



The Bend

The Combi
The Laser
The Punch
The System
The Software

Prima Power EBe
– a new solution for high-quality bending

Servo-electric technology for better bending and improved operation economy



Well known for advanced bending technology and innovative servo-electric applications, Prima Power has combined them in the new automatic bending cell EBe. EBe automates the bending process of high-quality sheet metal components.

The new EBe, featuring Prima Power's E-technology, offers outstanding benefits through

- flexibility for small series production
- excellent bending quality as required by e.g. design products
- low overall operation cost due to
 - low energy consumption (- 64 %)
 - low oil maintenance cost
- very fast operation

Compared with all-hydraulic solutions, truly remarkable savings can be made in your component manufacturing.

New industrial design – easy integration

Prima Power EBe has also been designed for the modern manufacturing facility, with carefully planned ergonomics through integrated safety covers.

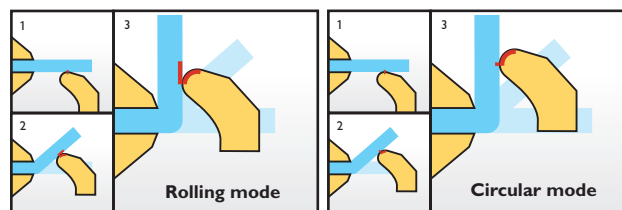
Servo operated blade movements

The new construction features actuation of the bending blade movements (vertical and horizontal) by servo NC-axes instead of hydraulic cylinders. The upper tool movements are made also by another NC servo-axis.

Prima Power EBe provides the high bending quality required in demanding applications such as component production for design products. This is achieved through precise control of bending axes, fast and smooth bending, open programmability, and the fact that the construction is immune to variation in thermal conditions.

Two operating modes

For optimum product quality, a new bending principle is now available. With this new principle, when the "rolling mode" is used, there is a wider contact surface between the blade and the sheet but no relative friction. Alternatively, when using a standard "circular mode", the contact point remains constant whereas the contacting point of the blade changes during the bending movement.



Other features

- Sophisticated software, including graphic parametric programming, and simulation at operator interface
- Off-line programming
- Reduced vibration
- Very low noise level
- Configurability with all Prima Power bending options
- Upper pressure force automatically adjusted according to material thickness and length
- Automatic recording of bending parameters in material data base
- Environmentally friendly Green Means® solution

Technical Data	EBe 4	EBe 5-2	EBe 5-3	EBe 6
Max. bending length	2,250 mm	2,650 mm	2,650 mm	3,350 mm
Min. length between bends *	350 mm	350 mm	350 mm	350 mm
Min. width between bends *	160 mm	160 mm	160 mm	160 mm
Sheet length (min. ... max.)	370 ... 2,850 mm	370 ... 2,850 mm	370 ... 2,850 mm	370 ... 3,800 mm
Sheet width (min. ... max.)	180 ... 1,500 mm	180 ... 1,500 mm	180 ... 1,500 mm	180 ... 1,700 mm
Max. bend height type	200 mm	200 mm	200 mm	200 mm
Max. re-entering bend *	55 mm	55 mm	55 mm	55 mm
Max. panel diagonal	3,000 mm	3,000 mm	3,000 mm	3,950 mm
Bending force	32 t	30 t	41 t	41 t
Sheet holding force	52 t	52 t	90 t	100 t
Max. material thickness				
Steel, 410 N/mm ²	2.5 mm	2.0 mm	3.2 mm	3.0 mm
	3.0 mm for max. 1,800 mm length			3.2 mm for max. 3,000 mm length
Stainless steel, 680 N/mm ²	1.8 mm	1.5 mm	2.2 mm	2.0 mm
	2.0 mm for max. 1,800 mm length			2.2 mm for max. 3,000 mm length
Aluminium, 265 N/mm ²	3.5 mm	3.0 mm	4.0 mm	3.5 mm
	4.0 mm for max. 1,800 mm length			4.0 mm for max. 3,000 mm length
Min. material thickness	0.5 mm	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	1.5 ... 2 x sheet thickness
Bending angle	-130° ... +130°	-130° ... +130°	-130° ... +130°	-130° ... +130°
Max. number of bends per side	Unlimited	Unlimited	Unlimited	Unlimited
Numerical Control	Siemens Sinumerik 840D Solution Line	Siemens Sinumerik 840D Solution Line	Siemens Sinumerik 840D Solution Line	Siemens Sinumerik 840D Solution Line
Average power consumption	9.5 kWh	9.5 kWh	13.5 kWh	13.5 kWh
Voltage	400 v (50/60 Hz)	400 v (50/60 Hz)	400 v (50/60 Hz)	400 v (50/60 Hz)

(Note: * All values cannot coexist in single part construction)