WYSONG®

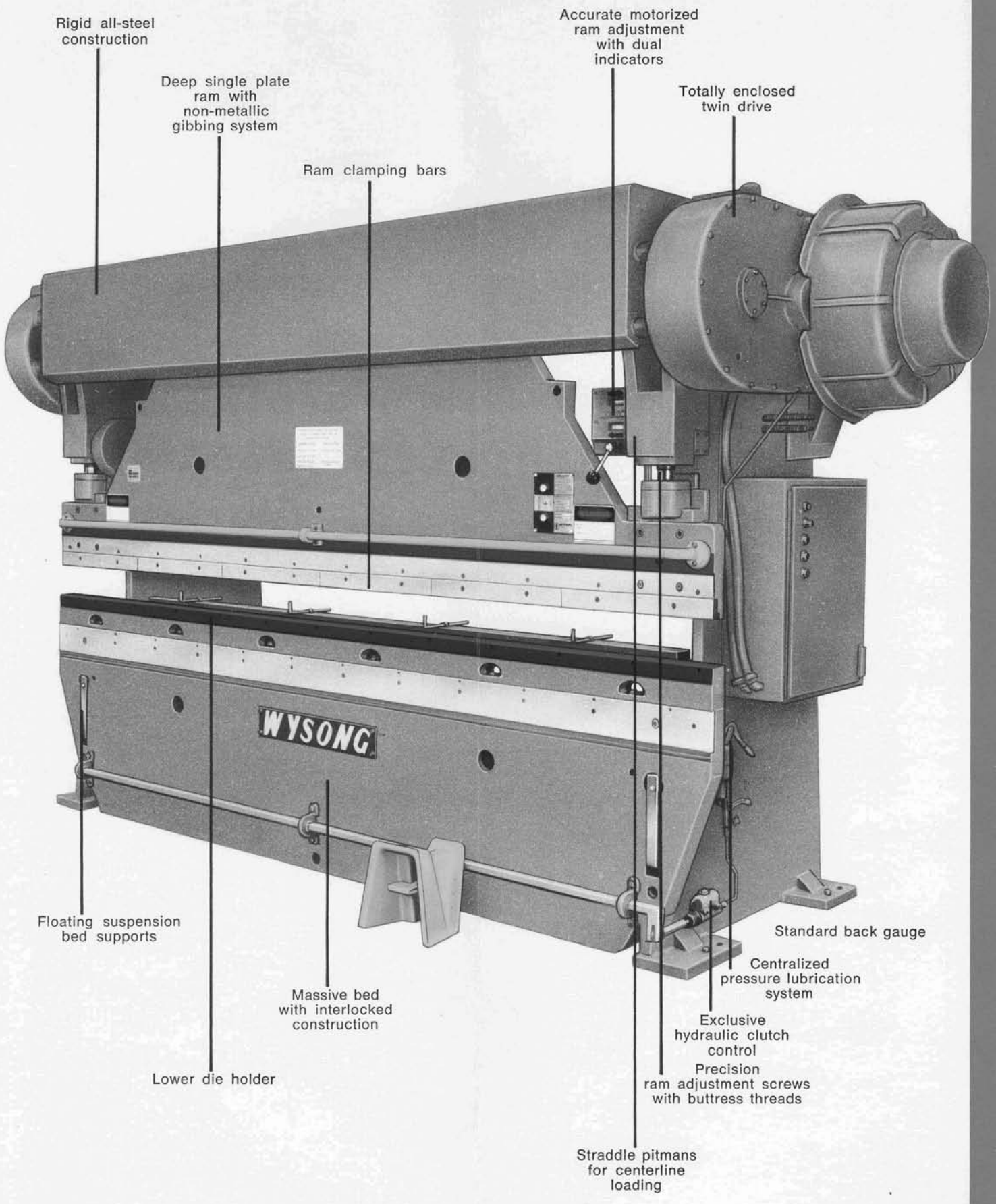
press brakes

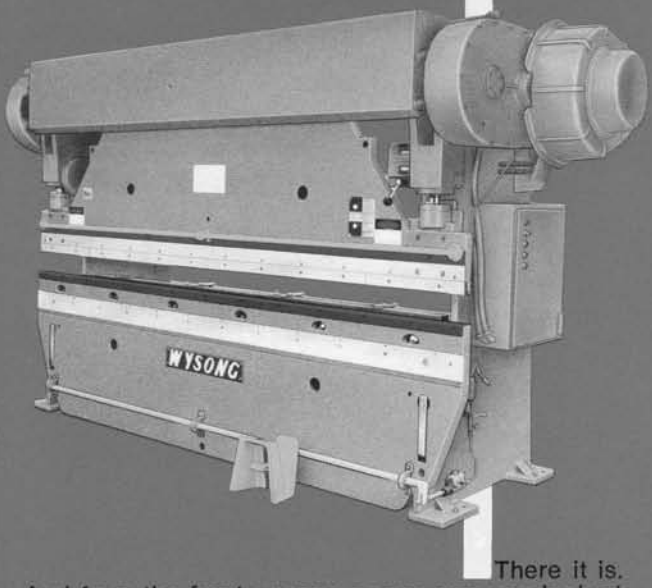


member nmba

the machines backed by people

CATALOG NO. PB-784 15M


Rigid all-steel construction
Deep single plate ram with non-metallic gibbing system
Ram clamping bars
Accurate motorized ram adjustment with dual indicators
Totally enclosed twin drive
WYSONG
Floating suspension bed supports
Lower die holder
Massive bed with interlocked construction
Straddle pitmans for centerline loading
Precision ram adjustment screws with buttress threads
Exclusive hydraulic clutch control
Centralized pressure lubrication system
Standard back gauge



There it is. And from the front or rear, or any way you look at it, you can see this is a better press brake. Notice the little things that are largely responsible for the way the brake operates. Straddle pitmans, non-metallic gibbing system, bed and ram design that provide minimum deflection at rated capacity. And its accuracy that lasts. Note the ample die space. Convenience of adjustment controls. And our exclusive hydraulic clutch control, the only control that gives an operator the touch he needs for complete mastery of the stroke.

WYSONG press brakes

It's an all-around good design. Good enough to use on all our press brakes from 55 to 225 tons. So we won't bore you with extra pictures. The dimension chart with each series will give you dimensions. And for your reference, there's a tonnage chart on the inside back cover. Look closely. We think you'll like what you see.

But there is something you won't see. The people behind the machine. People who have never settled for second best. In design, in production, distribution and service. The people who have earned the deserved recognition of the industry in power shears and other metalworking machinery. They're behind our press brakes. Before and after the sale.

