



AD-S

PRESS BRAKES



**JMT offers quality machine tools
for all your metal fabrication needs**



JMTUSA.com

Email: JMT@JMTUSA.com

Toll Free: **855-773-7727**
(855-PRESS-BRAKE)

JMT machines are built by the largest volume press brake producer and the most respected manufacturer of sheet metal machinery in the world. This factory is one of the world's most contemporary production plants, with a 1.5 million square foot footprint and over 1500 dedicated employees.

JMT machines are built to extremely stringent standards and the factory has maintained continuous product research and development since 1956. With 75 R&D and product engineers on-staff at the plant, **JMT** products utilize the most modern techniques in design and engineering, and are equipped with proven quality components to fulfill a customer's most exacting requirements. **JMT** combines "accuracy, speed, flexibility, durability, reliability and advanced technology" with the highest performance/price ratio in the world.

A nationwide network of **JMT** distributors and technical support personnel are in place to assist you.

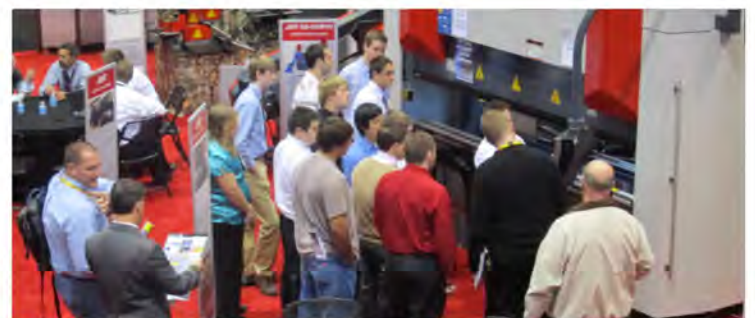
Our machines are built with world-renown components such as Rexroth, Siemens and Schneider, which are available off the shelf from your local supplier, your dealer, or direct from **JMT**.

For more information please visit JMTUSA.com.

You can also email us at JMT@JMTUSA.com or call toll free to **855-773-7727** (855-PRESS-BRAKE).



MACHINE PARTS INVENTORY



JMT Press Brakes

JMT press brakes guarantee precision, low maintenance costs, low operating costs, and long-term reliability. These features, along with large investments in modern manufacturing equipment, have made the factory the largest volume press brake producer in the world.

All **JMT** press brakes are produced with modern design technology and incorporate rigid stress relieved frames to increase your productivity with accurate part production. Demanding application requirements are easily met. **JMT** press brakes come in a broad range of sizes with features to satisfy nearly all budgets.

JMT AD-R Series Press Brakes

3-5 Axis CNC • 4'-20' Bending Lengths + Tandem • 66-660 Tons

These value-oriented press brakes have exceptionally large strokes, daylights, and throat depths to allow cost effective production of simple to complex shapes that require large dimensions for ease of handling and removal. An easy-to-use control reduces the required operator skill level.



JMT AD-S Series Press Brakes

5-14+ Axis CNC • 6'-30' Lengths + Tandem/Trio/Quad • 66-4000 Tons

The possibilities are unlimited with these popular press brakes that feature faster setups and part production as well as large daylight opening and working areas.

Features include a stable and fast AC servo motor-driven back gauge system; a powerful, yet simple, 3D graphical viewing controller (standard); automatic CNC table crowning; and outboard-mounted long ram guides (which provide stability while allowing full length between the frames for acute angle bending).



JMT AD-SERVO Hybrid Series Press Brakes

5-14+ Axis CNC • 8'-10' Bending Lengths • 110, 150, 195 Tons

These eco-friendly hybrid press brakes provide fast, quiet, clean, accurate bending operations at a lower cost in an energy-efficient press brake design.

Like the AD-S, the AD-SERVO features a stable and fast AC servo motor-driven back gauge system; a powerful, yet simple, 3D graphical viewing controller (standard); automatic CNC table crowning; and outboard-mounted long ram guides (which provide stability while allowing full length between the frames for acute angle bending).



JMT FBS Press Brakes (Flexible Bending Solutions)

JMT provides the latest technology in "large format" bending and automation with their "Flexible Bending Solutions." This advanced technology allows diversified uses in different industries while avoiding long, expensive welding operations (which also risk the stability of the material).

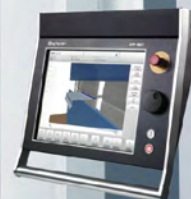
Features include reduced material handling, compensation for high spring-back sheets, reduced setup times through automated loading and unloading as well as increased employee safety.

The higher tonnage press brakes utilize a unique "box construction" design which provides the most stable machine frame in the industry.



***JMT AD-S* SERIES PRESS BRAKES**

- **5-14+ Axis CNC**
- **66-4000 Tons**
- **6'-30' Lengths + Tandem/Trio/Quad**
- Powerful, easy-to-use CNC touch screen control with 3D graphical visualization
- High-end solution for bending
- Representing the latest technology in press brake automation
- Well-conceived design
- The ultimate in precision and productivity
- Large daylight opening and working space
- The application of highly dynamic hydraulic servo valves
- Long double guides in combination with well-designed cylinder construction make a large and flexible beam opening possible
- Stable and fast AC Servo motor driven back gauge system
- CNC-controlled crowning — ensures maximum angle accuracy thus satisfying even the highest demands
- Provides CNC control of 5 axes: Y1, Y2, X, R and CNC motorized wave crowning (standard equipment)



JMT AD-S PRESS BRAKE FEATURES



CNC Crowning (Standard)

CNC controlled motorized crowning system equalizes bending force along every point of the part to produce straight bends and eliminate the need for shimming.



Sliding Front Arms (Standard)

Quickset support arms are mounted on a linear guide way and ball bearing system that allows "finger tip" lateral adjustment of the front support arms. Vertical adjustment is quick and easy.



X/R Back Gauge (Standard)

With the X/R style back gauge, the height of the back gauge is programmable in addition to the depth. This is very useful for changes in die height, extreme crowning settings, and for gauging to a flange that may be a different height than the die.

Finger depth and height is calculated by the CNC controller and executed by high-speed Siemens servo motors. Retraction is also a standard feature that helps the accuracy of the produced part. Back gauge fingers are easily adjusted on linear guides by a ball bearing integrated motion system.



Large Working Space (Standard)

Large Stroke + Large Daylight + Large Throat

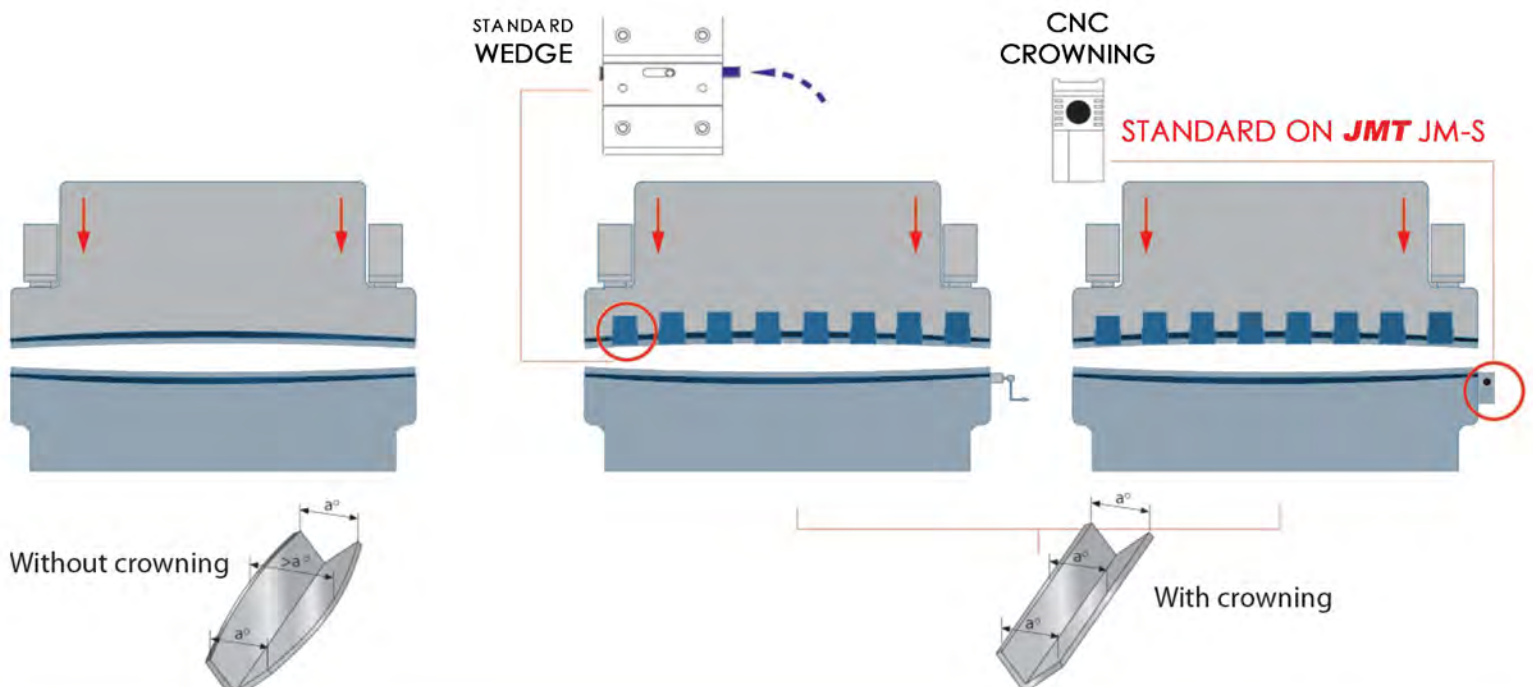
The large openings and strokes of the AD-S Series facilitate the versatile production of complex large parts requiring increased clearance, such as the production of deep-sectioned four-sided boxes. This provides for more clearance when bending parts with larger flanges. In some cases this allows the buyer to purchase a shorter press brake, as this large clearance allows large flange bending. The wide space can also reduce cycle times.



Laser Safety Systems (Optional)

Because of the versatility of press brakes and their uses, safety at the point of operation is the responsibility of the owner and operators.

JMT offers the ram-mounted AKAS-LC Safety Light Guard. Located at the bending level and based on the location of the punch tip, this system helps prevent injuries. Transmitter and receiver are fixed to the ram of the machine and form a laser-optical safety light grid that follows the ram or punch tip.



Shimless Bending (Standard)

JMT offers both manual and automatic controlled crowning systems for all our press brakes. Automatic CNC crowning comes standard on our AD-S machines. The position and setting is automatically calculated and set from the normal program information via the CNC control.

JMT AD-S Press Brake Tooling and Tool Holders



American/European Box Clamping (Standard)

Because of their deep sectioned characteristics, our standard American/European style clamps are very useful in deep box forming. They are designed with an integrated wedge which allows vertical adjustment to offset deflection and tool wear.



Hydraulic New Standard Clamping (Optional)

Wila's hydraulic New Standard clamping is a state-of-the-art system that operates quickly and easily without any external moving parts. This type of clamping is especially suitable for automatic tool changeovers.



Hydraulic Euro-Style Clamping (Optional)



JMT Tool Clamping (Optional)



Hydraulic Punch Clamping (Optional)

JMT offers several styles of hydraulic punch clamping. Each automatically centers and seats the punch and allows vertical removal. Setup times can be dramatically reduced. It is available for American and New Standard style concepts.



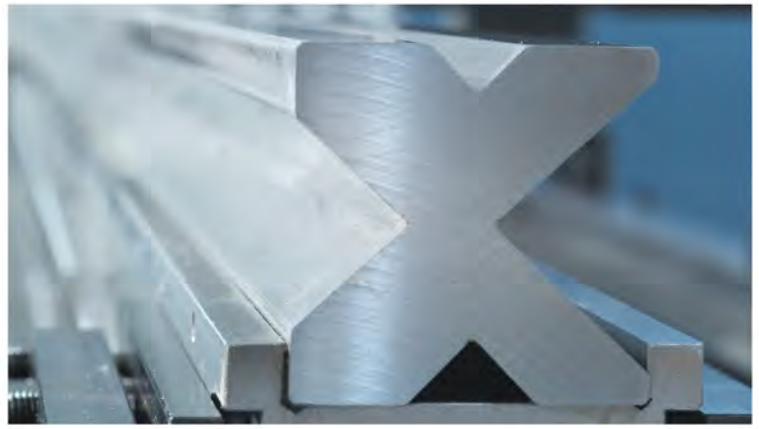
JMT Hydraulic Punch Clamping (Optional)

Patented "easy slide" removal of the punch. Built to withstand loads up to 330 Tons per foot for demanding jobs with heavy load over short area.



