

March 25, 2024

WALKER MANUFACTURING

17 Star Lake Road
 Sequin, Ontario P2A 0B6

Attention: Kris Walker / 705.774.6777 / kriswalker@walkermfg.ca

MASTEEL MBHSA-08130 CNC SYNCHRONIZED HYDRAULIC PRESS BRAKE

Dear Kris,

Thank you for the opportunity to quote the **MASTEEL MBHSA-08130 CNC SYNCHRONIZED HYDRAULIC PRESS BRAKE** for your facilities in Sequin, Ontario.



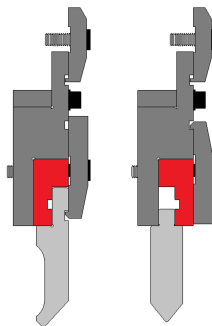
SPECIFICATIONS

maximum capacity	130 ton
maximum bending length	8'
distance between side frames	76"
bed height	34"
bed below floor	-
throat depth	12.75"
ram stroke	8"
fast approach speed	275" per minute
press speed	25" per minute
fast return speed	245" per minute
maximum open height	17.125"
motor	10 hp
back gauge travel	28"
machine weight	12,500 lbs.
machine width x depth x height	102" x 52" x 103"

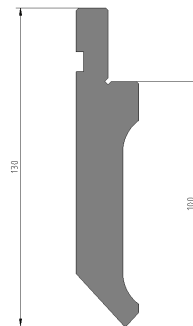
STANDARD EQUIPMENT

- tooling:
 - European or North American 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 adapters accommodate both European and North American style punches
 - Adjustable wedges on punch adapter 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

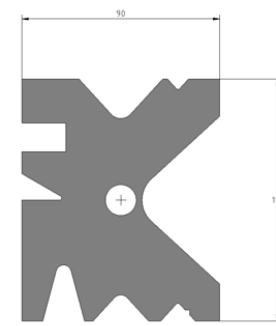
European or North American punch holders



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



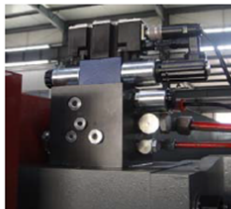
MD-4W5-110x090 4-way die



CONTROL FEATURES

- Standard Siemens TP-700 control with 7" touch screen display and Y1/Y2/X/R/Z1/Z2 position control, R and Z1/Z2 axis as option.
- Ram bending position control - Y1/Y2 axis:
 - Y1, Y2 programable independently in angle or position.
 - Ram tilt capacity at $\pm 0.5''$.
 - Bosch-Rexroth closed-loop proportional hydraulic position control with 0.0006" repeatability.
- Servo driven back gauge position control:
 - Standard CNC back gauge with 400ipm speed.
 - Optional R-axis CNC control.
 - Optional CNC Z1/Z2-axis or power operated Z1/Z2-axis.
 - Programmable back gauge retract function.
 - 3-step finger position with automatic offset on the X-axis.
- Two way angle corrections allow inexperienced operators 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 the bending position with Y-axis incremental per degree calculated by the control system.
- Dual ram position feedback with hydraulic synchronized control allows bending at one end of the press brake for deep boxes.
- Tool memory for quick recall of tool setup.
- 200 job program memory with an average of 30 bends per program.
- Programmable tonnage control.
- Programmable ram delay and programmable tonnage at the bending station for bump bending or heavy bending applications.
- Automatic maintenance schedule reminders.
- Operating prompts and troubleshooting messages.
- Inch/Metric conversion.

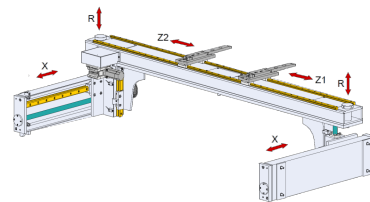
Bosch-Rexroth hydraulic control



servo driven back gauge position control



servo driven back gauge axes



optional X1, X2, R1, R2, Z1, Z2 back gauge



OPERATION FUNCTIONS

- 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 set-up
 - single mode: one full bend cycle per control input
 - double stop mode: ram stop above material and excellent for sight bend operations



inch		190 Ton		ASTEEL	
	CURRENT	FINAL	A	A	
Y1	3.882	- 0.179	90	1.5	
Y2	3.875	- 0.183	90	0.5	
	CURRENT	FINAL	RETRACT		
X	4.650	2.750	1.000		
R	0.000	-0.020	Y/°	4	
W	6.0 ft	0.060 in	V	0.625 in	

Repeat Ref Setup Auto Jog

inch		Work Setup		ASTEEL	
R-Y1	11.532 in	P	3.900 in	Param. Setup	
R-Y2	11.525 in	D	3.750 in	Jog Axes	
Ram Speed		100 %	Working Pressure	120 ton	
Top	3.880 in	X-Offset	1.000 in	Crowning Pressure	12.5 ton
Slow	0.500 in	Holding Pressure	60 ton	Auto	
Pinch	0.060 in	Holding Time	1.0 s	Main	

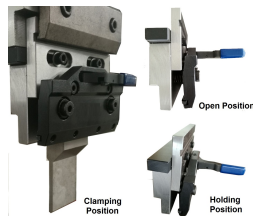
OPTIONAL EQUIPMENT

- 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
- power operated Z1/Z2-axis
- two (2) quick set sheet 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
- CNC R-axis

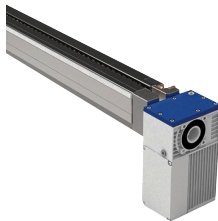
power operated Z1/Z2-axis



quick change punch adapter



CNC servo crowning system



quick set sheet support arms



interlocking back guard



safety light curtain





PRICING

MASTEEL MBHSA-08130 CNC SYNCHRONIZED HYDRAULIC PRESS BRAKE	\$79,700
quick change punch adapters for European style punch <i>in lieu of standard bolt-on style punch</i>	\$6,600
CNC servo crowning system	\$5,840
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
central lubrication	\$2,740
electrical 440V or 600V	\$1,230
back gauge finger assembly (each)	\$740
manual positioning single sheet follower	\$31,125
Power positioning single sheet follower	\$46,125



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

