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CNC Busbar Machinery

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CNC Busbar Punching and Shearing Machine GJCNC-BP-50



GJ3D Programming Software

Main Functions and Features:

GJCNC-BP series CNC busbar punching & shearing machine is the computer-controlled equipment of high efficiency and high precision, specially used for busbar processing; Dies of punching, shearing and embossing are placed together in the storeroom of dies; It is capable of executing punching (round, oblong and other holes), embossing, shearing, slotting, round cornering and other processes; Automatic clamp switching can be achieved without manual intervention for longer busbars. Finished work pieces will be sent out through the conveyor. Such machine series can be used in combination with the CNC busbar bending machine to form an assembly line of busbar processing.

① GJ3D Programming Software:

The software kit of the equipment is the special CAD software (GJ3D) developed by our company, which can be used on line to realize the automation of programming. The software pioneers in applying three dimensional graphics, the state of the art technology, in the industry of busbar processing. Such software is easy to operate and can display the processed shapes of the copper bar in a visual and three dimensional manner. It is able to calculate the accurate positions of the punched, sheared, and embossed work pieces, and generate the machine code automatically, therefore shortening the time of manual programming and eliminating the potential errors occurred in manual programming. Such software can demonstrate the entire process of punching, shearing and bending, so as to prevent material waste arisen from the error in manual code entry.

② Main and auxiliary clamps:

For one clamping, the maximum stroke of X Axis is 2000mm, and both the main and auxiliary clamps will operate simultaneously, which will lower the quality requirements on the flatness and bending of the bus bar, thus improving the processing accuracy; during the processing, auto-clamping is obtained to save labor, and to improve the processing efficiency and accuracy.

③ Fast Hauling Belt:

After the processing, the work pieces will be hauled away with the stainless steel hauling belt, so as to improve the efficiency and to protect the work pieces from wearing.

④ Touch Screen:

Human-computer interface is easy to operate and reflects in real time the program execution. It has the function of displaying the alarm message of equipment operation, and allows the easy setting of die parameters and the operation of equipment.

⑤ High-Speed Operation System:

This machine uses high-precision ball screws and linear guides to ensure the high precision and efficiency. Components and elements of national and world famous brands can provide longer service life and guarantee the quality.

⑥ Die Kit:

It has multiple die kit (including dies for shearing, embossing and punching) and adopts integral shearing blade, which is able to cut the busbar at a time, thus improving the processing precision, the section perpendicularity and the processing efficiency; it has special embossing die for producing larger embossing area, thus improving the contact area of busbar and the processing efficiency; the dies are easy to dismantle and assemble, safe and reliable, and easy to replace, guaranteeing the improvement of productivity under circumstances of frequent replacement of dies. The used die satisfies the requirements on accuracy and performance with the punching time no more than 50000.

Main Technical Parameters:

Description		Unit	Parameter
Press Force	Punching Unit	kn	500
	Shearing unit	kn	500
	Embossing Unit	kn	500
X Max Speed		m/min	48
X Max Stroke		mm	2000
Y Max Stroke		mm	530
Z Max Stroke		mm	350
Stoke of Hit Cylinder		mm	45
Max Hit Speed		HPM	60
Tool Kit	Punching Mould	Set	5
	Shearing Mould	Set	1
	Embossing Mould	Set	1
Control Axis			3
Hole Pitch Accuracy	Mm/m		±0.20
Max Hole Punch Size		mm	Φ 32 (thickness of copper bar: < 12mm)
Max embossing area		mm ²	160*60
Max Busbar Size(L*W*H)		mm	6000*200*15
Total power		kw	15.7
Main Machine Size:(L*W)		mm	7500*2980
Machine Weight		kg	7600

New Fast CNC Busbar Punching and Shearing Machine GJCNC-BP-50A



Main Technical Parameters:

Description		Unit	Parameter
Press Force	Punching Unit	kn	500
	Shearing unit	kn	500
	Embossing Unit	kn	500
X Max Speed		m/min	48
X Max Stroke		mm	2000
Y Max Stroke		mm	530
Z Max Stroke		mm	350
Stoke of Hit Cylinder		mm	45
Max Hit Speed		HPM	100
Tool Kit	Punching Mould	Set	7
	Shearing Mould	Set	1
Control Axis			3
Hole Pitch Accuracy	Mm/m		±0.20
Max Hole Punch Size		mm	Φ 32 (thickness of copper bar: < 12mm)
Max Busbar Size(L*W*H)		mm	6000*200*15
Total power		kw	15.7
Main Machine Size:(L*W)		mm	7500*2980
Machine Weight		kg	7600

