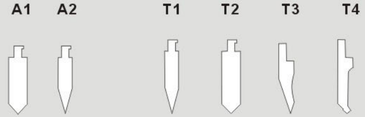
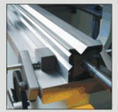
TOOLING

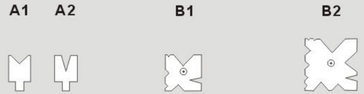
• Standard Sets

Top Blade

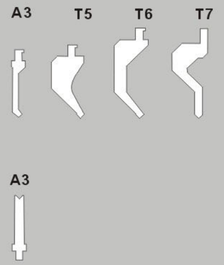


Bottom Die





* Optional Sets



For 30-45 ton models:
- A1 or A2 Sets.

*A3 set is upon request.
*B1 bottom die is optional.

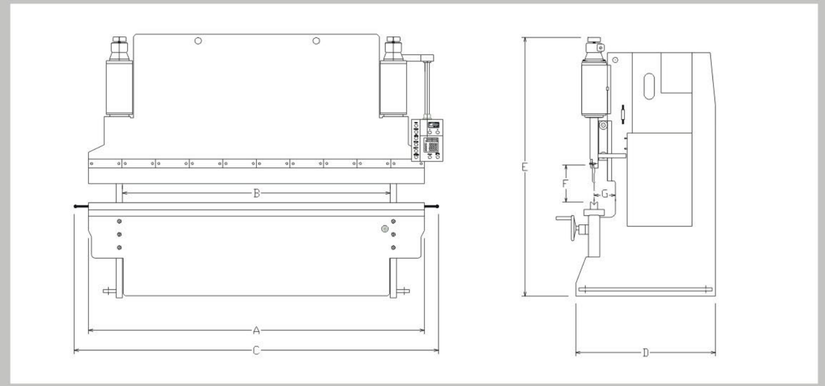
For 60-80 ton models:
- T1, T2, T3 or T4 top blades.
- B1 bottom die.

*T5, T6 and T7 top blades are optional.

For 110-220 ton models:
- T1, T2, T3 or T4 top blades.
- B2 bottom die.

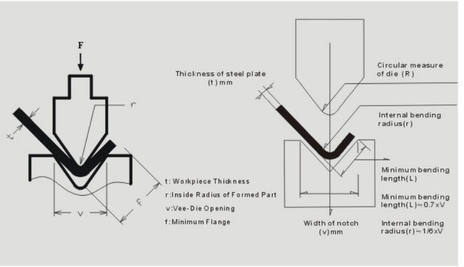
*T5, T6 and T7 top blades are optional.

TECHNICAL DIMENSIONS



PRESSING PRESSURE CHART

V die width	Curved radius sets	Minimum Flange Length	Steel plate (45g/mm) 0.5	1.0	1.2	1.6	2.0	2.3	2.6	Length 1000mm 3.2	3.6	4.5	Curvature pressing pressure(ton) 6	9	12	16	19	22	25	30
6	1	4	3	11																
8	1.5	5.5	2	8	12															
10	1.5	7	2	7	10	17														
12	2	8.5		6	8	14	22													
16	2.5	11			6	11	17	22												
20	3	14				9	13	17	22											
25	4	18					11	14	18	27										
32	5.5	23						11	14	21	27									
40	6.5	28							11	17	21	34								
50	8	35								14	17	27	50							
63	10	45									14	21	38	85						
80	13.5	57											30	67						
100	16	71											24	54	95					
125	20	89												43	76	135				
160	26	113													60	106	149			
200	35	140														85	119	160		
250	42	175															95	128	165	238



