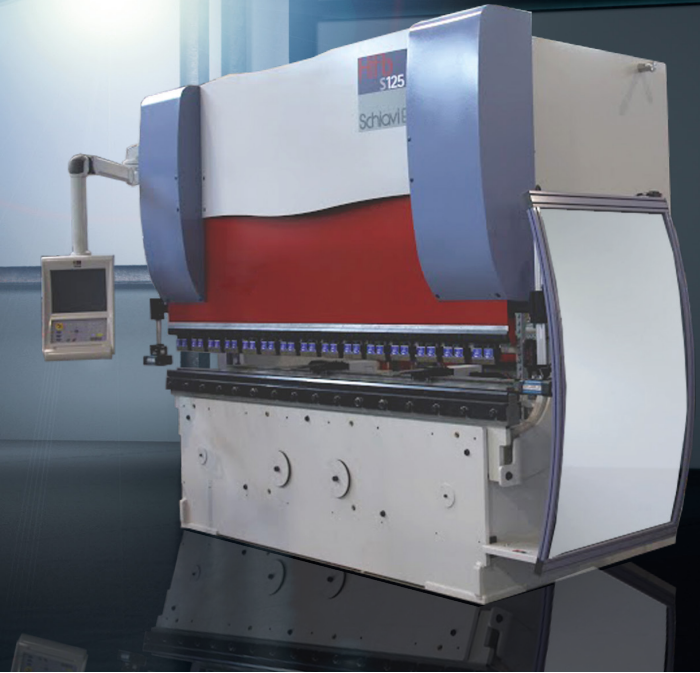




HFBs



PRESS BRAKE

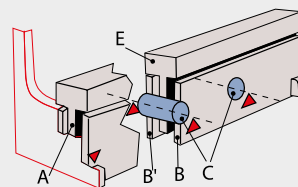
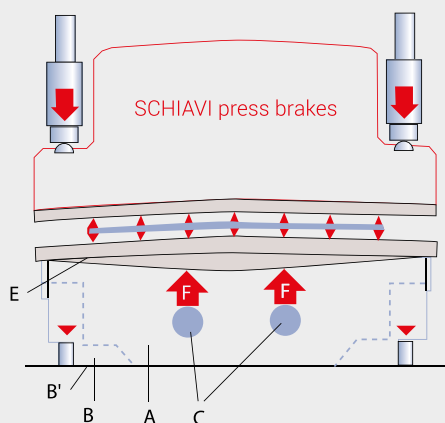
efficiency
Optional:
Optimized bending process
for guaranteed energy savings

BEND WITH ABSOLUTE PRECISION

The Schiavi HFB press brake represents the most advanced model in the automation of the bending process. The HFBs model allows companies operating in sheet metal industry to increase their competitiveness, by combining a dedicated hydraulic system and a CNC control software of the latest generation. The HFBs press brakes are particularly suited for the integration in a robotic bending cell. The HFBs model ensures great versatility and flexibility with excellent results in the production of sheet metal parts, of various thicknesses, for every possible application.

COMPOUND LOWER BEAM

The compound lower beam is **patented internationally** and, while keeping the traditional layout of the side-mounted cylinders moving the upper beam, it 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. Through the innovative use of an additional "Gooseneck", the distance between the beams is accurately measured, regardless of structural deflections. Since the 80's, the Schiavi patent stands for reliability and professionalism: **Made in Italy** and **technological innovation** to bend with absolute precision.



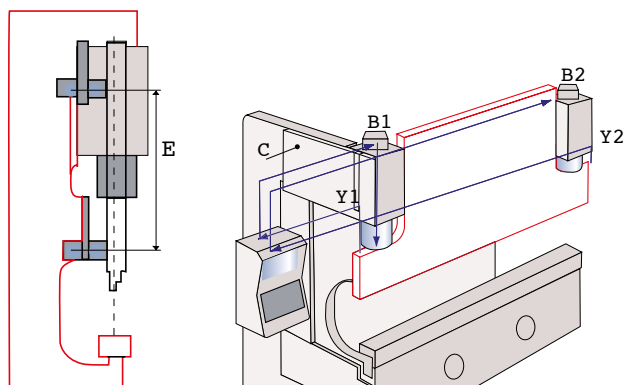
- A - Beam core
- B and B' - Side plates, welded on the sides
- C - Two reaction pins, integral with the plates (the beam core rests on them)
- E - Die holder beam welded on the beam core
- F - Reaction forces

**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 (Y1 and Y2) are mounted on two plates (C) shaped as the side's throat and fixed to the lower beam. Moreover, the optical scales are connected to the CNC, allowing to control the oil flow through the servo-valves (B1 and B2).

During the downward of the upper beam, the optical scales record the movements: the difference between the data determines the automatic compensation and the consequent parallelism of the tables.

TECHNICAL SPECIFICATIONS

		HFBs 50.20	HFBs 50.25	HFBs 80.20	HFBs 80.25	HFBs 100.30	HFBs 125.30	HFBs 125.40	HFBs 170.30	HFBs 170.40	HFBs 220.30	HFBs 220.40
Bending force	kN	500	500	800	800	1000	1250	1250	1700	1700	2200	2200
Length of the tables	mm	2090	2550	2090	2550	3100	3220	4200	3270	4250	3340	4320
Distance between columns	mm	1660	2120	1660	2120	2700	2700	3760	2700	3760	2700	3760
Throat depth	mm	405	405	405	405	405	410	410	410	410	410	410
Max stroke	mm	250	250	250	250	250	250	250	250	250	250	250
Max Open Height	mm	450	450	450	450	450	500	500	500	500	500	500
Working level height	mm	910	910	910	910	910	960	960	960	960	960	960
Table width	mm	60	60	60	60	90	90	180	180	180	180	180
Nr. of intermediates	n°	10	12	10	12	15	15	21	16	21	16	21
Approach speed	mm/sec	200	200	200	200	200	200	200	200	200	200	200
Working speed min. - max	mm/sec	1-9	1-9	1-9	1-9	1-9	1-9	1-9	1-9	1-9	1-9	1-9
Return speed	mm/sec	90	90	90	90	90	90	90	90	90	90	90
Motor power	kW	5,5	5,5	5,5	5,5	7,5	9	9	11	11	15	15
Weight	kg	5800	6200	5800	6200	8400	8600	12500	12600	14600	17000	17800
Max length	mm	3100	3540	3100	3540	4120	4120	5180	4150	5210	4180	5240
Width	mm	1560	1560	1560	1560	1670	1860	1860	1890	1890	1970	1970
Height	mm	2800	2800	2800	2800	2900	3150	3150	3200	3200	3300	3300
Shipping height	mm	2600	2600	2600	2600	2700	2950	2950	3000	3000	3100	3100

