

PA
PA PLUS

adira

METAL FORMING SOLUTIONS



PRESS BRAKES PA / PA PLUS

TECHNICAL DATA SHEETS

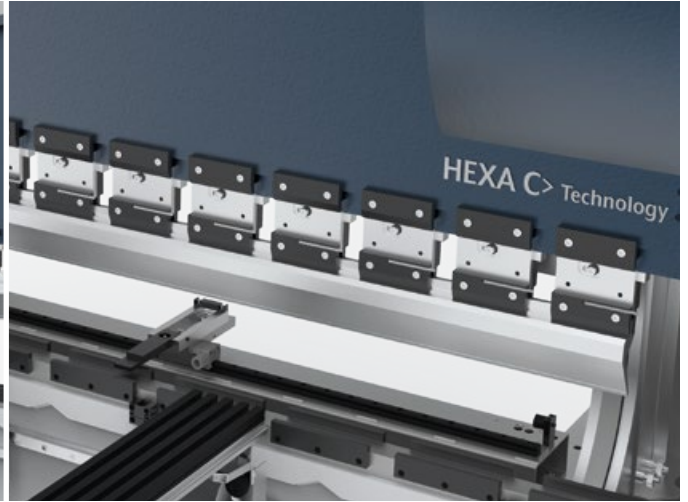
Press Brakes

PA / PA PLUS



The HEXA-C® frame ensures better bending precision, given that the movable ram stays perfectly aligned with the fixed ram.

Greendrive System (PA PLUS).



Main Features PA PLUS

Increased return speed (faster work cycle)

The Greendrive system makes the motor turn very slowly, thereby reducing consumption when the operator is not pressing the pedal or using the machine

A significant reduction in energy consumption

Standard machine equipped with a crowning table, Lazersafe safety system and 4-axis back gauge (X/R/Z1 and Z2)

PA Benefits

Electric-hydraulic synchronisation of the movable ram (Y_1 and Y_2 axes);

Electric-hydraulic stoppage of the movable ram at 0.01 mm; Comprehensive programming of the bending angle;

Movable ram slope programming (Y_1 and Y_2);

Programming work speeds (Advance and Return) [10-100%];

Start/Stop system that allows energy savings;

Standard machine equipped with crowning table, Lazersafe safety system and 2 axes on the back gauge with 4 back gauge stops (X/R).



The position of the ram is constantly monitored through guides, located at the ends of the HEXA-C frame, ensuring repeatability of 0.01 mm of ram positioning, irrespective of the tonnage, load position or oil temperature.

PA PLUS Benefits

GREENDRIVE SYSTEM – the system varies rotation of the electric motor, thus enabling:

- Increased return speed (faster work cycle)
- Residual motor rotation when the machine is stopped
- A significant reduction in energy consumption

TECHNICAL DATA SHEETS

Press Brake PA

PA		13530	13540	16030	16040	22030	22040
Capacity	kN	1350	1350	1600	1600	2200	2200
Bending length	mm	3000	4000	3000	4000	3000	4000
Distance between side frames	mm	2550	3150	2550	3150	2550	3150
Maximum stroke	mm	260	260	260	260	260	260
Max. opening without intermediate tools (A)	mm	500	500	500	500	500	500
Arch (B)	mm	400	400	400	400	400	400
Power	kW	15	15	15	15	15	15
Approximation speed	mm/s	150	150	150	150	130	130
Working speed	mm/s	10	10	10	10	8	8
Return speed	mm/s	100	100	100	100	85	85
X-axis stroke	mm	625	625	625	625	625	625
X-axis speed	mm/s	500	500	500	500	500	500
R-axis stroke	mm	180	180	180	180	180	180
R-axis speed	mm/s	50	50	50	50	50	50
Z1/Z2-axis stroke (optional)	mm	2150	2750	2150	2750	2150	2750
Z1/Z2-axis speed (optional)	mm/s	400	400	400	400	400	400
Min. machine length	mm	3950	4980	3950	4980	3950	4980
Max. machine length (C)	mm	4700	5780	4700	5780	4700	5780
Max. width (D)	mm	2180	2180	2180	2180	2180	2180
Max. height (E)	mm	2960	3120	2960	3120	3050	3120
Height for transport	mm	2750	2880	2750	2880	2830	2880
Approx. weight	Kg	9100	11500	9300	11700	11200	13500
Height of workstation (F)	mm	930	930	930	930	930	930



