

PANEL BENDERS

BENDING TECHNOLOGY





INDUSTRIES





Visit our website

Find out more about what our technologies can do for you and how you could benefit from our consulting and assistance services: **primapower.com**

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PRIMA POWER SOLUTIONS

FUTURE-PROOF YOUR MANUFACTURING

Our product range in the branch of machines and systems for sheet metal manufacturing sector is one of the widest in the industry, including 2D and 3D laser machines, punching and combined punch-laser and punch-shear machines, press brakes, panel benders, flexible manufacturing systems, storages, automation solutions and software.

With our solutions we help our customers enhance their competitiveness, becoming a key element in their value chains as strategic partners for smart, sustainable, and future-proof manufacturing.

Prima Power is present in our everyday lives. DISCOVER HOW









SOFTWARE

POWERING YOUR BUSINESS

BY PUSHING INNOVATION

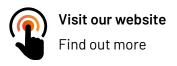


The main driver that moves us to innovate is **enhancing our customers' profitability** through advanced, reliable and **autonomous production systems**.

Whatever the type of application you need and whatever the industry you operate in, our comprehensive portfolio of technologies will meet your needs, with dedicated solutions in the automotive, space economy and many other high-growth sectors, as well as for job shops and contractors.

INDUSTRIES

Aerospace / Automotive
Building & Housing Equipment
Electric Cabinets
Elevators & Escalators
Energy / Food Service Equipment
Healthcare & Medical / HVAC
Mechanics & Machinery
Steel Furniture, Panels & Warehousing
Yellow Goods & Trucks









SUSTAINABILITY AND GROWTH

Sustainability means combining environmental protection and social progress with long-term profitability for our customers and all our stakeholders.

GREEN TECHNOLOGIES

Prima Power has a long tradition of continuous development and great flexibility, of operating economy through versatility and high automation levels, with low energy and maintenance costs. Under our Green Means® banner, this translates into technology and know-how that meet the requirements of productivity and more sustainable manufacturing.

We are pioneers in the electrification of machines, adopting servo-electric technology since 1998. Today we can offer a full line of servo-electric solutions that enables higher productivity and lower environmental impact.

We also believe that people make a difference. We pay special attention to diversity, sharing knowledge, promoting a positive work environment, and supporting the continuous growth of people – of our company, of our customers and other stakeholders.



GREEN HIGHLIGHTS

-64%
CO₂ EMISSIONS

WITH OUR SERVO-ELECTRIC PANEL BENDERS COMPARED TO HYDRAULIC SOLUTIONS







PRIMA POWER PANEL BENDER OPERATING PRINCIPLES

THE POWER OF SERVO-ELECTRIC

When we think of traditional bending machines, we usually think of those where the force is impressed by the downward movement of a punch against the fixed part of the press, known as the die.

In panel benders, the bending work is performed by the blades, while the blank holder holds the sheet still during bending.

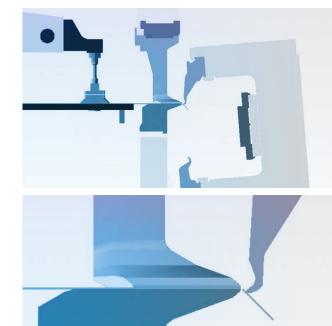
The blades are thus able to perform different types of folds, upwards or downwards, beginning with the outermost bends of one side, before then automatically performing the bend sequence towards the innermost bend.

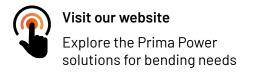
All of these movements are controlled by electric servo drives that guarantee maximum positioning accuracy in the bending trajectory, thus ensuring an optimal result.

Example of positive bend (upwards)



Example of negative bend (downwards)









PANEL BENDERS RANGE

SEMI-AUTOMATIC OR FULLY AUTOMATIC MACHINES AT YOUR SERVICE



Prima Power's panel bender range meets all different production requirements by offering extremely flexible solutions, with semi-automatic or fully automatic machines configured as stand alone cells or multi-technology lines.



FBe Fast Bend

The answer to multiple applications. A semi-automatic bending solution, compact but highly adaptable to any size of production batch.