WYSONG & MILES COMPANY

U. S. 29 North ☐ P. O. Box 21168
Greensboro, North Carolina 27420
919/621-3960

35/55 TON CAPACITY

Straddle pitmans and one-piece eccentrics place the entire load on the centerline of end frames for balanced direct loading.
Hydraulic clutch controls are found exclusively on Wysong press brakes, providing operator with the ultimate in sensitive control.
Rigid all-steel construction gives rigidity and permanent alignment, assured by massive frame structure of select steel plate with special interlocked construction and contoured stress points.
Non-metallic gibbing system as used on all Wysong shears, assures efficient, score-proof gib ways. Wear is reduced to minimum, thus maintaining gib clearance and minimizing adjustments.
Totally enclosed drive with all gears running in a constant bath of oil.
Deep bed and ram are designed with extra depth of solid, one-piece steel plate to assure accuracy. Wysong's unique floating suspension system provides solid bed support.
Lower die holder is moveable and permits accurate alignment of tooling.
Ample die space is provided to accommodate not only standard but also special press brake tooling.
Ram clamping bar is in sections, each fastened to ram with screws on 12-inch centers.

Positive spring-loaded disc brake stops the ram as soon as clutch is released. Easily accessible for normal maintenance.
Powerful Flex-Disc clutch assembly is divided into snap-out, quick-change segments, easily detached should maintenance ever be required.
Accurate motorized ram adjustment using power for raising and lowering ram is provided as standard feature.
Micrometer indicators with built-in limit switches.
Other standard features include solid bed support, standard back gauge, centralized lubrication system, and reduced voltage control circuit.
Optional features are listed beginning on page 22.

WYSONG press brakes series 55

specifications

Series	Model	Near bottom tonnage	Mid stroke tonnage	Series Capacity (Mild Steel)	Ram & bed length	Between housings	Throat	Stroke	Die space	Ram adj.	Ram adj. motor	SPM	Main motor 1800	Approx. shipping weight
55	55-4	55	35	6′ x 10 ga. 8′ x 12 ga. 10′ x 14 ga. 12′ x 16 ga.	6′	4′ 6″	8″	3″	12″	3″	1 HP	40	3 HP	8,800
	55-6				8′	6′ 6″								9,700
	55-8				10′	8′ 6″								11,800

dimensions

Model	A	B	C	D	E	F	G	H	J	K	L	M	N	O	P	R	S
55-4	54	72	88	36	52	57	11	46	34	—	88	3	3	12	2	4¼	8
55-6	78	96	112	48	64	57	11	46	34	—	88	3	3	12	2	4¼	8
55-8	102	120	136	60	76	57	11	46	34	—	88	3	3	12	2	4¼	8

60/90 TON CAPACITY

Straddle pitmans and one-piece eccentrics place the entire load on the centerline of end frames for balanced direct loading.
Hydraulic clutch controls are found exclusively on Wysong press brakes, providing operator with the ultimate in sensitive control.
Rigid all-steel construction gives rigidity and permanent alignment, assured by massive frame structure of select steel plate with special interlocked construction and contoured stress points.
Non-metallic gibbing system as used on all Wysong shears, assures efficient, score-proof gib ways. Wear is reduced to minimum, thus maintaining gib clearance and minimizing adjustments.
Totally enclosed twin drive is featured, with all gears running in a constant bath of oil, thereby providing uniform application of power.
Deep bed and ram are designed with extra depth of solid, one-piece steel plate to assure accuracy. Wysong's unique floating suspension system provides solid bed support.
Lower die holder is moveable and permits accurate alignment of tooling.
Ample die space is provided to accommodate not only standard but also special press brake tooling.
Ram clamping bar is in sections, each fastened to ram with screws on 12-inch centers.

Positive spring-loaded disc brake stops the ram as soon as clutch is released. Easily accessible for normal maintenance.
Powerful Flex-Disc clutch assembly is divided into snap-out, quick-change segments, easily detached should maintenance ever be required.
Accurate motorized ram adjustment using power for raising and lowering ram is provided as standard feature.
Micrometer indicators with built-in limit switches.
Other standard features include solid bed support, standard back gauge, centralized lubrication system and reduced voltage control circuit.
Optional features are listed beginning on page 22.

WYSONG press brakes series 90

specifications

Series	Model	Near bottom tonnage	Mid stroke tonnage	Series Capacity (Mild Steel)	Ram & bed length	Between housings	Throat	Stroke	Die space	Ram adj.	Ram adj. motor	SPM	Main motor 1800	Approx. shipping weight
90	90- 4	90	60	5′ x ¼″ 8′ x 3/16″ 10′ x 10 ga. 12′ x 12 ga.	6′	4′ 6″	8½″	3″	12″	4″	1 HP	40	7½ HP	12,500
	90- 6				8′	6′ 6″								13,300
	90- 8				10′	8′ 6″								14,200
	90-10				12′	10′ 6″								16,800
	90-12				14′	12′ 6″								18,000
	90-14				16′	14′ 6″								21,200

dimensions

Model	A	B	C	D	E	F	G	H	J	K	L	M	N	O	P	R	S
90- 4	54	72	111	40	71	67	12	55	34	—	99	3	4	12	3	5½	8½
90- 6	78	96	135	52	83	67	12	55	34	—	99	3	4	12	3	5½	8½
90- 8	102	120	159	64	95	67	12	55	34	—	99	3	4	12	3	5½	8½
90-10	126	144	183	76	107	67	12	55	34	—	99	3	4	12	3	5½	8½
90-12	150	168	207	88	119	67	12	55	34	—	99	3	4	12	3	5½	8½
90-14	174	192	231	100	131	67	12	55	34	11½	99	3	4	12	3	5½	8½

100/150 TON CAPACITY

Straddle pitmans and one-piece eccentrics place the entire load on the centerline of end frames for balanced direct loading.
Hydraulic clutch controls are found exclusively on Wysong press brakes, providing operator with the ultimate in sensitive control.
Rigid all-steel construction gives rigidity and permanent alignment, assured by massive frame structure of select steel plate with special interlocked construction and contoured stress points.
Non-metallic gibbing system as used on all Wysong shears, assures efficient, score-proof gib ways. Wear is reduced to minimum, thus maintaining gib clearance and minimizing adjustments.
Totally enclosed twin drive is featured, with all gears running in a constant bath of oil, thereby providing uniform application of power.
Deep bed and ram are designed with extra depth of solid, one-piece steel plate to assure accuracy. Wysong's unique floating suspension system provides solid bed support.
Lower die holder is moveable and permits accurate alignment of tooling.
Ample die space is provided to accommodate not only standard but also special press brake tooling.
Ram clamping bar is in sections, each fastened to ram with screws on 12-inch centers.

