OFFICE OF THE SHERIFF

COUNTY OF LOS ANGELES

HALL OF JUSTICE

ROBERT G. LUNA, SHERIFF

March 11, 2025

The Honorable Board of Supervisors
County of Los Angeles
383 Kenneth Hahn Hall of Administration
500 West Temple Street
Los Angeles, California 90012

Dear Supervisors:

REQUEST TO AUTHORIZE THE ACQUISITION AND INSTALLATION OF ONE CINCINNATI HS SERIES HYDRAULIC SHEAR AND CINCINNATI 135XFe HYDRAULIC PRESS BRAKE FOR THE LOS ANGELES COUNTY SHERIFF'S DEPARTMENT FOR FISCAL YEAR 2024-25 (ALL DISTRICTS) (3-VOTES)

SUBJECT

The Los Angeles County (County) Sheriff's Department (Department) is requesting the Board to authorize the acquisition of two pieces of sheet metal fabrication equipment: one Cincinnati HS Series Hydraulic Shear for the estimated cost of $342,000 and one Cincinnati 135XFe Hydraulic Press Brake for the estimated cost of $343,000. These purchases exceed the capital asset threshold established by the Board and require your approval to move forward with the acquisition process.

IT IS RECOMMENDED THAT THE BOARD:

Authorize the Internal Services Department (ISD), as the County's Purchasing Agent (CPA), to proceed with the solicitation and acquisition of one Cincinnati HS Series Hydraulic Shear and one Cincinnati 135XFe Hydraulic Press Brake for the estimated total amount of $685,000, which includes equipment, shipping, labor for installation, bonds, and taxes.

PURPOSE/JUSTIFICATION OF RECOMMENDED ACTION

The Department is the primary law enforcement organization for millions of County residents and manages the largest county jail population in the United States. With the continuous evaluation of incarcerated individuals who require higher security housing in the Department custody environment, the Department has had to increase the level of security to protect the sworn staff, professional staff, and those in custody. In addition to increased security precautions, there are also constant procedural and regulatory changes that are implemented per Title 15 for the safety and well-being of the incarcerated population.

The Department's Facilities Services Bureau (FSB) has been one of the primary resources in increasing the security infrastructure within the custody environment, from the jails to Sheriff's stations. The FSB is tasked with continuous repairs and modification of the custody facilities to safely and properly operate the custody facilities. These facilities are primarily built out of concrete and steel. With the purchase of these two specialized pieces of fabrication equipment, the Department's in-house production will save the Department time and money and will allow for specifically customized repairs utilizing the fabrication of various heavy gauge sheet metal products utilized to maintain and increase security within these facilities.

The Department currently has several older, outdated machines that require constant maintenance and repairs to keep them operational. The new equipment would allow for a significantly larger and more efficient work product to better serve the Department's patrol stations and custody facilities, all of which require very specific, fabricated items for the safety and security of staff as well as the incarcerated population.

- Power Press Break is a machine used to bend, shape, and form various thickness and sizes of sheet metal flat sheets, metal bars, and other metal products for the fabrication of various sheet metal items utilized in all Department facilities.

- Hydraulic Power Shear is a machine used to cut various thickness of sheet metal and bar stock material to sizes required to fabricate various sheet metal-related products utilized at all Department facilities.

Implementation of Strategic Plan Goals

The requested actions support the County Strategic Plan's North Star II: Foster Vibrant and Resilient Communities; Focus Area C: Enhance the safety of the public and our communities by addressing the risks, danger, harm, and conditions that cause, drive, or can help mitigate unlawful activity and crime and supports law enforcement accountability and transparency; Strategy I Prevention, Protection & Security: Support and invest in innovative practices, crime prevention resources, and infrastructure to provide protection and security.

FISCAL IMPACT/FINANCING

The total estimated cost for one Cincinnati Hydraulic Shear and one Cincinnati Hydraulic Brake is $685,000, which includes equipment, shipping, installation, training, and commissioning. Funding has been identified within the Department's operating budget via AB109 funding.

FACTS AND PROVISIONS/LEGAL REQUIREMENTS

Law enforcement is tasked with the primary mission of protecting lives and property. Additionally, the Department has legal obligations through Title 15 to provide a safe environment for the incarcerated population. Adherence to these obligations has required ongoing renovations and reconfigurations within custody facilities, most of which are handled through FSB. The acquisition of these specialized machinery tools would provide a tremendous benefit to the FSB operations, thus allowing the crafts personnel to make emergency repairs and customized fabrication of items needed within the Department's patrol stations and custody facilities.

On October 6, 2001, the Board approved the classification categories for fixed assets and new requirements for major fixed assets (now referred to as capital assets) acquisitions requiring County departments to obtain Board approval to purchase or finance equipment with a unit cost of $250,000 or greater, prior to submitting their requestion to ISD.

The acquisition of the equipment falls within the statutory authority of the CPA. Therefore, Board approval is required for the CPA to proceed with the aspect of the acquisition of one Cincinnati Hydraulic Shear and one Cincinnati Hydraulic Brake.

CONTRACTING PROCESS

The purchase is a brand-specific commodity purchase under the statuary authority of the CPA. The purchase will be requisitioned through and accomplished by the CPA in accordance with the County's purchasing policies and procedures.

IMPACT ON CURRENT SERVICES (OR PROJECTS)

There will be no negative impact on current County services or projects. The contractor will provide a timeline for delivery, installation, training, and commissioning and will not exceed the purchase order amount.

CONCLUSION

Upon Board approval, please return two copies of the adopted Board letter to the Department's Facilities Services Bureau and Administrative Services Division.

Sincerely,

R. Luna

ROBERT G. LUNA
SHERIFF

SOLE SOURCE/BRAND SPECIFIC JUSTIFICATION FORM

All negotiated transactions exceeding $5,000 must be reported to the Board of Supervisors.

Please check applicable box:

SOLE SOURCE - The product/service is exclusively available from only one supplier/source. **NOTE**: An item being a "sole brand" or a "sole manufacturer" does not automatically qualify a "sole source"as manufacturers sell their products through distributors.

BRAND SPECIFIC - A request that requires a specific brand name and/or model (also known as a "Do Not Substitute" request). The product may be available through various distributors.

Date:

Department:

RQN:

Commodity/Serivce

Vendor:

Total Amount of Purchase:

A Sole Source or Brand Specific must meet at least one of the following criteria:

(Check all that apply)

One-of-a-kind:
The commodity or service has no competitive product alternatives available.

Compatibility:
The commodity or service must match existing brand of equipment for compatibility.

Replacement Part:
The commodity is a direct replacement part for a specific brand of existing equipment and has no substitutes.

t№2Řdzǒǘ Proprietary:
The commodity or service №ŜIjdz№ŜY˙Ŝyǘă ǒl·y˙ƨyfề ōŜ Y˙Ŝǘ ōề ƨyfề ƨyŜ ØŜyŘ2№κădzLJLJfǘŜ№

Time Frame:
The department's required time frame for project completion is critical and cannot be exceeded without extreme hardship.

Service Continuity:
The cost to continue with the same service provider is less than the cost for any other vendor due to the time necessary to get "up to speed" (learning curve) with the project.

01. What is being requested?

02. Explain the reason that this product or service's unique features are indispensable to your operation:

03. Have other products been considered? List the products considered and reason for disqualification?

04. Will the item be an interface (match and inter-member), addition, or repair to the existing equipment? Identify the existing equipment and provide additional justification.

05. Was this product or service previously purchased? ***YES*** ***NO***
05a. If yes, please provide prior PO #.

06. Provide any other information relevant to the proprietary nature (ie. patents) of this product or service.

REQUESTOR NAME: **SIGNATURE:**

TITLE: **EMAIL:**

---------- **ISD USE ONLY** ----------

PURCHASING ANALYST: **DATE SUBMITTED:**

ADDITIONAL JUSTIFICATION (IF NEEDED): Describe all actions you have taken to reach your conclusion. Explain potential consequences for substitution of product/service. Include basis used to determine reasonableness of price and, if applicable, efforts to develop additional sources. Provide complete, brief, clear explanation. (Use reverse side of this sheet or attached additional sheet(s).

