# **ACCURPRESS HT**

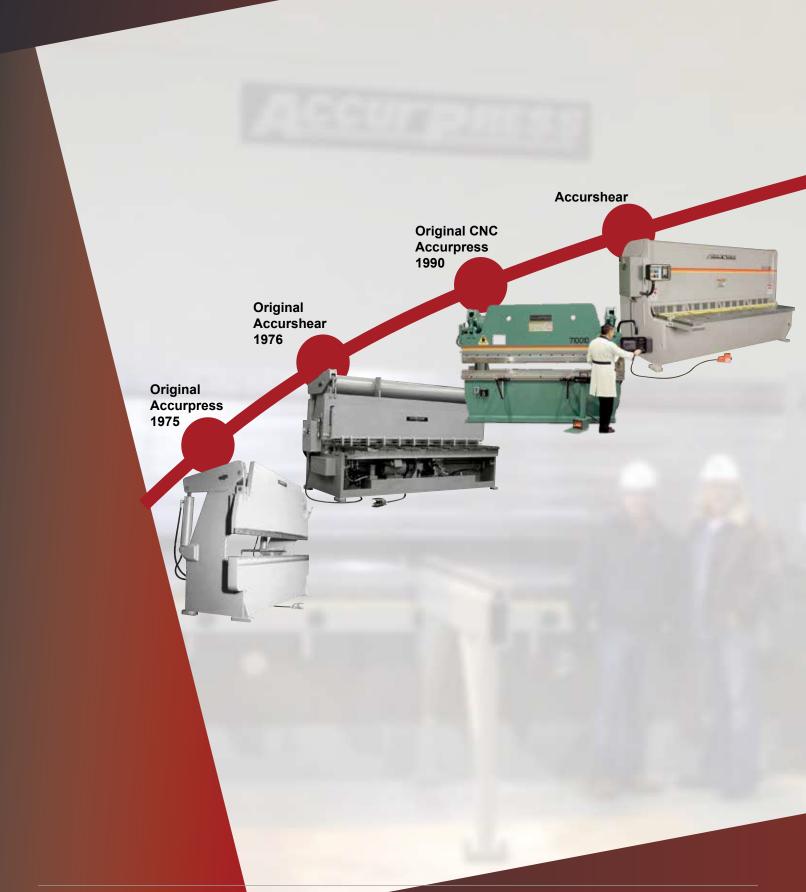
## HIGH TONNAGE MACHINES AND SPECIAL MODELS

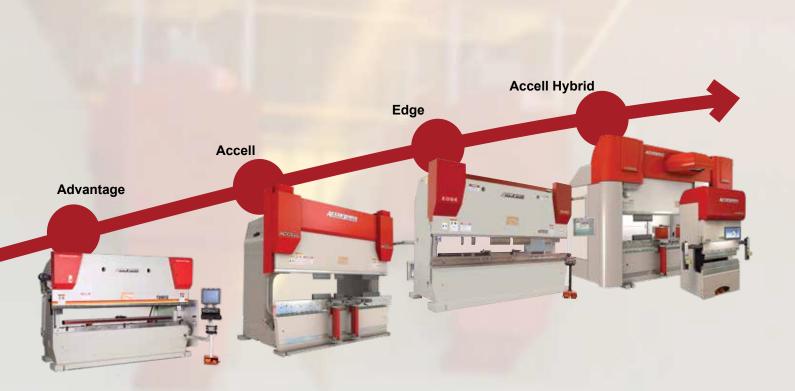




www.accurpress.com







## **ABOUT US**

With over 40 years in the marketplace, Accurpress continues to build on its tested history to manufacture an innovative and complete line of press brakes and shears for every bending and shearing application. Proudly North American made, Accurpress leads the way with high tonnage machines, revolutionary pole bending technologies, tandem machines, and robot automation. With over 19,000 machines sold to thousands of satisfied customers, Accurpress continues to build press brakes and shears to meet the demands of today's manufacturing environments.

## Steve Hilton President

"While 40 years has brought huge changes to the machine tool industry, all of us at Accurpress continue to stand firm on the original foundation of quality that the company was built on. Every Accurpress machine, including the one you'll buy, is made with 100% of our best efforts. Our business depends on it and so does yours."



## THE ACCURPRESS ROCKER HT LINEUP

From 600-2100 Tons

## HIGH TONNAGE MODELS



The Accurpress Rocker design stretches back to the 1970's and has stood the test of time in a multitude of heavy fabrication shops while offering long term dependability and forming accuracies.

