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PROFI 28 NC PROFI 28 CNC PROFI 56 CNC QUICK BEND CNC



simply better!

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Profi 28 NC / CNC





The **BOSCHERT** Profi 28 NC and Profi 28 CNC are precision hydraulic press brakes. The extremely compact and robust structure of these machines and the twin guides guarantee ram repeatability of 0.02mm.

The Profi are designed to manufacture small parts and perfectly compliment your existing larger machines.

By forming small parts on the Profi and larger parts your existing machines, plant productivity is greatly improved. Standard tooling is Amada style, with other systems available on request. Material stops are adjustable vertically and horizontally and have stop fingers with two faces each.

With a maximum bending force of 28 tons, typical work could include parts up to 300mm long and 10mm thick.



3 Position back gauge



R-axis option

The Profi 28 NC is simple to operate. The ram can be adjusted under pressure by using the handwheel. The powered back gauge is programmable with up to 99 programs of 30 lines

each.





Control with up to 99 programmable programms



2 or optional 4 side adjustable back gauges Optional 2 adjustable front supports

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Profi 56 CNC



The Profi 56 CNC models are available in 1000, 1400 and 2200mm bending lengths. The pressure of 56 tons takes place with 2 x 28 ton force cylinders. All CNC Profi 28/56 Press Brakes machines are equipped with the Cybelec CybTouch 12 as the standard control.

Control CybTouch 12



- Large touchscreen
- Hand drawing TouchProfile function
- USB port for memory sticks
- 4 axes control (Y1-Y2-X-R)
- TouchProfile 2D graphic part



Quick Bend 28 CNC



Productivity and ergonomics are combined in perfect harmony.

The nearly silent press brake Quick Bend, with up to 250mm/s approach speed and 200mm/s return speed is setting new standards in production.

Thanks to the hybrid technology, up to 80% energy savings compared with conventional hydraulic systems can be achieved.

The Quick Bend corresponds to all CE - Safety requirements with the CYBELEC Modeva Pac graphic controller, Rexroth hydraulics and the Fissler



AKAS III. Other standard equipment includes the R-axis, linear guide for the X axis and the quick-change tool system ROL 1.