Board Summary:

ISD PURCHASING MANGEMENT'S APPROVAL:

Section Mgr. - $24,999.99 and under ----------

Division Mgr. - $25,000.00 and above ----------

(REV. 11/2022)

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(REV. 11/2022)

Division Mgr. - $25,000.00 and above ---------- _____

COUNTY OF LOS ANGELES

Los Angeles County Sheriff's Department

SPECIFICATIONS

E-Caps requisition #: _____ **Bid #:** _____

For: PURCHASE OF CINCINNATI CI XForme CNC PRESS BRAKE
(12' overall length)
FOR
SYBIL BRAND INSTITUTE (SBI) SHEET METAL SHOP
4500 E. CITY TERRACE DR. LOS ANGELES, CA 90063

BIDDER TO COMPLETE THE FOLLOWING INFORMATION:

Vendor: _____

Address: _____

City & Zip: _____

Contact Person: _____

Phone: _____ **Fax:** _____

NOTICE: Bidders shall state in the right-hand column of these pages wherein your product offered differs, indicating performance, specific size, and/or make and model of all components when not exactly as specified. When bidders is bidding items exactly as described in the left hand column, please state "AS SPECIFIED" on the right hand column, labeled as "BIDDER'S RESPONSE". Failure to return and fill in this form will be considered sufficient reason for rejection of your offer. Literature alone is not sufficient for consideration of your offer.

All equipment must meet California and County of Los Angeles safety requirements. The equipment shall be the latest model and shall not have been used as a demonstrator. Bidders shall submit detailed literature on the unit they propose to furnish.

REQUIREMENTS	INDICATE EXCEPTION FOR "AS SPECIFIED" BELOW
The Los Angeles County Sheriff's Department / Facilities Services Bureau require the services of a vendor for purchasing for the following location: Los Angeles County Sheriff **SYBIL BRAND INSTITUTE (SBI) SHEET METAL SHOP** **4500 E. CITY TERRACE DR. LOS ANGELES, CA 90063** These specifications are intended to assist the vendor. It is the vendor's responsibility to ensure that all applicable Federal, State, and local regulatory guidelines are met. The County of Los Angeles Sheriff's Department shall hereafter be referred to as "Owner". The vendor shall hereafter be referred to as "vendor". The vendor shall have a current State of California vendor's State Licensing Board (CSLB) license in good standing. VENDOR TO FURNISH: **CINCINNATI 135Xfe10 CNC PRESS BRAKE 12 FOOT TOTAL OVERALL DIE SURFACE HYDRAULIC PRESS BRAKE WITH THE FOLLOWING SPECIFICATIONS:** 1. CINCINNATI QUICK CLAMP RAM NOSE (BOLT ON) 2. DYNAMIC THICKNESS COMPENSATION. 3. AUTOMATIC LEVELING CONTROL SYSTEM WITH DUEL LINEAR ENCODERS (.00002" RESOLUTION) 4. 24" CNC 5-AXIS BACKGAGE. 5. 14" STROKE 6. 18" THROAT 7. CI BEND SIMULATION MODULE AND OFFLINE PROGRAMMING SOFTWARE. 8. FAST SETUP WORK SUPPORTS (TWO 15" WORK SUPPORTS 10' OF TRACK) 9. PROTECH SAFETY LIGHTS AND BRACKETS. 10. ELECTRICALLY INTERLOCKED END GUARDS. 11. HOLD TO RUN FOOTSWITCH (IN PLACE OF STANDARD). 12. 12' FILLER BLOCK. 13. CI PC-BASED OPERATOR CONTROL WITH WINDOWS OPERATING SYSTEM. 14. 22" TFT LCD FLAT PANEL DISPLAY WITH TOUCHSCREEN INTERFACE KEYBOARD AND TRACKBALL. 15. REMOTE MONITORING VIA COMPANY SERVER AND WEB BROWSER.	

REQUIREMENTS	INDICATE EXCEPTION FOR "AS SPECIFIED" BELOW
16. USB CONVENIENCE OUTLET 17. ETHERNET CONVENIENCE OUTLET. 18. AUTOMATIC TOOL LOAD TONNAGE CALCULATION 19. FORMING MODES (ANGLES, DTC, TONNAGE, ABSOLUTE POSITION). 20. QUICK BEND MODE 21. JOB SETUP SCREEN WITH MATERIAL TYPE, SETUP NOTES, TOOL LIST. 22. TRANSFER BUTTON FOR RAM POSITION. 23. CAD PART SHAPE DESIGN WITH FLAT BLANK SIZE CALCULATION. 24. PROGRAMMABLE RAM TILT, CLAMP AND RETRACT FUNCTION. 25. PROGRAMMABLE SPEEDS (FORMING AND RETURN. 26. PROGRAMMABLE UP/DOWN STROKE STOPS. 27. ELECTRICAL **460/3/60** 28. MACHINE START UP AND DEMONSTRATION, 29. OPERATOR TRAINING 30. SHIPPING, RIGGING AND SETTING ON SITE. **WARRANTY:** **5 YEAR PARTS/LABOR** **PRESS BRAKE PARTS, CONTROLS,** **BACKGAGE AND SERVICE LABOR.**	

REQUIREMENTS	INDICATE EXCEPTION FOR "AS SPECIFIED" BELOW

COUNTY OF LOS ANGELES

Los Angeles County Sheriff's Department

SPECIFICATIONS

E-Caps requisition #: _____ **Bid #:** _____

For: PURCHASE OF CINCINNATI 250HS10 HYDRAULIC SHEAR
(10' overall length)
FOR
SYBIL BRAND INSTITUTE (SBI) SHEET METAL SHOP
4500 E. CITY TERRACE DR. LOS ANGELES, CA 90063

BIDDER TO COMPLETE THE FOLLOWING INFORMATION:

Vendor: _____

Address: _____

City & Zip: _____

Contact Person: _____

Phone: _____ **Fax:** _____

NOTICE: Bidders shall state in the right-hand column of these pages wherein your product offered differs, indicating performance, specific size, and/or make and model of all components when not exactly as specified. When bidders is bidding items exactly as described in the left hand column, please state "AS SPECIFIED" on the right hand column, labeled as "BIDDER'S RESPONSE". Failure to return and fill in this form will be considered sufficient reason for rejection of your offer. Literature alone is not sufficient for consideration of your offer.

All equipment must meet California and County of Los Angeles safety requirements. The equipment shall be the latest model and shall not have been used as a demonstrator. Bidders shall submit detailed literature on the unit they propose to furnish.

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REQUIREMENTS	INDICATE EXCEPTION FOR "AS SPECIFIED" BELOW

HS SERIES

HS Series Hydraulic Shear

Prepared For

Company Name	LASD
City/State	LA,CA
Prepared By	MARK.HEIDENREICH@E-CI.COM
Technical Proposal No.	MAH-23-106R1
Submission Date	6-20-23

CINCINNATI follows the policy of continuous advancement in product development. For this reason, specifications, images and dimensions are for reference only and can change without notice. Foundation plans are furnished with each new machine installation.

Introduction

CINCINNATI hydraulic shears combine proven shearing technology and a rugged backgage for enhanced reliability, accuracy and performance. Cincinnati shears are manufactured in Harrison, Ohio and supported by factory field-based service representatives.

Key Benefits

Fast Setup

To minimize burr and blank distortion, different materials and thicknesses require different shear settings. With the Touchscreen Shear Control, the operator enters the number of steps and cuts, gage position, material thickness and type. The control positions the gage displays the knife clearance, commands the proper rake angle, and automatically advances to the next step. Repeat jobs can be saved in the internal memory or offline with the standard Ethernet port.

