



PROFI BEND 28 NC
PROFI BEND 28 CNC
PROFI BEND 56 CNC
QUICK BEND CNC



Profi Bend 28 NC / CNC



Profi Bend 28/1000 NC



Profi Bend 28/1000 CNC

The **BOSCHERT** Profi Bend 28 NC and Profi Bend 28 CNC are precision hydraulic press brakes. The extremely compact and robust structure of these machines and the twin guides guarantee ram repeatability of 0.02mm.

The Profi are designed to manufacture small parts and perfectly compliment your existing larger machines.

By forming small parts on the Profi and larger parts your existing machines, plant productivity is greatly

Standard tooling is Amada style, with other systems available on request. Material stops are adjustable vertically and horizontally and have stop fingers with two faces each.

With a maximum bending force of 28 tons, typical work could include parts up to 300mm long and 10mm thick.



3 Position back gauge



R-axis option

The Profi Bend 28 NC is simple to operate. The ram can be adjusted under pressure by using the handwheel. The powered back gauge is programmable with up to 99 programs of 30 lines each.



Control with up to 99 programmable programmes



2 or optional 4 side adjustable back gauges
Optional 2 adjustable front supports



Profi Bend 56 CNC



Profi Bend 56/1400 CNC

The Profi Bend 56 CNC models are available in 1400 and 2200mm bending lengths. The pressure of 56 tons takes place with 2 x 28 ton force cylinders. All CNC Profi 28/56 Press Brakes machines are equipped with the CybTouch 15 as the standard control.

Control CybTouch 15



- Large touchscreen
- Hand drawing TouchProfile function
- USB port for memory sticks
- 4 axes control (Y1-Y2-X-R)
- TouchProfile 2D graphic part



Quick Bend 28 CNC



Quick Bend 28 CNC
Hybrid Technologie

Productivity and ergonomics are combined in perfect harmony.

The nearly silent press brake Quick Bend, with up to 250mm/s approach speed and 200mm/s return speed is setting new standards in production.

Thanks to the hybrid technology, up to 80% energy savings compared with conventional hydraulic systems can be achieved.

The Quick Bend corresponds to all CE - Safety requirements with the CYBELEC VisiPac 19 graphic controller, Rexroth hydraulics and the Fissler AKAS V.

Other standard equipment includes the R-axis, linear guide for the X axis and the quick-change tool system ROL 200.



Capacities	Profi Bend 28/1000 NC / CNC	Profi Bend 56/1400 CNC	Profi Bend 56/2200 CNC
Bending force	280	560	560
Bending length mm	1000	1400	2200
Dimensions			
Weight kg	3500	4800	6030
Width mm	1531	1950	2741
Depth mm	1530	1750	1750
Height from floor mm	2360	2360	2360
Distance between the frames mm	890	1260	2100
Throat depth mm	200	200	200
Width of worktable mm	2 x 270	2 x 270	2 x 270
Operating height mm without die	915	915	915
Daylight	305 (405*)	305 (405*)	305 (405*)
Y-Travel mm	200	200	200
Max. stop range in X mm	600	600	800
Downspeed mm/s	10	10	10
Working speed mm/s	8-10	8-10	8-10
Upstroke speed mm/s	30	30	30
Repeatability mm	+/-0,02	+/-0,02	+/-0,02
Power supply kVA	5,5	5,5	10
Control	Hejm / CybTouch15	CybTouch15	CybTouch15
*Option ()			
Capacities			
Bending force	2800	560	560
Bending length mm	1000	1400	2200
Dimensions			
Weight kg	3500	4800	6030
Width mm	1780	2180	2976
Depth mm	1980	1980	1980
Height from floor mm	2380	2380	2380
Distance between the frames mm	890	1260	2100
Throat depth mm	200	200	200
Width of worktable mm	1x 800x450	1 x 800x450	1 x 800x450
Operating height mm without die	985	985	985
Daylight	405	405	405
Y-Travel mm	200	200	200
Max. stop range in X mm	600	600	800
Downspeed mm/s	250	250	250
Working speed mm/s	8-10	8-10	8-10
Upstroke speed mm/s	200	200	200
Repeatability mm	+/-0,02	+/-0,02	+/-0,02
Power supply kVA	25	25	25
Control	VisiPac 19	VisiPac 19	VisiPac 19