Powerful Disc clutch assembly is mounted on the drive shaft for smooth, sensitive control of flywheel. Clutch can be slipped or inched at any point of ram stroke and is easily adjusted from outside the housing. Large flywheels supply the required energy to give machine-rated capacity.
Powerful spring loaded shoe brake is mechanically interlocked with clutch to stop ram as clutch is released, providing operator with positive control of ram at any point of the stroke. Unit is quickly accessible for easy maintenance.
Accurate motorized ram adjustment using power for raising and lowering ram is provided as standard feature.
Micrometer indicators with built-in limit switches.
Other standard features include solid bed support, standard back gauge, centralized lubrication system, reversing magnetic motor control, and reduced voltage control circuit.
Optional features are listed beginning on page 22.

WYSONG press brakes series 150

specifications

Series	Model	Near bottom tonnage	Mid stroke tonnage	Series Capacity (Mild Steel)	Ram & bed length	Between housings	Throat	Stroke	Die space	Ram adj.	Ram adj. motor	SPM	Main motor 1800	Approx. shipping weight
150	150- 4	150	100	8′ x ¼″ 12′ x 3/16″ 16′ x 10 ga.	6′	4′ 6″	8½″	3″	12″	5″	1½ HP	30	10 HP	17,900
	150- 6				8′	6′ 6″								21,000
	150- 8				10′	8′ 6″								23,900
	150-10				12′	10′ 6″								26,800
	150-12				14′	12′ 6″								29,200
	150-14				16′	14′ 6″								31,900

dimensions

Model	A	B	C	D	E	F	G	H	J	K	L	M	N	O	P	R	S
150- 4	54	72	117	42	75	80	16	64	34	—	114	3	5	12	3	5½	8½
150- 6	78	96	141	54	87	80	16	64	34	—	114	3	5	12	3	5½	8½
150- 8	102	120	165	66	99	80	16	64	34	—	114	3	5	12	3	5½	8½
150-10	126	144	189	78	111	80	16	64	34	—	114	3	5	12	3	5½	8½
150-12	150	168	213	90	123	80	16	64	34	10	114	3	5	12	3	5½	8½
150-14	174	192	237	102	135	80	16	64	34	15	114	3	5	12	3	5½	8½

150/225 TON CAPACITY

Straddle pitmans and one-piece eccentrics place the entire load on the centerline of end frames for balanced direct loading.
Hydraulic clutch controls are found exclusively on Wysong press brakes, providing operator with the ultimate in sensitive control.
Rigid all-steel construction gives rigidity and permanent alignment, assured by massive frame structure of select steel plate with special interlocked construction and contoured stress points.
Non-metallic gibbing system as used on all Wysong shears, assures efficient, score-proof gib ways. Wear is reduced to minimum, thus maintaining gib clearance and minimizing adjustments.
Totally enclosed twin drive is featured, with all gears running in a constant bath of oil, thereby providing uniform application of power.
Deep bed and ram are designed with extra depth of solid, one-piece steel plate to assure accuracy. Wysong's unique floating suspension system provides solid bed support.
Lower die holder is moveable and permits accurate alignment of tooling.
Ample die space is provided to accommodate not only standard but also special press brake tooling.
Ram clamping bar is in sections, each fastened to ram with screws on 12-inch centers.

Powerful Disc clutch assembly is mounted on the drive shaft for smooth, sensitive control of flywheel. Clutch can be slipped or inched at any point of ram stroke and is easily adjusted from outside the housing. Large flywheels supply the required energy to give machine-rated capacity.
Powerful spring loaded shoe brake is mechanically interlocked with clutch to stop ram as clutch is released, providing operator with positive control of ram at any point of the stroke. Unit is quickly accessible for easy maintenance.
Accurate motorized ram adjustment using power for raising and lowering ram is provided as standard feature.
Micrometer indicators with built-in limit switches.
Other standard features include solid bed support, standard back gauge, centralized lubrication system, reversing magnetic motor control, and reduced voltage control circuit.
Optional features are listed beginning on page 22.

WYSONG press brakes series 225

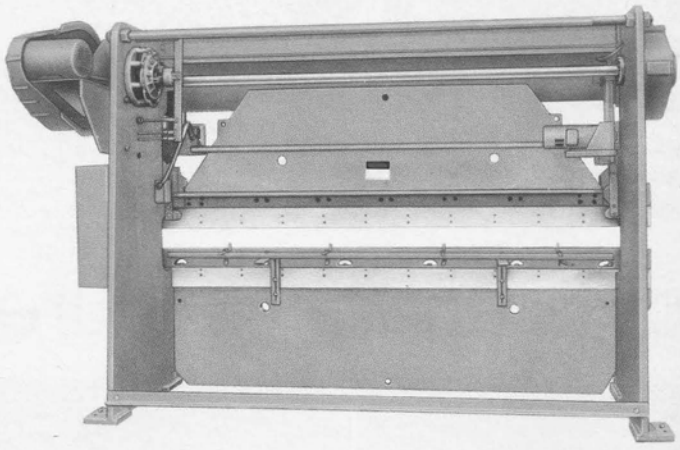
specifications

Series	Model	Near bottom tonnage	Mid stroke tonnage	Series Capacity (Mild Steel)	Ram & bed length	Between housings	Throat	Stroke	Die space	Ram adj.	Ram adj. motor	SPM	Main motor 1800	Approx. shipping weight
225	225- 4	225	150	7′ x 3/8″ 9′ x 5/16″ 13′ x 1/4″	6′	4′ 6″	8½″	3″	12″	5″	1½ HP	30	15 HP	21,900
	225- 6				8′	6′ 6″								25,900
	225- 8				10′	8′ 6″								30,800
	225-10				12′	10′ 6″								35,800
	225-12				14′	12′ 6″								39,800

dimensions

Model	A	B	C	D	E	F	G	H	J	K	L	M	N	O	P	R	S
225- 4	54	72	124	47	77	88	17	71	34	—	126	3	5	12	3	5½	8½
225- 6	78	96	148	59	89	88	17	71	34	—	126	3	5	12	3	5½	8½
225- 8	102	120	172	71	101	88	17	71	34	—	126	3	5	12	3	5½	8½
225-10	126	144	196	83	113	88	17	71	34	—	126	3	5	12	3	5½	8½
225-12	150	168	220	95	125	88	17	71	34	14	126	3	5	12	3	5½	8½

150/225 TON CAPACITY



Powerful Disc clutch assembly is mounted on the drive shaft for smooth, sensitive control of flywheel. Clutch can be slipped or inched at any point of ram stroke and is easily adjusted from outside the housing. Large flywheels supply the required energy to give machine-rated capacity.

Powerful spring loaded shoe brake is mechanically interlocked with clutch to stop ram as clutch is released, providing operator with positive control of ram at any point of the stroke. Unit is quickly accessible for easy maintenance.

Accurate motorized ram adjustment using power for raising and lowering ram is provided as standard feature.