JMT Laser-Hardened Tools (Optional)

Typically machines 350 tons and over are equipped with a large multi-V die with five or more v-openings. The opening sizes are dependent on the machine tonnage.



Precision Ground 4-Way Die (Optional)

JMT offers an economical, versatile precision ground tooling package that consists of a four way bottom die (openings: 0.625"/88°; 0.866"/88°; 1.37"/85°; 1.96"/85°), a four way die holder, and a 75° punch with a 0.030 radius. The longest punch/die is 32".



New Standard Style Tooling (Optional)

The New Standard concept is also available, representing the latest in modern press brake tooling technology.



American Style Tooling (Optional)

Both precision ground and sectional tooling (Wila, Wilson), as well as conventional full length plainer style tooling (**JMT**) is available.



Multi-V Adjustable Die Systems (Optional)

Multi-V dies are your most versatile solution in today's demanding market.



Hydraulic Die Clamping (Optional)

Hydraulic die clamping provides an equally fast method of securing the lower dies. It is available for both American/European and New Standard style dies.

JMT AD-S Press Brake Back Gauge Options



X, R, Z1, Z2 – 4 Axes (Optional)



X1, X2, R, Z1, Z2 – 5 Axes (Optional)

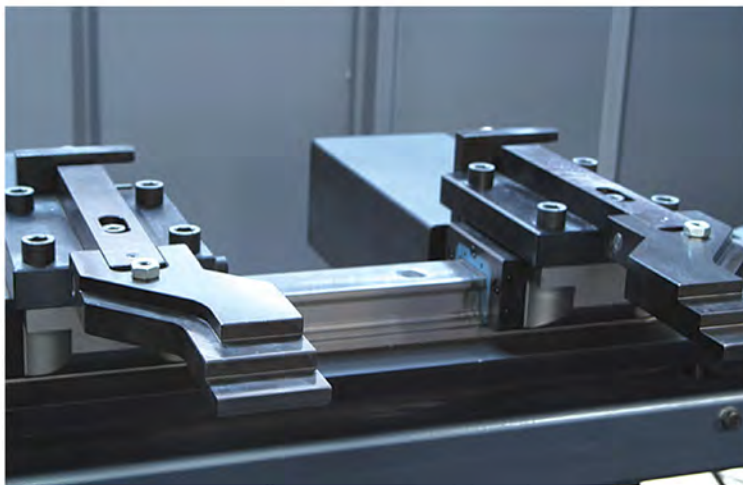


X1, X2, R1, R2, Z1, Z2 – 6 Axes (Optional)



Delta X (Optional)

JMT AD-S Press Brake Back Gauge Fingers

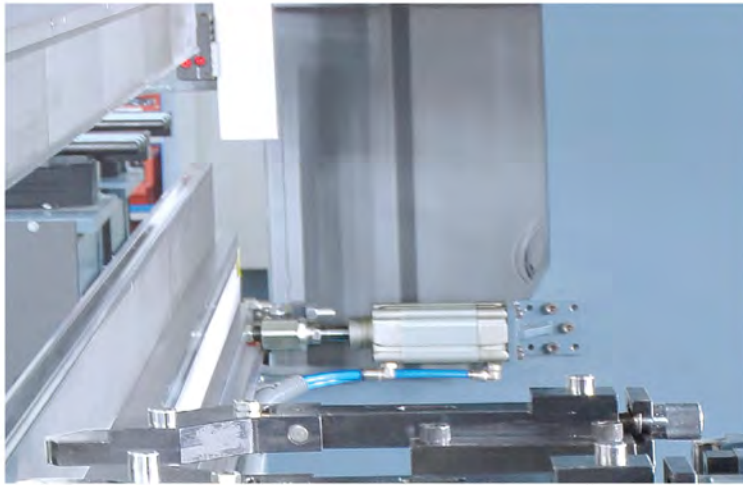


Finger Blocks (Standard)



Special Fingers (Optional)

JMT AD-S Press Brake Bottom Tool Positioning Systems



Pneumatic Positioning System (Optional)



Motorized Positioning System (Optional)



Laser Angle Measurement System (Optional)

Manufacturing sheet metal parts with accurate angles that are kept constant at all times, even when material parameters change, is very difficult. The best solution is a laser-based angle measuring device.

- Lasers can measure any bending angle.
- Lasers are very compact — everything is contained in the appliance.
- Lasers are accurate regardless of lighting influences. Working with light or dark material surfaces have almost no effect on a laser.

JMT AD-S Press Brake CNC Control Units

Delem DA-66T (Standard)

Embedded Reliability

Delem DA-Touch controls feature embedded, real-time Windows operating system for maximum reliability. Smooth start-ups are ensured, even after instant shut-off.

DA-66T Features

- 2D graphical touch screen programming mode
- 3D visualization in simulation and production
- 17" high resolution color TFT
- Full Windows application suite
- Delem Modusys compatibility (module scalability and adaptivity)
- USB, peripheral interfacing
- Open system architecture
- User specific application support within the controllers multitasking environment
- Sensor bending and correction interface

Standard Configuration

- Color LCD display
- 17" TFT, high brightness
- 1280 x 1024 pixels, 32 bit colour
- Full touch screen control (IR-touch)
- Storage capacity 256 MB
- 3D graphics acceleration
- Standard Windows® networking
- Emergency switch
- Integrated OEM-panel
- USB flash memory drive

Field Option

- Part support control
- X1-X2 angle programming
- Barcode reader interfacing
- Protractor interfacing
- Frame deflection compensation
- Sensor bending and correction interfacing
- Sheet thickness measurement and compensation system



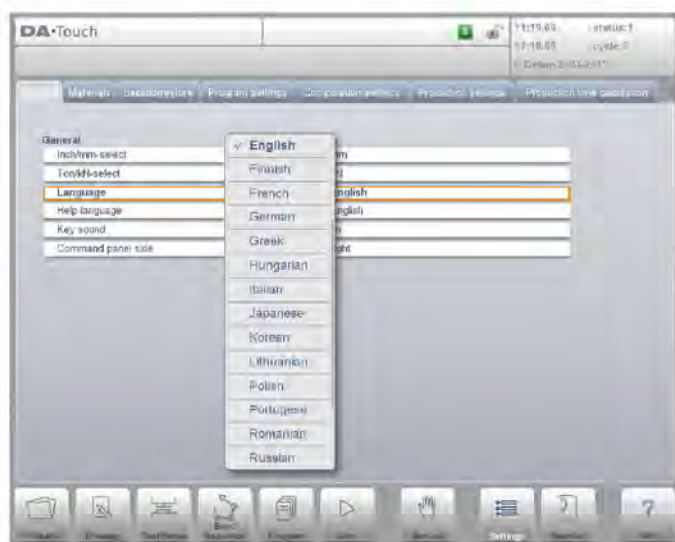
The new generation **DA-Touch** controls offers an even higher grade of efficiency in programming, operation and control of today's press brakes. Ease of use combined with state-of-the-art technology go hand in hand, **improving productivity**.

The **touch screen** gives access to the proven Delem user-interface and enables **direct navigation** between programming and production. Functions are directly located where you need them, offering **optimized ergonomics** throughout the application.

The DA-66T offers 2D programming that includes **automatic bend sequence calculation** and **collision detection**. Full 3D machine set-up with multiple tool stations giving true feedback on the product feasibility and handling.

Highly effective control algorithms **optimize the machine cycle** and **minimise set-up time**. This makes using press brakes easier, more efficient and more versatile than ever.

The OEM-panel located above the screen, reserved for machine functions and OEM-application switches, is integrated in the design and can be used depending on the required application.



Multi-level language selection (controlled by supervisor)

Delem

General

- Real-time embedded Windows® OS
- Multitasking environment
- Instant Shut Off
- Delem Modusys compatible

Electrical / interfacing

- Power supply: 24V
- Modusys HSB bus (up to 15 axes)
- RS232 port
- Network interface (100Mb/10Mb)
- USB ports
- SafetyPLC interfacing
- Protractor interfacing
- Angle control interfacing

Control

- Servo- / 2 speed AC control
- Unipolar / frequency inverter control
- Direct pressure valve control
- Direct proportional valve Y1, Y2 control
- Direct crowning control
- Multiple digital function outputs
- Tandem operation

Programming

- Alphanumeric product naming
- Real-scale product programming and visualization
- Automatic bend sequence calculation
- Easy graphical bend sequence swap and move
- Hemmed products programming
- One page programming table
- Graphical product and tool selection
- Programmable material properties
- Programmable axis speed
- Free material programming
- Product & tool search filter
- Inches/Millimeters, Ton/kN selection
- Stock counter
- Product notes

Tooling

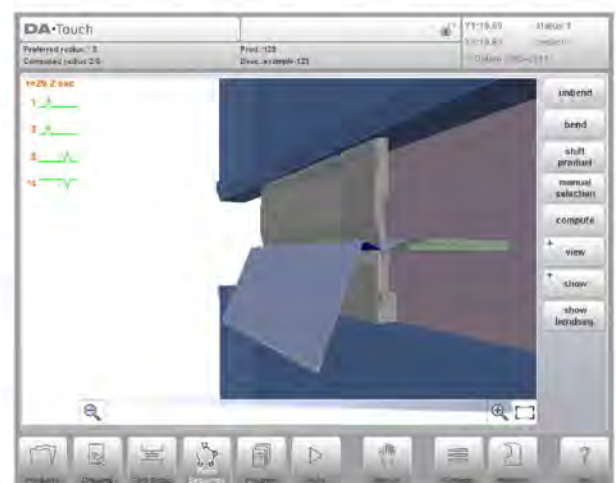
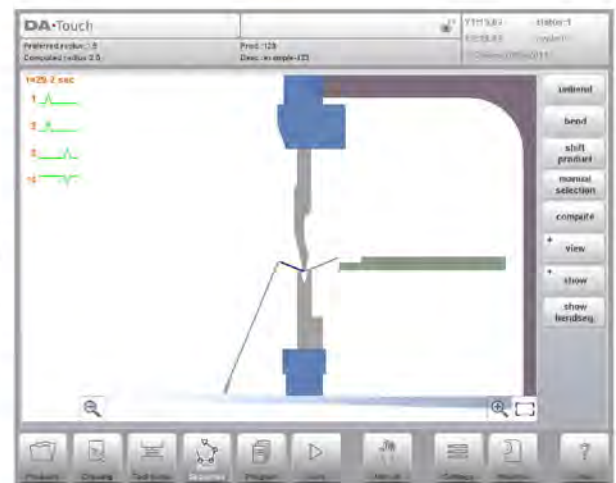
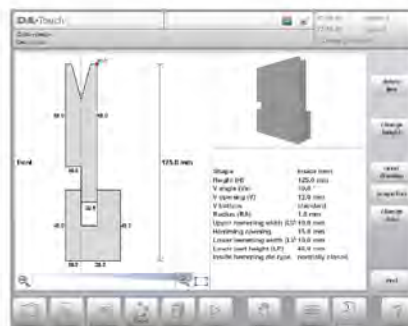
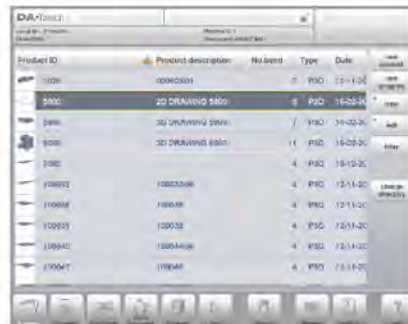
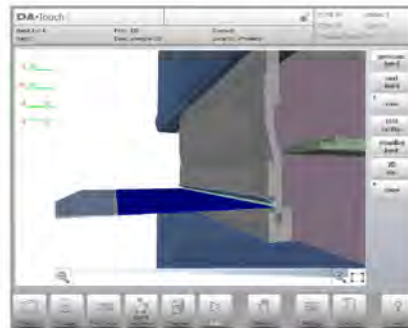
- Graphical tool configuration
- Multiple tool station set-ups
- Tool segmentation visualization
- Alphanumeric tool identification
- Free graphical tool programming
- Hemming tools
- Radius tools
- Tool adapter support

Computed

- Tooling safety zones
- Press force
- Bend allowance
- Crowning adjustment
- Developed length
- Bottoming force
- Hemming force
- Auto bumping calculation
- Radius programming
- Bend allowance table
- Learned angle correction database

Miscellaneous

- 'Teach-in' on all axes
- Handwheel movement of all axes
- Operator selectable dialogue languages
- Integrated help functions
- Error messaging system
- Diagnostic program
- Internet Explorer (web browser)
- Remote diagnosis
- User specific applications support
- Machine time + stroke counter
- On board Analysis Tool
- Sequencer functionality (PLC)



Delem DA 69T (Optional)



The optional DA-69T offers both programming that includes **automatic bend sequence calculation** and **collision detection**. Full **3D machine set-up** with multiple tool stations gives true feedback on the product feasibility and handling.

