



RSM Machinery Co.,Ltd

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Technical agreement

Hydraulic (HP) Press Brake

Model:HP-130/3200



Date: March 18, 2024

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QUOTATION

Quote No.: BJ2024262

Date: March 18, 2024

Buyer: Bonanza Industrial

No.	Model	Description of Goods	Unit price (USD)	Qty	Amount (USD)	Note
1	HP-1332	CNC HYBRID PRESS BRAKE 4+1 axis	\$40,653	1 set	\$40,653	4+1 axis: Y1、 Y2、 X、 R、 W CYBELEC 12 system Hydraulic drive system Fast clamping+1 set tool Power supply: 230V/3 Phase/60HZ

Noted: If LCL, need wooden packing. The wooden packing fee is \$500.

Terms and trade condition (General)

- 1. Place of Loading:** The seller's factory, CHINA.
- 2. Delivery time:** within 35 working days after receipt the 30% down payment.
- 3. Warranty period:** For Whole machine, its warranty is within 1 year under right operation.
Whole Machine enjoys service after sales for whole using life.
- 4. Note:** If steel raw material raised largely, then machine's price will update accordingly.
- 5. Payment terms:** T/T, with 30% down payment in advance, 70% balance payment before shipment.
- 6. Validity date:** One month.

1、 Machine model and main technical parameters:

1.1 Machine model: HP-130/3200 Y1、 Y2、 X、 R、 W (4+1 axis)

Standard CYBELEC CT12 system

1.2 Main technical parameters

HP		130/3200
Force (kN)		1300
Max. bending Length (mm)		3200
Distance between uprights (mm)		2700
Opening height (mm)		500
Throat depth (mm)		400
Cylinder stroke (mm)		225
Main power (kw)		10.5
Oil(L)		200
Upper beam Speed (mm/s))	Approaching speed	200
	Working speed	0-15
	Returning speed	160
Back gauge speed X axis	Stroke (mm)	600
	Max. speed (mm/s)	450
Back gauge speed R axis	Stroke (mm)	200
	Max. speed (mm/s)	75
Machine Dimensions (mm)	Length	3710
	Width	1670
	Height	2720
Weight (kg)		9000

