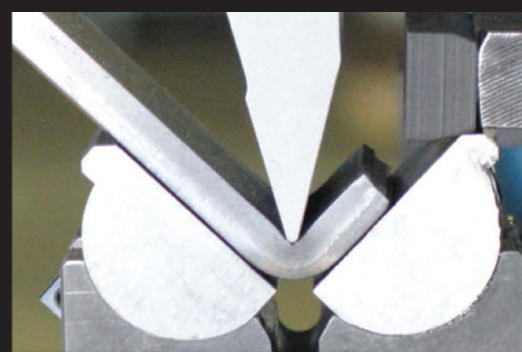
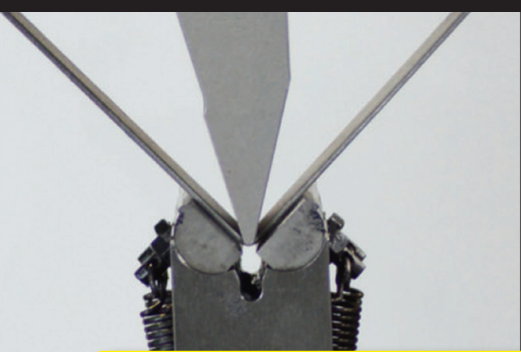


ACTIVE BEND



NEW TECHNOLOGY FOR HIGH QUALITY RESULTS

Active Bend provides advantages that the standard dies can't perform:

- 40° acute bending
- narrow minimum edges
- no die marking (between sectioned pieces)
- no strain with perforated sheets

NOVINKA - TECHNOLOGIE PRO VYSOKOU KVALITU OHYBU

Active Bend přináší výhody, které se standardními matricemi nezískáte:

- maximální úhel ohnutí 40°
- úzké minimální hrany ohýbaného plechu
- žádné otlaky po ohýbání (na přechodech matic)
- minimální napětí na děrovaném plechu

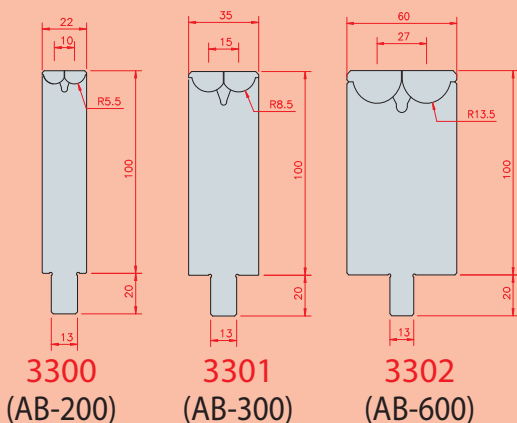


- ▶ no die mark bending
- ▶ 40° acute bending

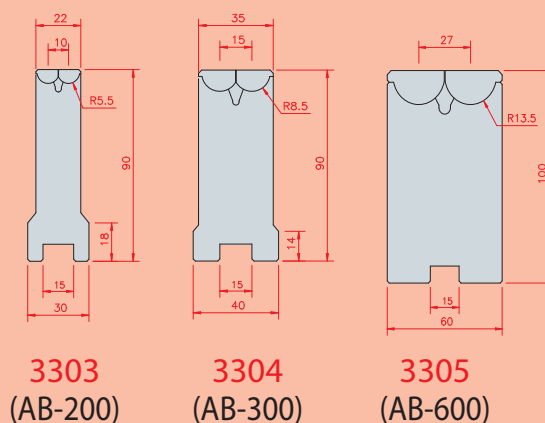


- ▶ bezotlakové ohýbání
- ▶ maximální úhel 40°

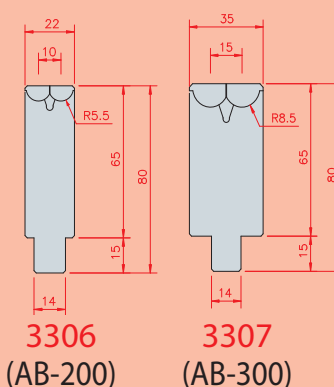
WILA-TRUMPF



AMADA-PROMECAM RAIL



AMADA-PROMECAM



MODEL / MODEL	DÉLKA / LENGTH (mm)
AB200	50
	100
	200
AB300	15, 20, 25, 30
	50
	100
	200
AB600	15, 20, 25, 30
	50
	100
	200

