



salvagnini

# P4-2512.MLA



**Salvagnini**  
Maschinenbau



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MLA

## Panel Bender P4-2512

### Technical specifications:

Min. sheet thickness:

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

Max. sheet thickness, Mild Steel (max. 410 N/mm<sup>2</sup>):

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

Max. sheet thickness, Stainless Steel (max. 600 N/mm<sup>2</sup>):

$S_{max} = 1,25 \text{ mm}$

On inquiry: Max. sheet thickness, Aluminum (max. 265 N/mm<sup>2</sup>):

$S_{max} = 3,00 \text{ mm}$

Processing of material with plastic protection

Processing of pre painted material

Max. sheet thickness when using option CLA (max. 410 N/mm<sup>2</sup>):

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

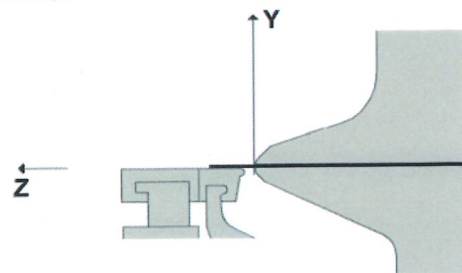
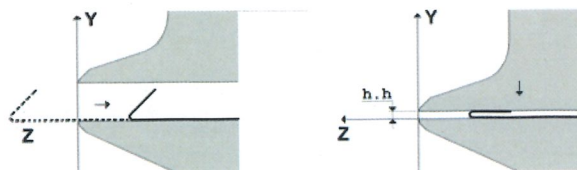
Max. sheet thickness when using option CLA (max. 600 N/mm<sup>2</sup>):

$S_{max} = 1,25 \text{ mm}$

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

Max. bending angle with option CLA: +90°

Max. tooling length for option CLA: 1000mm



### Maximum and minimum dimensions of the punched blank:

Max. length on entrance: 2695mm

Max. width on entrance: 1500mm

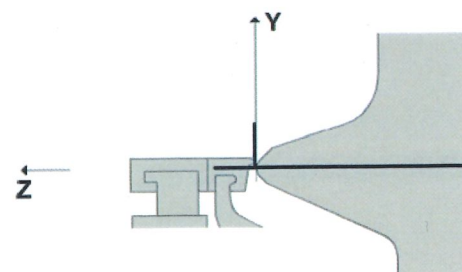
Min. length on entrance: 285mm

Min. width on entrance: 190mm

Max. diagonal: 2800mm

Max. width on exit: 1500mm

Max. referencing dimension: 2500mm



Manual tool changing system MLA

Computer:

Industrial PC  
(Siemens or HP)



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

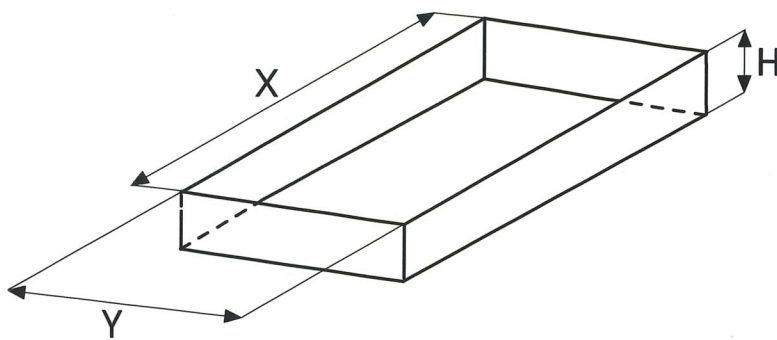


Fig. (1)