Remark: Y1, Y2 axis-controls the upper beam moving upward and downward

X axis-controls the back gauge moving forward and backward

R axis-controls the back gauge moving upward and downward

W axis-Lower mechanical crowning

1.3 Main precision level:

Upper beam positioning accuracy Y1、Y2 ± 0.02 mm

Upper beam repeated positioning accuracy Y1、Y2 ± 0.01 mm

Back gauge X repeated positioning accuracy $\leq \pm 0.01$ mm

Back gauge R repeated positioning accuracy $\leq \pm 0.02$ mm

Work piece angle tolerances $\pm 25'$ /Whole length

Work piece straightness tolerances: 0.25mm/1000mm

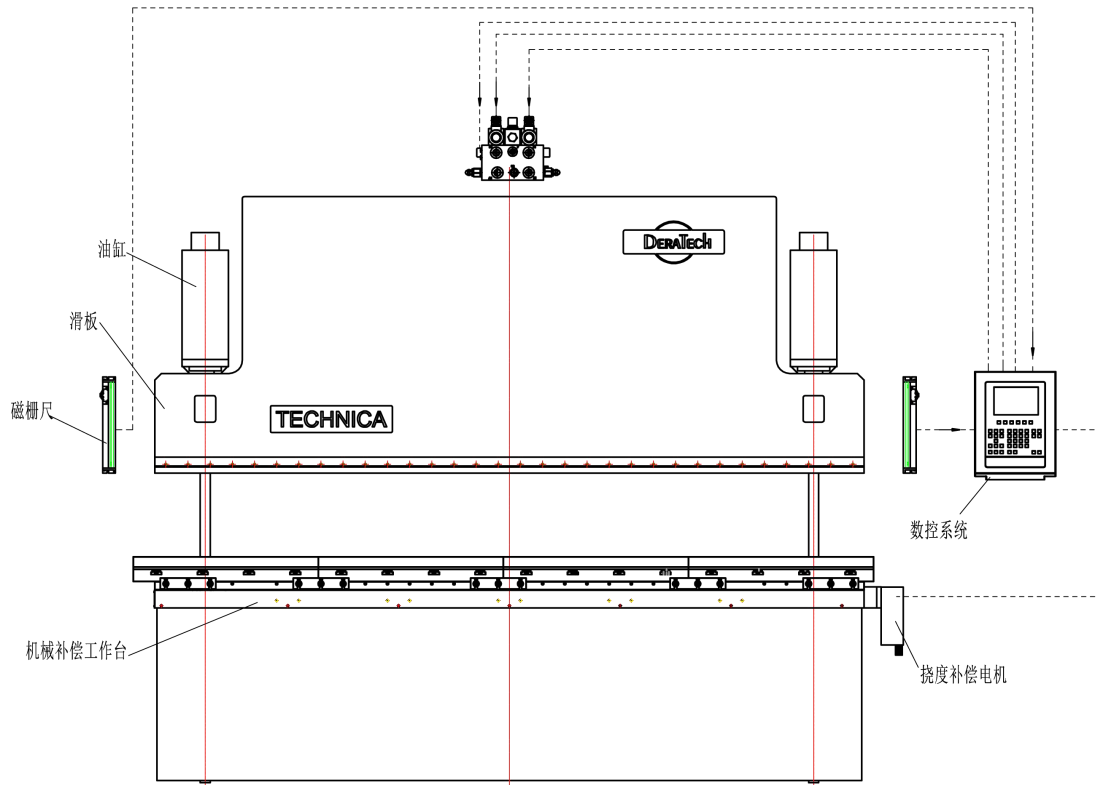
2、 Machine main structure and performance:

The machine is used Belgium DERATECH bvba new design and technology to manufacture, to ensure strength, rigidity and safety .Machine figure is simple and beautiful, fine workmanship, mechanical processing Assembly of parts are all intensively



and carefully work. Machines used in high quality steel welded structure, frame is heavy style and strong rigidity, painting imported antirust primer and surface coat to make machine durably and newly. The main frame and upper beam slider are made

by imported large CNC floor type boring and milling machine which are made to ensure the mounting surface location requirements.



The machine is constructed by main frame, upper beam, back gauge system, sliding system, Synchronization control device, tooling, hydraulic system, CNC system etc.

2.1 Main frame: This part is a frame construction. It is constructed by lower beam, left and right side board, connection bar, Lower mechanical crowning system. Used in high quality steel whole welded structure, good rigidity, high strength, it has good ability to resist distortion ; Through such processes as surface shot blasting treatment to eliminate internal stress, to ensure overall accuracy stably and durably ; When you start to bend, the upper beam and the working table will only have small deformation, to ensure that the work piece with excellent straightness and angle consistency.

2.2 Upper beam: Left and right cylinders are connected with screw and frame, Cylinder piston and upper beam are connected with spherical pads and screws. This construction can improve the working condition and the binding ability of piston and upper beam while the upper beam is under eccentric loading. Upper beam and main frame are connected by rectangular guide which has self-lubricating function. There is each one magnetic scale installed on the both sides of machine C-frame, to detect Two-cylinder synchronous motion, feedback to control the upper beam position.