The entry level Panel Bender. Semi-automatic panel bender with a basic configuration and a very compact layout, guarded by safety light curtains, to allow a fast loading and unloading, and to guarantee safe operations for the operator.



BCe Smart

Ergonomics and intelligence available to the operator. Compact solution with an intermediate level of automation but at affordable prices for efficient and safe semi-automatic production.



BCe Bending Centre

Flexibility at your service. Semi-automatic bending centre for medium/small batch production with LUT loading and unloading device for higher productivity.



EBe Express Bender

The non plus ultra of automation. Fully automatic panel bender that can be configured as stand alone or connected in line with other Prima Power technologies to offer an extremely high automation level.





PANEL BENDERS RANGE

SEMI-AUTOMATIC OR FULLY AUTOMATIC MACHINES AT YOUR SERVICE

Machine sizes available

	BEND HEIGHT		BENDING	LENGTH	
		2250 mm	2750 mm	3350 mm	3800 mm
FBe	204 mm	•	•	•	
BCe SHARP	204 mm	•			
BCe SMART	204 mm	•			
BCe	204 mm	•	•		
EBe	204 mm	•	•	•	•

Different levels of automation





	<u>.</u> ↑.:	<u> </u>	∷			. .
	LOADING	CENTRING	POSITIONING	BENDING	ROTATION	UNLOADING
FBe	"	"	•	•		"
BCe SHARP	#	•	•	•	•	4
BCe SMART	4	•	•	•	•	4
BCe	4	•	•	•	•	•
EBe	•	•	•	•	•	•



FBe FAST BEND

SEMI AUTOMATIC PANEL BENDER FOR SIMPLE, FLEXIBLE AND ACCESSIBLE PRODUCTION



Prima Power's Fast Bend is an intermediate product between the traditional press brake machine and the automatic panel bender.

It allows the automatic creation of multiple bends for each side, including positive / negative inversion, flattened and radius bends; only the loading, rotation and unloading operations are manual.

Fast Bend offers a quick and efficient response to an ever-increasing demand for the reduction in the quantity of pieces of the production batch, combining the simplicity of use of a compact model with a limited expense.



 Excellent bending quality thanks to angle correction database and servo-electric technology



• Suitable for bending various types of parts



Reduced footprint to fit all kinds of environment



- · Reduced operating costs
- · Reduced maintenance





TECHNICAL SPECIFICATIONS

FBe FAST BEND

	FBe 2220	FBe 2720	FBe 3320		
Maximum bending length	2,250	2,750	3,350	(mm)	
Sheet length (min. ÷ max.)	150 ÷ 2,850	150 ÷ 3,000	150 ÷ 3,800	(mm)	
Sheet width (min. ÷ max.)	100 ÷ 1,700	100 ÷ 1,700	100 ÷ 1,700	(mm)	
MINIMUM BENDING LENGTH					
- with re-entering bends	350	350	350	(mm)	
- without re-entering bends	150	150	150	(mm)	
Minimum width between the bends	140 mm with st	andard tools / 45 m	m with AUT T7	(mm)	
Minimum height of the 1st bend	5 times the thic	5 times the thickness of the sheet			
Maximum re-entering bend	55	55	55	(mm)	
Maximum bending height	204	204	204	(mm)	
Vertical distance between the blades	210	210	210	(mm)	
Minimum external radius	1.5 ÷ 2 times the	1.5 ÷ 2 times the thickness of the sheet			
Bending angle	±130	±130	±130	(°)	
Maximum acceptable planarity of the blank	10	10	10	(mm)	
Bending force	32-320	41-410	41-410	(t-kN)	
Sheet clamping force	52-510	90-890	100-980	(t-kN)	
MAXIMUM THICKNESS					
- Steel UTS 410 N/mm²	3.0	3.2	3.0 * - 3.2**	(mm)	
- Stainless steel UTS 680 N/mm ²	2.0	2.2	2.0* - 2.2**	(mm)	
- Aluminium UTS 265 N/mm ²	4.0	4.0	3.5* - 4.0**	(mm)	
Minimum thickness	0.5	0.5	0.5	(mm)	
Average absorbed power	4	5	5	(kWh)	
Numerical Control	OPEN by Prima	Electro			

 $The \ values \ shown \ refer \ to \ a \ standard \ machine. \ Prima \ Power \ reserves \ the \ right \ to \ change \ data \ without \ notice.$





^{*} Full length - ** Max. 3,000 mm

BCe SHARP

SEMI AUTOMATIC ENTRY-LEVEL PANEL BENDER



The BCe Sharp is the entry-level panel bender from Prima Power. Based on the same technological platform of the BCe Smart, with less options, it offers all the benefits of the panel bender with a more affordable price.

