

## NC HYDRAULIC PRESS BRAKE

### STANDARD ACCESSORIES (NC Control Torsion Synchronization Press Brake Machine)

- SWISS CYBELEC DNC60 Controller (Special System For Press Brake) to control axis Y (For RAM) and axis X (For Back Gauge) with two manually displaceable finger stops.
- JAPAN PANASONIC High efficiency AC servo motor and servo drives.
- NC Back gauge with - HIWIN Ball Screw, manually adjustable back gauge head for Axis 'R' (vertical movement of back gauge heads) and Axis 'Z' (cross movement of back gauge heads)

REST ALL STANDARD ACCESSORIES ARE SAME AS PER THE CONVENTIONAL HYDRAULIC PRESS BRAKE MACHINE

### OPTIONAL ACCESSORIES:-

- CYBELEC CONTROLLER MODEL DNC 880 SYSTEM or CYBELEC MODEVA SYSTEM
- CNC R Axis control
- CNC Z1 / Z2 Axis Control (With CYBELEC DNC 880 SYSTEM)

REST ALL OPTIONAL ACCESSORIES ARE SAME AS PER THE CONVENTIONAL HYDRAULIC PRESS BRAKE MACHINE

### STANDARD ACCESSORIES (CNC Control Electric – Hydraulic Synchronization Press Brake)

- Standard Four Axis control (Y1 – Y2 – X – V)
- Hydraulic Electric Synchronisation
- SWISS CYBELEC DNC600 Controller (Special System For Press Brake)
- BOSCH / HORBIGER High Performance Electric Hydraulic Synchronization Proportional System.
- ITALY GIVI Press Brake Special Light Encoded Gauge
- JAPAN PANASONIC High efficiency AC servo motor and servo drives
- Germany B & S seals
- BOSCH / HORBIGER Gear Pump
- GERMANY – REXROTH Line Guide
- CNC Back gauge with - HIWIN Ball Screw
- Standard Front Sheet Support Arm of 500mm length
- Pair of Die Lifting links
- One suitable multi – V Die and Universal Upper Blade (Segmented or full length) Hardened and Ground fitted on the machine
- Lower Table Hydraulic Crowning Structure ensures accuracy and uniform bend throughout the length of the work piece.
- THE AUTOMATIC PROPORTIONAL CROWNING DEVICE IS ENTIRELY MANAGED BY CNC.
- Rear and Side Guard Doors

**DNC60 CYBELEC SWISS CONTROLLER**  
Standard-characteristics

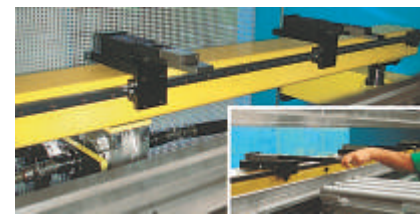
- Controls 1 – 4 Axis
- Keyboard with large keys.
- Monochrome graphic LCD screen 75 x 130 mm
- 240 x 128 pixels with automatic contrast correction.
- Internal SRAM memory.
- N2X axes with high speed counting (250 KHz) with PID regulator and programmable resolution.
- Conversion Inch/mm, TON/TONS, etc.

**DNC600 CYBELEC SWISS CONTROLLER**  
Standard-characteristics

- Controls 1 – 6 Axis (Y1-Y2-X-R-V)
- Automatically Calculating BDC
- 9" Monochrome graphic LCD screen
- Automatically Calculating Pressure
- Internal SRAM memory.
- N2X axes with high speed counting (250 KHz) with PID regulator and programmable resolution.
- Automatic Crowning

### BACK GAUGE

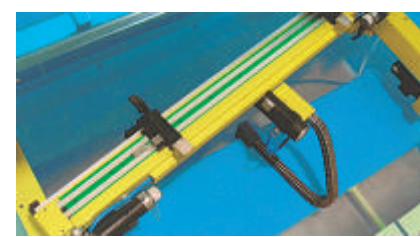
The back gauge is controlled through axes by the numerical control. It is available in a variety of models, according to customer's specific needs.



