



Royal Stancert Inc.
Certified Management System.



K B INDUSTRIES™
Quality, Our Legacy

Single Window Solution for
Sheet Metal Machinery

Hydraulic Press Brake

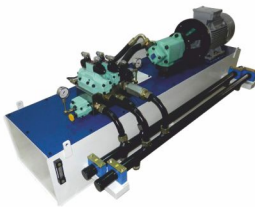
We are manufacturing Hydraulic Press Brakes with highly productive, accurate, and economical cost. Through advanced design and construction, our standard and optional features make it easier, better, durable & more efficient. We offers quality Press Brakes that provide simplified and easily accessible controls for optimum operator efficiency and output. We can deliver it to client at a considerable rate.



Range : 20 MT to 400 MT
 Length : 1250 mm to 4000 mm



! Ram tilting setting for maintain bending accuracy



! International quality hydarulic system for smooth opration

Design Features

- Accurate right angle welded steel frame made of ultrasonically tested IS 2062 plate standards gives accurate bending.
- Five piece adjustable guides with special wear resistant liners for accurate vertical movement of RAM.
- International quality hydraulic components. Specially designed compact. Manifold gives smooth, silent & jerk free operation.
- Fast approach & fast return speeds to save cycle time, slow pressing speed for better stroke control & bending accuracy, ensures high productivity.
- Emergency stop push switch with moveable console including motor on/off, RAM up/ down & cycle selection switch.
- Flexible sheet support for longer and heavier plates/sheets.
- Use of hardened pin and bushes gives less maintenance.
- Centralized lubrication with flow control ensures appropriate lubrication at all points.
- Accurately Synchronized cylinders for equally vertical force of RAM at full length.
- Front operated manual back gauge with micro-adjustment.
- Five V- Block in one and suitable Blade.
- Fine stroke adjustment Rod with limit switches

Standard Accessories Including Machine

- Pair of Blade & Block installed with machine.
- Operator Console & Foot switch for easier operation.
- Flexible sheet support for longer and heavier plates/sheets.

Technical Features

Bending Length : 1500/2000/2500/3000/4000

Thickness : Up to 4mm / 6mm / 8mm / 10mm / 12mm.

ACCURACY : ± 0.04MM

Back Gauge Length : 250mm & 600mm Manual Back Gauge, 600mm / 1000mm N C Back Gauge

NC Hydraulic Press Brake

NC hydraulic Press brakes are economical and very reliable solution for industry demand. NC hydraulic press brakes are designed to give more accuracy and better productivity. The controller has a facility to program the various jobs with complex bending sequence on screen.

The Numeric Control is used for Two Axis Control

1. Ram Axis Y 2. Back Gauge Axis X.

The program gives facility to bend different bending degrees; different back gauge positions & different open positions. It has a facility to save different programs and same can be reloaded as & when required. The back gauge consists of Flip-top Fingers, Ball Screw & Linear Bearing along with drive.



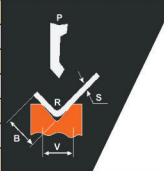
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 Length : 1250 mm to 4000 mm

Product Features

- It has a facility to program the variegated jobs includes complex bending sequence.
- This facility helps to perform complicated bending job in a signal setting and repeatable production.
- Dedicated controller from international brands.
- Bend angle & Depth Mode program.
- Stroke control and stroke counter on screen.
- Highly Precise press brake scale for accurate Y axis positioning.
- AC Servo drive for back gauge positioning.
- Hardened ground Balls screw and linear guide for better position accuracy and longer life.
- Ram tilting to maintain banding accuracy.

Force Chart For Press Brake

V	4	6	8	10	12	14	16	18	20	24	28	32	36	40	45	50	55	60	65	70	80	90	100	120	
B	2.8	4	5.5	7	8.5	10	11	12.5	14	17	20	22	25	28	31	35	38	42	46	49	56	63	70	85	
R	0.7	1	1.3	1.6	2	2.3	2.6	3	3.3	3.8	4.5	5	6	6.5	7	8	8	10	10.5	11	16	14	16	19	
S	0.5	40	30																						
	0.6	60	40	30	30																				
	0.8		70	50	40	30																			
	1		110	80	70	60																			
	1.2			120	100	80	70	60																	
	1.5				150	120	110	90	80																
	2					220	190	170	150	130	110														
	2.5							250	220	200	170	150	130												
	3								330	290	250	210	180	160											
	3.5									400	330	290	250	220	200	180									
	4										440	370	330	290	260	230	210								
	4.5											470	410	370	330	300	270	240							
	5												510	450	400	360	330	300	270	250					
	6															520	470	430	390	60	340	300			
	8																		700	640	600	520	460	420	
	10																				810	720	650		
	12																						950	780	
	14																							1300	1100



Calculation Formula

- $P=650 S^2L/V(*b=450N/mm^2)$
- P : Bending force (KN)
- S : The thickness of the plate (mm)
- L : The Width of the plate (m)
- V : V-width of the bottom die (mm)

CNC Press Brake

CNC Hydraulic press brakes are designed to give more accuracy and better productivity. The controller has a facility to program the various jobs with complex bending sequence on screen. The CNC Control is used for Three Axis Control or more.

- Synchronized Ram Axes Y1 & Y2
- Back Gauge Axis X

The program gives facility to bend different bending degrees; different back gauge positions & different open positions. It has a facility to save different programs and it can be reloaded as & when required. The back gauge consists of Flip-top Fingers, Ball Screw & Linear guides along with drive.