Accurpress offers very high concentrated load ratings on custom machines such as this 2100 ton capacity machine below.

1500 TON CAPACITY

To satisfy the endless variation of bending requirements, we offer a wide selection of heavy-duty optional accessories such as Titan Gauging, Sheet Follower Systems and massive Upper and Lower Dies to provide the optimum solutions for the biggest forming jobs.

2100 TON CAPACITY



## THE ACCURPRESS ACCELL HT LINEUP From 650-3000 Tons



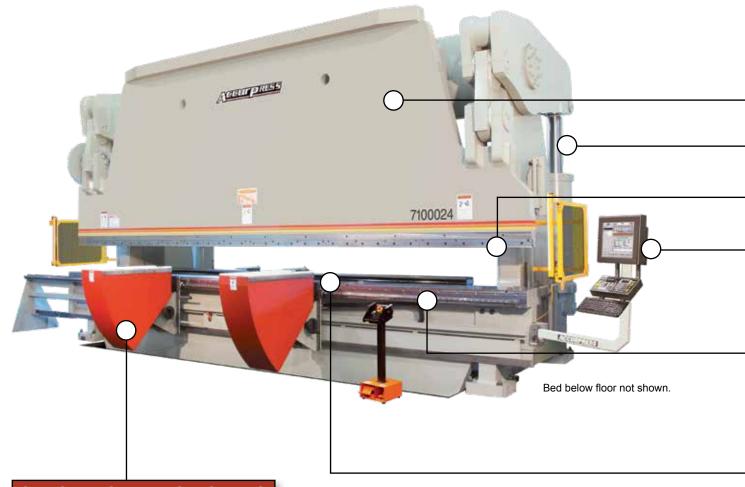
Accurpress Precision Forming Systems



## ACCURPRESS ROCKER II LINEUP 600 - 2100 Ton Models

The Accurpress Rocker-HT has an exceptional track record which is a testament to the reliability of the Rocker design over many decades of operation!

## FEATURING:



### **OPTIONAL SHEET FOLLOWERS**

The Accurpress Sheet Following System incorporates a movable table that lifts and supports material during the bending motion. It is fully synchronized with the ram bend speed and desired angle and can support a load capacity of 500lbs per Sheet Follower. Descent speed and activation of the Sheet Following System are fully programmable by the operator.



### **MACHINE DESIGN**

The engineering design of the Accurpress Rocker is built with cylinders mounted at the back of side frames and attached to a pair of heavy-duty rocker arms, and has proven itself in thousands of fabrication shops throughout North America since the mid 1970's. Constructed with quality components from leading suppliers throughout the world, including maintenance free, self-aligning spherical bearings suited for high tonnage loads and oscillating motion—has all resulted in a press brake built for the long haul.

### RAM TOOL CLAMPING SYSTEMS

The Press Brake Ram is manufactured with Hardened Clamp Bars to withstand the vigorous demands of heavy plate forming. Optional Hydraulic Clamping Systems are also offered to provide maximum efficiency specific to the required application.

### **CUSTOM BUILT**

Accurpress builds Press Brakes to meet and satisfy the strict demands of special forming jobs. We offer customized Ram/Bed Horn Extensions, Increased Ram Open Heights, Structural Modifications and a wide selection of optional accessories.

### ETS3000 CONTROL

The Accurpress Rocker-HT models operate via the robust ETS3000 control, developed and supported by Accurpress.

## SPECIALIZED TOOLING OPTIONS

The Ram is manufactured with Hardened Clamps or can be machined to accept optional Hydraulic Clamping Systems.

### TITAN BACKGAUGE

The Titan is the world's strongest backgauge! It has been designed by Accurpress to withstand the highest shock loads from heavy material like no other gauge can do. Offering up to 6 Axis in X1/X2, R1/R2, Z1/Z2.

