P4-2512.ALA

Salvagnini

Maschinenbau

salvagnini

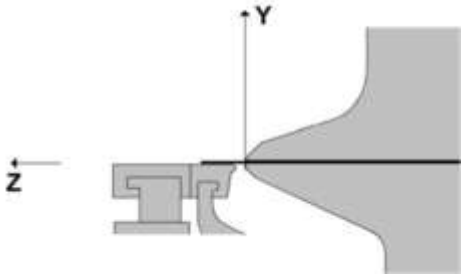
ALA

Panel Bender P4-2512

Technical specifications:

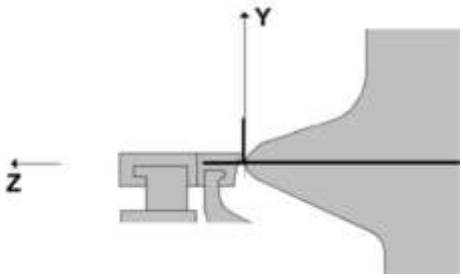
Min. sheet thickness:	S_{min}= 0,50mm
Max. sheet thickness, Mild Steel (max. 410 N/mm²):	S_{max}= 2,00mm
Max. sheet thickness, Stainless Steel (max. 600 N/mm²):	S_{max}= 1,25mm
On inquiry:Max. sheet thickness, Aluminum (max. 265 N/mm²):	S_{max}= 3,00mm
Processing of material with plastic protection	
Processing of pre painted material	
Max. sheet thickness when using option CLA (max. 410 N/mm²):	S_{max}= 2,00mm
Max. sheet thickness when using option CLA (max. 600 N/mm²):	S_{max}= 1,25mm

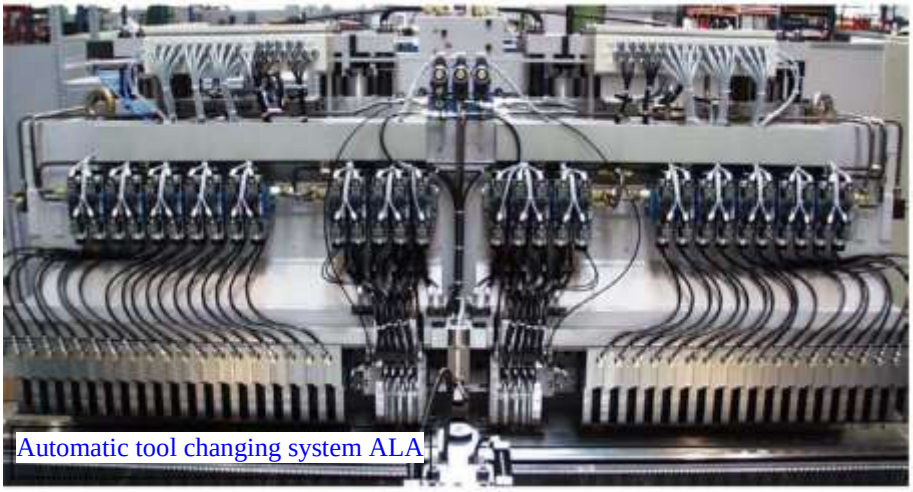
Max. bending angle: Ask Salvagnini about drawing of bending geometry.
Max. bending angle with option CLA: +90°
Max. tooling length for option CLA: 1000mm



Maximum and minimum dimensions of the punched blank:

Max. length on entrance:	2695mm
Max. width on entrance:	1500mm
Min. length on entrance:	285mm
Min. width on entrance:	190mm
Max. diagonal:	2800mm
Max. width on exit:	1500mm
Max. referencing dimension:	2500mm





Automatic tool changing system ALA

Computer: Industrial PC (Siemens or HP)

1. Panel with no return bends, the rotator clamp is parallel to the long side.

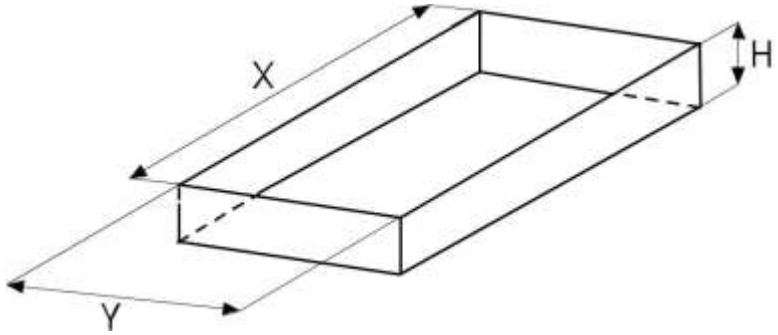


Fig. (1)

$Y_{min} = 124mm + k$ 1) 3) **or**
$Y_{min} = 200mm + k$ 2) 4)

$X_{min} = 596mm + 4*S$ 1) **or**
$X_{min} = 506mm + 4*S$ 2) **or**
$X_{min} = 536mm + 4*S$ 3) **or**
$X_{min} = 446mm + 4*S$ 4)

$X_{max} = 2500mm$

$H_{max} = 127mm$

1) with ALA 30/600/130 2) with ALA 30/510/200 3) with ALA 25/540/130 4) with ALA 25/450/200

2.. Panel with return bends, the rotator clamp is parallel to the long side.

