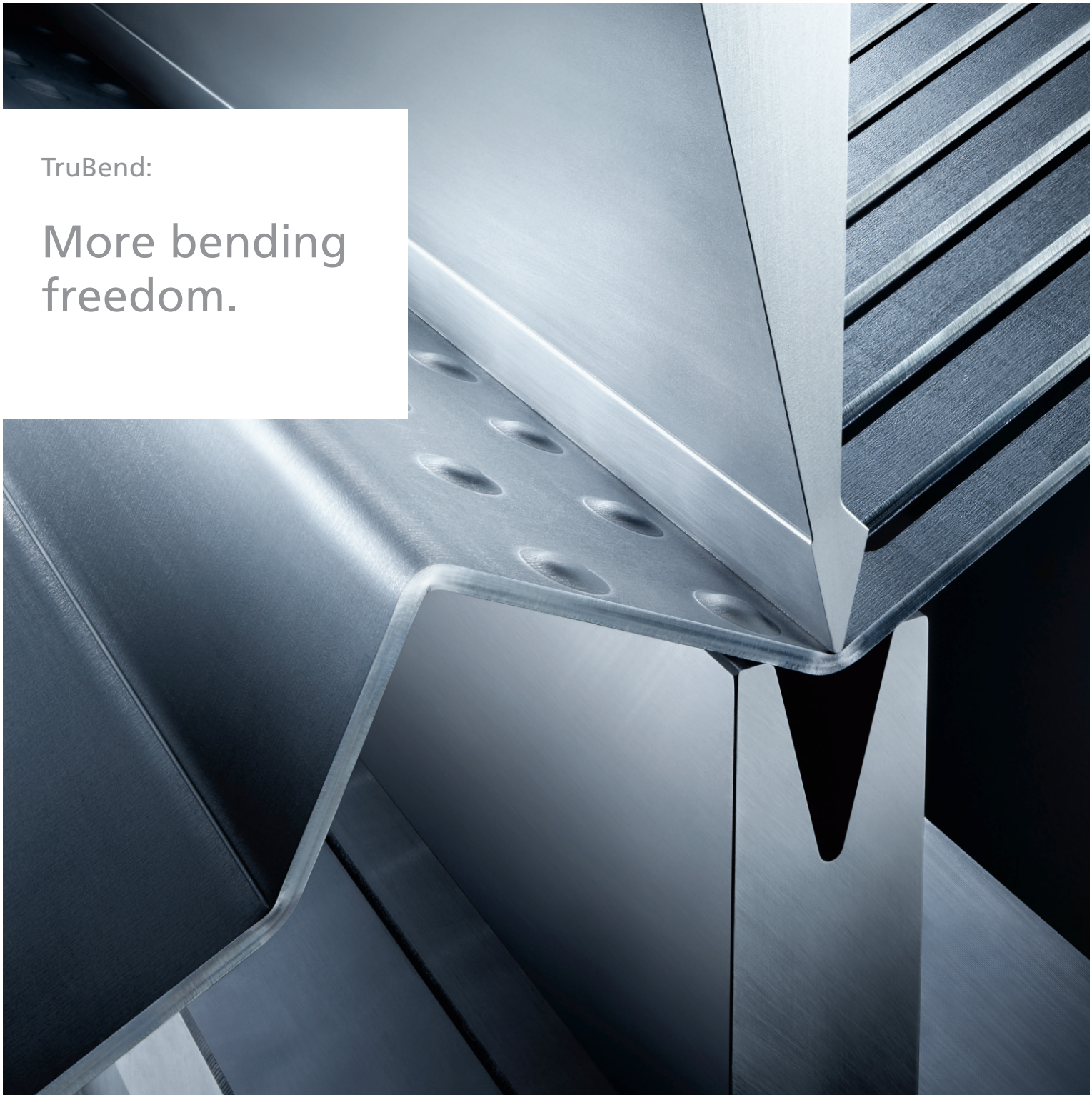

TruBend:

More bending freedom.

TRUMPF

Machine Tools/Power Tools
Laser Technology/Electronics

The best bending solutions.

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TruBend machines incorporate a wealth of experience in press brake technology coupled with pioneering innovations. They enable you to fabricate parts in any format, from the simplest to the most complex, precisely and cost-effectively.

TRUMPF has been designing and manufacturing press brakes since 1989. Among the most important developments are the ACB angle measuring system, patented 4-cylinder drive technology, machine control unit and operator ergonomics with innovative details. TRUMPF leads the field in programming convenience and ease of operation. TruBend machines are renowned above all for their flexibility, finished part quality, and high cost-benefit ratio. Moreover, TRUMPF can meet all of your additional requirements – for tools, automation and software – from a single source. Designed for years of continuous operation at full capacity, TRUMPF press brakes are favored by industrial customers the world over.

TruBend: Benefits at a glance.

1. The right machine for every part geometry.
2. Cost-effective bending due to high productivity.
3. Parts of the highest quality.
4. Single source for all requirements, including top-quality tools.
5. Ease of operation and ergonomic design.

TruBend Series 3000

Economical standard machine.
The right choice for users who value TRUMPF quality, simple operating procedures, and a favorable cost-performance ratio.

TruBend Series 5000

Productive jack of all trades.
High productivity throughout, from programming and tool setup to the bending process. The TruBend Series 5000 is capable of performing bending work on a wide range of parts, always with the greatest precision.

