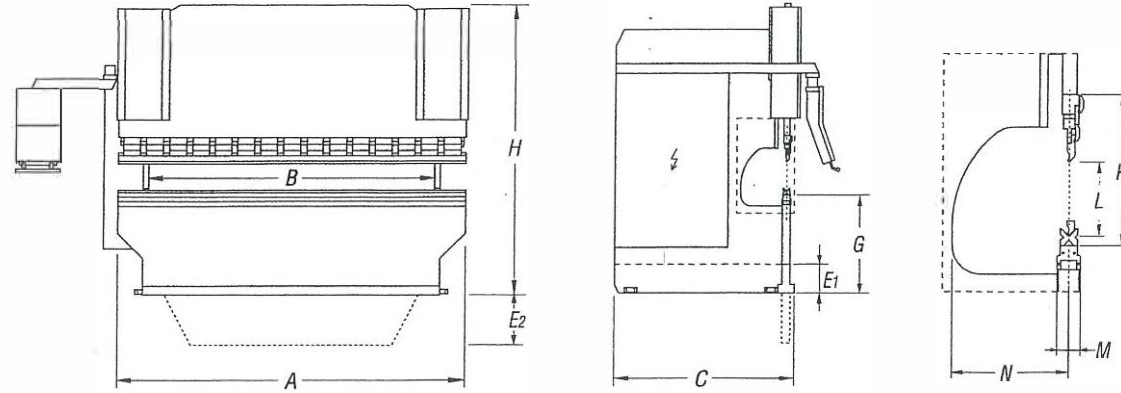


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TECHNICAL DATA
APHS cnc press brakes



Type	Bending Length	Bending Force	Main Motor	Oil Capacity	Inside Frames	Daylight Opening	Stroke	Throat Gap	Approach Speed	Working Speed	Return Speed
	Inches	Tons	Hp	Gallons	Inches	Inches	Inches	Inches	Inches/Sec	Inches/Sec	Inches/Sec
APHS 125040	49	44	5	18	42	18	8.45	16	6.3	0.393	5.12
APHS 21060	82	66	7	31	63	18.5	8.26	16	5.9	0.393	5.12
APHS 26090	102	99	9.75	31	80.7	21.25	10.23	16	5.9	0.393	5.12
APHS 31090	122	99	9.75	31	100	20.8	10.23	16	6.3	0.393	5.12
APHS 31120	122	132	14.3	31	100	21.25	10.23	16	6.3	0.393	5.12
APHS 31160	122	176	19.5	47	100	21.25	10.23	16	6.3	0.393	5.12
APHS 31200	122	220	24	47	100	20.87	10.23	16	5.9	0.393	5.12
APHS 31240	122	264	28	47	100	20.87	10.23	16	5.12	0.393	4.72
APHS 31300	122	330	28	62	100	25.98	12.59	19	4.33	0.314	3.93
APHS 31440	122	484	39	100	100	22.63	12.59	19	4.33	0.314	2.75
APHS 41160	161	176	19.5	46	139	20.86	10.23	16	7.87	0.393	4.72
APHS 41200	161	220	24	46	139	20.86	10.23	16	7.87	0.393	4.33
APHS 41240	161	264	28	46	139	20.86	10.23	16	6.3	0.314	3.93
APHS 41300	161	330	28	62	139	25	12.59	19.6	4.72	0.314	3.54
APHS 41440	161	484	39	100	139	23.23	12.59	19.6	3.14	0.314	2.75
APHS 61240	240	264	28	67	200	19.6	10.23	16	5.51	0.393	3.93
APHS 61300	240	330	28	67	200	22	12.59	19.6	4.72	0.314	2.75
APHS 61440	240	484	33	100	200	22.4	12.59	19.6	3.54	0.314	2.75
APHS 61600	240	660	48	111	200	24.4	14.17	19.6	3.14	0.275	2.75

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Design and specifications are subject to change without notice.