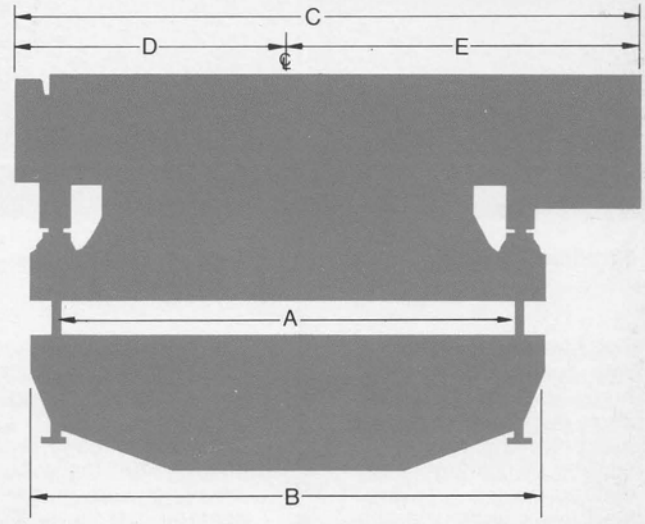
Micrometer indicators with built-in limit switches.

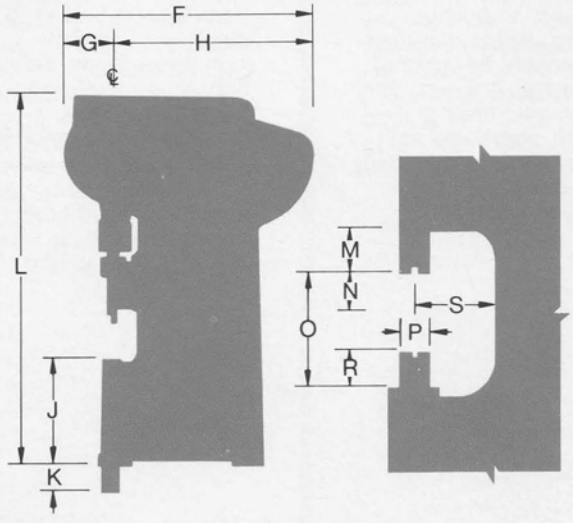
Other standard features include solid bed support, standard back gauge, centralized lubrication system, reversing magnetic motor control, and reduced voltage control circuit.

Optional features are listed beginning on page 22.

for 55 series to 225 series

WYSONG press brakes series 225



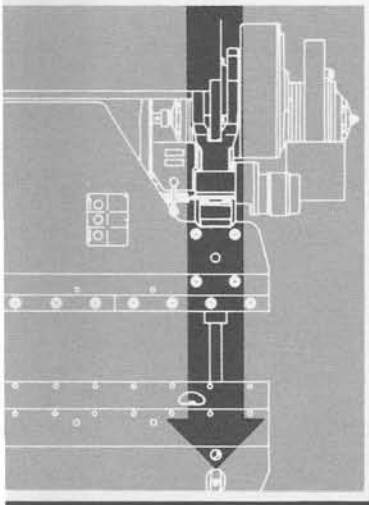


Throat	Stroke	Die space	Ram adj.	Ram adj. motor	SPM	Main motor 1800	Approx. shipping weight
8½″	3″	12″	5″	1½ HP	30	15 HP	21,900
							25,900
							30,800
							35,800
							39,800

	H	J	K	L	M	N	O	P	R	S
	71	34	—	126	3	5	12	3	5½	8½
	71	34	—	126	3	5	12	3	5½	8½
	71	34	—	126	3	5	12	3	5½	8½
	71	34	—	126	3	5	12	3	5½	8½
	71	34	14	126	3	5	12	3	5½	8½

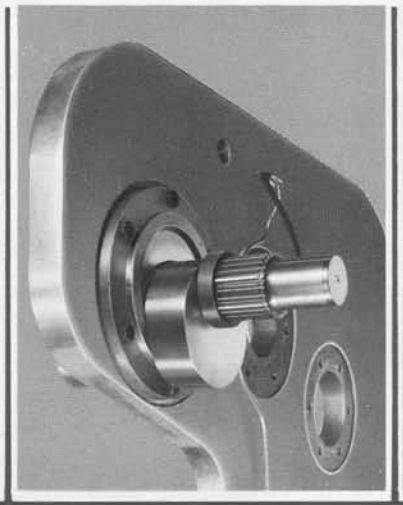
Wysong & Miles Company reserves the right to discontinue or change specifications, design or material at any time without prior notice or obligation. For detailed specifications and dimensions contact factory. When greater than standard stroke is furnished, mid stroke tonnage is reduced. Tonnage remains unchanged near bottom of stroke. Consult factory for special stroke requirements.

outstanding features



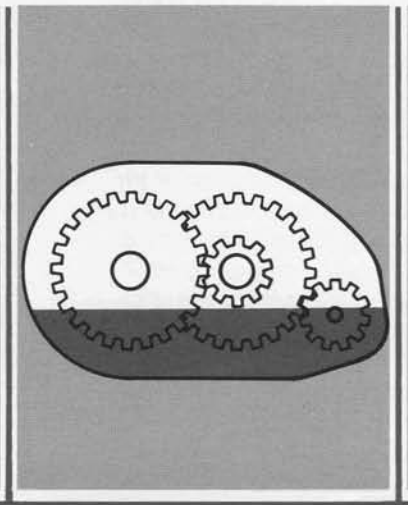
Straddle pitmans

The straddle pitmans—with dual precision-machined bronze bearings—ride with minimum friction on the double eccentrics, uniformly distributing the pressing load, even under extreme tonnages. With this Wysong design, you can look forward to years of trouble-free service. This greater efficiency in Wysong press brakes means higher productivity and more profit in your operation.



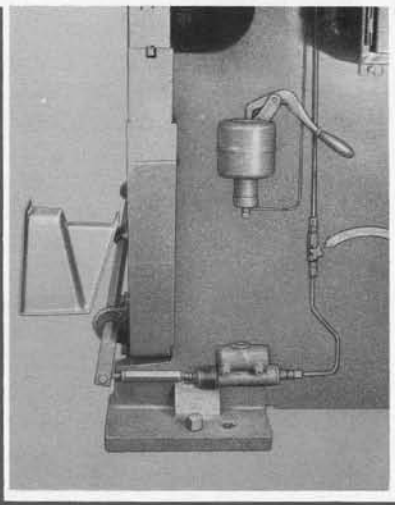
One-piece double eccentrics

The oversize, one-piece forged alloy steel double eccentrics, combined with the straddle-designed pitmans, ensures that the entire load is placed on the centerline of the end frames for a balanced direct loading. This minimizes frame deflection, thus resulting in longer sustained accuracy and service life.



