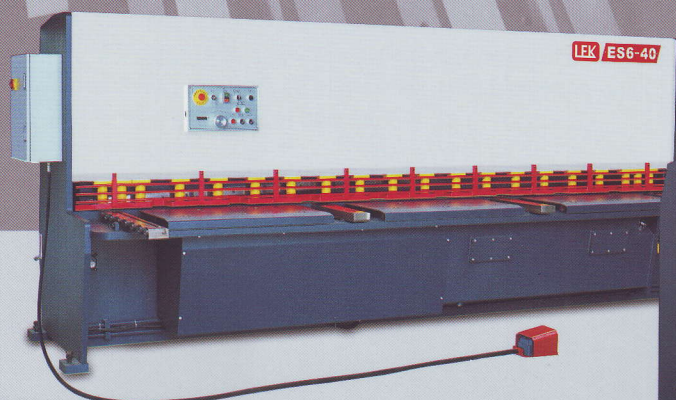




LEK MACHINERY COMPANY LIMITED

Professional design and manufacture of Turret Punch Press, Press Brake, Shear....

Hydraulic Press Brake & Guillotine Shear



ES Series Hydraulic Guillotine Shear



EP/CP Series Torsion Bar Hydraulic Press Brake



CQC ISO9001:2000
Cert.No:0105Q111587R1M/4400



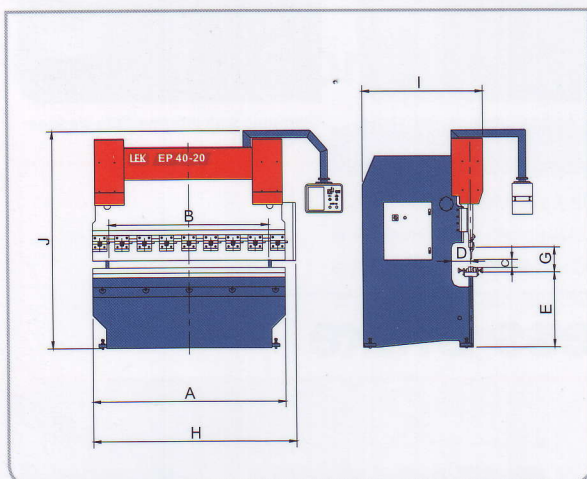
BS EN ISO9001:2000
Cert.No:FM71933

■ Xinyi Huahui CNC Machinery LTD. ■ Dongguan Huahui CNC Machinery LTD.

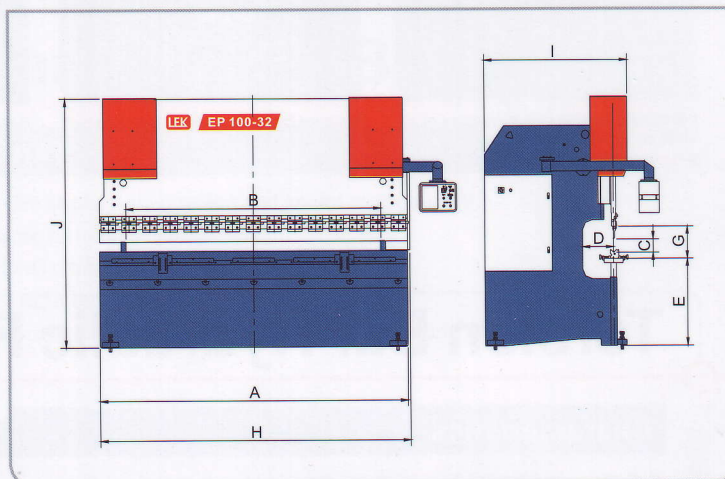
Hong Kong Dongguan Shanghai Beijing Thailand Singapore Malaysia Indonesia

