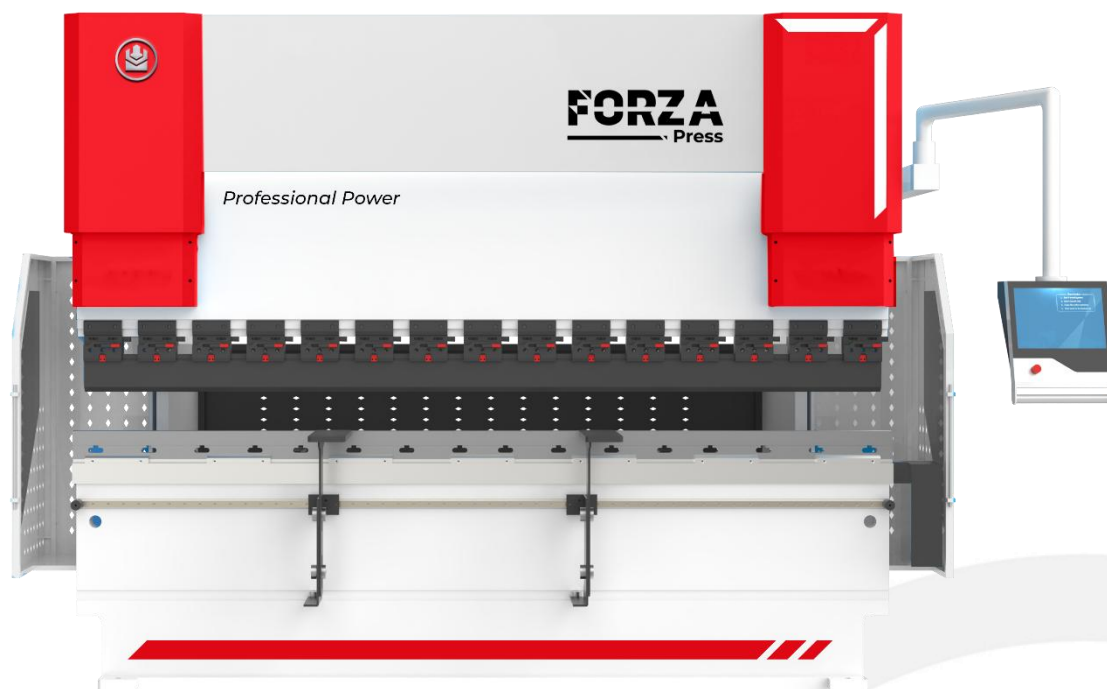




V250828

Datasheet
Model FXPXXTXX



FORZA Press

Robust 4+1 axis CNC hydraulic bending machine for high precision applications.

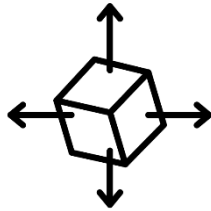
BENDING

The FORZA Press is engineered with advanced CNC technology for bending processes, ideal for industrial applications that demand maximum precision, repeatability, and automatic control, ensuring consistent results even on complex parts and in large production runs.

Built with a Q235B steel frame, it provides structural rigidity and dynamic stability, enabling the manufacturing of high-demand components such as panels, automotive parts, metal furniture, or machinery structures, ensuring a long service life with low maintenance.

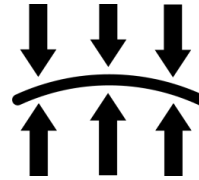
Special Features

4+1 Control Axis



The standard version features 4+1 degrees of freedom to position the sheet with greater precision in complex operations. It is possible to upgrade to 6+1 or 8+1 axes.

Crowning Technology



The V-axis automatically compensates for sheet deflection, resulting in precise and straight bends along the entire workpiece.

High strength machine bed



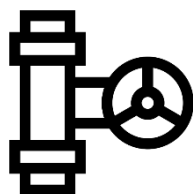
The machine is built from heat-treated Q235B steel plates, and all steel plate joints have relief grooves to ensure the strength of the entire machine.

Delem DA53T controller



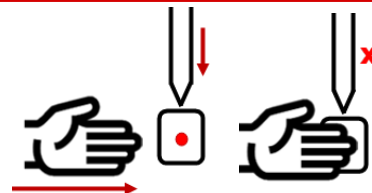
The Delem controller is the most widely used in CNC press brake applications. It features a color touchscreen, simple bending programming, and automatic correction functions, ensuring intuitive use and a comfortable learning curve.

Bosch-Rexroth hydraulic system



Premium hydraulic components guarantee the machine's operation under demanding conditions (18 MPa) and reduced maintenance throughout the machine's life cycle.

Laser protection system



A laser interlock safety system. When the machine is in the bending process, a laser sensor detects if the operator's hand enters and immediately stops the process, ensuring the well-being of the operator and the machine.