Main Functions and Features:

GJCNC-BP series CNC busbar punching & shearing machine is the computer-controlled equipment of high efficiency and high precision, specially used for busbar processing; Dies of punching, shearing and embossing are placed together in the storeroom of dies; It is capable of executing punching (round, oblong and other holes), embossing, shearing, slotting, round cornering and other processes; Automatic clamp switching can be achieved without manual intervention for longer busbars. Finished work pieces will be sent out through the conveyor. Such machine series can be used in combination with the CNC busbar bending machine to form an assembly line of busbar processing.

① GJ3D Programming Software:

The software kit of the equipment is the special CAD software (GJ3D) developed by our company, which can be used on line to realize the automation of programming. The software pioneers in applying three dimensional graphics, the state of the art technology, in the industry of busbar processing. Such software is easy to operate and can display the processed shapes of the copper bar in a visual and three dimensional manner. It is able to calculate the accurate positions of the punched, sheared, and embossed work pieces, and generate the machine code automatically, therefore shortening the time of manual programming and eliminating the potential errors occurred in manual programming. Such software can demonstrate the entire process of punching, shearing and bending, so as to prevent material waste arisen from the error in manual code entry.

② Main and auxiliary clamps:

For one clamping, the maximum stroke of X Axis is 2000mm, and both the main and auxiliary clamps will operate simultaneously, which will lower the quality requirements on the flatness and bending of the bus bar, thus improving the processing accuracy; during the processing, auto-clamping is obtained to save labor, and to improve the processing efficiency and accuracy.

③ Fast Hauling Belt:

After the processing, the work pieces will be hauled away with the stainless steel hauling belt, so as to improve the efficiency and to protect the work pieces from wearing.

④ Touch Screen:

Human-computer interface is easy to operate and reflects in real time the program execution. It has the function of displaying the alarm message of equipment operation, and allows the easy setting of die parameters and the operation of equipment.

⑤ High-Speed Operation System:

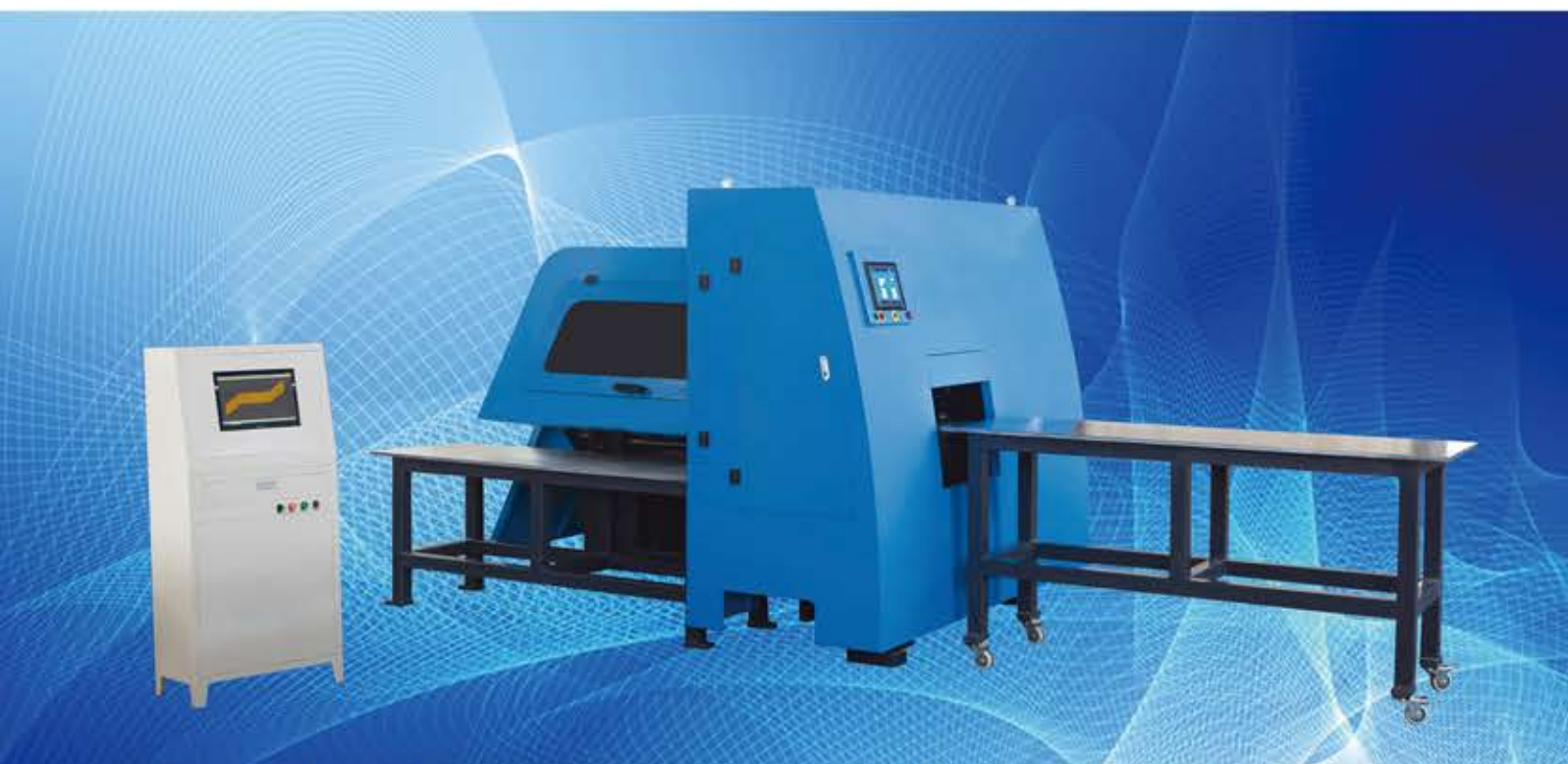
This machine uses high-precision ball screws and linear guides to ensure the high precision and efficiency. Components and elements of national and world famous brands can provide longer service life and guarantee the quality.