Overall Dimension

EP/CP 40 Series



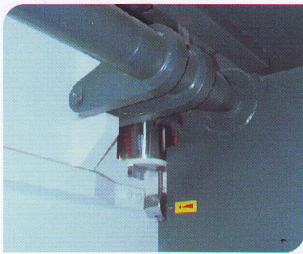
EP/CP 100/160 Series



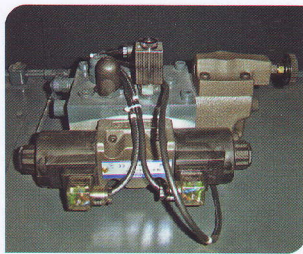
Machine Parameters of NC Torsion Bar Hydraulic Press Brake

Technical Specification		Unit	EP/CP 40-20	EP/CP 100-32	EP/CP 160-32	EP/CP 160-40
Max . Pressure		kN	400	1000	1600	1600
Table Length	(A)	mm	2000	3200	3200	4100
Distance Between Housings	(B)	mm	1660	2650	2640	3540
Ram Stroke	(C)	mm	100	150	200	200
Throat Depth	(D)	mm	200	320	320	320
Table Height	(E)	mm	775	900	900	900
Table Width	(F)	mm	130	200	200	200
Daylight Opening ⁽¹⁾	(G)	mm	260	330	380	380
Dimension (Width)	(H)	mm	2120	3230	3280	4100
Dimension (Depth)	(I)	mm	1230	1500	1600	1600
Dimension (Height)	(J)	mm	2250	2580	2730	2730
Ram Speed						
Approach Speed		mm/s	80	80	80	80
Work Speed		mm/s	15	10	8	8
Return Speed		mm/s	90	90	80	80
Main Motor		kW	4	5.5	7.5	7.5
Oil Tank Capacity		l	200	250	250	300
Machine Weight (Approx.)		kg	3100	7600	9300	11250

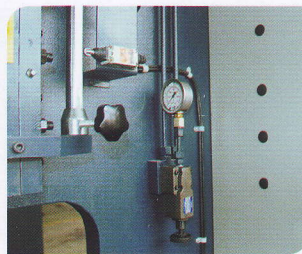
N.B. (1) Max. distance between ram and work table



Parallelism of the ram by means of a solid anti-torsion bar.



Imported hydraulic systems to ensure high reliability and safety.



Adjustable working pressure, ram stroke, ram opening and speed change-point.



Clamping with intermediate wedges (Standard)

Torsion Bar Hydraulic Press Brake

Characteristics

- Fully welded steel frame, stress relieved by vibration process.
- Imported hydraulic system to ensure high reliability and safety.
- Parallelism of the ram by means of a solid anti-torsion bar.
- Motorized mechanical depth stops incorporated in the cylinders.
- Adjustable working pressure, ram stroke, ram opening and speed change-point.
- Retaining the ram under pressure by means of timer switch.
- Pendant control panel with LED read-out of ram depth (except EP40).
- Motorized back gauge with fine adjustment by hand wheel.
- Back gauge with AC motor, lead screw and ground shaft.
- Back gauge travel: 500mm.