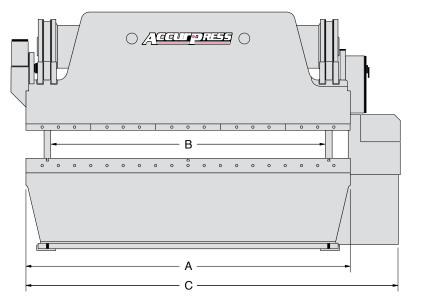


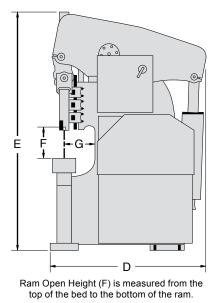
CYCLES PER

## ACCURPRESS ROCKER HT SPECIFICATIONS

																	, CYCLE			
		A	В				C	D	E		F		G				2.5" Fast A	Approach		
			DISTANCE			BED DEPTH		ROX. OVEF		LENGTH	RAM	RAM	TUDOAT		DX. SPE ES/MINU		0.5" Slov 3.0" Fast		ADDDOV	APPROX.
MODEL		LENGTH OF BED	BETWEEN FRAMES	BED HEIGHT	BED CAP WIDTH	BELOW FLOOR	LENGTH	DEPTH	HEIGHT	OF RAM STROKE	OPEN HEIGHT	CLOSED HEIGHT	THROAT DEPTH	FAST	SLOW	FAST	3.0 Fasi		APPROX. MOTOR	Shipping Weight
NUMBER	TONS	(INCHES)	(INCHES)	(INCHES)	(INCHES)	(INCHES)	(INCHES)	(INCHES)	(INCHES)	(INCHES)	(INCHES)	(INCHES)	(INCHES)	APPROACH	BEND	RETURN	STANDARD	HI-SPEED	HP	(LB)
760014	600	168	132	38	12	_	202	80	126	12	20	8	12	50	14	80	8	11.5	50	67,000
760016	600	192	156	36	12		226	80	130	12	20	8	12	50	14	80	8	11.5	50	71,000
760020	600	240	198	36	12	50	274	80	140	12	20	8	12	50	14	80	8	11.5	50	90,000
760024	600	288	246	36	12	55	322	80	154	12	20	8	12	50	14	80	8	11.5	50	99,000
775014	750	168	126	36	12		202	82	130	12	20		12	50	14	80		11.5	60	73,000
775016	750	192	150	36	12	46	226	82	131	12	20		12	50	14	80		11.5	60	79,000
775020	750	240	198	36	12	56	274	82	141	12	20		12	50	14	80		11.5	60	104,000
775024	750	288	246	36	12	66	322	82	154	12	20		12	50	14	80		11.5	60	114,000
7100014	1000	168	126	38	12	40	202	82	150	14	22	8	14	40		65		7.5	60	94,000
7100016	1000	192	150	38	12	50	226	106	158	14	22	8	14	40		65		7.5	60	112,000
7100020	1000	240	198	38	12	60	274	106	164	14	22	8	14	40		65		7.5	60	124,000
7100024	1000	288	246	38	12	72	322	106	170	14	22	8	14	40		60		7.5	60	140,000
7125014	1250	168	126	38	12	50	202	114	168	14	22		14			60	4.5	6.5	75	120,000
7125016	1250	192	150	38	12	60	226	114	174	14	22		14			60	4.5	6.5	75	140,000
7125020	1250	240	198	38	12	72	274	114	180	14	22		14			60	4.5	6.5	75	170,000
7125024	1250	288	246	38	12	80	322	114	188	14	22		14			60	4.5	6.5	75	180,000
7150014	1500	168	126	38	12	72	202	120	178	14	22	8	14	37		58	4.5	6.5	75	140,000
7150016	1500	192	150	38	12	82	226	120	184	14	22	8	14	37		58	4.5	6.5	75	160,000
7150020	1500	240	198	38	12	80	274	120	185	14	22	8	14	37		58	4.5	6.5	75	200,000
7150024	1500	288	246	38	12	88	322	120	190	14	22	8	14	37		58	4.5	6.5	75	230,000
7210013		156	124				174	156	184	14	26	12	22						75	175,000
7210016	2100	192	150				226	156		14	26	12	22						75	200,000
7210020	2100	240	198				274	156		14	26	12	22						75	240,000
7210024	2100	288	246	*	*	*	322	156	*	14	26	12	22	*	*	*	*	*	75	280,000

SPECIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE. CONSULT FACTORY FOR SPECIFICATIONS FOR MACHINES OVER 1500 TONS. \* DIMENSIONS & SPECIFICATIONS AVAILABLE UPON REQUEST

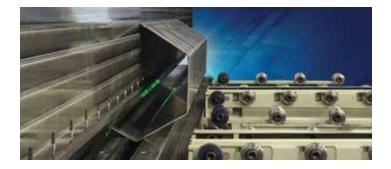








Bed below floor not shown.



