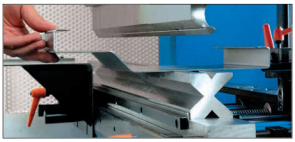
BOSCHERT



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

BOSCHERT

simply better!

Profi 28 NC / CNC

Profi 28/1000 NC

Profi 28/1000 CNC

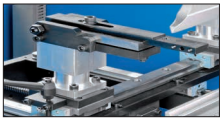
The ***BOSCHERT*** Profi 28 NC and Profi 28 CNC are precision hydraulic press brakes. The extremely compact and robust structure of these machines and the twin guides guarantee ram repeatability of 0.02mm.

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

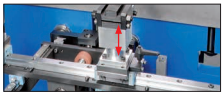
By forming small parts on the Profi and larger parts your existing machines, plant productivity is greatly improved.

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.



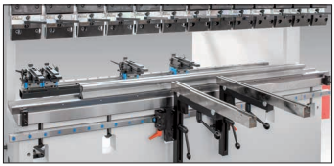
3 Position back gauge



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

Profi 56 CNC

Profi 56/1400 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

Quick Bend 28 CNC
Hybrid Technologie

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

Capacities	Profi 28/1000 NC	Profi 28/1000 CNC	Quick Bend
Bending force	280	280	280/560
Bending length mm	1000	1000	1000
Dimensions			
Weight kg	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
Daylight	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 ( )			

Capacities	Profi 56/1000 CNC	Profi 56/1400 CNC	Profi 56/2200 CNC
Bending force	560	560	560
Bending length mm	1000	1400	2200
Dimensions			
Weight kg	3800	4800	5500
Width mm	1531	1950	2741
Depth mm	1530	1560	1670
Height from floor mm	2360	2360	2360
Distance between the frames mm	890	1260	2100
Throat depth mm	200	200	200
Width of worktable mm	2 x 270	2 x 270	2 x 270
Operating height mm without die	915	915	915
Daylight	305 (405*)	305 (405*)	305 (405*)
Y-Travel mm	200	200	200
Max. stop range in X mm	600	600	800
Downspeed mm/s	10	10	10
Working speed mm/s	8-10	8-10	8-10
Upstroke speed mm/s	30	30	30
Repeatability mm	+/-0,02	+/-0,02	+/-0,02
Power supply kVA	10	10	12
Control	CybTouch12*	CybTouch12*	CybTouch12*
*Option ( )			

I Bending Chart

S mm.		0,6		0,8		1,0	
V mm.		6	8	6	8	6	8
F kN/mt	R.200N/mm²	20	10	30	20	60	40
	R.450N/mm²	40	30	70	50	130	80
	R.700N/mm²	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
F kN/mt	R.200N/mm²	60	40	70	60	110	80
	R.450N/mm²	130	100	160	130	250	170
	R.700N/mm²	200	150	250	200	390	260
Ri mm.		1,3	1,7	1,7	2,0	2,0	2,7
90°=B 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

S mm.		2,5		3		4	
V mm.		16	20	20	25	32	40
F kN/mt	R.200N/mm²	130	90	140	110	150	110
	R.450N/mm²	290	210	320	240	340	250
	R.700N/mm²	440	330	500	370	530	390
Ri mm.		2,7	3,3	3,3	4,2	5,3	6,7
90°=B mm.		12,6	15,4	15,6	19,2	24,6	30,3
60°=B mm.		17,3	21,3	21,5	26,5	34,0	42,0
35°=B mm.		27,9	34,5	34,8	43,1	55,2	68,5

S mm.		5		6		8	
V mm.		40	50	50	63	63	80
F kN/mt	R.200N/mm²	190	140	210	160	310	220
	R.450N/mm²	420	320	480	360	690	500
	R.700N/mm²	660	490	750	550	1070	780
Ri mm.		6,7	8,3	8,3	10,5	10,5	13,3
90°=B mm.		30,8	37,9	38,4	47,5	48,5	60,6
60°=B mm.		42,5	52,5	53	66,0	67,0	84,0
35°=B mm.		69,0	85,6	86,1	107,8	108,8	137,0

S mm.		10		12	
V mm.		80	100	100	125
F kN/mt	R.200N/mm²	380	280	430	320
	R.450N/mm²	840	630	960	720
	R.700N/mm²	1310	980	1490	1120
Ri mm.		13,3	16,7	16,7	20,8
90°=B mm.		61,6	75,7	76,7	94,4
60°=B mm.		85,0	105,0	106,0	131,0
35°=B mm.		138,0	171,3	172,3	213,8

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

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