Totally enclosed twin drive

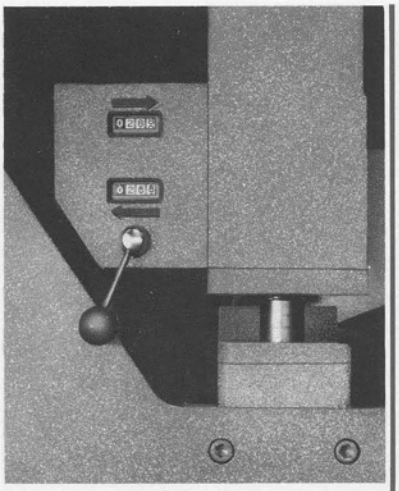
All Wysong press brakes (from 90 series up) are equipped with totally enclosed gear boxes on each end of the machine. The double-reduction gearing runs in a constant bath of oil, providing a smooth, uniform application of power. The main pinions — made of hardened alloy steel, stress relieved and precision cut for long life and quiet running—are specifically designed and manufactured to accept the heavy loads encountered in press brake operations.

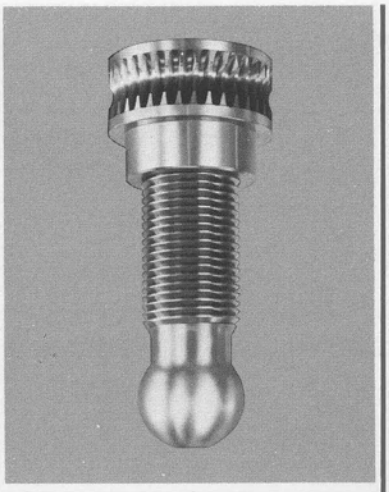


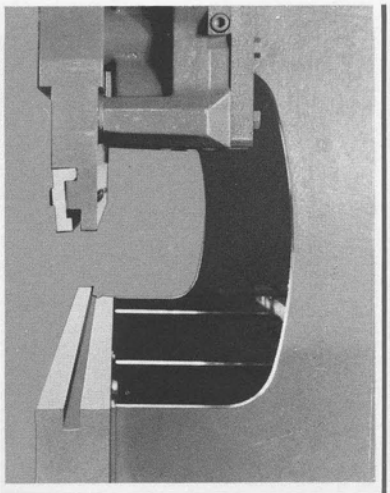
Exclusive hydraulic clutch control

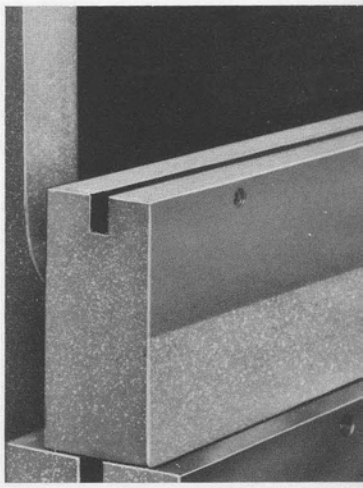
Wysong press brakes are equipped with a hydraulic clutch control which provides a smooth, sensitive operation of the ram. The operator can thus "feel" his way through the bend, thereby minimizing any "Back Bending" of wide sheets. Hydraulic master and slave cylinders are actuated by a foot pedal, allowing the operator complete mastery of the clutch so that the ram may be inched to any point in the stroke. In addition, a locking valve in the system is provided to prevent accidental engagement of the clutch. Should an accidental rupture occur to the hydraulic line, the brake will automatically spring-set, thus stopping the ram. Combined features such as these provide a great margin of operating ease over mechanically-linked machines.

WYSONG press brakes









Accurate ram adjustment

The ram adjustment controls include twin readout indicators (reading in thousandths) equipped with built-in limit switches, adjustment buttons, motor pilot light and tilt clutch lever. All are conveniently located near the front of the right pitman, eliminating any wasted operator motion. For tilt adjustments, the clutch lever and readouts provide quick and precise control. The twin readouts make reproduction of any previous job quick and easy, without trial, simply, by resetting the previous indicator readings.

Precision ram adjusting screw

The ram adjusting screws are machined from high tensile alloy steel forgings with buttress threads and heavy ball end. They are hardened and lapped to fit the contoured seat in the ram connection socket. Precision aluminum-bronze worm nuts rotate around the adjusting screws. The alloy steel worms are ball bearing mounted. With Wysong's swivel gibbing system the ram may be tilted for fade-out work or compensation for die variations without gibbing adjustment.

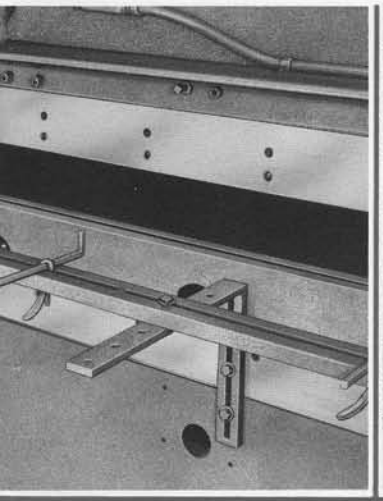
Die space

Die space on Wysong press brakes is more than ample to accommodate either standard or special dies. The die space allows the use of unitized commercial tooling and self-aligning or open-throat punch units, as well as leader-pin die sets. The Wysong standard deep throat design with large, ground and polished radii permits deep bends of wide material the full length of the bed without costly special throats and frames.

Die holder

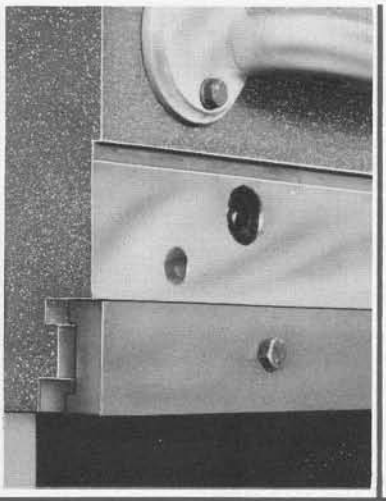
A full length die holder (filler block) is provided as standard equipment on all Wysong press brakes. This sturdy steel die holder will accommodate both large and small, standard or special dies. All Wysong die holders have cutouts for hold-down bolts on close centers, thus adding to the accuracy of the die setup.

more features



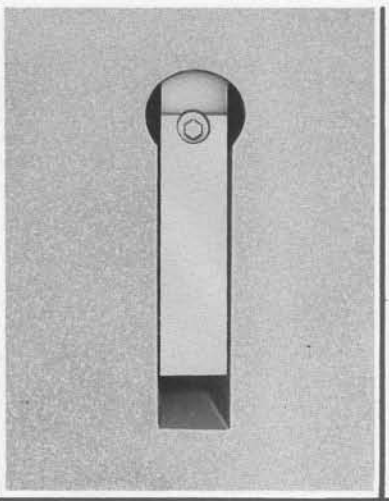
Standard back gauges

All Wysong press brakes feature as standard equipment, easily adjusted back gauges with full vertical and horizontal adjustment. They are mounted to the back of the bed and have reversible fingers for gauging narrow flanges. Should frequent gauging changes be required, much time may be saved through the use of a front-operated back gauge, which is available as optional equipment and for which all Wysong press brakes are pre-drilled.



