

**SALVAGNINI Maschinenbau GmbH**

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**P4-1812**

Nominal Power: 0 ÷ 25,8 kW  
Voltage: 3 ~ + PE 400V (±10%)  
Frequency: 50Hz  
Cooling Unit: R51  
Blankholder: MLA  
Loading Device: HPT201512  
Unloading Device: HPT201512

**PRODUCT SPECIFICATIONS**



Approximate required space: Length x width x height: 8600mm x 6800mm x 2800mm

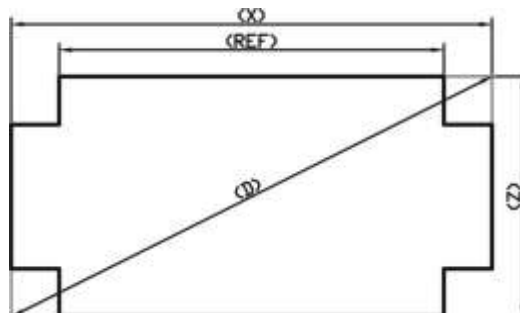
**TECHNICAL SPECIFICATIONS**

**1.) Thicknesses**

Min. sheet thickness:	0,5mm
On inquiry:	Processing of material with plastic protection Processing of pre painted material

**2.) Minimum and maximum dimension of the punched blank**

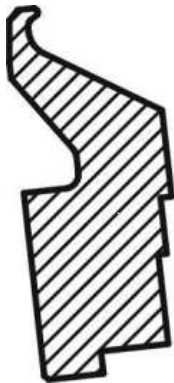
Max. length (X):	2000mm
Max. width (Z):	1500mm
Min. length (X):	285mm
Min. width (Z):	190mm
Max. diagonal (D):	2150mm
Max. referencing dimension (REF):	2000mm
Min. referencing dimension (REF):	270mm



### 3.) Bend Specifications



<b>LS</b> Max. sheet thickness, Mild Steel (max. 410N/mm <sup>2</sup> ) at 90°:	2,00mm
Max. sheet thickness, Mild Steel (max. 410N/mm <sup>2</sup> ) at 135°:	2,00mm
Max. sheet thickness, Stainless Steel (max. 580N/mm <sup>2</sup> ) at 90°:	1,25mm
Max. sheet thickness, Stainless Steel (max. 580N/mm <sup>2</sup> ) at 125°:	1,25mm
Max. sheet thickness, Aluminum (max. 265N/mm <sup>2</sup> ) at 90°:	3,00mm
Max. sheet thickness, Aluminum (max. 265N/mm <sup>2</sup> ) at 135°:	2,00mm
Max. sheet thickness when using option CLA (max. 410N/mm <sup>2</sup> ):	2,00mm
Max. sheet thickness when using option CLA (max. 580N/mm <sup>2</sup> ):	1,25mm
Max. bend angle option CLA/N:	90°
Max. bend length option CLA/N per side:	500mm

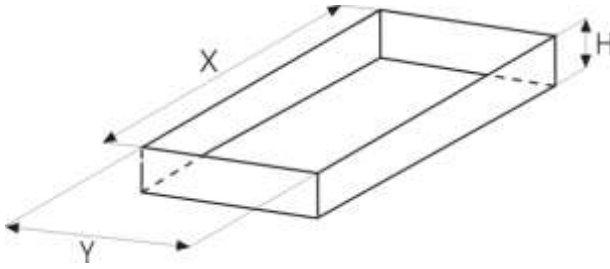


<b>LI</b> Max. sheet thickness, Mild Steel (max. 410N/mm <sup>2</sup> ) at 90°:	2,00mm
Max. sheet thickness, Mild Steel (max. 410N/mm <sup>2</sup> ) at 135°:	2,00mm
Max. sheet thickness, Stainless Steel (max. 580N/mm <sup>2</sup> ) at 90°:	1,25mm
Max. sheet thickness, Stainless Steel (max. 580N/mm <sup>2</sup> ) at 125°:	1,25mm
Max. sheet thickness, Aluminum (max. 265N/mm <sup>2</sup> ) at 90°:	3,00mm
Max. sheet thickness, Aluminum (max. 265N/mm <sup>2</sup> ) at 135°:	2,00mm
Max. sheet thickness when using option CLA (max. 410N/mm <sup>2</sup> ):	2,00mm
Max. sheet thickness when using option CLA (max. 580N/mm <sup>2</sup> ):	1,25mm
Max. bend angle option CLA:	90°
Max. bend length option CLA per side:	500mm