Bending Capacity

MODEL	MAX BENDING FORCE	MAX BENDING LENGTH		BENDING THICKNESS FOR FULL LENGTH ⁽¹⁾								
				CARBON STEEL			STAINLESS STEEL			ALUMINUM		
				mm	in	Gauge	mm	in	Gauge	mm	in	Gauge
FXP25T80	80	2500	8.2	4.75	3/16	7	4.25	5/32	8	5.5	7/32	5
FXP32T80	80	3200	10.5	4.25	5/32	8	3.75	5/32	9	5	3/16	6
FXP25T130	130	2500	8.2	5.75	7/32	4	5.25	3/16	6	7	9/32	3
FXP32T130	130	3200	10.5	5.25	3/16	6	4.75	3/16	7	6.25	1/4	3
FXP25T200	200	2500	8.2	7	9/32	3	6.25	1/4	3	8.25	5/16	-
FXP32T200	200	3200	10.5	6.25	1/4	3	5.75	7/32	4	7.5	9/32	2
FXP32T320	320	3200	10.5	13	1/2	-	11.75	7/16	-	15.75	19/32	-
FXP42T320	320	4200	13.8	11.5	7/16	-	10.5	13/32	-	14	17/32	-
FXP60T320	320	6000	19.7	10	3/8	-	9	11/32	-	12	15/32	-
FXP32T400	400	3200	10.5	14.5	9/16	-	13	1/2	-	17.25	21/32	-
FXP42T400	400	4200	13.8	12.75	1/2	-	11.5	7/16	-	15.25	19/32	-
FXP60T400	400	6000	19.7	11	7/16	-	10	3/8	-	13.25	1/2	-
FXP32T600	600	3200	10.5	17.25	21/32	-	15.5	19/32	-	20.5	13/16	-
FXP42T600	600	4200	13.8	15.25	19/32	-	13.75	17/32	-	18.25	23/32	-
FXP60T600	600	6000	19.7	13	1/2	-	11.75	7/16	-	15.75	7/32	-

1. The maximum thickness corresponds to a sheet with the full bending length. For shorter lengths, greater thicknesses can be used. For more information, consult the following bending force calculator: <https://support.forzaser.com/calculadora-fuerza-de-doblado/>. If you wish to bend thicknesses greater than 6mm, a die for thick materials must be requested.

Main Features

FEATURES	DETAIL
Application	Bending of metal sheets
Control Axes ⁽¹⁾	X-Y ₁ -Y ₂ -R + V (4+1)
Control Software	DELEM DA53T
Bending Angle Precision ⁽²⁾	±0.3°~0.5°
Punch Positioning Precision (Y ₁ - Y ₂)	±0.0004in 0.01 mm
Back Gauge Positioning Precision (X - R)	±0.001in 0.03 mm

1. The Y axes correspond to the vertical hydraulic cylinders. The X and R axes control the back gauge positioning. The V (+1) axis performs the sheet deflection compensation (crowning).
2. The angle accuracy applies to "air bending," where it depends on the punch's travel. In "bottom bending," the final angle exactly matches that of the die, provided the material adapts correctly to the tool.

