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Hi CD, I've seen a lot of great discussions on CNC mills, routers, etc., but not much on press brakes and tools. We have some grants coming in that we want to use to purchase press brakes and tools with. We have a few sponsors in our community who bend a lot of sheet metal and we visit with them, but I would like to see if anyone on the CD has the knowledge and recommendations to get set up. We do a lot of research and planning at this point in time. We would like to make a purchase this summer. This brake will be used for our robotics program and our engineering courses. We are currently looking at this Baileigh press brake: Youtube Link: Website: We like this machine because of the price, footprint, and features, but we are open to suggestions. We have an excellent engineering lab in the school that I run that has Haas CNC mills and machines, CNC routers, hand mills and machines etc. I see us using a lot of .090 aluminum and a lexan on the brake. Basic 90 degree bends, various sharp angles, hemlines, etc. It's obviously a new scope for us, but we're ready to learn more about the process. So... does anyone have any advice on the brake? What tools would you recommend, how should you start? Suppliers? What else do we need besides the brakes and the tools? 1 How is it really a spendy piece of equipment to get without any experience with press brakes. The 971 has a small hand-pressed brake they use. They may have some recommendations. I don't think you'll find many FRC teams that have press brakes in their stores, so any advice will likely have to come from people who use them at work. I would recommend talking to your local sheet metal store to ask their opinion on what you should get. If you are able to buy a running equipment you can probably get a better car cheaper. A local store will most likely lead to a good equipment chase or may be willing to donate tools or an old machine to you. We make a fair amount with curved sheet stocks. Combined with a WJ or CNC router, this is a great way to get a structure without excessive mass. Through sponsors, we have access to an old press brake very similar to the one depicted, as well as to the ancient handbrake and haircut. Honestly, we use the handbrake more than the big one. It's more convenient and safer. Plastic we usually make manually after heating it near the bend line. One tip: Pay attention to the alloys you're bending and how to control Radii. Otherwise you'll have parts of the crack/break on you. We knew it academically, but still had to learn on our hard way! Having a press brake is great, but like the above commentator, I agree that they spend. I looked at them. some time until I decided that I could just build one. No joke, I already had a 12-ton bottle-jack pipe bender (like this one) ( , so I spent about sixty bucks in steel and got to welding. This one will bend a 24-inch piece of .125 aluminum 5052-H32 without difficulty. Only made the frame rails once. basically bend the smaller stuff. We're basically air-bending, that is, we bend into an open gap, the edge of the ram is about 0.06 radius. I also build a right angle that can be placed in a hole, but we rarely used it. You have to bend past 90 to get the right angle with the spring back. We air bend through a 1-inch gap. With this type of bend, we can pass by 90 degrees too. This is what it looks like. I didn't do a CAD, but if someone wants to build one like him, I could do it pretty quickly, ask me. The 5804 is looking at getting a handbrake this summer to help with the manufacture of sheet metal. Baileigh is one of the companies we are looking at, particularly their boxes and pan brakes. I've been working in a terrific store with a few hydraulic press brakes (some cnc, some much older than me with dial back sensors) for seven years, but I'm still definitely limited in my knowledge of sheet metal bending and press brakes. I know enough though to know that there is a lot that goes into this process. A good amount of my time in this store was spent doing drawings for curved pieces of .060 aluminum depending on 3/4 soft steel, so I had to pick up on bending benefit rules, material properties, coronation, etc. you're not told in your post if you have any background with brakes or bending, but if not, I'd definitely encourage you to look more into it all. I'm sure the leadership machine is a good place to start on that (like everyone in store), in addition to what I'm sure is an endless stream of knowledge from around the web and sponsors in your community. You can also PM me if you have any other questions and I can either answer them or most likely ask one of the gray beards in the store. As for the brakes you're looking at getting, I'd be wary of the hydraulic press in the high school store as far as safety goes, but I'm also wary of the handbrake we get. Like any machine, there is plenty that can go wrong with a hydraulic brake from the obvious pinch (read: removal) of fingers and limbs to the cleavage dies and shower all those around with metal shrapnel at the level of the crotch. The latter may be less of a problem with new tools that are only hardened at the very surface where it comes into contact with work and then softer throughout but still worry in the back of my mind. I know I plan to be extremely strict about using our students' brakes and will always have hard supervision on the part of myself or another mechanical mentor while them, and the chances of disaster at the manual are much less than on hydraulic