



# **HDE**

## **HYDRAULIC PRESSBRAKES**



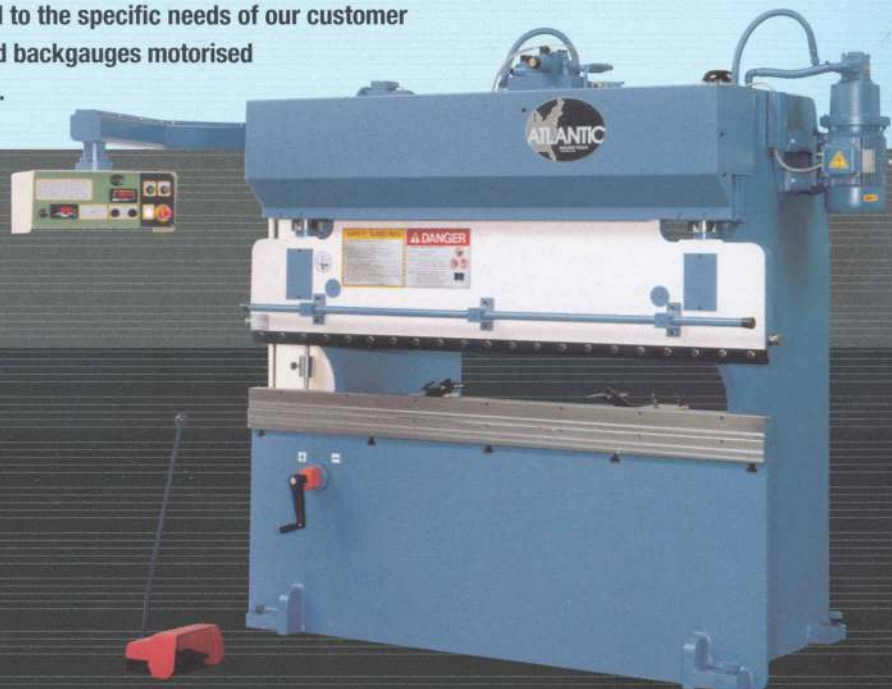
**your partner in quality and accurate bending**



# HDE

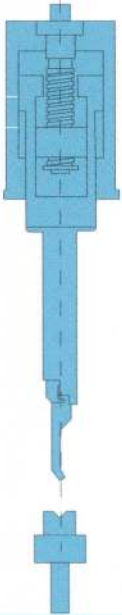
## HYDRAULIC PRESSBRAKES

We have been producing brakes and shears for over 35 years. With this long experience, thousands of brakes in operation all over the world and USA combined with our state of the art assembly lines we are able to bring to our customers a solid engineered, high quality and most of all an economical affordable pressbrake. Our HDE pressbrakes can be easily adapted to the specific needs of our customer offering a wide range of tooling and backgauges motorised or low cost CNC controlled as well.



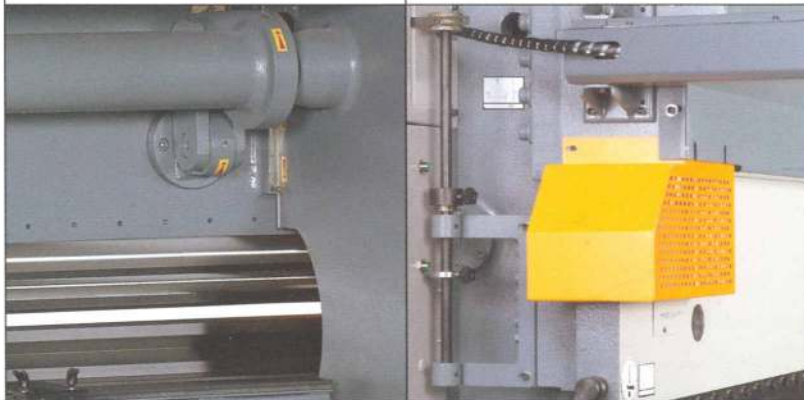
### positive depth setting

The HDE Machine has a unique design with mechanical depth stops incorporated in the hydraulic cylinders for very accurate depth stroke adjustment (0.0004"). Motorised adjustment is controlled with 2 push buttons and electronic read-out, conveniently located at the pendant control panel.



### ram parallelism

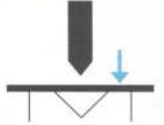
Parallelism of the upper beam is maintained through an Anti Torsion Bar System. This solid torsion bar links both ends of the ram and maintains parallelism throughout the entire stroke even if off-centre loadings occur.



