

Panel Bender Technical Details

Technical Specifications			PB2	PB4
Max. Bending Length		mm	2250	2800
Sheet Length	min	mm	215	
	max	mm	3048	3505
Sheet Width	min	mm	150	
	max	mm	1524	
Min. Bending Length	with re-entering bends	mm	350	
	without re-entering bends	mm	215	
Max. Sheet Diagonal		mm	2600	3300
Min. Width Between The Bends	Standard	mm	150	
	with option	mm	120 (with OC option)	
Min. Height Of The 1 st Bend			4 ÷ 5 times the thickness	
Max. Re-Entering Bend		mm	50	
Max. Bending Height		mm	254	
Distance Between The Bending Blades		mm	268	
Min. External Radius			1.5 ÷ 2 times the thickness	
Max. Bending Angle In One Step		°	±135	
Max. Acceptable Planarity Of The Blank		mm	10	
Bending Force		kN	320	500
Holding Force		kN	550	1000
Max. Thickness	Steel UTS 410 N/mm ²	mm	2,5	3,2
	Stainless Steel UTS 680 N/mm ²	mm	1,8	2,2
	Aluminium UTS 265 N/mm ²	mm	3,5	4
Min. Thickness		mm	0,5	
Average Consumption		kWh	3,75	4,5

Machine Characteristics	
Numeric Control	Siemens 840 D
Locking Tools Mechanism	Servo Electric
Crowning Bending Blade	Servo Electric
Reference Pins Control	Microswitch
Crowning Holder Device	Servo Electric
Holder Device Main Movements	4 actuators
Manipulator Clamping	Servo Electric
Negative Last Bend	Standard
Automatic Tool Setup	Standard
Axis Movements	Servo Electric
On - Off Movements	Pneumatic

Production process accuracy in according to ISO DIN 2768 - mK.