Accuracy

The shear incorporates a knife straightening system with push-pull bolts on 12” centers. This allows the knives to be set with extremely tight clearances for precision results along the entire length of the shear. A wide range of materials and thicknesses can be processed with variable rake angle and knife clearance. Low rake angle minimizes bow, twist and camber and knife clearance reduces burr in the part.

Cincinnati shears include a precision backgage with dual lead screws mounted in heavy duty frames. The cross shaft is located underneath the ram brace, away from lift trucks and crane hooks. Shock absorbing springs protect lead screws and alignment during material impact against the backgage. Backgage parallelism is maintained with micrometer adjusting nuts at the end of the backgage guides.

Durability

Cincinnati shears are the benchmark of the industry. A rugged frame and superior backgage provide years of dependable service. Steel frame members with interlocked construction eliminate stresses inherent with welded joints. A solid shear table and deep ram brace resist deflection during shearing. Clevis mounted cylinders reduce binding and twisting between the piston and cylinder to reduce oil leaks.

The control is designed as standard to operate in an ambient air temperature range of 32°F to 104°F. The hydraulic pump unit is designed to perform in an ambient temperature range of 50°F to 100°F. For ambient air temperatures outside of these ranges, please consult with Cincinnati Incorporated.

Safety

This shear is designed to meet the construction requirements of ANSI B11.4 and OSHA as evidenced by a compliance tag affixed to every new machine. Safeguarding covers all moving parts and areas of potential hazard. Glare resistant knife and holddown guards offer good vision of the work area while providing adequate safeguarding. Keylocked selector switches prevent unauthorized use and protect workers. Manuals on machine setup, operation or maintenance provide operators with details to properly operate and maintain the equipment safely.

250HS08 Technical Specifications

Specification	Standard	Metric
Capacities, Mild Steel For relative capacities of other materials refer to CINCINNATI Shear Capacities PT-30491. *Mild Steel defined as:* *Ultimate Tensile strength: 55,000 - 70,000 psi* *Yield strength: 35,000 - 50,000 psi* *Elongation (% in 2") 20-35%*		
• Maximum	.250"	6 mm
• Minimum	26ga	.5 mm
Cutting Length	98.75"	2,508 mm
Rake Angle (adjustable)	.234-.375"/ft	
Cycle Speed (Approximate) Expected cuts per minute can vary 5-15% less than free running spm depending on material thickness, tensile strength, knife condition, knife clearance and operator skill. Speed reduced 5/6 when 50 HZ service		
• Maximum, 12" (300mm) cut length with min rake	50 spm	50 spm
• Minimum, full length capacity at max rake	20 spm	20 spm
Frontgage Range (with optional front supports)	55"	1,397 mm
Holddowns		
• Holddown Type	Hydraulic	Hydraulic
• Number of Holddowns	10	10
Approximate base machine weight (does not include options, i.e. squaring arm support arms, etc.)	15,600 lbs.	7,076 kg
Backgage		
• Range	48"	1,219.2 mm
• Speed	60 IPM	1,524 mm/m
• Positioning	.005"	.13 mm
• Positioning Repeatability	± .002"	± .051 mm
Electrical	460/3/60	460/3/60
Motor Horsepower	25 HP	19 KW
Knife Type	A	A

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250HS10 Technical Specifications

Specification	Standard	Metric
Capacities, Mild Steel For relative capacities of other materials refer to CINCINNATI Shear Capacities PT-30491. *Mild Steel defined as:* *Ultimate Tensile strength: 55,000 - 70,000 psi* *Yield strength: 35,000 - 50,000 psi* *Elongation (% in 2") 20-35%*		
• Maximum	.250"	6 mm
• Minimum	26ga	.5 mm
Cutting Length	122.75"	3,118 mm
Rake Angle (adjustable)	.234-.375"/ft	
Cycle Speed (Approximate) Expected cuts per minute can vary 5-15% less than free running spm depending on material thickness, tensile strength, knife condition, knife clearance and operator skill. Speed reduced 5/6 when 50 HZ service		
• Maximum, 12" (300mm) cut length with min rake	45 spm	45 spm
• Minimum, full length capacity at max rake	20 spm	20 spm
Frontgage Range (with optional front supports)	55"	1,397 mm
Holddowns		
• Holddown Type	Hydraulic	Hydraulic
• Number of Holddowns	12	12
Approximate base machine weight (does not include options, i.e. squaring arm support arms, etc.)	16,600 lbs.	7,530 kg
Backgage		
• Range	48"	1,219.2 mm
• Speed	60 IPM	1,524 mm/m
• Positioning	.005"	.13 mm
• Positioning Repeatability	± .002"	± .051 mm
Electrical	460/3/60	460/3/60
Motor Horsepower	25 HP	19 KW
Knife Type	A	A

250HS12 Technical Specifications

Specification	Standard	Metric
Capacities, Mild Steel For relative capacities of other materials refer to CINCINNATI Shear Capacities PT-30491. *Mild Steel defined as:* *Ultimate Tensile strength: 55,000 - 70,000 psi* *Yield strength: 35,000 - 50,000 psi* *Elongation (% in 2") 20-35%*		
• Maximum	.250"	6 mm
• Minimum	26ga	.5 mm
Cutting Length	146.75"	3,727 mm
Rake Angle (adjustable)	.234-.375"/ft	
Cycle Speed (Approximate) Expected cuts per minute can vary 5-15% less than free running spm depending on material thickness, tensile strength, knife condition, knife clearance and operator skill. Speed reduced 5/6 when 50 HZ service		
• Maximum, 12" (300mm) cut length with min rake	45 spm	45 spm
• Minimum, full length capacity at max rake	20 spm	20 spm
Frontgage Range (with optional front supports)	62"	1,575 mm
Holddowns		
• Holddown Type	Hydraulic	Hydraulic
• Number of Holddowns	14	14
Approximate base machine weight (does not include options, i.e. squaring arm support arms, etc.)	17,600 lbs.	7,983 kg
Backgage		
• Range	48"	1,219.2 mm
• Speed	60 IPM	1,524 mm/m
• Positioning	.005"	.13 mm
• Positioning Repeatability	± .002"	± .051 mm
Electrical	460/3/60	460/3/60
Motor Horsepower	25 HP	19 KW
Knife Type	A	A

HS Standard Equipment

HMI Control Features

Combined control for shear and gage functions
Pedestal mounted
Industrial PC based
Windows operating system
22” flat panel color display
Touchscreen operator interface
Cycle selector-Off/Jog/Single Stroke/Continuous
Single Step/Auto Sequence
Maximum cuts per step 99
Maximum steps per program 99
Stroke counter
Batch counter
Setup notes
Spreadsheet tab
Main drive Start/Stop
Solid state drive
USB convenience outlet
Ethernet convenience outlet
Inch or Metric unit display
English/Spanish language display
Material library
Programmable backgage
Programmable rake
Programmable cut length
Programmable knife clearance (option 250)

Warranty

Shear Parts – 1 year
Backgage – 1 year
Service Labor – 1 year
Touchscreen Shear Control – 1 year
Multi-axis Gage parts – 1 year
Pneumatic Sheet Supports – 1 year
Programmable Knife Clearance – 1 year

FMA Company Membership (1 year)

Machine Features

48” range power backgage
Steel frame construction
60 IPM backgage speed
Manual knife clearance
Dovetail slots in shear table
Hand slots in shear table
Automatic lubrication to the backgage screws and ram guides
Decimal table scales
Manifold hydraulic system with cartridge valves
Hardened piston rods
Hydraulic holddowns
Dual Holddowns on left end
Automatic pullback of backgage angle
Guarded footswitch
Precision knife straightener
Knife change fixture (mounts to backgage)
Scrap chute
Side gage
Cushion Clamp Holddown (ON/OFF)
One set of knives (4-edge)
ANSI B11.4 and OHSA construction compliance Holddown and knife guards
One (1) Operation, Maintenance and Safety manual, (Red) USB flash drive
One (1) Operation and Safety Manual, (Blue) Hard copy
UL 508A Listed Industrial Control Panel
TEFC type motor
Paint – Laser Gray with red cylinder covers
LED work light – front

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Cincinnati Inc. (CI) Preferential Service

CI Preferential Service provides information and assistance on installation, safe operation, maintenance and repair of CI products. These services are available through CI Service Representatives located in major cities throughout the United States and Canada and include the following:

Pre-Installation Information and Foundation Plans

Foundation plan and installation information regarding lifting, leveling, service connections and equipment preparation will be provided prior to machine shipment. A single continuous slab of reinforced concrete is required, and will prolong machine life, reduce maintenance and contribute to quality production. The foundation plan will show the minimum requirements for good containment and operation. Actual foundation requirements will depend upon the physical properties of supporting soil and compactability. A civil engineer should be consulted if soil conditions are questionable. The machine must be properly anchored on a stable foundation.