The machine can be equipped with some high-end optional accessories like,

- Back gauge Axis X1, X2, R & Z
- Anti-Deflection units
- Special profile Hardened Dies & Punch



Range : 20 MT to 400 MT
 Length : 1250 mm to 4000 mm

Product Features

- World class dedicated controller from Cybelec & Step Automation.
- 3 or more axis control i.e. ram axis Y1,Y2 & Back gauge axis x.
- Bend angle & Depth Mode program.
- Highly Precise press brake scale for Y1, Y2 axis.
- Open & Close loop proportional hydraulics for ram synchronization.
- Zero leak sealing of hydraulic cylinders.
- Hardened & ground Multi V Die & Punch.
- Manual Anti deflection unit in punch.
- Quick release clamps.
- Highly Precise proportional valve to control accurate beam movement.
- The power pack is supplied by Hoerbiger / Atos
- Back gauge consist of hardened & ground ball screw, liner motion bearings and AC servo drive for accurate position up to 0.05 mm.



400 mm Throat Depth



Confirmation with Laser Safe



Sectioned Die & Punch 835 mm



Front sheet support



Back gauge and finger



Quick changeable toolings

Hydraulics Shearing Machine

We introduce our most technically advanced hydraulic shearing machines for the national and international markets. Our HVR Series Hydraulic Shearing Machine incorporates latest technologies with the high performance, simple operating device and is designed to function smoothly for a long time. The stable and robust machine features all ultrasonically tested IS 2062 grade steel welded frames of top quality international standards provide better quality of cutting. Our advanced safety features make shearing machines safer and more durable. Robust construction gives more rigidity & strength to machines. These machines are capable to perform the accurate and precise cutting needs.

Range : 3 mm to 20 mm
 Length : 1250 mm to 4000 mm



Product Features

- Variable Rake Angle Design Machines.
- Accurate clearance adjustment of both blades for BUR FREE shears.
- Better cutting accuracy in thin sheets at lower rake angle.
- Higher cutting capacity at maximum rake angle.
- Low noise & smooth operation gives higher efficiency of operator.
- Automatic Rake angle adjustment.
- Pre-calibrated easy blade gap adjustment.
- Less power consumption.
- Better safety for operator and machine.
- Fine stroke adjustment rod with limit switch.
- Front sheet support.
- Squaring arm with steel rule for front gauging.
- Hardened Transfer bars mounted on table.
- Extra powerful clamping force by Holling Cylinders.
- Four edge HCHCr Blade suitable to MS & SS.

Standard Accessories Including Machine

- Pair of Blades installed with machine
- Sheet support
- Measuring scale for smaller pieces at front
- Foot switch for easier operation
- Flexible sheet support for longer and heavier plates/sheets.
- Safety Finger guard.

NC Hydraulics Shearing Machine

NC shearing machine has all the advantages of hydraulic shearing machine. The NC controller adds some more special advantage to machine. The fast and accurate multi position back gauge system is very efficient and accurate.

The machine productivity and accuracy are much improved with NC controlled back gauge.

Range : 3 mm to 20mm
 Length : 1250 mm to 4000 mm



Product Features

- Multi-steps automatic back gauge program.
- AC Servo Drive & Timer belt for Back Gauge Movement.
- Hardened & ground ball screw with linear motion bearings.
- Stroke counting on screen.
- Fast production on smaller jobs.

Standard Accessories Including Machine

- Pair of Blades installed with machine
- Sheet support
- Measuring scale for smaller pieces at front
- Foot switch for easier operation
- Flexible sheet support for longer and heavier plates/sheets.
- Safety Finger guard.
- Back Gauge with Hardened & ground ball screw with linear motion bearings.

Technical Features

- Shearing Length: 1500/2000/2500/3000/4000
- Shear Material: MS / S S / ALUMINIUM / BRASS / COPPER
- ACCURCY: ± 0.1 MM / MTR
- Thickness: Up to 3mm / 4mm / 6mm / 8mm / 10mm / 12mm / 16mm / 20mm
- Back Gauge Length: 600mm / 1000mm and as per requirement

ABOUT US

K B GROUP was established in 1967 under the dynamic leadership of Late Mr. Shantilal Pandya. His grandson, Mr. Mayank Pandya started his career in sheet metal machinery manufacturing industries from 2001. In November 2015, after gaining complete experience and competence, established his own firm "K B INDUSTRIES" for serving the same industry. Now, with combined experience of 51 years of trading & 18 years experience of manufacturing of sheet metal Machineries, K B Industries have established itself as a prominent supplier of quality products.

Our slogan is "QUALITY, OUR LEGACY". It's It-self give us inspiration to improve and develop us. Our 1st preference is serving quality products & services. We introduce ourselves as a manufacturer and trader of all kind of hydraulic sheet metal machinery & spare parts. We are providing good quality products at competent economic value. We are providing single window solution to all your fabrication needs.



"C" Type Hydraulic Press

Cap. 15 ton to 125 ton
Application : Punching - Forming
- Straightening - Stamping
- Embossing - Cutting

"H" Type Hydraulic Press

Cap. 20 ton to 500 ton
Application : Punching - Forming
- Straightening - Stamping
- Embossing - Cutting



"H" Type Hydraulic Pillar Press

Cap. 15 ton to 125 ton
Application : Used for Blanking
- Embossing - Moulding - Punching
- Deep Drawing - Forming - Straightening
- Stamping and other application



K B INDUSTRIES™
Quality, OUR LEGACY

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* The information in this brochure is subject to change without notice and should not be construed as a commitment by us.

ALSO DEAL IN :

- Busbar Cutting & Bending Machine
- Hydraulic Horizontal Press
- Press Brake Tools & Accessories
- Shearing Blade & Accessories
- Hydraulic Cylinder & Power Pack
- Retrofitting - Overhauling
- All Hydraulic Machines

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