

## ⚡ S Bender –Left & Right Hand bender series

Han Jie also devotes its efforts to design Left & Right hand bending (LR) and also Spin head (LRS) function to provide customer much more user friendly operation. The advantage of LR and LRS series is to avoid collision, complete one workpiece just by one bending program, very suitable to bend symmetric and easy interference items. Moreover, both series also have teach mode and fine tune function thus easy to set mold up to save change over time.



⊗This machine is LR series, for reference only.

All Electric Left and Right bending series		LR series			LRS series		
Model		HC-250LR-NSM	HC-300LR-NSM	HC-380LR-NSM	HC-250LRS-NSM	HC-380LRS-NSM	HC-500LRS-NSM
Bending capacity	Mild steel (mm)	Ø25.4 × 1.5T	Ø30 × 1.5T	Ø38 × 1.5T	Ø20 × 1.5T	Ø38 × 1.5T	Ø50.8 × 2.5T
	Stainless steel (mm)	-	-	-	Ø16 × 1.5T	Ø32 × 1.5T	Ø38 × 2.0T
	Square(Mild steel)(mm)	-	-	-	□16 × 1.5T	□28 × 1.5T	□38 × 2.0T
Servo axis		8	8	8	11	11	11
Bending Speed (/sec)		450 / ±0.05	400 / ±0.05	250 / ±0.05	180 / ±0.05	125 / ±0.05	110 / ±0.05
Feeding Speed (mm / sec)		1100 / ±0.05	1000 / ±0.05	1500 / ±0.05	1100 / ±0.05	1030 / ±0.05	1000 / ±0.05
Rotation Speed (/sec)		750 / ±0.05	750 / ±0.05	750 / ±0.05	360 / ±0.05	450 / ±0.05	200 / ±0.05
Max. bending radius (mm)		70	80	135	100	180	200
Max. effective mandrel Length (mm)		1500	1500	2000	1500	2000	2500
Max. bending radius difference (mm)		20	25	45	25	65	60
Up & Down move controlled by		Bend-Head	Bend-Head	Bend-Head	M/C Body	M/C Body	M/C Body
Left & Right bending shift		Horizontal	Horizontal	Horizontal	Spin Head	Spin Head	Spin Head
Wiper Die instable		N	N	N	Y	Y	Y
Dimension of MC (mm)		3300×1300×1300	3600×1730×1250	4300×1800×1500	3600×1400×1500	4250×1200×1500	5200×1600×1900
Weight (kg)		1350	1800	2200	1800	4000	5000
Total Power (kw)		11	13.2	17.15	11.5	26.7	41.1



