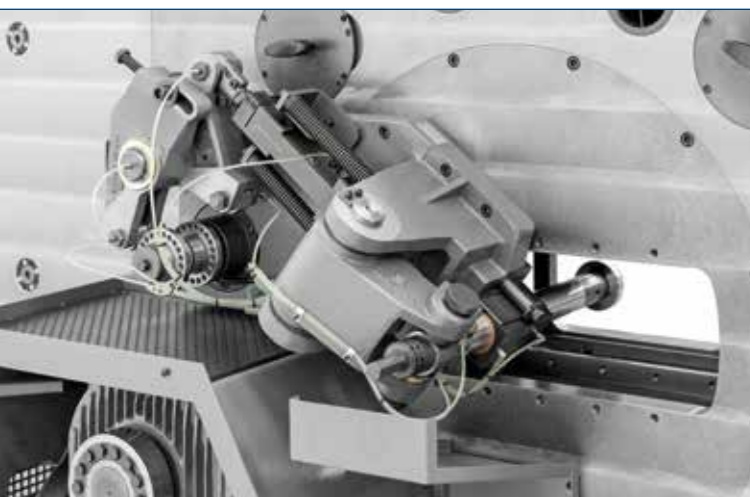
## Precise material feed

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. As option, the highly dynamic NC radial gripper feed RZV 2.1 can be added. This offers you even more flexibility in terms of processing time, infeed lengths and infeed movements.



