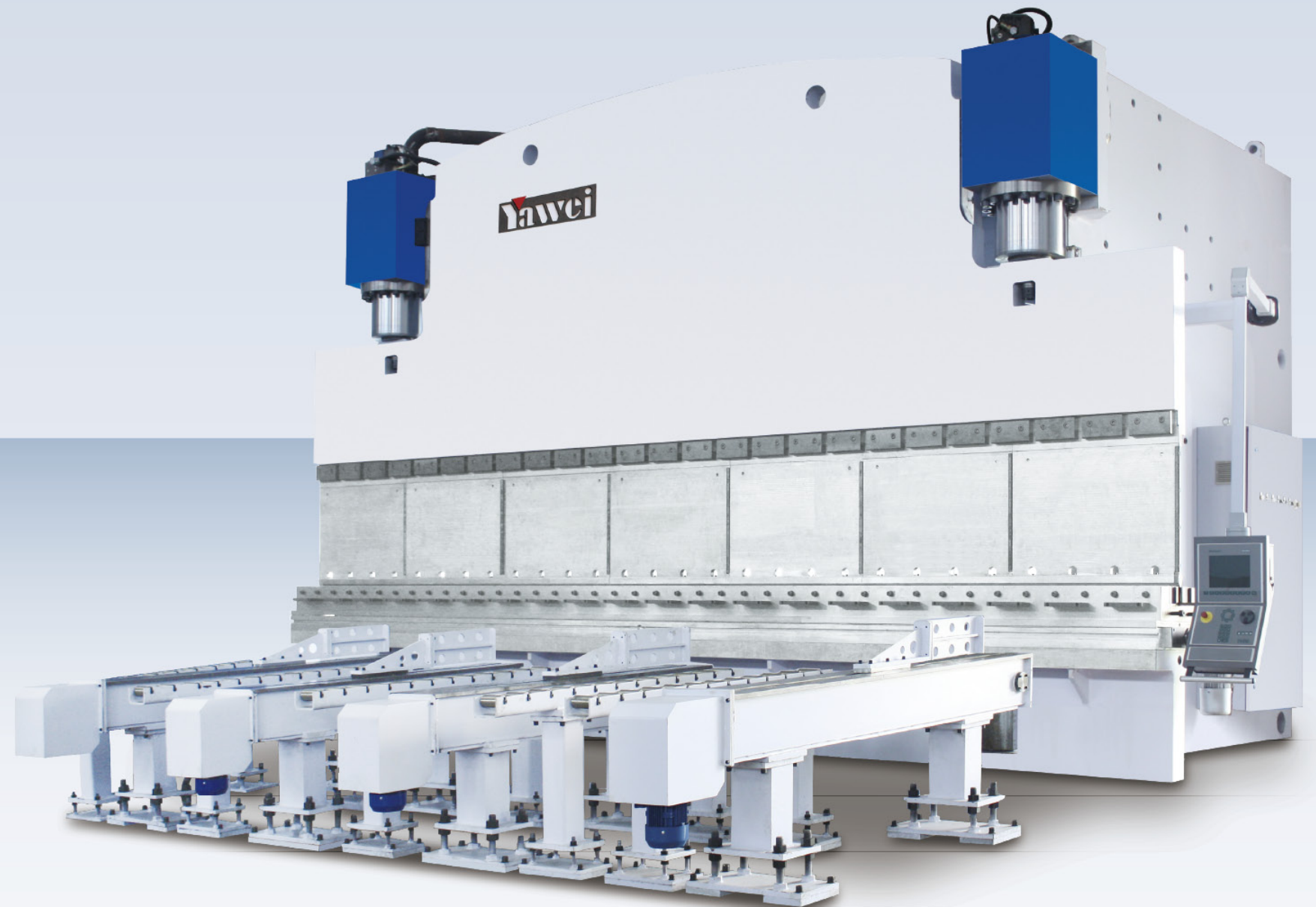


PBA系列 大型折弯机

PBA Series Heavy Duty Pressbrake

- 先进的设计，高速度、高精度、高刚性数控板料折弯机
- 优质的钢板原材料，大型五面体加工中心，是亚威高品质的保证
- 电液伺服系统，全闭环控制滑块同步
- 滑块双导轨结构，自润滑导轨，确保滑块长久精确运行
- 工作台机械挠度补偿和喉口变形补偿机构，确保折弯精度
- 油缸球面浮动支撑结构，活塞杆特殊导向结构，抗偏载能力强
- 后挡料采用数字式交流伺服电机驱动，精密滚珠丝杆传动，直线导轨导向
- CNC Pressbrake featuring an advanced design, with high speed, high accuracy and excellent rigidity
- Yawei machines are produced using high quality, world class steel plate and a large scale pentahedron machine center
- An Electro-hydraulic full loop servo system controlling the synchronization of the ram
- Dual aibbed ram structure with a self-lubrication system guarantees precise operation
- Mechanical bed crowning with C-frame deformation compensation system ensures precise bends
- Cylinders are attached to the ram spherical floating support and the piston rod is equipped with a unique guiding system to assist during unbalanced loading
- Backgauge components include: digital AC servo motors with precision ball screws and linear guides