in my opinion. Or at least disaster will happen in a slower and more controlled fashion::ouch:: What are you trying to do with this brake that you don't think you could do with the handbrake? You can certainly get a handbrake that will make up to 1/8 aluminum or soft steel, 90 degree bends, some sharper bends depending on what you need, and even some pretty tight reverse bends (No.625). I don't think you'll be able to find one in a position of hem, but I also don't think I've ever seen a use for hemming on any robots I've been a part of or seen in competitions, so I bet on a 25,000 price difference, you could get away without it. For lexan, I've actually never seen the press brake used to make bends. This may be possible, and from my reading, it seems like this is the case, but anytime I ever need to bend the plastic sheets, I just sat on the plastic bending the thermal strip for a few seconds and then bent it around the pattern (usually 2x4 or something simple). All that being said, if you can treat this machine as a learning device for students, I would say it is definitely worth it. My shop and many stores across the country find it hard to find a skilled workforce whether its welders, machinists, brake operators that you have. If, in your opinion, this brake and the knowledge that will inevitably come with it will positively affect more students in your area than the handbrake will be, I would say definitely pull the trigger on it. The thicker your material, the wider the bottom dies you will need to make bends, and you can find diagrams like this around which will show you that die to get over the thickness of the material and given the tonnage of your press. You can also have some gooseneck strokes for tight return bends, some hemming tools, and then maybe even some horn strokes that will allow the back of the curved part to swing back through the space created between the opposite horns to the front/back of the machine. Using the right toolkit is pretty dang important on hydraulic press brakes (see item 3), so definitely don't skimp on this stuff and always, always make sure they sit properly and tightly before you bend anything. If you end up getting a brake of any type, make sure you pay attention to your aluminum alloys. While I don't think you'll work into it much, some alloys aren't molded and cracked or split if you bend them past a certain point. Formed alloys 3003, 5052 or 6061, while you probably want to stay away from the alloy 7005. Most of what you usually encounter will be 6061 anyway, although the way I said, you probably won't have a problem with it most of the time. Time. some budget options that probably work well for most teams. I use a 12T HF kit at home to bend a lot of different things. I changed the manual cylinder for the air cylinder, which worked very well for me. The digital angle of the gage listed on Swag is a great tool to have in general. I have two that I use regularly. At 95 we got a press brake like this for our pit this year. It was huge for bending small brackets quickly and accurately in the pits. There are many other options out there for press brakes. Pan and Box brakes are a much cheaper way to get into folding large pieces of sheet metal though. Something like this machine might bend most of the thickness the FRC team would be interested in. 138-ton press brake with 2 robots for 22-25K. Now that may be a bit much, but with your budget something small with 3 axis CNClike thisshouldn't hard to find. The 5804 is looking at getting a handbrake this summer to help with the manufacture of sheet metal. Baileigh is one of the companies we are looking at, particularly their boxes and pan brakes. I've been working in a terrific store with a few hydraulic press brakes (some cnc, some much older than me with dial back sensors) for seven years, but I'm still definitely limited in my knowledge of sheet metal bending and press brakes. 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You can certainly get a handbrake that will make up to 1/8 aluminum or soft steel, 90 degree bends, some sharper bends depending on what you need, and even some pretty tight reverse bends (No.625). The box and pan brakes can make the hem with the right toolkit if necessary and they will still do lexan for as long as it is true lexan. All that being said, if you can treat this machine as a learning device for students, I would say it is definitely worth it. My shop and many stores across the country find it hard to find a skilled workforce whether its welders, machinists, brake operators that you have. If, in your opinion, this brake and the knowledge that will inevitably come with it will positively affect more students in your area than the handbrake will be, I would say definitely pull the trigger on it. The thicker your material, the wider the bottom dies you will need to make bends, and you can find diagrams like this around which will show you that die to get over the thickness of the material and given the tonnage of your press. You can also have some gooseneck strokes for tight return bends, some hemming tools, and then maybe even some horn strokes that will allow the back of the curved part to swing back through the space created between the opposite horns to the front/back of the machine. Using the right toolkit is pretty dang important on hydraulic press brakes (see item 3), so definitely don't skimp on this stuff and always, always make sure they sit properly and tightly before you bend anything. If you end up getting a brake of any type, make sure