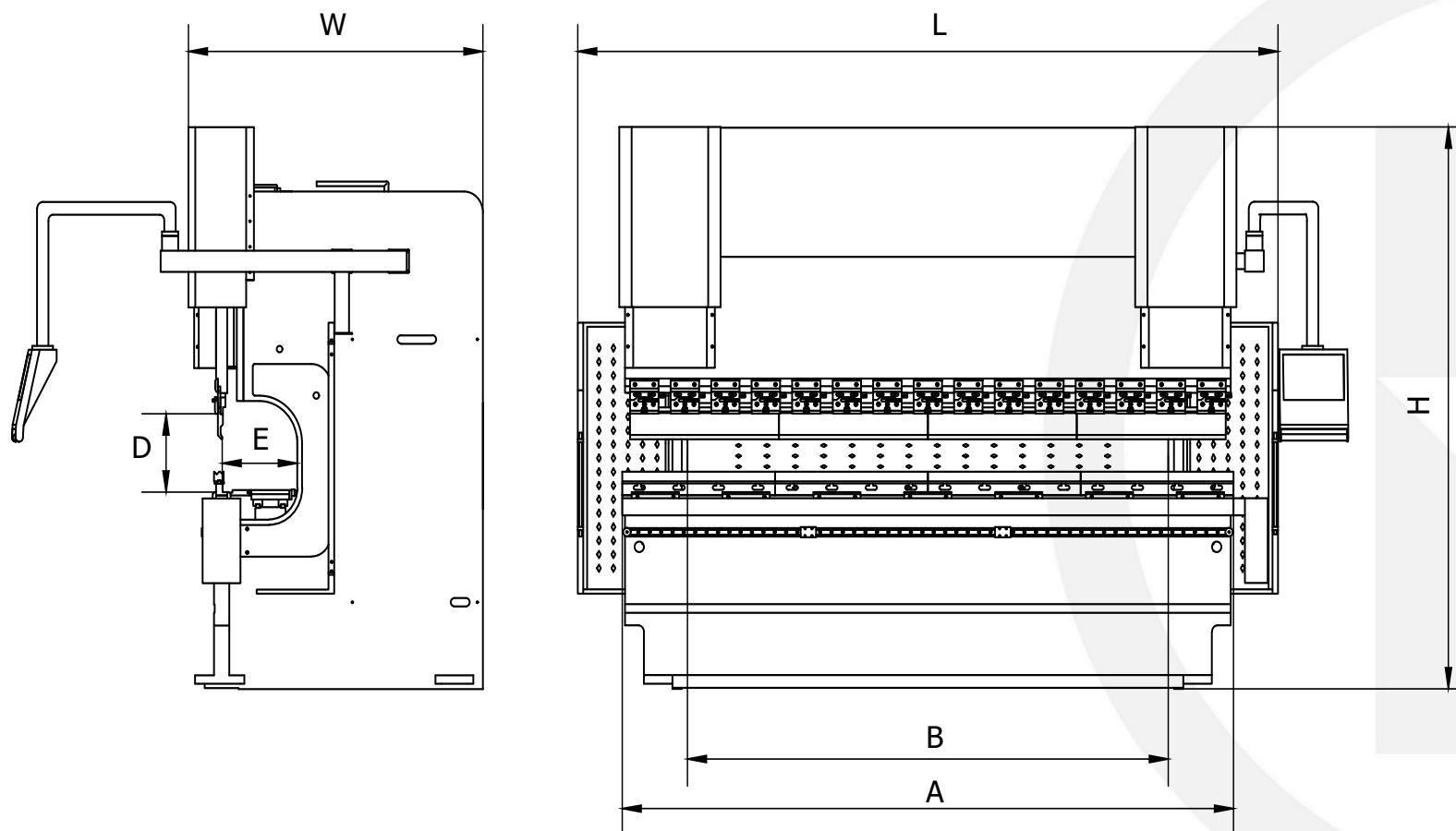
General Features

MODEL	OIL TANK VOLUME ISO 46 ⁽¹⁾		SPEEDS						MAIN MOTOR POWER	MAXIMUM EQUIPME NT POWER	MAXIMUM CURRENT PER LINE 220V-3ph	THERMO- MAGNETIC SWITCH (MCCB) @220V-3ph	REQUIRED CONDUCTOR GAUGE UP TO MCCB @220V-3ph ⁽²⁾	
			APPROACH		APPROACH		APPROACH							
	L	gal	mm/s	in/s	mm/s	in/s	mm/s	in/s					kW	kW
FXP25T80	200	53	180	7.1	0-10	0-0.4	160	6.3	7.5	13	37.9	40	3 x 8AWG + 1 x 10AWG(PE)	3 x 10AWG + 1 x 10AWG(PE)
FXP32T80	200	53	180	7.1	0-10	0-0.4	160	6.3	7.5	13	37.9	40	3 x 8AWG + 1 x 10AWG(PE)	3 x 10AWG + 1 x 10AWG(PE)
FXP25T130	200	53	180	7.1	0-10	0-0.4	160	6.3	11	16	46.7	50	3 x 6AWG + 1 x 10AWG(PE)	3 x 8AWG + 1 x 10AWG(PE)
FXP32T130	220	58.5	180	7.1	0-10	0-0.4	160	6.3	11	16	46.7	50	3 x 6AWG + 1 x 10AWG(PE)	3 x 8AWG + 1 x 10AWG(PE)
FXP25T200	400	105.5	140	5.5	0-10	0-0.4	120	4.7	15	20	58.3	60	3 x 4AWG + 1 x 10AWG(PE)	3 x 6AWG + 1 x 10AWG(PE)
FXP32T200	400	105.5	140	5.5	0-10	0-0.4	120	4.7	15	20	58.3	60	3 x 4AWG + 1 x 10AWG(PE)	3 x 6AWG + 1 x 10AWG(PE)
FXP32T320	440	116.5	110	4.3	0-8	0-0.3	100	3.9	22	28	81.7	90	3 x 3AWG + 1 x 8AWG(PE)	3 x 4AWG + 1 x 8AWG(PE)
FXP42T320	520	137.5	110	4.3	0-8	0-0.3	100	3.9	22	28	81.7	90	3 x 3AWG + 1 x 8AWG(PE)	3 x 4AWG + 1 x 8AWG(PE)
FXP60T320	650	172	100	3.9	0-8	0-0.3	100	3.9	22	28	81.7	90	3 x 3AWG + 1 x 8AWG(PE)	3 x 4AWG + 1 x 8AWG(PE)
FXP32T400	720	190.5	100	3.9	0-8	0-0.3	100	3.9	30	36	104.9	110	3 x 1AWG + 1 x 6AWG(PE)	3 x 3AWG + 1 x 6AWG(PE)
FXP42T400	720	190.5	100	3.9	0-8	0-0.3	90	3.5	30	36	104.9	110	3 x 1AWG + 1 x 6AWG(PE)	3 x 3AWG + 1 x 6AWG(PE)
FXP60T400	850	225	90	3.5	0-7	0-0.28	90	3.5	30	36	104.9	110	3 x 1AWG + 1 x 6AWG(PE)	3 x 3AWG + 1 x 6AWG(PE)
FXP32T600	1000	264.5	90	3.5	0-7	0-0.28	90	3.5	45	51	148.7	150	3 x 2/0AWG + 1 x 6AWG(PE)	3 x 1/0AWG + 1 x 6AWG(PE)
FXP42T600	1000	264.5	90	3.5	0-7	0-0.28	90	3.5	45	51	148.7	150	3 x 2/0AWG + 1 x 6AWG(PE)	3 x 1/0AWG + 1 x 6AWG(PE)
FXP60T600	1200	317	90	3.5	0-7	0-0.28	90	3.5	45	51	148.7	150	3 x 2/0AWG + 1 x 6AWG(PE)	3 x 1/0AWG + 1 x 6AWG(PE)

1. This value corresponds to 100% of the tank. However, it is recommended to fill the oil tank to between 70-80% of its total capacity.

