



Advanced CNC Press Brake With Air Forming/Plus

Incorporating State-Of-The-Art hydraulic and CNC technology, Ascension's new CNC Press Brake enables us to offer greater precision, reliability, accuracy and productivity with dramatically reduced setup times. This gives You better products and quicker turnaround, at lower cost. A plus for Your "just in time" or "aftermarket" requirements.





Ascension Now Offers State-Of-The-Art CNC Press Brake Capabilities To Meet Your Most Demanding Requirements In Sheetmetal Forming

With our new Cybelec DNC-equipped press brake we can quickly program your product part requirements.

The control will automatically calculate (which is key to air forming) the required values from the input of dimensions and angles of the part to be formed.

This includes tonnage, bed deflection compensation, blank size, bed allowance, bending sequence, back gauge retracts and switch points.

All of this plus a high degree of accuracy.

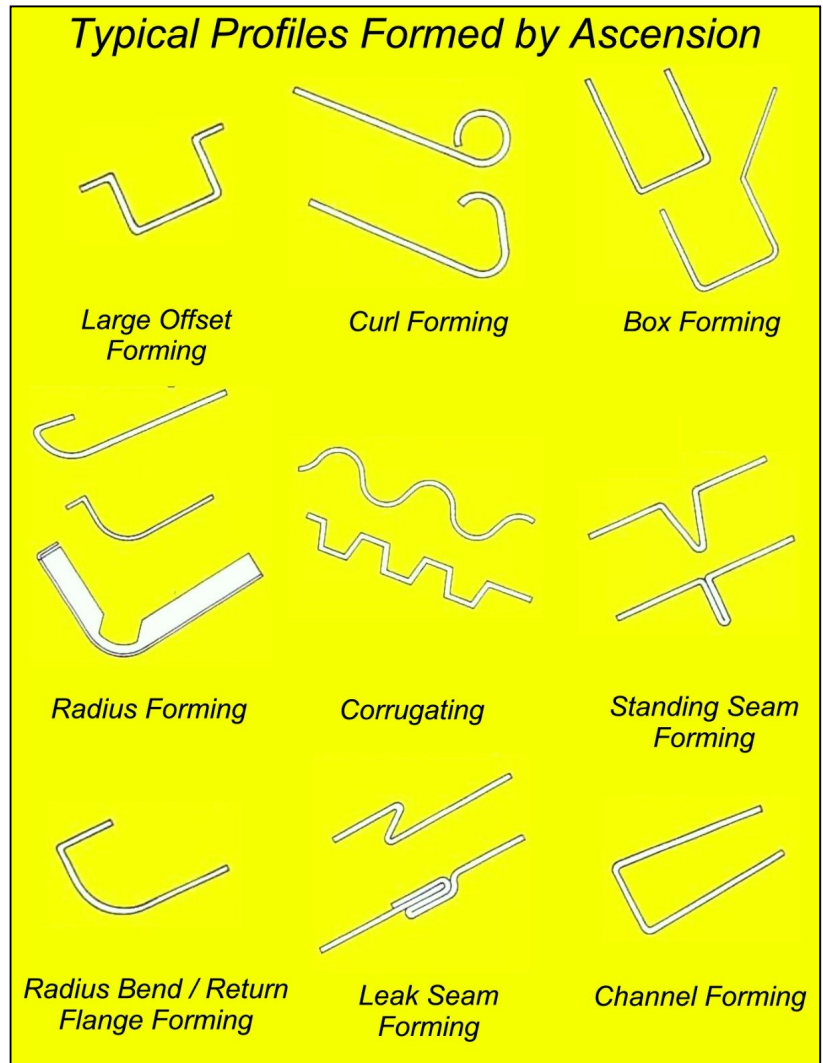
- ± 1/2° part accuracy
- ± .002" back gauge repeatability
- ± .004" back gauge positioning
- ± .0004" ram repeatability & ram level

More Ascension Large Machining Information Online:

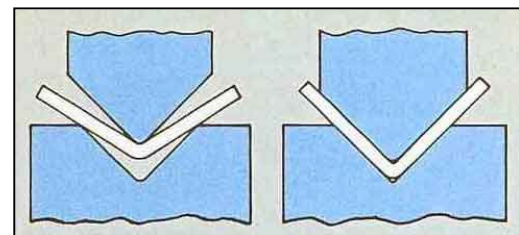
- [CNC Laser Cutting](#)
- [CNC Laser Cutting Downloadable PDF](#)
- [CNC Press Brake Downloadable PDF](#)
- [CNC Boring Drilling & Milling](#)
- [CNC Boring Drilling & Milling PDF](#)

For Dependable Service On ANY Type Of Metalworking Job

[Contact Ascension Industries](#)



Forming via Air Bending vs. Bottoming



AIR BENDING DIES are made at more of an acute angle than the angle to be formed. The only contact between the dies and material occurs at the tip of the male punch and the inside edges of the female die. The material is "air" formed rather than "coined" or "bottomed".

BOTTOMING DIES are used when sharp corners are required. This process requires three to five times the tonnage needed in air bending. Since more tonnage is needed, bottoming is seldom performed on steel greater than 12 gauge.