WC67Y 系列

液压板料折弯机

WC67Y Series Hydraulic Press Brake

性能与特点

Performance and Features

- 整机钢板焊接结构，采用振动时效消除内应力，机器强度高、刚性好；
- 液压双油缸上传动，机械挡块，扭轴同步，运行平稳可靠，精度高；
- 后挡料距离及滑块行程采用电动调节及手动微调方式，并配有数字显示装置，使用方便快捷；
- 上模配有挠度补偿装置。

- The whole machine is in sheet plate welded structure, with internal stress eliminated by vibration aging technology, high strength and good rigidity of machine.
- Double hydraulic oil cylinder is applied for upper transmission, provided with mechanical limit Stopper and synchronous torsion bar, typical of stable and reliable operation, as well as high precision.
- Electrical control and manual fine-tuning mode are adopted for distance of rear stopper and stroke of gliding block, and fitted with digital display device, easy and quick in use.
- Upper die is fitted with deflection compensation device.




WC67K 系列

简易数控液压板料折弯机

WC67K Series Hydraulic Simple CNC Press Brake

性能与特点

Performance and Features

- 主机采用WC67Y机型，配有简易数控系统；
- 具有后挡料及上滑块位置数码显示、X/Y 轴软限位、单向定位间隙提示功能；
- 后挡料及上滑块均装有编码器，配合数码显示系统使得后挡料及上滑块位置值准确显示，从而进一步提高机器的工作精度。

- WC67Y machine model is adopted for mainframe, fitted with digital display system.
- The machine is provided digital display for the positions of rear stopper and gliding block, as well as prompting function for soft limit of X/Y shaft and one-way positioning clearance.
- Rear stopper and uppper gliding block are both fitted with coders, for a more accurate display for positions of rear stopper and upper gliding block in cooperation with digital display system, thus to further increase the operating precision of this machine.

E21 / 南京埃斯顿公司

1、后挡料与挡块控制
2、控制普通电机或变频器
3、智能定位，工件计数
4、保压卸荷时间设定
5、40个程序存储，每个程序25步
6、单边定位，退让功能
7、参数一键备份与恢复
8、公英制，中 / 英文

1.Backgauge and block control
2.Control for general AC motors, frequency inverter
3.Intelligent positioning, Stock counter
4.Holding / decompression time setting
5.Program memory of up to 40 programs up to 25 steps per program
6.One side positioning, Retract function
7.One key backup / restore of parameters
8.mm / Inch, Chinese / English

WC67K 系列

扭轴伺服数控折弯机

WC67K Series Hydraulic Torsion Servo CNC Press Brake

性能与特点 >

Performance and Features

- 主机配置折弯机专用数控系统；
- 多工步编程功能，能够实现多步程序自动运行、连续定位，实现后挡料及滑块位置自动精确调节；
- 折弯计数功能，实时显示加工数量，断电记忆后挡料滑块位置、程序及参数；
- 后挡料采用进口滚珠丝杆和直线导轨，确保了后挡料的定位精度，机器加工精度更高。

- Special numeric-control system is fitted with mainframe of the bending machine.
- Multi-work-step programming function is able to achieve an automatic operation and contnuous positioning of multi-step procedures, as well as an automatic precision adjustment for positions of rear stopper and gliding block.
- The machine is provided with bend counting function, for a real-time display of processing quantity and power-failure memory of positions of stopper and gliding block, as well as procedures and parameters.
- Imported ball bearing lead screw and linear guide rail are used for rear stopper, to ensure the positioning precision of rear stopper, for processing precision of machine to be higher.

