

APHS - HYBRID

www.boykal.com.tr



Think Big, We Do.

PRESS BRAKE
technology



Boykal

“ THINK BIG, WE DO. ”

**READY 4.0
CHANGE**

Baykal

APHSH 31200
HYBRID





From Past to *Future*

With a foundation history going back to early 1950s, Baykal today is placed as a leading manufacturer and global supplier of sheet metal working machinery specialising in the production of press brakes, shears, notchers, punching machines, laser cutting systems, plasma cutting machines and Vertical Machining Center.

For its manufacturing operations Baykal utilises three factories which together combine a production area of 60,000 square meters, making it one of Europe's largest facility for sheet metal working and fabricating machinery. The total workforce at Baykal is currently numbered at 650 employees and is composed of highly trained and qualified machine operators and assembly technicians supported by a staff of 50 engineers. All the machines offered by Baykal are designed, manufactured, assembled and finished at Baykal's purpose-built plants in a CAD environment with extensive use of CNC machining and modern workshop equipment.

Baykal Company is accredited for the ISO 9001 Certification issued by the German TÜV institution. Also, since 1995, Baykal has been building machines in conformity with the European CE regulations for safety, being the first Turkish machine-tool manufacturer certified eligible to bear the CE Mark on its products. In addition, all Baykal products are manufactured with the TSE and TSEK quality certificates issued by the Turkish Standards Institution.

Since the last 40 years Baykal has progressed to become a major exporter of sheet metal working machines to the world markets with customers located in all the machine-tool consuming countries of the global geography from Americas to Australia. Baykal is currently represented in over 100 countries worldwide through appointed dealers. In the base market of Turkey, Baykal sheet metal working machines have traditionally commanded a leading market share thanks to the company's pioneering role in the development of Turkey's machine industry and its never-lessening emphasis on quality and service. Here, with a long engineering experience behind, Baykal wishes to present itself as a quality-conscious, professional machine-building company serving the industry.

APHS - HYBRID

01

ACCURATE

Because each side of the Hybrid press brake is independently operated by its own hydraulic system, It is an on demand direct drive system. It's very fast, accurate and repeatable.

02

AFFORDABLE

While still not the least expensive option, the Hybrid brake technology allows for a more efficient hydraulic system design.

03

FLEXIBLE

Large Range of Tonnages available.





04

GREEN

Up to a 60% energy savings while in standby and a 45% savings during forming with a likely total of 60% savings over one hour with 15 press cycles. That's a very big deal when you are looking at saving energy and operating costs.

05

QUIET

When it's in standby mode (all axis not moving), the hydraulics are not running.

06

SAFE

Most hybrid machines are incorporating a great deal of safety into their designs including lasers and other features to improve operator safety.

Servo electric technology: innovation first

Over the years, manufacturers have been developing different solutions to improve the performance of their products. Through tools, functionalities and technological innovations sheet metal press brakes have evolved starting from mechanical presses to hybrid cnc press brakes. Hybrid is a new developed technology which use hydraulics but instead without proportional valve. Hybrid Brakes are becoming more prevalent and more widely available. With a servo-hydraulic drive, when you turn the pump on each cylinder in one direction, you are pumping the ram down, when the cnc control unit sets the pump in the other direction, you are pumping the ram back up. By controlling the speed of the servo, you can also control the ram speed.

Benefits of this technology include substantial power saving as you don't have a conventional AC motor running all or most the time. The servos only activate as required. You also get incredibly fast response time and minimal piping as it does away with a central tank and proportional valves. You can expect higher speeds for both high-speed approach and high-speed return, around 200mm/sec. Hybrid press brakes use hydraulics in small tanks to assist with bending process and servo motors to control the flow to the cylinders. Small oil tanks translate into many advantages, such as:



User Friendly

Easy to install, use and maintain



Modular

Capable of meeting any production need, with a variety of possible configurations



Energy Efficient

Less energy required and lower environmental impact



Productive

High productivity due to reduced cycle times and higher process reliability



Flexible

Suitable for a wide range of different products

Headlines to enhance Your **Worklife**

Significantly low oil consumption compared to the hydraulic press brakes.

- **More savings**
- **Less environmental impact**
- **Less maintenance costs**
- **A quicker production**



The Hydraulic system are directly connected to two small oil tanks. The advantage is that the cnc press brake is more precise and is not affected by temperature variation, as opposed to traditional machines.