2. The cable gauge sizing was based on Table 310-15(b) (16) of NOM-001-SEDE for maximum conductor temperatures of 60°C and 90°C respectively, considering an installation in conduit. In case of an open-air cable installation, a smaller gauge than shown in this document could be used after consultation with the FORZA Laser technical department.

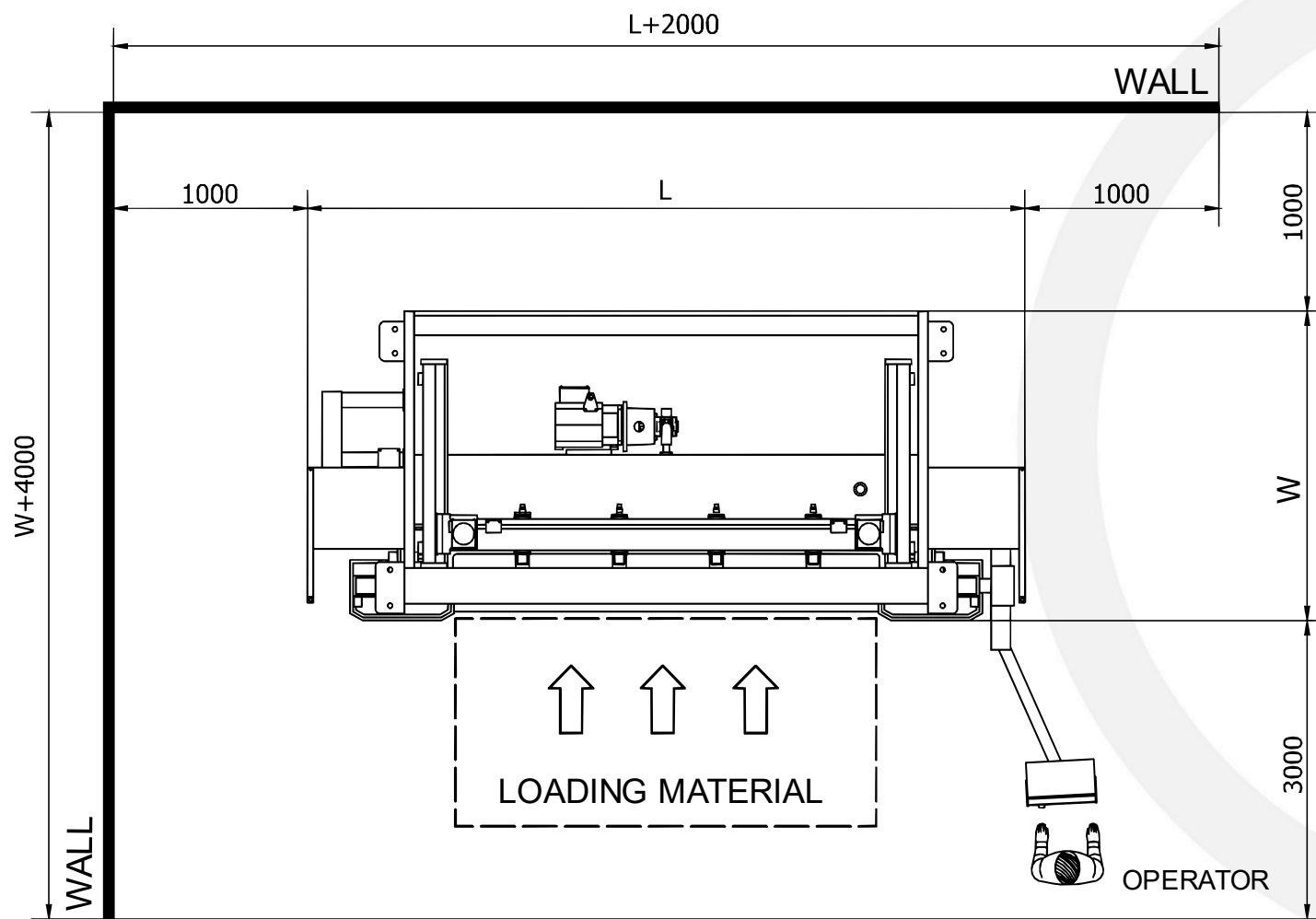
Machine Dimensions



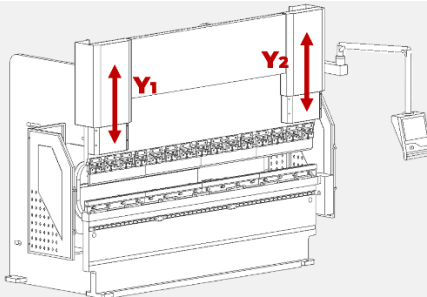
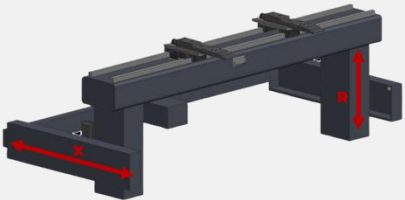
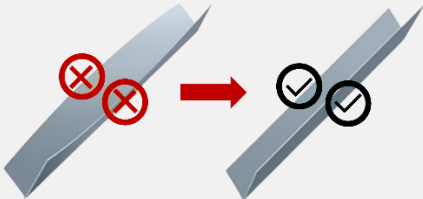
The following values are for reference; they may vary slightly depending on the equipment version

