

March 28, 2024

PL METAL FABRICATION LTD.

365 Deerhurst Drive, Unit #2
 Brampton, Ontario L6T 5K3

Attention: Ibrahim Yusuf / 416.888.5663 / Ibrahim@plmetal.ca

MASTEEL MBHS-12280 CNC SYNCHRONIZED HYDRAULIC PRESS BRAKE

Dear Ibrahim,

Thank you for the opportunity to quote the **MASTEEL MBHS-12280 CNC SYNCHRONIZED HYDRAULIC PRESS BRAKE** for your facilities in Brampton, Ontario.



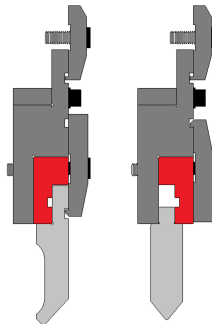
SPECIFICATIONS

maximum capacity	280 ton
maximum bending length	12'
distance between side frames	122"
bed height	36"
bed below floor	-
throat depth	12.75"
ram stroke	8"
fast approach speed	215" per minute
press speed	19" per minute
fast return speed	188" per minute
maximum open height	17.125"
motor	20 hp
back gauge travel	28"
machine weight	31,500 lbs.
machine width x depth x height	150" x 60" x 108"

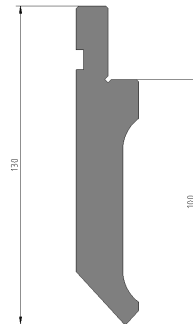
STANDARD EQUIPMENT

- tooling:
 - European or North American bolt clamping punch holder
 - gooseneck punch MP0-G915EQ-25.5x100 R1/85 or R2/85
 - Masteel 4-way die MD-4WS-110x090
- two-axis back gauge:
 - CNC controlled X-axis
 - manually adjusted 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 produces accurate flange lengths
 - Masteel bolt-on style punch holders accommodate both European and North American style 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 allowing for full length bend over bed

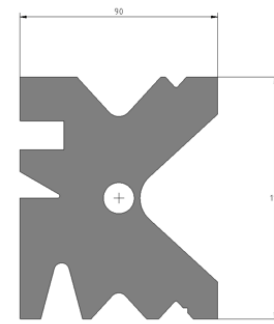
European or North American punch holders



MP0-G915EQ-25.5x100 R1/85 or R2/85 gooseneck punch



MD-4W5-110x090 4-way die





ESAUTOMOTION CNC S650 15" COLOUR TFT LCD CONTROL FEATURES

- 0.0004" high resolution linear scales provide precision dual ram position feedback
- Bosch-Rexroth closed-loop proportional hydraulic position control: repeatability at ± 0.0004 " and parallelism at ± 0.0004 "
- Y1, Y2 programmable independently in angle or position
- ram tilt capacity at ± 0.5 "
- hydraulic synchronized ram parallelism control compensates uneven force on the bend by means of hydra-electrical technique
- programmable ram delay control at bending position under adjustable pressure
- servo CNC back gauge with precision ball screw and double linear guide way ensures high rigidity capability and high productivity speed
- back gauge position speed at 1000" per minute, repeatability at ± 0.002 "
- automatic or programmable back gauge retract feature
- auto and programmable pressure control
- programmable ram top stop and slow bending position
- programmable bending speed
- automatic conversion: inch/mm
- Promecam punch clamping system with quick release
- interactive 2D graphic editor for work piece, parts and tool data entries
- 2D graphic display of machine frame, work-piece and tooling
- 2D graphic identification of optimum bending sequence
- automatic calculation of crowning tonnage
- automatically calculate back gauge position
- automatically calculate material thickness and offset back gauge position according to the bend
- optimum bend sequence
- collision detection
- up to 4 tooling stations in each program
- machine set-up preparation for pre-drawing and testing new fixture
- programmable Y1, Y2 by position and angle
- unlimited tool memory + Unlimited job memory
- optional offline programming system with similar user interface as CNC control + 2D profile view and simulation
- up and down load program and tooling data as well as machine parameters from floppy disk driver or optional USB port
- print-out capabilities
- keyboard interface adaptor
- built-in Ethernet internal communications port for upload/download from office
- web enabled monitoring function for service, troubleshooting and data transfer

