'HACO' HYDRAULIC PRESSBRAKE

TYPE HDSY : Heavy Duty Synchromaster

Indicative picture, example model : HDSY 60700

'HACO' HYDRAULIC PRESSBRAKE
TYPE HDSY 40700= HDSY 770-13-10

1.   STANDARD EXECUTION

Frame is a rigid bolted construction, stress relieved and machined on first class CNC long bed milling machines.

Machine and table projection under floor level.   This results in an ergonomic and comfortable table height above floor level.

The standard bed (table) is crowned (to compensate for unavoidable bed and ram-deflection under load) for average general purpose work with the machine. Optionally, a hydraulically driven CNC Anti-Deflection Table can be added to the equipment of the machine.

Long ram guiding, executed with non-metallic gibs, provides minimum clearance, long lifetime and excellent ram guiding accuracy.

A special designed punch holder guarantees the perfect alignment of the upper tooling with the die.

Hinge-pin connection between cylinder and ram enables a tilt value of the ram without introducing radial forces to the ram.

The hydraulic system is user-friendly located in the upper part of the machine. Use of first class hydraulic components (such as Rexroth, Vickers, …) and own build precision hydraulic manifold block.

The SYNCHRO system allows the Y1 and Y2 axis to operate as two independent double acting hydraulic systems. Both axis share the same oil supply but the flow to the valves as well as true positions of the ram are entirely and separately controlled by computer command.
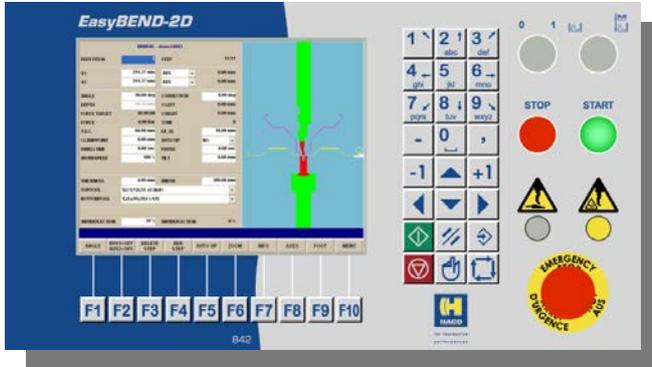
The CNC reads ram position from the linear encoders while monitoring and adjusting the proportional valves, producing a double closed loop system.

Two independent linear encoders are mounted by means of a separate C-frame to the table, so the unavoidable (even minimum) side frame deflection (and machine load) does not influence the exact measuring (0.01mm) of the ram position.

Pendant control panel with EasyBend 2D control.

ROBOSOFT EasyBend2D control

More-axis control : X-Y1/Y2-ADT (=anti-deflection)
10.4" colour graphic LCD display
Operating system Linux
Material library up to 30 different materials
Tool library with graphical visualisation for 30 upper and 30 lower tools
USB Support (stick included) + Network board
Multiple drawing methods
Graphic simulation of parts with Multitasking Real Time solution Finding
Automatic calculation of the required force and bending sequence
Automatic CNC program calculation
Programmable Beam Speed and Speed Change-Over Point,
Top Death Center (TDC), Back gauge Positioning with retraction
Programmable delay and dwell-time
Piece counter (up and down)

Heavy duty back gauge on ball screws, DC driven, speed 120 mm/s, stroke 1220 mm, CNC controlled by Robosoft EasyBEND-2D, including 2 heavy duty fingers manually adjustable in width and height.

Foot pedal control.

Non-Filled oil tank.

Operation and maintenance manual.

Machine painted in dark grey, light grey and yellow

Ram machined to use HACO type tooling.