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Masteel MBHSA CNC Synchronized Hydraulic Press Brake

Specifications	
Maximum Capacity	280 ton
Maximum Bending Length	12'
Distance Between Frames	122"
Height of Bed	36"
Bed Below Floor	-
Depth of Throat	12-3/4"
Length of Ram Stroke	8"
Fast Approach Speed	215”/minute
Press Speed	19”/minute
Fast Return Speed	188”/minute
Maximum Open Height	17-1/8"
Main Motor	20 hp
Back gauge Travel	28"
Weight	31,500 lbs.
Length x Width x Height	150” x 60” x 108”

MBHSA-12280	**$132,590**
Options	Price
Powered Z1 & Z2 Control	$3,300

Masteel CNC brakes and shears are built with quality North American made components and assembled in Delta, British Columbia, Canada. Service parts are available from local industrial suppliers at local supplier’s regular pricing without the need to pay for and wait for parts from overseas.

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Vancouver Head office: 7490 MacDonald Rd, #120 Delta, British Columbia V4G 1N2 604-952-4434

Edmonton Office: Metric Machine tool Service - A Division of Masteel, 854 78 Avenue, Edmonton, Alberta T6P 1L7 780-466-4693

Toronto Office: 940 Winston Churchill Boulevard, Oakville, Ontario L5T 1A3 905-845-4434

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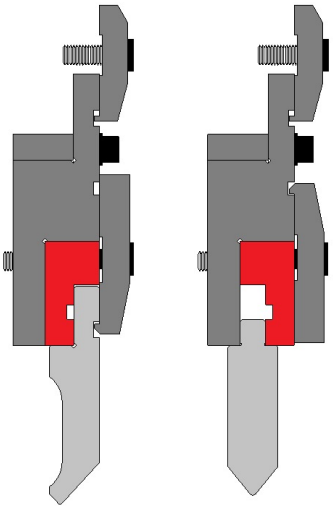
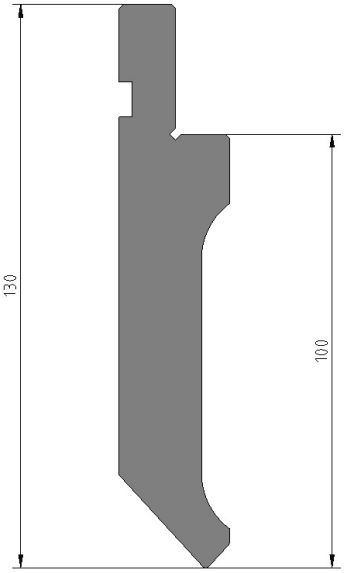
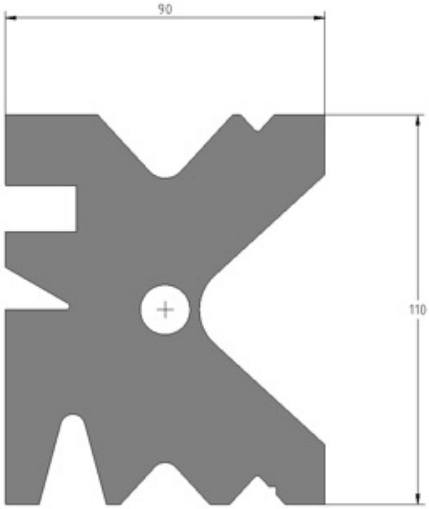
Standard Tooling Included in Price



Combination European/North American Punch Holder

Standard Gooseneck Punch
MP0 – G915EQ – 25.5x100
R1/85 or R2/85





MASTEEL MD-4W5-110x090 4 WAY DIE

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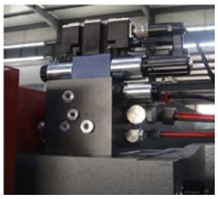
Control Features

- Standard SIEMENS TP-700 control with 7” touch screen display.
- SIEMENS CNC control with Y1/Y2/X/R/Z1/Z2 position control, R and Z1/Z2 axis as options.
- Ram bending position control – Y1/Y2 axis:
  - Y1, Y2 programmable independently in angle or position.
  - Ram tilt capacity at ±0.5”.
  - Bosch-Rexroth closed-loop proportional hydraulic position control: repeatability at ±0.0006”.



Bosch-Rexroth Hydraulic Control

Standard Masteel Back Gauge

- Servo driven back gauge position control:
  - Standard CNC back gauge: Speed at 400 IPM; Repeatability at ± 0.00’’.
  - Optional R axis CNC control.
  - Optional CNC Z1/Z2 axis or power operated Z1/Z2 axis.
  - Programmable back gauge retract feature.
  - 3-step finger position with automatic offset on X axis.

