

## MASTEEL CNC HYDRAULIC BRAKES

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

**MBHSA-20280**

List Price:

<b>Max. Capacity Tons</b>	280
<b>Max. Bending Length</b>	20'
<b>Distance between Frames</b>	198"
<b>Height of Bed</b>	38"
<b>Bed Below Floor</b>	*-/24"
<b>Depth of Throat</b>	12-3/4"
<b>Length of Ram Stroke</b>	8"
<b>Fast Approach Speed IPM</b>	215
<b>Press Speed IPM</b>	19
<b>Fast Return Speed IPM</b>	188
<b>Max. Open Height</b>	17-1/8"
<b>Main Motor</b>	30
<b>Back gauge Travel</b>	28"
<b>Weight Lbs</b>	68,000
<b>Dimensions L x W x H</b>	250x 60x114

\*- /: without Hydraulic Crowning in Bed



### 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