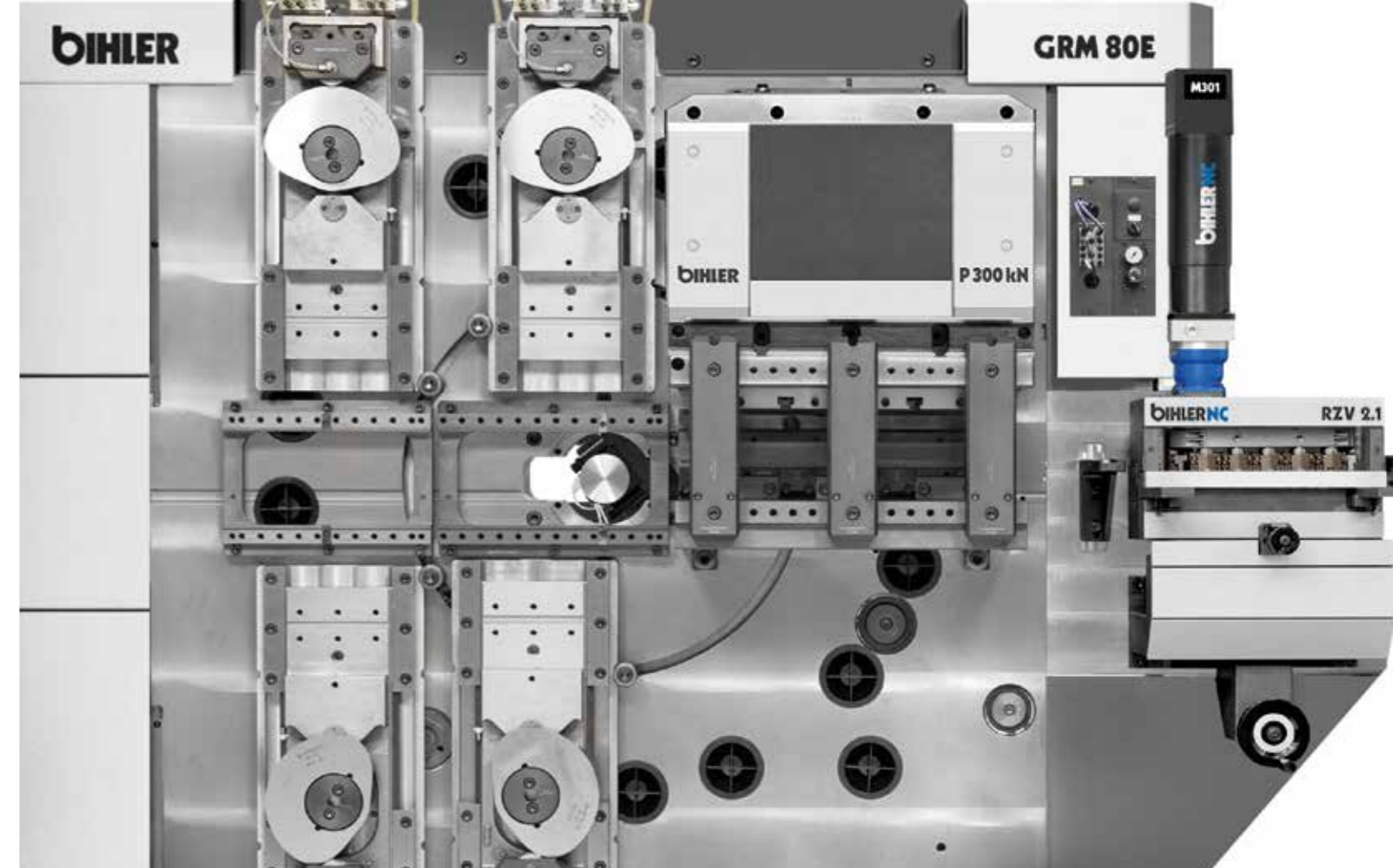
## Stable press for precise cuts

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

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.

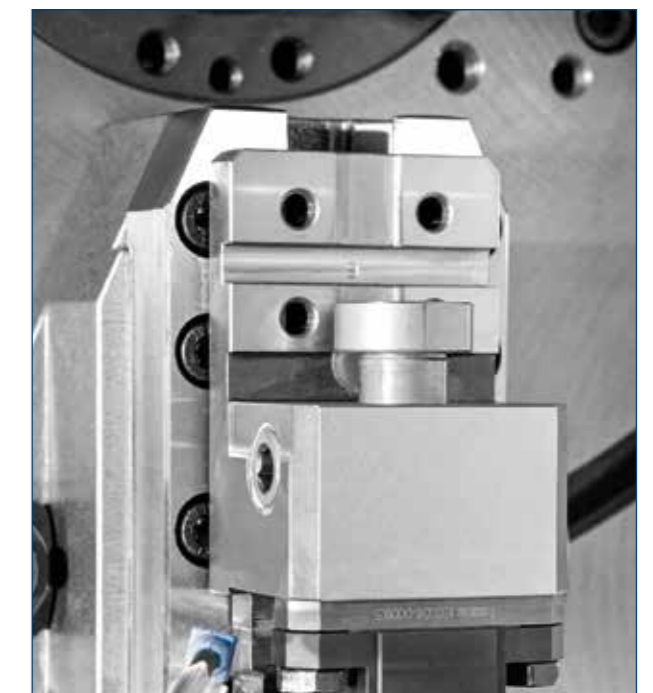


## Slide units with tool rapid-clamping system

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
- A total of 2,100 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



# GRM 80P

Stamping and forming machine



## 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.

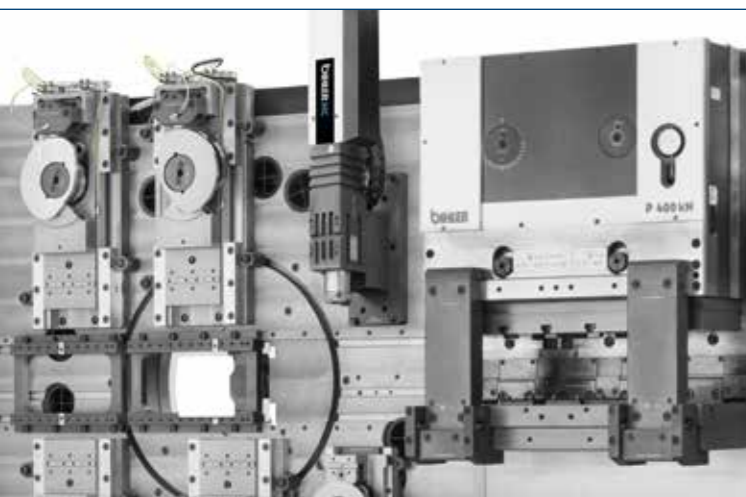
The shorter feed angle leaves a greater machining angle for optimum cam plate movement. This results in smoother running and higher production speeds. A mechanical feeder unit with feed time reduction can be installed as an option.