- Two way angle corrections - allow inexperienced operator to achieve desired angles without multiple test bends.
  - Input of the difference from desired angle to test bending, control will automatically adjust the bending position to achieve desired angle.
  - Adjust bending position with Y axis incremental per degree calculated by control system.
- Dual ram position feedback with hydraulic synchronized control allow bending at one end of brake for deep box
- Tool memory for quick recall of tool setup
- 200 job memory, with an average of 30 bends per program.
- Programmable tonnage control
- Programmable ram delay and programmable tonnage at the bending position for bump bending or heavy bending applications
- Automatic maintenance schedule reminders
- Operating prompts and troubleshooting messages
- Inch / mm conversion

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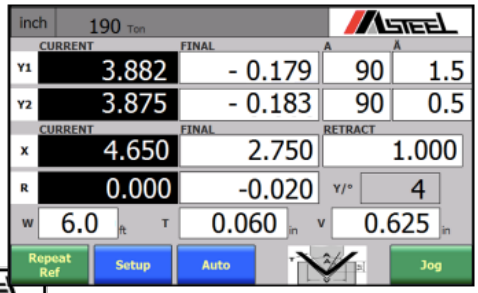
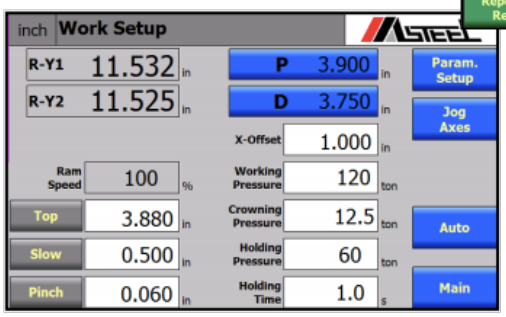
Operating Function

- Ram speed control:
  - Rapid approach and return speed.
  - Slow bending speed for accuracy control.
  - Programmable bending speed.
- Ram stroke control:
  - Programmable ram top stop limit for more efficient production.
  - Programmable slow working speed position.
  - Programmable second stop position.
- Four Operating Modes:
  - Jog mode: Inching control of the ram for tool setup.
  - Single mode: One full bend cycle per control input.
  - Double stop mode: Ram stop above material and excellent for sight bend operations.
  - Follow bend mode: Ram jogging down/up with foot paddle and easy to follow bending and ram return on large sheets or with crane handling.



Standard SIEMENS TP-700 Control



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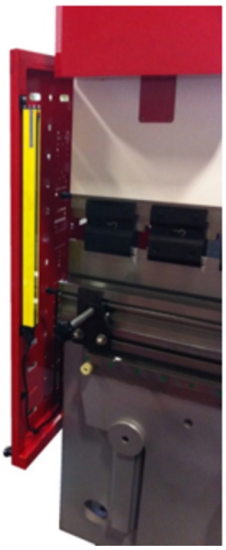
Standard Equipment

- Two axis back gauge:
  - X-axis, R-axis
  - 3-step precision-made back gauge fingers
- Fully equipped with Masteel tooling and clamping system:
  - Floating-adjustable die clamping system for various die applications. The fine alignments of horizontal tolerances in relation to the back gauge is for producing accurate flange lengths
  - Masteel reversible punch holder accommodates both American and European punches
  - Adjustable wedges on punch holder provide fine alignments for vertical tolerances in the press brake and tooling, which easily and effectively correct accumulated machine tolerance across the length of the whole machine, significantly extend the life span of press brakes.
  - Hardened and precision ground tool steel gooseneck punch: 53-58RC; 100Ton/M (33Ton/Ft) capacity.
  - Hardened and precision ground Masteel 8 openings, 4-way die: HB190-260.
- Deep throat depth with swing up clearance allows for full length bend over bed up to 12”.
- Two (2) Quick-Set front support arms.
- Central lubrication.
- Interlocking back guard.
- Safety light curtain
- 460 or 600V electrical.
- CNC servo crowning system for precise crowning and micro tuning with fully CNC controlled axis as YB marked in the red frame to automatically calculate the crowning setting and set-up correction by angle or position.

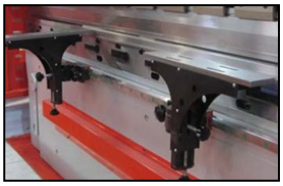
Safety Light Curtain



CNC Servo Crowning System

Interlocking Back Guard

Quick-Set Front Sheet Support Arms



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Optional Equipment

- Special top and bottom tools
- Hydraulic oil cooler
- NEMA 12 electrical cabinet
- WILA hydraulic top and bottom tool holding system
- CNC R-axis
- CNC Z1/Z2-axis or power operated Z1/Z2 axis
- Special throat depth (500, 600 and 750 mm)
- Laser protection system for die area

Optional Powered Z1 & Z2-Axis
Controlled from the Operator Stand

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Leasing Options Available

Terms and Conditions

Customer: Mr. Dave Stoneham
JMP Solutions
95 John Street, Unit 2
Orangeville, Ontario L9W 2R1
1-519-941-0005 extension 8120 / dstoneham@jmpsolutions.com

Price: All pricing is quoted in **Canadian Dollars**. Applicable taxes are extra.

FOB: Masteel, Oakville, Ontario.

Terms: 30% deposit with the balance due prior to pick-up.

Availability: To be confirmed at the time of purchase.

Warranty: *1 year Parts & Labour. Travel & accommodations are extra at cost.*

All electrics warranted by manufacturer. All parts are FOB Vancouver unless otherwise specified. All shipments are by ground transport. Fuses, wipers, and other normal wear items are not covered under this warranty.

Customer's responsibility:
- Pick-up the machine at the Masteel's Oakville warehouse in Ontario, Canada.
- Off-load the machine from the truck at the customer's site and place on shop floor.
- Supply electrical power to the machine.
- Supply hydraulic oil for the machine.

Masteel's responsibility:
- Level + commission the machine at the customer's site.
- One day of basic operator training.

This quote is valid for thirty (30) days.

We look forward to working with you on this project.

Sincerely,

Ron Nater
MASTEEL AMERICA CORPORATION

phone: 647.270.4434
email: ron@masteels.com
web: masteels.com / masteel.ca