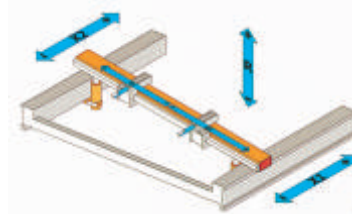
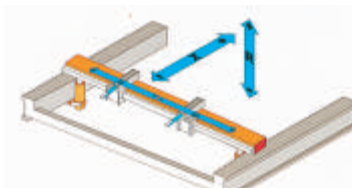
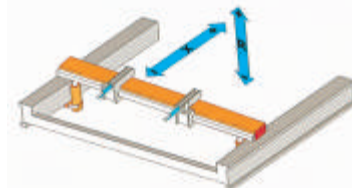
Back gauge mod. RPL with 2 axes (XR) with frontal movement of back gauge fingers.



Back gauge mod. RPL with 4 axes (X Z1 Z2) with movement of back gauge fingers controlled by CNC.



Back gauge mod. RPL with 5 axes (Z1 Z2 X1 X2) with inclination of the bar holding the fingers controlled by CNC and possibility of making conical bends.



## CNC HYDRAULIC PRESS BRAKE

### MAIN PARAMETER OF CNC PSH ELECTRIC-HYDRAULIC SYNCHRONIZATION PRESS BRAKE MACHINE

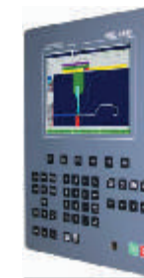
Model 'BPBC' Series	Nominal Pressure (kn)	Max Working Length (mm)	Distance Between Uprights (mm)	Open Height (mm)	Throat Depth (mm)	Stroke (mm)	Worktable Height (mm)	Main Motor (kw)	Hydraulic oil flow rate (L)	Speed (mm/s)			Dimensions (mm)			weight (kw)
										Approach	Working	Return	L	W	H	
40/1500	400	1500	1200	380	280	160	800	4	145	80	10	100	1700	1400	2200	3500
50/2000	500	2000	1700	420	300	160	820	4	170	80	8	100	2200	1500	2350	4200
63/2500	630	2500	2050	420	300	160	850	5.5	240	80	10	90	2700	1600	2450	6000
63/3200	630	3200	2700	420	300	160	850	5.5	300	80	10	90	3300	1600	2650	6600
80/2550	800	2550	2100	420	300	160	850	7.5	240	80	10	80	2700	1700	2500	7200
80/3250	800	3200	2700	420	300	160	850	7.5	300	80	10	80	3300	1700	2650	7750
100/2500	1000	2500	2050	480	350	200	900	7.5	350	100	8.5	80	2700	1800	2650	8300
100/3200	1000	3200	2700	480	350	200	900	7.5	440	100	8.5	80	3300	1800	2700	9500
100/4100	1000	4100	3600	480	350	200	900	7.5	600	100	8.5	80	4300	1800	2800	11500
100/5100	1000	5100	4600	480	350	200	800	7.5	700	100	8.5	80	5300	1800	2980	14400
125/2500	1250	2500	2050	480	350	200	900	7.5	350	100	7.5	80	2700	1800	2650	8820
125/3200	1250	3200	2700	480	350	200	900	7.5	440	100	7.5	80	3300	1800	2700	10600
125/4100	1250	4100	3600	480	350	200	900	7.5	600	100	7.5	80	4300	1800	2800	12400
125/5100	1250	5100	4600	480	350	200	900	7.5	700	100	7.5	80	5300	1800	2980	15700
160/2500	1600	2500	2050	480	350	200	900	11	350	100	8.5	80	2700	1800	2650	9650
160/3200	1600	3200	2700	480	350	200	900	11	440	100	8.5	80	3300	1800	2700	11800
160/4100	1600	4100	3600	480	350	200	900	11	600	100	8.5	80	4300	1800	2800	13800
160/5100	1600	5100	4600	480	350	200	800	11	700	100	8.5	80	5300	1800	2980	17620
160/6200	1600	6200	5600	480	350	200	800	11	700	100	8.5	80	6400	1800	3230	21200
200/2500	2000	2500	2050	520	400	240	910	18.5	525	100	10	110	2700	2000	2820	10220
200/3200	2000	3200	2700	520	400	240	910	18.5	700	100	10	110	3300	2000	2900	14000
200/4100	2000	4100	3600	520	400	240	910	18.5	930	100	10	110	4300	2000	2950	15000
200/5100	2000	5100	4600	520	400	240	800	18.5	1000	100	10	110	5300	2000	3200	20520
200/6100	2000	6100	5600	520	400	240	800	18.5	1000	100	10	110	6300	2000	3350	25100
250/2500	2500	2500	2050	520	400	240	950	18.5	525	100	8.5	95	2700	2000	2850	12850
250/3200	2500	3200	2700	520	400	240	950	18.5	700	100	8.5	95	3300	2000	2920	15000
250/4100	2500	4100	3600	520	400	240	950	18.5	930	100	8.5	95	4300	2000	2980	18000
250/5100	2500	5100	4600	520	400	240	800	18.5	1000	100	8.5	95	5300	2000	3200	25030
250/6100	2500	6100	5600	520	400	240	800	18.5	1000	100	8.5	95	6300	2000	3350	30000
320/3200	3200	3200	2700	520	400	300	1030	22	700	100	7.2	100	3300	2100	3150	19800
320/4100	3200	4100	3600	520	400	300	1030	22	930	100	7.2	100	4300	2100	3200	22800
320/5100	3200	5100	4600	520	400	300	800	22	1000	100	7.2	100	5300	2100	3450	28600
320/5200	3200	6200	5600	520	400	300	800	22	1000	100	7.2	100	6400	2100	3800	33600