## 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.

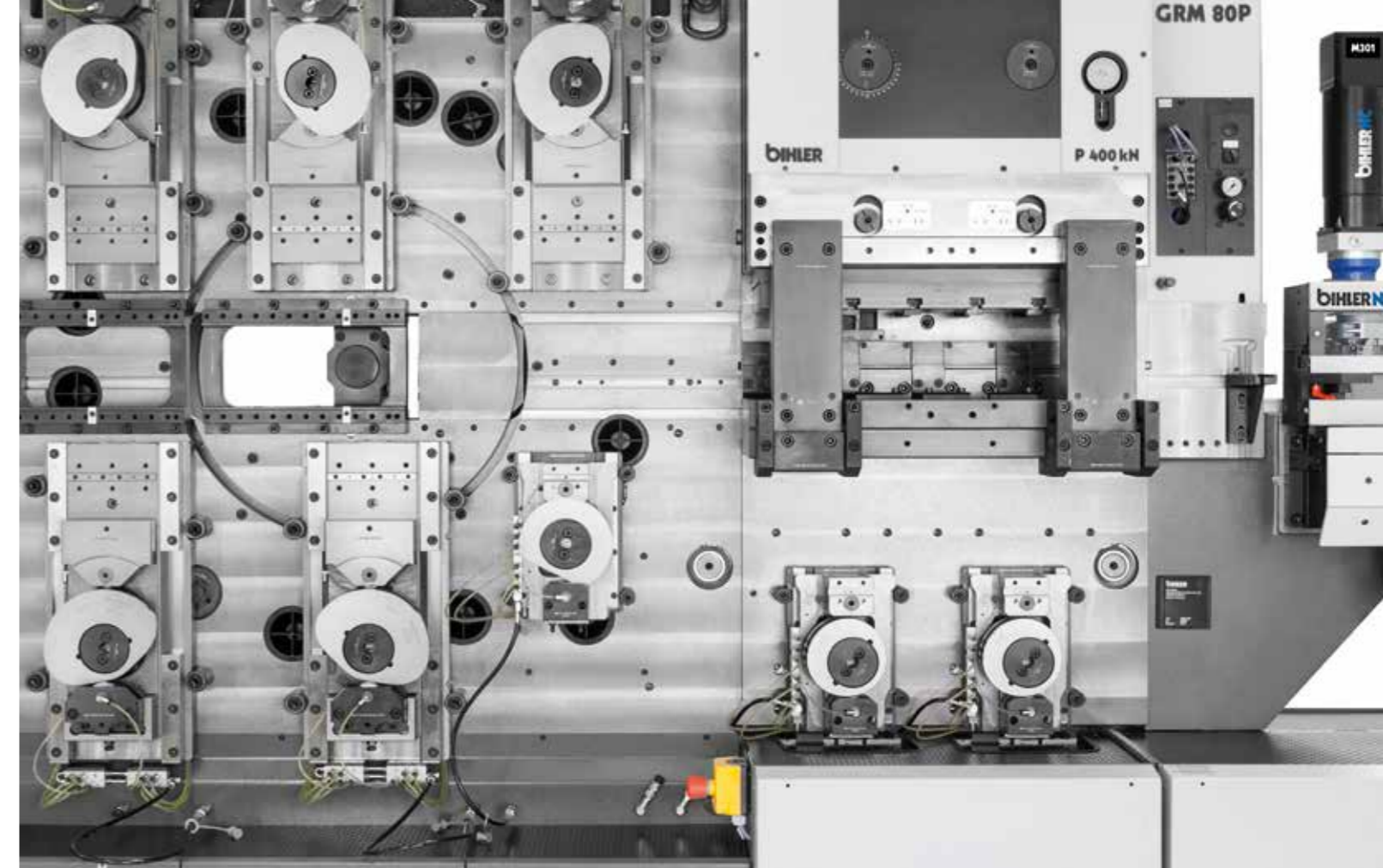
Temperature sensors on the bearing positions and the integrated press capacity monitoring system guarantee maximum tool and process reliability.