MODEL	WEIGHT		A: BENDING LENGTH		B: DISTANCE BETWEEN SUPPORTS		E: THROAT DEPTH		D: OPENING HEIGHT		CYLINDER STROKE		GENERAL DIMENSIONS					
													L: LENGTH		W: WIDTH		H: HEIGHT	
	kg	lb	mm	ft	mm	ft	mm	ft	mm	ft	mm	ft	mm	ft	mm	ft	mm	ft
FXP25T80	5500	12125	2500	8.2	2100	6.9	350	1.2	460	1.5	160	0.5	3200	10.5	1350	4.4	2450	8
FXP32T80	6000	1320	3200	10.5	2600	8.5	350	1.2	460	1.5	160	0.5	3900	12.8	1350	4.4	2450	8
FXP25T130	6400	14110	2500	8.2	2100	6.9	400	1.3	480	1.6	200	0.7	3200	10.5	1515	5	2630	8.6
FXP32T130	6800	14990	3200	10.5	2600	8.5	400	1.3	480	1.6	200	0.7	3900	12.8	1515	5	2630	8.6
FXP25T200	9200	20280	2500	8.2	2100	6.9	400	1.3	480	1.6	200	0.7	3200	10.5	1730	5.7	2725	8.9
FXP32T200	9350	20615	3200	10.5	2600	8.5	400	1.3	480	1.6	200	0.7	3900	12.8	1730	5.7	2725	8.9
FXP32T320	14800	32630	3200	10.5	2600	8.5	500	1.6	530	1.7	250	0.8	3900	12.8	1990	6.5	3200	10.5
FXP42T320	18000	39685	4200	13.8	3400	11.2	500	1.6	530	1.7	250	0.8	4900	16	1990	6.5	3200	10.5
FXP60T320	26500	12020	6000	19.7	4800	15.7	500	1.6	530	1.7	250	0.8	6700	22	2050	6.7	3620	11.9
FXP32T400	18000	39685	3200	10.5	2600	8.5	500	1.6	600	2	300	1	3900	12.8	2070	6.8	3300	10.8
FXP42T400	22000	48500	4200	13.8	3400	11.2	500	1.6	600	2	300	1	4900	16	2070	6.8	3400	11.2
FXP60T400	35000	77160	6000	19.7	4800	15.7	500	1.6	600	2	300	1	6700	22	2190	7.2	3950	13
FXP32T600	41000	90390	3200	10.5	2600	8.5	600	2	670	2.2	300	1	3900	12.8	2650	8.7	4550	14.9
FXP42T600	41000	90390	4200	13.8	3400	11.2	600	2	670	2.2	300	1	4900	16	2650	8.7	4550	14.9
FXP60T600	52000	114640	6000	19.7	4800	15.7	600	2	670	2.2	300	1	6700	22	2650	8.7	4750	15.6

Required Space

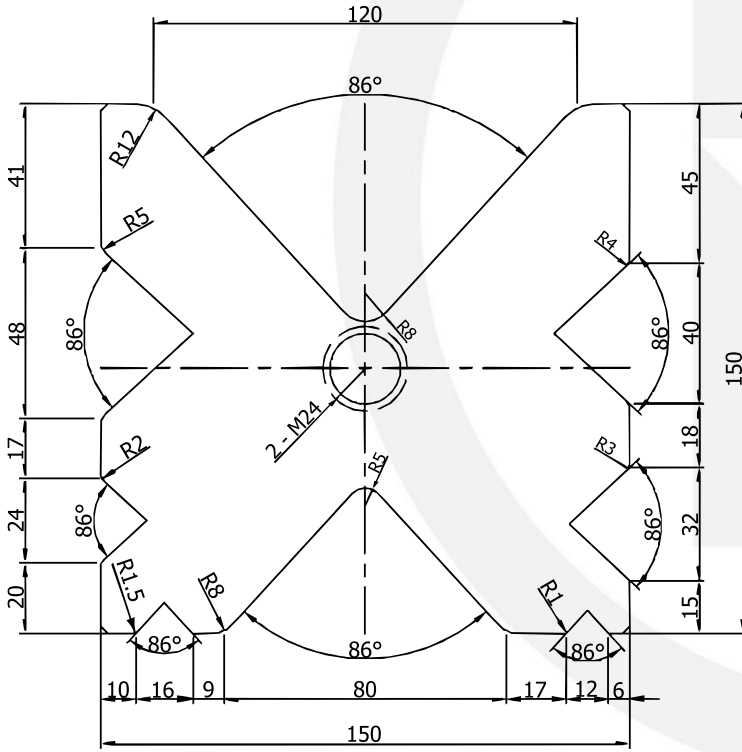
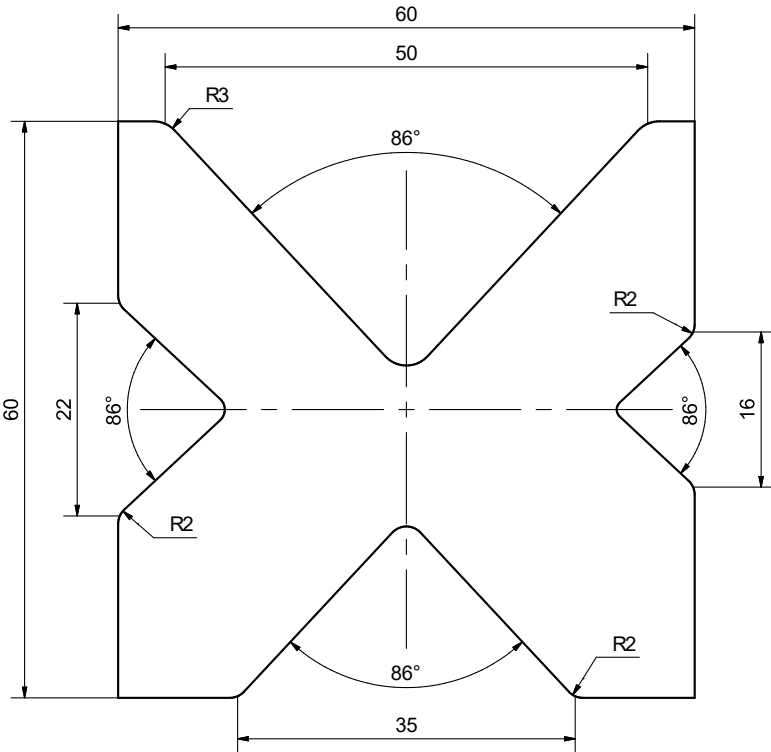