### OPTIONAL ACCESSORIES CNC PRESS BRAKE:-

- CYBELEC CONTROLLER MODEL DNC 880 SYSTEM or CYBELEC MODEVA SYSTEM
- CNC R Axis control
- CNC Z1 / Z2 Axis Control (With CYBELEC DNC 880 SYSTEM)
- Hydraulic Tool Clamping
- Sliding Sheet Supports with swing away stoppers
- CE Marking
- Laser Safe Finger Protection
- Light Curtain
- Oil Cooler
- Photo Electric Fingers Safety Guard
- Automatic Lubrication System
- Vibration Control Mounting Pads
- First Fill of Hydraulic Oil
- Light encode to detect RAM position

#### The Windows XP Embedded numerical control DNC 880S

- It has 10-inch TFT colour screen,
- It has a simplified keyboard with large keys
- The bending solutions are displayed graphically in 2D and indicate possible collisions with the tools or the machine frame.
- The DNC 880S manages the hydraulic crowning system and pressure proportional valve, calculates the bend allowance, and proposes a simple page to program in seconds a part.



#### The Windows XP Embedded CYBELEC MODEVA 12S

- It has 10-inch TFT colour screen,
- It has a simplified keyboard with large keys
- The bending solutions are displayed graphically in 3D and indicate possible collisions with the tools or the machine frame.
- The MODEVA 12S manages the hydraulic crowning system and pressure proportional valve, calculates the bend allowance, and proposes a simple page to program in seconds a part.
- Maximum 20 DNC Axis