可选配 DA-41S、E300、MD320、MD330 等数控系统

DA-41S

E300

MD320

MD330

TECHNICAL PARMETERS

技术参数 / WC67Y、WC67K系列

机床型号 type	公称压力 Nominal force	工作台长度 Worktable length	立柱间距 Poles distance	喉口深度 Throat depth	后挡料距离 Back–GaugeRange	滑块行程 Ram Strokes	最大开启高度 Max open	主电机功率 Power	外形尺寸Dimension Lxwxh (mm)
	KN	mm	mm	mm	mm	mm	mm	kw	mm
30T/1600	300	1600	1340	180	20–600	80	250	3	1800x1050x1700
40T/1600	400	1600	1330	220	20–600	120	320	5.5	1800x1340x2000
40T/2200	400	2200	1800	220	20–600	120	320	5.5	2400x1340x2000
40T/2500	400	2500	2000	220	20–600	120	320	5.5	2700x1340x2000
63T/2500	630	2500	2000	260	20–600	120	370	5.5	2700x1380x2250
63T/3200	630	3200	2500	260	20–600	120	370	5.5	3400x1380x2250
80T/2500	800	2500	2000	320	20–600	120	380	7.5	2700x1450x2250
80T/3200	800	3200	2500	320	20–600	120	380	7.5	3400x1450x2250
80T/4000	800	4000	3100	320	20–600	120	380	7.5	4200x1450x2250
100T/2500	1000	2500	2000	320	20–600	120	380	7.5	2700x1500x2420
100T/3200	1000	3200	2500	320	20–600	120	380	7.5	3400x1500x2420
100T/4000	1000	4000	3060	320	20–600	120	380	7.5	4200x1500x2420
100T/5000	1000	5000	4000	320	20–600	120	380	7.5	5200x1600x2500
125T/2500	1250	2500	2000	320	20–600	120	380	7.5	2700x1550x2450
125T/3200	1250	3200	2500	320	20–600	120	380	7.5	3400x1550x2450
125T/4000	1250	4000	3055	320	20–600	120	380	7.5	4200x1550x2450
125T/5000	1250	5000	4000	320	20–600	120	380	11	5200x1650x2550
125T/6000	1250	6000	5000	320	20–600	120	380	11	6200x1650x2550
160T/3200	1600	3200	2500	350	20–600	180	470	11	3400X1700x2520
160T/4000	1600	4000	3100	350	20–600	180	470	11	4200X1700x2520
160T/5000	1600	5000	4000	350	20–600	180	470	11	5200X1800x2800
160T/6000	1600	6000	5000	350	20–600	180	470	11	6200X1800x2900
200T/3200	2000	3200	2500	350	20–600	250	480	15	3400x1800x2550
200T/4000	2000	4000	3100	350	20–600	250	480	15	4200x1800x2550
200T/5000	2000	5000	4000	350	20–600	250	480	15	5200x1900x2900
200T/6000	2000	6000	4600	350	20–600	250	480	15	6200x1900x3100
250T/3200	2500	3200	2500	400	20–600	250	540	18.5	3400x1950x2800
250T/4000	2500	4000	3100	400	20–600	250	540	18.5	4200x1950x2800
250T/5000	2500	5000	4000	400	20–600	250	540	18.5	5200X2000x3000
250T/6000	2500	6000	4600	400	20–600	250	540	18.5	6200X2000x3150
300T/3200	3000	3200	2500	400	20–600	250	560	18.5	3400x2000x3200
300T/4000	3000	4000	3100	400	20–600	250	560	18.5	4200x2000x3200
300T/5000	3000	5000	4000	400	20–600	250	560	22	5200x2200x3300
300T/6000	3000	6000	4500	400	20–600	250	560	22	6200x2300x3400
400T/4000	4000	4000	3100	400	20–600	300	600	30	4200X2500x3400
400T/5000	5000	5000	4000	400	20–600	300	600	30	5200X2500x3500
400T/6000	6000	6000	5000	400	20–600	300	600	30	6200X2500x3600
500T/4000	4000	4000	3100	400	20–600	320	630	37	4200X2700x3700
500T/5000	5000	5000	4000	400	20–600	320	630	37	5200X2700x3800
500T/6000	6000	6000	4500	400	20–600	320	630	37	6200X2700x4000
600T/4000	4000	4000	3100	400	20–600	320	630	45	4200X2900x4300
600T/5000	5000	5000	4000	400	20–600	320	630	45	5200X3000x4700
600T/6000	6000	6000	4500	400	20–600	320	630	45	6200X3000x5000

Sample parameters are subject to change without prior notice! 样本参数如有更改恕不另行通知!