The BCe Sharp, with its compact solution, can manufacture finished parts starting from blank metal sheets. The operator loads the part to bend, and unloads the finished component in a single ergonomic sequence, while the machine automates all the bending cycles to grant an excellent bending quality.





PRODUCTIVE

- Single loading and unloading sequence
- Set-up by a high-level HMI software



ERGONOMIC

- Maximum comfort for the operator
- · Lack of physical barriers
- Work surfaces that can be lowered for loading small or medium-sized parts



SAFE

 Two safety light curtains that monitor the loading and unloading area



AFFORDABLE

Excellent cost / performance ratio





TECHNICAL SPECIFICATIONS

BCe SHARP

B	Ce	Sh	nar	n 2	222	C
_	-	\mathbf{v}	IUI	~		•

2,250	(mm)
215 ÷ 2,850	(mm)
180 ÷ 1,500	(mm)
350	(mm)
215	(mm)
3,000	(mm)
160 mm / 120 mm with UBC option	(mm)
5 times the thickness of the sheet	
55	(mm)
204	(mm)
210	(mm)
1.5 ÷ 2 times the thickness of the sheet	
±130	(°)
10	(mm)
32-320	(t-kN)
52-510	(t-kN)
2.5 * - 3.0**	(mm)
1.8* - 2.0**	(mm)
3.5* - 4.0**	(mm)
0.5	(mm)
4	(kWh)
OPEN by Prima Electro	
	215 ÷ 2,850 180 ÷ 1,500 350 215 3,000 160 mm / 120 mm with UBC option 5 times the thickness of the sheet 55 204 210 1.5 ÷ 2 times the thickness of the sheet ±130 10 32-320 52-510 2.5 * - 3.0 ** 1.8 * - 2.0 ** 3.5 * - 4.0 ** 0.5 4

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^{*} Full length - ** Max. 1,900 mm

BCe SMART

SEMI AUTOMATIC PANEL BENDER FOR EFFICIENT, INTUITIVE AND AFFORDABLE PRODUCTION



The BCe Smart bending cell is a revolutionary bending solution thanks to the "safety integrated" concept that allows the operator to focus only on value-added operations, aided by visual devices and sound signals.

Its compact layout and combined loading and unloading sequence guarantee high productivity, constituting a very important investment for anyone looking for a flexible and semi-automatic panel bender.



PRECISE

 Excellent bending quality thanks to angle correction database and servo-electric technology



ERGONOMIC

- Maximum comfort for the operator
- Lack of physical barriers
- Work surfaces that can be lowered for loading small or medium-sized parts



SAFE

 Two laser scanners to monitor the loading and unloading area



AFFORDABLE

- Reduced maintenance costs
- · Energy savings





TECHNICAL SPECIFICATIONS

BCe SMART

DC-	C	10000
BLE	Smar	t 2220

Maximum bending length	2,250	(mm)
Sheet length (min. ÷ max.)	215 ÷ 2,850	(mm)
Sheet width (min. ÷ max.)	180 ÷ 1,500	(mm)
MINIMUM BENDING LENGTH		
- with re-entering bends	350	(mm)
- without re-entering bends	215	(mm)
Maximum panel diagonal	3,000	(mm)
Minimum width between the bends	160 mm / 120 mm with UBC option	(mm)
Minimum height of the 1st bend	5 times the thickness of the sheet	
Maximum re-entering bend	55	(mm)
Maximum bending height	204	(mm)
Vertical distance between the blades	210	(mm)
Minimum external radius	1.5 ÷ 2 times the thickness of the sheet	
Bending angle	±130	(°)
Maximum acceptable planarity of the blank	10	(mm)
Bending force	32-320	(t-kN)
Sheet clamping force	52-510	(t-kN)
MAXIMUM THICKNESS		
- Steel UTS 410 N/mm²	2.5 * - 3.0**	(mm)
- Stainless steel UTS 680 N/mm²	1.8* - 2.0**	(mm)
- Aluminium UTS 265 N/mm ²	3.5* - 4.0**	(mm)
Minimum thickness	0.5	(mm)
Average absorbed power	4	(kWh)
Numerical Control	OPEN by Prima Electro	