Power Requirements

Machine controls have been designed to operate satisfactorily within normal incoming power variations. Electronics require power supplies free of extraneous signals and radical power fluctuations. The installation information contains the details of input power requirements.

Machine Start-Up and Demonstration

Machines must be located on the foundation, leveled, cleaned and connected to necessary services for operation, prior to start-up. The CI Service Representative will inspect, check level and test the machine in all modes of operation. Prior to the arrival of CI Service, the customer must have all machine members at the machine site and utilities installed. On machines shipped disassembled, CI Service will supervise and assist in the final assembly, inspection, level check and testing of the machine in all modes of operation. After start-up, CI Service will demonstrate the machine and provide instructions on operation, maintenance and safety. Materials and a qualified employee are to be furnished at no charge by the customer to assist in the testing and inspection of the machine. Machine start-up must be performed during normal working hours.

Warranty, Parts and Service

As specified in our general terms and conditions, defective parts will be replaced free of charge with surface transportation allowed. Replacement parts will be invoiced and credit issued upon the return of the defective part to CI. During the warranty period, a CI Service Representative, with customer assistance, will replace complex assemblies that have failed under warranty; labor to assist and/or necessary services are expected to be furnished by the customer at no cost to CI. On simple warranty repairs, CI will provide instructions to allow correction by customer personnel.

Training

Training programs are available to develop the skills of operators and maintenance personnel. Training may be provided at the customer's plant and/or at our facilities in Whitewater, Ohio. Quotations for CI Training Programs are available through our Training Department.

Normal Service Hours

Our Service Representative's normal working hours are from 8:00 AM to 4:30 PM, Monday through Friday. Any requested work performed outside our normal work period will be invoiced at appropriate overtime rates.

Options

Electrical

Machine is wired for 460/3/60.

- Transformer Kit for 208V/3/60
- Transformer Kit for 230V/3/60
- Transformer Kit for 575V/3/60

*Transformer Kit includes transformer, fittings, flexible conduit, and wire for up to 25’ between machine panel and transformer. User is responsible for all hardware between the transformer and electrical supply in accordance with applicable regulations.

Squaring Arm and Frontgages

- Extension squaring arm (includes one swinging stop)
- 60" hardened insert
- Frontgage support arm, 35" overall length
  (Includes one disappearing stop for manual setting of frontgage positions)
  - 24” longer than standard, 59” overall length
- Additional Stops for more versatile set-ups:
  - Swing stops
  - Solid stops
  - Disappearing stops for use in dovetail slots in table and frontgage support arms

Sheet Supports

- Pneumatically Operated Sheet Supports

Holddowns

- Holddown cups to provide insulation against marking soft or polished sheets
  NOTE: Distance under holddowns reduced by 3/16” when holddown cups installed.

Shear Knives

- Additional pair of knives
- Type “S” pair of knives *(in place of standard)*
- Additional pair of knives: Type “S”

CI Firesafe ECO Fluid

In place of standard hydraulic fluid

Other Options

- Ball Transfers in the shear table to reduce the effort of positioning heavy material
- Additional 3-position footswitch
- Light beam shearing gage to provide a shadow at pass line of knives in order to shear to a scribed line
- Operation and Safety Manual (Blue): One manual is supplied with each machine.
- Special language legend plates
- Thermostatically Controlled Heater Unit for oil reservoir when a shear is to be installed in shop where temperatures normally fall below 50° F. Customer to supply 110 volt power source
- Air-Cooled Heat Exchanger
- Special paint color (Laser Gray is standard): Tech Beige, Vista Green or Circuit Blue

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Option: Premium Support Plan (USA & Canada)

Premium Support Plan (1 Year Standard):

- Labor
- Shear Parts
- Backgage
- Control
- One Planned Maintenance service visit each year (does not include consumables)
- 10% discount on consumables and wear items on covered machine
- Terms/Conditions applicable per ES-207 document
- Additional 4 years can be purchased

Conditions concerning the purchase of the Premium Support Plan:

- The customer is responsible to have all planned maintenance (PM) service performed in accordance with schedule recommended in operator's manual, on time, during the Premium Support Plan.
- Any PM, consumable or repair parts must be purchased from Cincinnati Incorporated.
- It is the responsibility of the customer to have all parts and fluids on site prior to planned maintenance service visits. Failure to do so may incur further charges.
- Cincinnati Incorporated will ship covered part(s) to the customer at no charge using surface shipping methods. Any charges for expedited shipping are the responsibility of the customer.
- Customer must contact Technical Services prior to dispatch of Service Technician.
- This Support Plan does not cover the following:
    - Planned Maintenance Parts or Consumable Parts
    - Fluid and/ or fluid disposal services
    - Damage from: fire, electrical surge, accident, abuse, negligence or misuse
    - Defects or damages resulting from service or repair by anyone other than Cincinnati Incorporated or the Customer.
- The Premium Support Plan is not transferrable and adherence to the above requirements are necessary to keep the plan in force.

Terms & Conditions

F.O.B. Cincinnati, Inc. Harrison, OH

Shipment Date: Will advise at time of order.

Cancellation Charges: All orders are subject to cancellation charges. No cancellation will be accepted in the final month of assembly.

USA/Canada Payment Terms

30% due at time of order, 60% due prior to shipment, 10% (balance) due net 30 from date of invoice. Interest at 18% per annum will be charged on all past due balances. A 1-1/2% per month escalator will be added to the annual rate commencing 90 days after the invoice date. Payments are in US dollars.

Security Interest

Cincinnati Incorporated may retain a security interest in the equipment until it is fully paid. Equipment will be shipped only after a Security Agreement and UCC-1 Financing Statement, both signed by an officer of the Buyer, are received.

In the event you are unable to accept shipment of the machine upon its completion, you authorize Cincinnati Incorporated to invoice the machine and hold it for shipment instructions. In doing so, you agree to accept all associated risks and further agree to provide all required insurance for the machine beginning on the date you instruct Cincinnati Incorporated to hold for shipment. Should you require Cincinnati Incorporated to hold the machine longer than 14 days from the date of completion, you may be liable for storage charges to be determined by us. In no event shall Cincinnati Incorporated be required to hold the machine longer than 60 days.

Proposals are subject to the Terms & Conditions of Form ES-207 (attached).

International Payment Terms:

30% due at time of order by wire transfer. The remaining 70% (balance) due 5 days prior to shipment by wire transfer. Travel and living charges may apply. Consult CINCINNATI INC. at time of order. Prices do not include shipping, importation or broker fees.

Government Entities – Federal, State or Local.

This contractor and subcontractor shall abide by the requirements of 41 CFR §§ 60-1.4(a) 60-300.5(a) and 60-741.5(a). These regulations prohibit discrimination against qualified individuals based on their status as protected veterans or individuals with disabilities, and prohibits discrimination against all individuals based on their race, color, religion, sex, or national origin. Moreover, these regulations require that covered prime contractors and subcontractors take affirmative action to employ and advance in employment individuals without regard to race, color, religion, sex, national origin, protected veteran status or disability.

