



The AddisonMcKee DataBend 100ESRB machine is all electric in operation and is manufactured to a modular design enabling a number of variants to be offered based upon the same structure. This enables machines to be designed, or in some instances modified, specifically to suit individual customer needs.

The AddisonMcKee DataBend 100ESRB machine is a 100mm high performance draw bending machines designed for maximum productivity demanded by today's industry. All AddisonMcKee machines are built using exacting standards demanded and enforced by our own Total Quality Assurance programme.

The machine comes as standard with the following features:

- Touch Screen Control for ease and speed of operation
- Full Colour Graphics
- Graphical Representation of the Component Shape
- XYZ to YBC Conversion
- Tooling Data Storage Facility
- Sequence Teach Facility
- Production Monitoring Facility
- Piece Counter (Electronic)
- Floppy Disc Drive Backup Unit and CD ROM
- Phased Mandrel Retraction
- Powered Follower Slide
- Wiper Die Bracket
- Three Mandrel Rods
- On-line Modem Diagnostics

The DataBend 100ESRB as generally described is supplied complete with the following equipment:

- Databend CNC unit.
- Foot pedal cycle start.
- Clockwise bending rotation (anti-clockwise on request - no cost option).
- Two day operator training at our works.
- Operator manual and circuit diagrams.
- Automatic mandrel lubrication.
- Fibre optic safety mat system
- Safety barrier rail
- Recapture software
- Sequential software
- Safe load procedure (foot)
- CE mark

Capacity

Tube outside diameter	Standard	100 mm	MAX
Tube wall thickness		2.5 mm	MAX
Centerline radius		500 mm	MAX
" " "		50 mm	MIN
Bend arm rotation (i.e. bend angle)	C axis	193 deg	MAX
Length of tube over the mandrel rod into the collet	Y axis	5000 mm	MAX
Length of tube over the mandrel rod through the collet	Y axis	8000 mm	MAX
Length of tube into the collet before last bend - <i>subject to tooling limitations.</i>		550 mm	MIN
Tube working height		1250 mm	
Tube height from tooling platform		70 mm	MIN
" " " " "		420 mm	MAX
Mandrel retraction stroke		600 mm	
Follower slide stroke		650 mm	
Clamp slide stroke - fall away only		148 mm	
Reaction slide stroke		550 mm	
Vertical shift pitch	Z axis	350 mm	
Horizontal shift	X axis	650 mm	
Clamp slide - CLR adjustment stroke		310 mm	MAX
Boost stroke		2500 mm	
Boost force		80 KN	

Axis specification

AXIS	SPEED 100%	UNITS	RESOLUTION	UNITS	REPEATABILITY	UNITS
Y - feed	80	M/min.	0.008	mm/count	0.05	mm
B - rotate	70	r.p.m.	0.0028	°/count	0.05	degrees
C - bend	10	r.p.m.	0.001	°/count	0.05	degrees
X - radius	7.5	M/min.	0.0033	mm/count	0.05	mm
Z - shift	5.6	M/min.	0.0005	mm/count	0.05	mm

Total machine kVA @ 415V	99
C axis stall torque kNm	44

Dimensions

Overall length to the rear from tool post	10130 mm
Bend arm radius (clamp out)	1665 mm
Length forwards from tool post	360 mm
Length of reaction arm - at MAX. center line radius from Y axis center	1800 mm
Overall width	2400 mm
Overall height	1850 mm
Machine weight	16000 Kg (Est.)

Optional Extras

To complement the machine, a wide variety of optional extras are available. Some of these may be essential for your production needs, such as items to suit climatic conditions, or desirable for specific processes, such as automation systems.

Machine capacity figures are based on using material to the specification of BS3602:part 1:1987 having a mean tensile strength of 450 N/mm² bent at a radius of 2 times the outside diameter.

This document has been compiled in good faith. (Errors and omissions excepted).

This information applies to machines manufactured after serial number - 9338

The information in this document is not binding in detail.

In pursuit of excellence AddisonMcKee retain the right to amend designs from time to time without prior notice.