BR600 ANGLE BENDING MACHINE

According to your needs, we have various types of profile bending machine for you to choose from. We have these models for you to choose from:

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TEL: 86-513-88820117
Company Profile

Nantong Borisbang Industrial Technology (NBIT) rooted in Haian County of Jiangsu Province, China. The main production profile bending machine. NBIT was founded in 2001 and has more than 17 years experience in this field.

NBIT is your specialist and technology partner for powerful and future-proof tube bending machines and bending solutions. Having a solid trained technical team with a wide range of quality Section Bending Machines, and On-Time Deliveries, we have been accumulating happy customers worldwide.

Our core focus and specialisation is in the Section Bending Machines. Over the years, the Company has grown multifold and currently exports to several countries in Sweden, Germany, England, Thailand, Iran, Korea, Vietnam, Russia, Malaysia, Dubai, Saudi, Arabia, India, South Africa, United Arab Emirates, Singapore, Uzbekistan.

**Reliable**
- With small pressure loss and lower heat comes on.

**High precision**
- CNC control, with multifunction and flexible operation.

**Reasonable structure**
- Steel base and frame with high rigidity

**High safety performance**
- Machine have good rigidity, with low center of gravity and smooth running.

**After-sale service**
- Whole life service, supply the spear parts in time with low compensation.
1. Structure

W24S-600 profile bending machine is mainly composed of bed part, side roll part, idler part, transmission part, electrical part and hydraulic system, mould and so on.

The fuselage of the machine is a steel plate welded structure, and the internal stress is eliminated by annealing treatment. The angle bending machine has sufficient strength and stiffness to satisfy the bending of the profile in the range of the machine.

Replacement of the mold can be rolled angle steel, flat steel, steel, channel steel, I-beam, round steel, steel pipe and other profiles.

Profile bending machine is a kind of high efficient processing equipment for various special-shaped steels, such as roll bending angle steel, channel steel, I-steel, flat steel, Square steel, round steel and so on.

2. Technical Parameters

- Details technical parameters show:

<table>
<thead>
<tr>
<th>Max. Section (mm)</th>
<th>Min. Bending DIA (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>300 x 80</td>
<td>50000</td>
</tr>
<tr>
<td>240 x 240</td>
<td>40000</td>
</tr>
<tr>
<td>350 x 350 x 12</td>
<td>30000</td>
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<tr>
<td>200 x 200 x 30</td>
<td>80000</td>
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<tr>
<td>700</td>
<td>60000</td>
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<tr>
<td>500</td>
<td>40000</td>
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</tbody>
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<table>
<thead>
<tr>
<th>Max. Section (mm)</th>
<th>Min. Bending DIA (mm)</th>
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<tbody>
<tr>
<td>650 x 100</td>
<td>20000</td>
</tr>
<tr>
<td>510 x 20</td>
<td>10000</td>
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<tr>
<td>200 x 200 x 30</td>
<td>45000</td>
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<tr>
<td>700</td>
<td>60000</td>
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<tr>
<td>700</td>
<td>60000</td>
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</tbody>
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  **Sectional modulus cm³:** 500-600  **Bending speed:** 6 Meters/Minute

  **Material yield limit (Mpa):** 250  **Motor power (KW):** 45
Product Description

Angle Bending Machine is a kind of highly effective processing equipment which especially used in various of special sections, such as angle steel, channel steel, I-steel, flat steel, square steel, round steel and so on. Angle Bending Machine can complete the procedure of bending circle and corrective round working with one time load the material.

Angle Bending Machine are also referred to as Angle Roller, Angle Rolls, Section Benders, Section Bending Machine, Angle Rolling Equipment, Angle Rolling Machine, Angle Steel Bending Machine, Profile Bending Machine and Steel Angle Rolling Machine.

Export Country: Sweden, Germany, England, Thailand, Iran, Korea, Vietnam, Russia, Malaysia, Dubai, Saudi, Arabia, India, South Africa, United Arab Emirates, Singapore, Uzbekistan

The frame is made of high quality steel, special process, construction enables the currently strongest bending force available on the market in this machine size. Offer you the highest speed and the largest drive torque and therefore minimize the throughput time with a maximum of quality and throughput. Our machines are always more powerful and more heavily proportioned in terms of frame, shaft size, bearings and drive torque than machines from other suppliers. Roll shafts are made from high-strength chrome-nickel alloy steel, and are the largest diameter shafts of any comparable machine. These heavily proportioned shafts help minimize deflection, resulting in improved bending. Variable speed system hydraulic drive to reduce machine size, since these are often important for the overall functionality as well as performance and endurance.
2.2 Model and specification

Please find the right model according to the maximum bending resistant modulus of profiles.

