



# BSTs

## PRESS BRAKE

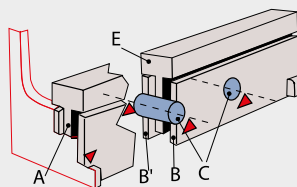
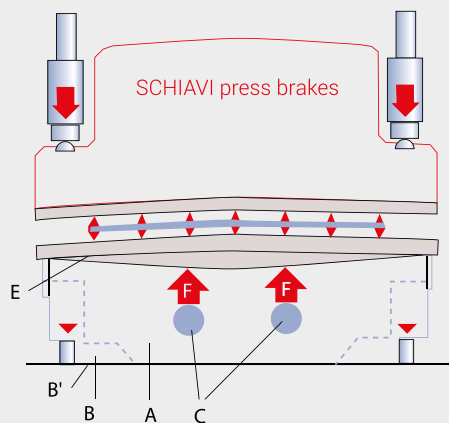
**efficiency**  
Energy recovery guaranteed  
by Start-stop System

### SIMPLICITY AND SAFETY

Schiavi BSTs press brakes are designed for customers that need basic processing, but can not give up the guarantee of Schiavi's technology. Special attention was given to safety features: with the objective of reaching high production standards. The structure is essential, but offers the strengths and reliability necessary to guarantee a precise and constant bend in every working condition. The BSTs press brake features the SK 12 CNC control (LCD monitor) and a 2-axis backgauge.

### COMPOUND LOWER BEAM

While keeping the traditional layout of the side-mounted cylinders, which move the upper beam, the lower beam allows to automatically compensate the deformation of the beams; hence assuring their parallelism. The distance between the upper and lower tools is constant along the entire length, and does not change during the bending process, assuring high quality results.



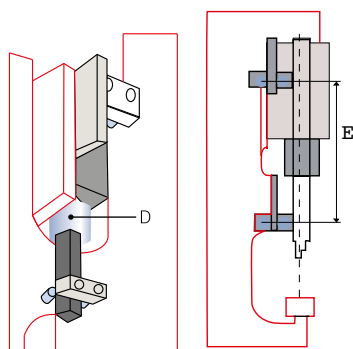
- A - Beam core
- B and B' - Side plates, welded on the sides
- C - Two reaction pins, integral with the plates (the beam core rests on them)
- E - Die holder beam welded on the beam core
- F - Reaction forces

**NATURAL  
CROWNING  
SYSTEM**

**Schiavi**

Since 1958

## PRECISE CENTERING



THE UPPER BEAM IS GUIDED BY 4 PAIRS OF BEARINGS THAT SLIDE, ALONG THE MACHINE'S SIDES, ON TRACKS OF HARDENED AND RECTIFIED STEEL. THE ALIGNMENT AND CENTERING OF THE BEAMS IS GUARANTEED BY THE GREAT DISTANCE BETWEEN THE UPPER AND LOWER BEARINGS (E). BOTH THE OPTICAL SCALES ARE CONNECTED TO THE CNC, ALLOWING TO CONTROL THE OIL FLOW THROUGH THE SERVO-VALVES.

## TECHNICAL SPECIFICATIONS

		BSTs 50.12	BSTs 50.20	BSTs 80.25	BSTs 100.30	BSTs 125.30	BSTs 125.40
Bending force	kN	500	500	800	1000	1250	1250
Length of the tables	mm	1250	2090	2550	3100	3220	4200
Distance between columns	mm	850	1660	2120	2700	2700	3760
Throat depth	mm	405	405	405	405	405	405
Max Open Height	mm	150	150	200	200	200	200
Max stroke	mm	355	355	400	400	400	400
Working level height	mm	910	910	910	910	910	910
Table width	mm	60	60	60	90	90	90
Nr. of intermediates	n°	6	10	12	15	15	21
Approach speed	mm/sec	200	200	200	200	200	200
Working speed min - max	mm/sec	1-9	1-9	1-9	1-9	1-9	1-9
Return speed	mm/sec	80	80	90	90	90	90
Motor power	kW	3	3	5,5	7,5	9	9
Weight	kg	3700	5500	5800	8000	8200	12000
Max lenght	mm	2100	2910	3370	3950	3950	5000
Width	mm	1560	1560	1560	1560	1800	1800
Height	mm	2360	2360	2410	2410	2800	2800

## INTEGRATED SK12 CNC CONTROL SYSTEM

THE BSTS PRESS BRAKE FEATURES THE SK12 CNC CONTROL WITH AN INTERNAL MICROPROCESSOR. THE CNC SK12 IS THE MOST COMPACT MODEL IN THE LINEUP, AND IT IS BASED ON THE LATEST TECHNOLOGIES. IT REPRESENTS THE IDEAL SOLUTION FOR PRESS BRAKE WITH 2 AXIS (X, R, Y1, Y2).

SIMPLICITY AND RAPIDITY AID THE USER DURING THE BENDING PROCESS. ON REQUEST, IT IS POSSIBLE TO INSTALL THE AUTOMATIC 2D SEARCH OF THE BENDING SEQUENCE.

## INTEGRATED 2-AXIS BACKGAUGE (X AND R AXIS)

THE BACKGAUGE OF PRESS BRAKES FROM 2 TO 4 METERS IS COMPOSED BY A CROSSBEAM SUPPORTED BY TWO ARMS FIXED ONTO THE MACHINE'S SIDES WITH A STROKE OF 500 MM ALONG THE X-AXIS GRANTED BY TWO PRISMATIC RECIRCULATING BALLS LINEAR GUIDEWAYS AND AN ALUMINUM SLIDE RAIL. THE MOVEMENT ALONG THE R-AXIS IS GIVEN BY TWO RECTIFIED PISTONS, HAVING A STROKE OF 150MM, RACK AND PINION ACTUATOR AND ENDLESS SCREW SPEED REDUCER.

FOR PRESS BRAKE OF 2 METERS OR LESS, A SINGLE BEAM BACK GAUGE, FIXED TO THE MACHINE'S SIDES, IS PROVIDED. THE X-AXIS ON HARDENED AND RECTIFIED SHAFTS OF 450 MM THROUGH BUSHINGS AND BALL SCREWS. THE MOVEMENT OF 150 MM ALONG THE R-AXIS, IS OBTAINED BY TWO ANTI-SEIZE CAST-IRON PISTONS, RACK AND PINION ACTUATOR AND ENDLESS SCREW SPEED REDUCER.

