

## **CNC (2 Axis) Tube Bender: PLC Control**

### **Features:**

- One axis numerical controlled of bending-axis by encoder / hydraulic valves
- Bending angle controlled by micro encoder, provides  $\pm 0.1$  tolerance
- Mitsubishi PLC ( Programmable Logic Control ) system
- Provides 200 programs memory, each program with 20 angles (bends)
- Provides anticipated two steps mandrel retraction
- Provides pressure die booster
- Provides pressure die micro adjustment of backward to protect the ball mandrel.
- Provides pressure die repetition
- Bending movement time can be programmable to meet different demands.
- 6" display touch screen to operate the machine easily
- Emergency stop of two safety plates with bending arm for working safety

### **Bending tooling & Accessories:**

- Bending die
- Clamping die
- Pressure die / guide die
- Mandrel (bullet shape)
- 6 pieces of stoppers for tube length control
- A working table for tube rotation fixtures (standard size)
- Wiper die rack
- Ball mandrel / multiple-direction ball mandrel (optional)
- Wiper die (optional)
- Split bending die (optional)

Model No.	CNC 2A-101	CNC 2A-90	CNC 2A-80	CNC 2A-70	CNC 2A-50	CNC 2A-38
Axis	1-3 A	1-3 A	1-3 A	1-3 A	1-3 A	1-3 A
Max. Tube O.D. Bending Capacity (mm)	Ø100	Ø90	Ø80	Ø70	Ø50	Ø38
Max. Tube Wall Thickness (mm)	4	3	3	3	2.5	2
Max. CLR (mm)	250	250	250	180	180	180
Max. Bending Angle (°)	180	180	180	180	180	180
Max. Mandrel Working Distance (mm) (Extra mandrel length as per customer requirement)	2000	2000	2000	2000	2000	2000
Processing Speed	Tube Feeding Speed	Manual Push	Manual Push	Manual Push	Manual Push	Manual Push
	Tube Rotation Speed (°/sec)	348	759	180	1371	390
	Tube Bending Speed (°/sec)	32.1	80	62.5	156.8	120
Repeatability	Tube Rotation Precision (°)	±0.1	±0.1	±0.1	±0.1	±0.1
	Tube Bending Precision (°)	±0.1	±0.1	±0.1	±0.1	±0.1
Total Power (kw)	114.45	65	48.05	68.5	63.49	51.06
Operation Height (mm)	1289	1275	1170	1170	1145	1200
Machine Length (mm)	8094	6114	6807	5570	5269	4432
Machine Width (mm)	2132	1977	1804	1637	1676	1324
Machine Height (mm)	2071	1925	1900	1914	1914	1630