TruBend Series 7000

Ergonomic high-speed machine.
Incorporating innovative features for high-speed bending of small and larger parts under optimized working conditions.

TruBend Series 8000

Flexible large-format machine.
The TruBend Series 8000 is an impressively powerful and versatile machine that offers high-precision results for thick and large-format parts.

Why TruBend is better.

Precise results whatever the format.

The right machine for every part geometry.

TruBend bending machines enable you to process parts of any geometry economically and with high-quality results. The advantages for your business include:

- Wide choice of machine configurations.
- Numerous press forces and working lengths.
- Choice of air bending, bottom bending, and precision-angle bending.
- Exact positioning with 2-, 3-, 4-, 5- or 6-axis backgauge systems.

The BendGuard can easily be pushed to the rear making it possible to load from the side.

Cost-effective bending thanks to high productivity.

TruBend machines enable you to minimize your cost per part. Several factors contribute to this cost-saving effect:

- High axis and working speeds.
- Minimum tool setup time.
- Automatic tool clamping systems.
- Energy-efficient drives.
- BendGuard: Maximum speed and optimum safety.

MobileControl reduces the need to walk around.

OCB accelerates angle measurement.

Top-quality parts.

With TruBend machines, you achieve precise results every time.

- The stable machine frame guarantees precision.
- Precise angles every time with integrated CNC crowning.
- Precise results thanks to ingenious angle measuring systems.

Single source for all requirements.

TRUMPF does not only develop and produce press brakes. We also provide:

- TRUMPF LASERdur quality tools.
- Highly advanced machine controls.
- Customized automation solutions.
- TRUMPF software and services.

Ease of operation and ergonomic design.

The interaction between operator and machine is a decisive factor in bending. That is why TruBend machines are designed with the operator in mind, to lighten the workload:

- Individually selectable control settings.
- User-friendly man-machine interface.
- Ergonomic bending supports and consoles.
- Less walking due to the MobileControl.
- Simple, vertical tool loading.

The footrest increases operator ergonomics.

LED lighting ensures optimal visibility.

2D code scanner facilitates program selection.

Efficient consultation with teleservices.

TruBend Series 3000

TruBend Series 3000: Benefits at a glance.

1. Cost-efficiency, even when operated at low capacity.
2. High part accuracy.
3. High productivity.
4. Simple operation, well thought-out control.
5. Access to complete TRUMPF expertise.

Clearly structured and self-explanatory multi-touch control system.

Economical standard machine.

The TruBend Series 3000 combines outstanding TRUMPF quality with user-friendly operation in a superb value-for-money package, enabling cost-efficient production even for small batches. You can be confident of getting high precision results and enjoying maximum safety standards at an affordable price.

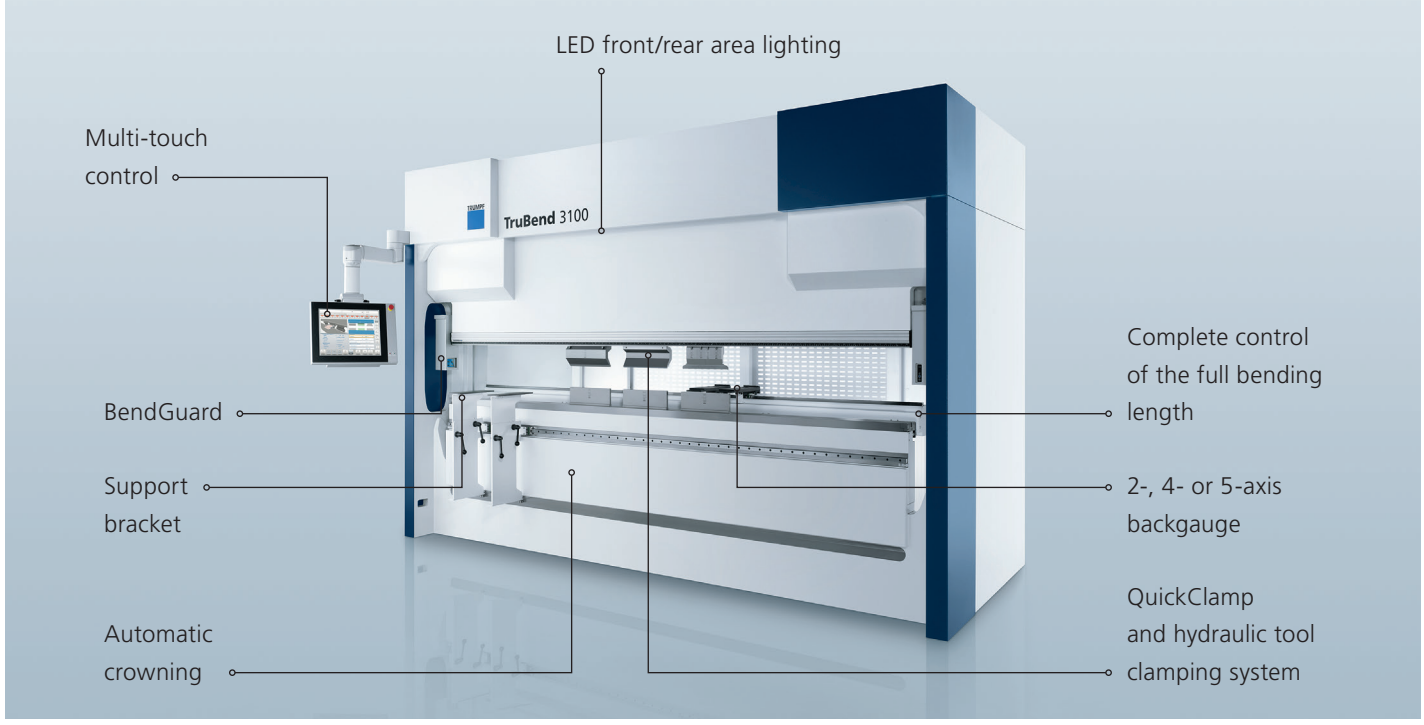
Designed to impress.