PBCNC系列

电液伺服数控折弯机

PBCNC Series ElectroHydraulic Synchronous Press Brake

性能与特点 >

Performance and Features

- 机身采用整体焊接及整体加工结构，机身主要部件均采用ANSYS有限元分析软件进行分析，确保了机床的可靠性及整机的精度；
- 两侧主油缸突破了传统机械挡块式折弯机的行程控制方式，而是采用了德国进口电液伺服阀及进口光栅尺构成的闭环控制方式，滑块位置反馈精度高，运行准确平稳，同步性能好，折弯精度、滑块的重复定位精度高；
- 后挡料中的功能部件均采用进口件，确保了后挡料的挡料精度，并可根据客户需求采用功能更为齐全的多个后挡料轴的后挡料机构；
- 液压系统均采用德国进口的集成式控制系统，减少了管路的安装，确保了机床的工作稳定性，外形简洁美观；
- 机身两侧装有C型板，高精度光栅尺安装在C型板上，从而避免了折弯时机身变形对折弯精度的影响；
- 下工作台具有液压挠度自动补偿机构，实现了无盲区有效补偿，折弯精度高，确保长期稳定；
- 数控系统采用意大利ESA、荷兰DELEM或瑞士CYBELEC公司的电液伺服折弯机专用数控系统，可实现折弯角度图形编程、角度修正补偿，折弯压力自动计算与自动调整，自动计算工作台变形补偿量、工件展开长度、压底折弯压力、开口距离、后挡料自动退让等功能。

- The machine body is in an overall welded and overall processed structure, and ANSYS finlte element analysis software is applied to main parts of the machine body for analysis, which has ensured the reliability of machine tool and the precision of entire machine.
- Closed loop control mode composed of electrohydraulic servo valve imported from Germany and imported grating ruler is adopted for fhe main oil cylinders on both sides, to break through the stroke control pattern of traditional bending machines of mechanical stoppe-r type, typical of high feedback precision for position of gliding block, accurate and stable operation, good synchronizing performance and high repeated positioning precision of gliding block.
- Imported parts are used for all the functional parts in the rear stopper to ensure the stopping precision of rear stopper and the mechanism of rear stopper will multiple stopping shafts for more complete functions is employed up to customer requirements.
- Integrated control system imported from Germany is adopted for the whole hydraulic system, to simplify the installation of pipelines, and to ensures stable operation as well as simple and nice appearance of the machine tool.
- C-shaped plates are fitted on both sides of the machine body, and the high precision grating ruler is mounted on the C-shaped plates, thus to avoid the influence over pending precision arising from distortion of machine body during bending process.
- The lower workbench is fitted with automatic compensation mechanism for hydraulic deflection, to achieve an effective dead zone free compensation with high bending precision and long stability guaranteed.
- The numeric control system refers to the numeric-control system special for electrohydraulc servo bending machines of Italian ESA, Netherland DELEM, or Swiss CYBELEC Companies, able to achieve the functions of graphic programming for bending angle, compensation for angle amendment, automatic calculation and adjustment of bending pressure, automatic calculation of compensation for workbench distortion, extending length of workpieces, bending pressure for sole pressing, open distance, and automatic withdrawal of rear stopper, etc.