$$Y_{\min} = 124\text{mm} + k$$

$$X_{\min} = 280\text{mm} + 2 \cdot k$$

$$X_{\max} = 2500\text{mm}$$

$$H_{\max} = 127\text{mm}$$

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

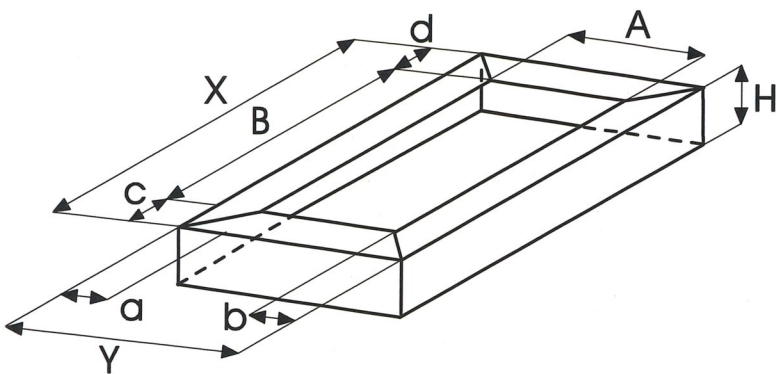


Fig. (2)

$$A_{\min} = 124\text{mm} + k$$

$$Y_{\min} = A_{\min} + a + b$$

$$X_{\min} = 366\text{mm} + 4 \cdot S$$

$$X_{\max} = 2500\text{mm}$$

$$H_{\max} = 127\text{mm}$$

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

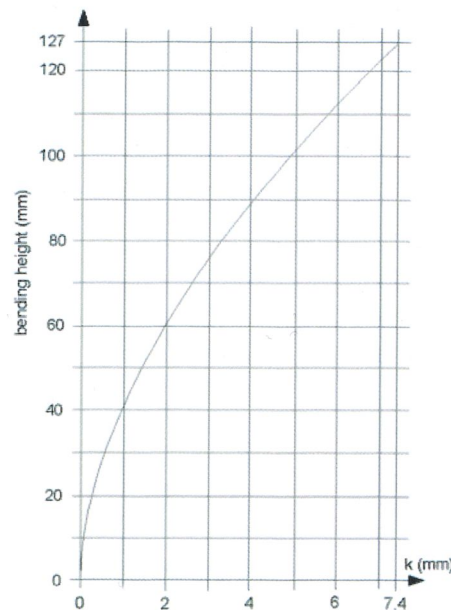
$$c_{\max} = d_{\max} = 30\text{mm}$$

**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**

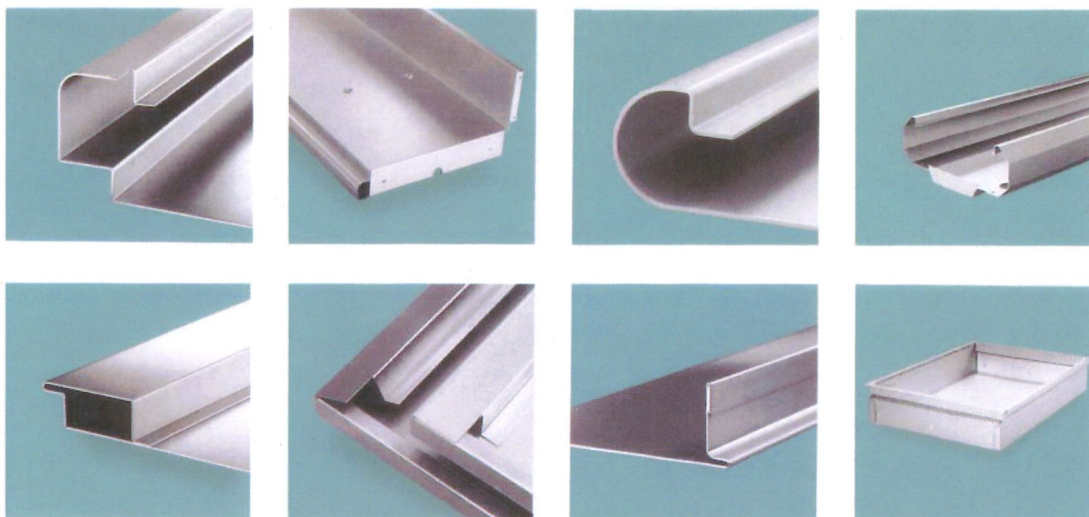
- The ability to load the blank into the machine (max. length, max. width).
- The maximum diagonal that can be rotated: **2800mm**.



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.**



# Salvagnini

M a s c h i n e n b a u  
S e r v i c e c e n t e r  
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