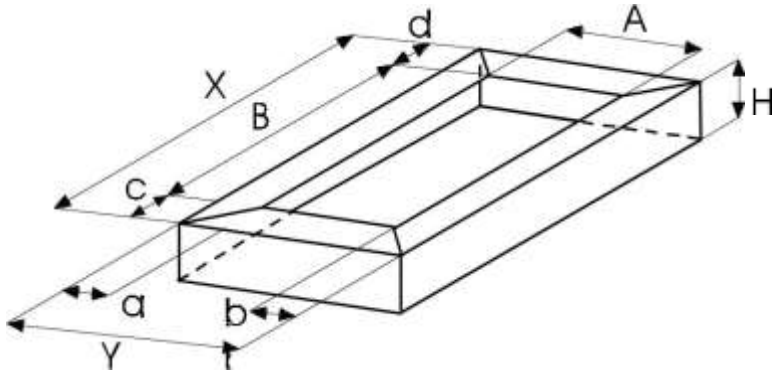


Fig. (2)

$A_{min} = 124mm + k$ 1) 3) **or**
$A_{min} = 200mm + k$ 2) 4)

$Y_{min} = A_{min} + a + b$

$X_{min} = 596mm + 4*S$ 1) **or**
$X_{min} = 506mm + 4*S$ 2) **or**
$X_{min} = 536mm + 4*S$ 3) **or**
$X_{min} = 446mm + 4*S$ 4)

$X_{max} = 2500mm$

$H_{max} = 127mm$

$a_{max} = b_{max} = 45$ mm

$c_{max} = d_{max} = 30$ mm $c_{max} = d_{max} = 25$ mm 1) 2) **or** 3) 4)

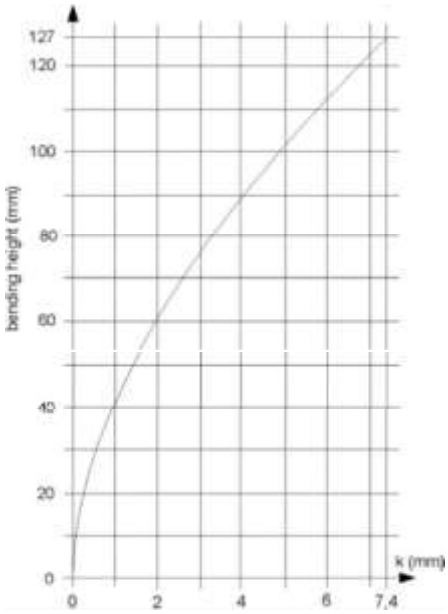
1) with ALA 30/600/130 2) with ALA 30/510/200 3) with ALA 25/540/130 4) with ALA 25/450/200

Minimum Panel Conditions

- The height of the bends: the higher the bent panel (max. = 127mm), the bigger must be the minimum panel width. This is because the Blankholder moves along an arc. (see 'k' values).
- The ability to load and to reference the blank; it must not be too small.

Maximum Panel Conditions

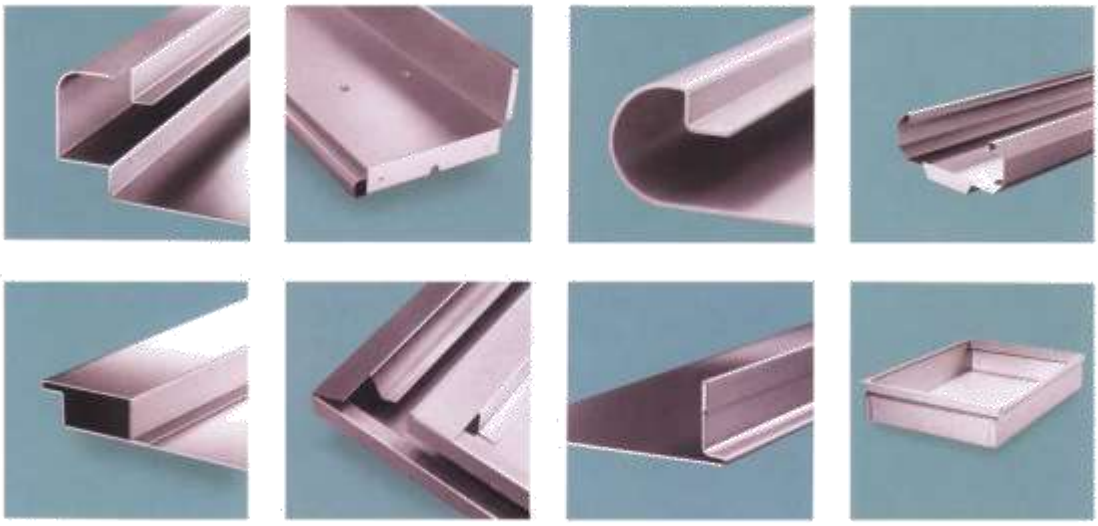
- The ability to load the blank into the machine (max. length, max. width).
- The maximum diagonal that can be rotated: **2800mm**.



The 'k' values are only important when making narrow pieces.

S....sheet thickness

This Data Sheet is only valid together with a drawing of the bending geometry. Further the minimum and maximum dimensions depends to the configuration of the loading and unloading unit.



Salvagnini

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