The compact architecture and integrated hydraulic drive are designed to deliver symmetrical force distribution. With the closed machine enclosure you can safely work with the entire bending length. And, automatic CNC crowning guarantees a precise and identical angle whatever the length of the bend. Simple to operate, robust and reliable, the TruBend Series 3000 offers the perfect combination of components to make it the fastest machine in its class.

Easy loading of tools from below thanks to Safety Click.

Use all available tools.

Manually with an Allen key, manually with QuickClamp or automatically with hydraulics, the TruBend Series 3000 allows you to choose from a range of different tool clamping systems. Each tool is automatically centered and quickly secured in place by the Safety Click locking mechanism. Third-party tools can also be used without the need for an adapter, so you can continue to use your existing stock of tools even after making the switch to TRUMPF machines.



TRUMPF
TruBend 3100

Technical data			
	TruBend 3066	**TruBend 3100**	**TruBend 3170**
Press force	72 tons	110 tons	187 tons
Bending length	80 in.	120 in.	160 in.
Width between columns	93 in.	133 in.	173 in.
Maximum table/beam distance	18.5 in.	18.5/24.5[1] in.	24 in.
Usable open height with manual and hydraulic tool clamping	14 in.	14/20[1] in.	20 in.
Usable open height with TRUMPF QuickClamp	17 in.	17/23[1] in.	23 in.
Operating height[2]	41–42 in.	41–42 in.	41–42 in.
Inclination of beam	± 0.12 in.	± 0.25 in.	± 0.3 in.
Speeds[3]			
Y rapid	472 in/min	472 in/min	402 in/min
Y working	max. 35 in/min	max. 35 in/min	max. 24 in/min
Y return traverse speed	472 in/min	472 in/s	402 in/min
X axis	1181 in/min	1181 in/min	1181 in/min
R axis	472 in/min	472 in/min	472 in/min
Z axis	2362 in/min	2362 in/min	2362 in/min
Precision			
Y axis position accuracy	0.0004 in.	0.0004 in.	0.0004 in.
X axis position accuracy	0.002 in.	0.002 in.	0.002 in.
R axis position accuracy	0.004 in.	0.004 in.	0.004 in.
Working range			
Y axis stroke	8 in.	8/14[1] in.	14 in.
Travel path X axis	24 in.	24 in.	24 in.
Max. gauge area in X	34 in.	34 in.	34 in.
Travel path R axis	6 in.	6 in.	6 in.
Control	T3500T	T3500T	T3500T
Connection values			
Connected load	15 kVA	20 kVA	30 kVA
Oil capacity (approx.)	120 l	32/44[1] gal.	48 gal.
Dimensions and weight			
Length x Width	102 x 65 in.	142 x 65 in.	182 x 65 in.
Height	93 in.	93/70[1] in.	115 in.
Weight	12,456 lbs.	16,975/17,637[1] lbs.	33,070 lbs.

[1] With enlarged open height (optional).

[2] With lower tool height 4 inches. Working height varies with the height of the installation material.

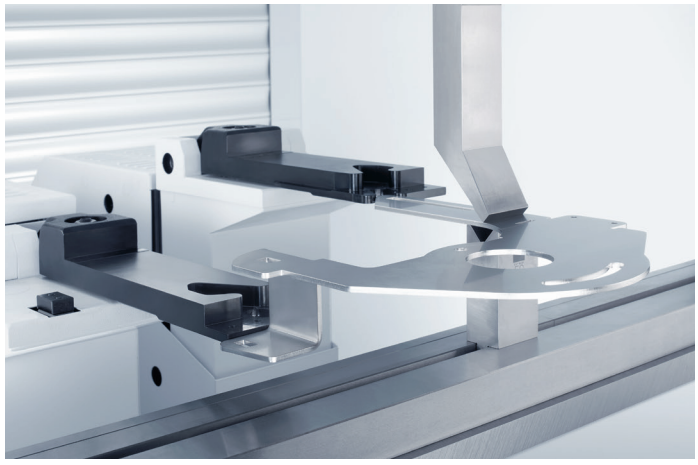
[3] Speeds freely programmable.

Subject to alteration. Only specifications in our quote and order confirmation are binding.

TruBend Series 5000

TruBend Series 5000: Benefits at a glance.

1. Unrivaled productivity.
2. Full application freedom.
3. Extremely user-friendly
4. Exact results.
5. Cutting-edge control.



