

# Hydraulic press brake type APHS

Best  
Quality



APHS 3110x200

Easy-to-use CNC system with complete bending computations and large tool library ideal for multi-bending of complex forms, as well as for volume production which require constant repeatability.

Bend accuracy and repeatability at least five-fold higher than a conventional press brake. Fully synchronised Y1-Y2 axes to  $\pm 0.01\text{mm}$  via proportional valves and precision linear scales. Very fast AC servo backgauge system controlled by CNC.

Euro-style top clamps with intermediaries and (available) quick-release clamping. Top tool is sectionalised gooseneck punch and bottom tool is sectionalised 4-V die. High stroke and daylight values. Extra deep (410 / 500 mm) throat gap.

Two front arms on linear rail and dual footswitch console with emergency stop. Swiveling pendant arm and side / rear safety gates (electrically interlocked and/or light or laser guarded).

Compactly-wired PLC electrics in ventilated cabinet. Type APHS are constructed with rigidly welded, monoblock machine frame for minimum deflection under load. Ram travel fully supported in low friction slideways.

Options for tooling and crowning.

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## CNC operating features

- CNC control Cybtouch 12PS
- Automatic identification of the best bend sequence numerically with collision detection
- 2D graphic editor for tool data entry
- Programming of the axis positions with automatic checks; automatic calculation of the R-axis position, bending tonnage and crowning
- High memory capacity for program steps and tooling data, capacity for 7000 programs and 80-steps in each program, high product number and 99 repeats of each program step
- FREE 2D graphical programming software to work off-line to create graphical bending files which can be transferred to the controller by USB flash disc

Product programming with direct angle input or in absolute dimensions. For each CNC program, the programmable and/or computed functions include : bending length/thickness, material selection, tooling selection, bend method, mute position, pinching point, press force/speed, incremental travel and retraction of backgauge, dwell time, delay time for axes repositioning, decompression speed, tilt adjustment, correction on Y and X axes.

- Manual operation of backgauge axes
- 16 selectable languages
- Memory storage on USB flash disk: information for tooling and programs

## Backgauge:

### (A) X-axes backgauge:

- Travel on ballscrew
- AC-servo driven
- With 2 micrometric finger-stops which have height and lateral adjustment
- Range : 750 mm
- Speed : 330 mm/s
- Positioning precision :  $\pm 0.03$  mm



X-axis backgauge



X+R-axes backgauge

### (B) X-R axes backgauge:

- Travel on ballscrew
- AC-servo driven
- With 2 micrometric finger-stops which have lateral adjustment
- **Range**  
X-axis : 750 mm  
R-axis : 160 mm
- **Travel speed (max)**  
X-axis : 350 mm/s  
R-axis : 240 mm/s
- **Positioning precision**  
X-axis :  $\pm 0.03$  mm  
R-axis :  $\pm 0.05$  mm



X-axis backgauge



X+R-axes backgauge

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Quick release Clamping



Motorised crowning



Tools



Manual crowning



Laser protection



CybTouch 12PS



Delem DA 53



Delem DA 58T



ESA S640 Touch

Art. no	Type	Cap.	Working length	Stroke	Daylight	Gap	Dist. btw. frames	Oil tank	Speed	Rapid traverse	Motor	Weight
	APHS	kN	mm	mm	mm	mm	mm	L	mm/s	mm/s	kw	kg
23300	1254x40	400	1250	215	455	410	1070	80	10	160	4	3300
23302	2104x60	600	2100	210	475	410	1600	140	10	150	5,5	5400
23304	2604x60	600	2600	210	475	410	2050	140	10	160	5,5	6200
23306	2606x90	900	2600	260	530	410	2050	140	10	150	7,5	7100
23308	3104x90	900	3100	260	530	410	2550	140	10	160	7,5	7900
23310	3106x120	1200	3100	260	530	410	2550	140	10	160	11	8400
23312	3108x160	1600	3100	260	530	410	2550	210	10	160	15	9700
23314	3110x200	2000	3100	260	530	410	2550	210	10	150	18,5	10000
23316	3112x240	2400	3100	260	530	410	2550	210	10	130	22	11000
23318	3116x300	3000	3100	320	660	500	2550	280	8	110	22	15000
23330	4106x160	1600	4100	260	530	410	3550	210	10	170	15	12000
23332	4108x200	2000	4100	260	530	410	3550	210	10	160	18,5	12500
23334	4110x240	2400	4100	260	530	410	3550	210	10	150	22	14000
23336	4112x300	3000	4100	320	635	500	3550	280	0	120	22	18500