Technical Data

I Bending Chart

Capacities	Profi 28/1000 NC	Profi 28/1000 CNC	Quick Bend	
Supusition				
Bending force	280	280	280/560	
Bending length mm	1000	1000	1000	
Dimensions				
Weight ka	3500	3500	3500	
Width mm	1460	1531	1780	
Depth mm	1310	1530	1750	
Height from floor mm	2030	2360	2380	
Distance between				
the frames mm	890	890	890	
Throat depth mm	200	200	200	
Width of worktable mm	2 x 270	2 x 270	1 x 800x450	
Operating height mm without die	915	915	985	
Davlight	305 (405*)	305 (405*)	305 (405*)	
Y-Travel mm	200	200	200	
Max. stop range in X mm	600	600	600	
Downspeed mm/s	10	10	250	
Working speed mm/s	8-10	8-10	8-10	
Upstroke speed mm/s	30	30	200	
Repeatability mm	+/-0.02	+/-0.02	+/-0.02	
Power supply kVA	5.5	5.5	5.5	
Control	Hejm	CybTouch12*	ModevaPac	
*Option ()	7	-,		
			l	
Capacities	Profi 56/1000 CNC	Profi 56/1400 CNC	Profi 56/2200 CNC	
	Profi 56/1000 CNC 560	Profi 56/1400 CNC 560	Profi 56/2200 CNC 560	
Capacities Bending force Bending length mm				
Bending force	560 1000	560 1400	560 2200	
Bending force Bending length mm	560 1000	560 1400 4800	560 2200 5500	
Bending force Bending length mm Dimensions Weight kg Width mm	560 1000 3800 1531	560 1400 4800 1950	560 2200 5500 2741	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm	560 1000 3800 1531 1530	560 1400 4800 1950 1560	560 2200 5500 2741 1670	
Bending force Bending length mm Dimensions Weight kg Width mm	560 1000 3800 1531	560 1400 4800 1950	560 2200 5500 2741	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm	560 1000 3800 1531 1530 2360	560 1400 4800 1950 1560 2360	560 2200 5500 2741 1670 2360	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm	560 1000 3800 1531 1530 2360	560 1400 4800 1950 1560 2360 1260	560 2200 5500 2741 1670 2360 2100	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm Distance between	560 1000 3800 1531 1530 2360 890 200	560 1400 4800 1950 1560 2360 1260 200	560 2200 5500 2741 1670 2360 2100 200	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm Distance between Throat depth mm Width of workstable mm	560 1000 3800 1531 1530 2360 890 200 2 × 270	560 1400 4800 1950 1560 2360 1260 200 2 x 270	560 2200 5500 2741 1670 2360 2100 200 2 × 270	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm foor mm Distance between the frames mm Throat depth mm Width of worktable mm Operating height mm without die	560 1000 3800 1531 1530 2360 890 200 2 x 270 915	560 1400 4800 1950 1560 2360 1260 200 2 x 270 915	560 2200 5500 2741 1670 2360 2100 200 2 x 270 915	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm Distance between the frames mm Throat depth mm Operating height mm without die Daylight	560 1000 3800 1531 1530 2360 890 200 2 × 270 915 305 (405')	560 1400 4800 1950 1560 2360 200 2 × 270 915 306 (405)	560 2200 5500 2741 1670 2360 2100 200 2 × 270 915 305 (405')	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm Distance between Throat depth mm Width of worktable mm Operating height mm without die Daylight Y-Travel mm	3800 1531 1530 2360 890 200 2 x 270 915 305 (405*) 200	560 1400 4800 1950 1560 2360 1260 200 2 x 270 915 305 (405°) 200	560 2200 5500 2741 1670 2360 2100 200 2 x 270 915 305 (405') 200	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm Distance between the frames mm Width of worktable mm Width of worktable mm Daylight Y-Travel mm Max. stop range in X mm	560 1000 3800 1531 1530 2360 890 200 2 x 270 915 306 (405') 200 600	560 1400 4800 1950 1560 2360 200 2 × 270 915 306 (405') 200 600	560 2200 5500 2741 1670 2360 2100 2 x 270 915 305 (405°) 200 800	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm Distance between Throat depth mm Width of worktable mm Operating height mm without die Daylight Y-Travel mm	560 1000 3800 1531 1530 2360 890 200 2 x 270 915 305 (405) 200 600	560 1400 4800 1950 1560 2360 1260 200 2 x 275 305 (405) 200 600	560 2200 5500 2741 1670 2360 2100 2 × 270 915 305 (405°) 200 800	
Bending force Bending length mm Dimensions Weight kg Weight kg Width mm Depth mm Height from floor mm Distance between the frames mm Width of worktable mm Operating height mm without die Daylight Max. stop range in X mm Downspeed mm/s Working speed mm/s	560 1000 3800 1531 1530 2360 800 200 2 x 270 915 305 (405) 200 10 8-10	560 1400 4800 1950 1560 2360 200 2 x 270 915 306 (405') 260 600 810	560 2200 5500 2741 1670 2300 2 x 270 915 305 (405°) 200 800 10 8-10	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm Distance between Distance between Width of workstable mm Operating height mm without die Daylight Y-Travel mm Max. stop range in X mm Max. stop range's Working speed mm/s Upstroke speed mm/s	560 1000 3800 1531 1530 2360 890 200 2 x 270 915 306 (65) 2600 10 8-10 30	560 1400 4800 1950 1560 2360 1260 200 2 x 270 915 305 (405') 200 10 8-10 8-10	560 2200 5500 2741 1670 2360 2100 200 2 × 270 915 900 10 8-10 30	
Bending force Bending length mm Dimensions Weight kg Weight kg Weight mm Height from floor mm Distance between the frames mm Width of worktable mm Operating height mm without die Daylight Y-Travel mm Max. glored mm/s Working speed mm/s Upstroke speed mm/s Repeatability mm	560 1000 3800 1531 1531 1530 2360 800 200 2 × 270 915 305 (405°) 200 80 80 80 90 10 10 10 10 10 10 10 10 10 10 10 10 10	560 1400 4800 1950 1560 2360 1280 2 × 270 915 305 (405') 200 600 600 100 100 100 100 100 100 100 1	560 2200 5500 2741 1670 2360 2100 2 × 270 915 305 (405°) 2000 800 800 801 810 30 4-0.02	
Bending force Bending length mm Dimensions Weight kg Width mm Depth mm Height from floor mm Distance between Distance between Width of workstable mm Operating height mm without die Daylight Y-Travel mm Max. stop range in X mm Max. stop range's Working speed mm/s Upstroke speed mm/s	560 1000 3800 1531 1530 2360 890 200 2 x 270 915 306 (65) 2600 10 8-10 30	560 1400 4800 1950 1560 2360 1260 200 2 x 270 915 305 (405') 200 10 8-10 8-10	560 2200 5500 2741 1670 2360 2100 200 2 × 270 915 900 10 8-10 30	

