

# CNC Gauging

Delem

DA-65



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## Product Summary

The graphical programming, bend sequence computation and 2D simulation provide the used the **most user-friendly** and **fast programmable** CNC for press brakes ever built.

Programming the Delem DA-65 is simply drawing the profile of your product on the screen. The bend **expert program** automatically calculates the optimum bending sequence whereafter you can watch a 2D simulation of your product showing you how to place it in the machine.

Knowing the bend sequence and which tools to use, the DA-65 helps you to save money because the easy way of using it saves a lot of time involved with trial and error on your machine.

Its new state of the art electronics and the new modular architecture offer you many other advantages such as:

- Optional **Flash disk** for those who need mass storage of the many parts they handle. §
- **Error message** system and help texts to warn you for faulty programming, operation errors and machine failures. This saves a lot of time finding out what is wrong.
- RS232 or an optional **Ethernet** interface for flexible DNC operations with download of part program and/or part drawings.
- **Barcode reader** interface for automatic product selection.

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## Technical Specifications

## General

- 12 inch CRT display (VGA, 4 greyscales) -
- Memory capacity:
  - 2.500 program steps
  - 90 tools
  - 10 upper machine shapes
  - 10 under machine shapes
- Program number, 7 digits
- Drawing number 20 digits alpha-numeric
- Program repeat max. 9,999
- Step number, 25 max. (sequences)
- Step repeat, 99 max.
- Memory storage on floppy (3.5" HD)
- Operator selectable language
- Handwheel movement of all axes
- PLC functions
- Annunciator system
- Machine time counter

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## Program specifications

Y axis	0 - 999.99 mm
Resolution	0.01mm
Accuracy	+/- 0.01 mm
Angle	0 - 180°
Y axis opening (DY)	0 - 999.99 mm
Mute	0 - 999.99 mm
Parallelism Y1-Y2	0 - +/- 50.00 mm
Holding time	0.1 - 10.0 s
Pressing speed	0.1 - 20.0 mm/s
Decompressing distance	0 - 999.99 mm
Decompressing speed	0.1 - 20.0 mm/s
Press force	1 - 9,999 kN
X axis	0 - 16,000.0 mm
Resolution	selectable, 0.1 or 0.01 mm
Retract backgaguge	0 - 9,999 mm
Positioning speed	600 mm/s max.

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## Computer Functions

- Muting
- Tooling safety zones
- Pinching point
- Press force in KN
- Bend allowance
- Crowning adjustment
- R axis position (R1-R2)
- Z axis position (Z1-Z2)
- Decompression
- Millimetres / inches
- Developed length
- Bottoming force
- Auto bumping calculation
- "Lay-on" support back gauge

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### Optional Functions

- Tandem operation
- Part support control
- X1-X2 angle programming
- Ethernet interface
- Flash disk card for memory extension
- Barcode reader interface
- Remote diagnosis

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### Axis Control (Modusys architecture)

Y axis	full cycle speed and synchro control
X axis	servoloop
R axis	servoloop
Z axis	servoloop
R1 - R2	servoloop
Z1 - Z2	servoloop
X1 - X2	servoloop
V axis	tool changer

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### Interfaces

- DNC-RS 232C, bi-directional
- Additional high speed bussystem (up to 24 modules)
- PC - 104 connector

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### **Miscellaneous**

- Diagnostic Program
- Many dialogue languages
- Help texts
- "Teach-in" on Y and X axis