PA PLUS		13530	13540	16030	16040	22030	22040
Capacity	kN	1350	1350	1600	1600	2200	2200
Bending length	mm	3000	4000	3000	4000	3000	4000
Distance between side frames	mm	2550	3150	2550	3150	2550	3150
Maximum stroke	mm	260	260	260	260	260	260
Max. opening without intermediate tools (A)	mm	500	500	500	500	500	500
Throat Depth (B)	mm	400	400	400	400	400	400
Power	kW	15	15	15	15	15	15
Approach Speed	mm/s	150	150	150	150	130	130
Working speed	mm/s	10	10	10	10	8	8
Return speed	mm/s	150	150	150	150	130	130
X-axis stroke	mm	625	625	625	625	625	625
X-axis speed	mm/s	800	800	800	800	800	800
R-axis stroke	mm	180	180	180	180	180	180
R-axis speed	mm/s	200	200	200	200	200	200
Approx. Z1/Z2-axis stroke	mm	2150	2150	2150	2750	2150	2750
Z1/Z2-axis speed	mm/s	800	800	800	800	800	800
X/X1-axis stroke (optional)	mm	± 100	± 100	± 100	± 100	± 100	-/100
X/X1-axis speed (optional)	mm/s	100	100	100	100	100	100
Min. machine length	mm	3950	3950	3950	4980	3950	4980
Max. machine length (C)	mm	4700	4700	4700	5780	4700	5780
Max. width (D)	mm	2180	2180	2180	2180	2180	2180
Max. height (E)	mm	2960	2960	2960	3120	3050	3120
Height for transport	mm	2750	2750	2750	2880	2830	2880
Approx. weight	Kg	9100	11700	9300	11700	11200	13500
Height of workstation (F)	mm	930	930	930	930	930	930



TECHNICAL DATA SHEETS

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Equipment		PA	PA PLUS
Punch Tightening	Fast clamping "ADIRA" punch holders, non-reversible	standard	
	Fast clamping "ADIRA" punch holders, reversible	■	standard
	"ADIRA/USA" punch holders	■	■
	Wila Pro Hydraulic Punch Clamping	■	■
	Wila Pro USA Hydraulic Punch Clamping		■
	Aperto Hidráulico Punção Wila Premium		■
	Aperto Hidráulico Punção Wila Premium USA		■
	Pneumatic Punch Clamping Teda with Frontal Insertion		■
Tables	Crowning Table, base 60, "Standard Table Kit"	standard	standard
	Table without Crowning, base 60, "Standard Table Kit"	■	
	Table without Crowning, 180 mm, "Table Kit II"	■	
	Table without Crowning, 13 mm, "Table Kit III"	■	
	180 mm Table for Multi V "Table Kit II" Dies	■	■
	13 mm Table for Wila "Table Kit III" Dies	■	■
	Wila Pro Hydraulic Clamping with Crowning table		■
	Pneumatic Clamping for 60 mm base dies		■
Sheet metal support	2 support arms on rail (without height adjustment, without brushes, L = 500 mm)	standard	standard
	1 additional support arm on rail (without height adjustment, without brushes, L = 500 mm)	■	■
	2 support arms on rail (with height adjustment, with brushes, L = 800 mm)	■	■
	1 additional support arm on rail (with height adjustment, with brushes, L = 800 mm)	■	■
	Bending Follower (AQ1)		■
	Second Bending Follower (AQ2)		■
Back gauges	X, R back gauge for AD25	standard	
	X/R/Z1/Z2 back gauge for AD25	■	
	X/R/Z1/Z2 back gauge for CYBTOUCH 15	■	
	X/R/Z1/Z2 for AD61		standard
	X/R/Z1/Z2 back gauge for Delem 6X		■
	X/X1/R/Z1/Z2 back gauge for AD61		■
	X/X1/R/Z1/Z2 back gauge for Delem 6X		■
	X1/X2 - R1/R2 - Z1/Z2 tower back gauge (AD61 or Delem 6X)		■
	1 extra light-duty back gauge stop	■	■
	2 extra back gauge stops		■
	Anti-collision function per stop (extra for each stop)		■

Equipment		PA	PA PLUS
Angle Measurement Safety	LZS- LG Laser Safety	standard	standard
	No safety	■	■
	IRIS Laser Safety		■
	IRIS PLUS Laser Safety (Angle Measurement) (only with AD60)		■
Controls	ESA AD40	standard	
	ESA AD75		■
	DELEM DA 69_3D (up to 16 axes)		■
Leds	Leds (Smart Placing) Esa (only with Wila and AD6X)		■
	Leds (Smart Placing) Esa (only with Wila and Delem6X)		■
	Leds (Smart Placing) Wila (apenas com Wila e Delem6X)		■
Other	UPS	■	■
	Supply Voltage 220 V/400 V 25 kV	■	■
	Robot Interface		■
	Adaptation to High Temperatures	■	■
	Adaptation to Low Temperatures	■	■
	Air Conditioning on the Electrical Cabinet	■	■
	Special Paint	■	■
	Standard tool kit - @ 85° Punch: 3 or 4 x701603305 + 1x701602302 / 4-vee die 3 or 4 x721103300 +1x721104300	■	■
	Special Tools	on request	on request
	Digital Goniometer		■
	AdBendPro	■	■
	2 Machines in tandem	on request	on request





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