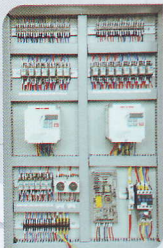
EP40-20
40Ton×2000mm



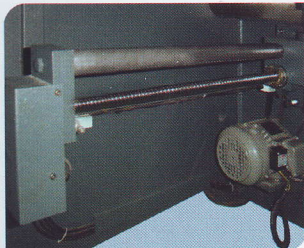
CNC Torsion Bar Hydraulic Press Brake

Characteristics w / DA41

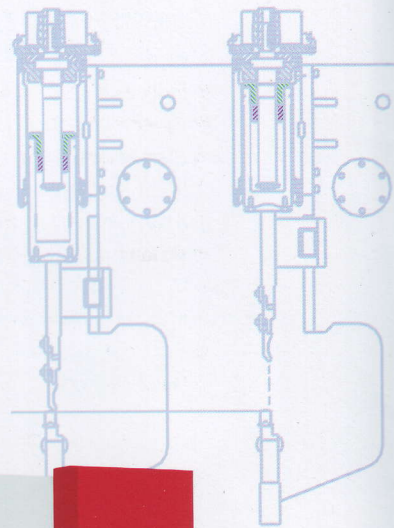
- Adjustable working pressure, ram stroke, ram opening and speed change-point.
- Retaining the ram under pressure by means of timer switch.
- Adopt Holland DELEM DA41 CNC control.
- Depth of the ram controlled by AC motor.
- Back gauge equipped with AC brake motor, high speed ball screw and ground shaft.



Import electrical components with inverters (Y & X axis)

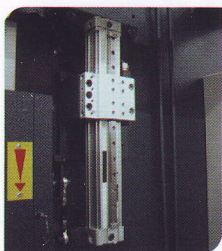


Back gauge equipped with AC brake motor, high speed ball screws and ground shaft.

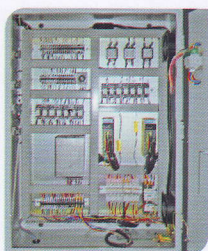


EP40-20
40Ton x 2000mm
DA41
2 axes (Y、X)

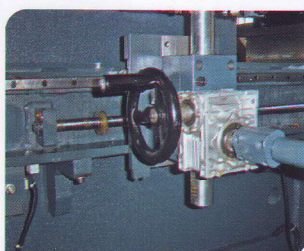
EP100-
100Ton x
DA41
2 axes



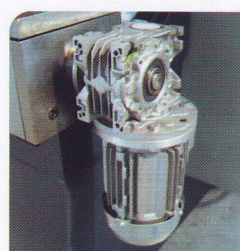
Adjustable ram stroke, ram opening and speed change-point by feed back of linear scale..



Import electrical components with AC servo drivers (Y & X axis)



Back gauge equipped with AC servo motor, high speed ball screw and linear guide way.



CNC Crowning Compensation (Optional)

CNC Torsion Bar Hydraulic Press Brake

Characteristics w / DA51

- Adjustable ram stroke, ram opening and speed change-point by feed back of linear scale.
- Retaining the ram under pressure by means of timer switch.
- Adopt Holland DELEM DA51 CNC control.
- Depth of the ram controlled by AC servo motor.
- Back gauge equipped with AC servo motor, high speed ball screw and linear guide way.



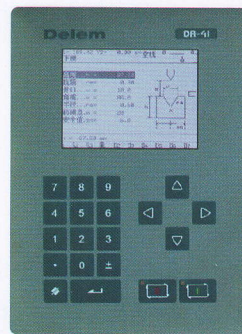
32
3200mm
(Y、X)

CP100-32
100Ton × 3200mm
DA51
2 axes (Y、X)

CNC system

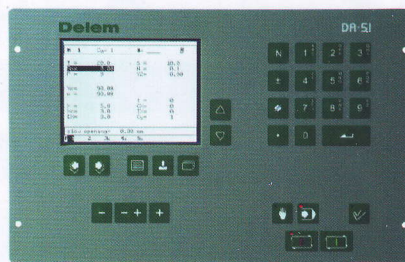
Holland DELEM DA41 CNC Control System

- Controlled axis: 2 axis (Y, X axis)
- 4.7" LCD display (240x320 pixels)
- Menu driven of fast key selection
- Direct angle programming data input
- Angle correction function *
- Manual bending sequence and positioning of all axes
- Data storage: 100 bending steps
- Each program can store 25 steps, each step repeat 99 times
- Tooling parameters (punch: N/A, die 7 kinds)
- Back gauge travel: 500mm
- Piece counter
- Safety zone set up for Y and X axis



