



Valco Manufacturing — Custom Metal Fabricating Services

Sheet Metal Bending

Equipment: BLM Group ProBend E-Series 320-150

The ProBend E-Series 320-150 is an advanced and energy-saving machine that combines precision, reliability, and productivity in bending operations, featuring a patented STR system for reliable and silent movement and a CNC-controlled tonnage force consumption for cost-effective and efficient bending operations.

Capabilities

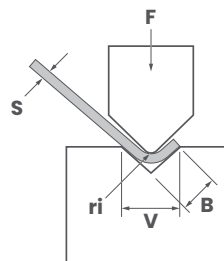
- 165 tons of force
- 100" between frames, 29" open height, 20" throat depth
- Accuracy: +/- 0.05 mm (0.002")
- Repeatability: +/- 0.02 mm (0.0008")

Metric Tonnage Chart

V (mm)	4	6	8	10	12	16	20	24	30	40	50	60	80	100	120	160
V (inch)	0.157	.236	.315	.394	.472	.63	.787	.945	1.181	1.575	1.969	2.362	3.15	3.937	4.724	6.299
B (outside mm)	2.8	4.2	5.6	7	8.6	11.5	14.4	17	21	19	36	42.4	56.5	71	85	114
ri (mm)	0.6	1	1.2	1.5	1.8	2.4	3	3.6	4.5	6	7.5	9	12	15	18	24

Material Thickness (mm)	Tons per meter															
0.5	4	2														
1		10	8	5.5	4.5											
1.2		16	12	9	7											
1.5			20	14	11	8	6									
2					22	15	11	9.5								
2.5						25	19	15	11							
3							28	22	17	12						
4								44	33	22.5	17					
5									55	37	29	22				
6										58	42	34				
8											83	65	45	35		
10												110	75	57	45	
12													116	85	68	
14														121	91	68
15														143	112	79
16														168	131	90
18															172	119
20															222	150
25																254

Chart is based on mild steel, aluminum = 0.5x tonnage, stainless steel = 1.5x tonnage.



Imperial Tonnage Chart

V (mm)	6.4	9.5	12.7	15.9	19.05	22.2	25.4	28.6	31.8	38.1	50.8	63.5	80	100	120	160
V (inch)	0.250	0.375	0.500	0.625	0.750	0.875	1.000	1.125	1.250	1.500	2.000	2.500	3.150	3.397	4.724	6.299
B (outside mm)	0.167	0.265	0.354	0.442	0.530	0.619	0.707	0.795	0.866	1.060	1.414	1.768	2.224	2.795	3.346	4.488
ri (mm)	0.038	0.056	0.075	0.094	0.113	0.131	0.150	0.169	0.188	0.225	0.300	0.375	0.472	0.591	0.709	0.945

Gauge / Thickness (in)																
20 / 0.036	3.2	2.0														
18 / 0.048	5.1	3.4	2.7	2.4												
16 / 0.060		5.8	4.0	3.1	2.5											
14 / 0.075			6.9	5.0	4.0	3.5										
12 / 0.105					8.3	6.9	5.6									
11 / 0.120						9.9	8.2	7.2	5.4							
10 / 0.135						11.9	9.9	7.3	7.1	5.8						
3/16" / 0.188								14.3	14.2	12.2	7.5					
1/4" / 0.250										23.7	16.5	11.4				
5/16" / 0.313											27.0	19.7				
3/8" 0.375											42.3	30.9	22.8	16.9		
7/16" / 0.428												32.2	24.3	19.4		
1/2" / 0.500													34.6	27.0	18.3	
5/8" / 0.625														47.1	32.0	
3/4" / 0.750															74.2	50.4
7/8" / 0.875																73.9
1" / 1.000																103.0

Chart is based on mild steel, aluminum = 0.5x tonnage, stainless steel = 1.5x tonnage.

