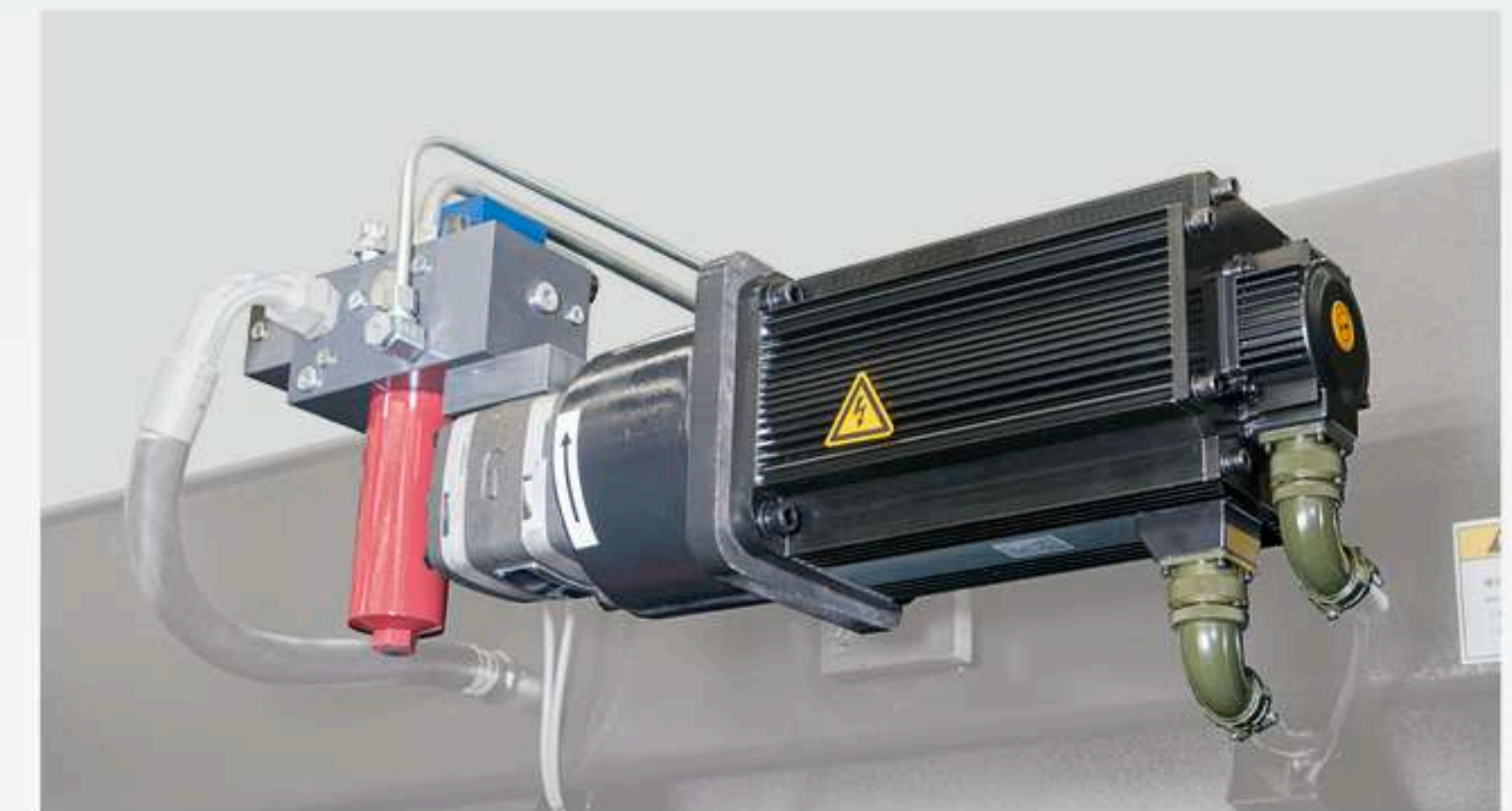


TPR8/TPM8/TPM9 SERIES CNC Bending



TPM8 uses servo motor instead of asynchronous motor, retaining proportional valve control technology, mature and reliable. Servo controlled variable pump technology can significantly reduce the noise of machine , reduce oil temperature, heat and save more than 35% of energy.