⑥ Die Kit:

It has multiple die kit (including dies for shearing, embossing and punching) and adopts integral shearing blade, which is able to cut the busbar at a time, thus improving the processing precision, the section perpendicularity and the processing efficiency; it has special embossing die for producing larger embossing area, thus improving the contact area of busbar and the processing efficiency; the dies are easy to dismantle and assemble, safe and reliable, and easy to replace, guaranteeing the improvement of productivity under circumstances of frequent replacement of dies. The used die satisfies the requirements on accuracy and performance with the punching time no more than 50000.



CNC Busbar Punch and Shear Machine Model GJCNC-BP-30



Main Functions and Features:

GJCNC-BP series CNC busbar punching & shearing machine is the computer-controlled equipment of high efficiency and high precision, specially used for busbar processing; Dies of punching, shearing are placed together in the storeroom of dies; It is capable of executing punching(round, oblong and other holes), shearing, slotting, round cornering and other processes; Automatic clamp switching can be achieved without manual intervention for longer busbars. Finished work pieces will be sent out through the conveyor. Such machine series can be used in combination with the CNC busbar bending machine to form an assembly line of busbar processing.

① 3D Drawing Software GJ3D:

The software kit of the equipment is the special CAD software (GJ3D) developed by our company, which can be used online to realize the automation of programming. The software pioneers in applying three dimensional graphics, the state of the art technology, in the industry of busbar processing. Such software is easy to operate, and can display the processed shapes of the copper bar in a visual and three dimensional manner. It is able to calculate the accurate positions of the punched, sheared, and embossed work pieces, and generate the machine code automatically, therefore shortening the time of manual programming and eliminating the potential errors occurred in manual programming. Such software can demonstrate the entire process of punching, shearing and bending, so as to prevent material waste arisen from the error in manual code entry.

② Main Clamp:

For one clamping, the maximum stroke of X Axis is 1000mm, during the processing, auto-clamping is obtained to save labor, and to improve the processing efficiency and accuracy.

③ Quick Side Unload Type:

Adopt side unload platform to discharge the finished piece by tilting the platform. Efficient and assure without abrasive wear to busbar surface.

④ Touch Screen:

Human-computer interface is easy to operate and reflects in real time the program execution. It has the function of displaying the alarm message of equipment operation, and allows the easy setting of die parameters and the operation of equipment.