you pay attention to your aluminum alloys. While I don't think you'll work into it much, some alloys aren't molded and cracked or split if you bend them past a certain point. Formed alloys include 3003, or 5052, while you probably want to stay away from like a 7005 alloy. Most of what you usually encounter will be the 6061, which I've seen bend fine as well as snap so just be careful with what you get. We're a pretty big sheet metal team so we bought a pre-season brake and its for bends on our drivetrain and bellypan, most 0.090 and 90 degree bends. It was relatively easy to use, just taking some practice getting used to adjusting the leaves and fingers. Our brake: brake: I think it works well for the FRC. Corey: It's really a spendy piece of equipment to get without any experience with press brakes. The 971 has a small hand-pressed brake they use. They may have some recommendations. I don't think you'll find many FRC teams that have press brakes in their stores, so any advice will likely have to come from people who use them at work. Since 2013, the 971 has had a Di Acro 16-24 handbrake. This is a very useful tool. I'm not actually sure whether these are made any more and they might be exclusive on the tool market used, but those are better deals anyway. There's a number of advantages to that good brake press will have more pan/finger brakes, and this hand works one good for most FRC applications. I'd stay away from the press brakes as part 3-1 (roller, brake, haircut). In my though limited experience, these tools combine 3 relatively poor tools into one, and you'd rather invest in a good tool for everyone, or not buy 3 in 1 at all, although the rollers are usually adequate at 3 in 1s. kevincrispie: 971 was a Di Acro 16-24 hand-driven press brake from 2013. This is a very useful tool. I'm not actually sure whether these are made any more and they might be exclusive on the tool market used, but those are better deals anyway. There's a number of advantages to that good brake press will have more pan/finger brakes, and this hand works one good for most FRC applications. I'd stay away from the press brakes as part 3-1 (roller, brake, haircut). In my though limited experience, these tools combine 3 relatively poor tools in 1, and you'd better invest in a good tool for everyone, or not buy 3 in 1 at all, although the rollers are usually adequate at 3 in 1s. This is the same hand press brake as we have. I believe they are only used these days, which is a shame. This is the brake we used to make an unreasonably complex belly pan for our robot 2016. Love it. Thanks for the answers. We already have a good brake finger. I understand that this is a big purchase and we appreciate it from our side. One of the things that we look at is that there are a lot of manufacturers in our community who do a lot of this kind of work. Our program likes to provide production skills that are available in our local community, so this type of equipment makes sense to

expand in. We are actively discussing this with them for recommendations etc. We will try to keep this post up to date with how we make decisions. Any other recommendations for a small medium hydraulic/electric press brake? We're looking, too. What about the magnetic press brake? I don't have any experience with him, but I know the machine shop that has one. we end up going with Baileigh that links earlier. Absolutely love him. We were able to do so much with our CNC router and press the brake. There was a lot to learn with the installation of the toolkit, but once we realized this it opened up a whole new world of possibilities for us. We bought tools Mate.com with a maglock and it was great. We bend the air and primarily used .090 5052 using 90 degree bends. 1 How do @mrwright Do you have pictures of things you did with your press brake? Also, what specific tools do you end up buying? I'm also wondering how your brake differs from the much cheaper BP-3305CNC. Also, I wonder if you found a standard 2-axis brake to be adequate, or if there is a need for additional axle? Anyone else who is an expert on press brakes, please feel free to chime in the multi-axis issue. I'm trying to build my understanding of what parts you can and can't do with different types of machines. I will be working on getting you some details after we return from the Champs-Elysees. @mrwright I understand the champions are upon us and you are probably busier than I can imagine. I'm looking to make a move on the press brake pretty quickly. Any information you are able to provide would be appreciated. I think the Baileigh brakes are the same we got in our machine shop... had it for several years, and it worked fine. For the FRC I used it to bend some battery boxes for commands of 1/8 aluminum (which we cut out on the waterjet... one of the advantages of being after the average institution ... We get some good toys). I don't use it all so much... It's a bit of a pain to get it set up and dialed in for one bend. It would be great for the production work, but not the fastest for prototyping. (Although, if I had used it regularly, I would probably have been faster when setting it up.) It replaced the smaller, manual press brake... and I miss the baby very much. It could do about 90% of the work about 10% hassle ... but for that last 10% of the work we absolutely couldn't do on the kid, it was nice to have. Jason This theme was automatically closed 365 days after the last response. New answers are no longer allowed. Allowed.

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