



salvagnini

P4-3212.ALA



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ALA

Panel Bender P4-3212

Technical specifications:

Min. sheet thickness:

Max. sheet thickness, Mild Steel (max. 410 N/mm²):

Max. sheet thickness, Stainless Steel (max. 600 N/mm²):

On inquiry: Max. sheet thickness, Aluminum (max. 265 N/mm²):

Processing of material with plastic protection

Processing of pre painted material

$S_{min} = 0,50\text{mm}$

$S_{max} = 1,50\text{mm}$

$S_{max} = 1,00\text{mm}$

$S_{max} = 2,00\text{mm}$

Max. sheet thickness when using option CLA (max. 410 N/mm²):

Max. sheet thickness when using option CLA (max. 600 N/mm²):

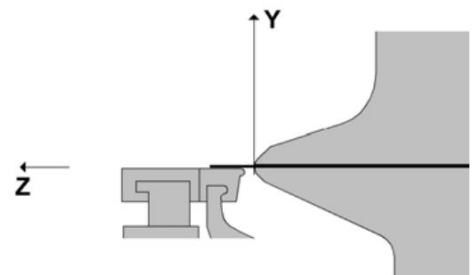
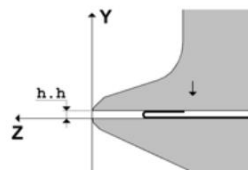
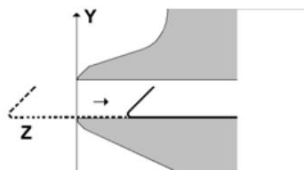
Max. bending angle: Ask Salvagnini about drawing of bending geometry.

Max. bending angle with option CLA: +90°

Max. tooling length for option CLA: 1000mm

$S_{max} = 1,50\text{mm}$

$S_{max} = 1,00\text{mm}$



Maximum and minimum dimensions of the punched blank:

Max. length on entrance: 3395mm

Max. width on entrance: 1500mm

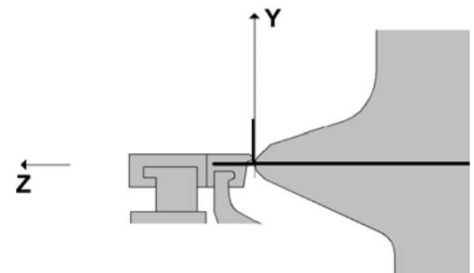
Min. length on entrance: 285mm

Min. width on entrance: 210mm

Max. diagonal: 3500mm

Max. width on exit: 1500mm

Max. referencing dimension: 3200mm



Automatic tool changing system ALA

Computer: Industrial PC
(Siemens or HP)



1. Panel with no return bends, the rotator clamp is parallel to the long side.

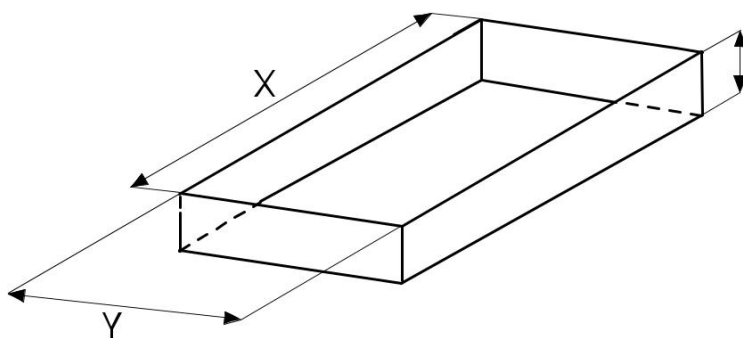
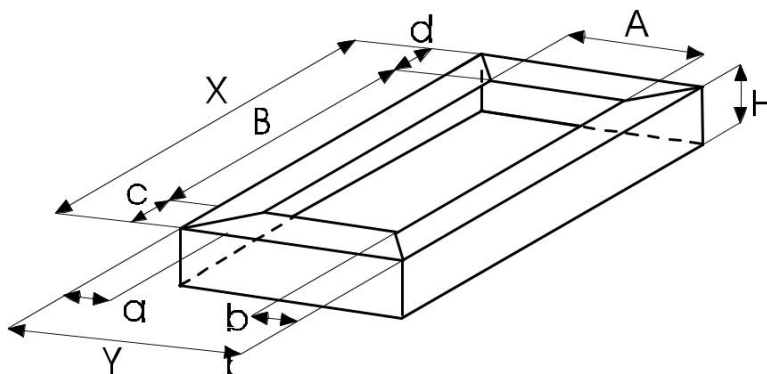