TECHNICAL PARMETERS

技术参数 / PBCNC系列

Type	63T/2500	80T/3200	100T/3200	160T/3200	200T/3200	250T/3200	320T/3200
公称力 nominal force	630KN	800KN	1000KN	1600KN	2000KN	2500KN	3200KN
折弯长度 bending length	2500mm	3200mm	3200mm	3200mm	3200mm	3200mm	3200mm
立柱间距离 poles distance	1900mm	2600mm	2600mm	2600mm	2540mm	2540mm	2700mm
喉口深度 throat depth	350mm	350mm	400mm	400mm	400mm	400mm	400mm
滑块行程 slider travel	120mm	120mm	150mm	170mm	200mm	200mm	200mm
工作台高度 height of table	800mm	800mm	800mm	800mm	800mm	800mm	800mm
装模高度 die loading height	380mm	380mm	420mm	420mm	420mm	420mm	420mm
主电机功率 power	5.5kw	7.5kw	7.5kw	11kw	15kw	15kw	18.5kw
补偿油缸数量 compensation	2	3	3	3	3	3	3
控制轴数 axes	3+1	3+1	3+1	3+1	3+1	3+1	3+1
后挡料 ×轴行程×travel	500mm	500mm	500mm	500mm	500mm	500mm	500mm
后挡料 ×轴速度×speed	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s
外形尺寸(长×高×宽) Dimension (mm)	3100×1450×2050	3500×1550×2100	3500×1580×2400	3500×1650×2500	3500×1680×2550	3500×1700×2600	3500×1880×2730
Type	400T/4000	500T/5000	500T/6000	500T/7000	600T/5000	600T/6000	600T/7000
公称力 nominal force	4000KN	5000KN	5000KN	5000KN	6000KN	6000KN	6000KN
折弯长度 bending length	4000mm	5000mm	6000mm	7000mm	5000mm	6000mm	7000mm
立柱间距离 poles distance	3500mm	3900mm	4900mm	5900mm	3900mm	4900mm	5900mm
喉口深度 throat depth	400mm	500mm	500mm	500mm	500mm	500mm	500mm
滑块行程 slider travel	200mm	320mm	320mm	320mm	320mm	320mm	320mm
工作台高度 height of table	800mm	800mm	800mm	800mm	800mm	800mm	800mm
装模高度 die loading height	420mm	600mm	600mm	600mm	600mm	600mm	600mm
主电机功率 power	22.5kw	37kw	37kw	37kw	45kw	45kw	45kw
补偿油缸数量 compensation	4	5	6	6	5	6	7
控制轴数 axes	3+1	3+1	3+1	3+1	3+1	3+1	3+1
后挡料 ×轴行程×travel	500mm	500mm	500mm	500mm	500mm	500mm	500mm
后挡料 ×轴速度×speed	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s
外形尺寸(长×高×宽) Dimension (mm)	4300×2080×2730	5400×2525×4600	6500×2525×4200	7500×2525×4900	5500×2450×4500	6500×2450×5100	7500×2450×5200

Type	800T/6000	800T/7000	800T/8000	1000T/6000	1000T/7000	1000T/8000	1200T/6000	1200T/7000	1200T/8000	1600T/6000	1600T/7000	1600T/8000
公称力 nominal force	8000KN	8000KN	8000KN	10000KN	10000KN	10000KN	12000KN	12000KN	12000KN	16000KN	16000KN	16000KN
折弯长度 bending length	6000mm	7000mm	8000mm	6000mm	7000mm	8000mm	6000mm	7000mm	8000mm	6000mm	7000mm	8000mm
立柱间距离 poles distance	4900mm	5900mm	5900mm	5900mm	5900mm	6900mm	4900mm	5900mm	6900mm	4900mm	5900mm	6900mm
喉口深度 throat depth	600mm	600mm	600mm	600mm	600mm	600mm	600mm	600mm	600mm	500mm	500mm	500mm
滑块行程 slider travel	420mm	420mm	420mm	420mm	420mm	420mm	420mm	420mm	420mm	320mm	320mm	320mm
工作台高度 height of table	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm
装模高度 die loading height	300mm	300mm	300mm	300mm	300mm	300mm	300mm	300mm	300mm	300mm	300mm	300mm
主电机功率 power	600mm	600mm	600mm	600mm	600mm	600mm	600mm	600mm	600mm	600mm	600mm	600mm
补偿油缸数量 compensation	74kw	74kw	74kw	90kw	90kw	90kw	90kw	90kw	90kw	110kw	110kw	110kw
控制轴数 axes	3	3	3	3	3	3	3	3	3	3	3	3
后挡料 ×轴行程 ×travel	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm	800mm
后挡料 ×轴速度 ×speed	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	200mm/s	500mm/s	500mm/s	500mm/s
外形尺寸 Dimension (mm)	6500×2750×5300	7500×2750×5500	8500×2750×5900	6500×2800×5600	6500×2800×5800	6500×2800×6100	6500×3100×5850	6500×3100×6550	8500×3100×7150	6500×3300×6500	7500×3300×7000	8500×3300×8000

