HORIZONTAL HYDRAULIC PRESS BRAKE

The versatility of the 20 Tons, Horizontal Press Brake NARGESA PP200 allows us to bend, fold, bend, cut, form, enlarge and reduce flaring, swaging, assembling ... all kinds of metal materials such as iron, steel, stainless, copper, brass, aluminum etc ... Its simplicity when it comes to work and its easy handling so users can adapt their forming dies make this Horizontal Press machine to be indispensable in any kind of business from small workshops to large companies. Our experience in this sector enables us to offer constantly renewed and competitive machines.

REQUEST QUOTATION

Please fill up the following form. We will contact you in less than 24 hours.

Working days

VIDEO MACHINE OPERATION

COMING SOON - Machine performance video

Follow us on Facebook, YouTube, Instagram, Twitter, LinkedIn
Pipe bending at fixed radius up to 150º could be considered one of the good features of these presses.

Cutting, piercing and punching flat bars or metal sheets turn this horizontal bending press into a punching shears machine.

Stretching and reducing pipes on the ends in order to make parts that fit or weld later.

It is also a solution to bend different profiles at different radius and keeping the ends straight, like when manufacturing handles and flanges.

Cold forge uses horizontal presses to make and form different shapes of balusters.

Tube notching to assemble at 90 degrees.

Folding operations with wrought iron machines permit to completely bend the parts or pieces unlike conventional flat bar section bending machines.
TECHNICAL FEATURES

Its robustness, versatility and easy handling are just three of the best features our hydraulic horizontal bending machine has..

> Folding operation with no risk of damaging the punches and dies with thick materials unlike conventional press brakes.
> Folding flat bars and sheets into completely close shapes. Conception of this horizontal bending press brake allows to make folding operations impossible to be carried out on a conventional press brake.
> Fast tool change, punches and dies: This change does not take more than 30 seconds most of the times.
> A set of punch and folding die is supplied along with the machine.
> Performance by a safety double activation hold pedal.
> Low noise level, improving the quality of work of the operator.
> The machine is shipped completely assembled and ready to work.
> Palletized lower bench to easily transport the machine up to its working or storage site.
> Dies support shelf included.
> Lateral stop to place it right or left.

Hydraulic System
> Monoblock hydraulic power unit with positioning and pressure regulation valves
> The hydraulic system can be regulated by means of pressure adjustment valves that affect the piston force.
> Pressure regulator with pressure gauge that allows to control the force carried out at any time.

Control Panel
> Programming mode: Manual or Automatic.
> Piece counter.
> Digital display in different languages
> Alarm diagnosis system

* All our products are manufactured in our facilities in Spain. Hydraulic and electrical components are all standard from the best leading European trademarks with technical support all over the world: Rexroth, Bosch, Roquet, Schneider Electric, LG, Telemecanique, Pizzato...
Displacement control
Continuous control of the work stroke by means of a hydraulic valve that guarantees maximum precision in folding or other operations. Inductive sensor that guarantees a repeatability of 0.05mm.

Guided hydraulic cylinder
The hydraulic cylinder placed on the work bench allows us to transfer all the force directly on the tools. Fully guided hydraulic piston to prevent any bending during the folding operation.

Cylindrical fastening bolts
Cylindrical fastening bolts easy to install, to guarantee maximum firmness to the tools during machining operations. Plugs to prevent the residues of the folding from entering inside the machine.

Work table without frame
The work bench is frameless, this is great for the movement of the parts to be machined for there isn't any element that obstructs its movement. The table is manufactured in a 60mm monoblock of welded steel, stabilized and machined. The operator’s working position must be at the side of the machine for accomplishing a better vision and control, as well as greater safety for the user since he will be outside the radius of action of the tools.
The advantage of the Horizontal Bending Press PP200 is to have a really simple head drive so that all our customers can adapt any die manufactured by themselves.

To add more options when fastening tools, the workbench has a series of clamping holes distributed throughout the area to ease up the fixing.

