



MASTEEL CNC HYDRAULIC BRAKES

MBHSA-24500

List Price:

Max. Capacity Tons	500
Max. Bending Length	24'
Distance between Frames	246"
Height of Bed	36"
Bed Below Floor	30"
Depth of Throat	15 – ¾"
Length of Ram Stroke	10"
Fast Approach Speed IPM	190
Press Speed IPM	17
Fast Return Speed IPM	188
Max. Open Height	23-3/5"
Main Motor	40
Back gauge Travel	28"
Weight Lbs	92,000
Dimensions L x W x H	300x 80x155



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 Siemens CNC control: X – axis
 - One axis manual adjustment: R – axis
 - Precision-made backgauge fingers can be easily & accurately positioned along gauge bar
- ▣ Compact SIEMENS control system provides hydraulic, electrical and CNC control in one for best reliable performance.
- ▣ Push button rapid and fine adjustments on backgauge and bending position.
- ▣ 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 with no cost
- ▣ Deep 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
- ▣ Standard SIEMENS two-axis CNC controller
- ▣ North-American made hydraulic & electrical system
- ▣ North-American standard hydraulic fittings and hoses

OPTIONAL EQUIPMENTS:

- ▣ KV-2004 or Delem control DA-56 or up model
- ▣ Offline program software for KV-2004 or Delem control
- ▣ Servo CNC back gauge with ball screw and linear guide way
- ▣ Optional multi axis control: R, Z1, Z2 up to 6 axis
- ▣ Manual WILA Anti-Deflection system,
- ▣ 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,
- ▣ One-shot slide greasing system,
- ▣ Special throat depth (500,600 and 750 mm),
- ▣ Special top and bottom tools