SPECIFICATION

MODEL	BENDING CAPACITY (MM)	MAX. PRESSURE (TON)	DISTANCE BETWEEN HOUSINGS (MM)	RAM STROKE (MM)	TABLE WIDTH (MM)	DISTANCE BETWEEN TABLE/RAM (MM)	OIL TANK (GALLON)	MAIN MOTOR (HP)	APPROACH SPEED (MM/SEC)	BENDING SPEED (MM/SEC)	RETURN SPEED (MM/SEC)	POWER BACK GAUGE (MM)	BACK GAUGE MOTOR (HP)	GAP (MM)	A	B	C	D	E	F	G	NW/GW (KG)	PACKING SIZE (MM)
HB-3012	2.5 x 1270	30	970	150	Bottom Die Holder	250	20	3	100	7	60	600	1/4 (OPT)	200	1270	970	1300	1100	2000	250	200	2000/2200	1800x1450x2350
HB-3015	2.0 x 1550	30	1250	150		250	24	3	100	7	60	600	1/4 (OPT)	200	1550	1250	1650	1100	2000	250	200	2400/2600	2000x1500x2350
HB-3020	1.5 x 2000	30	1550	150		250	24	3	100	7	60	600	1/4 (OPT)	200	2000	1550	2300	1100	2000	250	200	TBA	TBA
HB-4515	3.0 x 1500	45	1250	150		250	28	5	100	7	60	600	1/4 (OPT)	200	1500	1250	1650	1200	2000	250	200	2650/2850	2000x1500x2400
HB-6020	4.0 x 2000	60	1550	150	160	300	35	7.5	100	7	60	600	1/2	200	2000	1550	2300	1200	2100	300	200	3500/3800	2500x1920x2480
HB-6026	3.2 x 2600	60	2100	150	160	300	35	7.5	100	7	60	600	1/2	200	2600	2100	2800	1200	2100	300	200	4500/4800	3200x1920x2480
HB-6032	2.5 x 3200	60	2600	150	160	300	35	7.5	100	7	60	600	1/2	200	3200	2600	3400	1200	2100	300	200	5050/5350	3800x1920x2480
HB-8020	5.0 x 2000	80	1550	150	160	300	45	10	100	6	60	600	1/2	200	2000	1550	2100	1250	2100	300	200	4400/4700	2500x1920x2480
HB-8026	4.0 x 2600	80	2100	150	160	300	45	10	100	6	60	600	1/2	200	2600	2100	2800	1250	2100	300	200	5200/5500	3200x1920x2480
HB-8032	3.2 x 3200	80	2600	150	160	300	45	10	100	6	60	600	1/2	200	3200	2600	3400	1250	2100	300	200	6200/6500	3800x1920x2480
HB-11026	4.5 x 2600	110	2100	200	200	350	55	10	100	6	60	600	1/2	250	2600	2100	2800	1250	2200	350	250	6200/6400	TBA
HB-11032	3.5 x 3200	110	2600	200	200	350	55	10	100	6	60	600	1/2	250	3200	2600	3400	1250	2200	350	250	6600/7100	TBA
HB-11040	2.5 x 4000	110	3400	200	200	350	55	10	100	6	60	600	1	250	4000	3400	4300	1250	2200	350	250	9400/9700	TBA
HB-16026	6.5 x 2600	160	2100	200	200	400	80	15	100	6	60	800	1	250	2600	2100	2800	1400	2400	400	250	7800/8300	TBA
HB-16032	5.0 x 3200	160	2550	200	200	400	80	15	100	6	60	800	1	250	3200	2550	3400	1400	2400	400	250	9200/9600	TBA
HB-16040	4.3 x 4000	160	3350	200	200	400	80	15	100	6	60	800	1	250	4000	3350	4300	1400	2400	400	250	TBA	TBA
HB-22026	9.0 x 2600	220	2100	200	200	400	100	20	100	6	60	800	1	250	2600	2100	2800	1600	2550	400	250	8200/8600	TBA
HB-22032	8.0 x 3200	220	2500	200	200	400	100	20	100	6	60	800	1	250	3200	2500	3400	1600	2550	400	250	TBA	TBA
HB-22040	6.5 x 4000	220	3300	200	200	400	100	20	100	6	60	800	1	250	4000	3300	4300	1600	2550	400	250	13000/14500	TBA

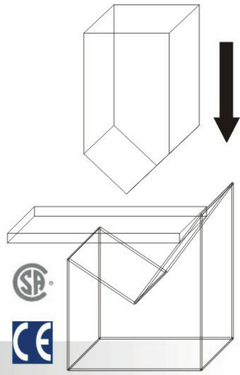
*** Models Over 220 Tons Are Upon Request**

Thickness of steel plate(t) mm	0.6-4.0	4.5-8	9-25
Width of notch (v)mm	(6-8)xt	(8-10)xt	(10-12)xt

ISO-MAC

HYDRAULIC PRESS BRAKE

ISO-MAC



Press Brake Solution

ISO-MAC HYDRAULIC PRESS BRAKE

HB-3015

HB-8020

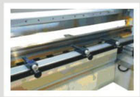
HB-11032

Standard Equipments

- Front sheet support arms.
- Manual bending angle and back gauge adjustment w/ front displays (for models under 45 tons, including 45 ton model).
- One set of top blade and bottom die (Please see the tooling chart).
- Foot switch w/ safety protection housing.
- Toolbox w/ maintenance tools, lifting hooks and leveling pads.