LR series

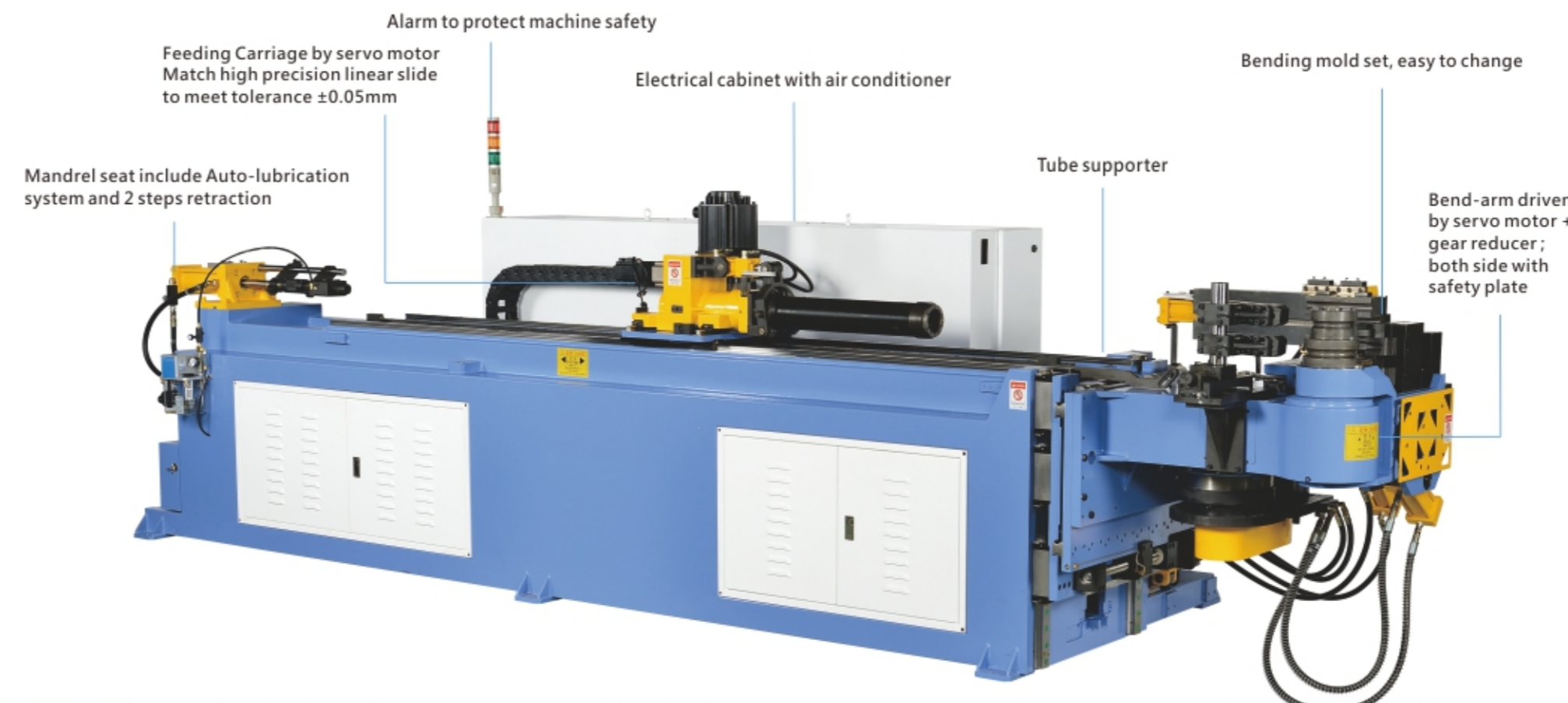


LRS series

## ⚡ S Bender – Hybrid series

Hybrid series is most common used in industries, adopting Servo motor + Hydraulic system to drive bending machine. We can design multi-stack bending mold to meet different requirement from a variety of customers, number of stack depends on pipe diameter. (Multi-stack mold applies on Up & Down axis driven by servo motor). Same as all electric series, this series can be equipped optional device such as punching/cutting/split die/Auto-loading & Off-loading...etc.

Hybrid series		HC-160	HC-250	HC-300	HC-380	HC-500	HC-650	HC-800	HC-1000	HC-1300
Model		HC-160	HC-250	HC-300	HC-380	HC-500	HC-650	HC-800	HC-1000	HC-1300
Bending capacity	Mild steel (mm)	Ø16 × 1.5T	Ø25.4 × 2.0T	Ø30 × 2.0T	Ø38.1 × 2.0T	Ø50.8 × 2.5T	Ø63.5 × 3.0T	Ø76.2 × 3.0T	Ø101.6 × 3.5T	Ø127 × 4.0T
	Stainless steel (mm)	Ø12 × 1.5T	Ø22 × 1.5T	Ø28 × 1.5T	Ø32 × 1.8T	Ø45 × 2.0T	Ø50.8 × 2.0T	Ø65 × 2.5T	Ø90 × 2.0T	Ø114 × 3.0T
	Square(Mild steel)(mm)	□12 × 1.2T	□22 × 1.2T	□28 × 1.2T	□32 × 1.8T	□45 × 2.0T	□50.8 × 2.0T	□65 × 3.0T	□90 × 2.0T	□100 × 3.0T
Bending Speed (/sec)		800 / ±0.05	400 / ±0.05	250 / ±0.05	200 / ±0.05	150 / ±0.05	120 / ±0.05	90 / ±0.05	80 / ±0.05	70 / ±0.05
Feeding Speed (mm / sec)		1200 / ±0.05	1100 / ±0.05	1200 / ±0.05	1200 / ±0.05	1400 / ±0.05	800 / ±0.05	800 / ±0.05	600 / ±0.05	500 / ±0.05
Rotation Speed (/sec)		700 / ±0.05	800 / ±0.05	900 / ±0.05	800 / ±0.05	300 / ±0.05	400 / ±0.05	400 / ±0.05	400 / ±0.05	180 / ±0.05
Max. bending radius (mm)		90	120	120	150	200	250	350	400	450
Max. effective mandrel Length (mm)		1000	1500	1500	2000	2500	3000	3500	4000	4500
Max. bending radius difference (mm)		30	40	40	50	60	65	70	75	80
Dimension of MC (mm)		2700×1250×1700	3500×1300×1700	3600×1300×1700	4200×1500×1700	5100×1500×1700	6000×1700×1700	6300×2150×1700	7500×2000×2200	1000×2200×2750
Weight (kg)		1200	1400	1500	2200	4500	5000	8000	11000	13000



## ⚡ S bend CNC Software (developed by HJ)

Han Jie develop user friendly CNC software which is installed in all our CNC Tube bending machines.

### Key features :

1. PC-based control system in Windows OS.
2. Adopt industrial computer with Intel 4 Core CPU 2.3G
3. Use SSD (120G) high speed reading/writing (with spare SSD\*1), can save 2 Million files at least
4. Simply input XYZ to be converted YBC
5. 3D bending process simulation
6. Simultaneous axis movement on YBC available to save cycle time
7. Work flow editable to avoid interference
8. Repeatable feeding to save pipe material (Minimize tailing)
9. Repeatable pressure die sliding to overcome big bending angle
10. Mirror function enables users to get symmetrical shape
11. Reverse function enables users to get the reverse shape
12. Remote control function available
13. 3D file (.stp or .igs) transfer to CNC software (optional)
14. Integrate measuring system/software (optional)