DA-69T Features

- 3D and 2D graphical touch screen programming mode
- 3D visualization in simulation and production
- 17" high resolution color TFT
- Full Windows application suite
- Delem Modusys compatibility (module scalability and adaptivity)
- USB, peripheral interfacing
- Open system architecture
- User specific application support within the controllers multitasking environment
- Sensor bending & correction interface
- 2D/3D graphical CNC system for hydraulic press brakes with fully automatic bend sequence computation and CNC production computation

Standard Configuration

- Color LCD display
- 17" TFT, high brightness
- 1280 x 1024 pixels, 32 bit color
- Full touch screen control (IR-touch)
- Storage capacity 1 GB
- 3D graphics acceleration
- Standard Windows® networking
- Emergency switch
- Integrated OEM-panel
- USB flash memory drive

Field Option

- Part support control
- X1-X2 angle programming
- Barcode reader interfacing
- Protractor interfacing
- Frame deflection compensation
- Sensor bending & correction interfacing
- Sheet thickness measurement and compensation system

ModEva 10S/12S/15S 3D with PC 1200 3D S W (Optional)



ModEva is a range of numerical controls adapted to the actual market demand. Therefore the complete ModEva series runs now under Windows ModEva can provide a calculating capacity and performance adapted to simple machinery with a 3D graphic display, it can also be transformed into a real workstation with a very high-power CPU and maximum graphic capabilities thus making Cybelec® adapted numerical control available to the most sophisticated machinery.

3D / 10,4" color screen

TFT type screen

128 Mb Ram

128 DM Main Memory

Easy Cursor

Automatic Bend Sequences

PC Off line 3D Software

All ModEva™ consoles are equipped with the new Quick Cursor™ device. One of its main features is the possibility of completely programming a part on a single page. When producing more complex parts, the graphic sequences generated by a CAD/CAM system can easily be viewed on the user console.

All ModEva come with PC 1200 off line bending software. PC 1200 program allows you to prepare your programs, calculate offers and check feasibility of the parts in your Office on a PC. No time wasted on the machine.

JMT AD-S Press Brake Optional Offline Software

Delem VBend (Optional)

Delem's **VBend** Virtual Bend software is a high-end CAD-CAM package that offers an offline solution for programming your press brake, as well as post processing the programs and showing a simulation of the actual bending process.

Product programming, make-ability checks, tool preparation and many other activities can be carried out offline.

The VBend suite includes bend sequence calculation and modification in the main program completed with either a graphical product programming or multiple import converters for externally developed designs. This can be done in both 2D and 3D CAD file formats.

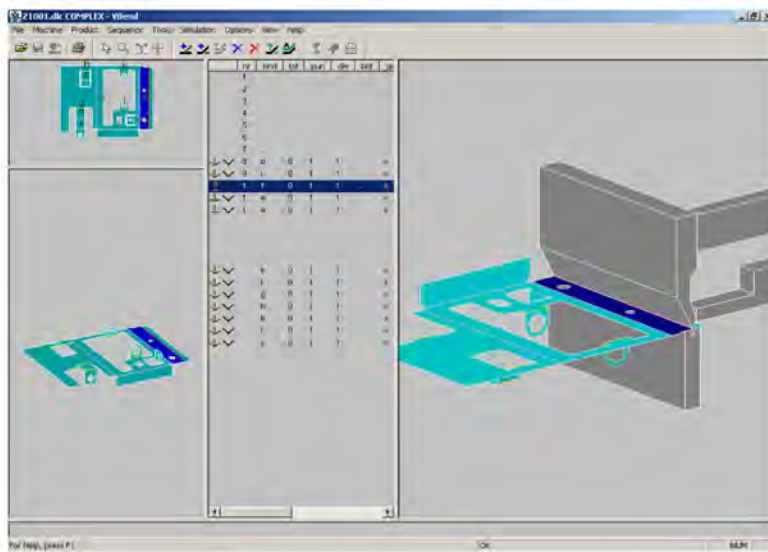
The simulation integrated in VBend shows the user the bending process on an accurate model of the press brake that is being used. With the simulation even the latest dynamic collisions and practical production issues can be optimized in the design stage.

After finishing, a product can easily be transferred to a machine for production.

In VBend multiple press brake models can be used for a complete production environment.

Features

- Full-scale offline programming, simulation and adjustments
- Fast graphical product programming and program generation
- Full 3D automatic bend sequence calculation
- Static and dynamic collision detection
- Feasibility studies and production preparation
- Direct CAD 2D/3D input interface DXF / SAT / IGES / STEP
- Flexible **bend sequence calculation** via unbending or bending
- **Parametric** tool definition
- Tools import and export
- Special tool operations (hemming, radius, etc.)
- Automatic tool set-up (type, heels, position)
- Tool optimization
- Printout of CNC program and machine set-up
- **DXF output** in cutting dimensions for laser machines
- **VDraw** fast product drawing tool
- Simulation on detailed virtual customized press model
- Machine set-up preparation including print-out functionality
- Product sharing over Windows networking with press brake CNC
- Windows XP / Vista compliant



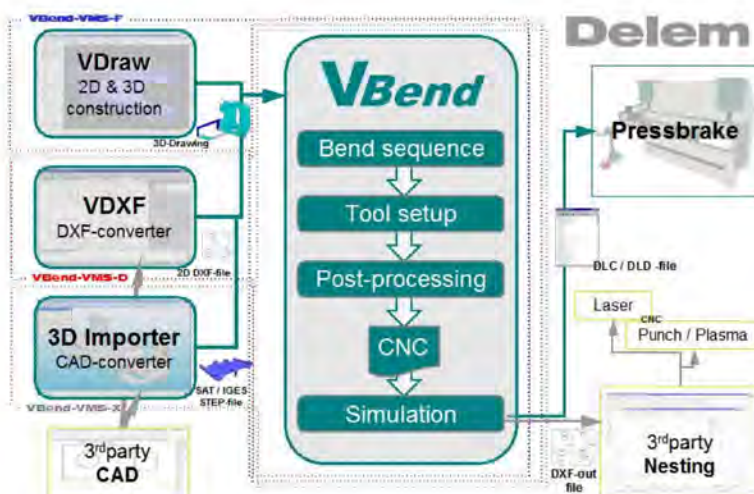
Delem VBend Product Configuration

Standard

- Flexible bend sequence generation
- Collision detection for part, tools and machine
- 3D accurate machine representation
- 3D finger view
- T.O.M.(R), tool optimization module

Ordering Configuration Options

- VBend VMSD Offline Software
Includes DXF-converter (VDXF)
- VBend VMSF Offline Software
Includes fast graphical drawing module (VDraw)
- VBend VMSX Offline Software
Includes DXF-converter and 3D-importer (V-SAT)
- V-IGES / V-STEP



Programming Functions

- Bend sequence generation (unbend / bend by bend start flat)
- Numeric product naming, up to 7 digits
- Automatic bend sequence calculation
- Graphical product and tool selection
- Programmable axis speed
- Free material programming
- Special tool operations (hemming, bumping, etc.)
- Number of steps up to 99
- Production simulation on accurate press brake model
- CNC program editor
- Easy millimeter/inch conversion
- kN / Ton selection

Tooling

- Graphical tool configuration
- Multiple tool station set-ups
- Tool optimization module (TOM)
- Tool segmentation visualization
- Parametric tool definition
- Tool import / export
- Tool library / database

Computed Functions

- Tooling safety zones
- Press force
- Bend allowance
- Crowning adjustment
- Bottoming force
- Hemming force
- User definable bend allowance tables
- DXF output in cutting dimensions

Graphical Print Functions

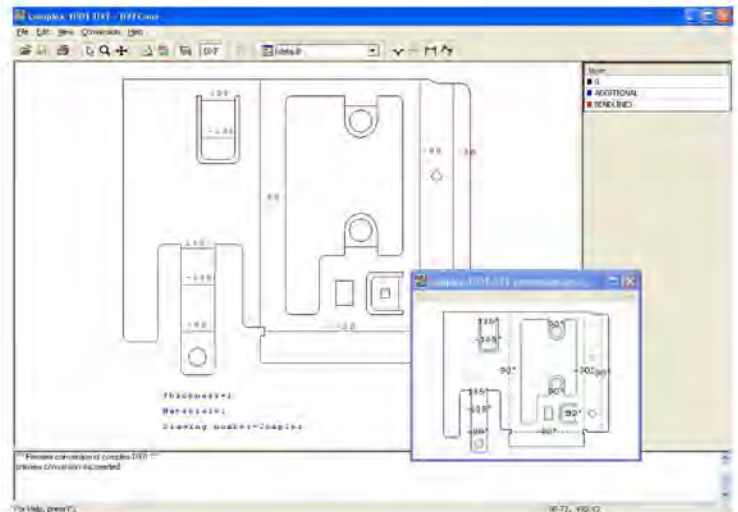
- Print-out of CNC program includes:
 - Product data
 - Tool set-up
 - Numerical bend sequence
 - Graphical bend sequence

Miscellaneous Features

- Multiple onboard dialogue languages
- Help texts, via Online Help functions
- Customized press brake modelling

System Requirements

- IBM compatible PC
- Windows 2000 / XP
- CD-ROM player
- Parallel or USB port

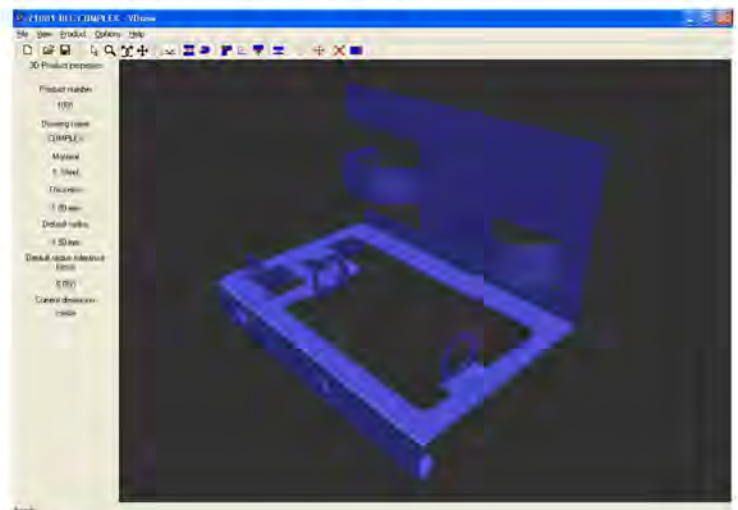


Option:

V-DXF

DXF Conversion Tool

- Automatic conversion of DXF files
- Manual conversion using **layer selection**
- Conversion of DXF files in **projection dimensions**
- Conversion of DXF files in **cutting dimensions**
- Use and store of configuration settings
- Editing operations for fine tuning



Option:

VDraw

Graphical Programming Tool

- Quick creation of 3D products
- Conversion of simple 2D profile to 3D products
- Defining surface overlap
- (Un)fold 3D product
- Create hemming bends
- Tolerance on bend radius

Option:

V-SAT

3D Importer and Conversion Tool

- Automatic conversion of SAT / IGES / STEP files
- Manual corrections / healing
- Use and store of configuration settings
- Editing operations for fine tuning

Delem's **Profile-W** Profile-on-Windows entry level operator/ user package is a 2D/3D software solution that facilitates offline programming and simulation.