The advantage of the hybrid machine is to run the hydraulics with servo motors only during bending and go off during standby which brings about half as much electrical energy. Hybrid system allows the machine to consume energy only when the pedal is activated. This means that the consumption of the press brake is minimum when tools are changed and, in general, during those steps in which the crosspiece is not involved.

There is a mix of electric and hydraulic systems that allow the machine to be much more responsive while maintaining a higher degree of accuracy than a traditional hydraulic press brake system. Reducing cycle times by 30% or more while maintaining a high degree of accuracy these systems.

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Industry 4.0
READY



GREEN

60 % less energy and oil consumption in average compared to the Standard Hydraulic Press Brakes.



AUTOMATION

Ready for robotic applications.



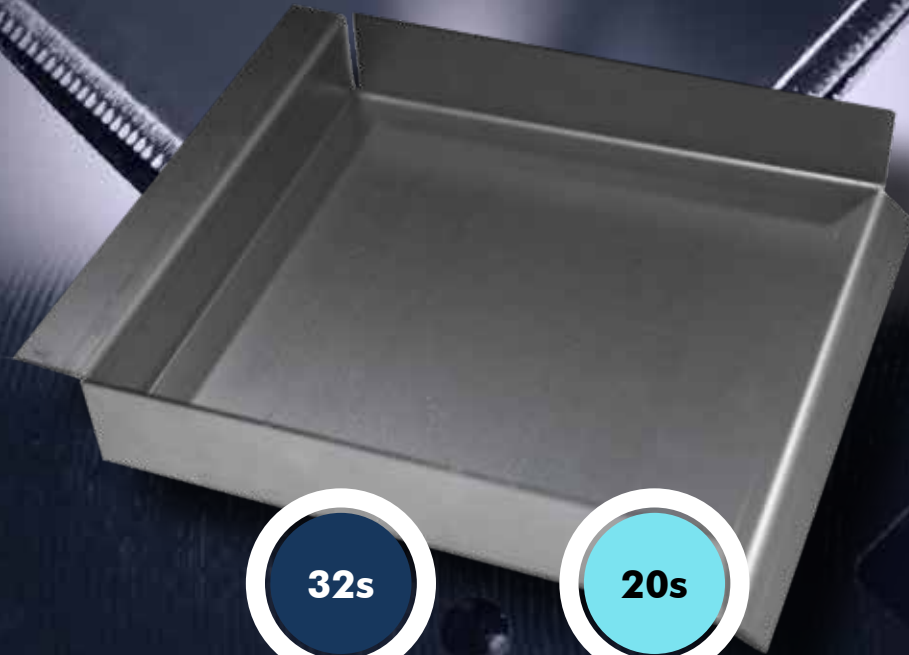
EFFICIENCY

Compared with standard hydraulic press brakes, Hybrids can easily reach 200 mm/s movement speeds. (For 240-300 tons higher speeds are available with H+Package)

High reliability and Maximum Productivity



**Time Cycle
Comparison**



32s

100t Conventional
Press Brake
110 mm/s

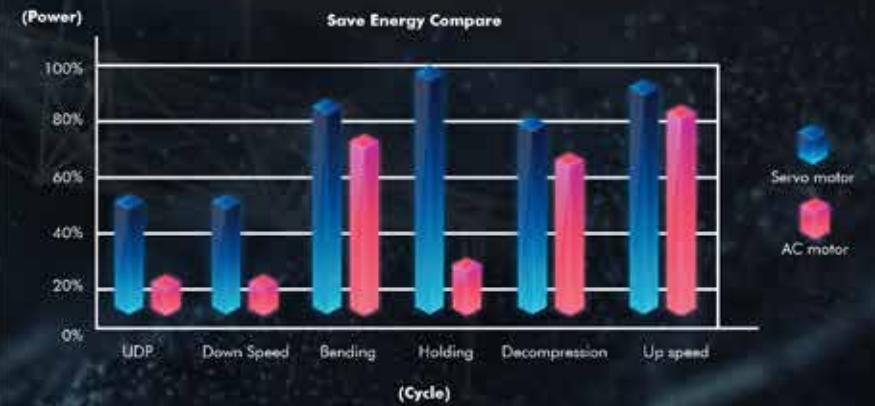
20s

100t APHS-Hybrid
200 mm/s



MOTORIZED GUARD SYSTEM

Easily openable door with remote control.



ENERGY SAVE

To reduce electrical consumption and heat, the pump motor is active only when the machine is working.



