

## MASTEEL CNC HYDRAULIC BRAKES

 [Printable Version \(PDF\)](#)

**MBHSA-08090**

List Price:

Max. Capacity Tons	90
Max. Bending Length	8'
Distance between Frames	76"
Height of Bed	34"
Bed Below Floor	—
Depth of Throat	12 – ¾"
Length of Ram Stroke	8"
Fast Approach Speed IPM	275
Press Speed IPM	25
Fast Return Speed IPM	245
Max. Open Height	17.5"
Main Motor	10
Back gauge Travel	28"
Weight Lbs	11,500
Dimensions L x W x H	102 x 44 x 74



### STANDARD CONTROL FEATURES:

- ▣ **Standard SIEMENS TP-700 control with 6" Touch Screen display**
- ▣ **SIEMENS Two Axis CNC controls on back gauge and ram bending position**
  - Bosch-Rexroth Closed-loop proportional Hydraulic position control:  
repeatability standard at  $\pm 0.0006''$ , optional at  $\pm 0.0004''$
  - Backgauge position control:  
Standard CNC backgauge: speed at 200 IPM as per Demo Video; repeatability at  $\pm 0.003''$   
Programmable backgauge retract feature
- ▣ **CNC bending angle control –Only inputs of bending angle, material thickness & die opening**
- ▣ **Two-way bending calibration controls** -allow inexperienced operator to achieve desired angles with no time consuming multiple test bends. Save on costly skilled labour and test bend material.
  - By correction of test-bending angle, control system automatically sets itself to achieve desired angle.
  - By correction of bending position calculated automatically by control system.
- ▣ **Dual ram position feedbacks with hydraulic Synchronized control compensates for uneven force on the bend**
- ▣ **Tool memory for quick recall of tool setup**
- ▣ **200 Job memory with average of 30 bends in each program**
- ▣ **Programmable pressure control**
- ▣ **Programmable ram delay control at bending position under adjustable pressure for bump bending or special heavy bending application**
- ▣ **Maintenance plan auto-prompts service schedule**

- ▣ Operating hour meter
- ▣ Operating prompts and Trouble shooting messages
- ▣ Inch / MM conversion

### **OPERATING FUNCTION:**

- ▣ **Ram speed control:**
  - Rapid approach and return speeds insure more efficient production.
  - Slow bending speed for better control of bending accuracy
- ▣ **Ram stroke control:**
  - Programmable ram top stop limit for more efficient production
  - Programmable slow working speed position and second stop position
- ▣ **Four Operating Modes:**
  - Jog mode: inching control of ram for tool setup
  - Single mode: one full bend cycle per control input.
  - Double stop mode: excellent for sight bend operations.
  - Follow bend mode: easy to follow bending and ram return on large sheet or with crane handling

### **QUALITY & VALUE STANDARD EQUIPMENT:**

- ▣ Two axis back gauge
  - One axis CNC control: X – axis
  - One axis manual adjustment: R – axis
  - Precision-made back gauge fingers
- ▣ Fully equipped with Masteel tooling and clamping system.
  - Floating-adjustable die clamping system for various die application
  - Hardened and precision ground tool steel gooseneck punch: 53-58RC; 100Ton/M(33Ton/Ft) capacity
  - Hardened and precision ground Masteel 10 openings, 4-way die: HB190-260.
- ▣ Masteel Crown Device for easy-adjusting tooling and machine wear intolerances
- ▣ Deeper throat depth with swing up clearance allows full length bend over bed up to 12"
- ▣ T- slotted bed for support arms or custom setups
- ▣ 2 - Front support arms

### **OPTIONAL EQUIPMENTS:**

- ▣ Delem control DA-56 or up model
- ▣ Offline program software
- ▣ Manuel WILA Anti-Deflection system,
- ▣ Optional multi axis control: R, Z1, Z2 up to 6 axis
- ▣ Motorized Wila Anti-Deflection System which operates automatically with DNC unit according to tonnage applied,
- ▣ Hydraulic CNC crowning bed for automatic anti-deflection according to the tonnage
- ▣ Safety light curtain
- ▣ Laser protection system for die area,
- ▣ Hydraulic top and bottom tool holding system,
- ▣ Quick- set front sheet support arm with linear bearing rollers,
- ▣ Hydraulic oil coolant,
- ▣ Automatic slide greasing system,
- ▣ Special throat depth (500,600 and 750 mm),
- ▣ Special top and bottom tools