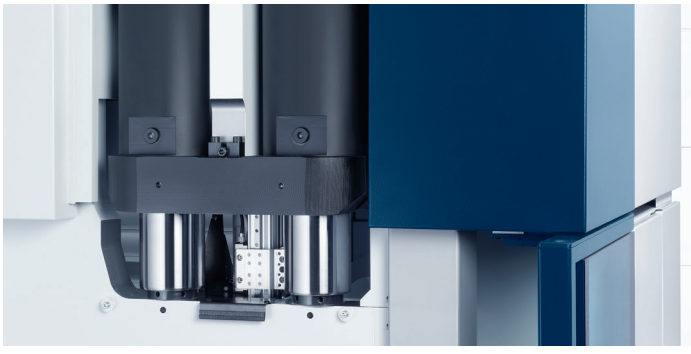
Flexible production with the 6-axis backgauge.

Productive jack of all trades.

The TruBend Series 5000 is TRUMPF's most successful bending machine worldwide. High productivity throughout, from programming and tool setup to the bending process. Innovative features such as the lower tool displacement rail and the 6-axis backgauge give you complete application freedom.

Operator in focus.

The third generation of the TruBend Series 5000 has a great many innovative features to make an operator's everyday work easier. These include a revolutionary control concept that can be used easily and intuitively, as well as a variety of ergonomic solutions.



Optimal part precision due to 4-cylinder drive technology.

Precision is its strong point.

The TruBend Series 5000 achieves optimal part precision and angle accuracy starting from the very first part as a result of, among other things:

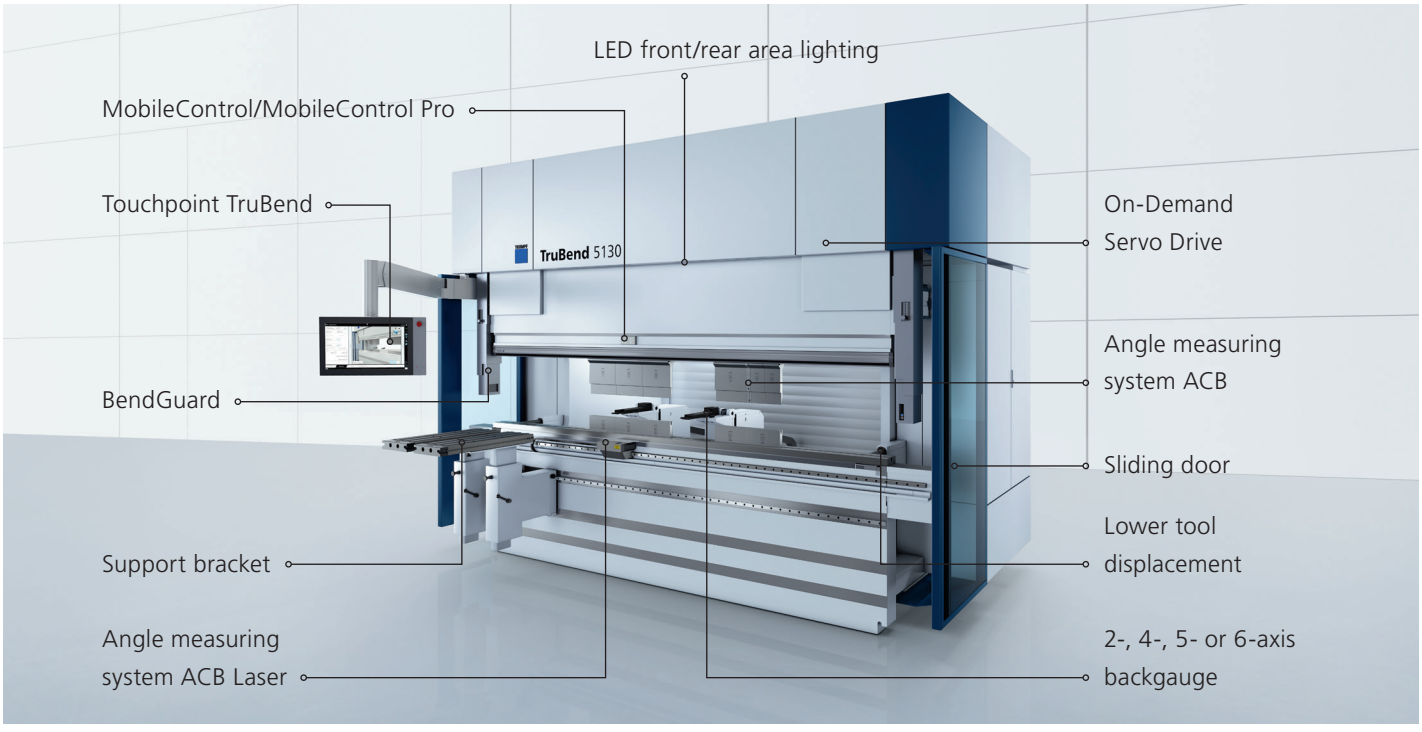
- 4-cylinder drive technology.
- CNC-controlled crowning.
- Ingenious angle measuring systems.

Surprisingly quiet, convincingly fast.

Not only is the On-Demand Servo Drive extremely energy-efficient, but at 520 in/min it is also particularly fast. In addition, the eco-friendly drive has another impressive feature - it is unusually quiet.

Flexible positioning.

The lower tool clamping can be moved into a variety of positions in the X direction. This allows you to use special lower tools whenever necessary, for example to make folds or Z edges at one station – quickly and without the need for a new setup. Repositioning is also useful when removing parts.