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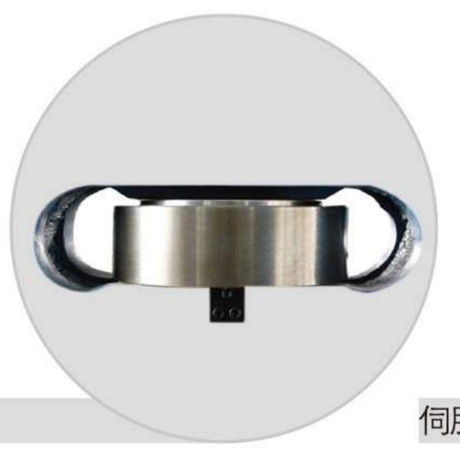
PBCNC系列

电液伺服数控折弯机

PBCNC Series ElectroHydraulic Synchronous Press Brake

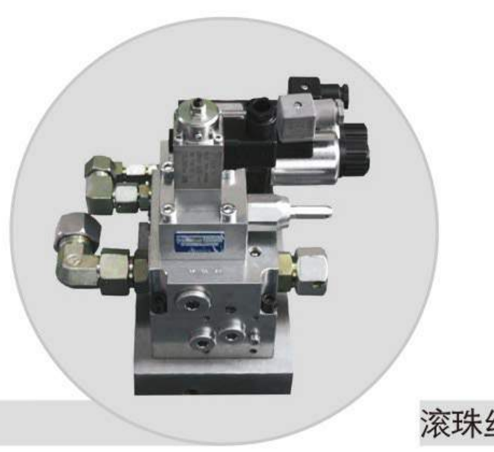
可选配置 Main Import Deployment List



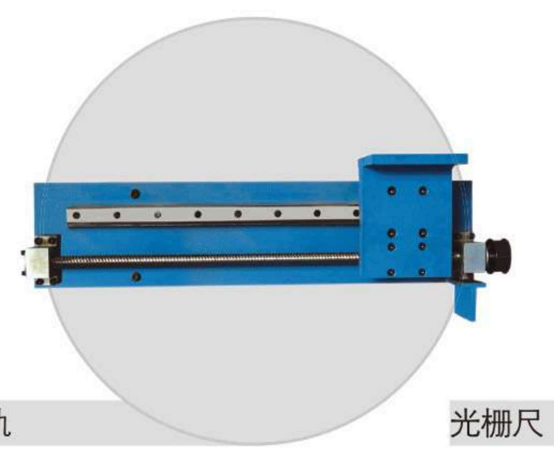
工作台液压补偿机构
Workbench Hydraulic Compensation Mechanism