135XFe Technical Proposal

Prepared For

Company Name	LASD
City/State	
Prepared By	mark.heidenreich@e-ci.com
Technical Proposal No.	MAH-24-176
Submission Date	8-6-24

CINCINNATI follows the policy of continuous advancement in product development. For this reason, specifications, images and dimensions are for reference only and can change without notice. Foundation plans are furnished with each new machine installation.

Introduction

CINCINNATI press brakes are designed for everyday use by advanced, metal fabricators. Cincinnati press brakes are manufactured in Harrison, Ohio and supported by factory, field-based service representatives.

Key Benefits

Energy Efficient

CINCINNATI's XFe with dual servo-motor pump drive system runs quiet and reduces energy consumption. The servo-motors and pumps run only when forming parts, not during idle, saving energy while the ram is stationary. The low capacity hydraulic system uses environmentally friendly, non-flammable CI Firesafe ECO Fluid for simplified maintenance.

Fast Programming

CINCINNATI's PC-based operator control, Windows® software, touchscreen interface and large color display eliminate two-thirds of the programming steps compared to conventional CNC controls. New programs are quickly entered manually while repeat programs are recalled from a solid state hard drive or network.

Consistent Forming

Dual .00002" resolution linear encoders maintain ram repeatability to ±.0004" along the length of the press brake. CINCINNATI controls simplify setup through the use of saved programs with detailed setup information. The Job Setup screen displays tool locations and 3D part views guide the operator through each step of the bend sequence. Programmable forming speeds, stroke stops and gage pause time improve part handling. Ram tilt is programmable per step.

Versatility

The standard long stroke length improves forming versatility by maximizing space for adapters and deep flanges. The open frame design minimizes forming restrictions.

Reliability

Cincinnati press brakes are designed for simple service and long life. The interlocked frame provides maximum strength without load bearing welds. Clevis mounted cylinders, hardened piston rods and a large capacity hydraulic tank reduce oil leaks, oil temperature and wear of hydraulic components. Hardened linear guides and self-lubricated slide liners assure accurate ram guiding with minimal maintenance. Controls and hydraulics are designed to operate in an ambient temperature range of 45° F to 100° F (For ambient air temperatures outside of these ranges, please consult with CI).

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XFe Standard Equipment

HMI Control Features

Industrial PC-based

Windows Embedded OS

Bed-mounted Control Arm - right hand side

24” TFT LCD flat-panel color display

Touchscreen operator interface

Keyboard

Trackball

Solid State Hard Drive

USB Convenience Outlet

Ethernet Convenience Outlet

Inch or Metric unit display

English / Spanish language display

Graphical Tool Library

- Pre-loaded Wilson and Wila tool files
- Automatic tool load tonnage calculation
- Tool selection
- Tool segment length auto calculation

Quick Bend mode

CAD functions

- Part Design by cross section or flat pattern
- Flat blank size calculation
- Manual Bend Sequencing

Part Orientation Guide

Setup Notes field

Print setup notes and program

Convert utility for programs

Batch program operation

Spreadsheet display of program steps with editing capability

Management and Diagnostic Features

- Password level (Operator, Manager, Administrator)
- Machine strokes
- Parts counter
- Batch counter
- Power-on time
- Total cycle time
- Main drive on time
- Parts per minute
- Cycle time per part
- Maintenance messages
- Diagnostic Display Information
- Oil Level and Temperature Sensing
- Backup and Restore Wizard
- Web-enabled machine monitoring
- Email notification of machine faults

Operator Adjustable Ram Control Inputs:

- Multiple Step and Repeat
- Forming modes (Angle, Tonnage, Position, Absolute, Angle/Dynamic Thickness Compensation)
- Angle Correction Dialog
- Ram Opening
- Guard Mute Position
- Forming and return speeds
- Tool selection for each step
- Speed change position (up and down)
- Ram tilt, total end-to-end 1”
- Dwell time at bottom of stroke (limited)
- Up and down stroke stops (ON / OFF)
- Material Clamp: Pause / Stop (ON / OFF)
- Tonnage reversal auto calculation

Operator Adjustable Gage Control Inputs:

- Flange dimension
- Z-axis position auto-calculation (with 5 and 6 axis backgages)
- Retract distance
- Gage Pause time
- Incremental gage move

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Operator Controls

One (1) footswitch for “STROKE” mode of operation

One (1) two-hand palm button operator station for “SETUP”

or “STROKE” mode of operation, mounted on HMI control

Hand/Foot Sequence mode of operation

Ram Stroke Mode Selector (OFF, SETUP, STROKE)

Ram Cycle Mode Selector (SINGLE STEP and AUTO SEQUENCE)

Ram Up button

Emergency Stop button

Red and green ram directional lights

Machine Features

CINCINNATI Quick Clamp Ram Nose (Bolt-on), manual clamp

24” 5 Axis Backgage

CINCINNATI Bend Simulation Module (control and offline)

Non-metallic liners for ram guiding surfaces

Dual English/Metric Rule on ram nose

Automatic leveling control system with dual, linear encoders (0.00002” resolution)

Microcrown

Interlocked frame construction

Clevis-mounted hydraulic cylinders

Hardened piston rods

Full length dovetail slot in front and back of bed

Crosswise “C” slots in bed top on 24” centers

Hydraulic manifold blocks to reduce piping and connections

Firesafe ECO Hydraulic fluid and filters

Replacement filter

Paint color - White

LED Work Light - rear

Air Conditioner, main power electrical cabinet

Machine Features (cont.)

One Operation, Safety and Maintenance Manual (Red)

(USB flash drive)

One Operation and Safety Manual (Blue) (hard copy)

UL 508A Listed Industrial Control Panel

Warranty\Training

Press Brake Parts – 1 year

Control – 1 year

Backgage Parts – 1 year

Service Labor - 1 year

CNC Crowning – 1 year

Hydraulic Clamping – 1 year

Presence Sensing Device – Warranted by Manufacturer

Operator Training at Cincinnati – 2 slots

FMA Company Membership (1 year)

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135XFe8 Technical Specifications

Specification	Standard	Metric
Full Capacity Tonnage For Specific Capacity refer to CINCINNATI Press Brake Capacities PT-50691. *(**Note:** Machine not intended for punching, stripping of parts or for tools with urethane inserts.)*	135 Tons	122 Tons
Maximum tonnage at full forming speed	135 Tons	122 Tons
Maximum speed at full tonnage	70 IPM	30 mm/sec
Clear distance between housings	8’ - 6-1/4”	2,597 mm
Total overall die surface	10’	3,048 mm
Bed top width	3.5”	89 mm
Closed Height	7”	178 mm
Stroke Length	14”	356 mm
Open Height	21”	533 mm
Throat	18”	457 mm
Ram Speeds		
• High Approach	550 IPM	232 mm/sec
• Variable Forming (programmable)	5-70 IPM	2-30 mm/sec
• Variable Return (programmable)	5-550 IPM	2-230 mm/sec
Ram Repeatability	±.0004”	±.01 mm
Ram Tilt, total end-to-end	1"	25.4 mm
Approximate base machine weight *(does not include options, filler block, etc.)*	24,700 lbs.	11,204 kg
Electricals	460/3/60	460/3/60
Motor Horsepower	10.39 HP (x2)	7.75 kW (x2)
Oil Capacity	37 gal	140 L

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135XFe10 Technical Specifications

Specification	Standard	Metric
Full Capacity Tonnage For Specific Capacity refer to CINCINNATI Press Brake Capacities PT-50691. *(**Note:** Machine not intended for punching, stripping of parts or for tools with urethane inserts.)*	135 Tons	122 Tons
Maximum tonnage at full forming speed	135 Tons	122 Tons
Maximum speed at full tonnage	70 IPM	30 mm/sec
Clear distance between housings	10’ - 6-1/4”	3,207 mm
Total overall die surface	12’	3,658 mm
Bed top width	4.5”	114 mm
Closed Height	7”	178 mm
Maximum stroke length	14”	356 mm
Open Height	21”	533 mm
Throat	18”	457 mm
Ram Speeds		
• High Approach	550 IPM	232 mm/sec
• Variable Forming (programmable)	5-70 IPM	2-30 mm/sec
• Variable Return (programmable)	5-550 IPM	2-230 mm/sec
Ram Repeatability	±.0004”	±.01 mm
Ram Tilt, total end-to-end	1"	25.4 mm
Approximate base machine weight *(does not include options, filler block, etc.)*	27,500 lbs.	12,474 kg
Electricals	460/3/60	460/3/60
Motor Horsepower	10.39 HP (x2)	7.75 kW (x2)
Oil Capacity	37 gal	140 L

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CNC 5 Axis Backgage

Low profile backgage provides programmable control of two front-to-back (X1,X2) axes, two left-to-right (Z1,Z2) axes and one up-down (R) axis. Designed to process up to ¼" thick material that can be handled by one or two operators. Thicker materials weighing up to 150 lbs., but not requiring a crane assist can be processed when reasonable care is exercised.

