



The AddisonMcKee DataBend 75ESRB 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 75ESRB machine is a 76mm high performance draw 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.

- Auto setting due to control of all movements being programmable
- Noise levels below 80dB (A) Leq
- Clean machine – no hydraulics
- Improved axis resolution giving better repeatability
- Faster floor to floor due to greater axis control
- Reduced running costs

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 Diagnostic

The DataBend 75 CNC 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	76	Mm	MAX
Tube wall thickness		3	mm	MAX
Centerline radius		250	mm	MAX
" " "		25	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	2000	mm	MAX
Length of tube into the collet before last bend - <i>subject to tooling limitations.</i>		50	mm	MIN
Tube working height	Lower	1145	mm	
Tube height from tooling platform	Lower	50	mm	
" " " " "	Upper	400	mm	
Mandrel retraction stroke		300	mm	
Follower slide stroke		450	mm	
Clamp slide stroke - <i>direct acting only</i>			mm	
Reaction slide stroke		380	mm	
Vertical shift pitch	1 st	350	mm	
Boost stroke		350	mm	
Horizontal shift	X axis	300	mm	
Difference between tooling radii - <i>subject to tooling limitations.</i>		100	mm	MAX
Boost thrust		65	KN	
Clamp slide - CLR adjustment stroke		195	mm	

Axis specification

AXIS	SPEED 100%	UNITS	RESOLUTION	UNITS	REPEATABILITY	UNITS
Y - feed	100	M/min.		mm/count	0.05	mm
B - rotate	85	r.p.m.		°/count	0.05	degrees
C - bend	18.5	r.p.m.		°/count	0.05	degrees
X - radius	18	M/min.		mm/count	0.05	mm
Z - vertical	14.5	M/min		mm/count	0.05	mm
Y - boost	13	M/min		mm/count	0.05	mm

Total machine kVA @ 415V	48
C axis stall torque kNm	12

Dimensions

Overall length to the rear from tool post	4850	mm
Bend arm radius	1200	mm
Length forwards from tool post	230	mm
Length of reaction arm	1650	mm
Overall width	2000	mm
Overall height (including electrical cabinet)	2000	mm
Machine weight	5000	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.