机械补偿剖视图
Sectional view of mechanical
crowning compensation

机械挠度补偿工作台，可以在工作台全长上获得精确的挠度补偿。加凸工作台由一组带斜面的加凸楔块组成，每个加凸楔块是根据滑块、工作台立板有限元分析的挠度曲线设计而成。数控系统根据工件折弯是负载力的大小（该力将导致滑块和工作台立板产生挠度变形），计算所需的补偿量，自动控制加凸楔块的相对移动量，从而有效地补偿了滑块和工作台立板产生地挠度变形，能得到理想的折弯工件。

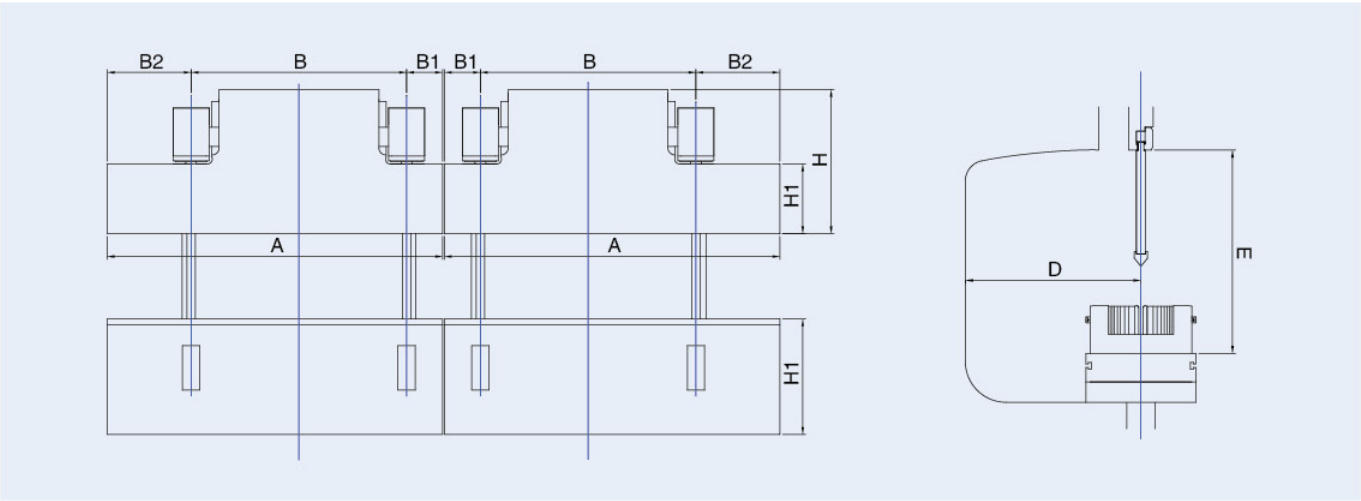
The CNC Mechanical bed crowning system utilizes a beveled wedge style for compensation. The CNC system calculates the needed crowning based on the force during the bending process(to compensate for deflection during the bending process)and adjust the wedges accordingly. This effectively compensates for the defection cased during the bending process ensure a quality part for the full length of the bend.

PBA钢管杆双机系列折弯机

PBA Series Tandem CNC Pressbrake for Steel Pipe Pole

标准配置 Standard Configuration

- 非对称结构设计，适合钢杆塔“厚板不长，长板不厚”的特点
- 可调式下模，V型槽开口步距调节，可适应不同板厚、折弯圆弧的需求
- 可换式上模头，有棱形和圆弧形选择，满足各种钢杆的加工需求
- 前后送料装置，变频电机控制，手动控制，位置数显，减轻人工强度，提高送料效率
- 侧出料装置，模具区域嵌入式滚轮设计，出料更轻松，出料架对称式滚轮设计，手轮调节距离，操作更方便
- Asymmetrical structure design,suitable for the feature of steel pole “the thick plate is not long,the long plate is not thick”
- Bottom die has V shaped groove opening and is step adjustable to meet requirements of different thickness and bending angles
- Changable upper tool to primatic or circular shapes to meet many different requirements of different steel poles
- Front and Back feeding devices,controlled by variable frequency motors with manual controls and digital displays for position.This reduces labor and increases efficiency
- Side discharge device with rollers inlayed in the tool area to make the removal of the part easier and symmetrical rollers designed in the discharge frame.The distance is controlled by hand wheels and is very user friendly