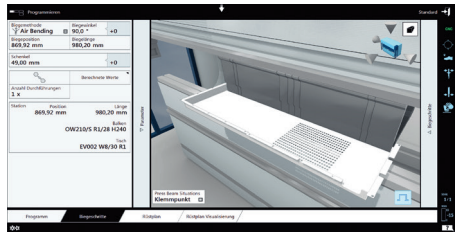


TruBend Series 5000

A dialog between man and machine.

TRUMPF has combined the advantages of state-of-the-art multi-touch technology with industrial control to make operating with Touchpoint TruBend remarkably simple.

- Intuitive operation just like that of a tablet or smartphone, even when wearing gloves.
- Displays concentrate on the essentials and make operation easier.
- Realistic 3D visualization complete with collision monitoring simplifies processing.
- Ideal solution for every application – no matter how simple or complex the component may be.
- The high-performance processor guarantees constant fast and reliable use in your everyday industrial operations.



Intuitive operation with the Touchpoint TruBend.

Walking less, doing more.

With MobileControl and MobileControl Pro you can control your machine from wherever you happen to be. This saves you from having to move from the control unit to the workstation, and as a result productivity is increased. Each MobileControl unit features all of the essential control functions. The MobileControl Pro modules also allow you to adjust the most important settings, such as correction values or the order of bending steps, right at the machine. The MobileControl and MobileControl Pro modules enable you to work from anywhere along the work area.

Mobile operating units increase productivity.

Bending assistance.

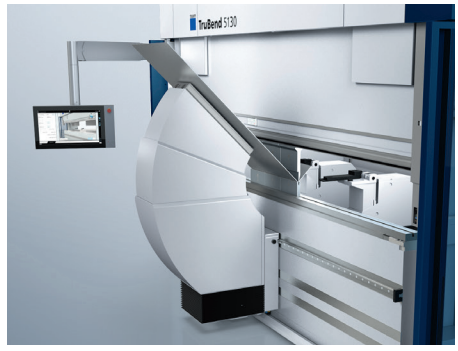
The bending aid provides valuable practical assistance for angles of up to 30° and includes an automatic height adjustment. It supports operators in bending especially heavy or large parts. There is a choice of either synthetic, brush or roller supports.

On good form.

Support brackets with infinite height adjustment make it easier to handle your parts. They can take loads of up to 441 lbs. and, just like the bending aid, are available with a choice of different supports.

Twice as bright.

With the Tool Indicator operators can work more productively. During setup, white LEDs show with millimeter precision exactly where bending tools are needed. And while bending, the optical positioning aid always lights up at the station where the next bending operation is done. The operators no longer have to consult the control unit.



The bending aid provides support for the processing of heavy or large blanks.

Robust consoles facilitate handling.

TruBend Series 5000

More room, more light, the best view.

Sideways sliding doors take up minimum space and create extra room around the machine for supplying sheet metal and for depositing bent parts. Since the doors are made of safety glass, they ensure both optimum protection and ideal lighting conditions in the work area.

This optimal illumination is further enhanced by LEDs found both in front of and inside the machine. These not only keep energy consumption low but also prevent the production of excess heat that would otherwise bother operators in their work.

Sliding doors minimize space requirements.

Keeping an eye on sheet thicknesses.

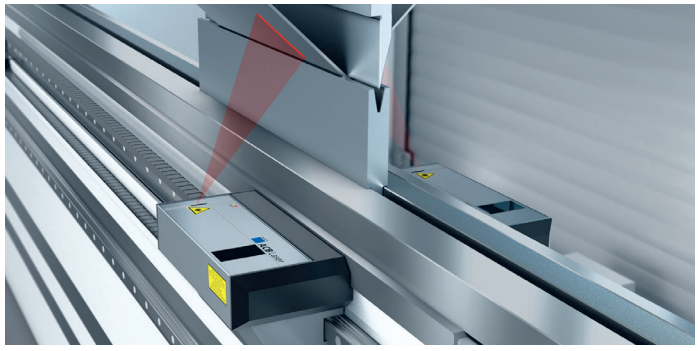
Thickness Controlled Bending (TCB) is a straightforward function that compensates for variations in sheet thickness. Sensors in the machine detect the thickness of the next sheet and adjust the upper tool's plunge depth accordingly. This allows you to achieve angle quality regardless of the sheet thickness – without having to recalibrate or reprogram, and with no drop in productivity.

LEDs provide optimal lighting conditions.

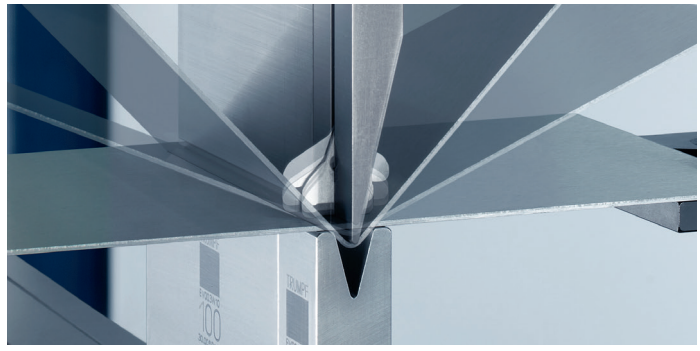
Straight ahead to precise angles.