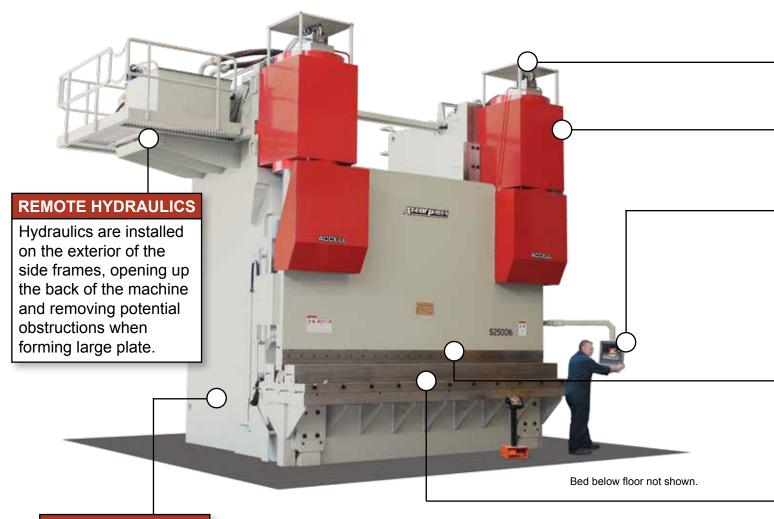
The Accurpress Rocker-HT has found its way into a multitude of shops doing a wide variation of forming jobs, such as this 750-ton X 24-foot machine built with a massive open/closed height configuration utilized in the forming of poles. Specialized tooling was produced by Accurpress along with the heavy duty Frontgauge System to automate the process.



## ACCURPRESS ACCELL HT LINEUP 650 - 3000 Ton Models

The standard features of the Accell-HT combine technology and efficient material handling options to make big jobs easier to accomplish. All aspects of our High Tonnage machines are designed to be reliable, flexible and perform in the most demanding conditions.

## **FEATURING:**



#### TITAN BACKGAUGE

The Titan is the world's strongest backgauge! It has been designed by Accurpress to withstand the highest shock loads from heavy material like no other gauge can do. Offering up to 6 Axis in X1/X2, R1/R2, Z1/Z2 for Accell-HT models.



#### MACHINE DESIGN

The Accurpress Accell-HT is engineered with the most advanced Y1/Y2 proportional hydraulic technologies to ensure positional accuracies of +/-0.0004, all monitored via a Safety PLC.

#### **CUSTOM BUILT**

Special applications for forming large plate sections may require excessive Ram Stroke and Open Height configurations. The Accell-HT line comes standard with generous Stroke and Ram Heights as well as the flexibility for increased optional length and height requirements. Accurpress will engineer the Accell-HT with structural modifications to support massive tooling applications and/or additional requirements to ensure all factors are addressed in order to provide the best possible press brake solution for special jobs.

### **VISION CONTROL**

The powerful and advanced Vision Control is a standard feature with the Accell-HT models. Numerous features including automatic bend sequencing, tool selection, teach crowning features, 3D offline packages and ease of programming for custom tools provides for the most streamlined part processing software in the industry.

#### **RAM TOOL CLAMPING SYSTEMS**

The Press Brake Ram is manufactured with Hardened Clamp Bars to withstand the vigorous demands of heavy plate forming. Optional Hydraulic Clamping Systems are also offered to provide maximum efficiency as each application and required tooling selections will determine.

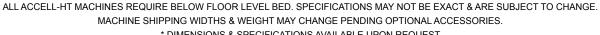
#### SPECIALIZED TOOLING OPTIONS

Accurpress offers an endless selection of Adjustable Channel-lock Tooling options in any and all required die openings, as well as specialized massive Customized Tooling Systems to satisfy the most complicated bending requirements.