Fig. (1)

$$\begin{aligned}
 Y_{\min} &= 124\text{mm} + k && \text{or} \\
 Y_{\min} &= 210\text{mm} + k \\
 X_{\min} &= 611\text{mm} + 4 \cdot S && \text{1) or} \\
 X_{\min} &= 506\text{mm} + 4 \cdot S && \text{2) or} \\
 X_{\min} &= 551\text{mm} + 4 \cdot S && \text{3) or} \\
 X_{\min} &= 446\text{mm} + 4 \cdot S \\
 X_{\max} &= 3200\text{mm} \\
 H_{\max} &= 127\text{mm}
 \end{aligned}$$

1) with ALA 30/615/130 2) with ALA 30/510/210 3) with ALA 25/555/130 4) with ALA 25/450/210

2.. Panel with return bends, the rotator clamp is parallel to the long side.



$$a_{\max} = b_{\max} = 45 \text{ mm}$$

$$c_{\max} = d_{\max} = 30 \text{ mm}$$

$$\begin{aligned}
 A_{\min} &= 124\text{mm} + k && \text{or} \\
 A_{\min} &= 210\text{mm} + k \\
 Y_{\min} &= A_{\min} + a + b \\
 X_{\min} &= 611\text{mm} + 4 \cdot S && \text{1) or} \\
 X_{\min} &= 506\text{mm} + 4 \cdot S && \text{2) or} \\
 X_{\min} &= 551\text{mm} + 4 \cdot S && \text{3) or} \\
 X_{\min} &= 446\text{mm} + 4 \cdot S \\
 X_{\max} &= 3200\text{mm} \\
 H_{\max} &= 127\text{mm}
 \end{aligned}$$

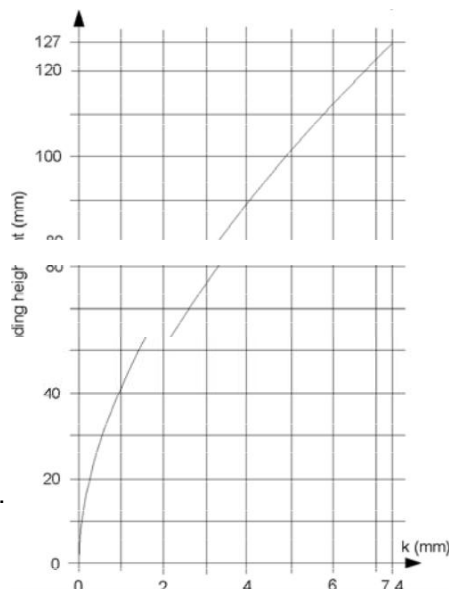
1) with ALA 30/615/130 2) with ALA 30/510/210 3) with ALA 25/555/130 4) with ALA 25/450/210

Minimum Panel Conditions

- The height of the bends: the higher the bent panel (max. = 127mm), the bigger must be the minimum panel width. This is because the Blankholder moves along an arc. (see 'k' values).
- The ability to load and to reference the blank; it must not be too small.

Maximum Panel Conditions

- The ability to load the blank into the machine (max. length, max. width).
- The maximum diagonal that can be rotated: 3500mm.



The 'k' values are only important when making narrow pieces.

S....sheet thickness

**This Data Sheet is only valid together with a drawing of the bending geometry.
Further the minimum and maximum dimensions depends to the configuration of
the loading and unloading unit.**

The information provided in this Data Sheet is subject to be changed without notice.

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