Precise angles are essential for bending. Variations in material characteristics such as strength or springback can compromise precision. TRUMPF's solution is called ACB, which stands for Automatically Controlled Bending. Using the angle measuring systems from the ACB family means even the first part in a series turns out perfect. Sensors determine the actual angle together with the springback and guide the ram to achieve the desired angle.

TRUMPF offers two systems that complement each another perfectly. Depending on the application, the ideal system is deployed.



Optical angle measuring system ACB Laser.



Tactile angle measuring system ACB.

The right solution for every application.

ACB Laser.
The TRUMPF ACB Laser offers you a non-contact, optical system for measuring angles. A laser projects a line onto the sheet and a camera detects the angle. This involves putting two measuring units into position using CNC.

ACB.
The user-friendly ACB determines and adjusts angles with the help of sensor disks integrated into the upper tool.

ACB Laser strengths	ACB strengths
■ High speed. ■ High angle accuracy. ■ Applicable with different bending methods.	
■ Special fields of application: – Acute and open angles. – Thick sheets. – Large radii. ■ No setup effort. ■ Easy to use. ■ Use with special tools. ■ Maximum surface quality.	■ Special fields of application: – Short sides. – Reflective surfaces. – Internal flanges. ■ Quick station bending. ■ Fast multi-point measurements. ■ No interference contours. ■ An inexpensive entry into angle measuring.

Awards for the TruBend 5130:

DESIGN AWARD 2015

reddot award 2015
winner

GERMAN DESIGN AWARD WINNER 2016

Award for Touchpoint control:

reddot award 2016
winner interface design

Technical data

	TruBend 5085	TruBend 5130	TruBend 5170	TruBend 5230	TruBend 5320
Press force	94 tons	141 tons	187 tons	253 tons	353 tons
Bending length	87 / 107[1] in.	127 in.	127 / 167[1] in.	127 / 1670[1] in.	174 in.
Width between columns	69 / 89[1] in.	106 in.	106 / 145[1] in.	106 / 145[1] in.	145 in.
Maximum table / beam distance	20 / 29[1] in.	20 / 29[1] in.	29 in.	29 in.	29 in.
Usable open height	15 / 24[1] in.	15 / 24[1] in.	24 in.	24 in.	24 in.
Throat	16.5 in.	16.5 in.	16.5 in.	16.5 in.	16.5 in.
Operating height[2]	43 – 44 in.	43 – 44 in.	43 – 44 in.	43 – 44 in.	44 – 45 in.
Inclination of beam	±0.4 in.	± 0.4 in.	± 0.4 in.	± 0.4 in.	± 0.4 in.
Speeds[3]					
Y rapid	520 in / min	520 in / min	520 in / min	520 in / min	520 in / min
Y working[4]	max. 59[4] in / min	max. 59[4] in / min	max. 59[4] in / ,in	max. 59[4] in / min	max. 59[4] in / min
Y return traverse speed	520 in / min	520 in / min	520 in / min	520 in / min	520 in / min
X axis[6]	2362 / 4132 in / min	2362 / 4132 in / min	2362 / 4132 in / min	2362 / 4132 in / min	2362 / 4132 in / min
R axis	780 in / min	780 in / min	780 in / min	780 in / min	780 in / min
Z axis[6]	4132 / 5906 in / min	4132 / 5906 in / min	4132 / 5906 in / min	4132 / 5906 in / min	4132 / 5906 in / min
Precision					
Y axis position accuracy	0.0002 in.	0.0002 in.	0.0002 in.	0.0002 in.	0.0002 in.
X axis position accuracy	0.002 in.	0.002 in.	0.002 in.	0.002 in.	0.002 in.
R axis position accuracy	0.003 in.	0.003 in.	0.003 in.	0.003 in.	0.003 in.
Working range					
Y axis stroke	8.5 / 17.5[1] in.	8.5 / 17.5[1] in.	17.5 in.	17.5 in.	17.5 in.
Travel path X axis	24 in.	24 in.	24 in.	24 in.	24 in.
Max. gauge area in X[6]	34 / 39 in.	34 / 39 in.	34 / 39 in.	34 / 39 in.	34 / 39 in.
Travel path R axis	10 in.	10 in.	10 in.	10 in.	10 in.
User interface	Touchpoint TruBend	Touchpoint TruBend	Touchpoint TruBend	Touchpoint TruBend	Touchpoint TruBend
Connection values					
Connected load	13[4] / 32[5] kVA	17.5[4] / 42[5] kVA	24[4] / 61[5] kVA	33[4] / 69[5] kVA	40[4] / 90[5] kVA
Oil capacity	18 gal	30 gal	48 / 58[1] gal	48 / 58[1] gal	58 gal
Dimensions and weight[7]					
Length x Width	120 x 71 in. 139 x 71[1] in	157 x 75 in.	157 x 75 in. 196 x 75[1] in.	163 x 81 in. 202 x 81[1] in.	204 x 81 in.
Height	94 / 112[1] in.	94 / 112[1] in.	118 in.	126 in.	126 in.
Weight	17637 / 19180[1] lbs.	23590 / 26015[1] lbs.	31195 / 39353[1] lbs.	37920 / 43762[1] lbs.	51588 lbs.

[1] Second figure relates to extended version (optional).

