

SERIES CNC ELECTRO-HYDRAULIC SERVO PRESS BRAKE : WC67



WC67

Series hydraulic multi-cylinder press brake

Product introduction

- On the base of the original bending machine, the machine adds a compensating cylinder in the middle of the sliding block, and compensates the central part of bending machine to solve the problem that the central Angle is not place.it is very effective to improve the straightness of the workpiece and reduce the deformation caused by long time use.
- This machine is specially designed for stainless steel processing, door industry, etc., and is highly recognized by users.



Servo Moter and Driver

Servo cylinder



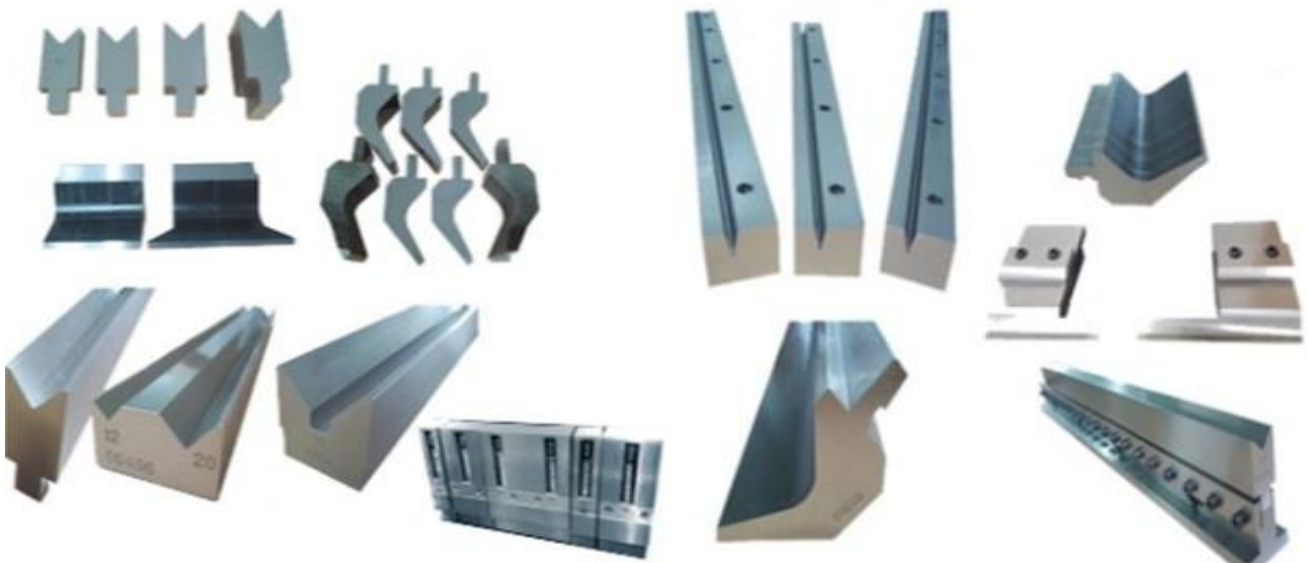
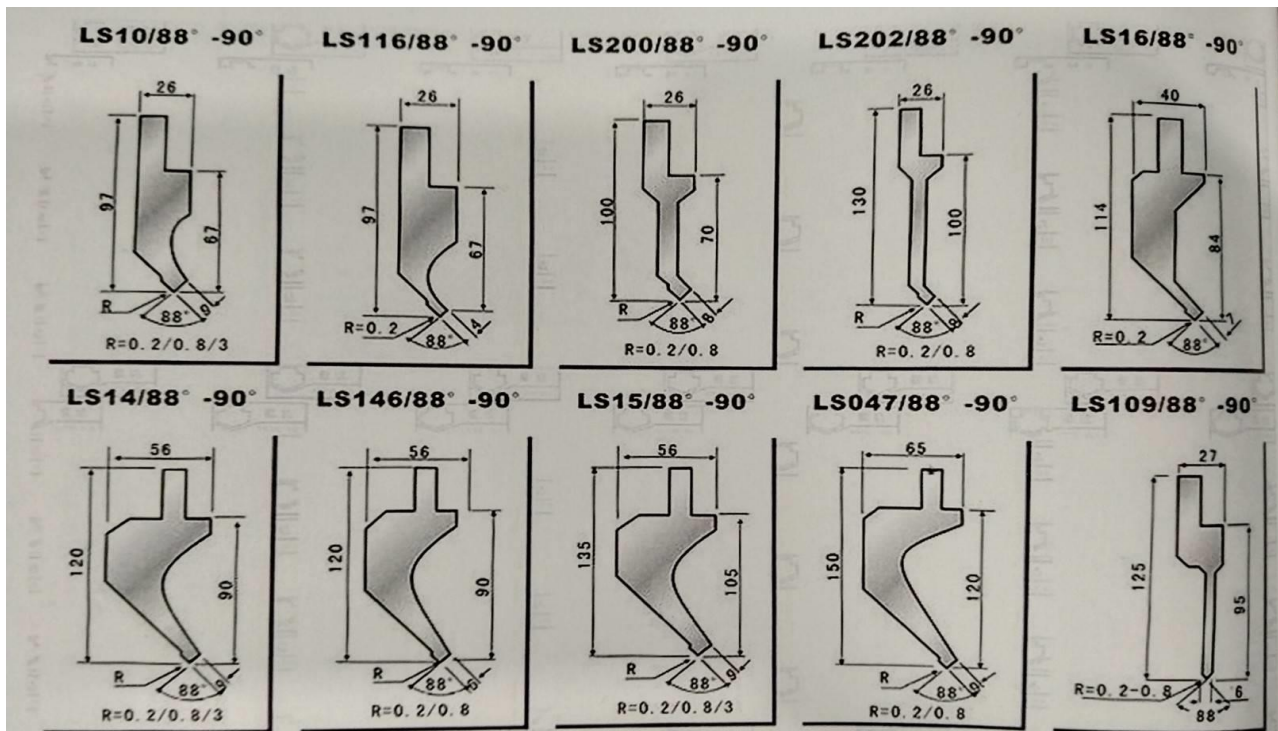
Imported sealing ring