伺服电机及驱动
Servo Motor and Drive

模具快夹
Mould fast clamp

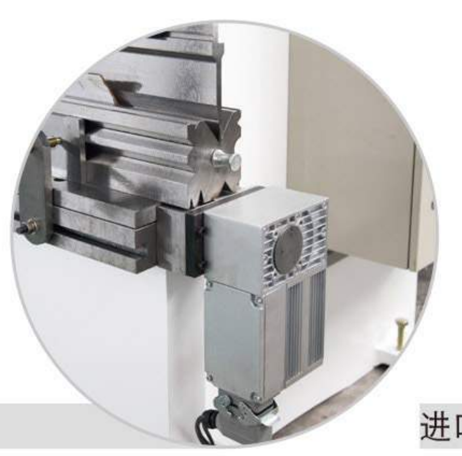


液压系统
Hydraulic System

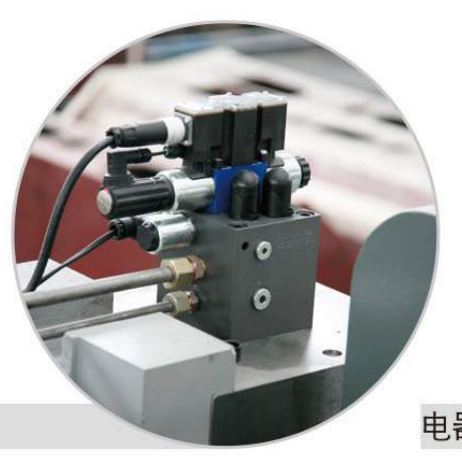


滚珠丝杆及直线导轨
Ball Bearing Lead Screw and Linear Guide Rail

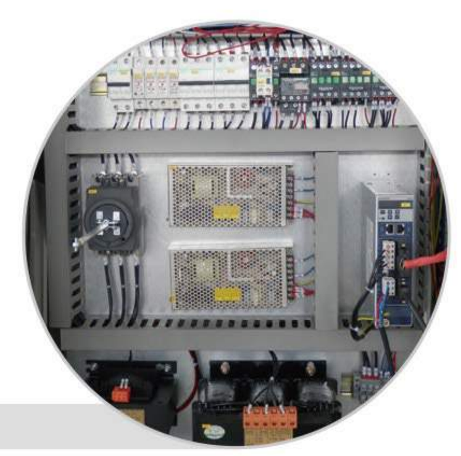
光栅尺
Grating Ruler



工作台挠度补偿装置
Worktable deflection compensation device



进口阀组
Inlet valve group



电器控制
Electronic

Optional Numeric system
可选配的数控系统

DA-52S / 荷兰DELEM公司

- 一页式参数快速编程
- 导航快捷键
- 7” 宽屏彩色TFT
- 最大4轴控制(Y1.Y2和两附加轴)
- 工作台挠度补偿控制
- 模具/材料/产品库
- USB外设接口
- 先进的Y轴控制算法,既可控制闭环,也可控制开环阀
- 面板式安装结构,可选悬吊箱

- Quick, one page programming
- Hotkey navigation
- 7” widescreen colour TFT
- Upto4axes(Y1,Y2,and2 auxiliary axes)
- Crowning control
- Tool/material/product library
- USB, peripheral interfacing
- Advanced Y-axis control algorithms for closed loop as well as open loop valves
- Panel based controller with optional housing

DA-56S / 荷兰DELEM公司

- 二维图形编程
- 10.4" LCD TFT 彩显
- 折弯工序确定
- 展开长度计算
- 工作台变形补偿
- USB接口
- 先进的Y轴控制算法,既可控制闭环,也可控制开环阀
- 伺服控制,变频控制和A C交流电机控制

- 2D graphical programming
- 10,4" LCD TFT colour display
- Bend sequence determination
- Developed length calculation
- Crowning control
- USB peripheral interfacing
- Servo, frequency inverter and AC control
- Advanced Y-axis control algorithms for closed-loop as well as open-loop valves.

DA-65W / 荷兰DELEM公司

- Windows操作平台，内置PLC，10.4"彩色液晶显示
- 二维图形编程，工件与模具图形绘制，防碰撞检测，自由设定材料参数
- 折弯压力、工作台变形补偿、压底折弯力、大圆弧折弯、展开长度自动计算
- 角度校正数据库，多国语言选择，手轮移动所有轴
- 数据备份、恢复、支持用户专业应用

- Windows operation plat, built-in PLC, 10.4"color liquid crystal display
- 2D drawing programming, work-piece and die drawing, anti-impact testing and freely setting material parameters
- Compensation for bending pressure and work table deformation and automatic calculation of bottom bending force, large-arc bending and developed length
- Angle correction data base, multi-nation selection and shaft movement with hand wheel
- Date back-up and recovery, supporting user special application

DA-69W / 荷兰DELEM公司

- Windows操作平台，内置PLC，12"彩色液晶显示
- 完整Windows组件（互联网、邮件、PDF浏览器）
- 二维/三维图形编程，工件与模具图形绘制，防碰撞检测，自由设定材料参数
- 折弯压力、工作台变形补偿、压底折弯力、大圆弧折弯、展开长度自动计算
- 角度校正数据库，多国语言选择，手轮移动所有轴
- 数据备份、恢复、支持用户专业应用

- Windows operation plat, built-in PLC, 12"color liquid crystal display
- Complete Windows component (internet, Email and PDF browser)
- 2D/3D drawing programming, work-piece and die drawing, anti-impact testing and freely setting material parameters
- Compensation for bending pressure and work table deformation and automatic calculation of bottom bending force, large-arc bending and developed length
- Angle correction data base, multi-nation selection and shaft movement with hand wheel
- Date back-up and recovery, supporting user special application.