Specification	Standard	Metric
Horizontal (X1, X2)		
• Front-to-back range *(Three alternate gage points, 40" max)*	24"	609.6 mm
• Positioning speed	1200 IPM	508 mm/sec
• Positioning accuracy	± .001"	± .025 mm
• Positioning repeatability	± .001"	± .025 mm
Vertical (R1)		
• Up-down range	8"	203.2 mm
• Low Finger Position	.5 - 8.5"	12.75 - 215.9
• High Finger Position	3.25 - 11.25"	82.55 - 285.75 mm
• Over the Top Gage Position	5 - 13"	127 - 330.2 mm
• Positioning speed	270 IPM	114 mm/sec
• Positioning accuracy	± .005"	± .127 mm
• Positioning repeatability	± .003"	± .0762 mm
Lateral (Z1, Z2)		
• Left-to-right range (135XF8)	92"	2,337 mm
• Left-to-right range (135XF10)	116"	2,946 mm
• Positioning speed	3000 IPM	1270 mm/sec
• Positioning accuracy	± .015"	± .381 mm
• Positioning repeatability	± .015"	± .381 mm

5 Axis Backgage Includes:

- Two gage finger bases, two step fingers, two solid fingers
- Steel rear guarding with electrical interlocked gate
- Gage modes: Standard, Independent, Taper
- Graphical Gage Finger Library
- Flange correction dialog
- Automatic Z-axis position calculation
- Closed loop servo drive systems
- Remote pendant for ram control

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Electrical

For driving this machine, we provide two precision controlled servo motors built to NEMA standards.

Servo drive regulated starting provides overload protection.

Ram and backgage solid-state controls include:

- Programmable multi-axis custom control system: consisting of several processors and LCD display
- All controls conform to current NFPA 79 Electrical Standards, and meet or exceed ANSI B11.3 safety requirements

Safety

All goods in this proposal will conform to applicable machinery construction standards of the Federal Occupational Safety & Health Act of 1970. In the event of changes in standards between the date of this proposal and order acknowledgment date, CINCINNATI INCORPORATED will quote the additional cost required to meet the intervening standards. No warranty of compliance with state or local standards is made in the absence of specific reference thereto in our quotation.

This CINCINNATI INCORPORATED press brake complies with the construction requirements of the current ANSI B11.3 safety standard. Each new CINCINNATI press brake is so identified by a compliance tag upon machine completion at our factory.

Each machine is furnished with an Operation, Safety and Maintenance Manual, a copy of ANSI B11.3 safety standards to assist in the proper care and use of your machine, and safeguarding selection book PI-50686 for information on point-of-operation protection (see attached).

Operator Training

To increase productivity from your investment, attendance in our Operator Training Program at our facility in Harrison, OH is included; travel and lodging are not included. Travel and lodging assistance is available through our Training Department. Training can also be provided at your facility for an additional charge. Reservations must be made from 60 days prior to 1 year after shipment of your new machine.

Programs provide classroom and hands-on instruction on Safety, Fundamentals of Forming, Introduction to the CI Press Brake, Machine Mode Selection, Programming & Operation, Diagnostic Fault Messages, Gage Setup and Operating Techniques, Options. Training materials, manuals, lunches, one group dinner and transportation from a local hotel are included.

Additional Training at Cincinnati Inc.

- Operator Training, per person
- Maintenance Training, per person
- Bend Simulation Module Programmer Training, per person
- Fundamentals of Forming, per person

On-Site Training (6 participants)

- Operator Training (4 days)

Training programs are available to develop the skills of operators and maintenance personnel. Training may be provided at the customer's plant and/or at our facilities in Whitewater, Ohio. Quotations for CI Training Programs are available through our Training Department, training@e-ci.com

Cincinnati Inc. (CI) Preferential Service

CI Preferential Service provides information and assistance on installation, safe operation, maintenance and repair of CI products. These services are available through CI Service Representatives located in major cities throughout the United States and Canada and include the following:

Pre-Installation Information and Foundation Plans

Foundation plan and installation information regarding lifting, leveling, service connections and equipment preparation will be provided prior to machine shipment. A single continuous slab of reinforced concrete is required, and will prolong machine life, reduce maintenance and contribute to quality production. The foundation plan will show the minimum requirements for good containment and operation. Actual foundation requirements will depend upon the physical properties of supporting soil and compactability. A civil engineer should be consulted if soil conditions are questionable. The machine must be properly anchored on a stable foundation. Expandable anchor bolts are acceptable where noted on the foundation plan.

Power Requirements

Machine controls have been designed to operate satisfactorily within normal incoming power variations. Electronics require power supplies free of extraneous signals and radical power fluctuations. The installation information contains the details of input power requirements.

Machine Start-Up and Demonstration

Machines must be located on the foundation, leveled, cleaned and connected to necessary services for operation, prior to start-up. The CI Service Representative will inspect, check level and test the machine in all modes of operation. On machines shipped disassembled, CI Service will supervise and assist in the final assembly. Prior to the arrival of CI Service, the customer must have all machine members at the machine site and utilities installed. Qualified riggers, a qualified employee, and materials must be furnished by the customer to assist in assembly at no charge to CI. After start-up, CI Service will demonstrate the machine and provide instructions on operation, maintenance and safety. It is the customer's responsibility to provide the proper tooling, material and safeguarding for the machine demonstration.

Warranty, Parts and Service

As specified in our general terms and conditions, defective parts will be replaced free of charge with surface transportation allowed. Replacement parts will be invoiced and credit issued upon the return of the defective part to CI. During the warranty period, a CI Service Representative, with customer assistance, will replace complex assemblies that have failed under warranty; labor to assist and/or necessary services are expected to be furnished by the customer at no cost to CI. On simple warranty repairs, CI will provide instructions to allow correction by customer personnel.

Normal Service Hours

Our Service Representative's normal working hours are from 8:00 AM to 4:30 PM, Monday through Friday. Any requested work performed outside our normal work period will be invoiced at appropriate overtime rates.

Options

Ram

Warning: Must use tools with appropriate safety tongue. (Wilson & Wila)

- Wilson Hydraulic Clamp Upper APH-2: ½" Tongue, 77 tons/ft
- Wilson Hydraulic Clamp Upper WPH-2: 20mm Tongue, 80 tons/ft
- WILA Hydraulic Clamp Upper ASCL-I-HC/UPB: ½" Tongue, 77 tons/ft
- WILA Hydraulic Clamp Upper NSCL-I-HC/UPB: 20mm Tongue, 84 tons/ft
- Wila Smart Tool Locator® (STL) for Wila ASCL or NSCL)

Bed

Hydraulic Clamp Lower requires Hydraulic Upper from same manufacturer

- Manual or Hydraulic Clamp Lower with CNC Crowning
- Wilson ADM-20 Manual Clamp Lower with CNC Crowning: 3.74" H x 3.5"W, 80 tons/ft.
- Wilson ADH-20 Hydraulic Clamp Lower with CNC Crowning: 3.74" H x 3.5"W, 80 tons/ft.
- WILA NSCR-I-MC-CNC/B3 Manual Clamp Lower with CNC Crowning: 3.74"H x 3.5"W, 68 tons/ft.
- WILA NSCR-I-HC-CNC/B3 Hydraulic Clamp Lower with CNC Crowning: 3.74"H x 3.5"W, 68 tons/ft.