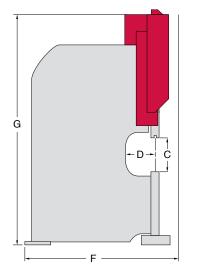


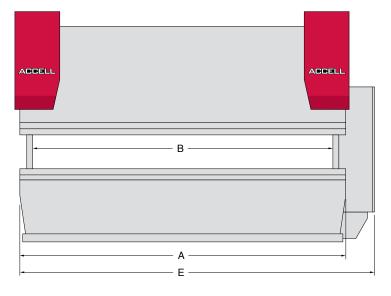
## ACCURPRESS ACCELL HT SPECIFICATIONS

MODEL NUMBER	TONS	A LENGTH OF BED (INCHES)	B DISTANCE BETWEEN FRAMES (INCHES)	BED HEIGHT (Inches)	TOP BED WIDTH (Inches)	C LENGTH OF RAM STROKE (INCHES)	RAM OPEN HEIGHT (Inches)	RAM CLOSED HEIGHT (Inches)	D THROAT DEPTH (INCHES)	E OVER LENGTH (INCHES)	F ALL DIMENS DEPTH (Inches)	G HEIGHT (INCHES)	AP APPROACH SPEED (In/min)	PROX. SPE BEND SPEED (In/MIN)	EDS RETURN SPEED (IN/MIN)	APPROX. SHIPPING WEIGHT (LB)
565016	650	192	168	38	12	14	24	10	20	216	100	154	260	24	200	82,500
565020	650	240	216	38	12	14	24	10	20	264	100	154	260	24	200	110,000
565024	650	288	264	38	12	14	24	10	20	312	100	154	260	24	200	132,000
585016	850	192	164	38	12	14	24	10	20	216	104	164	240	20	160	101,000
585020	850	240	212	38	12	14	24	10	20	264	104	164	240	20	160	121,000
585024	850	288	260	38	12	14	24	10	20	312	104	164	240	20	160	138,000
5100016	1000	192	164	38	12	14	24	10	20	216	108	174	160	20	120	120,000
5100020	1000	240	212	38	12	14	24	10	20	264	108	174	160	20	120	132,000
5100024	1000	288	260	38	12	14	24	10	20	312	108	174	160	20	120	143,000
5125016	1250	192	153	38	12	18	28	10	20	216	114	178	100	12	100	128,000
5125020	1250	240	201	38	12	18	28	10	20	264	114	178	100	12	100	146,000
5125024	1250	288	249	38	12	18	28	10	20	312	114	178	100	12	100	164,000
5125030	1250	360	321	38	12	18	28	10	20	384	114	178	100	12	100	240,000
5150016	1500	192	150	38	12	18	28	10	20	216	120	182	100	12	100	135,000
5150020	1500	240	198	38	12	18	28	10	20	264	120	182	100	12	100	160,000
5150024	1500	288	244	38	12	18	28	10	20	312	120	182	100	12	100	185,000
5150030	1500	360	318	38	12	18	28	10	20	384	120	182	100	12	100	260,000
5200016	2000	192	146	38		24	34	10	22	216	126		90	10	90	175,000
5200020	2000	240	194	38		24	34	10	22	264	126		90	10	90	200,000
5200024	2000	288	242	38		24	34	10	22	312	126		90	10	90	235,000
5200030	2000	360	314	38		24	34	10	22	384	126		90	10	90	308,000
5250024	2500	288	236	38		24	34	10	22							310,000
5250030	2500	360	308	38		24	34	10	22							390,000
5300024	3000	288	230	38		24	34	10	22							390,000
5300030	3000	360	302	38		24	34	10	22							450,000



\* DIMENSIONS & SPECIFICATIONS AVAILABLE UPON REQUEST







Accurpress has the experience and reputation of building hundreds of High Tonnage machines, located all across North America.



Accurpress Tandem 1500 ton by 30 ft press brakes forming 60 ft custom poles.

## No job is too big for Accurpress!



## **VISION CONTROL**

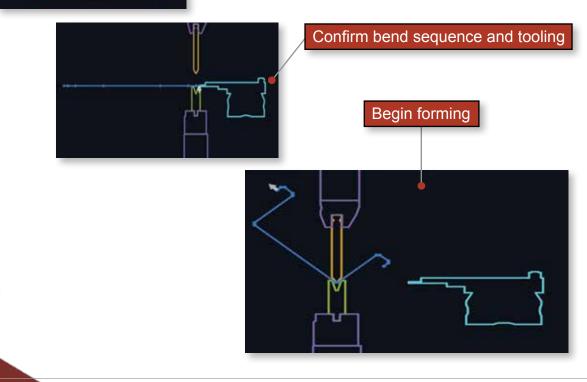
The Vision Control is a ground-breaking and revolutionary press brake control software system. Vision streamlines and simplifies the bending process, giving you full control over every aspect of metal forming.