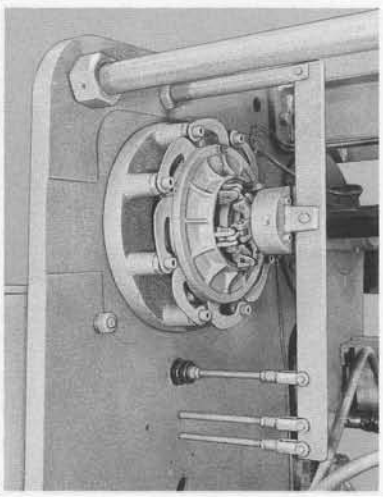
Ram clamping bars

Ram clamping bars are furnished in sections. Each section is fastened to the ram by screws on 12-inch centers. Replaceable, hardened, threaded insert bushings are pressed into the ram to receive the clamping bar bolts.



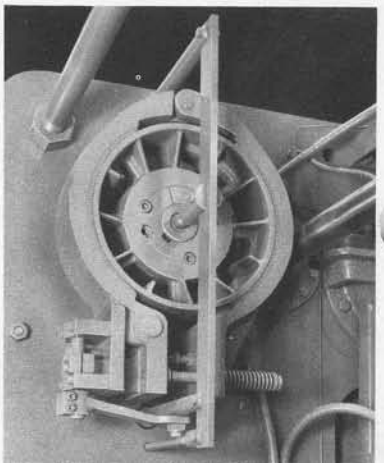
Solid bed support

Wysong's floating suspension provides solid bed support at critical mounting points. This suspension is achieved through the use of machined saddle blocks.

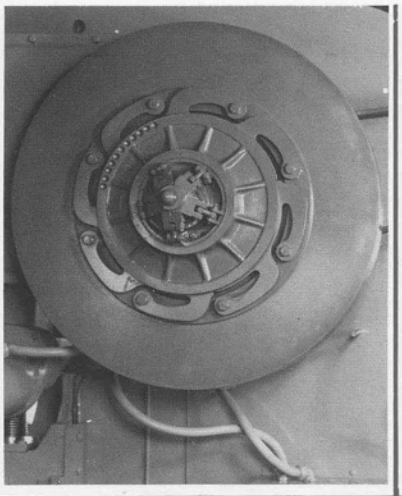


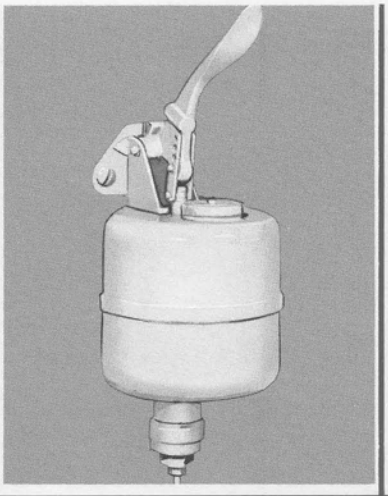
Positive spring-loaded disc and shoe brakes

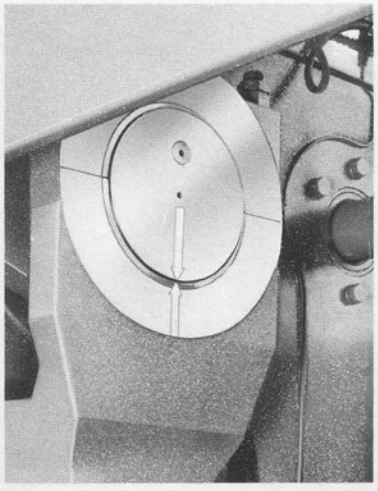
The positive action disc brake utilized on Series 55 and 90, is interlocked with the spring loaded Flex-Disc clutch, to avoid overlapping of functions. Series 120 to 225 utilizes a self energizing shoe type brake. Both types stop ram as clutch is released providing operator with positive control of ram at any point in the stroke. Both assemblies are readily accessible for easy maintenance.

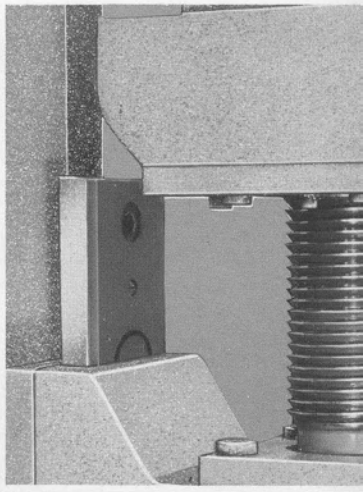


WYSONG press brakes









Powerful disc clutch assembly

On all series, the powerful and responsive hydraulically-actuated Disc-type clutch is mounted on the drive shaft. It is sensitive for instant response and allows inching through any point of the ram stroke. The clutch assembly is easily accessible for adjustments should any maintenance be required.

Centralized lubrication system

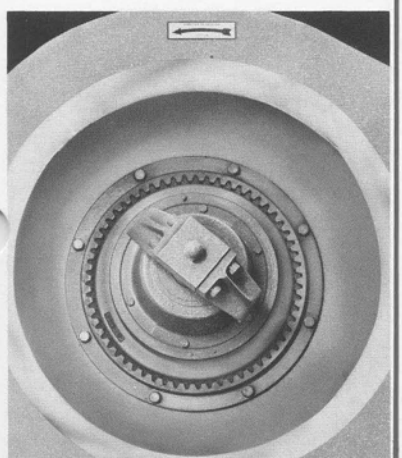
The central lubrication system on Wysong press brakes is a manually operated pressure system which delivers oil to the various lube points. The higher speed main reduction gears operate constantly in an oil bath, while this system meters lubrication under pressure to the pitmans, intermediate shafts, eccentric bearings, ram housing gibs, etc. It is the most reliable and economical system for press brakes, affording one-shot positive lubrication control.

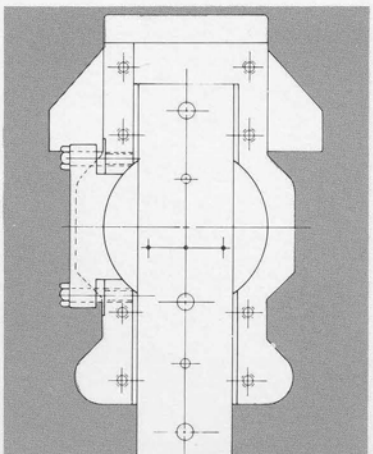
Bottom of stroke indicator

Wysong's bottom of stroke indicator gives quick visual reference to stroke position for further assistance in die setting or forming operations.