The graphical product programming shows a real-scale representation of the intended product. This realistic product information gives feedback to the programmer on feasibility and required tools and tool adapters. Even special product operations like hemming are supported in both the graphical product programming screen and the bend sequence computation screen.

Product programming, make-ability checks, tool checks, operator training, production notes and many other activities can be carried out offline.

The Profile-on-Windows package offers the same familiar interface as the control. After programming, a product can easily be transferred to machine for production.



3D Bend Simulation

Features

- Full-scale offline programming
- Familiar GUI 1-to-1 user interface with DAonWindows controls (DA-66W/DA-69W compatible)
- Software upgrades parallel to DA-66W and DA-69W versions
- Easy import of Delem control settings
- Graphical product programming and program generation
- Feasibility studies and production preparation
- 3D machine representation
- X1-X2 angle programming
- 3D finger view standard available
- Full 3D automatic bend sequence calculation
- Collision detection
- Product sharing over Windows networking with press brake CNC
- Machine set-up preparation including print-out functionality
- Production time calculation
- Printing functionality of products and tools
- Easy support for end users
- 2 versions (2D or 3D) for leveling:
 - W2D basic package, with graphics similar to DA-66W
 - W3D extra option with graphics similar to DA-69W

Profile-W2D

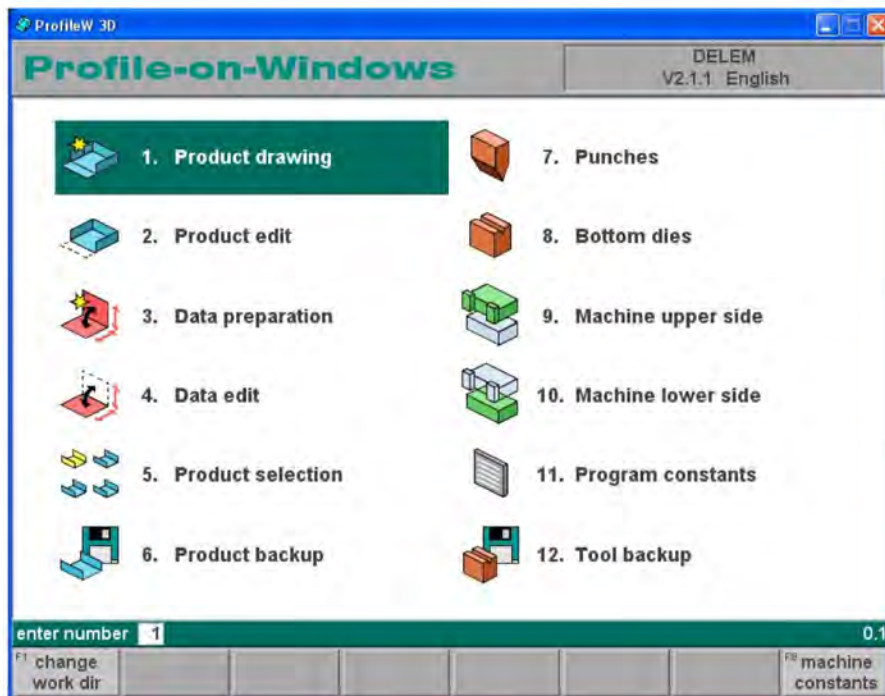
- Graphical product drawing
- Tool drawing 2D
- 2D bend sequence calculation
- 3D machine set-up / tool stations

Profile-W3D

- Additional 3D product drawing
- 3D full automatic bend sequence calculation



Delem



Programming Functions

- Alphanumeric product naming, up to 25 characters
- 2D / 3D real-scale product programming and visualization
- Automatic bend sequence calculation in 2D and 3D
- Easy graphical bend sequence swap and move
- Front part support visualization
- One page programming table
- Graphical product and tool selection
- Programmable axis speed
- Free material programming
- Program repeat max. 9,999
- Number of steps up to 99
- Step repeat, 99 max.
- Product & tool search filter
- Millimeters / inches
- kN / Ton selection

Tooling

- Graphical tool configuration
- Multiple tool station set-ups
- Tool segmentation visualization
- Alphanumeric tool identification, up to 25 characters
- Free graphical tool programming
- Tool adapter support

Computed Functions

- Tooling safety zones
- Press force
- Bend allowance
- Crowning adjustment
- Developed length
- Bottoming force
- Hemming force
- Auto bumping calculation
- Radius programming

Graphical Print Functions

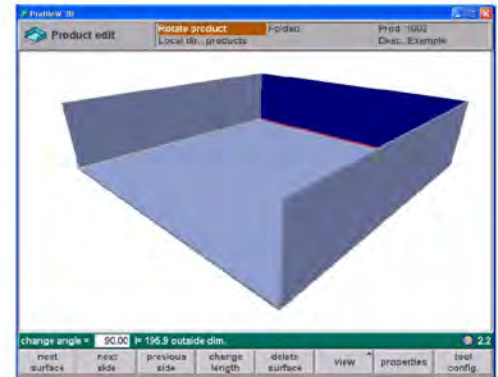
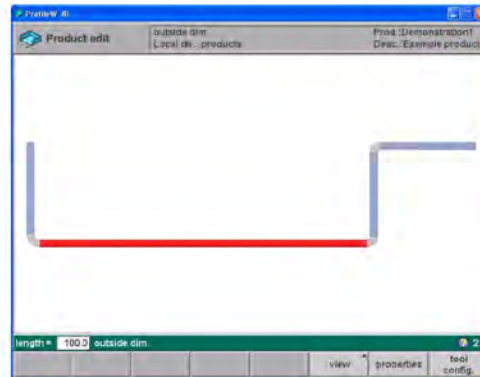
- Print-out of CNC program, including:
 - Product data
 - Bend sequence
 - Tool set-up

Miscellaneous Features

- Multiple onboard dialogue languages
- Help texts, via Online Help functions
- User definable color setting
- VBend demo program included

System Requirements

- IBM compatible PC
- Windows 2000 / XP
- Minimum 40MB free disk space
- CD-ROM player
- Parallel or USB port



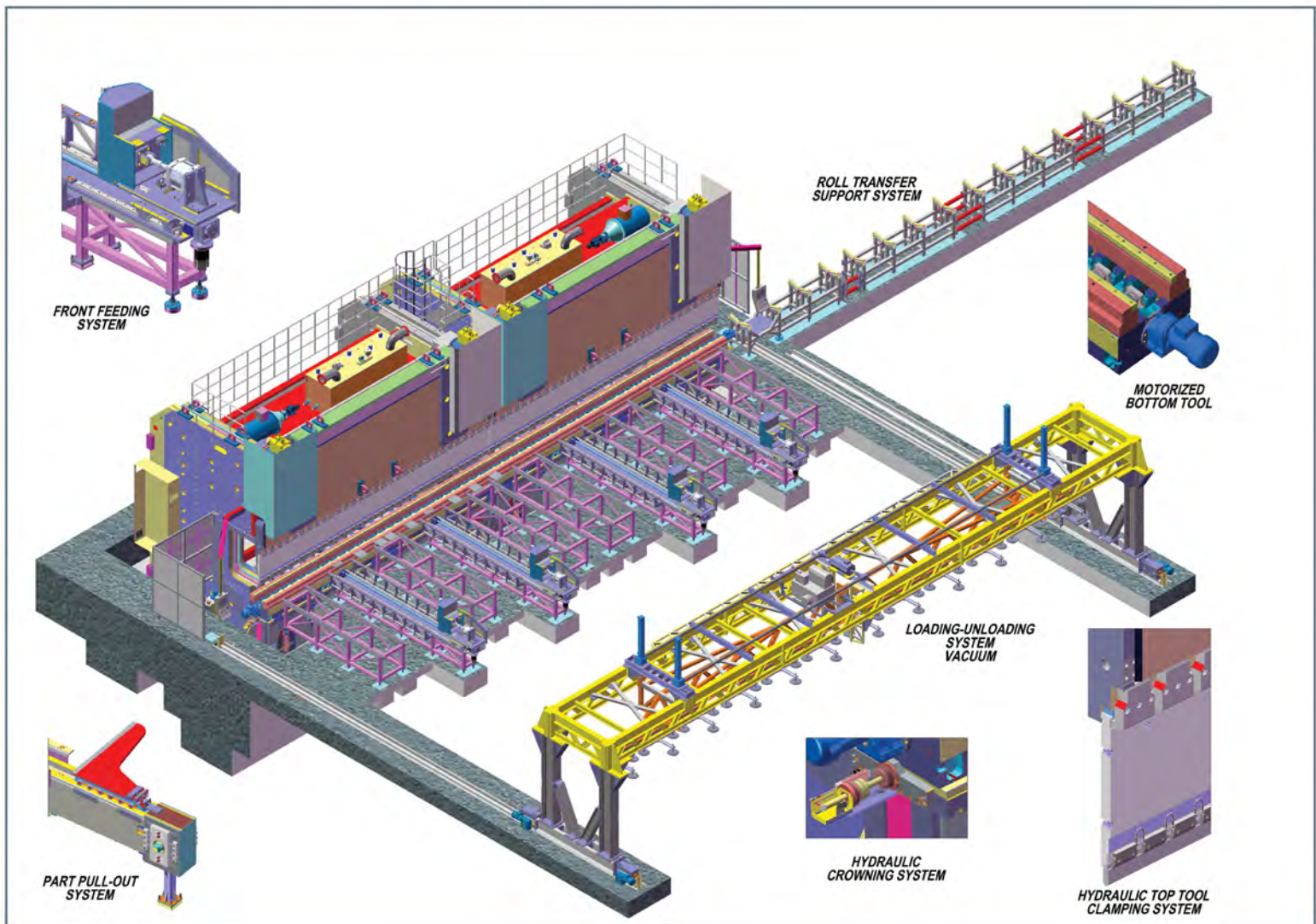
JMT AD-S Press Brake Sheet Followers



CNC Controlled Sheet Followers (Optional)

CNC-controlled followers reduce operator involvement and "dishing" of large sheets or panels. Followers support large sheets as they are being bent. A "parking station" is available on one end of the bed allowing the operator to quickly and easily position the sheet follower units out of the way when they are not required for a job. The following units adjust easily in height and width via a linear guide. Power height adjustment is standard.