4+1 control axes

AXES		
AXIS	FUNCTION	DIAGRAM
Y1	Controls the stroke of the hydraulic cylinders at each end.	
Y2		
X	Longitudinal control of the back gauge.	
R	Vertical control of the back gauge.	
+ V	Sheet deflection compensation.	

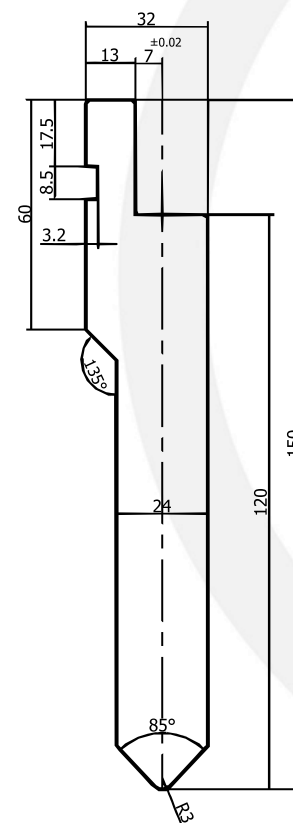
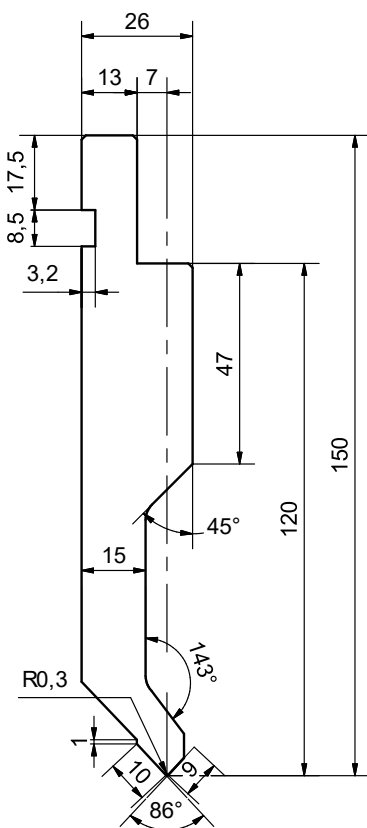
Standard Tooling

DIE	
Integral heat treatment	Hardness HRC47±2°
Dimensional tolerance	±0.02mm
Flatness tolerance	±0.02mm
Total length	Depends on the length of the equipment model
OPTION FOR THIN AND MEDIUM THICKNESSES, (UP TO 6mm 1/4in – MACHINES UP TO 320TON)	OPTION FOR MEDIUM AND THICK THICKNESSES, (OVER 6mm 1/4in – MACHINES FROM 320TON)



NOTE: The machine includes only one die option selected according to the customer's requirements. It is not possible to include both sets; the choice must be made at the time of purchase, based on the type of work that will be performed most frequently.

PUNCH	
Integral heat treatment	Hardness HRC47±2°
Dimensional tolerance	±0.02mm
Flatness tolerance	±0.02mm
Total length	Formed by sections according to the equipment length
OPTION FOR THIN AND MEDIUM THICKNESSES, (UP TO 6mm 1/4in – MACHINES UP TO 320TON) OPTION FOR MEDIUM AND THICK THICKNESSES, (OVER 6mm 1/4in – MACHINES FROM 320TON)	



NOTE: The machine includes only one punch option, selected according to the customer's requirements. It is not possible to include both sets; the choice must be made at the time of purchase, based on the type of work that will be performed most frequently.