## FEATURES:

- Touch screen control
- Automatic bend sequencing
- Automatic tool selection
- Quick tooling change
- Complete control over all axis
- Simple bump bending
- Special bend support such as offset, hemming and pre-bends
- Easily program custom tools
- Teach crowning features

Sketch part profile using touchscreen

Easily add dimensions and angles





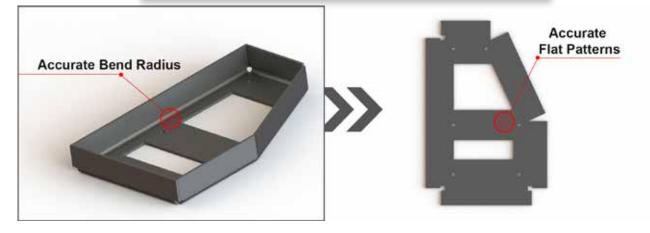




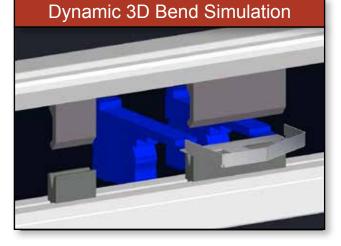
Working with Solidworks or Inventor, Vision 3D lets you import part models into Vision for full 3D programming, bend visualization and dynamic viewing during the forming process.

## FEATURES:

## **USE VISION RIGHT IN YOUR PART MODELS**



## Use Vision 3D for ETS3000







## **GAUGING OPTIONS**



## **SUPREME BACKGAUGE**

For applications demanding the most complex sheet metal parts and in high productions shops, Accurpress offers the Supreme backgauge available for the Accell-U models. Constructed from a one-piece rugged steel platform that is isolated from the press brake ram movements, the Supreme backgauge is built for optimum accuracy, high speeds on all six axis (X1/X2, R1/R2, Z1/Z2) and for years of minimal service requirements. Included with the Supreme backgauge is a rear gate attached to the back of the Accell-U inclusive of a safety interlock switch to meet all applicable safety standards.

Position

Repeatability

Holding Force

+/- 0.005"

1.000 lbs

+/- 0.001"

+/-0.002'

To ensure compliance to applicable safety standards, Accurpress installs rear guarding inclusive of a gate with a safety interlock switch on all Accurpress models sold with the Supreme Backgauge.



1 1	TII TII	TAN SPE	CIFICAT	IONS
A A		X1/X2 Axis	R1/R2 Axis	Z1/Z2 Axis
Note: The Titan Backgauge is available	Axis Travel	39" 990.6 mm	12" 304.8 mm	Distance between side frames minus 52"
for larger Accell E and U models. Please reference the Accell HT Brochure.	Positioning Speed	500 ipm	500 ipm	500 ipm
	Position Repeatability	+/- 0.001"	+/- 0.001"	+/- 0.002"
	Holding Force	5,000 lbs		

## TITAN BACKGAUGE

The Titan 6-Axis (X1/X2, R1/R2, Z1/Z2) is the world's heaviest and strongest gauge built specifically for Accurpress HT models that are fabricating the most extreme parts! Each and every component including the oversized fingers have been engineered to withstand the most extreme conditions, shock loads and massive forces from placement of large plates in preparation for final gauging and forming. Each X-Axis is capable of 65,000 lbs of static and 20,000 lbs of dynamic load capacity. This rugged backgauge features servo-drive motors, lifetime lubricated precision linear bearings and an unsurpassed ability to handle the heaviest of structural plate applications.

To ensure compliance to applicable safety standards, Accurpress installs rear guarding inclusive of a gate with a safety interlock switch on all Accurpress models sold with the Titan Backgauge.



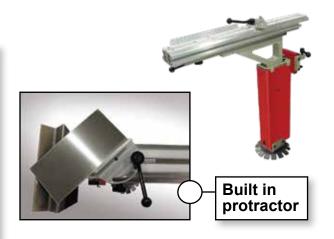
## SUPPORT FIXTURES + SHEET FOLLOWERS

## FRONT SUPPORT ARMS

The Accurpress Front Support Arms (36" support length) are fully adjustable for different tooling heights and thicknesses. The bottom Foot Disk allows the operator to easily adjust the height of the Support Arm while the top support piece can be adjusted front to back depending on the desired position. These support arms are mounted on a linear rail for smooth and accurate positing left to right on the press brake.

## SHEET FOLLOWERS

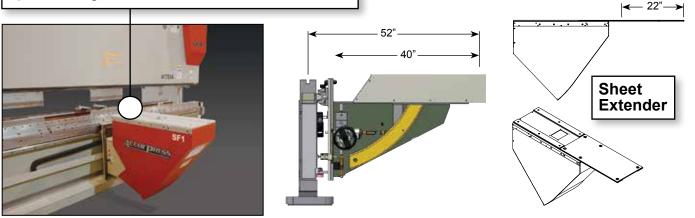
Accurpress offers two Sheet Follower capacities to provide the most efficient and cost-effective options for a variety of applications in the fabrication industry. The Sheet Following System is inclusive of moveable support table(s) that rotate during the bending motion, synchronized with the ram speed and desired angle. The standard design allows for a load capacity of 500lbs per each support table. The Follower(s) are integrated to the Accurpress ETS3000 or Vision Control allowing the machine operator programming options for optimal usage.