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^{*} Full length - ** Max. 1,900 mm

BCe BENDING CENTRE

SEMI AUTOMATIC PANEL BENDER COMBINING FLEXIBILITY AND PRODUCTIVITY



The BCe bending centre from Prima Power offers the ideal solution for those working with single parts, small batches or mass production.

This panel bender combines the well-known benefits of the Express Bender - flexibility, precision and high quality - with a semi-automatic yet highly productive process, where the machine is always in production thanks to the LUT loading and unloading table that allows you to load blanks and unload the bent components in masked time.





 Excellent bending quality thanks to angle correction database and servo-electric technology



FLEXIBLE

- Easy manual loading
- Batches of any size, including kits and single parts



CONFIGURABLE

 Full configuration in layout, loading & unloading area, bending options and tools



EASY

 3D programming with integrated simulation of the bending cycle





TECHNICAL SPECIFICATIONS

BCe BENDING CENTRE

	BCe 2220	BCe 2720	
Maximum bending length	2,250	2,750	(mm)
Sheet length (min. ÷ max.)	280 ÷ 2,850	280 ÷ 2,850	(mm)
Sheet width (min. ÷ max.)	180 ÷ 1,500	180 ÷ 1,500	(mm)
MINIMUM BENDING LENGTH			
- with re-entering bends	350	350	(mm)
- without re-entering bends	280	280	(mm)
Maximum panel diagonal	3,000	3,000	(mm)
Minimum width between the bends	160 mm / 120 mr	m with UBC option	(mm)
Minimum height of the 1st bend	5 times the thicl	kness of the sheet	
Maximum re-entering bend	55	55	(mm)
Maximum bending height	204	204	(mm)
Vertical distance between the blades	210	210	(mm)
Minimum external radius	1.5 ÷ 2 times the	thickness of the sheet	
Bending angle	±130	±130	(°)
Maximum acceptable planarity of the blank	10	10	(mm)
Bending force	32-320	41-410	(t-kN)
Sheet clamping force	52-510	90-890	(t-kN)
MAXIMUM THICKNESS			
- Steel UTS 410 N/mm²	3.0	3.2	(mm)
- Stainless steel UTS 680 N/mm²	2.0	2.2	(mm)
- Aluminium UTS 265 N/mm ²	4.0	4.0	(mm)
Minimum thickness	0.5	0.5	(mm)
Average absorbed power	6.5	6.5	(kWh)
Numerical Control	OPEN by Prima I	Electro	
		-	

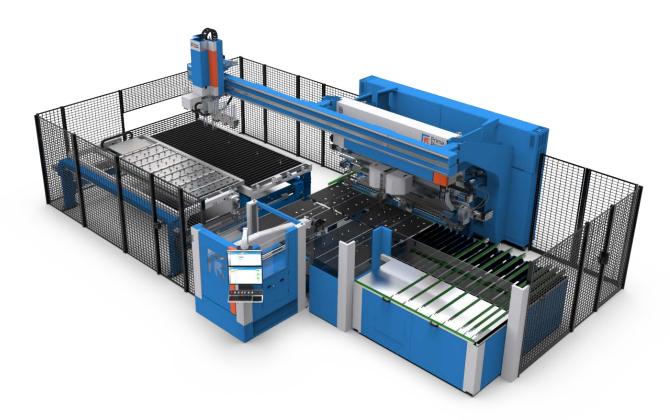
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EBe EXPRESS BENDER

COMPLETELY AUTOMATIC PANEL BENDER FOR HIGH PERFORMANCE AND MAXIMUM PRODUCTIVITY



Prima Power's EBe Express Bender is the servo-electric panel bender which considerably increases the production capacity thanks to the automated loading and unloading process, thus maximising the efficiency of the bending process.