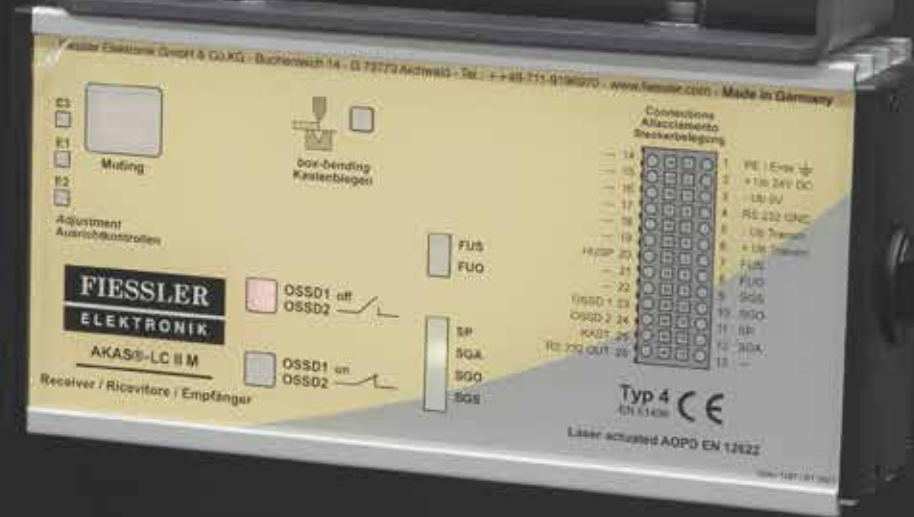
INNOVATIVE

Lead to Lean Manufacturing and Ready for Industry 4.0

Baykal

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HYBRID





INTEGRATED SAFETY

Front and Rear Safeguarding systems allow safe operation.

Important Steps for Perfect Bending.



ACCURATE

Because of the servo drives, the movement of the brakes is considerably faster in all directions when compared to conventional press brakes, the result of that is increased productivity while maintaining perfect accuracy and repeatability in all directions.



QUIET

With 63 dB of sound level, .As servo motor and pump assembled inside the tank with compact design of hydraulic system, 13% more silent work achieved.