DA-66T / 荷兰DELEM公司

- 2D触摸式图形编程
- 3D产品图形模拟显示
- 17” 高分辨率TFT真彩显示
- 完整的Windows应用程序包
- 兼容Delem 模块化结构系统
- USB,外设接口
- 多任务环境下用户程序应用
- 角度检测传感器接口

- 2D graphical touch screen programming mode
- 3D visualization in simulation and production
- 17” high resolution color TFT
- Full Windows application suite
- Delem Modusys compatibility (module scalability and adaptively)
- USB, peripheral interfacing
- Open system architecture
- Sensor bending &correction interface

DA-69T / 荷兰DELEM公司

- 2D和3D触摸式图形编程
- 3D产品图形模拟显示
- 17” 高分辨率TFT真彩显示
- 完整的Windows应用程序包
- 兼容Delem 模块化结构系统
- USB,外设接口
- 多任务环境下用户程序应用
- 角度检测传感器接口

- 2D and 3D graphical touch screen programming mode
- 3D visualization in simulation and production
- 17” high resolution color TFT
- Full Windows application suite
- Delem Modusys compatibility (module scalability and adaptively)
- USB, peripheral interfacing
- Open system architecture
- Sensor bending &correction interface

S540 / 意大利ESA公司

- 液晶彩显10.2"TFT SVGA抗辐射
- 交互式2D图形编辑和模具输入
- 3D显示工件，模具和机床框架
- 手动2D图形用于设置最佳的折弯步序
- 类似WINDOWS的操作方式，以制表方式编程程轴的位置，操作简单，自动检查，计算R轴X轴及折弯吨位
- 预设标准PC键盘（选配）
- 用户自定义报警功能

- 10.2” TFT SVGA color display with antiglare screen
- Interactive 2D graphic editor for work-pieces and tools data entry
- 2D graphic display of machine frame, work-piece and tools
- Manual 2D graphic identification of the best bending sequence
- Programming of the axes positions in tabular mode with automatic syntactical checks, automatic calculation of the R,Z and A positions and of the bending and crowning tonnage Windows like user interface
- Preset for standard PC keyboard
- Customizable alarm messages

S525 / 意大利ESA公司

- 单色5.7"LCD显示器（320x240像素）
- 实时自动检查的填表式编程模式，自动计算折弯以及补偿力
- 所有的程序，模具，参数可以保存在本机内存或U盘
- 提供控制轴及其它辅助功能的编程功能
- 控制三个轴

- Graphic monochrome 5.7" LCD display(320x240 pixels resolution)
- Programming of the axes positions in tabular mode with automatic syntacical checks, automatic calculation of the bending and crowning tonnage
- All programs, tools desciption, parameters can be stored on the intemal memory or on USB memory stick. These files can be exchanged with other CNC and PC trough USB memory stick
- Selectable and programmable axes and auxiliary functions
- Control 3 axes

2WC67K 系列

双机联动液压板料数控折弯机

2-WC67K Series Hydraulic Plate CNC Press Brake In Tandem

性能与特点 >

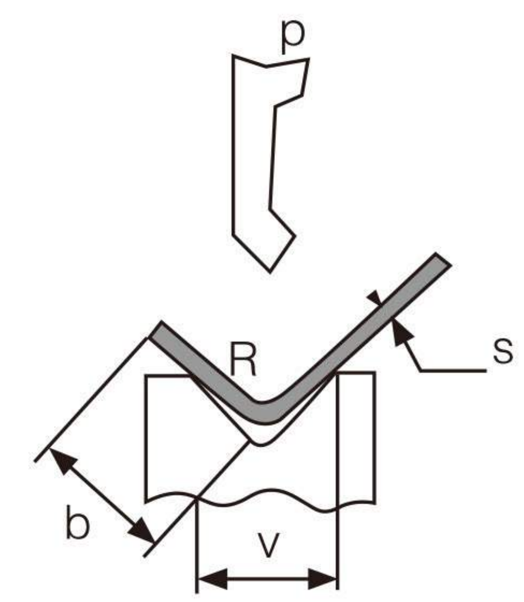
Performance and Features

- 选用两台WC67K同规格主机，配置双机联动同步装置；
- 两台机床联动可加工特长工件；
- 两台机床还可以同时单独使用，提高生产效率，配有挠度补偿机构；
- 同步机构采用电液伺服或机械挡块；上滑块行程和后挡料架位置采用机动快速调节，手动微调，电子数控显示。