### SHEET FOLLOWER PARKING STATION

Sheet Followers can be moved off to the side when not in use, providing full access of the front of the machine.







## TITAN FOLLOWERS

High tonnage applications will necessitate press brake optional accessories to complement the vigorous demands placed on the equipment. Accurpress has the solutions! The Titan Follower System is manufactured to withstand massive forces in heavy plate fabrication environments. Each table can support a load capacity of 1500lbs synchronized with the ram bend speed and desired angle.



## **IMPRESSIVE FEATURES**

- Titan Follower(s) may be purchased as a single or dual units
- Titan Follower(s) are fully synchronized with the ram bending speed and bend angles
- Titan Follower(s) are compatible with either the Accurpress ETS3000 or Vision controls
- Load capacity = 1500 lbs. for each table
- Table size: 36-inches wide X 42-inches length
- Table(s) Height (R-axis): 6 inches of travel is manually adjusted or optional CNC is available
- Table(s) Forward-Reverse (X-axis): 7 inches of travel is manually adjusted or optional CNC is available
- Table(s) Left-Right (Z-axis) positioning is accomplished manually by sliding the units on the custom rail on the front of the Accurpress bed

Important: The Accurpress machine configurations including tooling specifics must be confirmed to assure conformity of the Sheet Follower functionality!



## **TOOLING OPTIONS**

Accurpress manufactures an endless variety of tooling that is specifically tailored to meet any and all press brake forming jobs. We will work with you to provide the best solution every time!

## ADJUSTABLE POWER LOCK DIES

The Accurpress Channel-lock Adjustable Power Lock Die offers the most efficient time-saving V-opening positions for large tooling worldwide. It eliminates the enormous amounts of wasted time wrestling large pieces of tooling on/off a press brake. The Accurpress HT models are customized with widened bed caps to facilitate the size of Adjustable Tooling ordered. The units are available in a variety of options and sizes from manual crowning and V-Die openings to full CNC V-Die openings and Power Lock/Unlock.

#### AUTOMATIC V-OPENING ADJUSTMENT

The hydraulic system provides lift to accommodate quick and easy die opening adjustments.

### CNC FUNCTIONALITY

Adjust V-openings in just seconds via the Vision or ETS3000 Control.





#### SPECIAL TOOLING... ALL SIZES AND CONFIGURATIONS

Accurpress Tooling Specialists will define and recommend the best possible solutions for special applications. The Adjustable Die pictured here was manufactured for a High Tonnage Accurpress offering flexibility to open up to 30-inches for heavy plate forming between the side frames of the press brake, and reduced openings for the two ends.

#### REPLACEABLE HARDENED INSERTS

The hardened inserts provide extra heavy load capacities and longer tool life. The inserts can be replaced when needed, preserving the unit from excessive wear.

### **OPTIONAL PLATE ROLLERS**

The addition of optional plate rollers along the full length of the die allows for easier positioning of the plate and prevents marks in the finished product.

#### FORM 90 DEGREES ON ALL V-OPENINGS

Clearance exists in all V-openings to produce 90 degree bends. Larger profiles can be made allowing for openings beyond 14". Special requests can be accommodated.

#### **OPTIONAL CROWNING CAPABILITY**

Optimal forming quality and huge time saving measures are available through the optional CNC or Manual Crowning feature.



## **OPTIONS TO SUIT ALL FORMING JOBS**



Increased Rap Open Heights and Stroke Lengths may be necessary to accommodate special bending applications. The Accurpress Accell-HT model can be customized with increased RAM Stroke/Open Height configurations to meet any and all necessary requirements for forming and plate removal. Unlike the Accell-HT, the Rocker-HT is not offered with additional Stroke Lengths, but may be ordered with additional Ram Open/Closed Heights.



Hydraulic Ram Clamping Systems are available for the Accurpress HT models to provide ease when installing and removing heavy tooling. In order to accommodate the heaviest tonnage and load capabilities, Accurpress offers the Wila Heavy Duty System, built to withstand the vigorous demands of bending large plates. A tooling station attached to the machine is also available as an added benefit to facilitate storage along with a time-saving and organized method of removing and attaching the desired punches or dies.