If you need a special die, Prada Nargesa offers a technical support to all our customers who wish to make their own tools. Moreover, we have an extra service for designing and manufacturing exclusive tooling on request, for each of the machines we manufacture.
**DETAILED FEATURES**

- **Working strength**: 20 Ton. (200 KN).
- **Working speed**: 9,8 mm/s.
- **Return speed**: 35 mm/s.
- **Maximum displacement**: 250 mm.
- **Repetitivity**: 0,05 mm.
- **Bench size**: 600x1170 mm.
- **Working height**: 950 mm.
- **Engine power**: 2.2 KW / 3 CV a 1400 r.p.m.
- **Electric Tension**: 230 / 400 V three-phased
  
  *For Single-phased machines, please ask the manufacturer.*

- **Intensity**: 9/5 A.
- **Hydraulic pressure**: 50 a 215 Kg/cm2.
- **Hydraulic pump**: 7,5 litres/minute
- **Tank Capacity**: 27 litres
- **Machine dimensions**: 760x1174x1150 mm.
- **Weight**: 625 Kg.
EXTERNAL DIMENSIONS

CHARACTERISTICS OF THE PACKAGING

- Tariff Item Code: 84624990
- The machine is delivered completely mounted.
- Packaging with wooden pallet NIMF15 and 3-layered cardboard box suitable for sea freight.
- Optional: Complete wooden packaging NIMF15.

<table>
<thead>
<tr>
<th>Width</th>
<th>700 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Length</td>
<td>1250 mm</td>
</tr>
<tr>
<td>Height</td>
<td>1400 mm</td>
</tr>
<tr>
<td>Volume</td>
<td>1,23 m³</td>
</tr>
<tr>
<td>Nett weight</td>
<td>625 Kg</td>
</tr>
<tr>
<td>Gross Weight</td>
<td>650 Kg</td>
</tr>
</tbody>
</table>
STANDARD TOOLING PROVIDED ALONG WITH THE MACHINE

Folding die at 100 mm · V 16, 22, 35, 50 mm

Folding or bending die up to 100mm with 4 openings (16, 22, 35, 50mm) and a punch of 80°. This multi-V die allows 1mm up to 8mm sheet to be folded. The 70mm outer diameter punch allows to make completely closed shapes to a minimum of 75mm inner wing.

V 16: Sheet from 1 to 3mm
V 22: Sheet from 2 to 4mm
V 35: Sheet from 3 to 6mm
V 50: Sheet from 4 to 8mm
Max. Folding length: 100mm
Max. Folding thickness: 8mm

Download folding chart

OPTIONAL TOOLING

Baluster forming die 01

REF: 140-16-01-00001
Die to form cold forging balusters for grills, gates, fences, handrails...

For other shapes or capacities, request the manufacturer.

Optional tooling

<table>
<thead>
<tr>
<th>Max. width</th>
<th>Thickness</th>
<th>Die length</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>20mm</td>
<td>4, 5, 6, 8mm</td>
<td>656mm</td>
<td>21Kg</td>
</tr>
</tbody>
</table>
Ring forming

**REF:** 140-16-01-00003
Die to form rings or English banister railing, used as ornamental piece in forging railings, gates, fences... for bars bonding.

*For other shapes or capacities, request the manufacturer.*

**Optional tooling**

<table>
<thead>
<tr>
<th>Max. width</th>
<th>Thickness</th>
<th>Outer sizes</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>50mm</td>
<td>6mm</td>
<td>90mm</td>
<td>9,3Kg</td>
</tr>
</tbody>
</table>

Baluster forming die 04

**REF:** 140-16-01-00004
Die to form cold forging balusters for grills, gates, fences, handrails...

*For other shapes or capacities, request the manufacturer.*

**Optional tooling**

<table>
<thead>
<tr>
<th>Square sizes</th>
<th>Die length</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>5, 6, 8, 10, 12, 14, 16, 18mm</td>
<td>600mm</td>
<td>20,5 Kg</td>
</tr>
</tbody>
</table>

Bending tool for big radius

**REF:** 140-16-01-00006
Die to form curves in flat bars, pipes, bars or profiles at big radius. It's perfect for bending small series or special parts without requiring a specific custom mold.