ACTIVE BEND



OHÝBACÍ PARAMETRY PRO ACTIVE BEND

REDUKCE OHYBU

MATERIAL	T	90° OHYB (RAZNÍK S ÚHLEM 88° X 0.2R)		
		AB-200	AB-300	AB-600
SPCC	0.8	2.10		
	1.0	2.32	2.67	
	1.2	2.49	2.88	
	1.6	2.90	3.51	
	2.0	3.56	3.98	
	3.0		5.21	5.50
	4.5			6.95
	6.0			9.95
SECC	0.8	1.78		
	1.0	1.98	2.47	
	1.2	2.25	2.59	
	1.6	2.88	3.06	
	2.0	3.63	4.05	
SUS304	0.5	1.14		
	0.8	2.09		
	1.0	2.23	2.60	
	1.2	2.63	3.08	
	1.5	3.24	3.49	
	2.0	3.68	3.95	
	3.0		5.57	
AL	0.5	1.52		
	1.0	2.05	1.97	
	1.5	2.69	2.79	
	2.0	3.80	3.94	
	3.0		5.17	

VNĚJŠÍ RÁDIUS

MATERIAL	T	90° OHYB (RAZNÍK S ÚHLEM 88° X 0.2R)		
		AB-200	AB-300	AB-600
SPCC	0.8	1.868		
	1.0	1.851	2.511	
	1.2	2.222	2.597	
	1.6	2.573	3.333	
	2.0	2.806	3.718	
	3.0			5.597
	4.5			7.093
	6.0			8.686
SECC	0.8	1.726		
	1.0	1.823	2.378	
	1.2	2.321	2.527	
	1.6	2.729	2.909	
	2.0	2.870	3.454	
SUS304	0.5	1.970		
	0.8	2.485		
	1.0	2.497	3.156	
	1.2	2.657	3.455	
	1.5	2.847	3.684	
	2.0	3.209	4.102	
	3.0		4.755	
AL	0.5	0.971		
	1.0	1.536	1.891	
	1.5	2.414	2.535	
	2.0	2.669	3.362	
	3.0		4.210	

(UNIT:MM)



PARAMETRY OHÝBÁNÍ PRO ACTIVE BEND

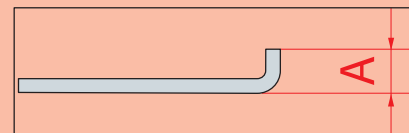
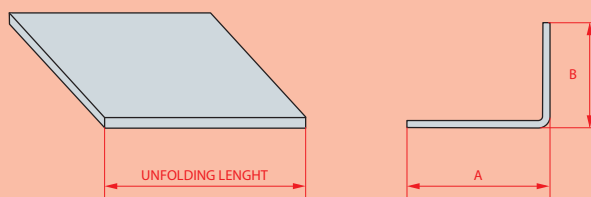
SÍLA OHYBU

T	AB200	AB300	AB600
0.5	50		
0.8	70		
1.0	80	80	
1.2	110	110	
1.6	200	200	
2.0	300	300	
2.3			
2.6			
3.0		510	300
4.0			
4.5			400

T	MATRICE - V
0.5	40 (V 4)
0.8	70 (V 6)
1.0	110 (V 6)
1.2	120 (V 8)
1.6	170 (V 10)
2.0	220 (V 12)
2.3	250 (V 14)
2.6	280 (V 16)
3.2	270 (V 25)
4.0	340 (V 32)
4.5	440 (V 32)
6.0	480 (V 50)

MATERIAL	T	ROZMĚJ OKRAJE (A)		
		AB-200	AB-300	AB-600
SPCC	0.8	6.01		
	1.0	6.13	9.15	
	1.2	6.37	9.39	
	1.6	6.91	9.64	
	2.0	7.21	9.84	
	3.0			17.0
	4.5			17.5
6.0			18.3	
SECC	0.8	5.80		
	1.0	6.16	9.01	
	1.2	6.39	9.23	
	1.6	6.93	9.56	
	2.0	7.33	9.94	
SUS304	0.5	5.49		
	0.8	6.01		
	1.0	6.35	9.34	
	1.2	6.61	9.40	
	1.5	7.04	9.64	
	2.0	7.44	10.05	
3.0		10.82		
AL	0.5	4.85		
	1.0	5.61	8.56	
	1.5	6.17	8.83	
	2.0	6.75	9.60	
3.0		10.47		

THIS DATA IS FOR REFERENCE. IT DEPENDS ON THE UPPER TOOL RADIUS, MATERIALS AND SO ON. WE RECOMMEND THE TEST BENDING.



EQUIVALENT V WIDTH
 SB200... V 10
 SB300... V 16
 SB600... V 25

※ UNFOLDING VALUE = (A + B) – UNFOLDING LENGTH