Filler Blocks

- US/Euro, filler block: 2.36" wide x 3.25" high
- US/Euro filler block, low profile, 2.36" wide x 2.0" high (Not for use with PowerExpress ™ Lower Die Holder)
- Clamp plates for US/Euro filler block
- Universal filler block for 3-1/4" 4-way die
- Universal filler block for 3-5/8" 4-way die
- Universal filler block for 5-1/4" 4-way die
- Narrow filler block, 2-1/2" wide x 3-1/4" high
- Narrow filler block, 2-1/2" wide x 4-1/2" high
- Flat top filler block 4" wide x 3-3/4" high
- Flat top filler block 5" wide x 4-1/2" high
- Wider die slot .530" (in place of standard)
- Additional set screws in filler block

Fast Setup Work Supports

Two 15" work supports with quick release handles are manually positioned left/right and up/down. 12" steel track sections are attached to the front of the bed. Vertical adjustment range is 1.88" - 8.5" above bed top. Filler block and lower die cannot be more than 1/2" wider than bed top.

- Two 15" work supports
- 24" slides (in place of 15")
- Additional Work Supports
- End Stop Kit for Fast Setup Work Supports

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Option: CNC 6xLT Backgage

Low profile backgage provides independent control of two front-to-back (X1,X2) axes, two left-to-right (Z1,Z2) axes and two up-down (R1,R2) axes. Designed to process up to ¼" thick material that can be handled by one or two operators. Thicker materials weighing up to 150 lbs, but not requiring a crane assist, can be processed when reasonable care is exercised. The servo control will hold position against external forces applied during normal gaging operation, but gradually applied load of greater than 50 pounds per drive will overcome the servo and force the gage out of position without damage.

Specification	Standard	Metric
Horizontal (X1, X2)		
• Front-to-back range *(Three alternate gage points, 40" max)*	0 - 24"	0 - 609.6 mm
• Positioning speed	3000 IPM	1270 mm/sec
• Positioning accuracy	± .002	± .051 mm
• Positioning repeatability	± .001"	± .025 mm
Vertical (R1)		
• Up-down range	2 to 10"	51 to 254 mm
• Over the Top Gage Position	5 to13"	127 to 330 mm
• Positioning speed	300 IPM	127 mm/sec
• Positioning accuracy	± .005"	± .127 mm
• Positioning repeatability	± .003"	± .076 mm
Lateral (Z1, Z2)		
• Left-to-right range (135XF8)	92"	2,337 mm
• Left-to-right range (135XF10)	116"	2,946 mm
• Positioning speed	3000 IPM	1270 mm/sec
• Positioning accuracy	± .004"	± .102 mm
• Positioning repeatability	± .002"	± .051 mm

6XLT Axis Backgage Includes:

- X-Z axes linear motor drives, R axis ball screw
- Two gage finger bases, two step fingers, two solid fingers
- Steel rear guarding with electrical interlocked gate
- Gage modes: Standard, Independent, Taper
- Graphical Gage Finger Library
- Flange correction dialog
- Automatic Z-axis position calculation
- Closed loop servo drive systems
- Remote pendant for ram and gage control
- *Optional*: Combinational gage fingers (in addition to standard fingers)

Options: Safety

Standard controls require either the palmbutton(s) or footswitch(es) to be active for the entire program. Palmbutton(s) and footswitch(es) combinations can be programmable per each step in the program with the following option. Additional palmbutton and/or footswitch can be purchased with this option.

Programmable palmbutton/footswitch: Software feature allows palmbutton and/or footswitch combinations to be selected per program step.

If you anticipate having two persons working together on your press brake, we recommend an operator control for each person.

- Additional Palmbutton Operator Station
- Pedestal mounted, limit one additional
- Hold-to-Run Footswitch in place of standard
- Additional Standard or Hold-to-Run Footswitch

Presence Sensing Device Interface

A user installed Presence Sensing Device or Laser Type Device requires an interface.

Optional interface iIncludes a Presence Sensing Device On/Off indication light mounted on the ram. Muting, making the Presence Sensing Device inoperative during a specific portion of the press brake cycle, is programmable at any point in the down stroke and is independent of the speed change point. The selection of a user supplied Presence Sensing Device should consider the following:

For operator convenience, the device provided should have the ability to electrically simulate a device interrupt. In the Single Stroke Mode of Operation, the machine control must receive a Presence Sensing Device interrupt signal after ram reversal before a new cycle will be allowed. This can be done either by the machine control electrically simulating a Presence Sensing Device interrupt or by a physical interrupt of the sensing field by the operator or piece part. This is required to provide the operator with a point-of-operation guarding system that is completely checked for proper operation on each stroke of the machine.

Presence Sensing Devices

Vertically mounted to bed with rugged heavy duty swing-away mounting brackets. All necessary interface provisions are included.

Presence sensing beam blocking and press brake end guards are not included and are the responsibility of the user to determine specific application requirements. Presence Sensing Device is warranted by its manufacturer.

- Link brand, #LL-MAX-18-A-S, 18”, “Black Max”, Infrared
- Link brand, #LL-MAX-36-A-S, 36”, “Black Max”, Infrared
- ISB brand, Merlin 4000, 24” Infrared (M4024)
- ISB brand, Merlin 4000, 36” Infrared (M4036)
- Protech 25-33KP Eagle Eye 18” DBO “K” Infrared

Presence Sensing Device ON/OFF control

User must provide a statement on company letterhead that they will provide an alternate means of point of operation guarding when the device is turned off. Presence Sensing Device On/Off selector is not provided as standard.

Options: Safety

Lazersafe IRIS

Includes factory integration, hold to run footswitches, 12” of vertical adjustment below ram. On some models, maximum ram speeds may be reduced with a laser-type guard.

Lazersafe IRIS PLUS

10’ max overall length. Includes factory integration, hold to run footswitches, 12” of vertical adjustment below ram. On some models, maximum ram speeds may be reduced with a laser-type guard.

Lazersafe SmartLink Motorized Brackets

Electrically Interlocked Steel End Guards

E-Stop Pendant with Magnetic Base

Hand held pendant can be positioned at a readily accessible location for the operator.

Die Safety Blocks

Programmable Palmbutton/Footswitch Software

Options

Transformer

Machine wired for 460/3/60. For direct connection without a transformer, the machine must be Wye connected 460/3/60 ± 10%

- Transformer Kit for 208/3/60
- Transformer Kit for 230/3/60
- Transformer Kit for 575/3/60

Transformer kit includes transformer, fittings, conduit and 25' wire. User is responsible for all hardware between transformer and electrical supply in accordance to applicable regulations

5 Axis Backgage, 40" range in place of standard 24" range

24" Range Heavy Duty Backgage in place of standard 5 Axis Backgage

Robot Interface

OMNI-ARM: Overhead mount, right side, with dual 24" monitors. Reaches 1 ft from center on 8 ft nominal machine.

Tech Package: includes Front/Rear Cameras, Barcode Reader, WIFI

Robot Interface

Special Paint Color: Consult factory for color options

Pedestal Mounted Control In Place Of Standard Pendant Arm

Programmable Outputs

CSA Z142-10 Machine & Control Compliance

CSA Z142-10 requires a safeguarding device. With the Machine & Control Compliance, Cincinnati Incorporated can provide a safeguarding device interface or a factory-installed safeguarding device.