Features

- Optimized by finite element design to ensure that the machine body has high strength and high rigidity.
- Compared with the traditional CNC bending machine, increasing the filling fluid flow, oil pump displacement, etc., the frequency of Y-axis movement is about 25% higher than the market mainstream bending machine.
- Adopt high-frequency response proportional valve to ensure high stability and high precision during high-speed operation.
- Increased closed height, throat depth, ram stroke, etc., to facilitate bending and handling of large and complex workpieces.
- Automatic mechanical crowning compensation system as standard configuration to solve the influence of the ram deformation on the workpiece quality during bending, convenient and accurate.

Main Specification of TPR8

Main Specification	Unit	60T	100T		150T			225T		320T		400T		500T		600T	
Model		TPR8 060/2050	TPR8 100/3100	TPR8 100/4100	TPR8 150/3100	TPR8 150/4100		TPR8 225/3100	TPR8 225/4100	TPR8 320/3100	TPR8 320/4100	TPR8 400/4100	TPR8 400/6000	TPR8 500/5000	TPR8 500/6000	TPR8 600/6000	
Bending Force	kN	600	1000	1000	1500	1500		2250	2250	3200	3200	4000	4000	5000	5000	6000	
Bending Length	mm	2050	3100	4100	3100	4100		3100	4100	3100	4100	4100	6000	5000	6000	6000	
Column Distance	mm	1600	2700	3700	2700	3700		2700	3700	2700	3700	3700	5100	4400	5100	5100	
Throat Depth	mm	350	410	410	410	410		410	410	410	410	410	400	500	500	500	
Stroke of Ram	mm	215	215	215	215	215		215	215	315	315	315	315	315	315	315	
Closed Height	mm	480	480	480	480	480		480	480	580	580	580	580	580	580	580	
Speed	Approaching	mm/s	180	220	220	180	180		160	170	110	120	110	110	80	90	80
	Working	mm/s	18	14	14	11	11		10	10	9	9	8	8	7	7	8
	Return	mm/s	180	170	150	150	150		140	140	110	110	85	85	70	70	70
Main Motor Power	kW	7.5	11	11	15	15		22	22	22	22	30	30	37	37	37	
Oil Tank Capacity	L	250	400	550	400	550		400	550	400	550	600	800	700	800	800	
Backgauge	Precision	mm	±0.10	±0.10	±0.10	±0.10	±0.10		±0.10	±0.10	±0.10	±0.10	±0.20	±0.20	±0.20	±0.20	
	Stroke	mm	500	500	500	500	500		500	500	500	500	500	500	500	500	
	Speed	mm/s	400	400	400	400	400		400	400	400	400	400	250	250	250	250
	Power	kW	1	1	1	1	1		1	1	1	1	1	1.5	1.5	1.5	1.5
Dimension L×W×H	mm	L:2900	L:3950	L:4950	L:3970	L:4950		L:3980	L:4980	L:3510	L:4510	L:4510	L:6450	L:5480	L:6480	L:6480	
		W:1400	W:1700	W:1700	W:1720	W:1720		W:1960	W:1960	W:2200	W:2200	W:2200	W:2200	W:2050	W:2050	W:2500	
		H:2330	H:2600	H:2610	H:2610	H:2610		H:2650	H:2650	H:3270	H:3270	H:3300	H:3650	H:3300	H:3300	H:3500	

◆ Note: Controlling axes can be designed into 3+1 axes/4+1 axes/6+1 axes/8+1axes/10+1axes.

The exact specifications and configuration are subject to the actual quotation.

Main Specification of TPM8

Main Specification		Unit	60T	100T		150T		225T	
Model			TPM8 060/2050	TPM8 100/3100	TPM8 100/4100	TPM8 150/3100	TPM8 150/4100	TPM8 225/3100	TPM8 225/4100
Bending Force	kN	600	1000	1000	1500	1500	2250	2250	
Bending Length	mm	2050	3100	4100	3100	4100	3100	4100	
Column Distance	mm	1600	2700	3700	2700	3700	2700	3700	
Throat Depth	mm	350	410	410	410	410	410	410	
Stroke of Ram	mm	215	215	215	215	215	215	215	
Closed Height	mm	480	480	480	480	480	480	480	
Speed	Approaching	mm/s	180	220	220	180	180	160	170
	Working	mm/s	18	17	17	14	14	12	12
	Return	mm/s	180	210	150	180	170	160	160
Main Motor Power	kW	6	10.8	10.8	13.2	13.2	16.7	16.7	
Oil Tank Capacity	L	250	400	550	400	550	400	550	
Backgauge	Precision	mm	±0.10	±0.10	±0.10	±0.10	±0.10	±0.10	±0.10
	Stroke	mm	500	500	500	500	500	500	500
	Speed	mm/s	400	400	400	400	400	400	400
	Power	kW	0.75	0.85	0.85	0.85	0.85	0.85	0.85
Dimension L×W×H	mm	L:2900	L:3950	L:4950	L:3970	L:4950	L:3980	L:4980	
		W:1560	W:1700	W:1700	W:1720	W:1720	W:1960	W:1960	
		H:2420	H:2600	H:2610	H:2610	H:2610	H:2650	H:2650	

◆ Note: Controlling axes can be designed into 3+1 axes/4+1 axes/6+1 axes/8+1axes/10+1axes.