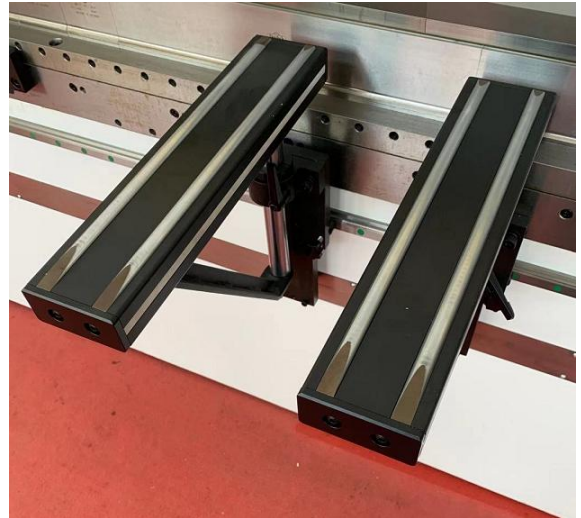
2.3 Mechanical crowning system: When you use the press brake, the upper beam will be deformed inevitably, to make the work piece angle smaller on the both sides and larger in the middle. This machine is used lower mechanical crowning system, it is controlled by CNC system, to make the working table convexly in advance to compensate the deformed of upper beam, to control the work piece angle changes in the tolerance range, to ensure the high quality bending accuracy.



2.4 Tooling and clamping equipment: The tooling is including upper tooling and lower tooling, whole heat hardening, durable in use. The upper tooling is installed on the upper beam, to be fixed by the accuracy and fast clamping, the lower tooling is used double V style, Fast and easy to change the tooling, reduce labor intensity and improve productivity.



2.5 Front support with linear guide: This part is a standard part, it is installed on the front of working table. When you use it, according to the work piece length, you can fix the front support to the place where you want. The front support can be adjusted in horizontal and vertical direction.



2.6 The special structure of the throat distortion compensating device: There is each one magnetic scale installed on the both sides of the machine to measure and feedback the accuracy distance between the upper beam and working table. The magnetic scale is connected by C-frame and working table, Eliminates the throat distortion effect on the position of the upper beam; The upper beam runtime location data back to CNC system, and output signal control by CNC system of hydraulic servo valve two groups of proportional servo valve so that the two cylinders being accurate synchronization. This structure can make the machine with eccentric loading-resistant ability, it can effectively prevent non-standard work piece to touch magnetic scale.



2.7 Back gauge position: Use Belgium new design accurate and stable back gauge, servo-motor driven ball screw, has characteristic



of high speed and high setting accuracy; New and unique double linear guide construction, to ensure the good positioning accuracy. Design of multistage stops, to increase the positioning range, above the price in value; Building block design, number of control axes are available from single-axis x to multi-axis.

2.8 Rotating arm: More ergonomics in rotating arm, reasonable radius of rotation, more flexible, easier operation.



2.9 The main motor adopts servo motor servo drive control, which has the characteristics of high efficiency, environmental protection, energy saving, precision, durability and low noise. The electro-hydraulic servo

system adopts on-demand oil supply mode, which can effectively save energy; the thermal balance temperature is low, which can extend the



service life of the hydraulic system and components; the oil change interval is extended, which can reduce the energy waste and reduce the user's cost; when bending different workpieces, the speed can be adjusted.

3、Hydraulic system:

3.1 Use German HAWE(Previous name HEROBIGER) proportional servo hydraulic integrated system, integrated design, compact conformation, German original imported.



3.2 The main cylinders are used the German SKF/U.S.A PARKER original imported seals, the sealing property is superior, reliable performance and long service life.

3.3 Pump is used German HAWE(Previous name HEROBIGER) high performance internal gear pump, high volume efficiency speed, small flow and pressure fluctuation, low noise, light weight, wide viscosity range, excellent oil-absorbing characteristics.

3.4 Tube joint used high quality brand, to ensure the hydraulic pipes no leakage.

3.5 Oil tank is made by professional special oil proof material, it is easy to get the high cleanliness, to ensure the stable running of the hydraulic system.

3.6 With the clear oil level and temperature display equipment

3.7 The hydraulic system has over loading function, to protect the machine to avoid damage when the machine is over loading.