Optional Equipments

- CE Standard.
- CSA Electrics.
- Sliding front sheet support arm.
- Power back gauge and bending angle settings w/ NC controllers.
- Safety sensors.
- Front safety guarding w/ enhanced light curtains.
- Rear safety guarding.
- Automatic bottom die compensation mechanism (60 tons and heavier models are standard).
- Deeper throat.
- Customized top blade and bottom die.



Rear View of Power Backgauge

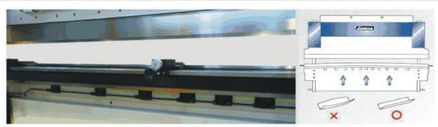
WORLD CLASS FEATURS

Front Sheet Support Arms

Firm and tough designs for heavy and consecutive workpiece loading. The support arms can be vertically adjusted for precise positioning. **Slide Front Sheet Support Arms** (Optional) can be horizontally adjusted.

Side Sensors

One each mounted on left and right side that protects operators from working hazards (Optional).

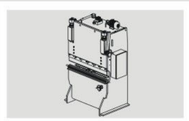


Automatic Bottom Die Crowning Compensation Mechanism

Hydraulic driven mechanism ensures precise and consistent angle across the bent workpiece.

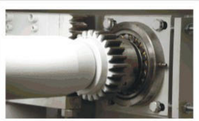
Power Back Gauge

The movement of the power back gauge is transmitted by a precision ballscrew for more smooth and accurate measurements.



Rigid and High-Tension Machine Frame

Every piece of ISO-MAC Press Brake frames is meticulously machined and processed to ensure life long durability and rigidity.



Parallel Mechanism w/ High Precision and Durable Bearing

Ensures parallel and smooth bending motion. Force from the ram are evenly applied across the length of the workpiece.

Hydraulic Circuit System

Tonnage Limit Control

The downfallen pressure of ram can be adjusted from the controller in case of excessive loads to protect your tooling.

Depth Positioning

The high accuracy depth positioning (bending angle) is achieved through mechanical stops in the cylinders.

High Performance Hydraulic Circuits and Cylinders ensure smooth and stable operations.

- Standard Hydraulic Circuit System includes stable solenoid valves and 2 powerful cylinders.
- On Top Hydraulic Circuit System ensures strong downfallen oil pressure by the nature of gravity.
- **Open-loop system -** hydraulic oil doesn't circulate in the circuit after operations and returns to recycle tank to cool down the oil temperature. Thus, the entire hydraulic circuit will not be operating under high temperature. This will extend the life of the hydraulic system.

ADVANCED SAFETY FEATURS

(Optional)

Front Safety Guarding w/ Enhanced Light Curtain Sensors

Safety Sensors are mounted on the front guarding (one on each side). Long shape design gives sensitive and wider detecting area. When the operator approaches the working area, the sensors detect object and cut the power off right away. The machine stops completely to prevent the operator from working hazards.

Rear Safety Guarding

Preventing the operator walks into the working area of the machine. When the doors of the guarding are opened, the machine cuts the power off and stops immediately.

CONTROL PANELS

2-axes NC Controller, Delem DA-41.

Power mechanism controller, adjusting :1.Power bending angle,or 2.Power back gauge. (Customer can choose either one-axis or two axes together).

Manual bending angle & back gauge adjustment model.

Control Panels:

· Models under 45 tons (includes 45 ton):

-Standard: Manual adjustment (2-axes) w/ LED displays showing bending angle (depth positioning) and back gague.
-Optional: Power mechanism controller (either 1-axis or 2-axes together) or NC Controller,Delem DA-41, 2-axes.

· Models 60 tons and beyond:

-Standard: Power mechanism controller (2-axes together).
-Optional: NC controller, Delem DA-41, 2-axes.