**B A J A J Machinery Corporation**

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# HYDRAULIC PRESS BRAKE



**B A J A J**  
Machinery Corporation

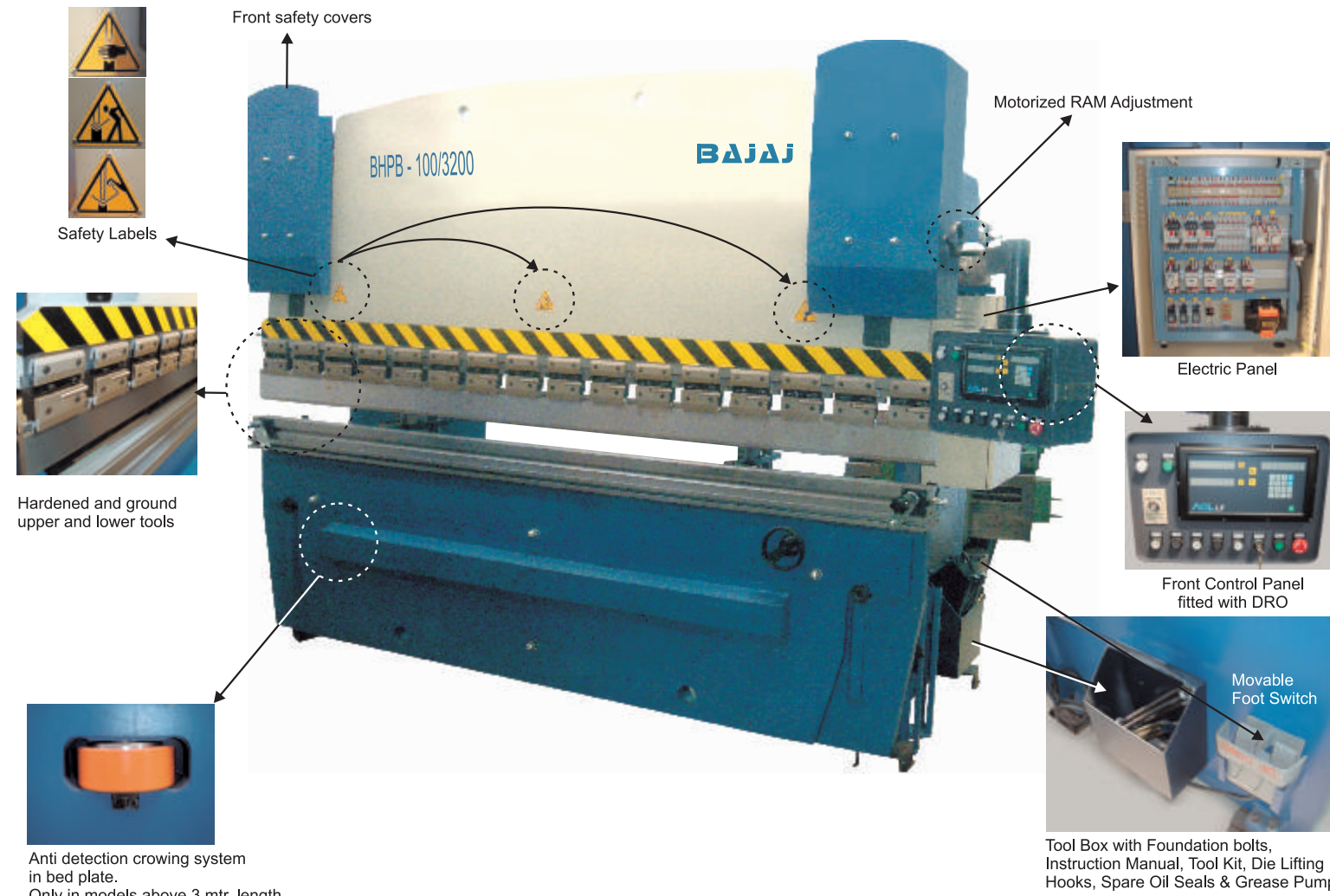


### SALIENT FEATURES OF CONVENTIONAL AND NC - PRESS BRAKE MACHINE

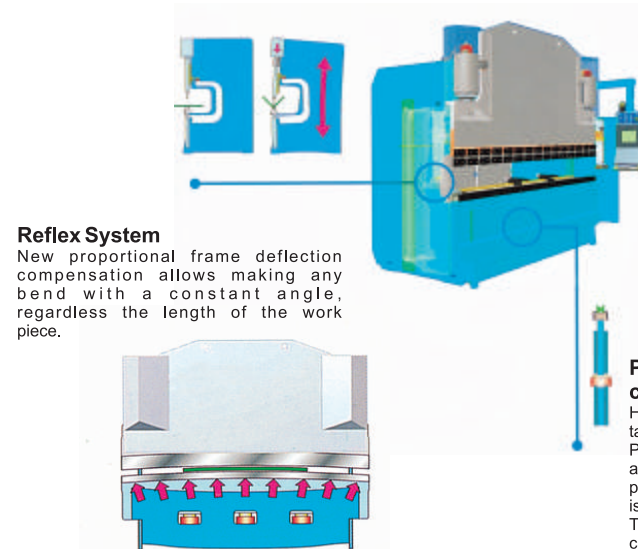
1. Rigidly Welded, Mono Block steel frame for minimum deflection under full load.
2. Solid torsion bar linkage for RAM parallelism and accuracy.
3. Three cycles of operation INCH - SINGLE - CONTINUOUS for greater convenience and maximum output.
4. Precision RAM Control and Accurate BACK GAUGE Position - The High precision Linear encoder's are mounted on the Back Gauge as well as on the top of the RAM Plate. These encoders takes RAM Position and Back Gauge Movement readings and feeds them to the DRO (In Conventional Machines) and Controllers (In NC Machines).
5. Noiseless operation and least impact loads on tools and foundations.
6. International Quality Hydraulic Components with specially designed compact manifolds gives smooth, silent and jerk less operation.
7. International Quality branded electrical components ensures trouble free operation over a period of time.
8. Movable foot switch to operate the machine from convenient positions.
9. Pre - Set, 2 speed bending cycle giving fast approach, slow bending and fast return, resulting in reducing idle travel time and improving productivity.
10. Cylinders from high quality forged steel and are precisely honed. Pistons are hard chromed for longer life.

### MAIN PARAMETER OF TORSION SYNCHRONIZATION CONVENTIONAL & NC PRESS BRAKE MACHINE

Model 'BHPB' SERIES	Nominal Pressure (kn)	Max Working Length (mm)	Distance Between Uprights (mm)	Open Height (mm)	Throat Depth (mm)	Stroke (mm)	Stroke adjustment (mm)	Worktable Height (mm)	Main Motor (kw)	Hydraulic oil flow rate (L)	Speed (mm/s)			Dimensions (mm)				weight (kg)