JMT AD-S Press Brake Automation



Large Format Automation

JMT AD-S Press Brake Large Format Options



Large Format Press Brakes

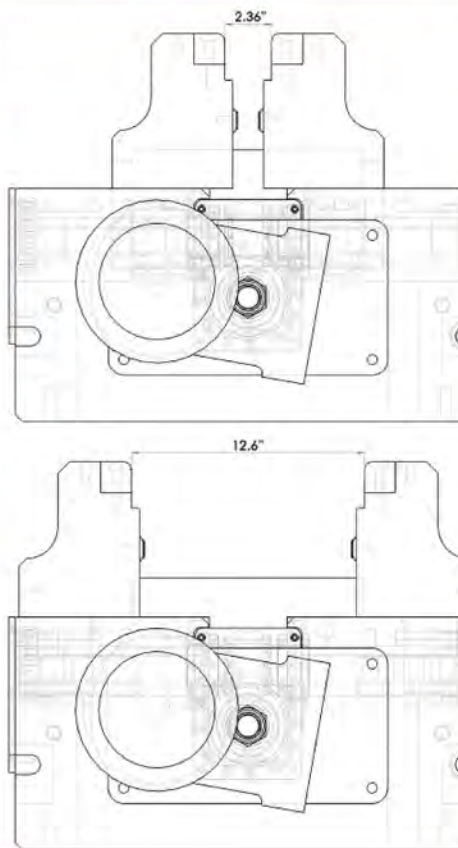


Tandem/Trio/Quad Systems

JMT AD-S Press Brake Large Multi-V Options



Manual Multi-V



Motorized Multi-V

Large Manual and Motorized Multi-V Dies (Optional)

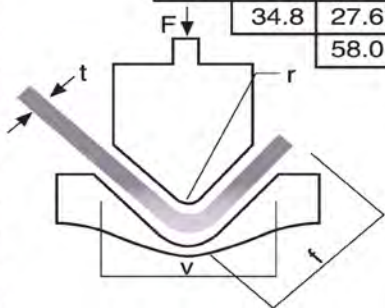
JMT AD-S Press Brake Air Bending Tonnage Guide

Force to Air-Bend Mild Steel (60,000 PSI)

F = U.S. tons/lineal ft. of workpiece

All Dimensions in inches

t	v	1/4	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	5	6	8	10	v
ga.	f	3/16	9/32	11/32	7/16	9/16	11/16	7/8	1 1/8	1 3/8	1 3/4	2 3/16	2 13/16	3 1/2	4 1/2	5 1/2	6 7/8	f
in.	r	1/32	1/16	5/64	7/64	9/64	5/32	13/64	1/4	5/16	13/32	33/64	5/8	3/4	1 1/32	1 5/16	1 5/8	ga.
20	0.036	3.1	1.75	1.2														20
18	0.048	5.4	3.1	2.1	1.55	1.3												18
16	0.060	9.6	5.5	3.8	2.8	2.2	1.45											16
14	0.075		9.3	6.4	4.7	3.8	2.5	1.85										14
12	0.105		20.5	14.0	10.4	8.1	5.6	4.1	3.2	2.2								12
11	0.120			18.5	13.9	10.9	7.4	5.6	4.3	2.9	2.15							11
10	0.135			25.2	17.2	14.5	9.9	7.3	5.7	3.8	2.85	2.23						10
3/16	0.188			34.8	27.6	19.1	13.9	11.0	7.5	5.6	4.3							3/16
1/4	0.250			58.0	39.5	29.0	22.8	15.5	11.4	8.9	6.1	4.5						1/4
5/16	0.313				69.5	51.0	40.0	27.0	20.0	15.6	10.5	7.8	6.1					5/16
3/8	0.375					75.0	59.0	40.0	29.5	23.4	15.8	11.7	9.2	6.2	4.6			3/8
7/16	0.438					115.0	90.0	61.0	45.5	35.2	24.0	17.8	13.9	9.4	6.9	7/16		7/16
1/2	0.500						85.0	62.0	44.3	33.0	24.5	19.1	13.0	9.8	1/2			1/2
5/8	0.625							86.0	58.0	43.0	34.0	23.2	17.5	5/8				5/8
3/4	0.750								91.0	67.0	53.0	36.4	26.7	3/4				3/4
7/8	0.875									136.0	101.0	79.0	54.0	40.0	7/8			7/8
1	1.000										146.0	115.0	68.0	58.0	1			1



t = Workpiece thickness
r = Inside radius of formed part
v = Vee-die opening
f = Minimum flange

For steel of different tensile strength.
F valve differs in proportion to strength ratio.
Inside radius r for mild steel, is about
5/32 of female die opening v. for any t.
Shaded F values are for v = 8t, common for
average 90° bending.
For t = 1/2 inch or more, use v = 10t.

PLEASE VERIFY YOUR TOOLING IS CAPABLE OF HANDLING THE TONNAGE

*Tonnage requirements for coining are 3 to 5 times Greater than when air bending. Bending pressures for other metals are:

• Soft brass = 50% of pressure shown. • Soft Aluminum = 50% of pressure shown. • Aluminum alloys heat treated = same as steel. • Stainless steel = 50% more than steel.

JMT AD-S PRESS BRAKE STANDARD EQUIPMENT

JMT AD-S Series press brakes are manufactured with exceptionally large stroke and daylight combinations as well as high speed ram and back gauge positioning. The production of deep boxes and other parts requiring large clearances are produced with ease. The AD-S Series is truly a machine for fast and accurate production of precision parts; simple, complex, large or small.

- 5 axis CNC:
 - Y1, Y2 precision ram positioning*
 - X, R precision servo-driven back gauge
 - CNC motorized wave crowning
- Large trio of value:
 - Large open height
 - Large stroke
 - Large throat depth
- Delem DA-66T touch screen CNC control unit with 3D graphical visualization (see optional controls below)
- CNC controlled hydro-mechanical crowning (standard on 880 Ton and larger)
- Clamping:
 - American/European section-style box punch clamps (standard on 440 Ton and lower)
 - American-only style punch clamp available at no charge on 440 Ton and lower
 - JMT clamping system (standard on 660 Ton and larger)
- Standard X-axis travel is 25.6" with third gauge step capable of gauging parts up to 39" with standard back gauge (most machines)
- Stable and fast AC servo motor-driven precision back gauge with linear guide and ball bearing system (X - R)
- Quick-set sliding front sheet support arms with full-length linear guide, tilting stop and T-slot (front gauging squaring, etc.)
- Protection covers (side and rear safety doors)
- Rear work light
- World-class hydraulic and electronic components that are easily replaceable (parts stocked by us or available off-the-shelf from your local supplier):
 - Hydraulic blocks and valves (Rexroth)
 - Electronics system (Siemens, Schneider)
- High-yield plate construction
- Ability to accurately fade ram
- Stage bending
- Automatic bend sequence determination
- Automatic stretch length calculator for blank size determination



- * Features Y1/Y2 ram positioning system where each cylinder operates independently in a closed loop system. Linear encoders are mounted on a separate sub-frame on each side of the machine. These encoders combined with precision servo-hydraulic valves and the CNC command center, provide accuracy of $\pm .0004$ " and the ability to program all ram positions, ram speeds and ram tilt. The decompression point is also programmable, which, along with programmable speeds is very useful when bending large sheets or high-yield material.

JMT AD-S PRESS BRAKE OPTIONAL EQUIPMENT

- Safety laser: AKAS-LC manual or motorized
- Light curtain: SICK C 4000 for tandem/trio/quad machines
- Robotics
- Adaptive bending sensors
- Up to 14+ axes available:
 - Z1, Z2 axes
 - X1, X2 axes
 - R1, R2 axes
 - Delta X axis, +/- 5" stroke (10" total)
 - X Axis = 40" travel – back protection with light barrier
 - X1 X2 axes for light pole production
 - X1 X2 axes for lighting pole pneumatic pushers
 - AP3-AP4 sheet follower with sliding guide – motorized height adjustment
 - F1-F2 front feeding system with supports
 - F1-F2 front feeding system with supports – pneumatic pushers
- Other CNC control units available:
 - Delem DA-69T touch screen 2D/3D CNC control
 - Cybelec ModEva 10S/12S/15S 3D with PC 1200 3D SW
- Clamping:
 - Quick release clamping
 - JMT hydraulic or mechanical clamping
 - Wila or Wilson hydraulic or mechanical clamping
- Various tool options (JMT, Euro-American, Wila or Wilson)
- Bottom tool positioning system
- Thickness measurement systems
- Offline software (V-Bend, Profile-W)

- Tooling packages
- Multiple brake configurations available:
 - Tandem configuration
 - Trio configuration
 - Quad configuration

Many options and customizations are available — please contact us for details.

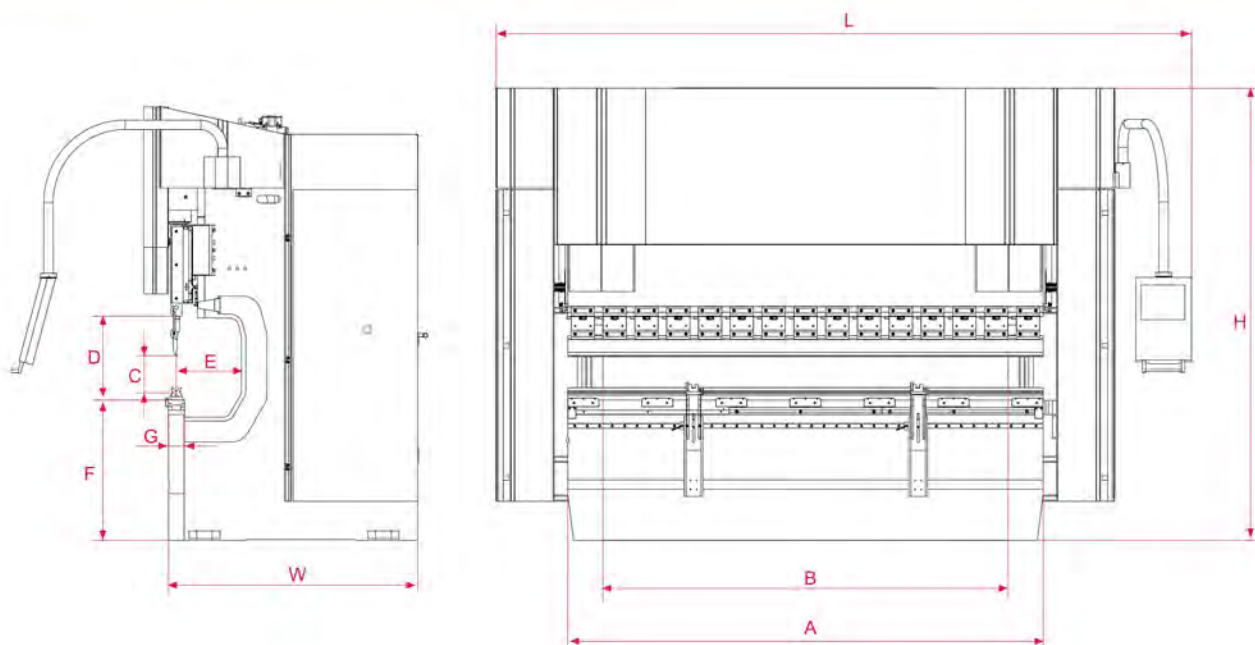
Web: **JMTUSA.com**

Email: **JMT@JMTUSA.com**

Call Toll Free: **855-773-7727**
(855-PRESS-BRAKE)