## 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 1,400 mm travel for linear tool applications a total of 2,100 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

The standard full machine enclosure with two sliding doors on the front and back offer maximum personal and noise protection.



# VC 1

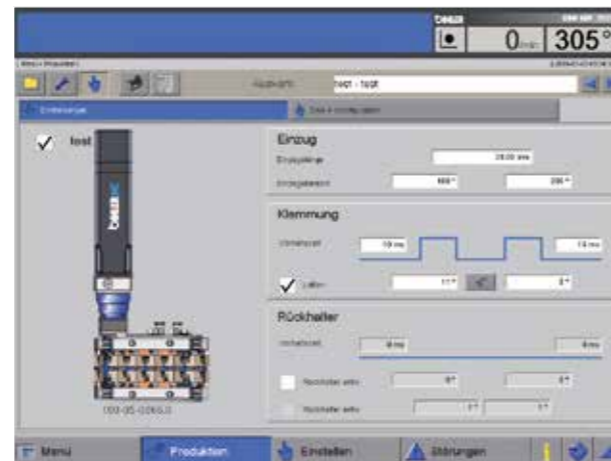
Machine and process control

## The highlights at a glance

- Simple, versatile machine setup without external programming device
- Customized production menus and user interfaces
- Multimedia diagnostic and online help system
- Freely configurable production menus and user interfaces
- Integrated monitoring system of production and machine sensing data

## 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.



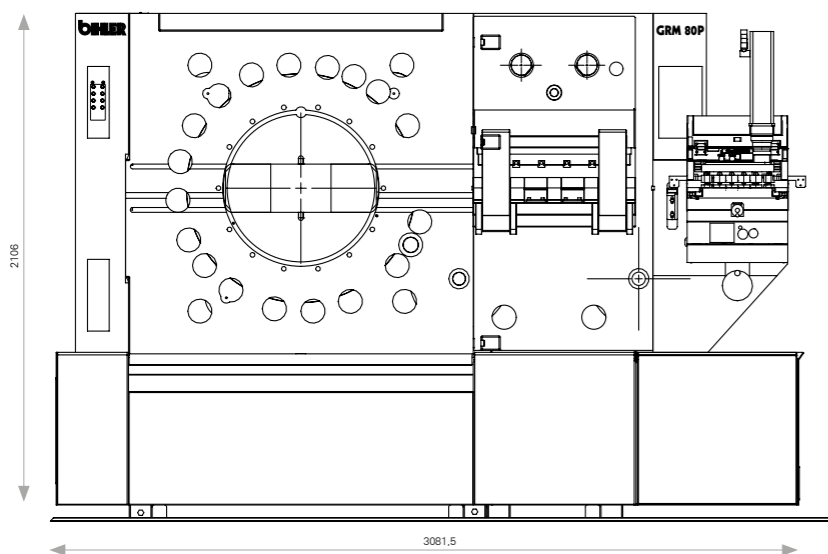
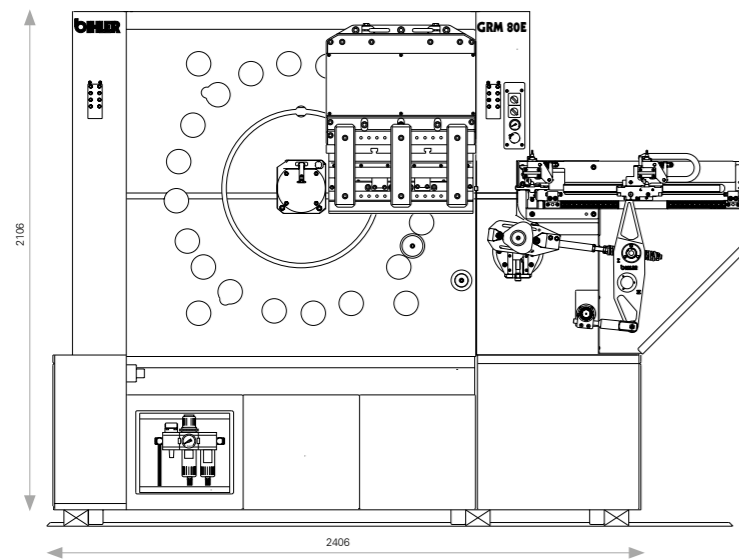
## Support at the touch of a button

The extremely versatile remote maintenance solution fulfils 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.



