

# Profi 28



Profi 28/1000 NC

The Boschert Profi 28 manual and Profi 28 CNC are precision hydraulic press brakes. The extremely compact and robust structure of these machines and the twin guides guarantee ram repeatability of 0.02mm.

The Profi are designed to manufacture small parts and perfectly compliment your existing larger machines. By forming small parts on the Profi and larger parts your existing machines, plant productivity is greatly improved.

Standard tooling is Amada style, with other systems available on request. Material stops are adjustable vertically and horizontally and have stop fingers with two faces each.

With a maximum bending force of 28 tons, typical work could include parts up to 300mm long and 10mm thick.

# Profi 28

The Profi 28 is simple to operate. The ram can be adjusted under pressure by using the handwheel. The powered back gauge is programmable with up to 99 programs of 30 lines each.



Profi Fun



Twin guides system on both sides



Stroke length adjustable under pressure



One or two 28 tons pressure cylinder



Control with up to 99 programmable programmes

# Profi 28 CNC



Profi 28/1000 CNC

# Profi 56 CNC



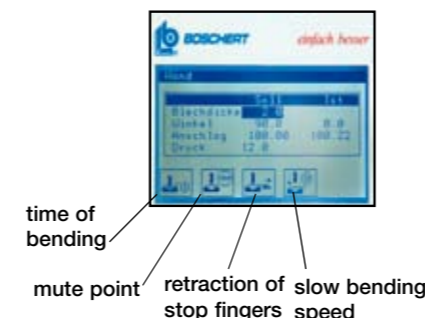
Profi 56/1000 CNC

# Profi CNC

With the CNC version, both the back gauge and bend angle are programmable. Boschert has built in even more user friendly features in this machine. It is possible to program a part in only four lines.



With Boschert's unique teach-in feature, material specifications can be entered making test bends unnecessary. By pressing a single button, more functions are activated.



time of bending  
mute point  
retraction of stop fingers speed



Profi 56/2200 CNC

# Equipment

- Side and height adjustable depth stops



# Options

- 2 Frontstops on linearguide



- Quick clamping system ROL 1



- Swivelling arm for control
- Lighting for stops
- Working height 950 mm

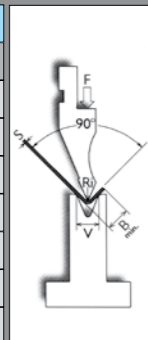
S mm.	0,6		0,8		1,0	
V mm.	6	8	6	8	6	8
F R.200N/mm <sup>2</sup>	20	10	30	20	60	40
F R.450N/mm <sup>2</sup>	40	30	70	50	130	80
F R.700N/mm <sup>2</sup>	60	40	110	80	190	130
Ri mm.	1,0	1,3	1,0	1,3	1,0	1,3
90°=B mm.	4,5	6,0	4,6	6,1	4,7	6,2
60°=B mm.	6,3	8,3	6,4	8,4	6,5	8,5
35°=B mm.	10,3	13,6	10,4	13,7	10,5	13,8

S mm.	1,2		1,5		2,0	
V mm.	8	10	10	12	12	16
F R.200N/mm <sup>2</sup>	60	40	70	60	110	80
F R.450N/mm <sup>2</sup>	130	100	160	130	250	170
F R.700N/mm <sup>2</sup>	200	150	250	200	390	260
Ri mm.	1,3	1,7	1,7	2,0	2,0	2,7
90°=B mm.	6,3	7,7	7,8	9,2	9,5	12,3
60°=B mm.	8,6	10,6	10,8	12,8	13,0	17,0
35°=B mm.	13,9	17,2	17,4	20,7	21,0	27,6

S mm.	2,5		3		4	
V mm.	16	20	20	25	32	40
F R.200N/mm <sup>2</sup>	130	90	140	110	150	110
F R.450N/mm <sup>2</sup>	290	210	320	240	340	250
F R.700N/mm <sup>2</sup>	440	330	500	370	530	390
Ri mm.	2,7	3,3	3,3	4,2	5,3	6,7
90°=B mm.	12,6	15,4	15,6	19,2	24,6	30,3
60°=B mm.	17,3	21,3	21,5	26,5	34,0	42,0
35°=B mm.	27,9	34,5	34,8	43,1	55,2	68,5