											Approach	Working	Return	L	W	H		
40/1500	400	1500	1200	365	220	120	70	720	4	120	60	9.5	60	1750	1165	2110	2850	
40/2200	400	2200	1700	365	220	120	70	720	4	170	60	9.5	60	2300	1165	2110	3350	
50/2500	500	2500	2000	375	220	120	70	720	4	200	60	9.5	60	2600	1165	2110	3650	
63/2500	630	2500	2000	385	250	120	70	780	5.5	200	60	9.5	60	2600	1210	2185	4300	
63/3200	630	3200	2700	385	250	120	70	780	5.5	280	60	8.5	60	3300	1210	2185	5280	
80/2500	800	2500	2000	385	320	120	70	800	5.5	200	60	8.5	80	2600	1385	2225	4680	
80/3200	800	3200	2700	385	320	120	70	800	5.5	280	60	8.5	80	3300	1385	2225	5600	
100/2500	1000	2500	2000	430	350	160	70	850	7.5	400	80	9	70	2600	1565	2500	6800	
100/3200	1000	3200	2700	430	350	160	70	850	7.5	480	80	9	70	3300	1565	2500	7800	
100/4100	1000	4100	3300	430	350	160	70	850	7.5	580	80	9	70	4200	1565	2500	9000	
100/2500D	1000	2500	2000	390	350	160	70	900	7.5	400	80	9	70	2600	1565	2490	7300	
100/3200D	1000	3200	2700	390	350	160	70	900	7.5	480	80	9	70	3300	1565	2490	8500	
100/4100D	1000	4100	3300	390	350	160	70	900	7.5	580	80	9	70	4200	1565	2490	9300	
100/5100D	1000	5100	4400	390	350	160	70	950	7.5	580	80	9	70	5200	1600	2600	12500	
125/2500	1250	2500	2000	390	350	160	70	900	11	400	80	7	70	2600	1660	2500	7800	
125/3200	1250	3200	2700	390	350	160	70	900	11	480	80	7	70	3300	1660	2500	9000	
125/4100	1250	4100	3300	390	350	160	70	900	11	580	80	7	70	4200	1660	2500	10500	
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200/5100	2000	5100	4600	450	400	200	100	990	15	580	80	7	85	5200	1940	2890	20500	
200/6100	2000	6100	5400	450	400	200	100	1050	15	580	80	7	85	6200	1940	3030	24000	
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320/5100	3200	5100	4500	520	400	250	150	1050	22	620	80	9	60	5300	2150	3500	29500	
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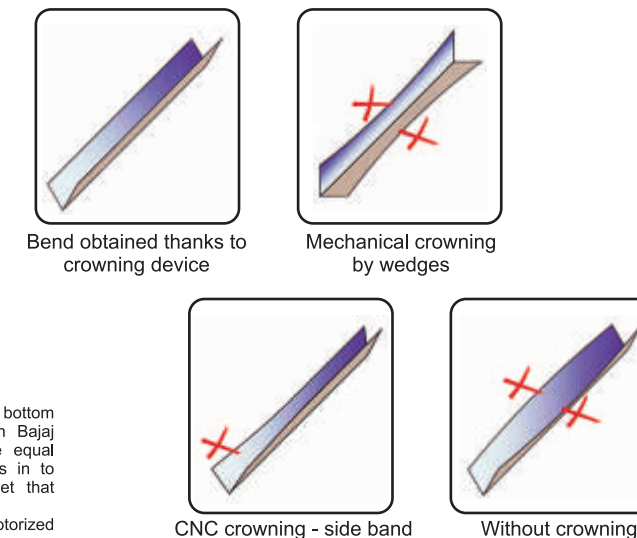