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Baykal APHS Press Brakes



WESTWAY MACHINERY LTD.
specialists in metal forming and fabrication machinery
2370 Cawthra Road, Mississauga, Ontario
www.westwaymachinery.com
(905) 803-9999



DESIGN AND OPERATING FEATURES

- Rigid, welded, monoblock steel frame for minimum deflection under load up to 330 tons (Models above 330 tons are bolted).
- Downstroking bending beam with two cylinders made from high-quality certified forged steel, precisely honed and chrome plated.
- Ram travel fully supported in low friction fiber slideways.
- Full electronic synchronization with proportional valve technology assuring maximum bend accuracy and repeatability through constant monitoring and correction of beam parallelism by a CNC system +/- .0004 parallelism and repeatability.
- Stroke-depth measurement through high-precision linear scales which are bed referenced for the best bending repeatability
- CNC-controlled backgauge on ballscrew spindles with AC servo motor for precise accuracy and speed.
- Block-type European hydraulics.
- Large electrical cabinet for maximum ventilation.
- Full conformity with EU/CE Machinery Directive for safety certification.
- ST 44-2 Certified steel used for components.
- CSA certified & PHSR compliance ready.
- Block laser safety guarding.

CNC SYSTEM

DELEM DA-66T 2D Graphical control with 2D numerical programming and machine control facilities in a user-friendly environment.

Main features include:

- Programmable multi-axis control.
 - Y1-Y2 cylinder axes
 - X 1-X2-R1-R2-Z1-Z2 backgauge axes
 - CNC crowning axis
 - Modular expansion for additional axes
- High-memory capacity. Over 50,000 programs and 200 tool data.
- High number of product and bend repeat possibility
- Direct graphical programming with automatic computation of all axis positions and bend sequence in full graphic simulation.
- Product programming with direct angle mode. For each CNC program and bend sequence, the programmable and/or computed functions include: bending length and thickness, material selection, tooling selection, bend method, mute position, pinching point, press force/speed, incremental travel and retraction of backgauge, programmable move time for axis re-positioning, decompression stroke/speed, tilt adjustment, corrections on Y and backgauge axis for bending full length machine parts.
- Operator selectable languages English / French.
- Integrated diagnostic software.
- Memory storage on USB flashdisk
- Real-time Windows system for multi-tasking and file management.
- Networking or server connection compatability.

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DA-66T 2D



DA-69T 3D

Optional with 3D graphic controls



Backgauge Fingers

BACKGAUGE OPTIONS

- (A) Backgauge system with X axes:
 - Travel on ballscrew spindles
 - Two micrometric stop-fingers with lateral adjustment
 - Range

X-axis : 39.3"
R-axis : 6.3"
 - Travel speed (max)

X-axis : 826"/min
R-axis : 567"/min
 - Positioning precision

X-axis : ± .001"
R-axis : ± .002"

- (B) Additional backgauge axes for special applications:

• X1 - X2	• X1 - X2	• X
• R1 - R2	OR • R	OR • R
• Z1 - Z2	• Z1 - Z2	• Z1 - Z2

Details of these special backgauge systems are available on request



Optional 6 Axis Backgauge



Standard Backgauge

ACCESSORIES

STANDARD:

- Baykal CNC Mechanical crowning.
- American/European-style top tool holders.
- Starter tool package consisting of segmented gooseneck punch and multi-vee die block, full length.
- Pedestal console with double foot pedal.
- Front support arms on linear guides.
- Electrically-interlocked side and rear guards.
- Profiler Lite-T (Delem) software.
- Front light guards or front laser protection for enhanced safety.

OPTIONAL:

- Top tool manual quick-release clamps, Hydraulic tool clamping systems, Programmable sheet follower arms.
- Special tooling for customer applications:
 - Special-profile top and bottom tools.
 - Single-vee dies with table adapters.

Delem Profile T3D Offline Programming Software

Includes:

- An upgraded DA-69T Touchscreen Controller with 2D as well as 3D programming.
- 2D and 3D part programming and DXF import functionality.
- Automatic Tool Selection.
- Automatic Bend Sequence.
- Import part and tool profiles (IGES, SAT, STEP etc.).
- Ability to connect to multiple Press Brakes.



CNC Crowning



Tooling