The exact specifications and configuration are subject to the actual quotation.

Main Specification of TPM9

Main Specification		Unit	60T	100T		150T		225T	
Model			TPM9 060/2550	TPM9 100/3100	TPM9 100/4100	TPM9 150/3100	TPM9 150/4100	TPM9 225/3100	TPM9 225/4100
Bending Force	kN	600	1000	1000	1500	1500	2250	2250	
Bending Length	mm	2550	3100	4100	3100	4100	3100	4100	
Column Distance	mm	2150	2700	3700	2700	3700	2700	3700	
Throat Depth	mm	350	420	420	420	420	420	420	
Stroke of Ram	mm	215	265	265	265	265	265	265	
Closed Height	mm	530	530	530	530	530	530	530	
Speed	Approaching	mm/s	200	250	250	180	180	160	160
	Working	mm/s	20	20	15	14	14	12	12
	Return	mm/s	200	250	150	180	180	160	160
Main Motor Power	kW	6	13.2	10.8	13.2	13.2	16.7	16.7	
Oil Tank Capacity	L	300	400	550	400	550	400	550	
Backgauge	Precision	mm	±0.10	±0.10	±0.10	±0.10	±0.10	±0.10	±0.10
	Stroke	mm	500	500	500	500	500	500	500
	Speed	mm/s	400	400	400	400	400	400	400
	Power	kW	1.5	1.5	1.5	1.5	1.5	1.5	1.5
Dimension L×W×H	mm	L:3400	L:3950	L:4950	L:3970	L:4970	L:3980	L:4980	
		W:1500	W:1700	W:1700	W:1720	W:1720	W:1960	W:1960	
		H:2510	H:2700	H:2710	H:2700	H:2700	H:2850	H:2850	

◆ Note: Controlling axes can be designed into 3+1 axes/4+1 axes/6+1 axes/8+1axes/10+1axes.

The exact specifications and configuration are subject to the actual quotation.

The CNC Bending Machine Series



Max. Bending Length 1500mm-4100mm



Max. Bending Length above 4100mm

Bending Tonnage Calculation Table (Reference)

Bending chart

V	R	B	T=420-480N/mm ² (C=1) P(KN/m)																		
			0.5	0.8	1	1.2	1.5	2	2.5	3	4	5	6	8	10	12	15	20	25	30	
4	0.7	2.6	40	105																	
6	0.9	3.9	26	69	106	153															
8	1.5	5.2	20	55	80	115	180														
10	1.7	6.5		41	65	95	145	260													
12	2	7.8			55	80	120	215	335												
16	2.7	10.4				60	90	160	250	360											
20	3.4	13					75	130	200	290	520										
24	3.9	15.6						106	166	240	426	666									
30	5	20							140	190	340	540	770								
35	6	23								170	300	460	660								
40	7	26								150	260	400	580	1030							
50	8.5	32									210	320	460	820	1280						
55	9	36										300	420	750	1170						
60	10	39										270	390	690	1070						
70	11.7	45											330	590	920	1620					
80	13.5	52											290	520	800	1160	1800				
90	15	58												460	710	1030	1600				
100	17	65												410	640	930	1440				
120	20	78													540	780	1220				
140	24	91														660	1030	1830			

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◆ The calculation in the table is based on mild steel.

