



The Bend

The Combi
The Laser
The Punch
The System
The Software

**Prima Power BCe
Bending centres**

New automatic and flexible bending process with semi-automatic material handling by Prima Power



Prima Power's BCe series bending centres offer the well-known express bender benefits – precision, flexibility and high surface quality in a semi-automatic process. Only loading is performed manually – an easy task due to user-friendly design.

BCe series provides productive capacity manufacturing of single pieces and small batches as well for serial production. It enlarges bending capability to the applications that were not possible without it, allowing production of

components which are fully perforated, have large or high forms, or need large openings.

Wide option range

The BCe bending centre can be customized using the wide range of Prima Power options such as automatic tool change, additional upper tool, additional short blade, etc.

Some BCe benefits:

- Favourable energy savings, (- 64 % consumption and CO₂ emission compared with hydraulic solution)
- Excellent bending accuracy and surface quality with high repeatability
- Higher productivity – loading operation is simultaneous with unloading – shorter cycle time
- Elimination of skilled operator need, still maximum productivity
- Full safety for the operator – the parts to be processed are transferred automatically from an external table
- Reliable, accurate operation – automatic clamp feeder moves the part to be bent from the table to the manipulator
- Higher operator efficiency – automatic pusher conveyor (LBN) unloads bent parts to the unloading table with automatic buffer function
- Fully automatic set-up between different components (with ATC)
- With automatic tool change ATC and bar code reader the machine makes automatic setup and activates new part program
- Very low maintenance cost (- 65%)
- Compact layout
- Higher productivity and faster programming compared with manual folding machines and robotized press brake

Technical Data	BCe4	BCe5-2	BCe5-3
Max. bending length	2,250 mm	2,650 mm	2,650 mm
Min. length between bends *1	350 mm	350 mm	350 mm
Min. width between bends *1	160 mm	160 mm	160 mm
Sheet length (min. ... max.)	370 ... 2,850 mm	370 ... 2,850 mm	370 ... 2,850 mm
Sheet width (min. ... max.)	180 ... 1,500 mm	180 ... 1,500 mm	180 ... 1,500 mm
Max. bend height type	200 mm	200 mm	200 mm
Max. re-entering bend *1	55 mm	55 mm	55 mm
Max. panel diagonal	3,000 mm	3,000 mm	3,000 mm
Bending force	32 t	30 t	41 t
Sheet holding force	52 t	52 t	90 t
Max. material thickness			
Steel, 410 N/mm ²	2.5 mm (3.0 mm for max. 1,800 mm length)	2.0 mm	3.2 mm
Stainless steel, 600 N/mm ²	1.8 mm (2.0 mm for max. 1,800 mm length)	1.5 mm	2.2 mm
Aluminium, 260 N/mm ²	3.5 mm (4.0 mm for max. 1,800 mm length)	3.0 mm	4.0 mm
Min. material thickness	0.5 mm	0.5 mm	0.5 mm
Min. external radius	1.5 ... 2 x sheet thickness	1.5 ... 2 x sheet thickness	1.5 ... 2 x sheet thickness
Bending angle	-130° ... +130°	-130° ... +130°	-130° ... +130°
Max. number of bends per side	Unlimited	Unlimited	Unlimited
Numerical Control	Siemens Sinumerik 840D Solution Line	Siemens Sinumerik 840D Solution Line	Siemens Sinumerik 840D Solution Line
Average power consumption *2	9.5 kWh	9.5 kWh	13.5 kWh
Voltage	400 v (50/60 Hz)	400 v (50/60 Hz)	400 v (50/60 Hz)

Notes: *1 All values cannot coexist in single part construction *2 Based on average piece dimensions and average batch production