技术参数 Technical Specifications

型号 Model	油缸中心距 Center distance of oil cylinder	喉口深度 Throat depth	滑块行程 Ram stroke	最大开启 高度 Max. day light	下模最大开口 Max. die opening	工作台宽度 Worktable width	滑块速度 Ram speed			电机功率 Motor power	不掉头折弯单缝管对边距 Across flat of bending single slit tube without turning around Octagon		不掉头折弯双缝管对边距 Across flat of bending double slit tube without turning around Octagon		调头折弯双缝管对边距 Across flat of bending double slit tube with turn- ing around Octagon		折弯最大板厚×板宽 Max. bending thickness × width		机器总重 Weight
											8边形 8 Dodeca- gon	12边形 12 Do- decagon	8边形 8 Dodeca- gon	12边形 12 Do- decagon	8边形 8 Dodeca- gon	12边形 12 Dodeca- gon			
2-PBA- × / ×	mm	mm	mm	mm	mm	mm	mm/s			kw	mm	mm	mm	mm	mm	mm	mm × dm	mm × dm	kg
500/6000	4500	1000	315	1100	280	500	100	9	90	2×37	500	480	900	850	1380	1540	19×100	17×120	135000
500/7000	5200																17×120	16×140	150000
630/6000	4500	1100	315	1200	280	500	100	9	90	2×45	560	550	1030	950	1550	1720	23×100	21×120	150000
630/7000	5200																21×120	19×140	162000
800/6000	4500	1100	410	1200	280	500	100	9	90	2×75	560	550	1030	950	1550	1720	26×100	24×120	184000
800/7000	5200																24×120	22×140	202000
800/8000	6000																22×140	20×160	223000
1000/7000	5200	1600	410	1250	320	600	100	9	90	2×90	815	805	1500	1380	2260	2240	28×120	26×140	253000
1000/8000	6000																26×140	24×160	279000
1200/7000	5200	1600	410	1250	320	600	90	8	80	2×90	815	805	1500	1380	2260	2240	30×120	28×140	288000
1200/8000	6000																28×140	26×160	317000
1600/7000	4500	1600	410	1600	320	600	70	7	70	4×55	815	805	1500	1380	2260	2510	38×120	35×140	347000
1600/8000	5200																35×140	32×160	372000
2000/8000	5200	1600	410	1600	320	600	70	6	70	4×55	815	805	1500	1380	2260	2510	38×140	36×160	465000

大型折弯机 通用部件

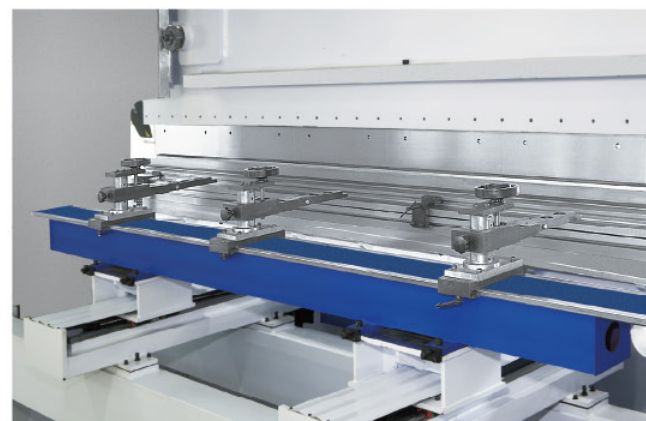
Options for Heavy Duty Pressbrake

可供选择的后挡料部件 Backgauge Options



H型后挡料3C H-type Backgauge 3C

- 箱式挡料梁结构，刚性高，稳定性高
- 二级挡指结构，扩大档料范围
- 配置X轴，伺服驱动，数控系统自动控制，定位精度高
- 挡指沿导轨左右移动
- Box tube beam construction for extreme rigidity and stability
- Two step finger design to increase bending flange length
- X axis controlled by an AC servo motor and programmed through the CNC for excellent positioning accuracy
- Fingers move left and right along the swallowtail guide