**Optional tooling**

<table>
<thead>
<tr>
<th>Maximum bar capacity</th>
<th>Maximum pipe capacity</th>
<th>Minimum diameter</th>
<th>Maximum diameter</th>
</tr>
</thead>
<tbody>
<tr>
<td>40mm or 1 1/2&quot;</td>
<td>80x80 mm or 3&quot;</td>
<td>300mm</td>
<td>There is no maximum</td>
</tr>
</tbody>
</table>
Baluster forming die 08

REF: 140-16-01-00008
Die to form cold forging balusters for grills, gates, fences, handrails...

For other shapes or capacities, request the manufacturer.

Optional tooling

<table>
<thead>
<tr>
<th>Max. width</th>
<th>Thickness</th>
<th>Die length</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>20mm</td>
<td>4, 5, 6, 8mm</td>
<td>650mm</td>
<td>19.5Kg</td>
</tr>
</tbody>
</table>

Baluster forming die 09

REF: 140-16-01-00009
Die to form cold forging balusters for grills, gates, fences, handrails...

For other shapes or capacities, request the manufacturer.

Optional tooling

<table>
<thead>
<tr>
<th>Flat bar size</th>
<th>Die length</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>5, 6, 8, 10, 12mm</td>
<td>522mm</td>
<td>22Kg</td>
</tr>
</tbody>
</table>

Baluster forming die 10

REF: 140-16-01-00010
Die to form cold forging balusters shaped parts for grills, so called “belly top railing”.

For other shapes or capacities, request the manufacturer.

Optional tooling

<table>
<thead>
<tr>
<th>Flat bar size</th>
<th>Die length</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>12mm</td>
<td>1165mm</td>
<td>50Kg</td>
</tr>
</tbody>
</table>
Baluster forming die 11

**REF:** 140-16-01-00011

Die to form cold forging balusters for grills, gates, fences, handrails...

*For other shapes or capacities, request the manufacturer.*

**Optional tooling**

<table>
<thead>
<tr>
<th>Flat bar size</th>
<th>Die length</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6, 8, 10, 12mm</td>
<td>760mm</td>
<td>32.5Kg</td>
</tr>
</tbody>
</table>

Twisted bars forming die

**REF:** 140-16-01-00013

Die to bend metal plate, flat bar or square bar to obtain a nice braid twisted effect. It’s very used to make fences and grills

For flat bar from to 6, 12 and 14mm.

*For different sizes, please ask the manufacturer*

**Optional tooling**

<table>
<thead>
<tr>
<th>Max. capacity</th>
<th>Min. capacity</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>Square 14 mm</td>
<td>2x40 mm metal sheet</td>
<td>18Kg</td>
</tr>
</tbody>
</table>

Flat bar cutting tooling 100x10mm

**REF:** 140-16-01-00014

Flat bar and metal sheet cutting die up to 100mm through a maximum thickness of 10mm in mild steel.

**Optional tooling**

<table>
<thead>
<tr>
<th>Max. Cutting length</th>
<th>Max. Cutting thickness</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>100mm</td>
<td>10mm</td>
<td>23Kg</td>
</tr>
</tbody>
</table>
Die to bend square or rectangular pipe

**REF:** 140-16-01-00015

Tool to bend square pipe or bar at given or specific degrees. Technical drawing or sample pieces are required.

*Optional tooling*

<table>
<thead>
<tr>
<th>Maximum capacity</th>
<th>Maximum bending</th>
</tr>
</thead>
<tbody>
<tr>
<td>30mm or 1’1/4 x 3mm thickness</td>
<td>120° - 150°</td>
</tr>
</tbody>
</table>

Tool to shape pipe ends

**REF:** 140-16-01-00016

Basic die to modify the ends of the tubes for their assembly. You can make all kinds of shapes and flaps according to the customer needs.

*For special forms consult the manufacturer.*

*Optional tooling*

Weight: 110 Kg aprox.

Diameter reduction tools

Composed by the clamp holder to reduce tube and the reduction clamp.

This accessory is adapted to the Tooling to shape pipe ends, to perform the operation of reducing the ends of the tubes, for its coupling.

