

Broad specifications
CNC PRESS BRAKE Machine

1. Machine Overview

A 800T capacity high-precision **CNC Hydraulic Down Stroke Press Brake** machine with filled oil, bending tools, voltage stabilizer, CNC controller cooler, hydraulic oil chiller unit and material handling system is required for the high precision bending of all types of steel plates.

2. Technical Requirements

S. N.	Parameter	Requirement	Remarks
I.	Machine Type	CNC Hydraulic Press Brake	Vendor to comply
II.	Machine Capacity	800 Ton (minimum)	Vendor to comply
III.	Bending Length	5000 mm (minimum)	Vendor to comply
IV.	Material	MS, SS, carbon steel, alloy steel, copper	Vendor to comply
V.	Plate Thickness	5mm, 6mm, 8mm, 10mm, 12mm, 16mm, 20mm and 25mm.	Vendor to comply
VI.	Operation Type	CNC controlled preferred	Vendor to specify
VII.	CNC Crowning	system for uniform bending accuracy	Vendor to comply
VIII.	Accuracy	High precision, repeatability required	Vendor to comply
IX.	Frame Type	Heavy-duty welded steel construction (if any other please specify)	Vendor to specify
X.	Back Gauge System	back gauge designed for high repeatability	Vendor to comply
XI.	Tooling System	Dies suitable for bending of 5mm to 25mm plate thicknesses	Vendor to comply

3. General Table

Machine shall do bending for different thicknesses as tabulated below.

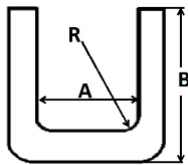
Thick (mm)	5	6	8	10	12	16	20	25
Max Bending Length (mm)	5000	5000	5000	5000	5000	5000	*	*

* what can be bent on the 800T capacity machine

- i. Material Grade - E350
- ii. Tensile Strength - 490Mpa to 630MPa

4. Typical job requirements (this is only typical job requirement & dimensions can vary as per design and job requirement)

Machine shall be able to bend the jobs in U-shape as tabulated below.



Thick	(A)	(B)	Radius	Bending Length
8 TK	426	220	23	4541
8 TK	390	230	23	4547
10 TK	330	100	23	1503
25 TK	305	295	50	2300
25 TK	285	283	50	1440
25 TK	310	268	50	2680
25 TK	285	295	50	3000

All dimensions are in mm

5. PRE-QUALIFICATION REQUIREMENTS (PQR)

8.1 Only those Makes & Brands which have supplied at least one number CNC Hydraulic press brake machine of capacity 500 Ton (Min.) or more in the past 7 years from the date of tender opening should apply. The following information is also to be submitted by all the bidders for qualification of their offer (BHEL may verify the supply and satisfactory performance / submitted credentials).

8.2 PO copy or Invoice copy or Any one of the following documents:

- i. Airway bill or
- ii. Bill of Lading or
- iii. LR document or
- iv. Delivery challan or
- v. E-way bill or
- vi. Customer certificate for receipt of material or
- vii. Goods Receipt Note