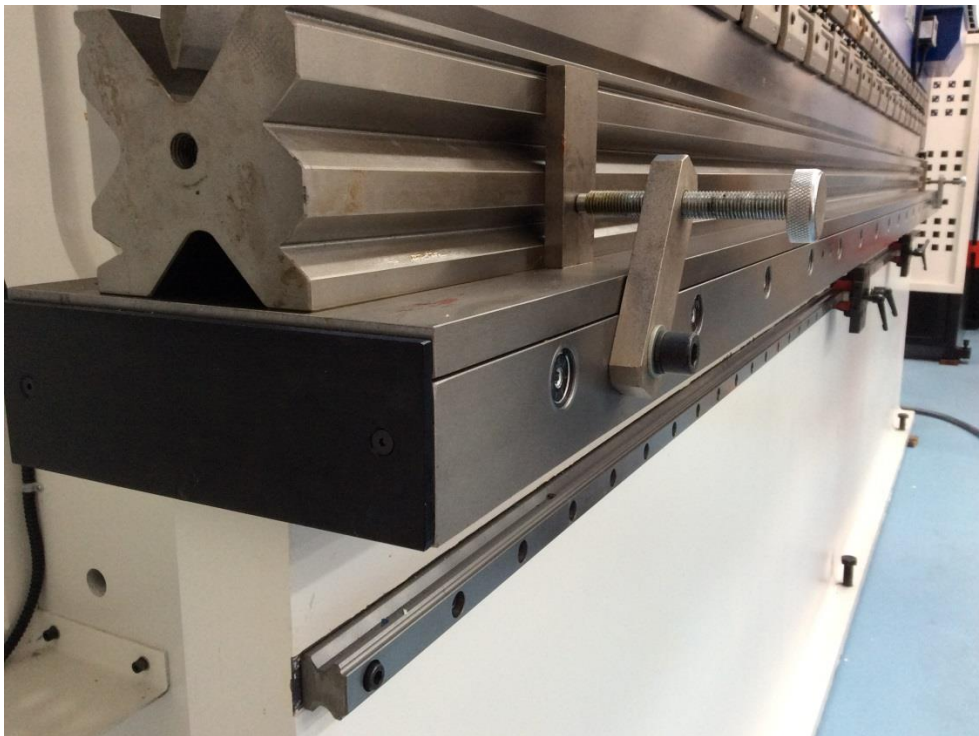


CMT MECHANICAL CROWNING TABLES FOR PRESS BRAKES

Table Crowning – Do you need it?

State-of-the-art press brakes all offer high accuracy and repeatability; what separates high-end machines from the rest of the pack is the ability to adjust for the changing properties of the workpiece material. Even with the most accurate and repeatable machine in the world, if its crowning system cannot be changed easily to adjust for changed material properties from job to job, there is no way accurate, repeatable forming results can be expected.

Back in the day pieces of newspaper were routinely packed under the die block to achieve a cambered shape to the die block and while it is a novel solution it was subject to continuing change as the newspaper compressed and deteriorated while working.



Crowning—the method by which press brakes compensate for deflections in the upper beam and lower bed when pressure is applied—occurs by different methods depending on the make and model of press brake.

123 Bluestone Circuit, Seventeen Mile Rocks, Qld 4073

Ph: 07 32793344 Fax: 07 32793364

Email: sales@completemachinetools.com.au

Internet: www.completemachinetools.com.au

Complete

Machine Tools Pty Ltd

Despite almost all press brakes being fitted with a wedge system on the upper tool clamps the vast majority of press brake users do not use it because of the nightmare presented by having to reset the wedges after having spent a considerable time setting them for a particular job.



Mechanical crowning using a series of adjustable wedges under the bottom tooling is the most simple system available and makes a difficult task of adjusting for press brake beam deflection much easier. The CMT crowning table can be fitted to any brand of press brake using a multi vee bottom die.

The wedge adjusters positioned at a distance of 235mm are easily adjusted using an allen key and graduations on the adjustment dial allow settings to be repeated to speed setup times on recurring jobs or as a starting point on similar jobs.



123 Bluestone Circuit, Seventeen Mile Rocks, Qld 4073

Ph: 07 32793344 Fax: 07 32793364

Email: sales@completemachinetools.com.au

Internet: www.completemachinetools.com.au

Complete

Machine Tools Pty Ltd



The CMT crowning table sits under your multi vee die and simply forms part of the table of your press brake. It requires very little maintenance and all moving parts are inside the table assembly assuring long life and no nasty pieces protruding to compromise safety of your operators.

123 Bluestone Circuit, Seventeen Mile Rocks, Qld 4073

Ph: 07 32793344 Fax: 07 32793364

Email: sales@completemachinetools.com.au

Internet: www.completemachinetools.com.au