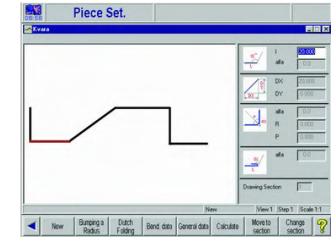
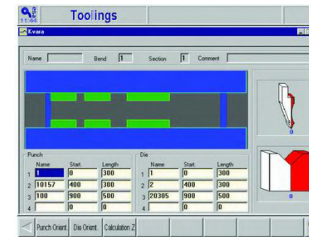
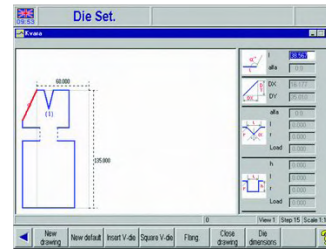
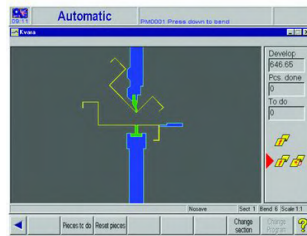
ESAUTOMOTION CNC S650 15" COLOUR TFT LCD CONTROL SCREENS

simulation + optimum bending sequence with back gauge position: the optimized bending sequence can be simulated in the graphic window prior to the actual production of a part and avoid costly damage and collisions

create tooling: new tooling may be tested in your bend sequence prior to ordering from your tool supplier, saving time and money + create your own custom tooling when needed

4 Tooling Stations in Each Program (Across the Bed): Excellent feature for various bending applications requiring different tooling setup within a single job under one program, no need to change program or re-set tooling

easy draw a work piece: the cursor may be placed within the screen field to allow operator easy entry of desired angles and/or dimensions



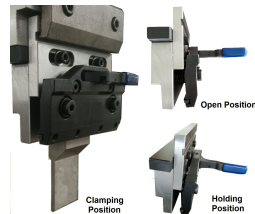
OPTIONAL EQUIPMENT

- special top and bottom tools
- hydraulic oil cooler
- NEMA 12 electrical cabinet
- quick change punch adapters for European style punch
- WILA hydraulic top and bottom tool holding system
- special throat depth (500, 600 and 750 mm)
- laser protection system for die area
- CNC Z1/Z2-axis or power operated Z1/Z2 axis
- programmable sheet followers
- two (2) quick set front support arms
- automatic single sheet follower or double sheet followers with manual or power positioning
- 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
- CNC R-axis
- off-line programming system
- 6-axis CNC back gauge (X1/X2/R1/R2/Z1/Z2) with esautomation CNC S660 19" TFT control

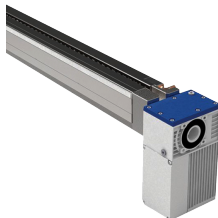
power operated Z1/Z2-axis



quick change punch adapter



CNC servo crowning system



quick set sheet support arms



interlocking back guard



safety light curtain





PRICING

MASTEEL MBHS-12190 CNC SYNCHRONIZED HYDRAULIC PRESS BRAKE	\$132,900
quick change punch adapters for European style punch <i>in lieu of standard bolt-on style punch adapters for North American + European style punches</i>	\$9,900
CNC servo crowning system	\$8,750
CNC R-axis	\$8,810
safety light curtain	\$7,300
interlocking back guard	\$1,830
power operated Z1/Z2 -axis control	\$4,140
quick set sheet supports	\$1,830
CNC Z1/ZX2-axis	\$12,920
central lubrication	\$2,740
electrical 440V or 600V	\$1,230
back gauge finger assembly (each)	\$740
off-line programming system	\$2,440
6-axis CNC back gauge (X1, X2, R1, R2, Z1, Z2) with esautomation CNC S660 19" TFT control	\$59,000
manual positioning double sheet follower	\$46,000
Power positioning double sheet follower	\$68,000



TERMS AND CONDITIONS

The pricing

The shown pricing is in Canadian Dollars F.O.B. Masteel Oakville warehouse. Applicable taxes are extra. CSA approval is included in the pricing. Lease + capital financing is available on approved credit.

The Payment Terms

30% with order, 60% before pick-up, 10% 30 days after delivery.

Warranty

Twelve (12) months.

Delivery

To be confirmed at the time of purchase.

Customer's Responsibility

Provide a single concrete slab level foundation per the machine foundation requirements, power to the machine by a certified electrician and hydraulic oil for the machine.

Masteel's Responsibility

Assemble / level the machine on the customer's shop floor, complete the machine installation and accuracy test and one day of basic machine operator training.

Pre-Start Health and Safety Review (PHSR) is the responsibility of the customer and is not included in the above pricing.

Please note that this quote is subject to change without notice.

Sincerely,

MASTEEL AMERICA CORPORATION

Ron Nater

Manager, Eastern Canada

647.270.4434 / ron@masteels.com / www.ronnater.ca