Holland DELEM DA51 CNC Control System

- Controlled axis: 2 axis (Y, X axis)
- 7" LCD display (240x320 pixels)
- Menu driven of fast key selection
- Direct angle programming data input
- Angle correction function
- Manual bending sequence and positioning of all axes
- Manual blank length calculation (DIN6935)
- Data storage: 500 bending steps
- Each program can store 25 steps, each step repeat 99 times
- 10 kinds of tooling parameters (punch 3 kinds, die 7 kinds)
- Piece counter
- Safety zone set up for Y and X axis



Bending Chart

P=Capacity (Ton)

$$\nabla = \text{Tensile strength} = 42 \text{ kg/mm}^2$$

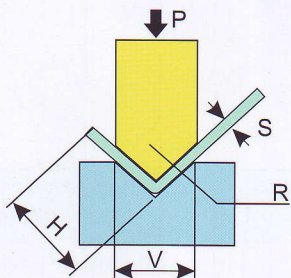
S=Sheet thickness (mm)

$L = \text{Sheet length} = 1000 \text{ (mm)}$

V=Die opening (mm)

R=Internal radius

H=Min.sheet bending length (mm)



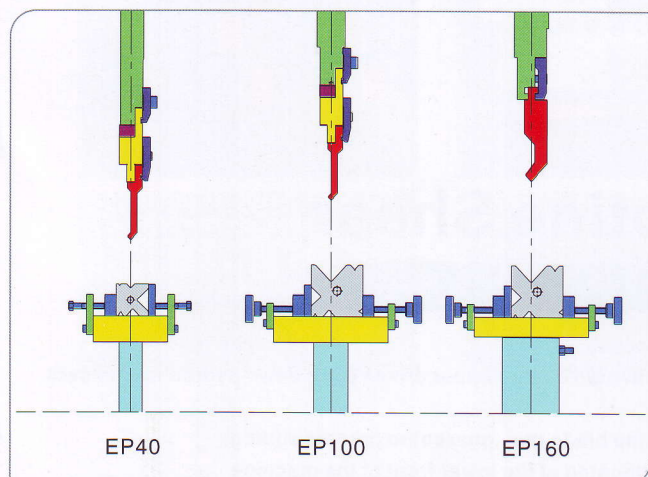
$$P = \frac{1,42 \times \nabla \times S^2 \times L}{1000 V} \text{ (Ton)}$$

BENDING CHART




[illegible]

Combination of Punch and Die

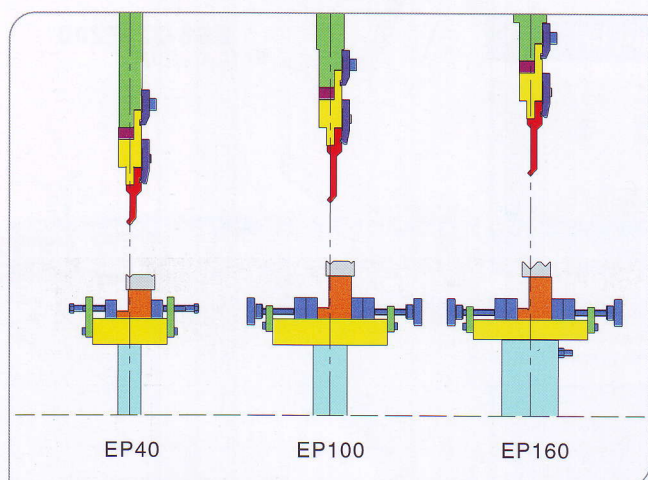
Standard Combination





Punch

	10.200/88°	10.202/88°	P110C/85°
			
EP40	○	●	—
EP100	—	●	○
EP160	—	○	●



Optional Combination









Multi-V Die

	MV0556	MV0690
		
EP40	●	—
EP100	—	●
EP160	—	●

L Die base (Optional)

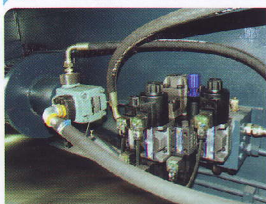
	40.07/50	40.07/75
		
EP40	○	—
EP100	—	○
EP160	—	○

2V Die (Optional)