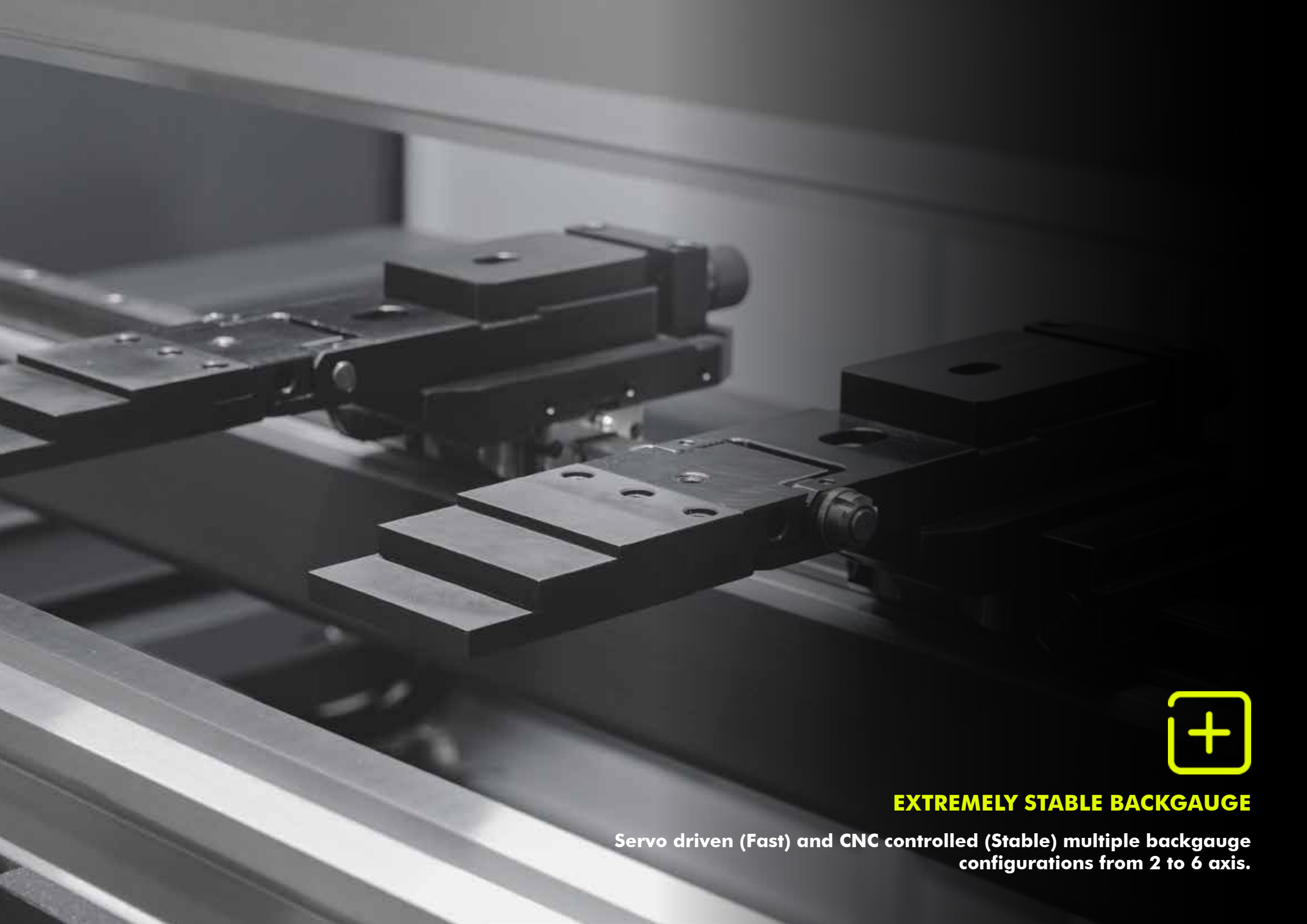
REPEATABILITY WITH SERVO MOTOR SYSTEM

With servo motor and compact hydraulic system,
precision and repeatability achieved as 0.01.



MOVEABLE AND ADJUSTABLE SUPPORT ARMS

A Range of Support Arms for Light- and Heavy-Duty- Sheet Metal-Work



EXTREMELY STABLE BACKGAUGE

Servo driven (Fast) and CNC controlled (Stable) multiple backgauge configurations from 2 to 6 axis.



ERGONOMICS

Full Control of Operations with one finger.



FRIENDLY CONTROLLER

Hybrid press brakes with height adjustable control arm system; operator comfort and easy to use the control unit achieved.

TECHNICAL DATA

Baykal	APHS-HYBRID									
No		31120	31160	31200	31240	31300	41160	41200	41240	41300
Bending Length	mm	3100	3100	3100	3100	3100	4100	4100	4100	4100
Bending Force	Tons	120	160	200	240	300	160	200	200	300
Oil Capacity	lt	2x34.5	2x55	2x55	2x55	2x55	2x55	2x55	2x55	2x55
Rated Power	kW	2x6	2x9.2	2x9.2	2x9.2	2x9.2	2x9.2	2x9.2	2x9.2	2x9.2
Daylight opening	mm	540	540	530	530	660	530	530	530	635
Stroke	mm	260	260	260	260	320	260	260	260	320
Throat Gap	mm	410	410	410	410	500	410	410	410	500
Approach	mm/s	200	200	200	160/200*	140/200*	200	200	160/200*	140/200*
Working	mm/s	10	10	10	8/10*	7/10*	10	10	8/10*	7/10*
Return	mm/s	200	200	200	160/200*	140/200*	200	200	160/200*	140/200*
X axis Range	mm	750	750	750	750	750	750	750	750	750
X axis Speed	mm/s	350	350	350	350	350	350	350	350	350
X axis Precision		0,03	0,03	0,03	0,03	0,03	0,03	0,03	0,03	0,03
R axis Range	mm	160	160	160	160	160	160	160	160	160
R axis Speed	mm/s	240	240	240	240	240	240	240	240	240
R axis Precision		0,05	0,05	0,05	0,05	0,05	0,05	0,05	0,05	0,05

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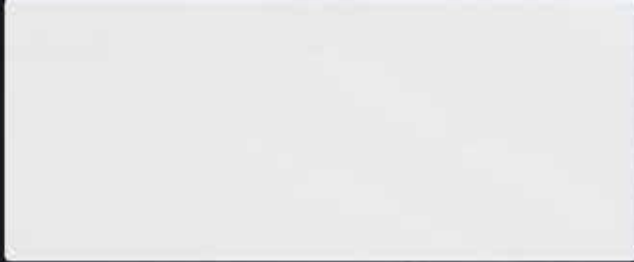
Higher Speeds are available with **H+Package**

Machine built with CE-safety conformity are available as option.

Design and specifications are subject to change without notice.

Legal Notice:





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