Packing List

- ❑ 1 x FORZA Press Machine 
- ❑ 1 x Control Pedals with Emergency Stop 
- ❑ 4 x Leveling Plates 
- ❑ 4 x Leveling Bolts 
- ❑ 4 x J-Type Anchor Bolts with Nuts 
- ❑ 1 x ESTUN E21 Controller 
- ❑ 1 x Laser Protection System for Operators (DSP) 
- ❑ 1 x Hydraulic Pump 
- ❑ 1 x Pressure Gauge with Connection Hose 
- ❑ 1 x Support Structure for Work Plates 

- TOOLBOX -

- ❑ 1 x Plastic Toolbox 
- ❑ 1 x Manual Oil Can 
- ❑ 1 x Metric ALLEN Wrench Set 
- ❑ 1 x Open-End Wrench 11-13mm 
- ❑ 1 x Grease Gun 
- ❑ 1 x Phillips Screwdriver 
- ❑ 1 x Adjustable Wrench 
- ❑ 1 x Set of O-rings 

- LICENSES -

- ❑ 1 x ESTUN **Software** License
- ❑ 1 x 1-Year **FORZA Vectors** License
- ❑ 1 x 1-Year Full **FORZA Academy** License
- ❑ 1 x 4-Year **Super 7 SUPPORT** License

- CONSUMABLES -

- ❑ 1 x Set of Dies 
- ❑ 1 x Set of Punches 

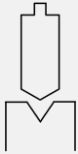
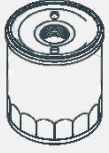
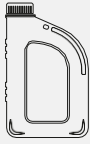
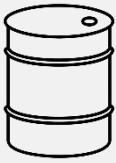
- POWER CABLES AND CONDUIT -

- ❑ 10 m x Metal Conduit 
- ❑ 10mx Cable 3x__ AWG + 1x__AWG, B-M (T:Ring-Tip) @220v3ph 
- ❑ 10mx Cable 3x__ AWG + 1x__AWG, B- M (T:Ring-Tip) @250v3ph 
- ❑ 10mx Cable 3x__ AWG + 1x__AWG, B- M (T:Ring-Tip) @380v3ph 
- ❑ 10mx Cable 3x__ AWG + 1x__AWG, B- M (T:Ring-Tip) @440v3ph 
- ❑ 10mx Cable 3x__ AWG + 1x__AWG, B- M (T:Ring-Tip) @480v3ph 

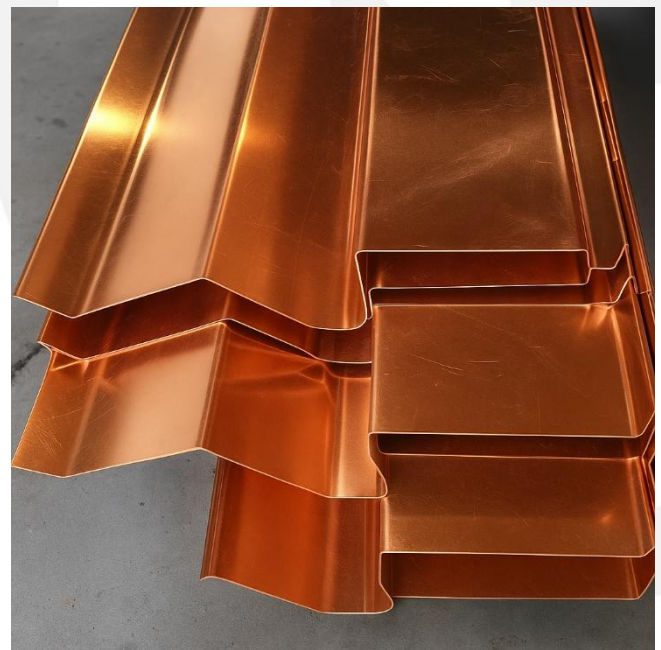
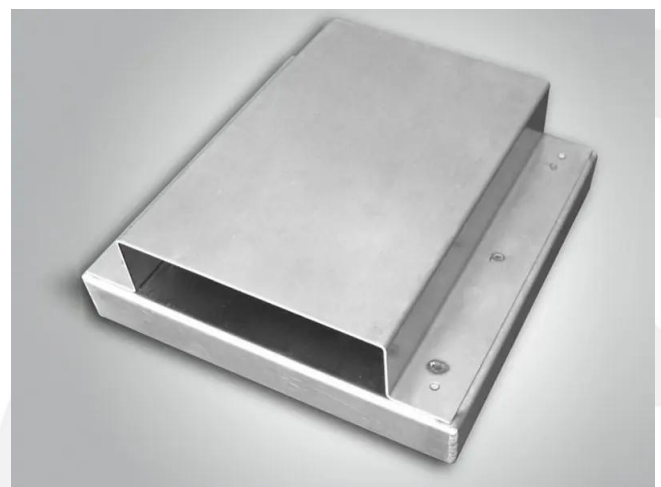
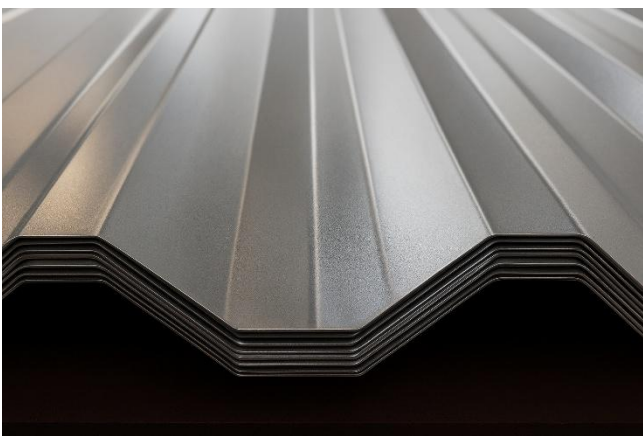
* Reference cables are TW-type insulation

