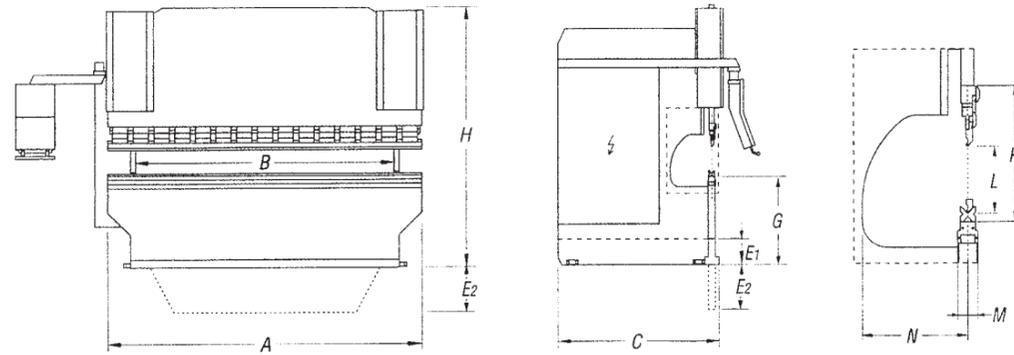




TECHNICAL DATA  
**APHS CNC SERVO PRESS BRAKES**

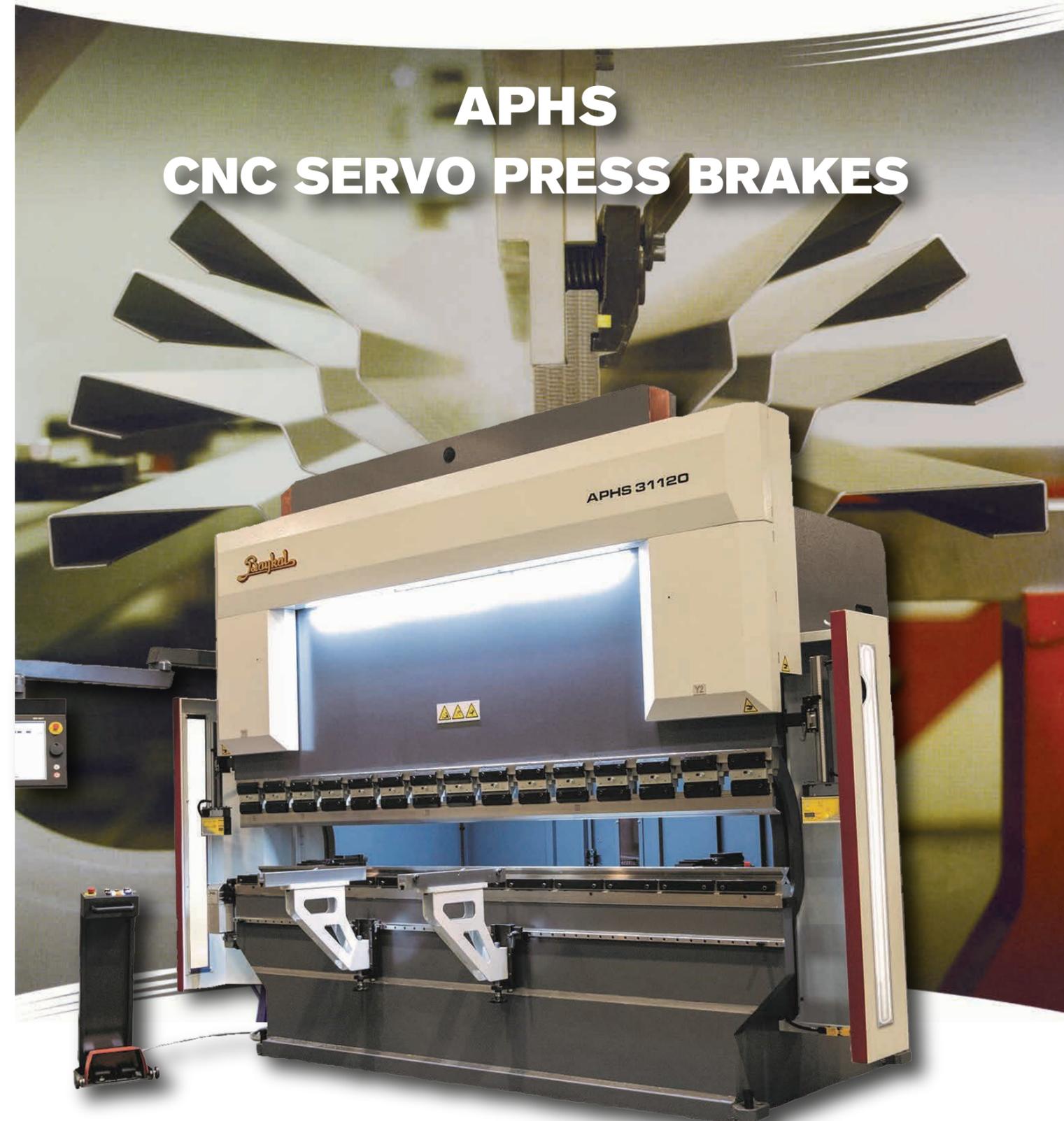


TYPES	Capacity TON	Working Length INCH	Motor Output HP	Speeds			Approx. Weight LBS	Bending Length A INCH	Inside Frames B INCH	Side Frame Width C INCH	Bed Height G INCH	Pit Depth		Machine Height H INCH	Daylight Opening K INCH	Stroke L INCH	Table Width M INCH	Throat Gap N INCH
				Inch/Min Approach	Inch/Min Working	Inch/Min Return						E1 INCH	E2 INCH					
APHS 1250 x 40	44	3'6"	5	378	24	307	5,500	49"	3'6"	58"	31"	-	-	89"	17.9"	8.4"	2.3"	16"
APHS 2104 x 60	66	5'3"	7	354	24	307	11,880	6'10"	5'3"	62"	35"	-	-	100"	18.7"	8.2"	2.3"	16"
APHS 2606 x 90	100	6'8"	10	354	24	307	15,620	8'6"	8'4"	63"	35"	-	-	103"	20.8"	10.2"	2.3"	16"
APHS 3104 x 90	100	8'4"	10	378	24	307	17,380	10'2"	8'4"	63"	35"	-	-	103"	20.8"	10.2"	2.3"	16"
APHS 3106 x 120	132	8'4"	15	378	24	307	18,480	10'2"	8'4"	63"	35"	-	-	114"	20.8"	10.2"	2.3"	16"
APHS 3108 x 160	175	8'4"	20	378	24	307	21,340	10'2"	8'4"	63"	35"	-	-	114"	20.8"	10.2"	2.3"	16"
APHS 3110 x 200	220	8'4"	25	354	24	307	22,000	10'2"	8'4"	63"	35"	-	-	114"	20.8"	10.2"	3.5"	16"
APHS 3112 x 240	265	8'4"	30	307	24	283	24,200	10'2"	8'4"	63"	35"	-	-	114"	20.8"	10.2"	3.5"	16"