# GRM SERIES

Technical data / Dimensions



## GRM 80E

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)

Infinitely variable from approximately 5 to a max. of 250 rpm

Infinitely adjustable drive; nominal drive power 17 kW

VariControl VC 1E process control in separate, stand-alone control cabinet 700x700x2100 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 programmable with 16 inputs and 16 outputs; 1 press force monitor as option, slide force monitor as option

Maintenance unit with 2 tap connections for oil-free air; normal pressure 6 bar; pressure monitoring with machine cut-out

Pneumatically operated hydro pump with pressure accumulator and valves for hydraulic feed activation; Pmax. = 144 bar

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

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

Mechanical feed unit, extension on housing right-hand side, max. feed length 500 mm, feed-time reduction, hydraulic material clamping; as option: NC radial gripper feed unit RZV 2.1, feed stroke from 0 to infinity

Two-point eccentric press; nominal capacity 300 kN; stroke 16 mm; fitting height at BDC 126 mm, stroke position adjustment -4 mm, mounting space for die sets up to 540 mm length and 230 mm width; max. strip width 80 mm (larger strip widths on request possible); two point eccentric press, nominal capacity 100 kN; stroke 12 mm; table length 250 mm; eccentric press; nominal capacity 100 kN; stroke 16 mm

Positively controlled or spring-return normal slide units, stroke from 35 mm to 95 mm, max. nominal force 90 kN; positively controlled or spring-return narrow slide units, max. stroke 70 mm, nominal force 50 kN; bottom slide units max. stroke 25 mm, nominal force 30 kN; enlarged slide units, max. stroke 50 mm, nominal force 45 kN \*, integration of NC units as option

Bellcrank lever units, double slide units, coiling slide units, tie rod control units, etc. available upon request

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 2006/42/EG, 2 sliding doors

With full enclosure: width 3,140 mm x depth 1,595 mm x height 2,220 mm; approx. 3.000 kg depending on equipment (without tooling)

## GRM 80P

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)

Infinitely variable from approximately 5 to a max. of 250 rpm

Infinitely adjustable drive; nominal drive power 17 kW

VariControl VC 1 process control in separate, stand-alone control cabinet 700x700x2100 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 programmable with 16 inputs and 16 outputs; 1 press force monitor, slide force monitor as option

Maintenance unit with 2 tap connections for oil-free air; normal pressure 6 bar; pressure monitoring with machine cut-out

Pneumatically operated hydro pump with pressure accumulator and valves for hydraulic feed activation; Pmax. = 144 bar

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

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

NC radial gripper feed RZV 2.1, feed length from 0 to infinity; optional: mechanical feed, attached on right side of enclosure

Two-point eccentric press; nominal capacity 400 kN; stroke 20 mm, fitting height at BDC 157 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 press force monitoring

Positively controlled or spring-return normal slide units, stroke from 35 mm to 95 mm, max. nominal force 90 kN; positively-controlled or spring-return narrow slide units, max. stroke 70 mm, nominal force 50 kN; bottom slide units max. stroke 25 mm, nominal force 30 kN; enlarged slide units, max. stroke 50 mm, nominal force 45 kN \* integration of NC units as option

Bellcrank lever units, double slide units, coiling slide units, tie rod control units, etc. available upon request

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 2006/42/EG, 2 sliding doors

With full enclosure: width 3,930 mm x depth 1,595 mm x height 2,220 mm; 4,500 kg subject to equipment (without tools)

\* additional versions can be used subject to application

b subject to change without notice 09/23





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