

Although it has been thought to be impossible, you can now quickly machine a small bend - one and a half times as thick as the board - with a press brake.

When you want to machine other boards whose thickness are different, you can easily do it by inserting a shim that is as thick as the board you want to machine.

CHOMMAGEKUN L=835 S=415

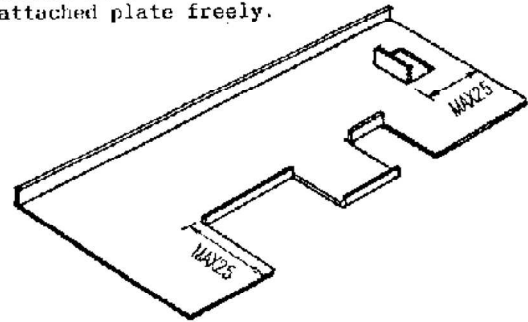
First, do clearance adjustments of upper and lower dies according to the thickness of the product you want to machine.

- a Loosen the bolts (1), and replace the shim (2) with a shim whose thickness is the same as the product you want to machine.
- b After that, press the lower die to the thrust pad of the upper die and fix it (3).
- c With this procedure, you can set the clearance of the upper and lower dies, therefore, you can bend your products.

The combination of dividing blades will enable you to make partial bendings of the dimensions you like. Attached blades

L 835	15	20	25	30	40	50	100	135	415	835
S 415	15	20	25	30	40	50	100	135	415	

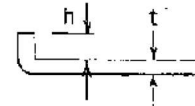
We have made T holes so that you can move blades of the lower die and the side attached plate freely.



The corner of the blades of the lower die is reversible, therefore, you can use both sides. The value of R of one side is small, and that of the other side is large to prevent abrasion.

$$0.2k \quad \text{MIN}$$

$$1.5R \quad h - 2 + t \times 1.$$

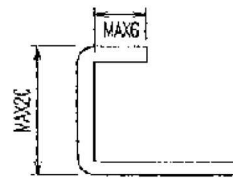


Required pressure

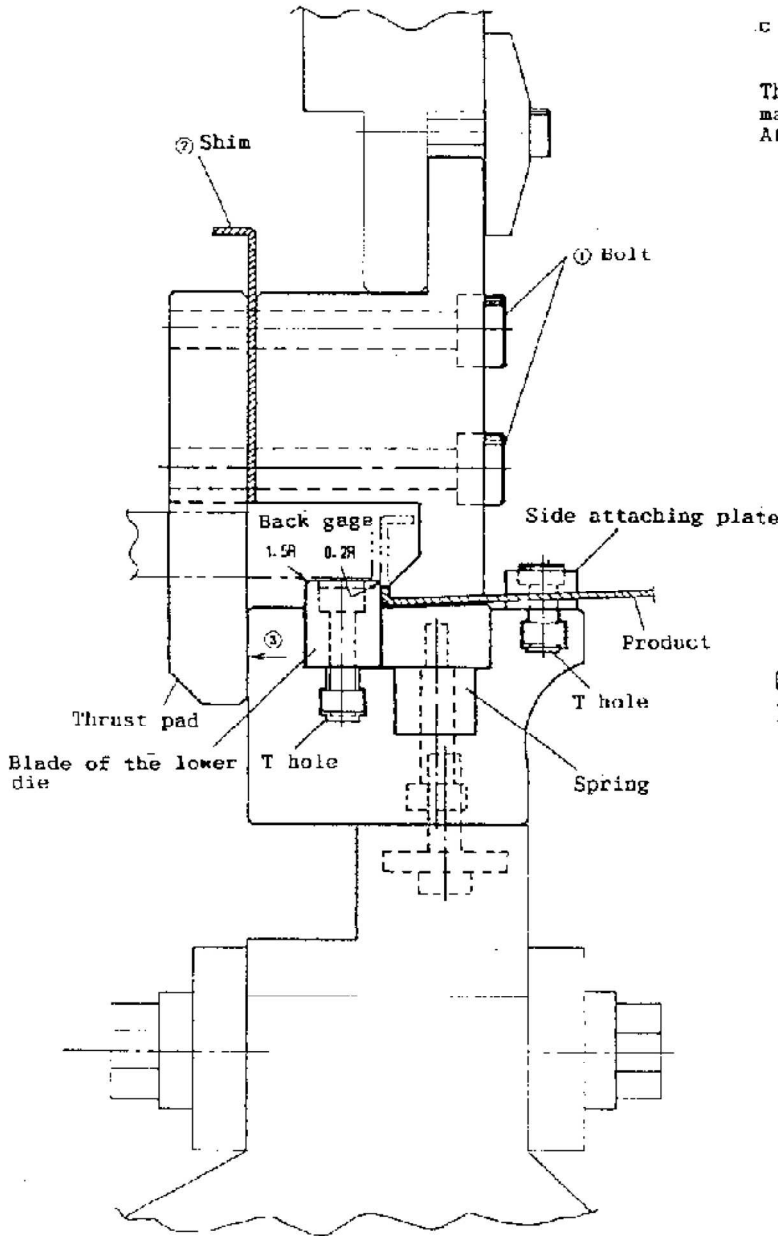
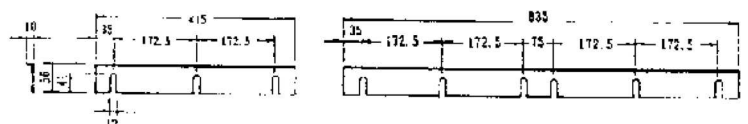
Thickness	Ton
0.6	10
0.8	12
1.0	15
1.2	19
1.6	25

SPC=1000mm
SUS=750mm

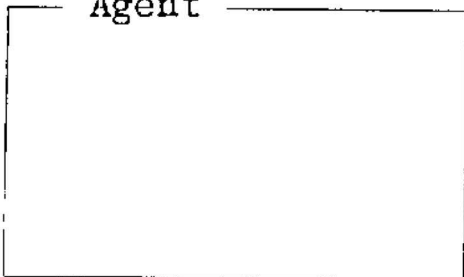
In addition to small bendings, you can make the bending shown below.



The dimensions of shim (2)



Agent



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dies for stage pressure machines,
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