



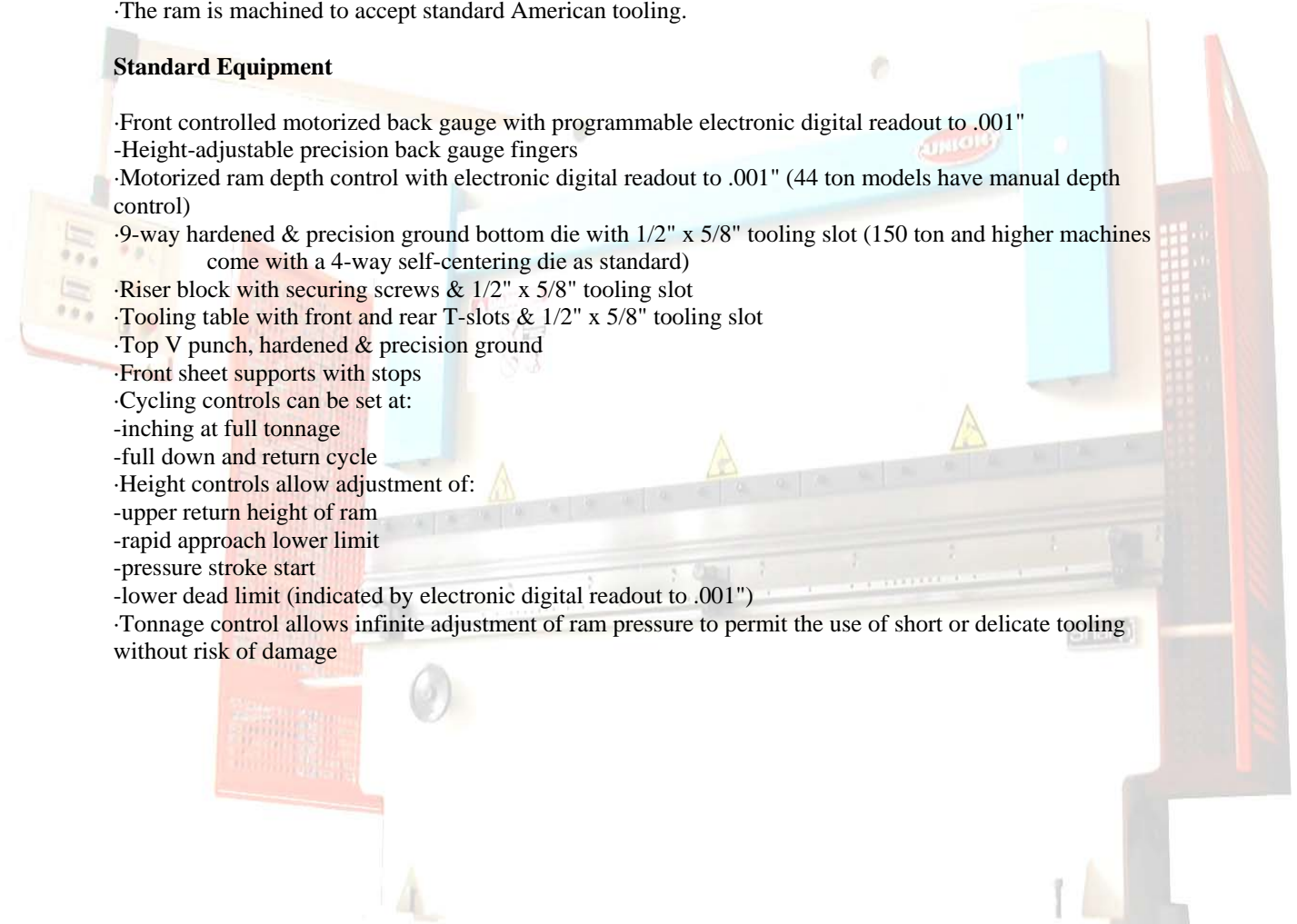
UNION D-SERIES Hydraulic Press Brakes

Standard Features

- Absolutely accurate bends - from end to end - every time
- Two direct down stroke cylinders complete each stroke at internal precision stops which assures depth repeatability to within .0005" - end to end - every time.
- No need to constantly adjust "ram tilt". No need to "bottom" every bend to assure accuracy.
- DRO monitored motorized ram depth control allows effortless and absolutely parallel bend changes.
- Adjustable tonnage control at the control panel allows the use of short or delicate tooling without risk of damage. Single or multiple unit punches can be used in conjunction with forming or shearing die sets.
- Pre-crowned bed table to counteract deflection
- Generous throat depth to 16" with double thickness side frame at gap
- Hydraulics are quiet, efficient and compact. They are located up and out of harm's way between the side frames. No extra floor space is needed as is the case for side mounted hydraulics.
- The ram is machined to accept standard American tooling.

