

BB

adira

METAL FORMING SOLUTIONS



PRESS BRAKES **BB**

TECHNICAL DATA SHEETS

Press Brakes

BB

Equipped with a Hexa-C frame, which ensures precision in guiding the movable ram, this fully electric machine, powered by the Bluedrive system, is capable of faster bending and, at the same time, allows energy savings thanks to its economical operation.



Supplied with all optional extras and accessories, this machine is the way forward for your bending solutions!

Available in two standard models ranging from 35 to 50 tonnes and 1.5 to 2 metres.



Main Features

- No need for stoppages when changing the bending speed, thereby considerably reducing cycle time
- High acceleration and deceleration ramps
- Off-centre bending, enabling load distribution
- Pre-loaded guidance system to maintain off-centre bending
- Bluedrive: Fast, Precise, Simple and Clean heavy-duty servomotors
- Heavy duty Servomotors

Benefits

- Incredible precision in stopping the movable ram +/- 0.002 mm;
- Hexa-C frame: high precision in off-centre bending, maintaining the advantages of the C frame;
- No torsion is transmitted from the frame to the part in multi-station bending;
- Energy consumption ratio in the region of 40-60% when compared to hydraulic press brakes;
- Low mechanical complexity, simplifying maintenance tasks.

High-performance spindle with high load capacity – 25,000 hours of useful life (maximum load, 50% work cycle).

Automatic lubrication, equipped with an automatic electrical lubrication unit.

SIMPLE AND SUSTAINABLE TECHNOLOGY

Bluedrive: Fast, Accurate, Simple and Clean
Low mechanical complexity



TECHNICAL DATA SHEETS

BB		BB 3515	BB 5020
Bending strength	kN	350	500
Max. bending length	mm	1500	2000
Distance between side frames	mm	1250	1550
Maximum stroke	mm	250	250
Max. opening without punch holders	mm	480	480
Throat Depth	mm	400	400
Power	kW	2x5.5	2x7.5
Approach Speed	mm/s	140	130
Working speed	mm/s	10	10
Return speed	mm/s	140	130
X-axis stroke	mm	500*	625**
X-axis speed	mm/s	400*	400**
R-axis stroke	mm	150	180
R-axis speed	mm/s	50	50
Z - Z1/Z2-axis stroke	mm	1000	1250
Z - Z1/Z2-axis speed	mm/s	800	800
X1-axis stroke	mm	NA	±100
X1 speed	mm/s	NA	100
Length	mm	2250	3050
Width	mm	1900	1900
Height	mm	2910	2910
Approx. mass	Kg	4400	5900



* Specifications for the series BG (back-gauge) 1.1 (standard)

** Specifications for the BG (back-gauge)3 series

Equipment	BB	
Punch Tightening	"ADIRA/USA" Punch Holders	■
	ADIRA Punch holders with fast clamping without reversibility	standard
	ADIRA Punch holders with fast clamping and reversibility	■
	Pneumatic Punch Clamping Teda with Frontal Insertion	■
Tables	Standard 60 Base Table Kit	standard
	Kit table III (13 mm)	■
	Hydraulic Clamping Wila Pro	■
	Pneumatic clamping for 60 mm base dies	■
Sheet metal support	2 support arms on rail (without height adjustment, without brushes, L = 500 mm)	standard
	1 additional support arm on rail (without height adjustment, without brushes, L = 500 mm)	■
	2 support arms on rail (with height adjustment, with brushes, L = 800 mm)	■
	1 additional support arm on rail (with height adjustment, with brushes, L = 800 mm)	■
	Bending Follower(AQ1)	on request
Back gauges	X, R back gauge for AD20	standard
	X, R back gauge for AD58	■
	X/R/Z1/Z2 back gauge for AD60	■
	X/R/Z1/Z2 back gauge for Delem 6X	■
	X/X1/R/Z1/Z2 back gauge for AD60 (available only for BB5020)	■
	X/X1/R/Z1/Z2 back gauge for Delem 6X (available only for BB5020)	■
	X1/X2 - R1/R2 - Z1/Z2 tower back gauge (AD61 or Delem 6X)	■
	2 extra back gauge stops	■
Angle Measurement Safety	IRIS Laser Safety	standard
	IRIS PLUS Laser Safety (Angle Measurement) (only with AD60)	■
Controls	ESA AD20 (4 axes)	standard
	DELEM DA 58 (up to 4 axes)	■
	ESA AD40	■
	ESA AD75	■
	DELEM DA 69_3D (up to 16 axes)	■
	VISIPAC	■
Leds	Leds (Smart Placing) Esa (only with AD6X)	on request
	Leds (Smart Placing) Esa (only with Wila and AD6X)	on request
	Leds (Smart Placing) Esa (only with Wila and Delem6X)	on request
Other	Air Conditioning on the Electrical Cabinet	■
	Standard tool kit - @ 85° Punch: 3 or 4 x701603305 + 1x701602302 / 4-vee die 3 or 4 x721103300 +1x721104300	■
	Special Tools	on request
	Digital Goniometer	■
	Ergonomic kit	■
	2 Machines in tandem	on request



Rua das Lages 67 . 4410-272 Vila Nova de Gaia

T.: +351 226 192 700 . adira@adira.pt