121/88° V4,V7	123/88° V6,V10	124/88° V8,V12
		
125/88° V14,V18	126/88° V12,V20	127/88° V16,V25
		

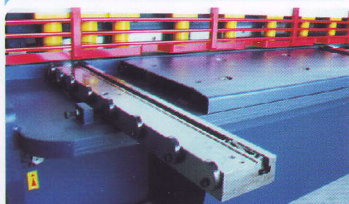
● Standard ○ Optional — N/A

Hydraulic system



The oil tank, the main motor and the hydraulic pump are located at the lower front of the machine

Front squaring arm with scale



Front squaring arm with ruler, T-slot and disappearing stop(1000mm)

NC Hydraulic Guillotine Shear

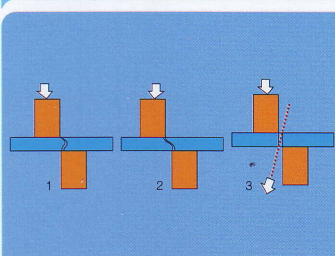
Characteristics

- Fully welded steel frame, stress relieved by vibration process
- The up and down movements of the cutting beam are activated by two upper driven push down hydraulic cylinders.
- Adopting quality whole piece 4 edges cutting blades
- Calibrate the thickness to change the cutting angle and the blade gap ,guarantee precise cutting
- The oil tank, the main motor and the hydraulic pump are located at the lower front of the machine

ES6-32-E200

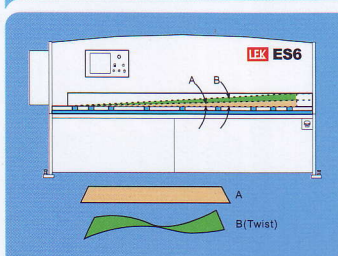


Blade gap



1. For small blade gap, the shearing section of the sheet will be damaged and incur excessive shearing force.
2. For large blade gap, the cut metal strip will be bent and stretched seriously with rough cutting edge and inaccuracy.
3. Normal blade gap.

Cutting angle



When cutting different thickness of metal sheet, it will achieve the ideal condition (A) with minimum twist of the metal strip by adjusting the cutting angle.

Control panel



Motorized back gauge

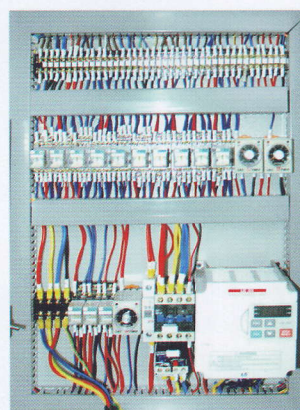
Mechanical read out of the back gauge with fine adjustment by hand wheel



NC back gauge

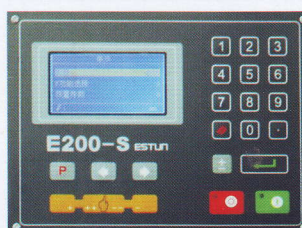
E200 NC back gauge driven by AC brake motor and ball screw and inverter with automatic retraction and high repeatability

Electrical cabinet



Import electrical components with inverter (X axis)