⑤ High Speed Transmission System:

This machine uses high-precision ball screws and linear guides to ensure the high precision and efficiency. Components and elements of national and world famous brands can provide longer service life and guarantee the quality.

⑥ Tool Kit:

It has multiple Tool Kit (including dies for shearing, punching) and adopts integral shearing blade, which is able to cut the busbar at a time, thus improving the processing precision, the section perpendicularity and the processing efficiency, thus improving the contact area of busbar and the processing efficiency; the dies are easy to dismantle and assemble, safe and reliable, and easy to replace, guaranteeing the improvement of productivity under circumstances of frequent replacement of dies. The used die satisfies the requirements on accuracy and performance with the punching times no more than 50000.

Main Technical Parameters:

Description		Unit	Parameter
Press Force	Punch Unit	Kn	300
	Shear Unit	kn	300
X Max Speed		m/min	48
X Max Stroke		mm	1000
Y Max Stroke		mm	530
Z Max Stroke		mm	350
Stoke of Hit Cylinder		mm	45
Max Hit Speed		HPM	60
Tool Kit	Punch Mould	set	4
	Shear Mould	set	1
Control Axis			3
Hole Pitch Accuracy		mm/m	±0.20
Max Hole Punch Size		mm	Φ 32 (Press<300 KN)
Max Busbar Size(L*W*H)		mm	6000*125*12
Total Power		kw	15
Machine Size:(L*W)		mm	2000*1900
Machine Weight		kg	3200

CNC Busbar Processing Machine GJCNC-40



Main Technical Parameters:

Description	Unit	Parameter
Nominal force	kn	400
Bending accuracy	Degree	±0.3
Max bending stroke	mm	250
Stroke of side striker	mm	2000
Max motion speed of side striker (X axis)	m/min	15
Bending head(Y axis)	m/min	Fast:5; Low:1.25
Min inner width of U-shape bend	mm	40(Note:Plea se consult us for smaller dimensions)
Max bending angle	Degree	90
Level bending (W*H)	mm	200*15
Vertical bend (W*H)	mm	125*15
Total power	kw	7.2
Main machine dimension: L*W	mm	4150*1590
Total Weight	kg	2700

Main Functions and Features:

CNC Busbar Processing Machine is the computer-controlled equipment dedicated for busbar bending, performing various bending operations through the coordination of X-axis and Y-axis movements, assisted with manual feeding. The selection of different dies can complete the plane bending, side bending and other processes of busbar. The machine can be used in combination with GJ3D software, and is able to accurately calculate the spread length of the bend. As to the frequently bent workpiece, it can automatically find the bending order to achieve programming automation, simulate the bending order to place busbar and avoid errors in determining the bending positions.

① Closed-loop Bending Structure:

X and Y axes use a precision linear guide to ensure the fabricating accuracy and to avoid the drawbacks of open-loop bending, and to ensure the consistency of the machining angle in the width direction. During the vertical bending, the dies of this machine have automatic clamping and releasing functions, to ensure the machining plane flatness, and to reduce damages due to bending arc.

② GJ3D Programming Software:

The assistant software (GJ3D) specially used for busbar processing is adopted by networking with this machine to realize the automated programming. User can use this software to carry out operations conveniently and rapidly. This software can accurately calculate the punching position after the bending is spread, and automatically generate the machine code, thus saving the tedious manual programming of machine code. It can also demonstrate the whole process of busbar bending, which can effectively prevent from material waste caused by coding errors from manual entry. We are the first to apply 3D graphics to the busbar processing industry, making great contribution to the industry, and such technology ranks among the forefront in the world.

③ Touch Screen:

Human-computer interface is easy to operate and reflects in real time the program execution. It has the function of displaying the alarm message of equipment operation, and allows the easy setting of die parameters and the operation of equipment.

④ High-Speed Operation System:

This machine uses high-precision ball screws and linear guides to ensure high precision and high efficiency. Long operation life and Zero noise.



Hydraulic vertical bending die



Level bending die



Dent-free female die

Bus Arc Machining Center (Chamfering Machine) GJCNC-BMA



Main Functions and Features:

CNC bus chamfering machine mainly functions in milling fillet and big fillet in the busbar. It automatically generates the program code and transmits the code to the equipment basing on the requirements on the busbar specification and the data input onto the display screen. It is easy to operate and can machine useful busbar arc with nice looking.