- CSA Hydraulics
- Electrical Interface for Die Safety Blocks
- Electrical Interface for Guarding Interlocks
- Follow-up visit by CINCINNATI Service Representative to turn
- on the Presence Sensing Device Interface when user installs
- their own Presence Sensing Device.
- UL 508A Listed Industrial Control Panel (local inspection not included)
- Hold-to-Run footswitch

Notes: Handheld Ram/Gage positioning wheel is removed. Ram cycle speed without a safeguarding device limited to 10mm/sec

Option: Cincinnati Sheet Following System

Provides dual motorized arms synchronized to the ram motion to follow the part up and down during the stroke.

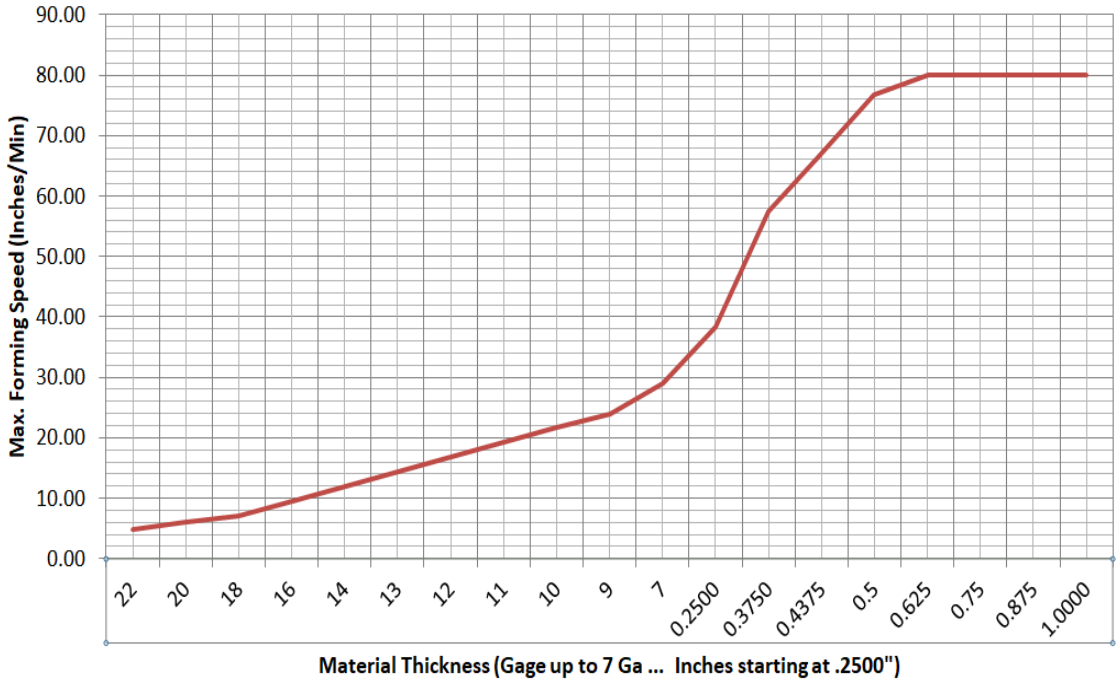
Features and Specifications:

- 500 pound maximum part weight per arm with part's center of gravity within the work support surface
- Front mounted guide rail to manually position the lift arms left and right along the front of the press brake
- 45" extension rail parking zone on left end (not provided on Hyform model)
- Work surface, 11" wide x 40" long, Nylatron GS
- 6" height range (4.7"-10.7" above bed) for varying die heights
- Available on 90-600 ton 8-20' overall length machines
- For use with ½" – 8" vee die openings
- 90 degree maximum bend angle
- Selection per step: Left/Right/Both/None
- Paint Red/Black

Notes:

- Not compatible with accessories that bolt to front of the bed (i.e. die aligners, work supports, angle brackets, light curtains, end guards, bed adapters)
- CI Bend Sim Software does not simulate lift motion
- For use with Angle Mode with measured tools

Forming Speed Chart:



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Option: Premium Support Plan (USA & Canada)

Premium Support Plan (1 Year Standard):

- Labor
- Press Brake Parts
- Backgage
- Control
- Wilson/Wila Clamps
- One Planned Maintenance service visit each year (does not include consumables)
- 10% discount on consumables and wear items on covered machine
- Terms/Conditions applicable per ES-207 document
- Additional 4 years can be purchased
- 1 Training Seat Included (Operator or Maintenance) *Terms Apply - See Below*

Conditions concerning the purchase of the Premium Support Plan:

- The customer is responsible to have all planned maintenance (PM) service performed in accordance with schedule recommended in operator's manual, on time, during the Premium Support Plan.
- Any PM, consumable or repair parts must be purchased from Cincinnati Incorporated.
- It is the responsibility of the customer to have all parts and fluids on site prior to planned maintenance service visits. Failure to do so may incur further charges.
- Cincinnati Incorporated will ship covered part(s) to the customer at no charge using surface shipping methods. Any charges for expedited shipping are the responsibility of the customer.
- Customer must contact Technical Services prior to dispatch of Service Technician.
- This Support Plan does not cover the following:
    - Presence Sensing Devices except integrated Lazersafe devices sold by CI (interfaced directly not connected by an Auxiliary Device Interface-ADI)
    - Planned Maintenance Parts or Consumable Parts
    - Fluid and/ or fluid disposal services
    - Damage from: fire, electrical surge, accident, abuse, negligence or misuse
    - Defects or damages resulting from service or repair by anyone other than Cincinnati Incorporated or the Customer.
- The Premium Support Plan is not transferable and adherence to the above requirements are necessary to keep the plan in force.
- Premium Plan Training Seat Terms
    - The supplied training seat is available for one year from the Premium Plan start date.
    - The training seat can only be used for the product the Premium Plan was purchased for.
    - The training seat can be used for operator or maintenance training.
    - Training seats are available on a first come, first served basis.
    - There can be no carry-over of training seats from previous years of Premium Training Seats.
    - The training seat provided by this plan does not extend the expiration date for seats that are currently provided with new machines.

Payment Terms & Conditions

F.O.B. Cincinnati, Inc. Harrison, OH

Shipment Date: Will advise at time of order.

Cancellation Charges: All orders are subject to cancellation charges. No cancellation will be accepted in the final month of assembly.

USA/Canada Payment Terms

30% due at time of order, 60% due prior to shipment, 10% (balance) due net 30 from date of invoice. Interest at 18% per annum will be charged on all past due balances. A 1-1/2% per month escalator will be added to the annual rate commencing 90 days after the invoice date. Payments are in US dollars.

Security Interest

Cincinnati Incorporated may retain a security interest in the equipment until it is fully paid. Equipment will be shipped only after a Security Agreement and UCC-1 Financing Statement, both signed by an officer of the Buyer, are received.

In the event you are unable to accept shipment of the machine upon its completion, you authorize Cincinnati Incorporated to invoice the machine and hold it for shipment instructions. In doing so, you agree to accept all associated risks and further agree to provide all required insurance for the machine beginning on the date you instruct Cincinnati Incorporated to hold for shipment. Should you require Cincinnati Incorporated to hold the machine longer than 14 days from the date of completion, you may be liable for storage charges to be determined by us. In no event shall Cincinnati Incorporated be required to hold the machine longer than 60 days.

Proposals are subject to the Terms & Conditions of Form ES-207 (attached).

International Payment Terms:

30% due at time of order by wire transfer. The remaining 70% (balance) due 5 days prior to shipment by wire transfer. Travel and living charges may apply. Consult CINCINNATI INC. at time of order. Prices do not include shipping, importation or broker fees.

Government Entities – Federal, State or Local.

This contractor and subcontractor shall abide by the requirements of 41 CFR §§ 60-1.4(a) 60-300.5(a) and 60-741.5(a). These regulations prohibit discrimination against qualified individuals based on their status as protected veterans or individuals with disabilities, and prohibits discrimination against all individuals based on their race, color, religion, sex, or national origin. Moreover, these regulations require that covered prime contractors and subcontractors take affirmative action to employ and advance in employment individuals without regard to race, color, religion, sex, national origin, protected veteran status or disability.