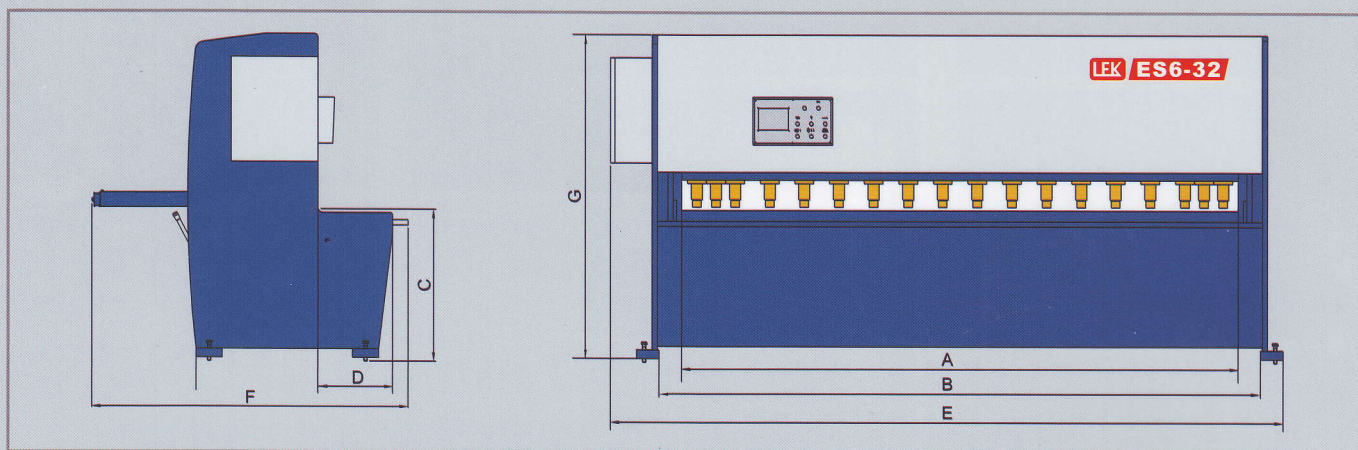
E200 NC system



E200 Single axis NC-control with flexible programming possibility. Modern compact user friendly NC-control with a clear LED display.

- Automatic mode: To run your program continuously.
- Semi-automatic mode: To run your program step by step.
- Manual mode: Manual movement of the axis.
- Memory: 100 program steps.
- Display: Segment character display.

Overall Dimension



Machine parameters of ES NC Hydraulic Guillotine Shear

Technical Specification	Unit	ES6-32	ES6-40	ES13-32
Cutting Capacity Range				
Mild Steel (45kg/mm ²)	mm	0.5-6	0.5-6	4-13
Stainless Steel (70kg/mm ²)	mm	0.5-4	0.5-4	2-8
Maximum Cutting Length (A)	mm	3200	4000	3200
Cutting Angle	degree	1°-3°	1°-3°	1°-3°
Strokes Per Minute	spm	22/min	22/min	6/min
Maximum Travel of Back Gauge	mm	800	800	800
Hold down Cylinders	pcs	18	20	18
Clearance Between Columns (B)	mm	3480	4360	3560
Height of Worktable (C)	mm	870	870	870
Width of Worktable (D)	mm	435	530	550
Overall Width (E)	mm	3870	4730	4010
Overall Depth (F)	mm	1820	1910	2010
Overall Height (G)	mm	1850	1950	1980
Oil Tank Capacity	Litre	200	200	500
Main Motor (380V/50Hz)	kW	7.5	7.5	18.5
Machine Weight (Approx.)	kg	5800	7000	11390

N.B. Voltage stabilizer and hydraulic oil to be bought by the users.

Standard equipment

Standard equipments	ES6-32/40	ES6-32/40-E200	ES13-32-E200
Control panel position	Left front of the machine, cutting from left to right		
Control system	Mechanical digital read out	Estun E200 NC system	
Back gauge driver	AC Motor	AC Servo Motor	
Back gauge transmitting parts	Lead Screw, ground shaft	Ball Screw, ground shaft	
Blade gap, cutting angle and stroke length adjustment	Manual adjustment		
4 edges upper & lower blades	One set		
Hydraulic hold downs	Independent with built-in spring		
Working table with ball transfers	●		
Front squaring arm with scale	One piece, 1000mm long		
Front support arms	●		
Cutting line illumination	●		
Foot pedal	●		
One set of tool box	●		
● Standard Equipment			

N.B. Subject to changes without prior notice.



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