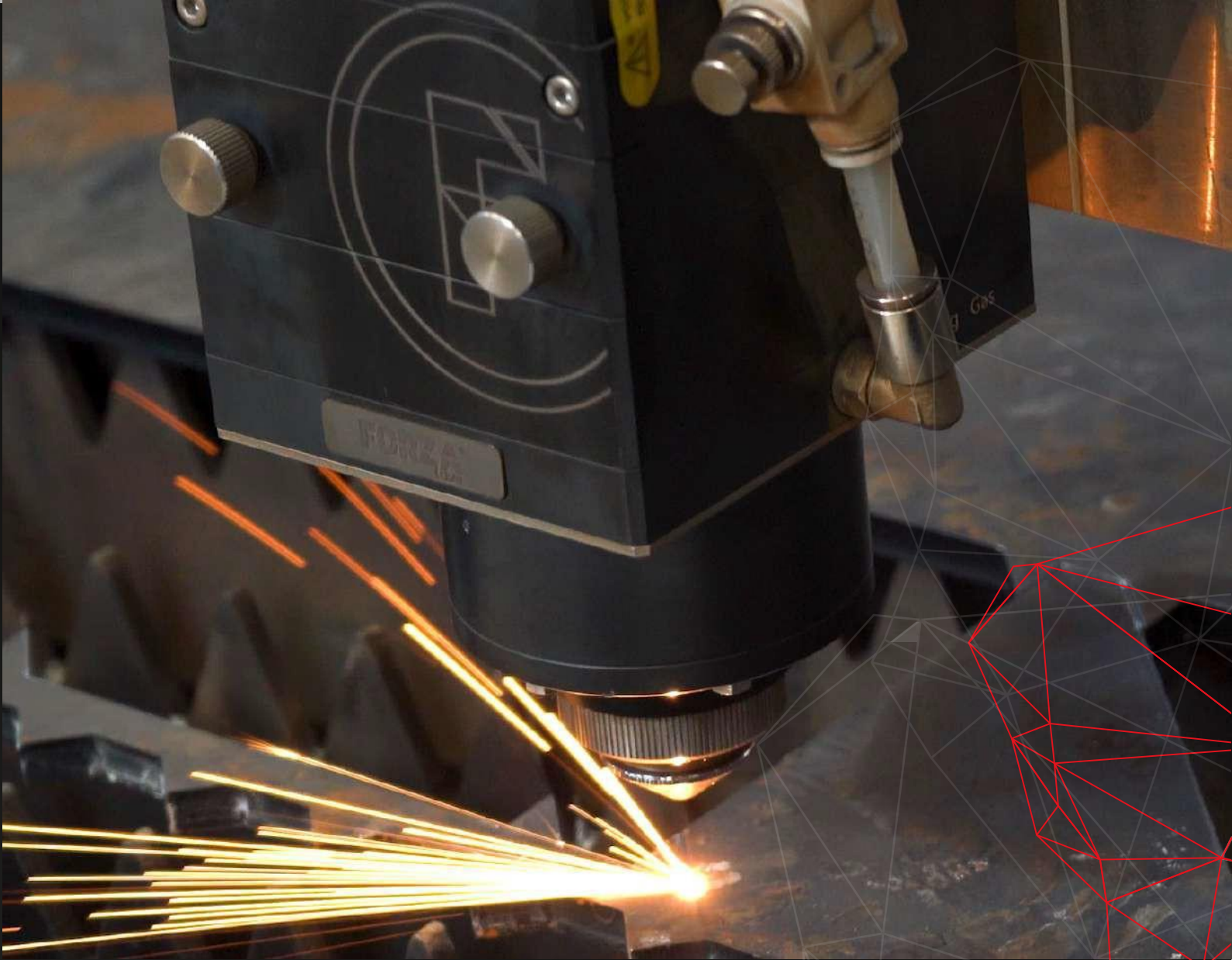
Transport symbols:  (Package),  (Inside the package),  (Installed on the machine).

Consumables

IMAGE	ITEM	DESCRIPTION	LIFESPAN
	Die and Punch	Made of ultra-resistant 42CrMo material, they need to be resharpened or replaced after several years of use.	Not specified
	Oil Filter	Needs to be replaced to ensure the purity of the oil in the hydraulic system.	2000 – 4000 hours
	Blue Lithium Grease	For lubricating specific points such as bearings and guide rails.	100 – 500 hours
	Lubrication Oil, ISO 68	For moving parts and transmission systems.	100 – 500 hours
	Anti-Wear Mineral Hydraulic Oil, ISO 46	Replacement or refilling of the tank depending on the level and quality of the oil.	2000 – 4000 hours

Manufactured Parts





At FORZA Laser, laser specialists, our team has everything you need to take your business to the next level.

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