	a max= 63,5mm (without CLA/N)						
	s	b min/a<=20	b min/a=30	b min/a=40	b min/a=50	b min/a=60	b min/a=63
smin	13,8	16,2	18,9	21,6	24,3	26,4	
1,0	16,6	19	21,7	24,4	27,1	29,2	
1,5	18,6	21	23,7	26,4	29,1	31,2	
2,0	19,4	21,8	24,5	27,2	29,9	32	
2,5	19,4	21,8	24,5	27,2	29,9	32	
3,0	20	22,4	25,1	27,8	30,5	32,6	
	a max= 55mm						
	s	b min					
smin	13,6						
1,0	16,3						
1,5	18,2						
2,0	19,3						
2,5	19,8						
3,0	20,9						

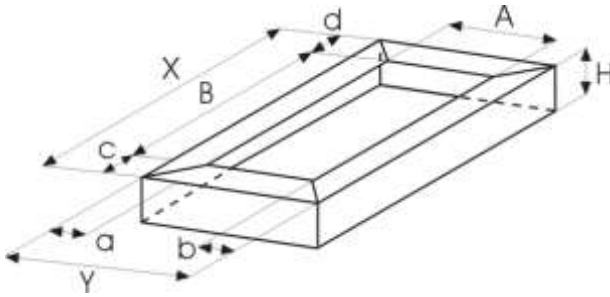
#### 4.) Restrictions on Dimensions

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



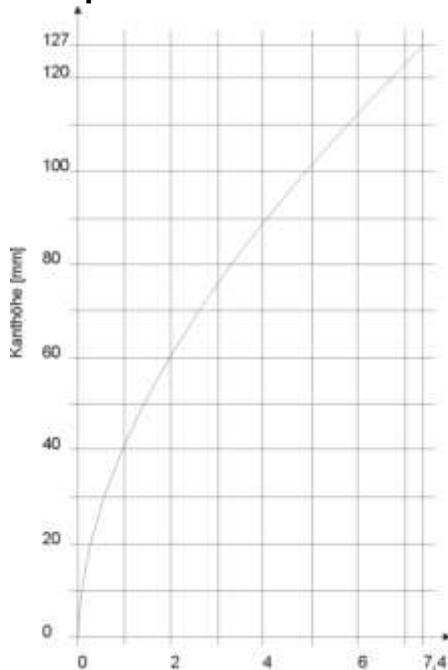
$$\begin{aligned} Y_{\min} &= 119\text{mm} + 4*s + k \\ X_{\min} &= 280\text{mm} + 2*k \\ X_{\max} &= 1850\text{mm} \\ Y_{\max} &= 1500\text{mm} \\ H_{\min} &= 5 * s \\ H_{\max} &= 127\text{mm} \end{aligned}$$

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



$$\begin{aligned} A_{\min} &= 119\text{mm} + 4*s + k \\ Y_{\min} &= A_{\min} + a + b \\ X_{\min} &= 366\text{mm} + 4*s \\ X_{\max} &= 1850\text{mm} \\ Y_{\max} &= 1500\text{mm} \\ H_{\max} &= 127\text{mm} \\ a_{\max} &= b_{\max} = 45\text{mm} \\ c_{\max} &= d_{\max} = 30\text{mm} \\ c_{\min} &= d_{\min} = 30\text{mm} \end{aligned}$$

#### k-parameter



The k-parameter is important for small panels (s...sheet thickness).

#### Minimum panel conditions

The height of the bends: The higher the bend the bigger must be the minimum panel width. This is because the Blankholder moves along an arc. (see 'k' values). Red graph is valid for ABA in case of tall bends on both long sides!

The ability to load and reference the blank (size and corner notches).

#### Maximum panel conditions

The ability to load the blank (max. length, max. width).

The maximum diagonal that can be rotated.

#### 5.) Accuracy

Tolerance on bend angles  $\pm 0.9^\circ$

Tolerance on bend dimensions  $\pm 0.2$  mm

Repeatability  $\pm 0.1$  mm

Total positioning error during referencing  $\pm 0.1$  mm

Tolerance on straightness  $\pm 0.1$  mm/m



**Notes**

*no CLA tool selected*

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*no CLA tool selected*