JMT AD-S PRESS BRAKE TECHNICAL DIMENSIONS

Y-Axis Speeds (Inches per Minute)													
AD-S SERIES Model	Bending Length [A]	Bending Force (Tons)	Between Frames [B]	Y-Axis Rapid Speed	Y-Axis Working Speed	Y-Axis Return Speed	CNC Crowning <i>Standard</i>	Daylight [D]	Bed Cap Width [G]	Bed Height [F]	Depth of Pit	Stroke [C]	Throat Depth [E]
AD-S 1260	4' 1"	66	3' 5"	472	23	260	Motorized	15.75"	4"	35.4"	—	6.3"	13.75"
AD-S 2060	6' 8"	66	5' 7"	472	23	236	Motorized	15.75"	4"	35.4"	—	6.3"	13.75"
AD-S 25100	8' 4"	110	7' 2"	425	23	283	Motorized	20.87"	4"	35.4"	—	10.4"	16"
AD-S 30100	10'	110	8' 6"	425	23	283	Motorized	20.87"	4"	35.4"	—	10.4"	16"
AD-S 30135	10'	150	8' 6"	378	23	283	Motorized	20.87"	4"	35.4"	—	10.4"	16"
AD-S 30175	10'	192	8' 6"	283	23	236	Motorized	20.87"	4"	35.4"	—	10.4"	16"
AD-S 30220	10'	242	8' 6"	283	23	236	Motorized	20.87"	6"	35.4"	—	10.4"	16"
AD-S 30320	10'	352	8' 6"	236	23	236	Motorized	24.8"	4"	35.4"	—	14.4"	16"
AD-S 37175	12' 1"	192	10' 2"	283	23	236	Motorized	20.87"	4"	35.4"	—	10.4"	16"
AD-S 37220	12' 1"	242	10' 2"	283	23	236	Motorized	20.87"	4"	35.4"	—	10.4"	16"
AD-S 40175	13' 3"	192	11' 9"	283	23	236	Motorized	20.87"	4"	35.4"	—	10.4"	16"
AD-S 40220	13' 3"	242	11' 9"	283	23	236	Motorized	20.87"	4"	35.4"	—	10.4"	16"
AD-S 40320	13' 3"	352	11' 9"	236	23	236	Motorized	24.8"	6"	35.4"	—	14.4"	16"
AD-S 40400	13' 3"	440	11' 1"	236	19	189	Motorized	24.8"	12"	40.9"	—	14.4"	20"
AD-S 40600	13' 3"	660	10' 2"	189	16	189	Motorized	27.56"	12"	39"	4'	14.4"	20"
AD-S 43175	14'	192	12' 2"	283	23	236	Motorized	20.87	4"	35.4"	—	10.4"	16"
AD-S 43220	14'	242	12' 2"	283	23	236	Motorized	20.87	4"	35.4"	—	10.4"	16"
AD-S 43320	14'	352	12' 2"	236	23	236	Motorized	24.8	6"	35.4"	—	14.4"	16"
AD-S 43400	14'	440	12' 2"	236	19	189	Motorized	24.8	12"	40.9"	—	14.4"	20"
AD-S 60220	20'	242	16' 8"	189	23	236	Motorized	20.87	6"	43.3"	—	10.4"	16"
AD-S 60320	20'	350	16' 8"	236	23	236	Motorized	24.8	6"	43.3"	—	14.4"	16"
AD-S 60400	20'	440	16' 8"	236	19	189	Motorized	24.8	12"	48"	—	14.4"	20"
AD-S 60600	20'	660	16' 8"	189	16	189	Motorized	27.56"	12"	39"	4'	14.4"	20"
AD-S 60800	20'	880	16' 8"	165	14	189	Hydro-Mech	27.56"	16"	31.5"	4' 4"	15.75"	24"
AD-S 70800	23' 1.5"	880	16' 8"	189	16	165	Hydro-Mech	27.56"	16"	31.5"	4' 4"	15.75"	24"
AD-S 701000	23' 1.5"	1100	16' 8"	165	11	141	Hydro-Mech	31.5"	16"	31.5"	5'	19.68"	24"
AD-S 701250	23' 1.5"	1375	16' 8"	165	16	165	Hydro-Mech	31.5"	16"	35.4"	5' 7"	23.62"	24"
AD-S 80800	26' 5"	880	21'	189	16	165	Hydro-Mech	27.56"	16"	31.5"	4' 4"	15.75"	24"
AD-S 801000	26' 5"	1100	21'	165	11	141	Hydro-Mech	31.5"	16"	31.5"	5' 3"	19.68"	24"
AD-S 801250	26' 5"	1375	21'	165	16	165	Hydro-Mech	31.5"	20"	35.4"	5' 11"	19.68"	24"
AD-S 801600	26' 5"	1760	21'	165	14	165	Hydro-Mech	39.37	20"	35.4"	5' 11"	23.62"	24"
AD-S 802000	26' 5"	2200	21'	165	14	141	Hydro-Mech	39.37	28"	37.4"	6' 11"	23.62"	29"



JMT AD-S PRESS BRAKE TECHNICAL DIMENSIONS (Continued)

AD-S SERIES Model	Sliding Support Arms	B.G. Finger Blocks	Gauging Axes <i>Standard</i>					Motor Power (HP)	Oil Tank Capacity (Gallons)	Overall Dimensions			Weight (Approx. Lbs.)
			X-Axis Speed (IPM)	X-Axis Travel	Gaugeable with 3rd Positon	R Max. Speed (IPM)	R-Axis Travel			Length [L]	Width [W]	Height [H]	
AD-S 1260	2	2	1200	25.6"	39.6"	827	9.85"	10	27	7' 7"	4'	7' 9"	6,840
AD-S 2060	2	2	1200	25.6"	39.6"	827	9.85"	10	27	10' 6"	4'	7' 9"	7,830
AD-S 25100	2	2	1200	25.6"	39.6"	827	9.85"	15	27	12' 6"	5' 6"	9'	19,580
AD-S 30100	2	2	1200	25.6"	39.6"	827	9.85"	15	27	13' 10"	5' 6"	9'	20,900
AD-S 30135	2	2	1200	25.6"	39.6"	827	9.85"	20	40	13' 10"	5' 6"	9'	23,100
AD-S 30175	2	2	1200	25.6"	39.6"	827	9.85"	25	66	14'	5' 7"	9'	25,300
AD-S 30220	2	2	1200	25.6"	39.6"	827	9.85"	30	66	14'	5' 10"	9' 6"	27,500
AD-S 30320	2	2	1200	25.6"	39.6"	827	9.85"	50	66	14' 2"	6'	10' 8"	38,500
AD-S 37175	2	2	1200	25.6"	39.6"	827	9.85"	25	66	16' 3"	5' 7"	9' 6"	28,600
AD-S 37220	2	2	1200	25.6"	39.6"	827	9.85"	30	66	16' 3"	5' 10"	9' 6"	31,592
AD-S 40175	2	2	1200	25.6"	39.6"	827	9.85"	25	66	17' 3"	5' 7"	9'	28,820
AD-S 40220	2	2	1200	25.6"	39.6"	827	9.85"	30	66	17' 3"	5' 10"	9' 6"	33,000
AD-S 40320	2	2	1200	25.6"	39.6"	827	9.85"	50	66	17' 5"	6' 4"	10' 8"	46,200
AD-S 40400	2	2	827	29.5"	43.5"	709	9.85"	50	120	18' 11"	6' 11"	11' 7"	59,400
AD-S 40600	2	2	827	29.5"	43.5"	709	9.85"	60	132	18' 7"	10' 8"	12' 7"	89,100
AD-S 43175	2	2	1200	25.6"	39.6"	827	9.85"	25	66	18' 3"	5' 7"	9' 6"	30,320
AD-S 43220	2	2	1200	25.6"	39.6"	827	9.85"	30	66	19' 4"	5' 10"	9' 6"	37,835
AD-S 43320	2	2	1200	25.6"	39.6"	827	9.85"	50	66	19' 11"	6' 4"	10' 8"	47,900
AD-S 43400	2	2	827	29.5"	43.5"	709	9.85"	50	120	20'	7' 10"	11' 7"	65,480
AD-S 60220	4	4	827	29.5"	43.5"	709	9.85"	30	66	24' 8"	7' 9"	10' 8"	45,848
AD-S 60320	4	4	827	29.5"	43.5"	709	9.85"	50	66	24' 8"	6' 4"	11' 4"	62,700
AD-S 60400	4	4	827	29.5"	43.5"	709	9.85"	50	132	24' 8"	6' 11"	12' 2"	79,200
AD-S 60600	4	4	827	29.5"	43.5"	709	9.85"	60	132	25'	8' 9"	12' 8"	118,800
AD-S 60800	4	4	827	29.5"	43.5"	709	9.85"	75	200	26' 5"	10' 6"	12' 11"	158,400
AD-S 70800	4	4	827	29.5"	43.5"	709	9.85"	75	200	28' 7"	10' 6"	12' 11"	174,900
AD-S 701000	4	4	709	39.4"	53.4"	591	9.85"	75	264	28' 11"	10' 8"	19' 4"	210,100
AD-S 701250	4	4	709	39.4"	53.4"	591	9.85"	120	330	28' 11"	10' 8"	21'	242,000
AD-S 80800	4	6	709	29.5"	43.5"	709	9.85"	75	200	32' 2"	10' 6"	12' 11"	187,000
AD-S 801000	4	6	709	39.4"	53.4"	591	9.85"	75	264	32' 10"	10' 8"	19' 4"	224,400
AD-S 801250	4	6	709	39.4"	53.4"	591	9.85"	120	330	32' 10"	10' 8"	21'	297,000
AD-S 801600	4	6	709	39.4"	53.4"	591	9.85"	120	330	33' 2"	11' 6"	23'	358,600
AD-S 802000	4	6	709	49.25"	63.25"	591	9.85"	150	530	34' 6"	14' 4"	26' 7"	547,800

The above are standard specifications.*

Please contact us for other sizes and options:

- Bed lengths to your specifications
- Custom distance between frames
- Extra throat depth (up to 60")
- Extra open height
- Extra stroke
- Longer back gauge travel
- Tandem/Triple/Quad machine configurations for increased bending length

All readily available.

**Due to ongoing product development, specifications are subject to change.*

***JMT* AD-SERVO HYBRID SERIES**

- **5-14+ Axis CNC**
- **110, 150, 195 Tons**
- **8'-10' Bending Lengths**
- Increase your competitive forces by 62% lower power consumption
- Lower cost per part by ecological technology
- Quiet, energy efficient and accurate
- Ram movement is powered by AC Servo motors driving hydraulic oil in line with variable speed pump.

New technology allows :

- Silent bending
 - Noise level reduced to 63 dbA from 76 dbA
- Energy saving
 - 62% at stand-by
 - 44% during the press cycle
 - 60% in 1 hour with 15 press cycles
- Supports your production cost efficiency and increases your competitive forces.
- Small hydraulic oil tank for clean environment and cost reduction
 - New technology reduces hydraulic tank from 60 gallons to 2 x 10 gallons
- Speed and accuracy and synchronization
 - Beam speeds to 472" per minute (higher with optional safety laser guarding)
 - 5.6 times better synchronization in high speed mode (Y1/Y2)



JMT AD-SERVO PRESS BRAKE STANDARD EQUIPMENT

JMT AD-SERVO Hybrid Series press brakes are manufactured with exceptionally large stroke/daylight combinations as well as high speed ram and back gauge positioning. The production of deep boxes and other parts requiring large clearances are produced with ease. The AD-SERVO Series is truly a machine for fast and accurate production of precision parts; simple, complex, large or small.

- 5 axis CNC:
 - Y1, Y2 precision ram positioning (twin electro/hydraulic drive)*
 - X, R precision servo-driven back gauge
 - CNC motorized wave crowning
- Large trio of value:
 - Large open height
 - Large stroke
 - Large throat depth
- Delem DA-66T touch screen CNC control unit with 3D graphical visualization (see optional controls below)
- American/European section-style box punch clamps
- Standard X-axis travel is 25.6" with third gauge step capable of gauging parts up to 39" with standard back gauge (most machines)
- Stable and fast AC servo motor-driven precision back gauge with linear guide and ball bearing system (X - R)
- Quick-set sliding front sheet support arms with full-length linear guide, tilting stop and T-slot (front gauging squaring, etc.)
- Protection covers (side and rear safety doors)
- Rear work light
- Specially-designed electro-hydraulic operation (Rexroth)
- World-class electronics system (common, off-the-shelf components)
- High-yield plate construction
- Ability to accurately fade ram
- Stage bending
- Automatic bend sequence determination
- Automatic stretch length calculator for blank size determination



- * Two direct-acting servo motors for ram positioning where each cylinder operates independently in a closed loop system. Linear encoders are mounted on a separate sub-frame on each side of the machine. These encoders combined with precision servo-hydraulic valves and the CNC command center, provide accuracy of $\pm$ one Micron (0.00004") and the ability to program all ram positions, ram speeds and ram tilt. The decompression point is also programmable, which, along with programmable speeds is very useful when bending large sheets or high-yield material.

JMT AD-SERVO PRESS BRAKE OPTIONAL EQUIPMENT

- Safety laser: AKAS-LC manual or motorized
- Light curtain: SICK C 4000 for tandem/trio/quad machines
- Robotics
- Adaptive bending sensors
- Multiple axes available:
 - Z1, Z2 Axes
 - X1, X2 Axes
 - R1, R2 Axes
 - Delta X axis, +/- 5" stroke (10" total)
 - X Axis = 39.4" travel - Back protection with light barrier
 - AP3-AP4 Sheet follower with sliding guide - motorized height adjustment
- Other CNC control units available:
 - Delem DA-69T touch screen 2D/3D CNC control
 - Cybelec ModEva 10S/12S/15S 3D with PC 1200 3D SW
- Clamping:
 - Quick Release Clamping
 - JMT Hydraulic or Mechanical Clamping
 - Wila or Wilson Hydraulic or Mechanical Clamping
- Various tool options (JMT, Euro-American, Wila or Wilson)
- Bottom tool positioning system
- Thickness measurement systems
- Offline software (V-Bend, Profile-W)
- Tooling packages

Many options and customizations are available — please contact us for details.

