

折弯压力表 LIST OF BENDING PRESSURES

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	31	35	38	42	46	49	56	63	70	85	
R	0.7	1	1.3	1.6	2	2.3	2.6	3	3.03	3.8	4.5	5	6	6.5	7	8	9	10	11	11	13	14	16	19	
S	0.5	40	30																						
	0.6	60	40	30	30																				
	0.8	70	50	40	30																				
	1	110	80	7	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	200												
	4								440	370	330	290	260	260	210										
	4.5									470	410	370	330	300	270	250									
	5										510	450	400	360	330	300	270	250							
	6														520	470									
8																700	640	600	520	460	420				
10																					810	720	650		
12																							950	780	
14																								1300	1100

This chart is calculated according to the plate of tensile strength σ_s , the plate of tensile strength σ_s , 450N/mm² and length L=1m. The force can be got according to the proportion while different kind of plate and different length to be bent.

本表数值上以材料强度 σ_s 450N/mm² 及长度 L=1m 计算所需的折弯力可按相应的比例计算而得。

可选配的数控系统 MAIN DISPOSITION DETAILED LIST



DA-69W
荷兰DELEM公司
Netherlands DELEM

1. Windows 操作平台, 内置 PLC, 12" 彩色液晶显示;
2. 完整 Windows 组件 (互联网, 邮件, PDF 浏览);
3. 2D / 3D 图形编程, 工件与模具图形绘制, 防撞检测, 自由设定材料参数;
4. 折弯压力, 工作会变形补偿, 压底折弯力, 大圆弧折弯, 展开长度自动计算;
5. 角度校正数据库, 多国语言选择, 手轮移动所有轴;
6. 数据备份, 恢复, 支持用户专业应用。



DA-51W
荷兰DELEM公司
Netherlands DELEM

1. Windows 操作平台, 内置 PLC, 10.4" 彩色液晶显示;
2. 2D 图形编程, 工件与模具图形绘制, 防撞检测, 自由设定材料参数;
3. 折弯压力, 工作会变形补偿, 压底折弯力, 大圆弧折弯, 展开长度自动计算;
4. 角度校正数据库, 多国语言选择, 手轮移动所有轴;
5. 数据备份, 恢复, 支持用户专业应用。



DA-41
荷兰DELEM公司
Netherlands DELEM

1. 运用伺服控制技术;
2. 4.7" 高亮液晶显示屏, 包括中文在内的多国语言界面;
3. 模具参数设置, 折弯角度编程;
4. 可存储 100 道程序, 每个程序 25 个工步;
5. 送料可编程, 加工数量计数, 断电记忆, 公英制转换。



DA-56
荷兰DELEM公司
Netherlands DELEM

1. 10" color LCD display, the storage capacity of 32M, mold information storage capacity of 2M data backup;
 2. 2D graphics programming and display graphically the bending process definition, anti-collision detecting;
 3. Free to set the material parameters, free graphics preparation of the die angle correction database;
- Bending pressure workbench deformation compensation, the bending force, pressure at the end arc bend, expand the length of the automatic calculation.



E10

1. 后挡料单向间隙提示;
2. X/Y 轴丝杆螺距误差补偿;
3. 软限位功能;
4. 时间继电器功能;
5. 计数功能。

1. backgauge clearance prompted a one-way;
2. X/Y-axis screw pitch error compensation;
3. soft limit function;
4. Time relay function;
5. counting functions.



E20+

1. 运用变频控制技术;
2. 电动后挡料和上滑块自动定位;
3. 单向定位, 消除丝杆传动间隙;
4. 多道程序自动运行, 加工数量自动计数;
5. 断电记忆, 公英制转换。

1. The use of variable frequency control technology;
2. electric block the automatic positioning of the material and on the slider;
3. way positioning to eliminate the gap of screw drive;
4. multi-channel program to run automatically, the automatic counting of the number of processing;
5. Power and memory, Inch / metric conversion.



DA-51
荷兰DELEM公司
Netherlands DELEM

1. 6" 液晶显示屏, 多国语言显示, 金属外壳;
2. 最多可存储 500 道程序, 模具库可存储 30 副上模和 30 副下模;
3. 一页制表式编程, 折弯压力, 工作会变形补偿, 压底折弯力自动计算;
4. 角度校正功能, 自由设定材料参数, 断电记忆。

1. 6" LCD screen, multi-language display, metal casing;
2. can store up to 500 procedures, tool library can store 30 of the upper die and lower die 30;
3. A tabulation programming, bending stress, table deformation compensation, the bending force automatically calculate the pressure at the end;
4. Angle correction function is free to set the parameters of materials, power and memory.



MD11-1

1. 操作简单: 本系统具备 10 个工步的编程, 可随时更改不同的尺寸;
2. 手动功能: 方便调试安装, 用手动模式调整所需尺寸;
3. 后让功能: 此功能为本系统独有, 直接控制电机, 技术方面, 要达定位更定位的准确性, 以及电机的耐用性, 拥有本公司独有的技术和配件;
4. 参数的设定功能: 系统具有参数的修改功能, 根据机床的机械性能具体性, 修改着依的参数设置, 参数包括: 转动系数, 减速距离, 慢速时间, 前段软限位等;
5. 适用于折弯机单独控制后挡位。

1. Easy: The system has a 10-step programming subject to change in different sizes;
2. Manual function: to facilitate debugging installation, use manual mode to adjust the size required;
3. Back let function: This function-based system unique to the direct control of the motor, technical aspects, to achieve the repeated positioning accuracy, and durability of electrical appliances, the only sound technologies, and supporting the Company;
4. Parameter setting function: the system has modified function of the parameters, according to the machine's mechanical properties, modify the optimal parameter settings, parameters: rotation coefficient, deceleration distance, slow time, before and after the soft limit;
5. applies to the bending machine single-axis control gear.



MD20-F
带模具库折弯机控制系统
Bending machine with a mold library control system

1. 系统采用 240 × 128 液晶显示, 中文画面, 数字输入, 不代代码;
2. 控制轴数为二轴 (折弯机: 即 Y 轴和 X 轴);
3. 控制精度 Y 轴 0.03mm, X 轴为 0.1mm;
4. 可编程序: 系统具备 10 组程序, 每组程序有 20 个工步;
5. 后让功能;
6. 单向功能: (消除丝杆间隙);
7. 系统采用 12VAC 电源。

1. System uses 240 × 128 LCD, Chinese screens, digital input, do not code;
2. Control axis is two axis (bending machine: the Y axis and X axis);
3. Control accuracy of the Y-axis 0.03mm, X axis is 0.1mm;
4. programmable: The system is equipped with 10 set of programs, each group program has 20 working steps;
5. Back function;
6. one-way functions: (remove screw clearance);
7. System uses a 12VAC power supply.



MD-320

1. 运用伺服控制技术;
2. 电动后挡料和上滑块自动定位;
3. 全中文操作界面, 直观易懂;
4. 多道程序自动运行, 加工数量自动计数;
5. 挡料自动退让。

1. The use of servo control technology;
2. electric block the automatic positioning of the material and on the slider;
3. Chinese operation interface, easy and intuitive;
4. multi-channel program to run automatically, the automatic counting of the number of processing;
5. Backgauge automatically concessions.