APHS 3116 x 300	330	8'4"	30	260	18	236	33,000	10'2"	8'4"	71"	36"	-	-	124"	25.9"	12.5"	15"	19.6"
APHS 4106 x 160	175	11'7"	20	401	24	283	26,400	13'5"	11'7"	63"	35"	-	-	114"	20.8"	10.2"	2.3"	16"
APHS 4107 x 200	220	11'7"	25	378	24	260	27,500	13'5"	11'7"	63"	35"	-	-	114"	20.8"	10.2"	3.5"	16"
APHS 4109 x 240	265	11'7"	30	354	24	236	30,800	13'5"	11'7"	63"	35"	-	-	114"	20.8"	10.2"	3.5"	16"
APHS 4112 x 300	330	11'7"	30	283	18	212	40,700	13'5"	11'7"	72"	38"	-	-	126"	25"	12.5"	11"	19.6"
APHS 4116 x 440	480	11'7"	40	189	18	165	57,200	13'5"	11'7"	88"	43"	-	-	137"	23.2"	12.5"	15"	19.6"
APHS 6104 x 160	175	16'8"	20	330	24	236	44,000	20'	16'8"	77"	39"	-	-	112"	20"	10.2"	3.5"	19.6"
APHS 6106 x 240	265	16'8"	30	330	24	236	55,000	20'	16'8"	77"	43"	-	-	118"	19.6"	10.2"	3.5"	19.6"
APHS 6108 x 300	330	16'8"	30	283	18	165	66,000	20'	16'8"	81"	44"	-	-	129"	22"	12.5"	8"	19.6"
APHS 6110 x 380	420	16'8"	40	212	18	165	74,800	20'	16'8"	87"	43"	-	-	128"	22.4"	12.5"	9.4"	19.6"
APHS 6112 x 440	440	16'8"	40	212	18	165	85,800	20'	16'8"	88"	43"	-	-	146"	20.8"	12.5"	11"	19.6"
APHS 6114 x 500	550	16'8"	40	189	18	165	105,600	20'	16'8"	93"	32"	10"	31"	138"	20.8"	13.3"	15"	19.6"
APHS 6116 x 600	665	16'8"	50	189	16	165	121,000	20'	16'8"	94"	43"	15"	45"	161"	21"	14.1"	15"	19.6"

Design and specifications are subject to change without notice.