Non-metallic gibbing system

Laminated non-metallic ways and liners on rams prevent galling of bearing surfaces, simplify lubrication and permit closer running clearances.
These fibrous gibbing surfaces retain lubrication, assure accurate ram alignment and reduce wear to a minimum.

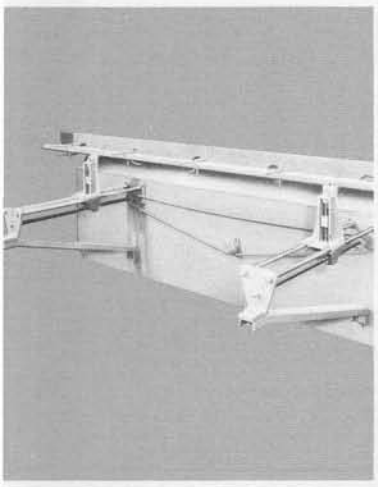




Swivel gibbing for tilting ram

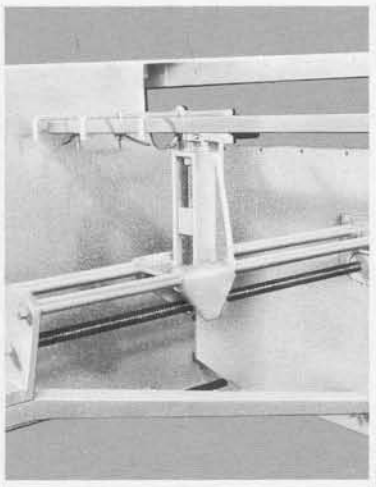
Tilting ram adjustment is a feature made possible through the use of swivel gibbing, which permits ram tilt without cramping the guide bearings. Dual indicators show amount of adjustment and tilt in thousandths of an inch, making accurate adjustment and return to parallel fast and easy. Thus, reproduction of work prior to tilt can be accomplished without trial.

optional features



Precision front-operated back gauge

For critical as well as frequent gauging changes, Wysong offers, as an additional option, the precision front-operated back gauge. Pre-drilled holes are provided in the bed for mounting this precision gauge.



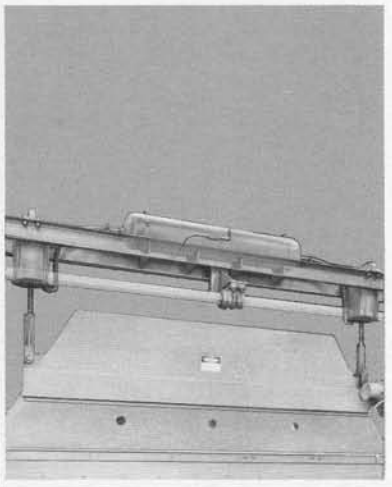
Triangular construction with double guide rods

The triangular construction with dual guide rods, in conjunction with the Saginaw ball screws and nuts, eliminates backlash, thus providing the ultimate in effortless, precise adjustment.



Precision front-operated back-gauge adjustment

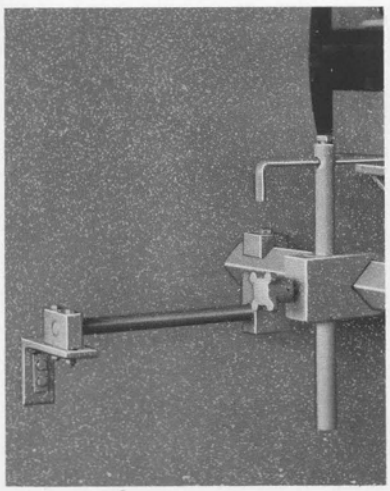
The precision front-operated back gauge comes with a direct reading dial indicator calibrated in thousandths of an inch.



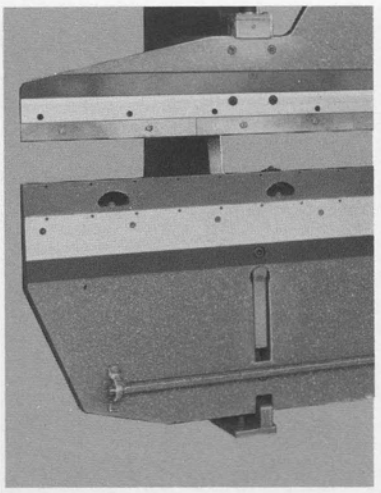
Air counterbalance system

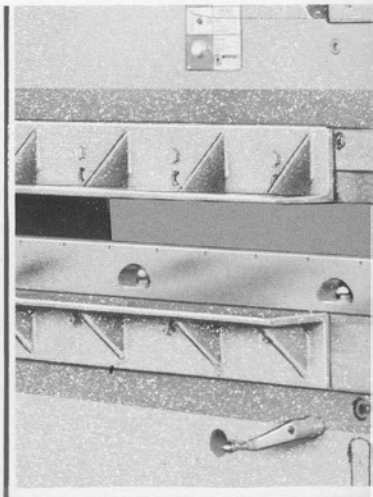
When unusually heavy dies or attachments are added, the press brake should always be equipped with air counterbalance. This will assure smoother brake operation with less wear and shock to the drive system. When punching, air counterbalance is required to offset shock. All series 90 through 225 press brakes are predrilled for field installation of air counterbalance.

WYSONG press brakes









Front-operated back gauge

To save time when frequent gauging changes are required, the front-operated back gauge is available as an option. This provides operator-convenience through a synchronized front control system. All Wysong press brake beds are pre-drilled for this installation.

Front-operated back gauge adjustment

The front-operated back gauge is designed to increase productivity and minimize set-up time.

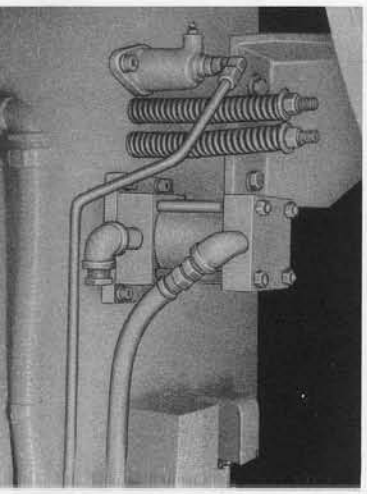
Bed and ram extensions

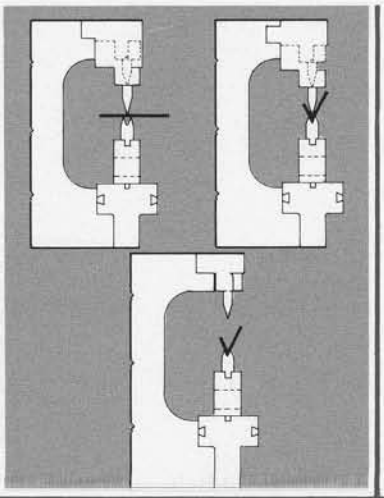
Wysong press brakes may be ordered with bed and ram extended beyond standard dimensions on either or both ends. This feature allows forming "Wrap-around" sections, tubular fabrication and other types of horning operations. These extensions provide additional forming length for lighter gauge materials.