The EBe is suitable for any production requirement. In the stand-alone version, one loading table can accommodate large quantities of the same part, but the EBe can also be configured with different loading options to prepare it for future connections with other Prima Power machines, as well as with the most advanced unloading and stacking solutions.

PRECISE

 Excellent bending quality thanks to angle correction database and servo-electric technology



- Reduction of cycle times
- Loading and unloading operations in masked time



SCALABLE

It includes all the sizes



EASY

 3D programming with integrated simulation of the bending cycle





TECHNICAL SPECIFICATIONS

EBe EXPRESS BENDER

	EBe 2220	EBe 2720	EBe 3320	EBe 3820	
Maximum bending length	2,250	2,750	3,350	3,800	(mm)
Sheet length (min. ÷ max.)	350 ÷ 2,850	350 ÷ 2,850	350 ÷ 3,850	350 ÷ 4,000	(mm)
Sheet width (min. ÷ max.)	180 ÷ 1,500	180 ÷ 1,500	180 ÷ 1,700	180 ÷ 1,700	(mm)
Maximum panel diagonal	3,000	3,000	3,950	4,000	(mm)
Minimum bending length	350	350	350	350	(mm)
Minimum width between the bends	160 mm / 120 m	m with UBC option	n		(mm)
Minimum height of the 1st bend	5 times the thic	kness of the shee	t		
Maximum re-entering bend	55	55	55	55	(mm)
Maximum bending height	204	204	204	204	(mm)
Vertical distance between the blades	210	210	210	210	(mm)
Minimum external radius	1.5 ÷ 2 times the	thickness of the	sheet		
Bending angle	±130	±130	±130	±130	(°)
Maximum acceptable planarity of the blank	10	10	10	10	(mm)
Bending force	32-320	41-410	41-410	41-410	(t-kN)
Sheet clamping force	52-510	90-890	100-980	100-980	(t-kN)
MAXIMUM THICKNESS					
- Steel UTS 410 N/mm ²	3.0	3.2	3.0* - 3.2**	2.0*- 3.2**	(mm)
- Stainless steel UTS 680 N/mm²	2.0	2.2	2.0* - 2.2**	1.5* - 2.2**	(mm)
- Aluminium UTS 265 N/mm²	4.0	4.0	3.5* - 4.0**	3.0* - 4.0**	(mm)
Minimum thickness	0.5	0.5	0.5	0.5	(mm)
Average absorbed power	6.5	6.5	7	7	(kWh)
Numerical Control	OPEN by Prima	Electro			

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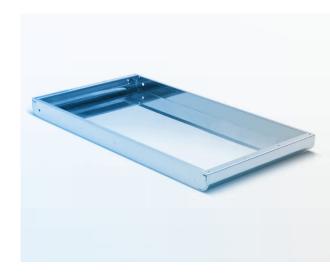
^{*} Full length - ** Max. 3,000 mm

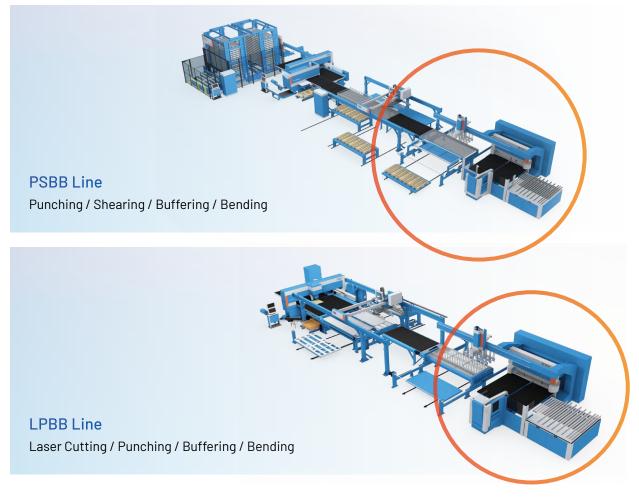
EBe CONNECTIONS

SEVERAL MACHINES IN ONE SINGLE INTEGRATED SOLUTION TO MEET YOUR PRODUCTION NEEDS

The panel bender can be integrated into all Prima Power FM systems (Flexible Manufacturing Systems). Do you want to drastically reduce operations handling raw and semi-finished materials between one process and the next?

