

primeline S-SERIES



**DNC SERVO
HYDRAULIC PRESS BRAKES**



PRIMELINE S-SERIES Press Brakes are constructed of steel plate weldments amply-size for the rigidity and stability to fully withstand the

applied bending forces and to keep deflection at the lowest possible level. They are fully hydraulic with downstroking rams and utilize servo hydraulic technology. The hydraulic system incorporates two cylinders and a high volume pump to assure quiet operation and is located for easy access. Cylinder pistons are ground, hard-chrome plated. Fully adjustable servo valves paired with linear scales ensure the machine maintains its $\pm .0004$ repeatability. An easy to operate DNC controller indicates the position of the ram and the back gauge axes. Stroke length can be adjusted and controlled. Two speed ram advance is standard. Controls are contained in a swiveling console mounted on the machine for convenient operation; and, there is also a movable pedestal with two-hand (*palm button*) control and emergency stop button. Electrics are for 3-phase, 60 Hz., 220/440 volt (*other voltages on request*), with low voltage at the controls.

Other Standard Equipment:

- Cybelec DNC 60 "Intelligent" Control
- "X", "Y1/Y2" Axes
- Punch holders for American and European forming punches
- Two front support arms
- Guard in rear of machine
- Training at your location

Optional Equipment:

- Cybelec DNC 880 2D Graphics Control
- Offline programming
- Manual Crowning
- CNC Crowning
(Standard in 20' machines)
- Support arms mounted on a linear rail
- Power "R" Axis
- Power "Z1/Z2" Axes
- Press brake tooling
- CE/CSA compliance



Optional Cybelec DNC 880 Graphic Controller (also pictured on cover)



Back gauge from behind

Safety cage at rear of machine

S-SERIES TECHNICAL SPECIFICATIONS & CAPACITIES

S-Series Model	Capacity (Tons)	Overall Bending Length (in.)	Distance Between Housings (in.)	Throat Depth (in.)	Adjustable Stroke Length (in.)	Open Height Without Tooling	Approach Speed of Ram (in./sec.)	Bending Speed (in./sec.)	Return Speed of Ram (in./sec.)	Motor HP	Overall Length (in.)	Overall Height (in.)	Overall Front to Back (in.)	Weight Approx. (lbs.)
45 X 4	45	49	41	13.77	6.30	14.56	5.90	0.59	3.93	10	83	94.5	49	7040
45 X 6	45	80.7	65	13.77	6.30	14.56	5.90	0.59	3.93	10	94.5	94.5	49	8932
100 X 8	100	100	85	13.77	6.30	13.77	5.90	0.31	2.67	10	148	96.5	53	12980
100 X 10	100	120	100	13.77	6.30	13.77	5.90	0.31	2.67	10	165	96.5	53	14850
135 X 10	135	120	100	13.77	7.08	14.76	5.90	0.35	3.03	15	165	102	59	18480
175 X 10	175	120	100	13.77	7.87	16.92	5.90	0.35	3.39	20	165	106	59	21604
225 X 10	225	120	100	13.77	8.27	17.52	5.90	0.28	2.87	20	177	106	70.87	26840
350 X 10	350	120	100	14.37	9.65	20.47	3.54	0.20	2.40	25	179	114	73	35200
175 X 12	175	145	122	13.78	9.64	16.99	3.93	0.35	3.38	20	193	106	59	25300
225 X 12	225	145	122	13.78	8.27	17.52	3.93	0.28	2.87	20	193	106	71	27550
350 X 12	350	145	122	14.37	9.65	20.47	3.54	0.20	2.40	25	201	114	73	38720
450 X 13	450	159	122	19.69	12.66	22.44	3.15	0.24	2.17	40	216	86	136	55000
225 X 20	225	238	201	13.78	8.27	13.78	3.15	0.28	2.87	20	285	118	75	43800
350 X 20	350	238	201	19.69	9.65	20.08	3.15	0.20	2.40	25	285	114	89	62700
450 X 20	450	238	201	19.69	12.60	22.44	3.15	0.24	2.17	40	300	150	91	89000

All data are approximate and subject to correction or change without prior notice.

Press Brakes in other lengths and tonnages are available.

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