*Optional tooling*

*We can find the different sizes in the following PDF file:*  

[PDF]
Diameter expansion tools

Composed by the Clamp Holder to Expand, Expansion Mandrel and the Expander Clamp.
This accessory is adapted to the Tooling to shape pipe ends, to perform the operation of expanding the ends of the tubes, for its coupling

Optional tooling

We can find the different sizes in the following PDF file:

Die to straighten out profiles

REF: 140-16-01-00017
Tool used to bend straight profiles or parts. It is adjustable to different capacities according to the profiles.

Maximum capacity: H 120mm
Weight: 72Kg.

Optional tooling

Die to bend special profiles

REF: 140-16-01-00018
Die to bend or fold different profiles such as U, T angle etc… with other specific radius and degrees. Technical drawing or sample pieces are required.

Optional tooling
Hinges making tool

REF: 140-16-01-00019
Die to manufacture hinges depending on the customer's requirements. Technical drawing or sample pieces are needed for the manufacturing.

Optional tooling

Baluster forming die 20

REF: 140-16-01-00011
Die to form cold forging balusters for grills, gates, fences, handrails...

For other shapes or capacities, request the manufacturer.

Optional tooling

<table>
<thead>
<tr>
<th>Square sizes</th>
<th>Circumference size</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>12mm</td>
<td>760mm</td>
<td>32.5Kg</td>
</tr>
</tbody>
</table>

Punching die

REF: 140-16-01-00022
Punch-holder die, compatible with our Nargesa brand punches.
Gooseneck: 54 mm
Free distance of tooling: 95 mm
Weight: 52Kg

Optional tooling

<table>
<thead>
<tr>
<th>Capacidad máx. Punzonado</th>
<th>Round</th>
<th>Square</th>
<th>Rectangular</th>
<th>Oval</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>43mm</td>
<td>35mm</td>
<td>20x34mm</td>
<td>21x40mm</td>
</tr>
</tbody>
</table>
Promecam punch holder

REF: 140-16-01-00023
Punch holder for all kind of punches for Promecam bending or folding press.
Compatible with any Promecam punch.

Optional tooling

<table>
<thead>
<tr>
<th>Max. Folding length</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>150mm</td>
<td>14kg</td>
</tr>
</tbody>
</table>

Clamp forming die

REF: 140-16-01-00024
Die to form all kinds of clamps. This tooling is manufactured according to the user’s needs thus it is required to have a technical drawing or a sample piece.

Maximum capacity: 100x4mm

Optional tooling

Bar clamps forming die

REF: 140-16-01-00028
Clamp forming die, used to manufacture the clamps used to join different forging bars with no need to get them welded.

Optional tooling

<table>
<thead>
<tr>
<th>Max. capacity</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>25x5mm</td>
<td>9Kg</td>
</tr>
</tbody>
</table>
Special punches

Folding punches to bend special pieces of small sizes or folded up to 30°.

1. **Nº1**
   - Folding Punch D70 30°
   - REF: 140-16-01-00025
   - Max. Folding length: 100mm
   - Punch degrees: 30°
   - Punch diameter: 70mm
   - Weight: 3Kg approx.

2. **Nº2**
   - Folding Punch D40 80°
   - REF: 140-16-01-00026
   - Max. Folding length: 60mm
   - Punch degrees: 80°
   - Punch diameter: 40mm
   - Weight: 3Kg approx.

3. **Nº3**
   - Folding Punch D22 80°
   - REF: 140-16-01-00027
   - Max. Folding length: 60mm
   - Punch degrees: 80°
   - Punch diameter: 22mm
   - Weight: 3Kg approx.

**Optional tooling**

Forming die adaptor

REF: 140-16-01-00029

It is an exchangeable fitting device for the forming dies, suitable for each of the different baluster forming tools. It is advisable to get one in order to work with the specified dies.

**Weight: 3,1 Kg**

**Optional tooling suitable for all forming dies**
Promecam Punches

Promecam punches of different shapes to bend and manufacture complex part. There are a lot more shapes, please consult the manufacturer.