CNC Bending Tooling

<p>10.10/86° 100T/m</p> <p>R=0.8</p>	<p>10.10/86° (120mm) 100T/m</p> <p>R=0.8</p>	<p>10.108/86° 50T/m</p> <p>R=0.3</p>	<p>10.109/86° 50T/m</p> <p>R=0.3</p>
<p>10.116/86° 20T/m</p> <p>R=0.3</p>	<p>10.12/35° 50T/m</p> <p>R=0.3</p>	<p>10.14/86° 70T/m</p> <p>R=0.3</p>	<p>10.146/86° 50T/m</p> <p>R=0.3</p>
<p>10.200/86° 40T/m</p> <p>R=0.3</p>	<p>10.200/86° (150mm) 30T/m</p> <p>R=0.3</p>	<p>10.202/86° 50T/m</p> <p>R=0.3</p>	<p>10.202/86° (150mm) 50T/m</p> <p>R=0.3</p>

<p>10.203/86° 80T/m</p> <p>R=0.8</p>	<p>10.210° 100T/m</p> <p>R=0.8</p>	<p>40.15</p>	<p>501/30° 50T/m</p>
<p>502/30° 60T/m</p>	<p>503/30° 70T/m</p>	<p>501/86° 60T/m</p>	<p>502/86° 70T/m</p>
<p>503/86° 70T/m</p>	<p>504/86° 100T/m</p>	<p>505/86° 100T/m</p>	<p>506/86° 100T/m</p>

Backgauge

Standard dual-rail backgauge for lengths of 4100mm and below (single-rail backgauge for lengths above 4100mm)

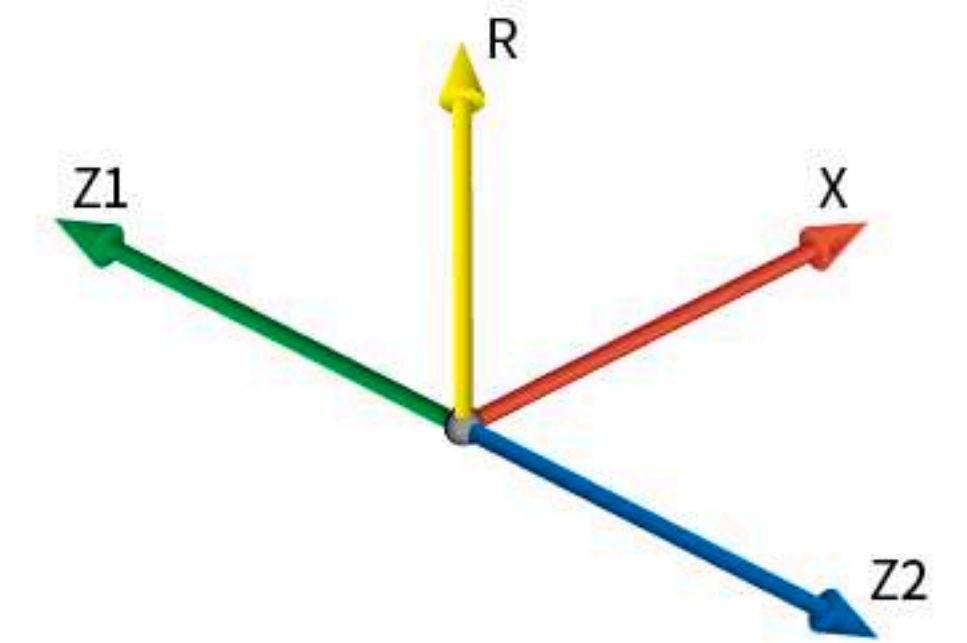
The large lead ballscrew and linear guideway from international famous company ensure the positioning accuracy of the machines. The full functional backgauge system can be extended up to six axis. The workpiece can be bent at whatever angle.