# APHS CNC SERVO PRESS BRAKES



**FAB-LINE MACHINERY, LLC**  
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## CNC SYSTEM

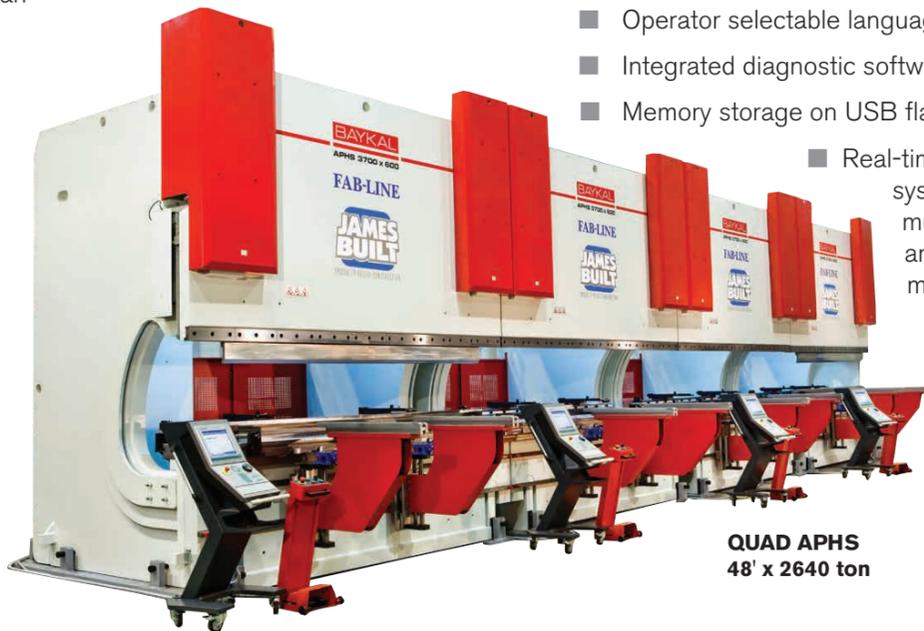
DELEM 66T graphical 17" control with full programming and machine control facilities in a user-friendly environment.  
Main features include:

- Programmable multi-axis control.
  - Y1-Y2 cylinder axes
  - X1-X2-R1-R2-Z1-Z2 backgauge axes
  - CNC crowning axis
  - Modular expansion for additional axes
- High-memory capacity for program steps and tooling data
- High number of product and bend repeat possibility
- Direct graphical programming with automatic computation of all axis positions and bend sequence in full graphic simulation
- Product programming with direct angle input or in absolute dimensions. For each CNC program and bend sequence, 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 re-positioning, decompression stroke/speed, tilt adjustment, corrections of Y axes and backgauge axes*
- Manual operation of all axes
- Teach-in on all axes
- Operator selectable languages
- Integrated diagnostic software
- Memory storage on USB flashdisk

- Real-time Windows system for multi-tasking and file management

## DESIGN AND OPERATING FEATURES

- Welded, monoblock steel frame for minimum deflection under load up to 480 tons (Models above 480 tons are bolted)
- Downstroking bending beam with two cylinders made from high-quality certified forged steel, precisely honed and chrome plated
- Ram travel fully supported in double low friction fiber slideways and a roller gib
- Full electronic synchronization with proportional valve technology assuring maximum bend accuracy and repeatability through constant monitoring and correction of beam parallelism by a CNC system +/- .0004 parallelism and repeatability
- Stroke-depth measurement through high-precision linear scales which are bed referenced for the best bending repeatability
- Controlled XR two axis backgauge
- Block-type European hydraulics
- Compact-wired electrical box with ventilation
- Full conformity with EC Machinery Directive for safety and certified CE marking
- ST44-2 or ST52-3 Certified steel used for components



QUAD APHS  
48' x 2640 ton



Delem DA-58 controller



Standard controller Delem DA-66T



Optional DA-69T graphical 3D Windows based colour controller



Optional ESA 660 3D Touchscreen controller



Backgauge system with 6 axes towers



Backgauge with X-R axes for special applications

## BACKGAUGE OPTIONS

- (A) Backgauge system with 6 axes towers:

- Travel on ballscrew spindles
- DC-motor driven
- Two mirometric stop-fingers with lateral adjustment
- Range
 

X-axis	: 39.3"
R-axis	: 6.3"
- Travel speed
 

X-axis	: 826"/min
R-axis	: 567"/min
- Positioning precision
 

X-axis	: ± .001"
R-axis	: ± .002"

- (B) Additional backgauge with X-R axes for special applications:

- X, R, Z1, Z1
- X1, X2, R, Z1, Z2
- X1, X2, R1, R2, Z1, Z2

Details of these special backgauge systems are available on request

## ACCESSORIES

### STANDARD:

- Baykal Mechanical crowning
- American/European-style top tool holders (American clamps on high tonnages)
- Starter tool package consisting of gooseneck punch and multi-vee die block
- Two-hand operation console with double foot-switch
- Front-arms on linear guides
- Electrically-interlocked side and rear guards
- 39" XR two axis Backgauge range
- Work Light

### OPTIONAL:

- Power-driven (CNC) crowning tables
- Top tool manual quick-release clamps
- Hydraulic tool clamping systems
- Programmable sheet following arms
- Special tooling for customer applications:
  - Special-profile top and bottom tools
  - Single-vee dies with table adapters
- Front light guards or front laser protection for enhanced safety
- Wide bed tops
- Open height, stroke or throat depth changes



Sheet following arms



Baykal CNC crowning



AKAS laser safety system



Hydraulic clamping systems



Manual crowning