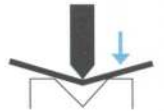
### stroke adjustment

Adjustable mechanical cams at the operators side of the brake to set the upper position, work speed change point.

fast approach



working speed



fast Return



### Standard features of HDE

- Mechanical equilibration by means of a heavy-duty solid anti-torsion bar.
- Mechanical depth stops submerged in the cylinders for long life operation.
- Pendant control panel.
- Infinitely motorised depth adjustment by 2 pushbuttons from the control panel with electronic read-out.
- Easy infinitely adjustable ram stroke.
- Adjustable open height.
- Adjustable speed change-over point.
- Tonnage control with electronic infinitely adjustment and read-out.
- Manual (Jog mode) and automatic cycle selector switch.
- Movable footpedal control.
- Short sectional tool holders to secure tool clamping.
- Filled oiltank.
- Instruction and maintenance manuals.
- Service tools.

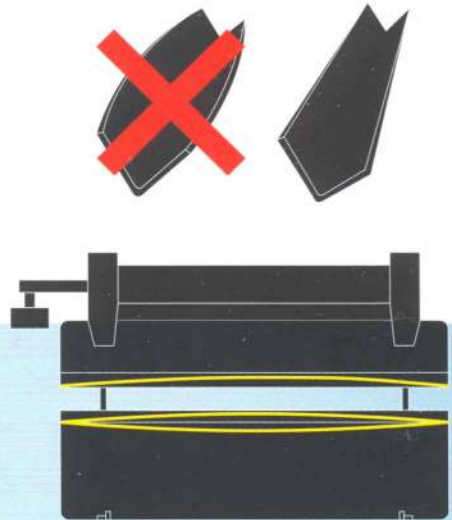
## available accessories and options

- Motorised backgauge stroke:			- Central manual adjustable Anti Deflection Tables.
machine		backgauge travel	
5' - 6' - 8'	45 tons	26"	
6' - 10'	75 tons	26"	
6' - 14'	120 - 330 tons	31"	- Different tooling.
- Backgauge stroke up to 39".			- Hydraulic Top tool clamping.
- CNC Controls ATL 550			- Fillerblock or 4-way die holder.
- Frontstops.			- Hour meter.
			- Stroke counter.
			- Additional safety fences and light curtains.
			- Two hand control



## crowning tables (optional)

Angular variations caused by ram and machine deformation can be compensated by a CROWNING TABLE fitted directly on the lower beam. It uses a system of wedges moving progressively on top of each other, giving the table the desired form in order to compensate for beam and bed deflection. This results in a constant angular profile of the workpiece over the full working length of the machine. The crowning table can be set independantly from machine type or execution and is available for standard American style tooling, European style tooling and Single V-dies. The crowning table up to 14' 350t is manually controlled by handcrank.



## ATL 550

Easy to program basic control for conventional pressbrakes. Electronic digital readout of depth stop position and pressure. Pre-selection mode: automatic positioning of backgauge and depth stop to the preselected position.

- Backgauge positioning (X - 0.004")
- Depth stop positioning (Y - 0,0004")

Programming mode: possibility to make several programs in which the backgauge and depthstop are positioned automatically after each step (bend).

- Programming X and Y (in depth only)
- Memory capacity: max. 400 steps, max. 200 programs

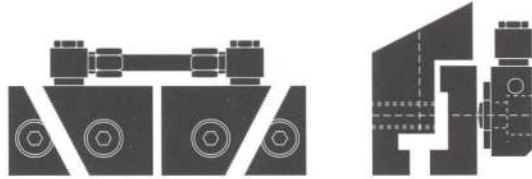


## pressbrake tooling

### American style tooling

A budget-friendly tool system specially designed for all machine capacities. The top tool is available in different shapes: flexible gooseneck tool 86°, straight tools of 86, 30, 60 or 180°, in full length or sectionalized.

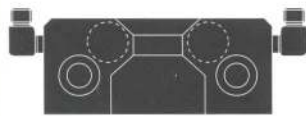
### Hydraulic clamping for American style upper tooling



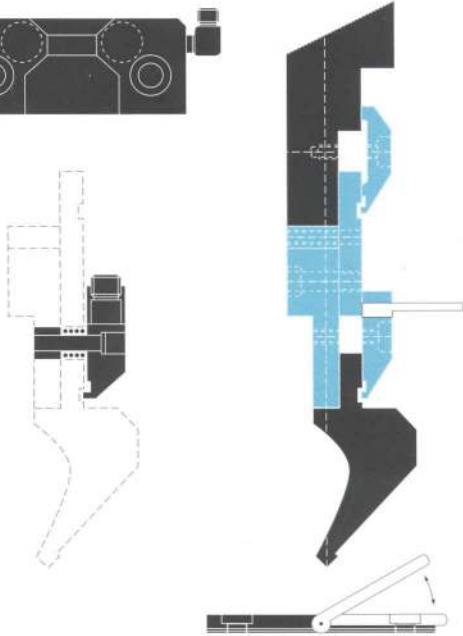
### European style tooling

European style tooling is available in a wide range of different bottom and top tools, to adapt the machine to almost any specific job. European style tooling is manufactured within the smallest tolerances in standard lengths so they can be fit together to achieve larger lengths. European style bottom tooling in combination with a crowning table results in a machine with the highest degree of accuracy.