### **ROBOTICS INTEGRATION**

Accurpress offers robotics press brake solutions for automated bending. Robotized bending combines the Accell press brake with experienced partners in robotics and offline software.





### TANDEM MODE

The Accell-HT Models can be installed in Tandem, where two or more machines operate as one. During operation, the machine controls are electronically connected to exchange information for fully synchronized forming. This flexible package offered by Accurpress provides the press brake operator with the luxury of choosing single machine operation or tandem via a simple selector switch.

### **INCREASED THROAT DEPTH**

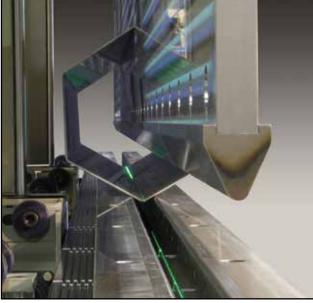
The Accell-HT can be customized to have additional throat depth clearance to facilitate parts with deeper flange lengths.





## **POLE BENDING MACHINES**





Accurpress has the solutions to meet the unique demands of Pole Bending applications. We will work with you to identify and detail the many requirements, including the machine build, that are essential to ensure the correct configuration for accurately bent poles.

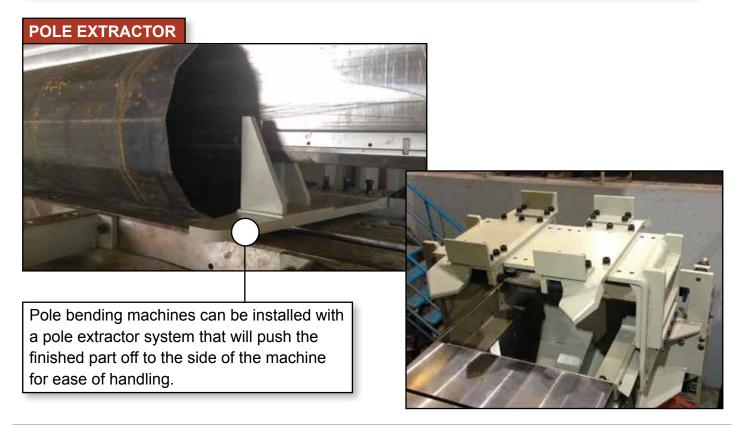


## POLE GAUGING

Accurpress' Pole Gauging system allows for material to be placed on the machine without the need for custom jigs or time consuming part alignment procedures.



- The risers will move forward and sense the material position and orientation.
- Plate position and shape are quickly determined. The gauging system will automatically move the part into position for the first bend.
- Tapered parts and offset gauging are not a problem with this one-of-a-kind gauging system.





## SAFETY GUARDING SYSTEMS

### LAZERSAFE SENTINEL



Lazersafe Sentinel is a Safety System offered on the Accurpress HT models that incorporates a continuous dual beam laser field protection zone directly below the punch tip. The Accurpress will immediately stop if any obstruction is detected when the ram is in motion. This system is most efficient up to 32' ram/bed lengths.

## **FIESSLER AKAS 3F**



The Fiessler Laser Guarding System protects the operator from the pinch point hazard of closing tooling. The Fiessler system transmits 3 lasers across the tooling area and monitors any interference as the parts are formed. In the event of an unplanned obstruction in the laser area, the ram is immediately stopped, thereby protecting the operator.

## LAZERSAFE SENTINEL PLUS

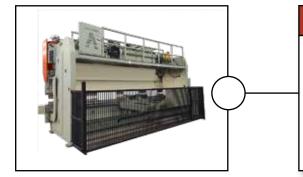


The Lazersafe Plus includes a dual beam system with a camera as a receiver that recognizes and monitors the silhouette of the punch. The Plus has the added benefit of allowing the ram to operate in fast speeds closer to the pinch point. This system is most efficient up to 18' ram/ bed lengths. A Sentinel Plus HL system is available for Accurpress models 20' and longer in length.

## LIGHT CURTAIN GUARDING



Some applications may be best suited to a Light Curtain Guarding System. Accurpress will work with you to recommend a safety system that will provide a secure working environment.



## **REAR GUARDING**

This is a standard feature for all Accurpress HT models that have an Elite or Titan Backgauge. A metal fixture with a gate and a safety interlock switch is installed and safely blocks operator access to the backgauge area. If the operator needs to access the back of the machine, the interlock switch on the gate will prevent the machine from turning on when the door is opened.





Contact your local Accurpress Dealership to discuss any length and tonnage press brake requirements. No job is too big for Accurpress!



For more information, please visit www.accurpress.com