- ◆ This machine is used to carry out sectional arc machining for busbar heads with the H53-15mm, W5140mm and L2280mm.
- ◆ The bar head will be machined to the shape with fixed structure.
- ◆ The clamps adopt automatic centering technology to press the pressing head better onto the force bearing point.
- ◆ A booster is used on the pressing head to secure the stability of workpiece, rendering a better machining surface effect.
- ◆ World standard BT40 tool holder is used for easy blade replacement, fine rigidity and high accuracy.
- ◆ This machine adopts high-precision ball screws and linear guides. Heavy-load large-size guide rails have been selected to offer better rigidity of the entire machine, lower the vibration and noise, improve the quality of workpiece and ensure high accuracy and efficiency.
- ◆ Using components of domestic and world famous brands, this machine is of long service life and can guarantee high quality.
- ◆ The program used in this machine is the embedded automatic graphics programming software developed by our company, realizing the automation in programming. The operator does not have to understand various codes, nor does he/she have to know how to operate the traditional machining center. The operator just has to enter several parameters by referring to the graphics, and the equipment will generate automatically the machine codes. It takes shorter time than manual programming and eliminates the potential of code error caused by manual programming.
- ◆ Busbar machined in this machine is of fine look, without point discharge, narrowing the cabinet size to save space and remarkably reducing the consumption of copper.



Main Technical Parameters:

Description		Unit	Parameter
Cutting sector	Speed of spindle	RPM/min	1000
	Motor power	KW	7.5
	Tool holder model		BT40
Number of die stations	X-axis stroke	mm	250
	Y-axis stroke	mm	350
	Servo power	kw	2*1.5
	Feeding Speed	Mm/min	1200
Tool parameter(diameter)		mm	100
Min allowable sheet length		mm	280
Max allowable sheet dimension(W*H)		mm	140*15
Min allowable sheet dimension(W*H)		mm	30*3
Air Source		MPa	0.5~0.9
Total power		kw	9.5
Main machine dimension: L*W		mm	2500*2000
Total weight		kg	2300

Multifunction Busbar Processing machine (Turret type) BM303-S-3-8P



Main Functions and Features:

The multifunction busbar processing machine is the patented product developed by our company. Comparing with the traditional busbar processing machine, this product has the following advantages and features:

- ◆ The punching unit adopts turret-type die kit, capable of storing eight punching dies or seven punching dies with one set embossing die.
 - ◆ The shearing unit adopts round integral structure, with novel and unique design rendering reasonable force bearing, and thus effectively guarantees the long-term use without deformation.
 - ◆ The bending unit uses integral structure and CNC angle control mode, allowing easy operation and high accuracy.
 - ◆ This machine adopts the design approach of double-layer work bench, truly realizing the simultaneous working of three stations without mutual interference.
- The machine is provided with an automatic oil charge and discharge system, easy to operate, with the hydraulic oil charged into the oil tank via a filter so as to protect the entire hydraulic system from contamination.
- ◆ This machine is provided with stainless steel oil tank to protect the hydraulic oil from corrosive deterioration and extend the service life of hydraulic oil and the seals.
 - ◆ PLC control that is stable and reliable.

Configuration of the machine:

Work Bench Dimension(mm)	Machine Weight(kg)	Number of Motors	Total Motor Power(kw)	Working Voltage(v)	Number of Hydraulic Units(MPa)	Control Mode
Layer I :1500*1200	1460	3+1	11.37	380	3*31.5	PLC+CNC angle bending
Layer II : 840*370						

Main technical parameters:

Description	Material	Machining W *H(mm)	Max Punched Hole	Max Output Force(kn)
Punching unit	Copper/Aluminum	H:15	Φ 32 (H≤10mm) Φ 25 (H≤15mm)	350
Shearing uni	Copper/Aluminum	Punching and shearing:12*160 Simple shearing: 15*160		350
Bending unit	Copper/Aluminum	Level bending:15*160 Vertical bending:12*120		350



Multifunction Busbar Processing Machine BM303-S-3



Main Functions and Features:

The multifunction busbar processing machine is the patented product developed by our company. Comparing with the traditional busbar processing machine, this product has the

following advantages and features:

- ◆ The punching and shearing units adopt round integral structure, with novel and unique design rendering reasonable force bearing, and thus effectively guarantees the long-term use without deformation.
- ◆ The bending unit uses integral structure and CNC angle control mode, allowing easy operation and high accuracy.
- ◆ This machine adopts the design approach of double-layer work bench, truly realizing the simultaneous working of three stations without mutual interference.
- ◆ The machine is provided with an automatic oil charge and discharge system, easy to operate, with the hydraulic oil charged into the oil tank via a filter so as to protect the entire hydraulic system from contamination.
- ◆ This machine is provided with stainless steel oil tank to protect the hydraulic oil from corrosive deterioration, and extend the service life of hydraulic oil and the seals, PLC control that is stable and reliable.
- ◆ Swappable dies offering extreme convenience.
- ◆ PLC control that is stable and reliable.

