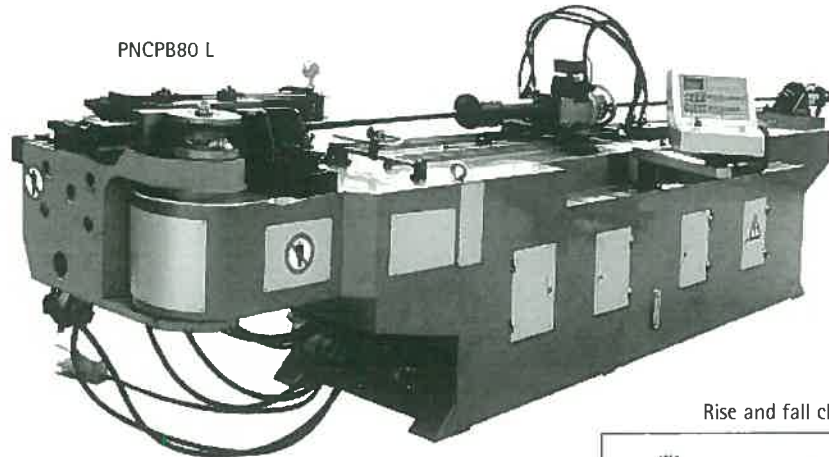


## PNCPB Two Axis Hydraulic Tube and Profile Benders

Two axis NC tube benders with B (Rotation) and C (Bending) under NC control. Ideal for low volume work where CNC accuracy is required.

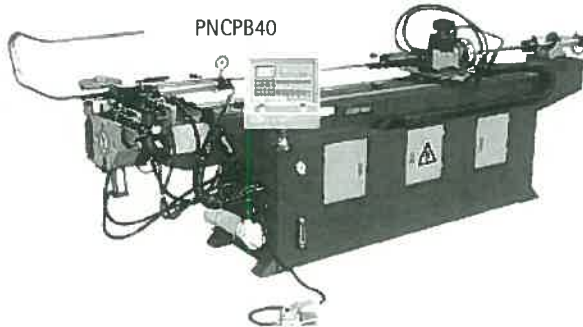
PNCPB80 L



Rise and fall clamp system



PNCPB40



PNCPB52



### Overview

Very easy to programme through a touch screen PLC control with graphic guidance to perform mandrel bends. Cycle would be as follows: Insert tube over the mandrel into the collet. Move carriage manually back to the first stop. Step on foot switch, clamp and pressure die comes in. Tube is bent to the pre-programmed angle. Mandrel retracts, clamp and pressure die opens. Operator moves the carriage manually to the next stop, the bend die returns to zero, the B axis rotates to the pre-programmed angle and the mandrel moves forward and the cycle repeats itself. Ten bends can be pre-programmed and performed in sequence. 100 programmes with ten bends each can be saved in the memory.

SPECIFICATION	UNIT	PNCPB18	PNCPB40	PNCPB52	PNCPB65	PNCPB80
Max Round Tube Mild Steel	mm	1.8 x 2	38.1 x 2	50.8 x 3	63 x 3	80 x 3
Non Ferrous	mm	20 x 2	38.1 x 4	50.8 x 5	63 x 6	80 x 6
Stainless Steel	mm	19 x 0.8	38.2 x 1.2	80.8 x 1.8	63 x 2	80 x 1.8
Square Tube Mild Steel	mm	15 x 15 x 1.2	30 x 30 x 2	40 x 40 x 2.5	50 x 50 x 2	60 x 60 x 2
Solid Bar	mm	8	20	25	30	40
Min/Max Bend Radius	mm	10 ~ 80	25 ~ 200	35 ~ 250	50 ~ 300	50 ~ 350
Spindle Diameter	mm	20	40	45	55	60
Clamp Stroke	mm	40	50	118	110	90
Pressure Slide Stroke	mm	50	50	65	90	90
Follower Slide Stroke	mm	118	300	410	360	500
Mandrel Stroke	mm	40	80	80	160	200
Max Bend Angle	Deg	190	190	190	190	190
Max Length Over Mandrel	mm	2000	3200	3000	3000	3000
Working Height	mm	1100	1000	1000	1000	1100
Tooling Centreline Height	mm	44	45	45	55	65
DOB (Bending Speed)	Deg / Sec	150	65	44	24	16.5
Accuracy of DOB	+/- Deg	0.3	0.3	0.3	0.3	0.3
POB (Rotation Speed)	Deg / Sec	160	140	140	70	60
Accuracy of POB	+/- Deg	0.3	0.15	0.15	0.15	0.3
Hydraulic Motor	Kw	1.5	4	5.5	7.5	11
Total Power	Kw	1.5	4.5	6	8	11
Hydraulic Pressure	Bar	80	120	120	140	130
Hydraulic Tank Capacity	L	60	150	160	175	220
Machine Length	mm	3000	3900	4800	4900	5900
Machine Width	mm	800	750	750	900	1100
Machine Height	mm	1450	1200	1200	1300	1300
Machine Weight	Kg	1200	2000	2800	3000	3000



PNCPB65



### Standard Features

- Anticipated mandrel retraction unit
- Mandrel lubrication unit
- Powered follower slide
- Water hydraulic cooler
- Rise and fall clamps
- Safety systems

### Optional

- Bend tooling
- Left hand bending (L)