Die fast clip



Schneider Electric

BENDING MACHINE MOULD



Processing Workpiece Drawing

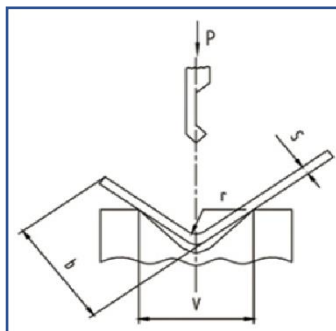


Plate bending strength table

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	28	35	38	42	46	49	56	63	70	85
S	0.7	1	1.3	1.6	2	2.3	2.6	3	3.3	3.8	4.5	5	6	6.5	6.5	8	9	10	10.5	11	13	14	16	19
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											
4										440	370	330	290	200	230	210								
4.5											470	410	370	260	300	270	240							
5												510	450	330	360	330	300	270	250					
6			$Q = 450\text{N/mm}^2$ $L = 1\text{m}$												400	520	470	430	390	360	340	300		
8																		700	640	600	520	460	420	
10																					810	720	650	
12																							950	780
14																							1300	1100

Bending strength formula

$$P=650S^2 L/V(Q_b = 450\text{N/mm}^2)$$



P – Bending force (KN)

S – Thickness of the plate (mm)

L – Width of the plate (m)

V – Opening of the bottom (mm)

note: No special requirement such as the R angle select lower die width V , shall be taken as the processed sheet thickness S of 8 to 10 times.