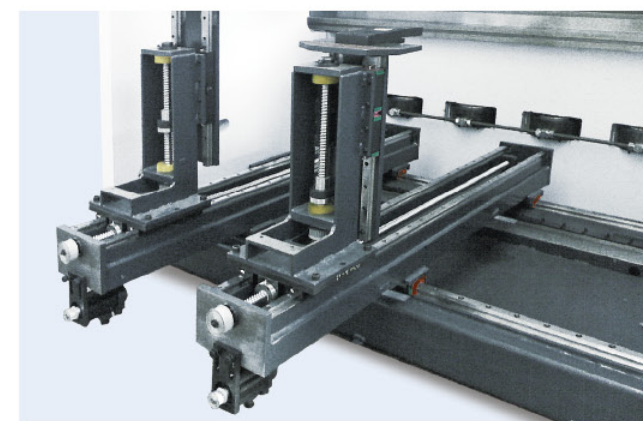
重型后挡料3C Heavy Duty Backgauge 3C

- 壳体卧式安装结构，稳定性高
- 单壳体双导轨导向，精度高
- 配置X轴，伺服驱动，控制系统自动控制
- 挡指沿导轨左右移动，抗冲击能力强
- Solid horizontal beam construction for exceptional stability
- Single rail construction with dual guided linear ways for high precision
- X axis controlled by an AC servo motor and programmed through the CNC for excellent positioning accuracy
- Finger move left and right along linear ways



重型后挡料4C Heavy Duty Backgauge 4C

- 壳体卧式安装结构，稳定性高
- 单壳体双导轨导向，精度高
- 配置X轴和R轴，伺服驱动，控制系统自动控制
- 挡指沿导轨左右移动，抗冲击能力强
- Solid horizontal beam construction for exceptional stability
- Single rail construction with dual guided linear ways for high precision Z axis movement
- X and R axis controlled by an AC servo motors and programmed through the CNC for excellent positioning accuracy
- Finger move left and right along linear ways



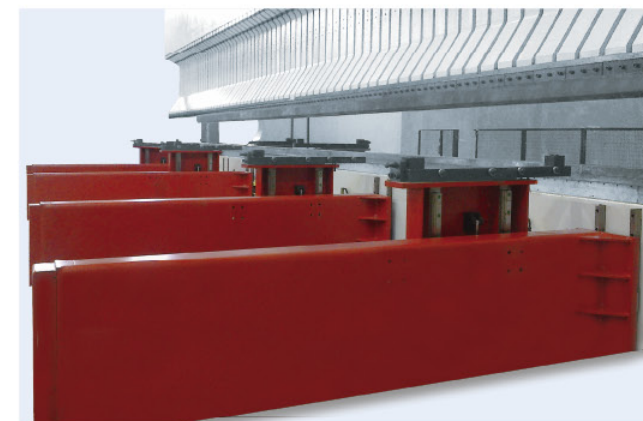
6轴后挡料 6-axis Backgauge

- 重载框架结构，刚性高，抗冲击能力强
- 配置X1、X2、R1、R2、Z1、Z2轴，伺服驱动，数控系统自动控制
- 适合不规则工件折弯挡料
- Heavy duty frame structure for excellent rigidity and high impact
- Axis include X1, X2, R1, R2, Z1 and Z2 all driven by servo motors and programmed through the CNC for excellent positioning accuracy
- Independent axis control allows you to bend irregular shaped or tapered parts easily



独立数控挡料 Independent CNC Gauge

- 前后挡料独立式结构
- 双直线导轨导向，精度高、稳定性高
- 配置X轴，大功率伺服驱动，数控系统自动控制
- 整个挡料沿直线导轨左右移动
- Independent front or rear gauge system
- Guided Dual-rail system for high precision and stability
- X axis is driven by high powered servo motor and programmed through the CNC for excellent positioning accuracy
- The gauge system moves left and right along linear guide



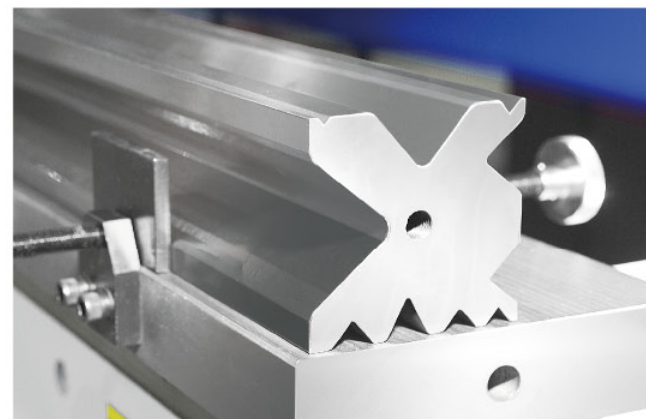
多功能数控挡料 Multi-functional CNC Gauge

- X轴：控制送料挡指前后移动
- R轴：控制送料挡指上下移动
- S轴：控制送料整体上下升降
- 挡料整体可降至地面以下，保证大工件折弯不干涉
- X axis: controls finger movement forward and backward
- R axis: controls finger movement up and down
- S axis: controls complete system up and down
- The complete gauge system can be lowered entirely below floor level eliminating interference during bending the process