S mm.	5		6		8	
V mm.	40	50	50	63	63	80
F R.200N/mm <sup>2</sup>	190	140	210	160	310	220
F R.450N/mm <sup>2</sup>	420	320	480	360	690	500
F R.700N/mm <sup>2</sup>	660	490	750	550	1070	780
Ri mm.	6,7	8,3	8,3	10,5	10,5	13,3
90°=B mm.	30,8	37,9	38,4	47,5	48,5	60,6
60°=B mm.	42,5	52,5	53	66,0	67,0	84,0
35°=B mm.	69,0	85,6	86,1	107,8	108,8	137,0

S mm.	10		12	
V mm.	80	100	100	125
F R.200N/mm <sup>2</sup>	380	280	430	320
F R.450N/mm <sup>2</sup>	840	630	960	720
F R.700N/mm <sup>2</sup>	1310	980	1490	1120
Ri mm.	13,3	16,7	16,7	20,8
90°=B mm.	61,6	75,7	76,7	94,4
60°=B mm.	85,0	105,0	106,0	131,0
35°=B mm.	138,0	171,3	172,3	213,8

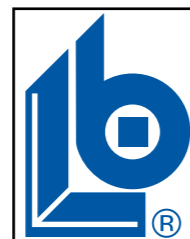


F = KN for meter S = Sheet thickness R = Sheet resistance - Material Hardness

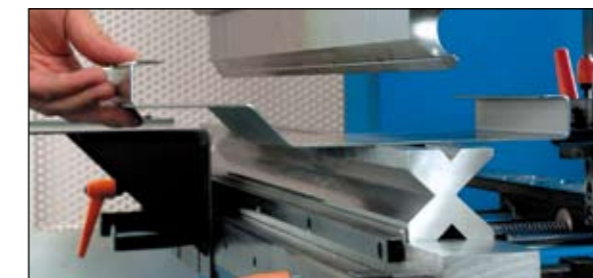
	Profi 28/1000 NC	Profi 28/1000 CNC	Profi Fun
<b>Capacities</b>			
Tonnage kN	280	280	280
Bending length mm	1000	1000	1000
<b>Dimensions</b>			
Weight kg	3500	3500	3500
Width mm	1500	1500	1600
Depth mm	1310	1310	1500
Height from floor mm	2200	2200	2450
Width between columns mm	890	890	890
Throat mm	200	200	200
Width of worktable mm	2 x 270	2 x 270	1 x 800x450
Operating height mm (ohne Matrizen)	915	915	985
Max. open height mm	305 (405*)	305 (405*)	305 (405*)
Y-Travel mm	200	200	200
Max. stop range in X mm	370 (500)	370 (500)	380
Normal speed mm/s	8-10	8-10	8-10
Return speed mm/s	30	30	30
Repeatability mm	+/-0,02	+/-0,02	+/-0,02
Connected load kVA	5,5	5,5	5,5
Control	Hejm	Labod	Labod

	Profi 56/1000 CNC	Profi 56/1400 CNC	Profi 56/2200 CNC
<b>Capacities</b>			
Tonnage kN	560	560	560
Bending length mm	1000	1400	2200
<b>Dimensions</b>			
Weight kg	3800	4800	5500
Width mm	1500	1600	2700
Depth mm	1310	2010/2310 m. Steuerung	1670
Height from floor mm	2200	2200	2200
Width between columns mm	890	1260	2100
Throat mm	200	200	200
Width of worktable mm	2 x 270	2 x 270	2 x 270
Operating height mm (ohne Matrizen)	915	915	915
Max. open height mm	305 (405*)	305 (405*)	305 (405*)
Y-Travel mm	200	200	200
Max. stop range in X mm	370 (500)	370 (500)	500
Normal speed mm/s	8-10	8-10	8-10
Return speed mm/s	30	30	30
Repeatability mm	+/-0,02	+/-0,02	+/-0,02
Connected load kVA	10	10	12
Control	Labod	Labod	Labod

\*Option ( )



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**PROFI 28 NC**  
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**PROFI Fun**  
**PROFI 56 CNC**