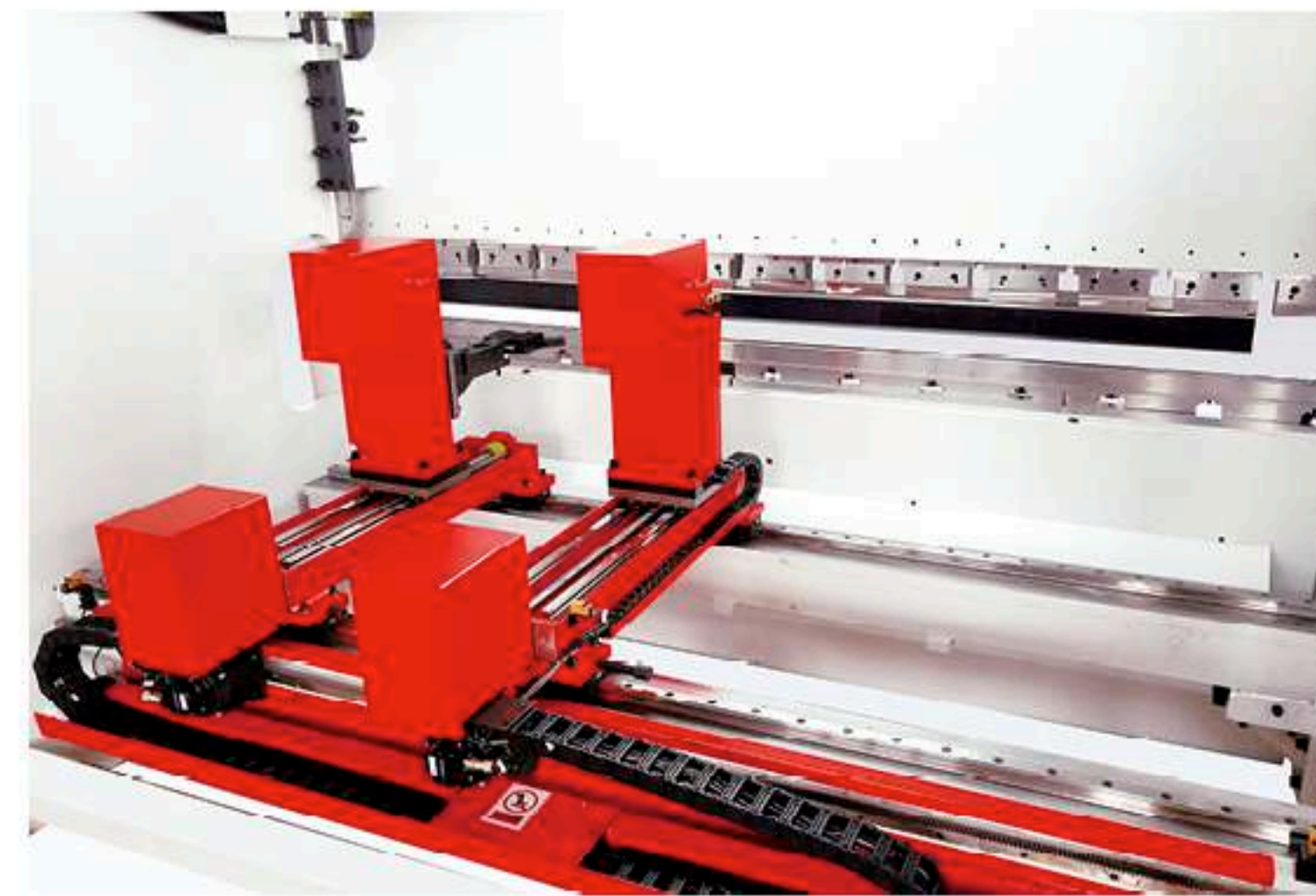
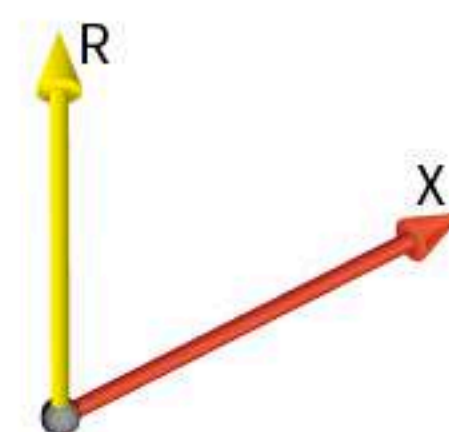
Backgauge: X Axis