V mm.	6	8	6	8	6	8
R.200N/ mm ²	20	10	30	20	60	40
	40	30	70	50	130	80
R.700N/ mm ²	60	40	110	80	190	130
Ri mm.	1,0	1,3	1,0	1,3	1,0	1,3
90*=B mm.	4,5	6,0	4,6	6,1	4,7	6,2
60°=B mm.	6,3	8,3	6,4	8,4	6,5	8,5
35°-B mm.	10,3	13,6	10,4	13,7	10,5	13,8
S mm.	1,2		1,5		2,0	
V mm.	8	10	10	12	12	16
R.200N/	60	40	70	60	110	80
	130	100	160	130	250	170
	200	150	250	200	390	260
Ri mm.	1,3	1,7	1,7	2,0	2,0	2,7
90°-8 mm.	6,3	7,7	7,8	9,2	9,5	12,3
60°=B mm.	8,6	10,6	10,8	12,8	13,0	17,0
35*=B mm.	13,9	17,2	17,4	20.7	21.0	27.6
)		1
S mm.	2	5	(3	32	
	2	5 20	20	25	32	40
S mm. V mm.	2 16 130	.5 20 90	20	25 110	32 150	40 110
S mm. V mm.	2 16 130 290	5 20 90 210	20 140 320	25 110 240	32 150 340	40 110 250
S mm. V mm. R.200N/ mm² F R.450N/ kN/mt mm² R.700N/ mm²	2 16 130 290 440	5 20 90 210 330	20 140 320 500	25 110 240 370	32 150 340 530	40 110 250 390
S mm. V mm. R.200N/ mm² F R.450N/ kN/mt mm² R.700N/ mm² RI mm.	2 16 130 290 440 2,7	5 20 90 210 330 3,3	20 140 320 500 3,3	25 110 240 370 4,2	32 150 340 530 5,3	40 110 250 390 6,7
S mm. V mm. R.200N/ mm² F. R.450N/ kN/mt mm² R.700N/ mm² RI mm.	2 16 130 290 440 2,7	5 20 90 210 330 3,3 15,4	20 140 320 500 3,3 15,6	25 110 240 370	32 150 340 530 5,3 24,6	40 110 250 390
S mm. V mm. R.200N/ mm² F R.450N/ kN/mt mm² R.700N/ mm² RI mm.	2 16 130 290 440 2,7	5 20 90 210 330 3,3	20 140 320 500 3,3	25 110 240 370 4,2 19,2	32 150 340 530 5,3	40 110 250 390 6,7 30,3
S mm. V mm. R200N/ m27 F R.450N/ kN/mt m37 R1 mm. 90"=8 mm. 60"=8 mm.	2 16 130 290 440 2,7 12,6 17,3 27,9	90 210 330 3,3 15,4 21,3 34,5	20 140 320 500 3,3 15,6 21,5	25 110 240 370 4,2 19,2 26,5 43,1	32 150 340 530 5,3 24,6 34,0 55,2	40 110 250 390 6.7 30,3 42,0 68,5
S mm. V mm. R.200N/ F. R.450N/ KN/Imt mm? R.700N/ mm? R1 mm. 90"+8 mm. 60"+8 mm. S mm.	2, 16 130 290 440 2,7 12,6 17,3 27,9	5 20 90 210 330 3,3 15,4 21,3 34,5	20 140 320 500 3,3 15,6 21,5 34,8	25 110 240 370 4,2 19,2 28,5 43,1	32 150 340 530 5,3 24,6 34,0 55,2	40 110 250 390 6,7 30,3 42,0 68,5