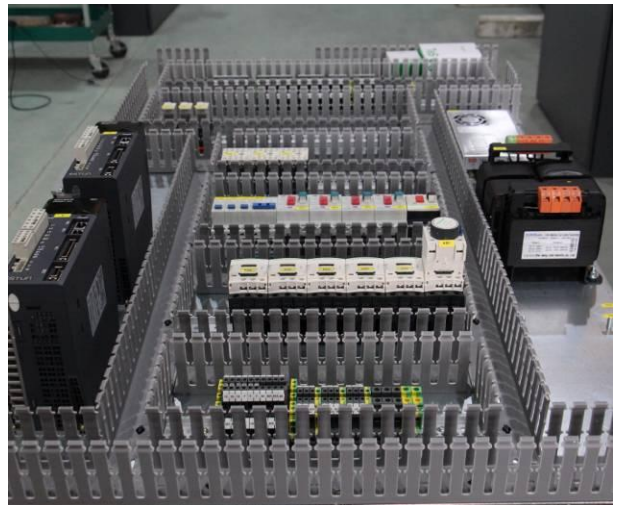
4、 Electric system:

4.1 The main electrical components used French SCHNEIDER brand, with international standard, safe and reliable, strong anti-jamming ability



4.2 With removable foot pedal control station, with the power on, power off and emergency stop function, easy to operate.

4.3 Electrical cabinet cabling is reasonable, clear, convenient for maintenance or clearing of fault, good heat release.



5、 Machine working environment

Power request: three phase four wire system、 380V、 50Hz

Installation place: clean、 less dust

Highest temperature : 40°C

Lowest temperature : -5°C

Relative humidity (RH): 55—85%

Altitude: less than 1000M

6、 Machine noise measurement standard:

LPA≤82dB (A)

LWA≤94 dB (A)

7、 Machine manufacture standard::

GB 17120-2012	《锻压机械 安全技术条件》
GB/T 34376-2017	《数控板料折弯机 技术条件》
Q/320585 DTM 01-2017	《 数控折弯机》

8、 CYBELEC CybTouch 12PS system features and functions

Easy Operating

- Fully Touch Screen, large and high-contrast interface.
- Hand drawing profile function.
- Simple pages, clear display, large keys.
- Intuitive user-friendly interface.
- Complete programming for efficient mass-production with multiple bends.
- Easy single bends thanks to the EasyBend page.
- Online help and interactive warning pop-up.
- Comfortable wireless software updating and data back-up using PC or Notebook.
- USB port for memory sticks.
- Large variety of languages available.

Better Bending

- Various automatic calculations of bend functions.
- Bending sequences and programs can be memorized.
- Angle, pressure and crowning management.
- Easy manual movement.
- EasyBend page provides immediate easy



use of the machine: a second operator can briefly interrupt production without changing the program when an urgent bend is required.

Powerful

- 4 axes control (Y1-Y2-X-R).
- 2D graphic part creation with manual sequencing.
- Automatic bend order calculation (option).
- Bend allowance calculation.
- Pressure – crowning calculation.
- Modulable tools for each part or bend.
- Punch depth calculation.
- Angle and back gauge correction.

Tandem option on CybTouch

Option configuration

The tandem feature requests an option on both CybTouch.

Tandem messages

In order to display the messages for the tandem status or any error related to tandem, a text file needs to be uploaded into the CybTouch.

CYBplc-XX.txt

It's possible to update this file using the CybTouchTools program or simply by transferring the file

using a key usb.

Please refer to the operating instructions for specific operations.