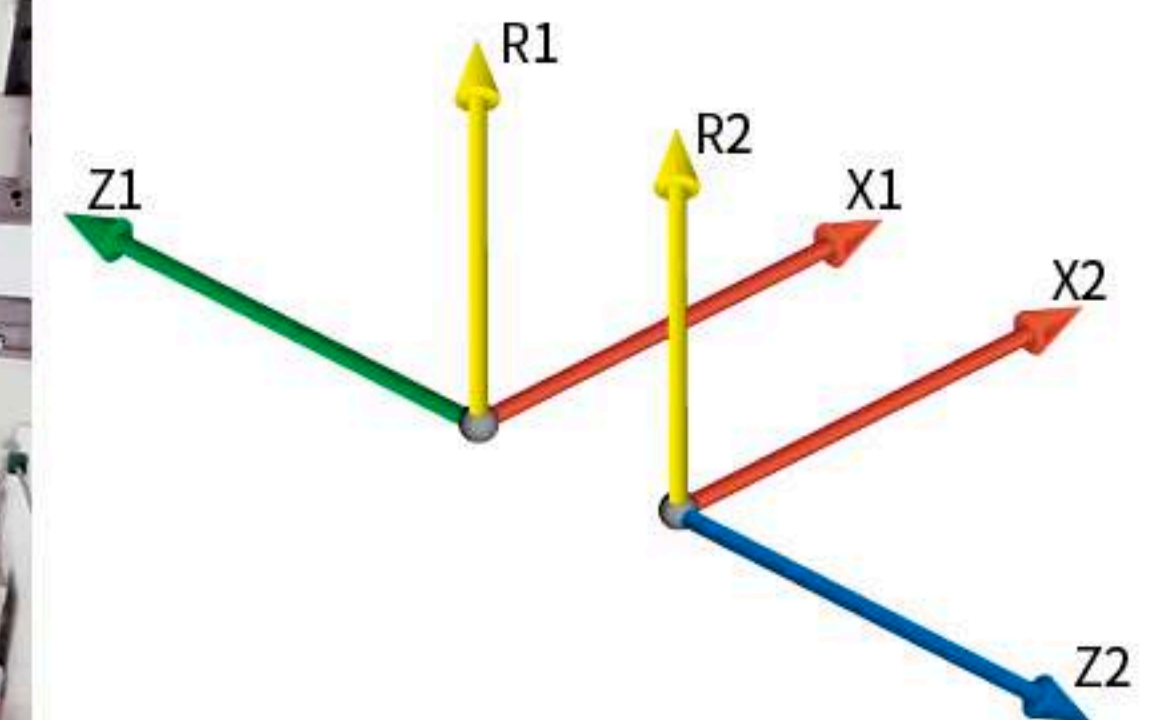
Backgauge: X, R, Z1, Z2



Backgauge: X, R



Backgauge: X1, X2, R1, R2, Z1, Z2



CNC System

DA53T System

- High resolution 10.1" full color LCD wide screen display.
- Industrial grade PCT toughened glass touch screen. Anti-scraping and gloves operation.
- The internal storage capacity is 1GB, and the material can be edited up to 99.
- Support flanging, big arc, one page tabular programming, support product search.



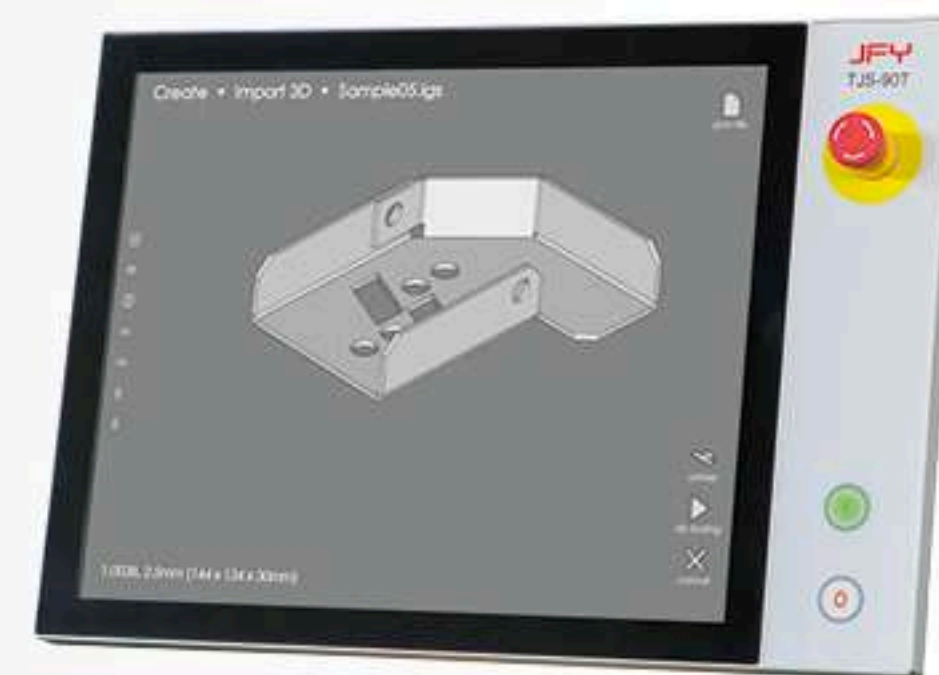
DA66T System

- 2D touch screen graphic simulation
- 3D visualization in production mode
- 17" TFT color display
- Memory capacity 1 GB
- USB interfacing



TJS-90T System

- 19" LCD/TFT touch screen
- 4GB CPU RAM, 64GB SSD
- Support remote control
- Multiple programming options



ABM automatic bending unit



JFY robot unit, intelligent choice for your easier and faster production.