### Hydraulic clamping for European style upper tooling

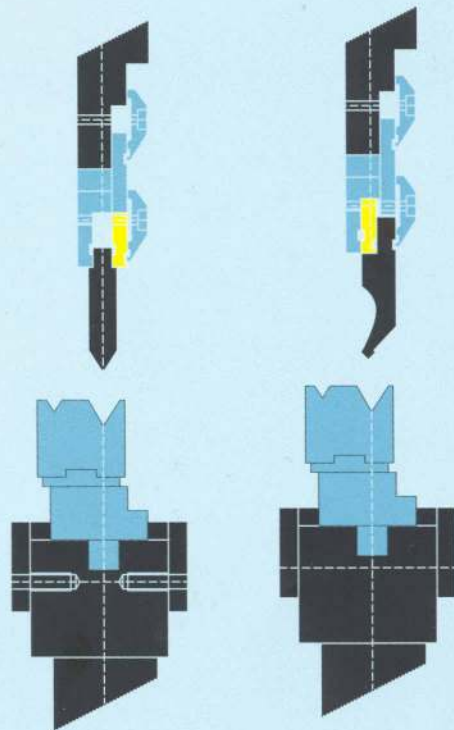


### Quick manual clamping



### Universal tool holders

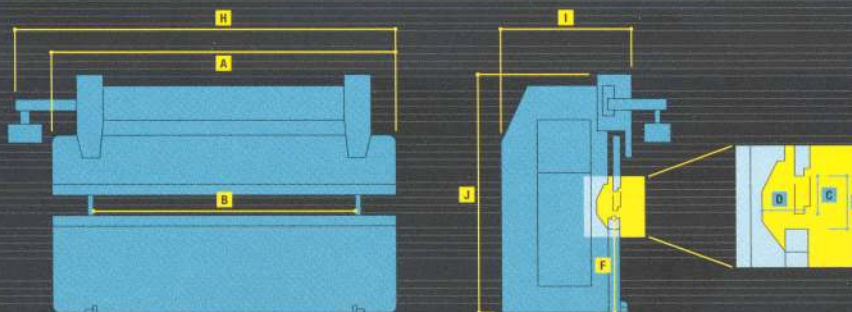
Both can be combined as 'universal tool holders', offering a choice between the use of American or European style tooling with one tool holder.



# technical specifications (\*)

Type	Max. capacity	A	B	C	D	E	F
		Bending length	Distance between housings	Ram stroke	Gap	Daylight opening	Table height
	Tons	inch	inch	inch	inch	inch	inch
45-5-3.5	45	63	43	3.9	7.6	11.6	33
45-6-5	45	192	63	3.9	7.6	11.6	33
45-8-6	45	102	82	3.9	7.6	11.6	33
75-6-5	75	82	63	3.9	7.8	11	33
75-8-6	75	102	82	3.9	7.8	11	33
75-10-8	75	122	102	3.9	7.8	11	33
120-8-6	120	102	82	4.7	9.8	12.8	34.4
120-10-8	120	122	102	4.7	9.8	12.8	34.4
120-12-10	120	144	124	4.7	9.8	12.8	34.4
120-13-10	120	161	124	4.7	9.8	12.8	36
120-14-12	120	169	147	4.7	9.8	12.8	36
150-8-6	150	102	82	4.7	9.8	12.8	36
150-10-8	150	122	102	4.7	9.8	12.8	36
150-12-10	150	144	124	4.7	9.8	12.8	36
150-13-10	150	161	124	4.7	9.8	12.8	36
150-14-12	150	169	147	4.7	9.8	12.8	36
165-8-6	165	102	82	4.7	9.8	12.8	36
165-10-8	165	122	102	4.7	9.8	12.8	36
165-12-10	165	144	124	4.7	9.8	12.8	36
165-13-10	165	161	124	4.7	9.8	12.8	36
165-14-12	165	169	147	4.7	9.8	12.8	36
200-8-6	200	102	82	7.8	11.8	17.7	35
200-10-8	200	122	102	7.8	11.8	17.7	38
200-12-10	200	144	124	7.8	11.8	17.7	38
200-13-10	200	161	124	7.8	11.8	17.7	38
200-14-12	200	169	147	7.8	11.8	17.7	38
240-8-6	240	102	82	7.8	11.8	17.7	38
240-10-8	240	122	102	7.8	11.8	17.7	38
240-12-10	240	144	124	7.8	11.8	17.7	38
240-13-10	240	161	124	7.8	11.8	17.7	38
240-14-12	240	169	147	7.8	11.8	17.7	38
275-10-8	275	122	102	7.8	11.8	17.7	38
275-12-10	275	144	124	7.8	11.8	17.7	38
275-13-10	275	161	124	7.8	11.8	17.7	35
275-14-12	275	169	147	7.8	11.8	17.7	35
350-10-8	350	122	102	9.8	13.0	19.6	35
350-12-10	350	144	124	9.8	13.0	19.6	35
350-13-10	350	161	124	9.8	13.0	19.6	35
350-14-12	350	169	147	9.8	13.0	19.6	35