Press brake CNC system



E21

E21 : LCD Display, 240x128;

- Multi-step programming, program automatic operation, continuous positioning;
- Automatic regress to avoid the interference of backstop and workpiece;
- One-way positioning to eliminate the gap of screw drive;
- Inch/mm selection;
- Position compensation;
- Power failure, memory function;



DA41

DA41 : High resolution LCD display;

- Block stop position control;
- Backstop control;
- Angle programming;
- Mold parameter setting;
- Nesting control function;
- 100 programs;
- Each program has 25 steps;



DA52S

DA52S : One page of parametric programming;

- 6.4" LCD real color TF display
- Working table deflection compensation control;
- Mold library;
- The second axis control is optional;
- USB interface;
- The advanced Y-axis control algorithm can control the closed loop valve and open loop valve;
- Servo control, frequency conversion control and AC control are optional;
- Panel structure;

**DA56S****DA56S : 2D programming;**

- 10.4"LCD TFT color display;
- Bending process will be told;
- Length calculation;
- Compensation for deformation of worktable;
- USB interface;
- Servo control. Frequency conversion control and AC motor control

**DA66T****DA66T :2D touch graphic programming;**

- 3D products simulation display;
- 17" high resolution TFT real color display;
- Full Windows application;
- Compatible with DELEM modular structure;
- USB peripheral interface;
- User program application in multi-task environment;
- Angle detection sensor interface;

**DA69T****DA69T : 2D/3D graphics programming**

- 3D graphics display;
- 12" TFT real color display;
- Touch screen;
- Integrated operation panel;
- Integrated standard USB floppy drive;
- USB keyboard and mouse interface;
- Support user professional application in multi-task environment;
- Angle calibration sensor interface.

BENDING TECHINCAL PARAMETERS : WC67Y/WC67K

MODEL	NOMINAL PRESSURE/KN	LENGTH OF WORKING TABLE/MM.	DISTANCE BETWEEN UPRIGHTS/MM.	THROAT DEPTH	RAM STROKE	MOTOR POWER
40T/2000	400	2000	1700	245	100	4
40T/2200	400	2200	1800	245	100	4
40T/2500	400	2500	1900	245	100	4
63T/2500	630	2500	1900	250	120	5.5
63T/3200	630	3200	2500	250	120	5.5
80T/3200	800	3200	2500	320	120	7.5
80T/4000	800	4000	3000	320	120	7.5
100T/2500	1000	2500	1900	400	120	7.5
100T/3200	1000	3200	2500	400	120	7.5
100T/4000	1000	4000	3000	400	120	7.5
100T/5000	1000	5000	4000	400	120	7.5
125T/2500	1250	2500	1900	400	120	7.5
125T/3200	1250	3200	2500	400	120	7.5
125T/4000	1250	4000	3000	400	120	7.5
125T/5000	1250	5000	4000	400	120	7.5
160T/3200	1600	3200	2500	400	200	11
160T/4000	1600	4000	3000	400	200	11
160T/5000	1600	5000	4000	400	200	15
160T/6000	1600	6000	4800	400	200	15
200T/3200	2000	3200	2500	400	200	15
200T/4000	2000	4000	3000	400	200	15
200T/5000	2000	5000	4000	400	200	15
200T/6000	2000	6000	4800	400	200	18.5
250T/3200	2500	3200	2500	400	250	18.5
250T/4000	2500	4000	3000	400	250	18.5
250T/5000	2500	5000	4000	400	250	18.5
300T/4000	3000	4000	3000	400	250	22
300T/5000	3000	5000	4000	400	250	22
300T/6000	3000	6000	4800	400	250	22
400T/5000	4000	5000	4000	400	250	30
400T/6000	4000	6000	4800	400	250	30
500T/6000	5000	6000	4800	400	300	37
500T/1200	5000	1200	-	400	300	37
600T/7000	6000	7000	5600	400	300	45
700T/7000	7000	7000	5600	400	300	55
800T/6000	8000	6000	4800	400	400	2X37
1000T/6000	10000	6000	4800	400	500	2X45



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