



The AddisonMcKee DataBend 130ESRB 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 130ESRB machine is a 130mm high performance boost bending machine 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 130ESRB 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	130 mm	MAX
Tube wall thickness		3 mm	MAX
Centerline radius		350 mm	MAX
" " "		75 mm	MIN
Bend arm rotation (<i>i.e. bend angle</i>)	C axis	193 deg	MAX
Length of tube over the mandrel rod into the collet	Y axis	3000 mm	MAX
Length of tube into the collet before last bend - <i>subject to tooling limitations.</i>		330 mm	MIN
Tube working height		1280 mm	
Tube height from tooling platform	Lower	85 mm	
" " " " "	Upper	435 mm	
Mandrel retraction stroke		665 mm	
Follower slide stroke		800 mm	
Clamp slide stroke - <i>rising</i>		N/A mm	
Reaction slide stroke		500 mm	
Vertical shift pitch		350 mm	
Horizontal shift	X axis	550 mm	
Difference between tooling radii		100 mm	MAX
Boost stroke		650 mm	
Boost force		120 KN	

Axis specification

AXIS	SPEED 100%	UNITS	RESOLUTION	UNITS	REPEATABILITY	UNITS
Y - feed	60	M/min.	0.002	mm/count	0.05	mm
B - rotate	50	r.p.m.	0.001	°/count	0.05	degrees
C - bend	8	r.p.m.	0.001	°/count	0.05	degrees
X - radius	8	M/min.	0.001	mm/count	0.05	mm
Z - shift	4.6	M/min.	0.001	mm/count	0.05	mm
Y - boost	13.3	M/min.	0.001	mm/count	0.05	mm

Total machine kVA @ 415V	99
C axis stall torque kNm	45

Dimensions

Overall length to the rear from tool post	8000 mm
Bend arm radius (<i>clamp out</i>)	1715 mm
Length forwards from tool post	360 mm
Length of reaction arm - <i>at MAX. center line radius from Y axis center</i>	1950 mm
Overall width	2400 mm
Overall height	1850 mm
Machine weight	14000 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.