- Two WC67K series in same specification are chosen as main machine with double motor linkage synchro device.
- which may work together to process overlong workpiece or operate separately to increase production efficiency.
- Defection compensation device is fitted,too.Mechanic and fluid servos with mechanic ram are utilized in synchronous device.
- The stroke of upper ram and the position of rear apiate support carritrpron are re-gulated quickly by machine and micro-regulated by hand with electronic NC display.

机床型号 type	公称压力 Nominal force	工作台长度 Worktable length	立柱间距 Poles distance	喉口深度 Throat depth	滑块行程 Ram Strokes	行程调节 adjustment capacity	最大开启高度 Max open	行程次数 Strokes	主电机功率 Power
	(KN)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(min^{-1})	(Kw)
100/3200	2×1000	2×3200	2550	320	120	100	375	≥10	7.5
100/4000	2×1000	2×4000	3350	320	120	100	375	≥10	7.5
160/4000	2×1600	2×4000	3140	350	200	150	470	≥8	11
200/4000	2×2000	2×4000	3140	350	200	150	470	≥8	15
250/3200	2×2500	2×3200	2540	400	250	180	530	≥6	18.5
250/4000	2×2500	2×4000	3100	400	250	180	530	≥6	18.5
250/5000	2×2500	2×5000	4000	400	250	180	530	≥6	18.5
250/6000	2×2500	2×6000	5000	400	250	180	530	≥6	18.5
300/5000	2×3000	2×5000	3900	400	250	180	535	≥5	22
300/6000	2×3000	2×6000	4900	400	250	180	535	≥5	22
00/7000	2×4000	2×7000	5800	450	300	220	630	≥4	30
500/6000	2×5000	2×6000	4900	450	300	220	650	≥4	37

Sample parameters are subject to change without prior notice! 样本参数如有更改恕不另行通知!



$P=650S^2L/V(\sigma_b=450N/mm^2)$
P=折弯力（千牛）
S–板厚（毫米）
L–板宽(米)
V–下模槽口宽（毫米）

P:Bending force(KN)
S:The thickness of the plate(mm)
L:The width of the plate(m)
V:V–width of the bottom die(mm)

板料折弯力计算公式

Calcultion Formula for Plate Bending Force

	V	4	6	8	10	12	14	16	18	20	24	28	32	36	40	45	50	55	60	65	70	80	90	100	120
	B	2.8	4	5.5	7	8.5	10	11	12.5	14	17	20	22	25	28	31	35	38	42	46	49	56	63	70	85
	R	0.7	1	1.3	1.6	2	2.3	2.6	3	3.3	3.8	4.5	5	6	6.5	7	8	9	10	10.5	11	16	14	16	19
S	0.5	40	30																						
	0.6	60	40	30	30																				
	0.8		70	50	40	30																			
	1		110	80	70	60																			
	1.2			120	100	80	70	60																	
	1.5				150	120	110	90	80																
	2					220	190	170	150	130	110														
	2.5							250	220	200	170	150	130												
	3								330	290	250	210	180	160											
	3.5									400	330	290	250	220	200	180									
	4										440	370	330	290	260	230	210								
	4.5											470	410	370	330	300	270	240							
	5												510	450	400	360	330	300	270	250					
	6															520	470	430	390	360	340	300			
	8																		700	640	600	520	460	420	
	10																					810	720	650	
	12																							950	780
	14																							1300	1100

This chart is calculated according to the plate of tensile strength $\sigma_b=450N/mm^2$ and length L=1m, the force can be got according to the proportion while different kind of plate and different length to be bent.

本表数值是以材料强度$\sigma_b=450N/mm^2$及长度L=1m计算而得，不同强度得材料及长度所需得折弯力可按相应得比例计算而得。

加工工件图 >

Processing Workpiece Drawing