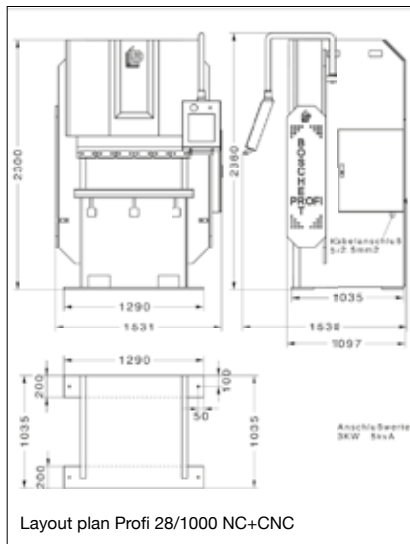
S mm.	0,6		0,8		1,0		
V mm.	6	8	6	8	6	8	
F kN/mt	R.200N/mm ²	20	10	30	20	60	40
	R.450N/mm ²	40	30	70	50	130	80
	R.700N/mm ²	60	40	110	80	190	130
Ri mm.	1,0	1,3	1,0	1,3	1,0	1,3	
90°=B mm.	4,5	6,0	4,6	6,1	4,7	6,2	
60°=B mm.	6,3	8,3	6,4	8,4	6,5	8,5	
35°=B mm.	10,3	13,6	10,4	13,7	10,5	13,8	

S mm.	1,2		1,5		2,0		
V mm.	8	10	10	12	12	16	
F kN/mt	R.200N/mm ²	60	40	70	60	110	80
	R.450N/mm ²	130	100	160	130	250	170
	R.700N/mm ²	200	150	250	200	390	260
Ri mm.	1,3	1,7	1,7	2,0	2,0	2,7	
90°=B mm.	6,3	7,7	7,8	9,2	9,5	12,3	
60°=B mm.	8,6	10,6	10,8	12,8	13,0	17,0	
35°=B mm.	13,9	17,2	17,4	20,7	21,0	27,6	

S mm.	2,5		3		4		
V mm.	16	20	20	25	32	40	
F kN/mt	R.200N/mm ²	130	90	140	110	150	110
	R.450N/mm ²	290	210	320	240	340	250
	R.700N/mm ²	440	330	500	370	530	390
Ri mm.	2,7	3,3	3,3	4,2	5,3	6,7	
90°=B mm.	12,6	15,4	15,6	19,2	24,6	30,3	
60°=B mm.	17,3	21,3	21,5	26,5	34,0	42,0	
35°=B mm.	27,9	34,5	34,8	43,1	55,2	68,5	

S mm.	5		6		8		
V mm.	40	50	50	63	63	80	
F kN/mt	R.200N/mm ²	190	140	210	160	310	220
	R.450N/mm ²	420	320	480	360	690	500
	R.700N/mm ²	660	490	750	550	1070	780
Ri mm.	6,7	8,3	8,3	10,5	10,5	13,3	
90°=B mm.	30,8	37,9	38,4	47,5	48,5	60,6	
60°=B mm.	42,5	52,5	53	66,0	67,0	84,0	
35°=B mm.	69,0	85,6	86,1	107,8	108,8	137,0	

S mm.	10		12		
V mm.	80	100	100	125	
F kN/mt	R.200N/mm ²	380	280	430	320
	R.450N/mm ²	840	630	960	720
	R.700N/mm ²	1310	980	1490	1120
Ri mm.	13,3	16,7	16,7	20,8	
90°=B mm.	61,6	75,7	76,7	94,4	
60°=B mm.	85,0	105,0	106,0	131,0	
35°=B mm.	138,0	171,3	172,3	213,8	



F = KN for meter
S = Sheet thickness
R = Sheet resistance - Material Hardness



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