3. Main structure of angle bending machine

All three rolls are main drive roller. The top roller move by elevation, the bottom roller rotate in a fixed position. It's easy to take off the finished work piece. Independent and movable console to make the operation easier. It's an advanced machine to easy operate and maintain with small flat edge.

Top roller install in the above the machine body, the bear in the two sides of the top roller used cylindrical roller bearing. The top roller movement up and down which driven by hydraulic.

Bottom roller rotate in a fixed position.

Top roller shaft and bottom roller shaft are all main drive shaft, through the hydraulic motor, gear, chain to drive the top roller shaft and bottom roller shaft rotary. The unique design of synchronous mechanism make the top and bottom mold have the same line speed when bending the different profiles.

Guide roller easy to roll the asymmetrical section to avoid the bending default.

4. Hydraulic system

The usage of the hydraulic system: drive the motor to make the top roller and bottom roller rotate; And drive the cylinder to make the top roller move by up and down.

The hydraulic system is reasonable in design, reliable operation, equipped with a high accuracy oil and return oil filter, in order to ensure cleanliness of the system oil.

The main valve hydraulic system adopts the famous quality products. Pump, oil filter, motor, seals are used brand-name manufacturers of domestic or foreign joint venture products, its advanced performance, reliable quality. All hydraulic parts into the factory have to undergo a rigorous testing, screening, to eliminate the hidden trouble.

Layout of pipeline system, convenient operation, flexible action neatly, and overload protection device.

5. Electric system

Main voltage 380V 50HZ 3phases

Main motor 5.5KW

The machine electric control part of the contactor as the core, with the electric control system and hydraulic system, in order to realize the machine each action, main buttons to move the button box and a console based.

Through the digital display shows the amount of movement, convenient intuitive operation.

The high voltage part of the main electrical components are brand-name and quality products, with long service life, no fault time.
6. Main characteristic

6-1. The molds of this machine have good mechanical properties, high strength, strong wearability, suitable for high load operation and long life after forging, quenching and tempering.

6-2. Double row self-aligning roller bearing mounted in the end of main shaft, there's large capacity and reduce the power loss caused by friction, long life service and saving energy.

6-3. Movable console and digital display for top roller elevation amount make the operation easier.

6-4. High accuracy displacement sensor of the top roller elevation ensure the precision and monitor of each roller.

6-5. This machine adopts the whole body, strong rigidity, good hoisting, easy to install, and annealing treatment, eliminate stress, improve the accuracy.

7. Angle bending machinery installation and commissioning

The level of the ground plane and tilt in any direction shall not exceed 2mm / m.

Machines should be checked before installation completely, all preparations have been installed before they can proceed on the installation sequence.

The following mold surface level as a benchmark to check the tilt and the upper and lower mold parallelism, adjusted to meet the requirement. All installed, inspected before tightening bolts.

Must ensure the equipment flexible running after the installation.

Prior to starting the test the connection to be solid and the department of inspection and adjustment of the gap part of all sports and travel and so on, to check whether or not a good electrical switch.

After the completion of preparatory work for the commissioning, commissioning of 10 minutes, stopping to check all in good condition after the operation before the load test.

8. Profile rolling machine operation and safety maintenance

This equipment is very easy to operate and reliable. Push the button “forward” and “backward” separately, can get the different rotate direction. The operation should obey the following principle:

8-1. Don’t running the machine when the electric system is in abnormal situation.

8-2. Forbid the operator who don’t know the machine and don’t abide by the rules running the machine.

8-3. Ensure there’s a good light in working area.

8-4. Don’t allow the two sides flat edge of the work piece overlapping to prevent damage the machine.

In order to ensure the machine is a good running station, please change the worn parts timely. Establish reasonable repair and maintenance system, the workplace, the device should be kept clean and tidy surroundings.
9. Machine lubrication

A reasonable machine lubrication is to reduce power consumption and increase machine life and effective measures to this, we must choose the right lubricants, to establish the necessary lubrication system.

9-1. Lubrication

The machine according to the work of cups were used lubricating oils, artificial fuel, lubricating oil tank focused on three ways.

9-2. Lubricant Selection

Artificial refueling Department, the use of calcium-based grease, oil cup lubrication points, the summer use of calcium-based #2 grease, the winter using a # calcium-based grease.

9-3. Lubrication system and note

The user according to the specific situation of the machine, load and operation of the establishment of a specific lubrication system.

The machine before starting the lubrication points must be sufficient oil supply.

The machine in a continuous working conditions, the oil cup oil in general 4 hours once a month in general lubricating the gears once.

Machine washed once a year the whole lubrication system.