Haco-Atlantic, Inc reserves the right to change any specifications without prior notice and reserves the right to correct any clerical and typographical errors.



					H	I	J
Fast approach speed	Fast return speed	Max. working speed	Motor power	Weight	Total length	Total width	Total height
IPM	IPM	IPM	HP	lbs	mm	mm	mm
165	130	19	5.5	5,500	83	57	83
165	130	19	5.5	6,600	96	57	83
165	130	19	5.5	7,700	115	57	83
165	130	19	10	9,680	96	57	83
165	130	19	10	10,340	110	57	83
165	130	19	10	11,220	138	57	83
165	142	17	10	15,180	110	67	88
165	142	17	10	16,280	138	67	88
165	142	17	10	18,040	161	67	88
165	142	17	10	20,020	173	67	96
165	142	17	10	23,320	185	67	110
165	142	17	10	16,280	110	67	90
165	142	17	10	17,200	138	67	90
165	142	17	10	19,360	165	67	90
165	142	17	10	21,560	173	67	96
165	142	17	10	23,760	185	67	110
165	142	17	15	16,940	110	67	108
165	142	17	15	18,040	138	67	108
165	142	17	15	20,460	165	67	110
165	142	17	15	22,880	173	67	110
165	142	17	15	28,380	185	67	114
189	224	21	20	22,000	110	69	105
189	224	21	20	25,080	131	69	108
189	224	21	20	29,480	153	69	108
189	224	21	20	31,240	170	69	110
189	224	21	20	36,080	178	69	114
189	224	21	25	25,520	110	79	108
189	224	21	25	26,620	131	79	108
189	224	21	25	33,220	153	79	110
189	224	21	25	35,200	170	79	110
189	224	21	25	39,600	178	79	114
189	212	19	25	29,480	131	81	110
189	212	19	25	36,300	153	81	110
189	212	19	25	38,280	170	81	110
189	212	19	25	42,900	178	81	118
189	245	19	30	38,940	131	81	118
189	245	19	30	44,440	153	81	122
189	245	19	30	47,740	170	81	126
189	245	19	30	52,800	178	81	126

#### Safety

All Haco-Atlantic machine tools are built conformable to American Standard Institute B11.3 2002 Safety Standards for hydraulic power press brake. However, due to the multipurpose use of some of the equipment the purchaser shall be responsible for the proper installation and continued use of point of operation guards or awareness between or assure complete operator safety.

#### Expressed warranty

All Haco-Atlantic machine tools are warranted to be free from defects for a period of one full year from date of installation by our serviceman. This includes all parts and labor except dies and tooling. Warranty will be considered void if the machine is not used in a normal and proper manner, not properly maintained, or modified for any special use. No other warranty is either expressed or implied by Haco-Atlantic Inc. or any of its representatives.

# complete sheet metal working program



## HYDRAULIC SHEARS

Conventional and CNC controlled. Up to 1 1/4."



## ANGLE NOTCHERS (left)

Fixed and variable angle. Up to 0.236"

## HYDRAULIC STEELWORKERS (right)

4 and 5 station universal steelworkers for punching, shearing flat, angle and bar cutting, notching. Up to 175 tons.



## CNC PUNCHING MACHINES

We offer single station and 12/20 station CNC punching machines. Indexable punching head on most models. Manual tool change turret for the single station models and automatic tool change turret for the 12/20 station machines are available as an option.

*Safety features, fences as shown are standard for countries requiring the CE safety specifications and optional for others. Haco-Atlantic, Inc reserves the right to change any specifications without prior notice and reserves the right to correct any clerical and typographical errors.*



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