1

Nº1 Punch Promecam PS.135.85.R08 PP200
REF: 140-16-01-00030
Folding length: 150mm
Weight: 3,2 Kg.

2

Nº2 Punch Promecam P.95.35.R5 PP200
REF: 140-16-01-00031
Folding length: 150mm
Weight: 2,3Kg.

3

Nº3 Punch Promecam PS.134.30.R08 PP200
REF: 140-16-01-00032
Folding length: 150mm
Weight: 2,7Kg.

Optional tooling

Die to bend round pipe DIN 2440

REF: 140-16-01-00037
Tool to bend round pipe in specific degrees.

For tube:
Ø 3/8' or 17,2 mm
Ø 1/2' or 21,3 mm
Ø 3/4' or 26,9 mm
Ø 1’ or 33,7 mm
Ø 1’1/4 or 42,4 mm
Ø 1’1/2 or 48,3 mm
Máx: 120º
## Dies to fold thick metal sheet

Promecam dies of different openings to fold sheets, flat bars or thicker plate sections up to 15mm. in order to fold even thicker sizes, ask the manufacture.

<table>
<thead>
<tr>
<th>No</th>
<th>Folding die</th>
<th>Code</th>
<th>Folding length</th>
<th>Thickness</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>T80.25.35 PP200</td>
<td>140-16-01-00036</td>
<td>150mm</td>
<td>From 1.5 to 5mm</td>
<td>4Kg.</td>
</tr>
<tr>
<td>2</td>
<td>M75-85-63 PP200</td>
<td>140-16-01-00033</td>
<td>150mm</td>
<td>From 5 to 10mm</td>
<td>5Kg.</td>
</tr>
<tr>
<td>3</td>
<td>M80-85-80 PP200</td>
<td>140-16-01-00034</td>
<td>150mm</td>
<td>From 6 to 12mm</td>
<td>6Kg.</td>
</tr>
<tr>
<td>4</td>
<td>M95-80-100 PP200</td>
<td>140-16-01-00035</td>
<td>150mm</td>
<td>From 8 to 15mm</td>
<td>9Kg.</td>
</tr>
</tbody>
</table>

Optional tooling
Round, square, oval and rectangular punches and dies

At Nargesa we own a wide catalog for punches and dies of all kinds. If the size the customer needs is not in the list, we manufacture it. In the PDF file you will be able to see all kinds and sizes we have.

*Optional tooling*

*Technical features* [PDF]

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Matriz de abocardar tubo

Dies for notching pipes from Ø16 to Ø50mm. It crops the pipe end so it could be joined perpendicularly to another pipe.

*Optional tooling*

*Technical features* [PDF]

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Matriz redondear esquinas

Die to get metal sheet corners rounded at different radius.

*Optional tooling*

*Technical features* [PDF]

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Matrices de orejetas

Tool to fabricate all kinds of tabs, with or without perforation, straight or rounded... they are very used as clamps, handles etc. Starting from a metal strip, there will be obtained one piece of the desired length at every stroke.

*Optional tooling*

*Technical features* [PDF]
OUR RANGE OF MACHINERY

- Iron Workers
- Section Bending Machines
- Horizontal Press Brakes
- Twisting/Scroll Bending Machines
- Gas Forges
- Hydraulic Press Brakes
- Hydraulic Shear Machines
- Iron Embossing Machines
- End Wrought Iron Machines
- Power Hammers
- Broaching Machines
- Welding Positioners
- Presses for Locks
Nargesa machines have 3 years warranty provided that the customer registers it in our website. Otherwise it would be only one year warranty. This one encloses any manufacturing default all along these 3 years for components. Any misuse is excluded from this condition. Labor, back and forth shipping and any eventual repair, are not included in this warranty.

Partner companies

Nargesa will arrange transport up to final destination, whenever the customers asks for so. There is also the possibility for the customer to arrange the shipment himself with his own agency.

All our customers have access to technical support quickly and efficiently. 90% of incidences are solved out on the phone, mail, Skype or videoconferencing in less than 24 hours. In case of needing presencial technical assistance, we may as well send a technician to the customer’s facilities.