### Crowning System



**Proportional crowning device**  
Hydraulic Crowning system on the bottom table is a standard equipment on Bajaj Press Brake Machines to provide equal angle in the whole length. It goes in to position in proportion to the sheet that is being processed. There is also CNC controlled motorized crowning as an optional equipment.

### Typical aspect of products after bending



### STANDARD ACCESSORIES (Conventional Hydraulic Press Brake Machine)

- Electrical control panel with selection of 'AUTO', 'INCH' and 'SINGLE CYCLEAUTO' mode of operation
- All Hydraulics are of Standard Make Rexroth or Bosch
- All Electric components are from Siemens or Sneider - France
- Motorized Back Gauge and Motorized Ram Adjustment fitted with DRO.
- Back Gauge Having Two Finger Stops which can move Leftward / Rightward and Upward / Downward Manually
- American Parker Oil Seals
- Fine stroke adjustment rod with limit switches
- One suitable multi - V Die and Universal Upper Blade (Segmented) Hardened and Ground fitted on the machine [Not covered under guarantee]
- Lower Table Hydraulic Crowning Structure ensures accuracy and uniform bend throughout the length of the work piece. (AVAILABLE IN MACHINES WITH LENGTH 3 Mtrs. AND ABOVE AND THICKNESS MORE THAN 4MM)
- Pair of front sheet supports 500mm length
- Movable Foot Switch to operate the machine from convenient positions.
- Pair of Die Lifting links
- Bending Chart on machine.
- Maintenance Tool Kit
- Comprehensive Instruction, Operational and Maintenance Manual in English
- Extra Depth of Throat
- Foundation Bolts
- One Set of Spare Oil Seal are provided alongwith the machine as Standard Accessory.

### OPTIONAL ACCESSORIES (Conventional Hydraulic Press Brake Machine)

- Ball Screw Back Gauge
- Hydraulic Tool Clamping
- NC Control Back Gauge
- NC Controller for Z and R - axis
- Sliding Sheet Supports with swing away stoppers
- CE Marking
- Rear and Side Guard Doors
- Laser Safe Finger Protection
- Light Curtain
- Oil Cooler
- Photo Electric Fingers Safety Guard
- Automatic Lubrication System
- Vibration Control Mounting Pads
- First Fill of Hydraulic Oil
- Light encode to detect RAM position