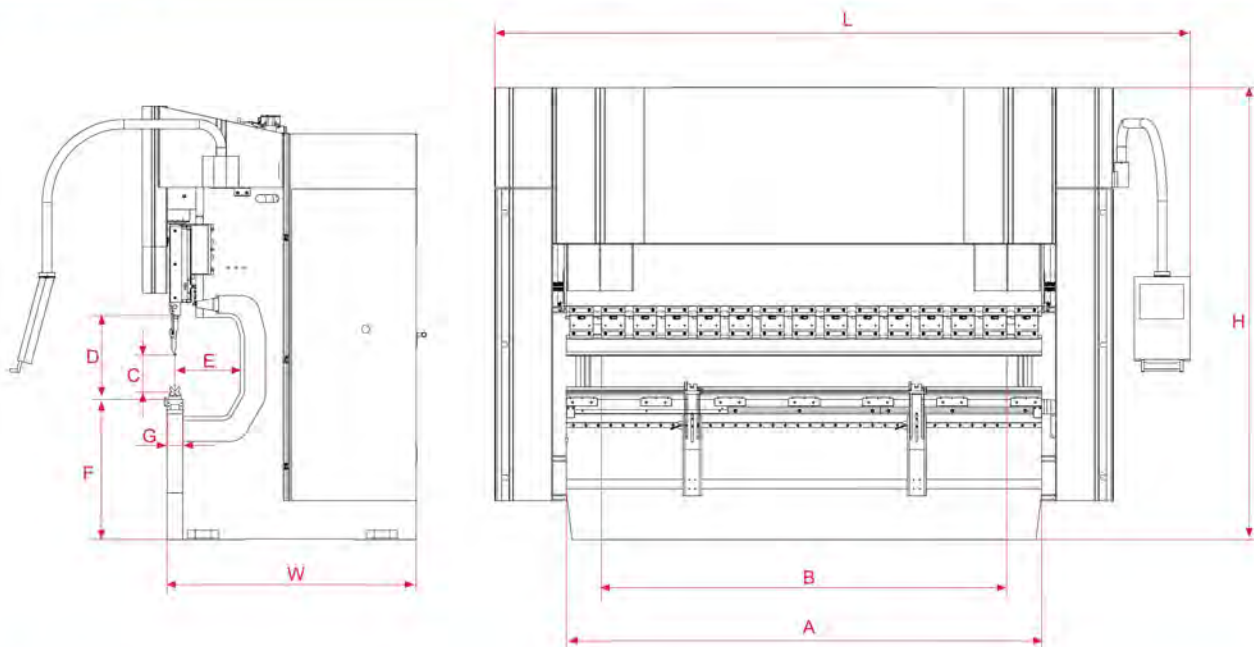
Web: **JMTUSA.com**

Email: **JMT@JMTUSA.com**

Call Toll Free: **855-773-7727**
(855-PRESS-BRAKE)

JMT AD-SERVO PRESS BRAKE TECHNICAL DIMENSIONS

AD-SERVO Series		25100	30100	30135	30175
Bending Length [A]		8' 4"	10'	10'	10'
Bending Force		110 Tons	110 Tons	150 Tons	192 Tons
Distance between Frames [B]		7' 2"	8' 6"	8' 6"	8' 6"
Y-Axis Speeds	Y-Axis Rapid Speed (Inches per Minute)	473	473	473	425
	Y-Axis Working Speed (Inches per Minute)	24	24	24	24
	Y-Axis Return Speed (Inches per Minute)	473	473	425	378
	CNC Crowning <i>Standard</i>	Motorized	Motorized	Motorized	Motorized
	Daylight [D]	20¾"	20¾"	20¾"	20¾"
Bed Cap Width [G]		4"	4"	4"	4"
Bed Height [F]		35½"	35½"	35½"	35½"
Depth of Pit		—	—	—	—
Stroke [C]		10½"	10½"	10½"	10½"
Throat Depth [E]		16"	16"	16"	16"
Sliding Support Arms (Quantity)		2	2	2	2
Back Gauge Finger Blocks (Quantity)		2	2	2	2
Gauging Axes <i>Standard</i>	Speed of Travel in X-Axis (Inches per Minute)	1200	1200	1200	1200
	Travel in X-Axis	25½"	25½"	25½"	25½"
	Gaugable with 3rd Position	39.6"	39.6"	39.6"	39.6"
	Speed of R-Axis (Maximum Inches per Minute)	826	826	826	826
	Travel in R-Axis	10"	10"	10"	10"
Motor Power		2 x 28 HP	2 x 28 HP	2 x 30 HP	2 x 40 HP
Oil Tank Capacity		21 Gallons	21 Gallons	21 Gallons	31 Gallons
Overall Dimensions	Length [L]	12' 6"	13' 10"	13' 10"	14'
	Width [W]	5' 6"	5' 6"	5' 7"	5' 7"
	Height [H]	9'	9'	9'	9'
	Weight (Approx.)	19,625 Lbs.	20,945 Lbs.	23,150 Lbs.	25,355 Lbs.



The above are standard specifications.* Please contact us for other sizes and options.

**Due to ongoing product development, specifications are subject to change.*

***JMT* FBS (FLEXIBLE BENDING SOLUTIONS)**

- Advanced technologies for bending large sheet metal for extremely diversified uses in the different industries while avoiding long, expensive welding operations which even takes the risk of material stability.
- FBS focuses also to minimize the large work pieces' handling before, during and after the bending operations and respects the next process. This offers:
 - Flexibility of bending varies for diversified uses
 - Accuracy for large and high spring-back sheets
 - Lowers setup times by automation of loading & unloading
 - Increases your employees' safety
- On high tonnage mega press brakes "box construction" frame is used which is the most stable machine body in the world utilized technology for press brakes. Stability and rigidity of box constructions is approved by our references all around the world and finite element analysis by our 50 in-staff engineers.
- JMT can provide you with all the support Flexible Bending Solutions and offer to the turnkey automatic bending cells complete with facility for loading and unloading.



JMT FBS PRESS BRAKE CUSTOM MADE PROJECTS



JMT AD-S 812000 Tandem

Loading Unloading System • Front Feeding System with Pneumatic Pushers • Light Pole Industry – Unmanned Production



JMT AD-S 911000 Tandem

Loading Unloading System • Front Feeding System with Pneumatic Pushers • Light Pole Industry – Unmanned Production



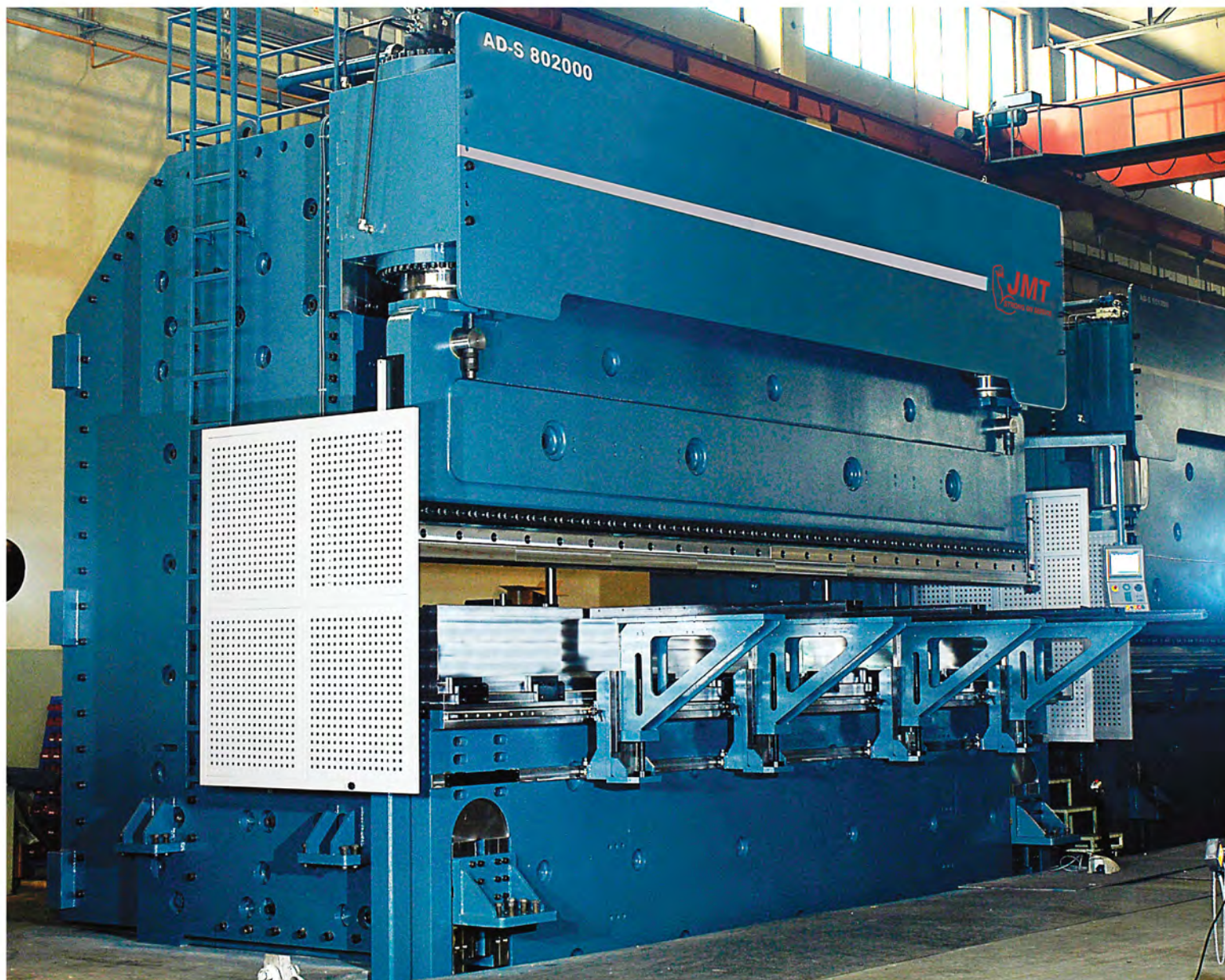
JMT AD-S 60400 Tandem

Motorized Front Feeding System • Light Pole Industry



JMT AD-S 80800 & JMT AD-S 40400 in Tandem

Dump Truck Industry



JMT AD-S 802000 (Defense Industry)



JMT AD-S 40400 Trio (Steel Service Industry)



JMT AD-S 1051500 (Special Hydraulics Front Support System, Steel Service Industry)