Prima Power offers multiple configurations of "systems" that combine the panel bender with various cutting technologies, storages and buffer systems. Several machines in one single integrated solution to meet your production needs.

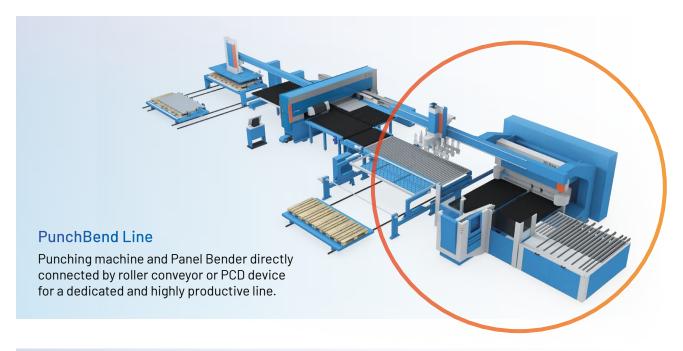


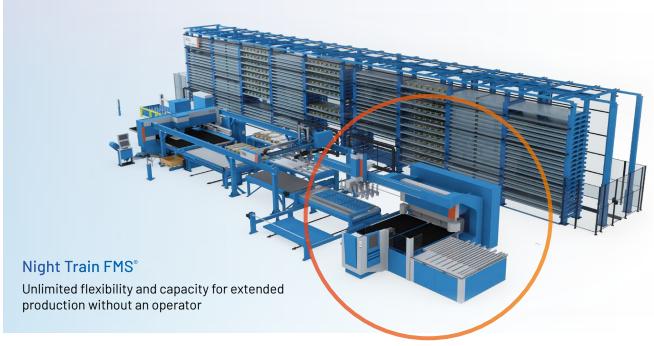




EBe CONNECTIONS

SEVERAL MACHINES IN ONE SINGLE INTEGRATED SOLUTION TO MEET YOUR PRODUCTION NEEDS







ROBOTIC BENDING SOLUTIONS

EFFICIENCY IN EVERY SINGLE APPLICATION



Prima Power can offer different bending solutions integrating its panel benders with a 6 or 7-axis industrial robot, which can be equipped with further devices to handle the material or to support the bending.

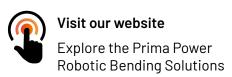
Further support devices can be added to these two main elements: a sheet separator unit for to be bent, a centering table, and a sheet reverser for blanks to be processed or the bent component to be stacked.

Everything is installed inside a considerably limited floor space.

The robotic solution offered by Prima Power allows a high level of integration and automation for programming (offline CAM), connection to ERP production management and planning, as well as feedback and reports in line with Industry 4.0.

What makes the difference on a practical level is the software for the offline programming, which typically represents a critical issue for robotized solutions. Since all the programming is done in the office, the operator activities are easy as they are limitated to check the programming on board, and allows the engineer to concentrate on bending operations.









ROBOTIC BENDING SOLUTIONS

CONFIGURABILITY AND MODULARITY



The great versatility of this solution allows finding the proper application in any industrial segment, exactly for its capacity to conform to batches of any dimension, always guaranteeing an optimal operation. The Robotic Bending Cell perfectly fits with subcontractors, whose production is represented by changeable volumes and parts with different geometries.

The combination of the two technologies allows all of the parts inside a unique production system, keeping the productivity at higher levels and minimizing the costs.

Within the system everything can be personalized according to customer needs.







This is a truly unique bending solution with a panel bender, a robot and an integrated press brake. But what we like the most is the fact that the whole system is extremely flexible!

Michael Winkler

Production Manager (Schulthess Maschinen AG, Switzerland)







Programming plays a very important role in the bending world. Today more than ever, customers are increasingly demanding that the software is latest generation and cutting edge, but also quick to learn and easy for the operator to use.

Prima Power software for programming and managing machine operations simplifies the process and reduces the number of steps required to create the finished component.

TULUS BEND® GRAPHIC INTERFACE

Tulus Bend[®] is the human-machine interface for all Prima Power panel benders. It is an integrated and scalable software tool for centralised production management.