S mm. V mm. R.200N/ FR.450N/ FR.450N/ NV/mt mm² RI mm. 90°+8 mm. 50°+8 mm. V mm.	2, 16 130 290 440 2,7 12,6 17,3 27,9	5 20 90 210 330 3,3 15,4 21,3 34,5	20 140 320 500 3,3 15,6 21,5 34,8	25 110 240 370 4,2 19,2 26,5 43,1	32 150 340 530 5,3 24,6 34,0 55,2	40 110 250 390 6,7 30,3 42,0 68,5
S mm. V mm. R.200N/ F. RP 1000/ R.700N/ M.700N/ M.70	2, 16, 130, 290, 440, 2,7, 12,6, 17,3, 27,9, 40,	20 90 210 330 3,3 15,4 21,3 34,5 50	20 140 320 500 3,3 15,6 21,5 34,8	25 110 240 370 4,2 19,2 26,5 43,1 63 160	32 150 340 530 5,3 24,6 34,0 55,2 8 63 310	40 110 250 390 6.7 30.3 42.0 68.5 80 220
S mm. V mm. R.2004V F. R.4504V R.7004V F. R.7004V	2, 16 130 290 440 2,7 12,8 17,3 27,9 40 190 420	.5 20 90 210 330 3,3 15,4 21,3 34,5 50 140 320	20 140 320 500 3,3 15,6 21,5 34,8 (50 210 480	25 110 240 370 4,2 19,2 26,5 43,1 63 160 360	32 150 340 530 5,3 24,6 34,0 55,2 63 310 690	40 110 250 390 6.7 30.3 42.0 68.5 3 80 220
S mm. V mm. R.200H mm F. R.450N MV mm BI mm. SO'-B mm. SO'-B mm. SO'-B mm. SO'-B mm. CO'-B mm. R.200H mm F. R.450N MM IT mm F. R.450N mm Mill mm F. R.700N mm	2, 16 130 290 440 2,7 12,6 17,3 27,9 40 190 420 660	5 20 90 210 330 3,3 15,4 21,3 34,5 5 5 140 320 490	20 140 320 500 3,3 15,6 21,5 34,8 50 210 480 750	25 110 240 370 4,2 19,2 28,5 43,1 63 160 360 550	32 150 340 530 5,3 24,6 34,0 55,2 63 310 690 1070	40 110 250 390 6.7 30.3 42.0 68.5 3 80 220 500 780
S mm. V mm. Rackev F Rackov F Rackov mm² Bi mm. 90"-8 mm. 30"-8 mm. X mm. Rackov F Rackov F Rackov Rackov F Rackov	2, 16 130 290 440 2,7 12,8 17,3 27,9 40 190 420	.5 20 90 210 330 3,3 15,4 21,3 34,5 50 140 320	20 140 320 500 3,3 15,6 21,5 34,8 (50 210 480	25 110 240 370 4,2 19,2 26,5 43,1 63 160 360	32 150 340 530 5,3 24,6 34,0 55,2 63 310 690	40 110 250 390 6.7 30.3 42.0 68.5 3 80 220





*Option()

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	1310	980	1490	1120	N.
Ri mm.	13,3	16,7	16,7	20,8	\
	61,6	75,7	76,7	94,4	
	85,0	105,0	106,0	131,0	-
35*=B mm.	138,0	171,3	172,3	213,8	

66,0

100 125

- F = KN for meter
- S = Sheet thickness R = Sheet resistance Material Hardness

80

380 280 430 320