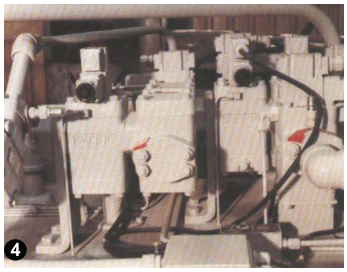
K- SERIES HYDRAULIC PRESS BRAKES

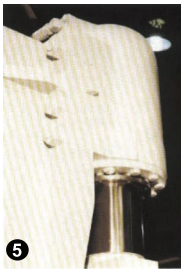
Series At-A-Glance

Key Features
- 2 cylinder design
- 100 - 3,000 tons
- 8' - 30' standard bed lengths
- Tandem designs for long part bending
- Custom tonnage and bed length configurations are available

Applications
- Medium to Heavy-Gauge Bending

The K-Series Hydraulic Press Brake offers a proven design up to the challenges of tough, continuous service. Numerous standard and optional features include CNC controls, higher-speed power units and manual or CNC-controlled heavy-duty back gauges.





Standard Features

1. Rigid, Interlocked Design assures absorption and uniform distribution of forces in capacity operations. Heavy steel plates are utilized for the ram, bed plate and extra deep side housings to resist deflection.

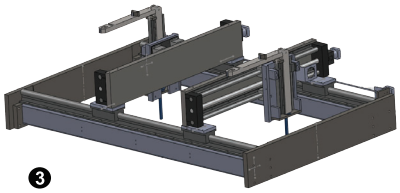
2. Pre-Crowned Beds are precisely machined for bed deflection compensation.

3. Ram Guiding System consists of heavy-duty, non-binding guides that maintain contact with extra long, hardened steel slideways through the stroke range.

4. Modular Stacked Valves are machined to provide maximum accuracy and special pressure and directional control characteristics. Valves are designed for long, rugged service with minimum maintenance.

5. Cylinder And Piston are heavy, cast single-piece domed cylinders to eliminate high stresses and potential leakage areas. Pistons and rods are one-piece, wear-resistant, Class 40 castings; bores are honed and polished to 16 micro inches.

Aditional Standard Features
- Tonnage control and non-overload relief valve system
- Automatic decompression system
- Temperature compensated amplifier level control



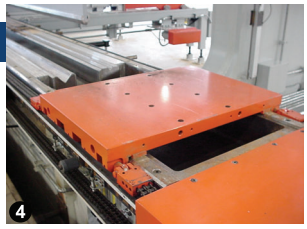
Optional Features

1. Plate cell. Optional laser bend alignment system, plate supports and electrically-driven plate positioning system eliminates the need for operators to manipulate the plate by hand.

2. Higher Speed Power Units. Three speed power units are standard on press brakes of 500 tons and higher, and are also available as an option on smaller tonnage K-Series brakes. Options include Rapid Advance (no tonnage), Fast Press (partial tonnage), and Normal Press (full tonnage) cycles.

3. Medium; Heavy-Duty Powered Backgauges. (manual and CNC-controlled models-CNC version drives X1, R and Z1&Z2 Axes.

Optional Features (Cont.)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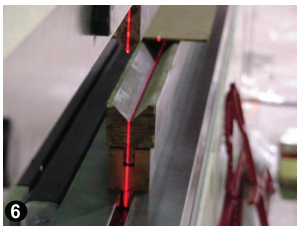
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4. Part Extractor. Electrically-driven, rigid chain extractor system moves along the lower tooling to remove a formed part that either cannot be removed from the front of the press brake or is more easily removed by sliding it out of one end of a tandem system.

5. Plate Manipulators. Hydraulically-powered, chain-driven plate manipulators installed in front and behind the press brake bed provide "hands-off" sheet manipulation. Joystick controls incorporated into two-hand controls allow operators to maneuver the sheet to the desired bend location.