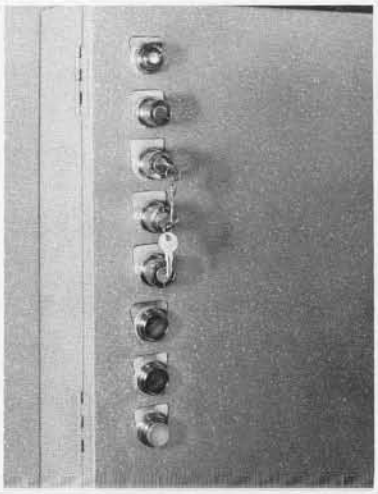
Angle brackets

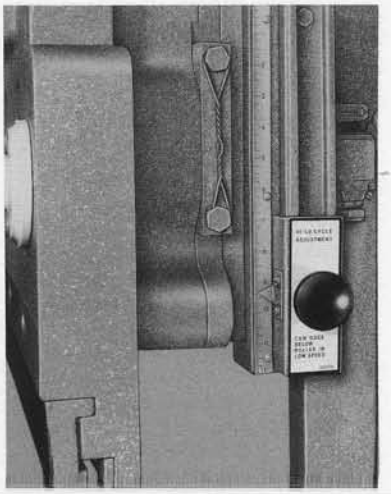
To increase the versatility of the press brake, Wysong offers as an option, beds and rams machined and pre-drilled to accept angle brackets. The working area of both bed and ram are thus increased to support punching or notching units, or wide die sets.

optional features









Combination hydraulic air actuated clutch brake control

An optional feature on Wysong press brakes is a combination of the standard hydraulic foot control or automatic air actuation of clutch and brake, allowing alternate choice operation of the press brake. When used as air actuated, it has automatic stop at the top of stroke and a selector switch is provided to give the operator a choice of "inch" or "run" modes of operations. For more intricate setups requiring sensitive control or slipping of the clutch, the standard hydraulic control may be used.

Auto speed control

This is a system designed to automatically duplicate the control that a skilled press brake operator applies when forming wide flanges. The ram approaches the work piece at high speed. At a pre-set point in the stroke (usually just before the die touches the work) the gearing automatically shifts into low speed. The bending phase of the cycle is completed at low speed, eliminating "Back Bending". The gearing then automatically shifts back to high speed and the ram returns to the top of the stroke and stops.

Control panel features two selector switches

Three-position INCH-OFF-RUN selector — inch position: Ram will inch throughout entire stroke as long as palm buttons are depressed. Ram will stop at top of stroke.
Run position: Foot switch or palm buttons must remain depressed until ram passes bottom of stroke and reaches a pre-set position. At this point it will return to the top-of-stroke automatically. Before ram can recycle, operator must release operating control and depress again.
Four position: HI-LOW-HI/LOW HI/STOP/LOW selector —
HI position: This position allows machine to operate at high speed.
LOW position: This position allows machine to operate at a fraction of its high speed.
HI/LOW position: This position allows machine to operate at high speed until the ram reaches a pre-determined point. At this point, it automatically shifts into low speed for the working portion of the stroke. It then returns to the top of the stroke at high speed.
HI/STOP/LOW position: This mode operates at two speeds as previously described with the following addition. At a pre-set point, just before the die touches the work, the ram automatically stops. The operating control is then re-activated to form the work at low speed.

tonnage table

Metal Thickness		Width of Vee Die Opening																				
Gauge	Inches	¼″	5/16″	⅜″	7/16″	½″	5/8″	¾″	⅞″	1″	1⅛″	1¼″	1½″	2″	2½″	3″	3½″	4″	5″	6″	7″	8″	10″	12″
20	0.036	3.1	2.3	1.7	1.4	1.1																		
18	0.048	5.3	4.0	3.0	2.5	2.2	1.7	1.3																
16	0.060	9.6	7.1	5.6	4.5	3.8	2.8	2.2	1.8	1.5														
14	0.075		11.9	9.2	7.6	6.3	4.7	3.5	3.0	2.5	2.1	1.8												
12	0.105				16.7	13.1	9.7	8.0	6.5	5.6	4.6	4.1	3.2											
11	0.120					19.2	14.2	11.1	9.0	7.5	6.3	5.5	4.4	2.9										
10	0.135						18.6	14.5	11.9	9.9	8.5	7.3	5.8	4.0										
3/16	0.188							27.4	23.1	19.3	16.4	14.3	11.2	7.5	5.7	4.4								
¼	0.250									39.4	33.3	29.5	22.7	15.4	11.4	9.0	7.4	6.1						
5/16	0.313											50.4	39.8	27.0	19.7	15.3	12.7	10.5	7.7					
⅜	0.375												61.6	42.3	30.9	24.0	19.6	16.3	12.3	9.5				
7/16	0.438													61.7	45.8	35.4	28.6	24.4	17.3	14.8	11.2			
½	0.500													85.2	63.6	48.8	39.7	33.3	24.6	19.4	15.9	13.1		
5/8	0.625														110.0	86.2	70.0	58.3	43.1	33.3	27.4	23.3	16.9	
¾	0.750															138.0	110.0	93.0	68.7	53.5	43.6	36.5	27.1	21.0
⅞	0.875																165.0	137.0	104.0	80.7	64.6	52.9	39.7	31.6
1	1.000																	197.0	143.0	113.0	91.2	76.2	56.3	44.2

Tons pressure required per lineal foot for bending (Bending mild steel with "Air Bend" dies)

Tonnages in the darker-color panels are for vee die openings eight times the thickness of the metal. These are generally used for average right angle bending work, giving an inside radius of the bend roughly equal to the metal thickness. When bending ordinary mild steel plates ½″ and thicker, it is usually necessary to use a vee die opening greater than eight times the metal thickness to prevent fracture. Tonnages in the lighter colored panels in the above chart are for vee die openings recommended for these heavier thicknesses.

Checklist of extras

Wysong press brakes:

- ☐ Auto-speed control
  HI-LOW-HI/LOW
  HI/STOP/LOW selector
- ☐ All selector switches are keylock type
- ☐ Combination hydraulic and air actuated clutch/brake control
- ☐ Special motors
- ☐ Special controls
- ☐ Air counterbalance
- ☐ Automatic lube system
- ☐ Increased throat gap
- ☐ Special bed slots
- ☐ Additional die space
- ☐ Bed and ram horn extension

Special back gauges:

- ☐ Front operated back gauge
- ☐ Precision front operated back gauge
- ☐ Motorized front operated back gauge

Wide bed and ram:

- ☐ Machined bed and ram for angles
- ☐ Bed and ram angle brackets

WYSONG®

press brakes



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