[2] With lower tool height 4 inches. Working height varies with the height of the installation material.

[3] Speeds freely programmable.

[4] With a working speed of 24 in/min.

[5] With increased working speeds at maximum press force (option).

[6] Depends on backgauge selected.

[7] Data refer to basic machine without options.

Subject to alteration. Only specifications in our quote and order confirmation are binding.

TruBend Series 7000

TruBend Series 7000: Benefits at a glance.

1. Outstanding productivity.
2. Maximized, multi-axis dynamics.
3. Engineered for maximum comfort.
4. Low energy consumption.
5. Reduced footprint.

Working without fatigue at the TruBend Series 7000.

Ergonomic high-speed machine.

The TruBend Series 7000 is a perfect example of the coordinated interaction between operator and machine. You can be sure of achieving outstanding productivity at every stage of the process due to its high speed and acceleration, and the optimized work environment provided by its ergonomic features. It is a particularly cost-effective solution for bending small- and medium-sized parts.

Certified ergonomic quality.

Human factor engineering played a significant role in the conceptual design of the TruBend Series 7000. As a result, the machines are a pleasure to use, operators can work quickly and efficiently, and part quality is consistently high. It is the first press brake to be awarded a quality certificate specifically for its ergonomic design.

Better quality assurance.

An integrated bending line laser projects a line of light onto the surface of the sheet metal, indicating precisely where it will be bent and enabling the operator to verify that the workpiece is in the correct position.

The integrated bending line laser ensures spot-on positioning.

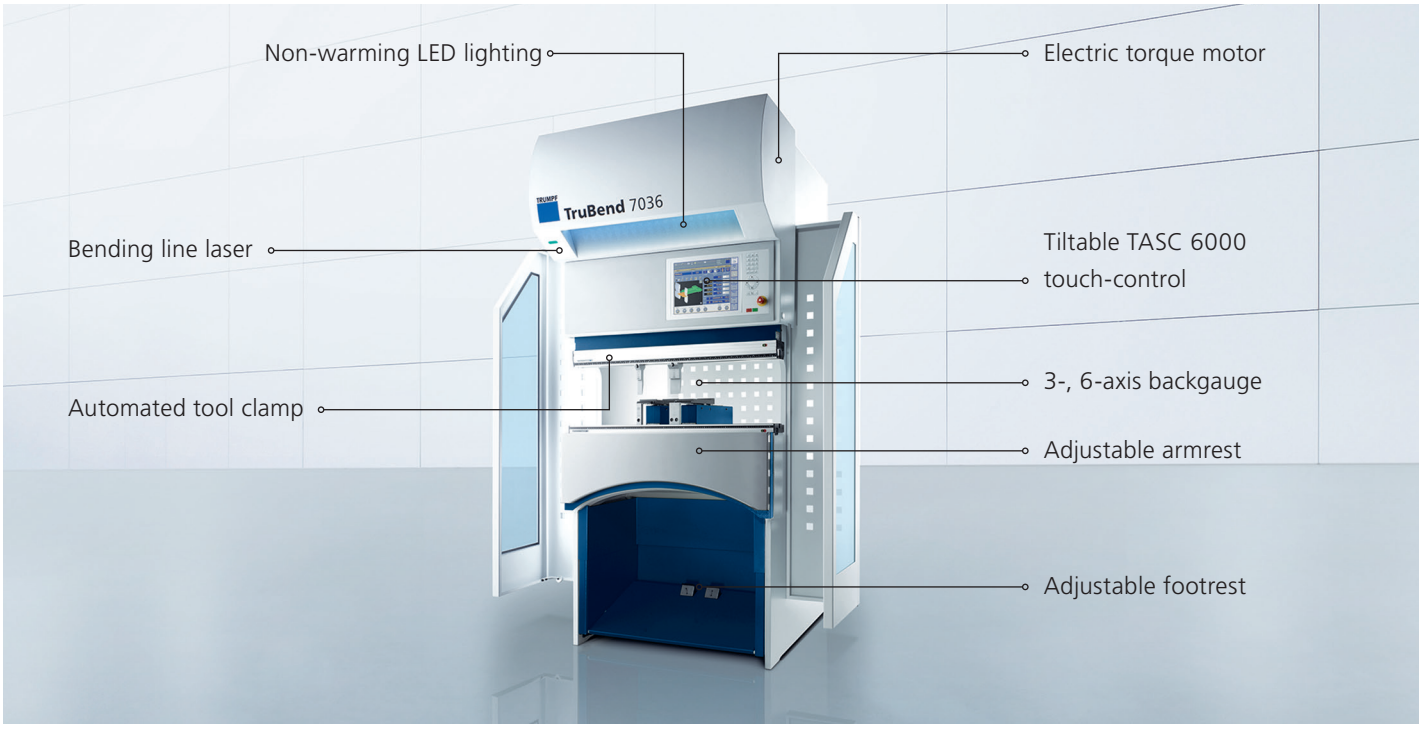
Outstanding productivity.

The gearless, direct-drive motor delivers high torque even when rotating at low speed – the optimum requirements for achieving a high press force coupled with a high throughput rate. This extremely energy-efficient electric motor helps you to reduce energy costs.

Maximized, multi-axis dynamics.