9、 Key components configuration

9.1 Lower mechanical crowning system (ERSM)

9.2 HAWE(Previous name HEROBIGER) hydraulic system (Germany)

9.3 HAWE(Previous name HEROBIGER) pump (Germany)

9.4 SKF/PARKER seals (Germany/U.S.A)

9.5 CYBELEC company (Switzerland)

9.6 Magnetic scale GIVI(Italy)

9.7 Servo motor and driver (Local brand)

9.8 SCHNEIDER relay group (France)

10、 Installation and adjustment, on-site training and acceptance

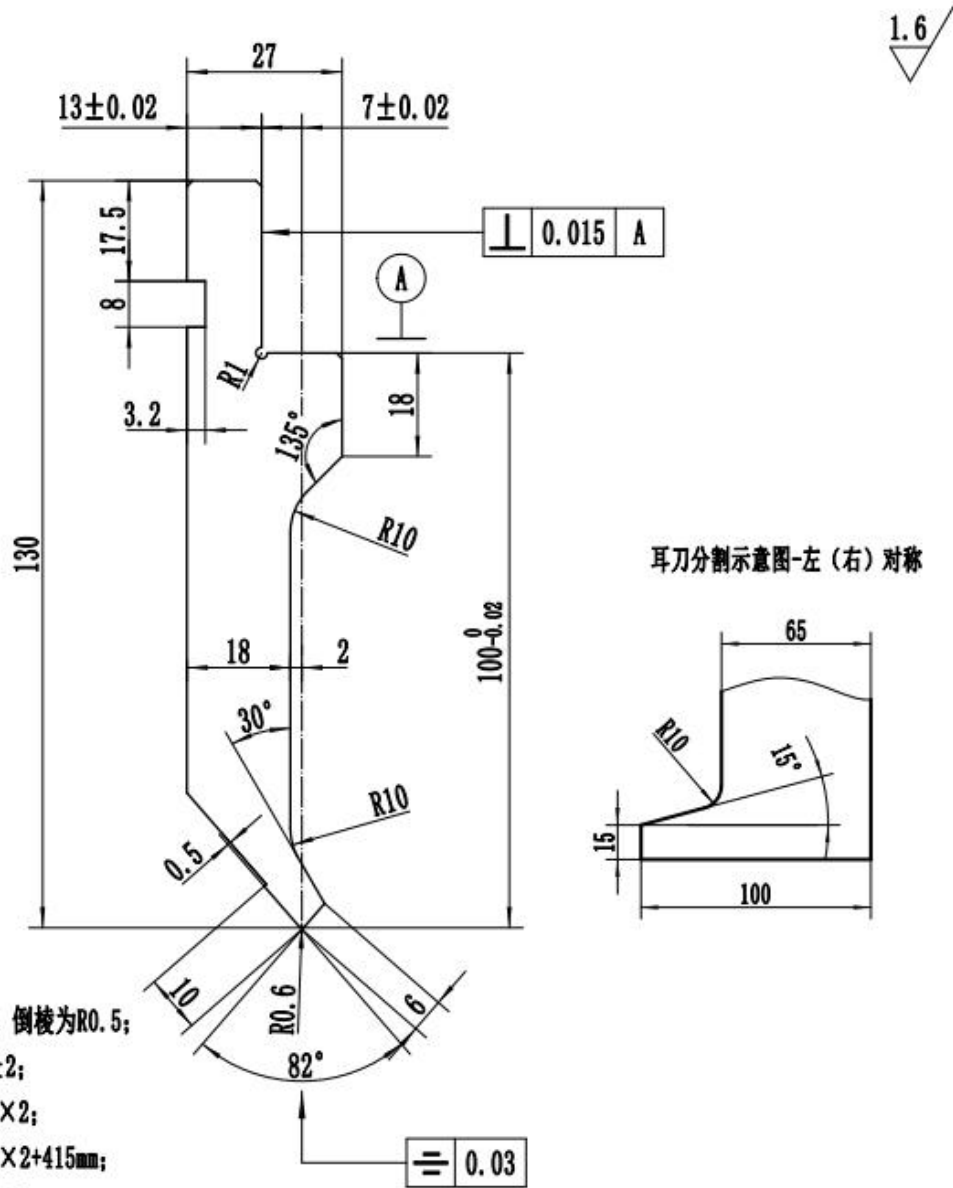
10.1. The buyer needs to prepare the required gas (provided on demand) and power supply, and make the foundation in advance as required. After the machine tool is transported to the buyer's use site, the buyer is responsible for providing hangers and general tools to place the machine in place. The seller is responsible for relevant assistance.