Configuration of the machine:

Work Bench Dimension(mm)	Machine Weight(kg)	Number of Motors	Total Motor Power(kw)	Working Voltage(v)	Number of Hydraulic Units(MPa)	Control Mode
Layer I :1500*1200	1280	3+1	11.37	380	3*31.5	PLC+CNC angle bending
Layer II : 840*370						

Main technical parameters:

Description	Material	Machining W*H(mm)	Max Punched Hole	Max Output Force(kn)
Punching unit	Copper/Aluminum	H:15	Φ 32 (H≤10mm) Φ 25 (H≤15mm)	350
Shearing unit	Copper/Aluminum	Punching and shearing:12*160 Simple shearing:15*160		350
Bending unit	Copper/Aluminum	Level bending:15*160 Vertical bending :12*120		350

Multifunction Busbar Processing Machine (For Large Busbar) BM603-S-3(16*260)



Main Functions and Features:

The multifunction busbar processing machine is the patented product developed by our company. Comparing with the traditional busbar processing machine, this product has

the following advantages and features:

- ◆ The punching and shearing units adopt column structure, with novel and unique design rendering reasonable force bearing, and thus effectively guarantee the long-term use without deformation.
- ◆ The bending unit uses integral structure and CNC angle control mode, allowing easy operation and high accuracy.
- ◆ Comparing with common busbar processing machine, this machine is of stronger capability in busbar processing, which is able to perform the punching, shearing, bending, etc. of busbar with special width and height.
- ◆ This machine adopts the design approach of double-layer work bench, truly realizing the simultaneous working of three stations without mutual interference.
- ◆ The machine is provided with an automatic oil charge and discharge system, easy to operate, with the hydraulic oil charged into the oil tank via a filter so as to protect the entire hydraulic system from contamination.
- ◆ This machine is provided with stainless steel oil tank to protect the hydraulic oil from corrosive deterioration, and extend the service life of hydraulic oil and the seals.
- ◆ Swappable dies offering extreme convenience.
- ◆ PLC control that is stable and reliable.

Configuration of the machine:

Work Bench Dimension(mm)	Machine Weight(kg)	Number of Motors	Total Motor Power(kw)	Working Voltage(v)	Number of Hydraulic Units(MPa)	Control Mode
Layer I :1500*1500	1800	3+1	11.37	380	3*31.5	PLC+CNC angle bending
Layer II : 840*370						

Main technical parameters:

Description	Material	Machining W*H(mm)	Max Punched Hole	Max Output Force(kn)
Punching unit	Copper/Aluminum	16*260	Φ 32	600
Shearing unit	Copper/Aluminum	Punching and shearing:16*260 Simple shearing:16*260		600
Bending unit	Copper/Aluminum	Level bending:16*260 Vertical bending :12*120		350

Multifunction Busbar Processing Machine BM603-S-3 (for Copper Rod/Tube)



Main Functions and Features:

The multifunction busbar processing machine is the patented product developed by our company. Comparing with the traditional busbar processing machine, this product has the following advantages and features:

- ◆ The punching unit adopts column structure, with novel and unique design rendering reasonable force bearing, and thus effectively guarantees the long-term use without deformation;
- ◆ The shearing unit adopts round integral structure, with novel and unique design rendering reasonable force bearing, and thus effectively guarantees the long-term use without deformation;
- ◆ The bending unit uses integral structure and CNC angle control mode, allowing easy operation and high accuracy;
- ◆ This machine adopts the design approach of double-layer work bench, truly realizing the simultaneous working of three stations without mutual interference;
- ◆ The machine is provided with an automatic oil charge and discharge system, easy to operate, with the hydraulic oil charged into the oil tank via a filter so as to protect the entire hydraulic system from contamination;
- ◆ This machine is provided with stainless steel oil tank to protect the hydraulic oil from corrosive deterioration, and extend the service life of hydraulic oil and the seals;
- ◆ Swappable dies offering extreme convenience;
- ◆ PLC control that is stable and reliable.