JMT AD-S 45220 Tandem with AP3 AP4 Sheet Followers



JMT Robotized Press Brakes



3/4" Thick Special Steel ArmoX for Defense Industry

JMT FBS PRESS BRAKE FEATURES

Light Pole Pull-Out Systems



Side Pull-Out System



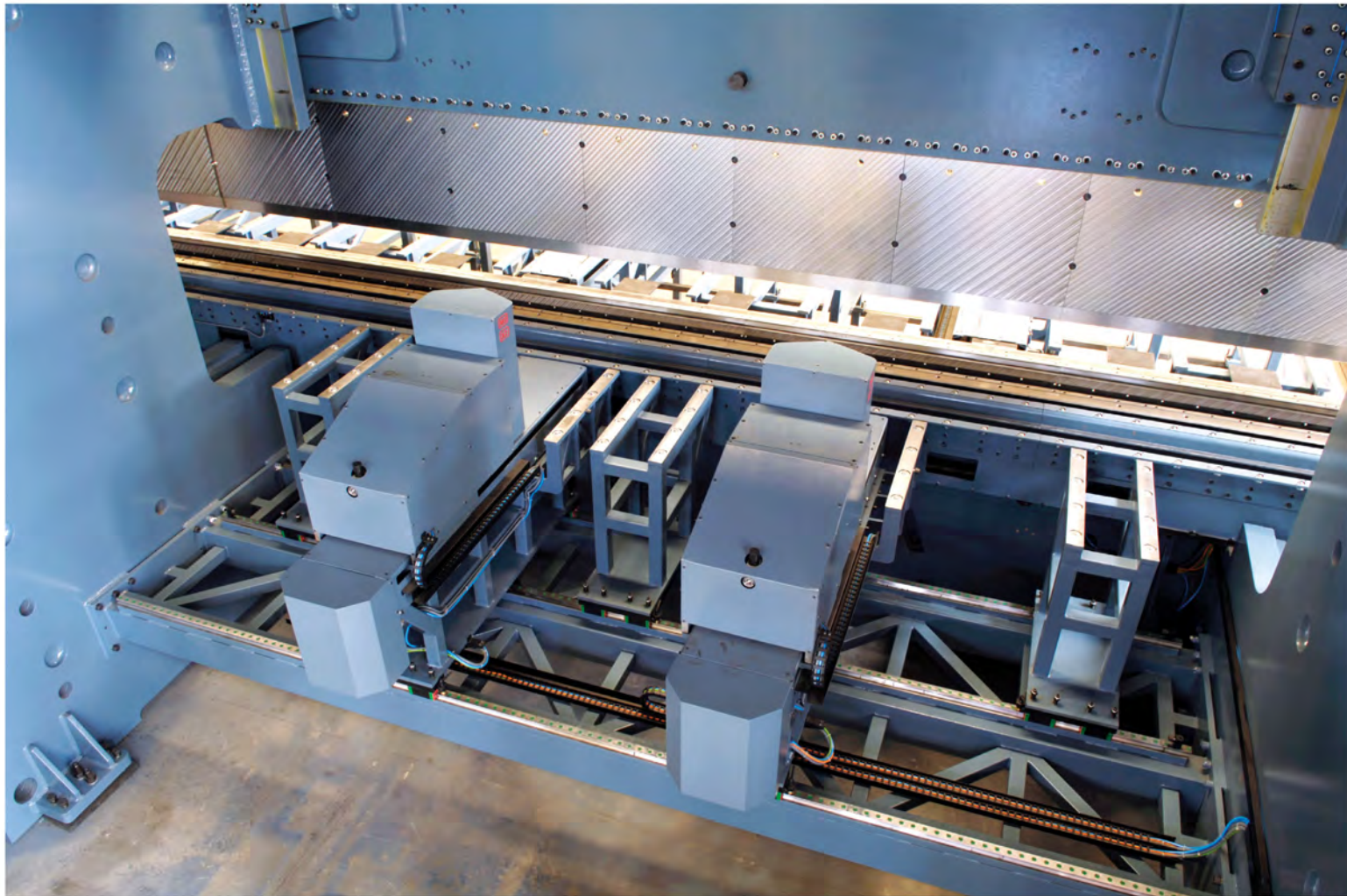
Bottom Pull-Out System



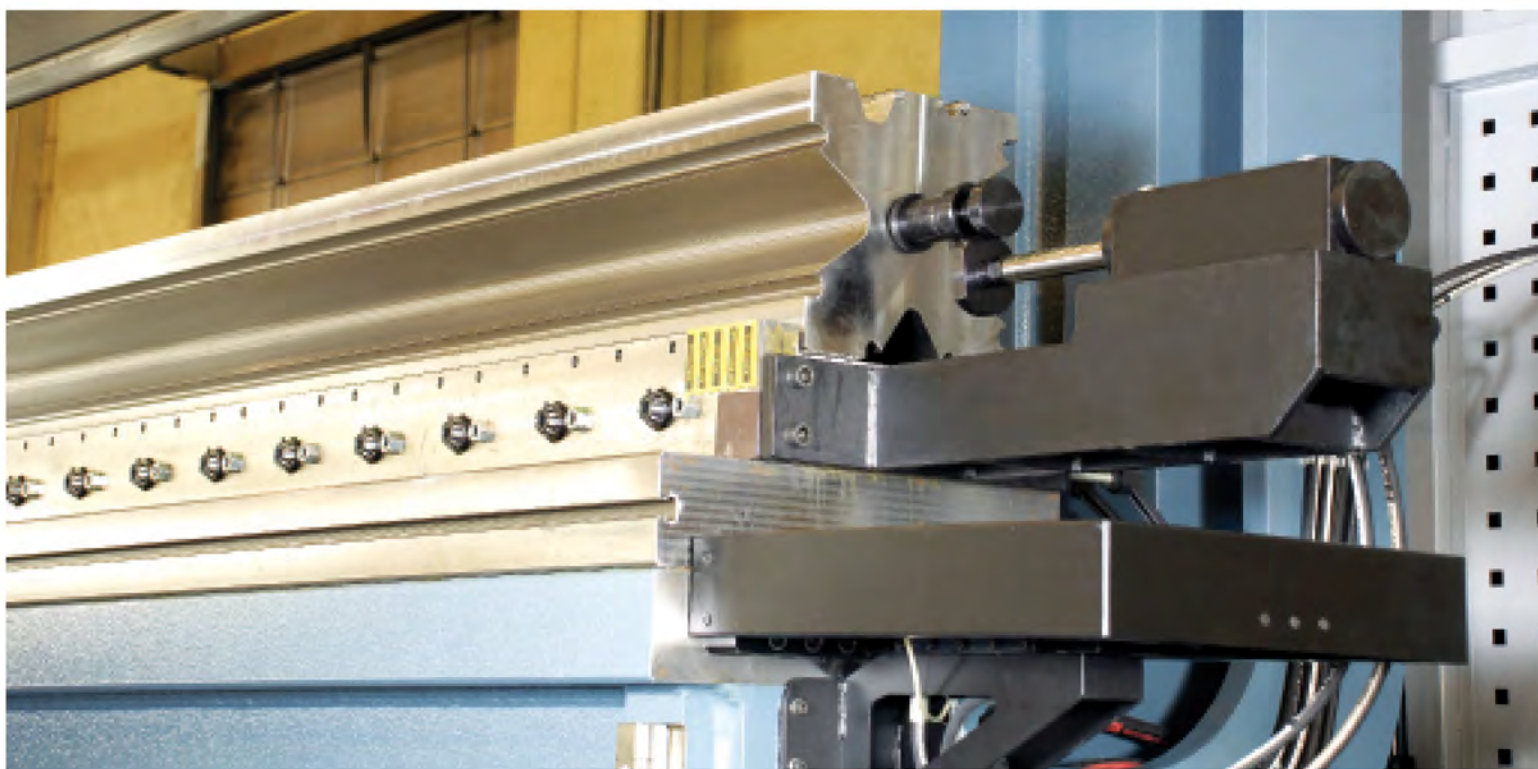
Special Hydraulic Front Support System



Road Barriers Industry

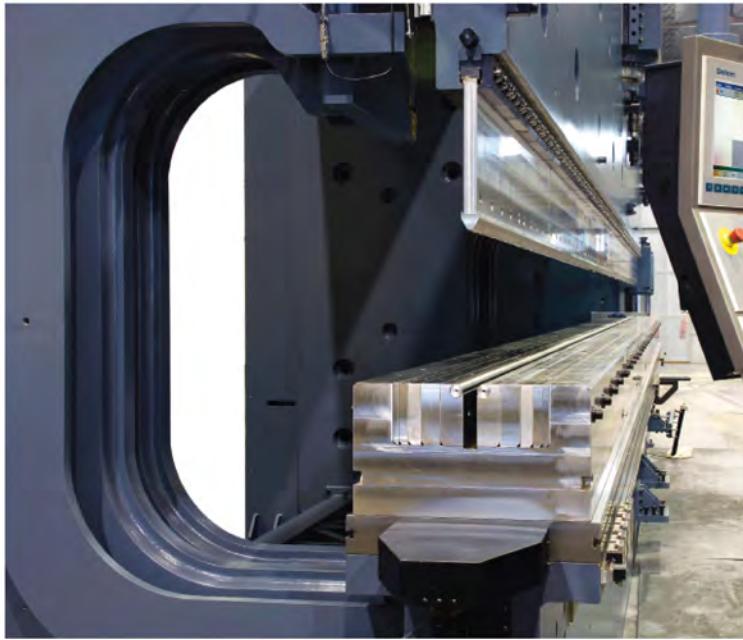


Special Back Gauge X1/X2 with Pneumatic Pushers



Hydraulic Bottom Tool Separation System

JMT FBS Press Brake Bottom Tool Adjustable Systems



Bottom Tool Lamel Adjustable System



Bottom Tool CNC Adjustable System (Multi-V)



Bottom Tool Motorized Adjustable System



Bottom Tool Manual Adjustable System



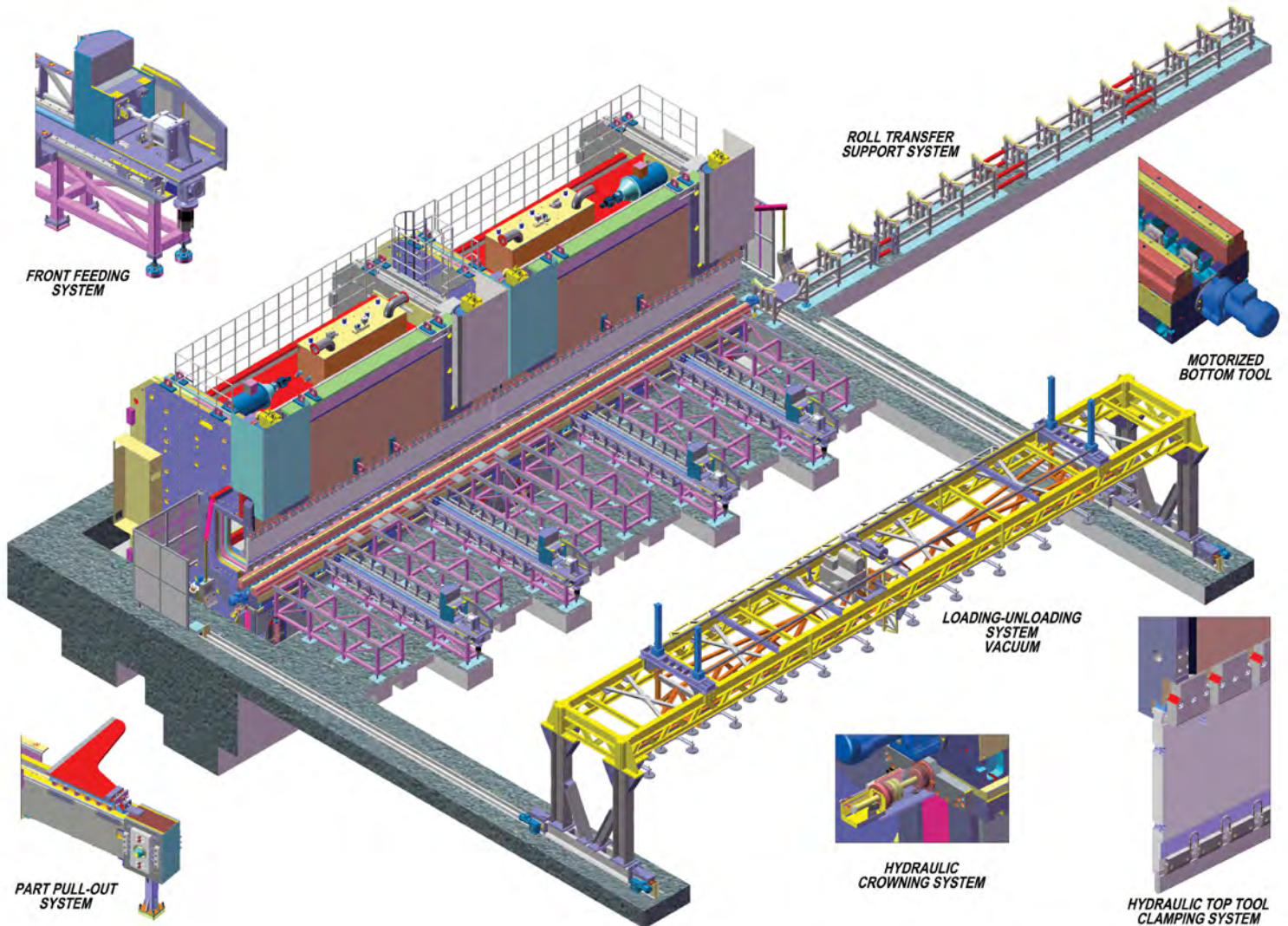
Robust Box Construction

On high tonnage mega press brakes "box construction" frame is used which is the most stable machine body in the world utilized technology for press brakes. Stability and rigidity of box constructions is approved by our references all around the world and finite element analysis on the computers.



Piston Production

Hydraulic pistons are produced with precise CNC machining centers in one shot without reposition.





Frame Machining Tandem - Trio – Quad Press Brakes

CNC precise processing applied for all frames at one time without repositioning for tandem, trio and quad press brakes.



AD-S 801000 Bottom Beam Machining



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(855-PRESS-BRAKE)