Tulus® Bend works by task list; each task manages a part to be bent. Parts are organized by archive; special functions allow part checking and modifying bending parameters. Tulus® Bend automatically compares current tools on board with the configuration set during machine setup.

While the operator is making panel bender tooling and parts graphic check, Tulus Bend guides him in a easy and contextual way by highlighting the buttons or the flow needed. Also the tool library is managed.



Complete diagnostic purposes thanks to:

- Machine status
- Alarms
- Axis coordinates
- Inputs & Outputs











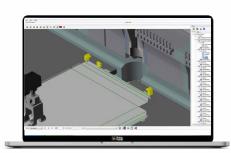


GRAPHIC AND PROGRAMMING MASTER BENDCAM

Master BendCam is the programming system for all Prima Power panel benders and is part of the standard machine supply. It uses interactive graphic techniques to simulate the bending process in a realistic way, generating optimised and safe programs.

MASTER BENDCAM FEATURES

- importing a 3D model (e.g. IGES, STEP, SAT, STL etc.), or a dxf through the Unfolding module of NC Express
- different programming modes: automatic, semi-automatic and manual
- advanced assisted programming with graphical positioning of the machine axes
- tree structure of bending processes
- program optimisation thanks to integrated
 3D simulation
- checking collisions between the piece to be bent and the machine components
- management and configuration of tools
- automatic calculation of cycle times



PRECISION AND REPEATABILITY ARE OUR GOALS

The goal of many customers is more commonly becoming the need to reduce the number of attempts required to reach a bent piece "within tolerance", maximising productivity by reducing waste.

Prima Power responds to this need with DABA technology (Dynamic Adjustment of the Bending Angle), thanks to which corrective parameters are proposed in relation to the material variables which allows a considerable reduction in the time required to create a new panel.









We want our customers to be main players of a new era in the history of manufacturing.

To help you fully capture the experience of Industry 4.0 and unleash the business potential of digital manufacturing,

Prima Power has built a unique Industry 4.0 solution offering in three key areas:

- Smart Machines & Factories
- Smart Software
- Smart Remote Care

SMART MACHINES & FACTORIES

Prima Power Smart Machines and automated factories can collect real-time and historical parameter data through sensors and cameras to maximize machine performance, enhance efficiency and flexibility.

SMART SOFTWARE

The Prima Power Smart Software family is a comprehensive portfolio of modular softwarebased systems that enable seamless production information flow, connectivity to ERP and MES through storing machine-generated data in the cloud.

SMART REMOTE CARE

Prima Power Smart Remote Care is a data-driven analytics and predictive maintenance service that improves machine availability, takes care of your production performance analysis, and monitors machine status and condition to ensure the highest possible machine performance.







We believe in long-term relationship with our partners, and we think that the real product we deliver to our customer is not just the machine itself, but the production capacity that our customer can achieve with our products and technology.

We monitor machine conditions in order to save your time and money, coming to your factory if necessary to intervene directly and quickly for maximum uptime and manufacturing efficiency. We provide you with the best tools and original spare parts, enabling you to stay on the cutting edge with machine upgrades: we work hard to make your work easy.

CLOSE TO OUR CUSTOMERS, WORLDWIDE

Thanks to more than **400 highly professional service engineers**, we are able to assist you wherever you are.



Preventive maintenance

Service agreements and warranty extensions

Phone and remote support

Augmented reality remote assistance

Service intervention

Strong factory tech support

Software care

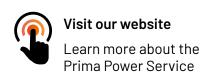
Machine upgrades

Spare parts

Tools

Training and process optimization

Relocations and refurbishment









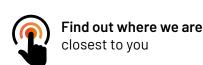
CONTACT US

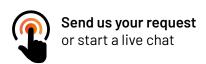
We operate in more than 80 countries around the world.

Our **eight plants** are spread over three continents and they are specialized in different technologies, delivering high-tech machinery and services all over the world. Our **seven Technology Centers** are available for technological consultation, feasibility studies, cycle time optimization, demonstrations and they are always open for you.

We have a direct sales and service presence in more than 25 countries as well as a worldwide network of agents and specialized distributors.

This organization guarantees a "glocal" presence, allowing us to be close to our customers wherever they may be.













Stay up to date with our activities