Configuration of the machine:

Work Bench Dimension(mm)	Machine Weight(kg)	Number of Motors	Total Motor Power(kw)	Working Voltage(v)	Number of Hydraulic Units(MPa)	Control Mode
Layer I :1500*1200	1500	3+1	11.37	380	3*31.5	PLC+CNC angle bending
Layer II : 840*370						

Main technical parameters:

Description	Material	Machining W*H(mm)	Max Punched Hole	Max Output Force(kn)
Punching unit	Copper/Aluminum	16*160	Φ 32	600
Shearing unit	Copper/Aluminum	Punching and shearing:12*160 Simple shearing:15*160		350
Bending unit	Copper/Aluminum	Level bending:15*160 Vertical bending :12*120		350

Portable Busbar Machine GJS-200



Main Functions and Features:

- ◆ This machine is the light of foreign advanced products, combined with the actual situation in china, in order to improve work efficiency, to save hours of work, while the design and manufacture.
- ◆ Suitable for transmission and distribution in a large workshop and site work construction, and power distribution cabinets and switch cabinets, etc.
- ◆ The use of electrical appliances factory.
- ◆ The machine is equipped with: bending, cutting, punching function.
- ◆ Optional foot switch or wire switch, easy to operate.

Main Technical Parameters:

Portable Busbar Machine GJS-200	
Functions	With Three Functions, Cutting, Punching and Bending.
Input Voltage/Control Voltage	Single Phase 50Hz, 220V
Rating Working Oil Pressure	700kgf/cm ² (Over Pressure Safety Valve Setting Value)
Outlet Force of Bus Bar Cutter	20ton
Bus Bar Cutting Capability	(Copper Bus Bar/Aluminum Bus Bar)200mm*12mm
Outlet Force of Puncher	35ton
The Distance Between Hole Center And Bus Bar Edge	110mm
Punching Capability-Copper Bus Bar /Aluminum Bus Bar	Φ 6 - Φ 20.5 Max Thickness:12mm
Standard Assembled Punching Dies	Φ 10.5, Φ 13.8, Φ 17.5, Φ 20.5mm
Outlet Force of Bender	20ton
Horizontal Bending Capability	200mm*12mm
Weight	230kg
Dimension of Moveable Workbench	70cm(L)*70cm(W)*82cm(H)
Machine Dimension	1050mm(L)*750mm(W)*1300(H)

Tool List for Multifunction BM Series

Multifunction Busbar Processing machine

Bending unit

Shearing unit

Punching unit

Bending unit

Level and vertical bending, elbow bending, cable lug molding, copper bar bending, etc. can be achieved by altering the dies.



Die of double-head level bending



Die of vertical bending



Die of Cable lug molding



Die of copper bar folding

Shearing unit

The adoption of punching and shearing approach guarantees the sectional perpendicularity, producing deformation-free workpiece with polished and nice-looking end face. Simple shearing is applied to get rid of material waste, thus saving the raw materials.



Simple shearing unit



Single shear



Punching and shearing unit



Punching shear

Punching unit

Such processes as punching hole, oblong hole, square hole and double-holes, knurling, pressing cooper bar, shearing cooper bar can be completed by changing dies.



Punching die (round/column structure)



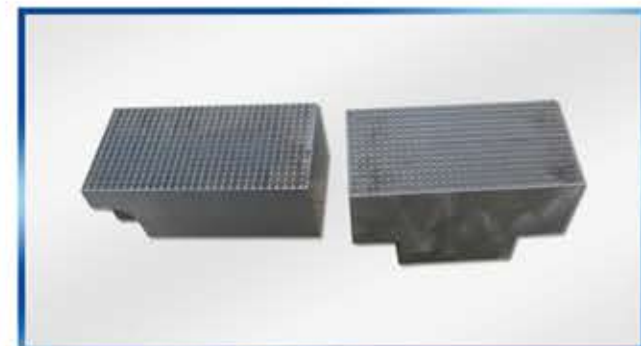
Embossing die (round/ column structure)



Die of shearing copper bar



Punching die (turret structure)



Embossing die (turret structure)



Die of pressing copper bar