Standard Equipment

- Front controlled motorized back gauge with programmable electronic digital readout to .001"
- Height-adjustable precision back gauge fingers
- Motorized ram depth control with electronic digital readout to .001" (44 ton models have manual depth control)
- 9-way hardened & precision ground bottom die with 1/2" x 5/8" tooling slot (150 ton and higher machines come with a 4-way self-centering die as standard)
- Riser block with securing screws & 1/2" x 5/8" tooling slot
- Tooling table with front and rear T-slots & 1/2" x 5/8" tooling slot
- Top V punch, hardened & precision ground
- Front sheet supports with stops
- Cycling controls can be set at:
 - inching at full tonnage
 - full down and return cycle
- Height controls allow adjustment of:
 - upper return height of ram
 - rapid approach lower limit
 - pressure stroke start
 - lower dead limit (indicated by electronic digital readout to .001")
- Tonnage control allows infinite adjustment of ram pressure to permit the use of short or delicate tooling without risk of damage





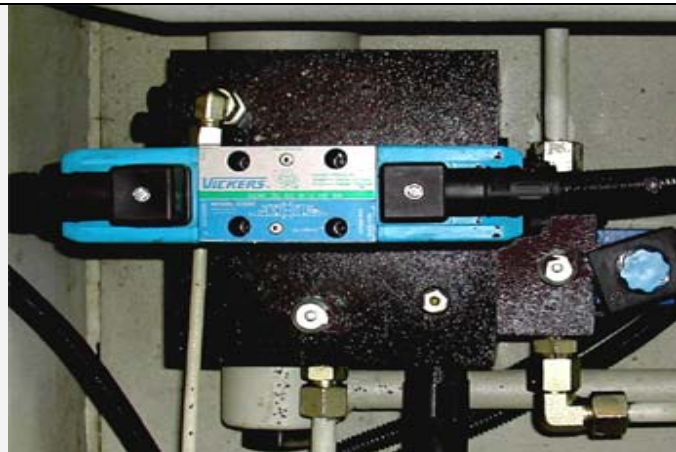
The UNION press brake's mechanical stops provide optimum repeatability and accuracy.



Simple and intuitive pendant-mounted controls reduce training time and enhance operator efficiency.



NACHI/VICKERS pumps



VICKERS/REXROTH valving

All components are recognized and available worldwide with North American representation, service, and replacement stock. All controls are low, isolation-transformed 24 Volts for safety.



BUSS/OMRON/TELEMECANIQUE electrics



SIKO Gmbh encoders and programmable displays



Simple foot pedal allows remote control of bending depth and is equipped with emergency stop.



Ram open height and height at which fast ram approach changes to slow pressing speed are easily adjustable.



Height-adjustable back gauge fingers are clamped to a heavy wall ribbed aluminum fence.



Deep throat areas are reinforced by double thickness side frames to prevent distortion.



North American style tooling, slotted riser block and wide bottom table allow for a wide range of tooling set-ups.



Electrically interlocked, hinged guarding prevents entry into dangerous locations during bending.

Model -->	44/49	44/78	44/98	77/98	77/120	110/98
Pressure (tons)	44	44	44	77	77	110
Table Length	49"	78"	98"	98"	120"	98"
Table Width	5 1/2"	5 1/2"	5 1/2"	5 1/2"	5 1/2"	7"
Uprights Dist.	35"	65"	81"	81"	100"	81"
Throat Depth/*	8"/12"	8"/12"	8"/12"	8"/12"	8"/12"	8"/12"
Stroke Adj.	3 1/8"	3 1/8"	3 1/8"	3 1/8"	3 1/8"	4 3/8"
Stroke Length	4"	4"	4"	4"	4"	5 1/8"
Approach Speed	4"/sec	4"/sec	4"/sec	4"/sec	4"/sec	4"/sec
Press Speed	1/2"/sec	1/2"/sec	1/2"/sec	1/3"/sec	1/3"/sec	1/3"/sec
Return Speed	4"/sec	4"/sec	4"/sec	3"/sec	3"/sec	3"/sec
Open Height	12"	12"	12"	12"	12"	12"
Motor	4HP	4HP	4HP	5 1/2HP	5 1/2HP	7 1/2HP
Weight (lbs)	4800	6000	7300	10600	11300	13300
Length	61"	85"	105"	105"	124"	104"
Width	42"	44"	44"	46"	47"	51"
Height	85"	78"	78"	84"	84"	88"
Backgauge Dist.	15 3/4"	15 3/4"	15 3/4"	24"	24"	24"
Hyd. Oil (Gal)	17	17	17	25	25	30
Model -->	110/120	110/157	150/120	150/157	182/120	182/157
Pressure (tons)	110	110	150	150	182	182
Table Length	120"	157"	120"	157"	120"	157"
Table Width	7"	7"	7"	7"	7"	7"
Uprights Dist.	100"	124"	100"	124"	100"	124"
Throat Depth/*	8"/12"	8"/12"	8"/12"	8"/12"	9 7/8"/12"	9 7/8"/12"
Stroke Adj.	4 3/8"	4 3/8"	4 3/8"	4 3/8"	4 3/4"	4 3/4"
Stroke Length	5 1/8"	5 1/8"	5 1/8"	5 1/8"	6"	6"
Approach Speed	4"/sec	4"/sec	4"/sec	4"/sec	4"/sec	4"/sec
Press Speed	1/3"/sec	1/3"/sec	1/3"/sec	1/3"/sec	1/3"/sec	1/3"/sec
Return Speed	3"/sec	3"/sec	3"/sec	3"/sec	3"/sec	3"/sec
Open Height	12 1/4"	12 1/4"	12 1/4"	12 1/4"	13 3/4"	13 3/4"
Motor	7 1/2HP	7 1/2HP	10HP	10HP	15HP	15HP
Weight (lbs)	14500	19800	15700	21500	20500	25600
Length	125"	160"	124"	160"	124"	160"
Width	51"	52"	55"	56"	61"	61"
Height	96"	96"	98"	98"	102"	102"
Backgauge Dist.	24"	24"	24"	24"	24"	24"
Hyd. Oil (Gal)	30	30	30	30	37	37