6. Laser Bend Alignment (Tandem Systems). Two laser line generators — one at each end of the tandem system - project a visible line at the centerline of the installed tooling. A blank with the bend lines marked is moved into the press brake until the mark and the visible laser line are aligned and the press brake is cycled to accurately complete the bend. An optional center-mount (removable) laser line generator is available when a single press brake of the tandem system is to be used.

Other Optional Features

- Lengths up to 45' in a single press brake
- Back Travel Over-Ride
- Foot Switch
- Deeper Throats
- Increased Open Heights and Longer Strokes
- Horns
- Multiple Depth-Stops
- Oil Coolers and Heaters
- Multiple Control Stations
- Light Curtains
- Automated Centralized Lubrication Systems
- Wide Platens and Angle Brackets
- Heavy Duty Ram Inserts

Specifications

Tonnage	100	135	150	175	200	225	300	350	400	500	600	750	1000	1250	1500	1750	2000	3000
Bend Length-L (1)	8'-16'	8'-16'	8'-16'	8'-16'	8'-16'	8'-16'	8'- 18'	8'-18'	8'- 22'	10'-22'	12'-24'	12'-30'	14'-30'	16'-30'	17'-30'	20'-30'	20'-30'	24' 30'
Distance Between Housings (2)	L-19½"	L-19"	L-19"	L-19½"	L-19"	L-19"	L-18½"	L-19"	L-19½"	L-19"	L-22"	L-22"	L-22"	L-22"	L-34"	L-46"	L-46"	L-54"
Bed Height	32	32	32	32	32	32	32	32	32	32	32	32	32	32	32	32	32	20
Stroke	10	10	10	10	12	12	12	12	12	12	12	12	12	18	18	18	18	24
Open Height	15	15	15	15	17	17	20	20	20	22	22	22	22	30	30	30	30	42
Closed Height	5	5	5	5	5	5	8	8	8	10	10	10	10	12	12	12	12	18
Throat Height	10½	10	10	10½	13½	13½	15	15	15	19	19½	21½	21½	24	25½	25½	27	40
Throat Depth	6	7	7	7	8	8	10	10	10	14	14	14	16	16	18	18	20	25
Platen Width	8	8	8	8	8	8	8	8	10	10	10	12	14	16	18	20	24	36
Horsepower	30	30	30	30	30	30	30	30	30	75	75	75	75	75	75	75	75	75
Rapid Advance	380	285	285	285	206	206	146	146	146	178	135	141	91	89	70	47	47	54
Fast Press	NA	NA	NA	NA	NA	NA	NA	NA	NA	71	54	56	36	33	26	17	17	23
Normal Press	50	50	50	50	38	38	26	26	26	31	25	21	16	15	12	8	8	8
Rapid Return	290	275	275	275	206	206	146	146	146	178	135	141	91	89	70	47	47	43
Normal Return	NA	NA	NA	NA	NA	NA	NA	NA	NA	71	54	56	36	33	26	17	17	16
Anti Whip	15	15	15	15	10	10	10	10	10	8	8	6	6	4	4	3	3	3
Overall Width	45	50	52	58	58	62	70	70	71	86	91	106	119	126	136	148	160	197
Overall Height	94	95	95	99	111	111	122	122	127	141	149	158	169	181	194	207	212	264
Slot Required (3)	>12'	>12'	>12'	>12'	>12'	>12'	>12'	>12'	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y
Pit Below Grade Required (4)	N	N	N	N	N	N	N	N	N	Y	Y	Y	Y	Y	Y	Y	Y	Y

Consult factory if your application requires machine dimensions, speeds or flush floor installation not shown in the table above.

Notes:

(1) Machine length (L) to be specified by customer;

(2) Distance between housing without horns is machine length (L) minus the dimensions shown (Example: K400-14 foot bend length. The between housings dimension is L=14 ft. minus 19½" =12' 4½");

(3) A slot in the floor is required to clear the bed plate on small machines over 12' length and all large machines;

(4) Models 500-tons and larger require below grade side housing support.

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