10.2. After the machine arrives at the use site, the seller will immediately send staff to the buyer's site for installation, commissioning and training of the buyer's operation and maintenance personnel to ensure that the buyer's operators can independently and skillfully carry out operation and maintenance.

10.3. Machine tool acceptance criteria: Acceptance according to relevant national standards and the acceptance terms mutually agreed by the buyer and seller, confirming that the machine tool performance and other technical indicators comply with the contract.

11. Punch and die of the machine

Punch

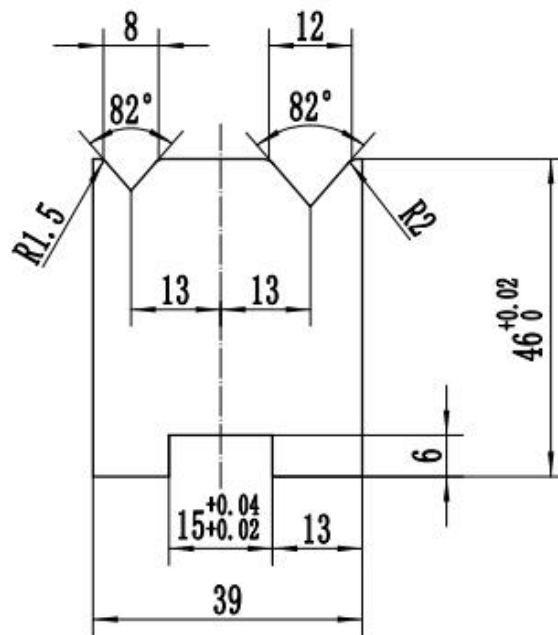


技术要求

1. 直角全部去毛刺，倒棱为R0.5;
2. 整体淬火HRC47±2;
3. 1650机型:835mm×2;
- 2050机型:835mm×2+415mm;
- 2500机型:835mm×3;
- 3200机型:835mm×4;
- 4100机型:835mm×5;
- 5100机型:835mm×6+415mm;
- 6100机型:835mm×7+415mm;

其中一段835mm分割成如下尺寸: 300、200、 2×100 (分左右耳) 50、40、20、15、10, 任意两段拼接处无明显手感。
 (打标: 模具详细参数 按模具公司标准) 适用于薄不锈钢板加工。

Die

技术要求

1. 整体淬火HRC47±2;
2. 直角全部去毛刺, 倒棱为C0.5;
3. 槽口圆角要光滑连接过渡;
4. 1650机型: 835mm×2;
- 2050机型: 835mm×2+415mm;
- 2500机型: 835mm×3;
- 3200机型: 835mm×4;
- 4100机型: 835mm×5;
- 5100机型: 835mm×6+415mm;
- 6100机型: 835mm×7+415mm;

其中一段835mm分割成如下尺寸: 400, 200, 100, 50, 40, 20, 15, 10, 任意两段拼接处无明显手感;
 (打标: 模具详细参数 按模具公司标准) 适用于1.0mm-1.5mm不锈钢板加工。



12、 Quality guarantee and after-sales service

12.1 The seller guarantees that the goods issued under the contract are completely new and qualified products.

12.2 The quality guarantee period is 12 months from the date of acceptance of the machine tool. During the quality guarantee period, due to the quality problems of the seller, the seller shall be responsible for repairing and replacing the unqualified parts and bear the cost; due to the quality problems caused by the buyer, the buyer shall be responsible for bearing the cost of replacement parts.

12.3 As a machine tool manufacturer, our company has a full set and sufficient quantity of spare parts, wearing parts and spare parts in stock, which can provide users with reliable, preferential and fast spare parts supply.

The Seller: RSM Machinery Co.,Ltd

(stamp and signature)

The Buyer: Bonanza Industrial

(stamp and signature)