大型折弯机 通用部件

Options for Heavy Duty Pressbrake

可供选择的下模结构 Optional Bottom Die Configurations



多V下模 Multi-V Bottom Die

- 标配多V下模，可选择不同开口和外形尺寸的设计，换模方便，可满足常规板材折弯加工，性价比较高
- Standard configuration is multi V bottom die, with multiple V openings and sizes to choose from easy change over via drilled and tapped holes in each end, is an economical way to meet all your bending needs



模口镶条式多V下模 Multi-V Bottom Die with Hardened Insert Bars

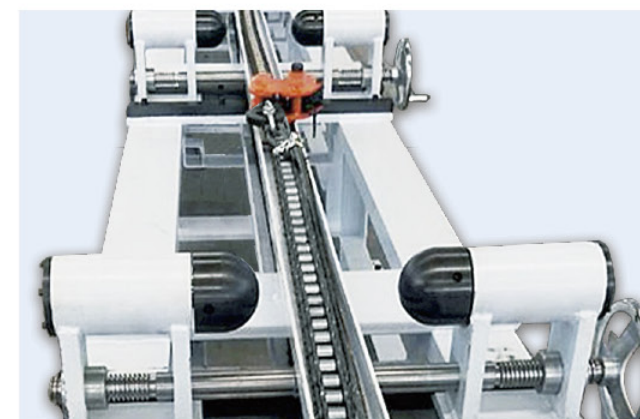
- 选配多V下模，可选择不同开口和外形尺寸的设计，模口镶高硬度条，耐磨性高，可满足高强度板材折弯加工，寿命长
- A Multi-V bottom die with hardened insert bars, with different V openings and sizes to choose from, The hardened inserts reduce wear increasing the life of your tools on high strength or abrasive steels



开口可调式下模 Bottom Die with Adjustable V

- 选配可调式下模，可选择不同开口尺寸的设计，模口采用高硬度材料设计，耐磨性高，可满足高强度板材折弯加工，寿命长
- An adjustable Bottom die is an option to accommodate a wide range of materials, This die is designed for use with high strength or abrasive steels to reduce wear and increase life of the die

其它辅机 Additional Options Material Handling



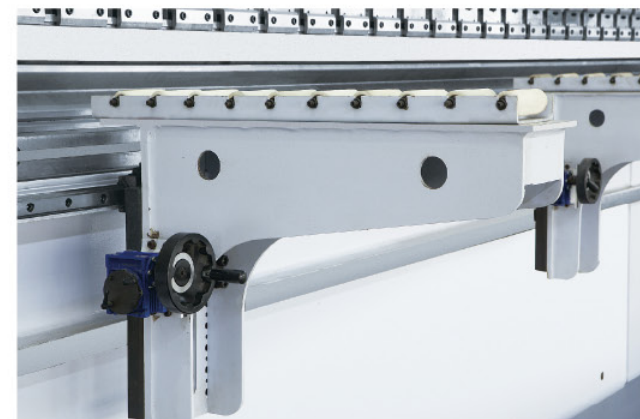
侧出料单元 Electric Drive Side Discharge

- 普通电机驱动、链条传动，安全系数大
- 对称式滚轮结构，手轮调节间距，以适应不同的管径
- 出料架长度可定制
- Motor and chain driven for easy material removal
- Symmetrical roller structure adjustable via hand wheels to accommodate a wide range of pipe diameters
- Customized lengths available



电动推料单元 Electric Drive Front Material Feed

- 普通电机驱动、链条传动，安全系数大
- 特殊的链条涨紧结构可以使传动精度更高
- 适用于制管行业
- Motor and chain driven for easy material handling
- High precision movement via a special chain tension structure
- Applicable for pipe bending



特殊前托架 Top Roller Front Sheet Supports

- 防划伤滚轮设计，保护板材
- 手轮升降，可沿直线导轨左右移动
- Roller design to prevent scratching or marking of plates
- Adjust height by hand wheel, moving left and right along linear guide