The time required to bend small parts depends only partly on the operating speed of the ram. An even more important factor is the acceleration of the backgauges. To enable them to be positioned more rapidly, they are built to a special design using a lightweight, stable carbon-fiber material. The machine can operate much faster because the mass it has to move is significantly lower. The system is available with either 3 or 6 axes.

The user-friendly touch screen with intuitive menus can be tilted to avoid reflections.



TRUMPF
TruBend 7036

Technical data	
	TruBend 7036
Press force	40 tons
Bending length	40 in.
Width between columns	37 in.
Maximum table/beam distance	16.5 in.
Usable installation height	12 in.
Throat	6 in.
Operating height[1]	45 in.
Speeds[2]	
Y rapid	520 in/min
Y working	max. 59 in/min[3]
Y return traverse speed	520 in/min
X axis	2362 in/min
R axis	780 in/min
Z axis	45 in/min
Precision	
Y axis position accuracy	0.00008 in.
X axis position accuracy	0.0008 in.
R axis position accuracy	0.0002 in.
Working range	
Y axis stroke	5 in.
Travel path X axis	9 in.
Max. gauge area in X	20 in.
Travel path R axis	3 in.
Control	TASC 6000
Connection values	
Connected load	6 kVA
Dimensions and weight	
Length x Width	7 x 52 in.
Height	94 in.
Weight	5732 lbs.

[1] For dies with a height of 4 inches.

[2] Speeds freely programmable.

[3] Depending on die width and application. May vary in accordance with local regulations.

Subject to alteration. Only specifications in our quote and order confirmation are binding.

TruBend Series 8000

TruBend Series 8000: Benefits at a glance.

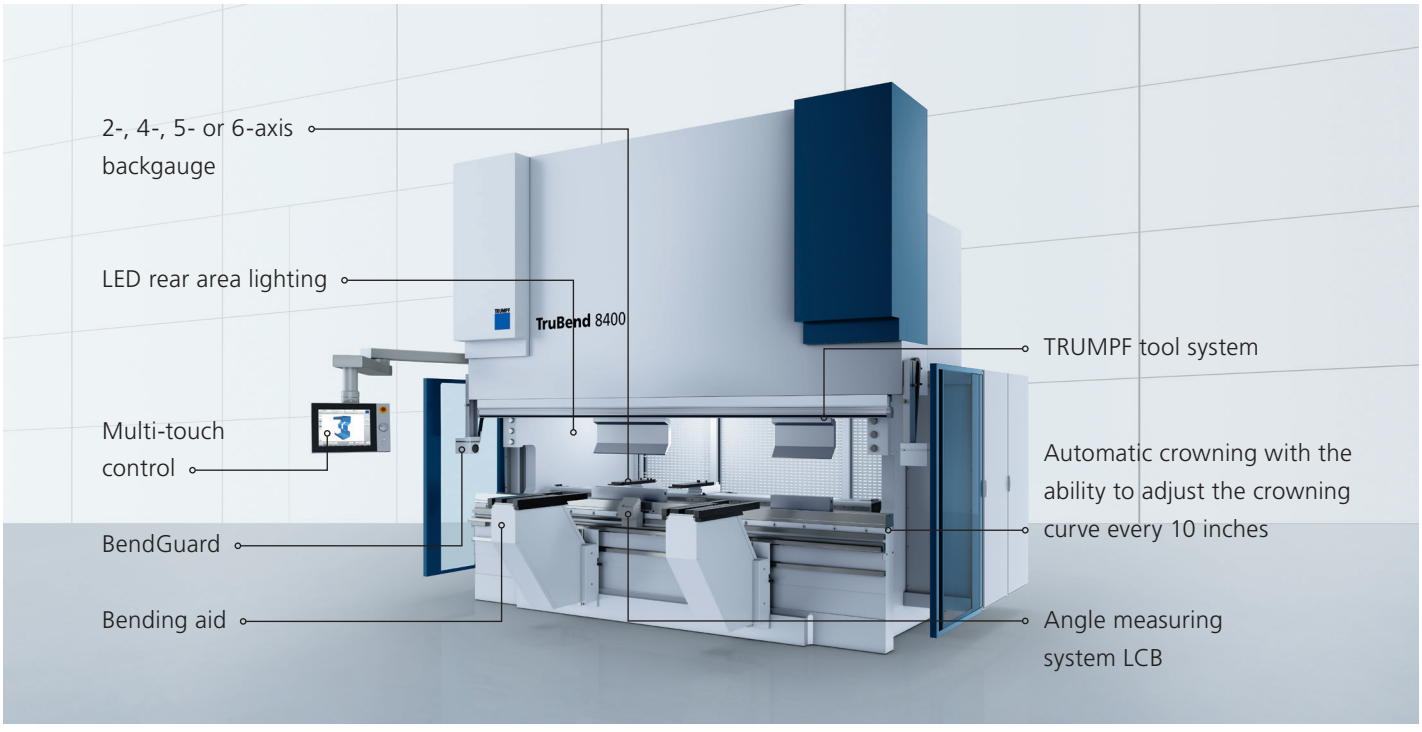
1. Bends oversized parts.
2. Can handle up to 186 t/ft.
3. Precise angles from the very first part.
4. Designed with the operator in mind.
5. Surface-mounted machines up to 20 feet.

Designed for special cases.

The TruBend Series 8000 is a great choice if you're looking for high precision and versatility, a generous open height, and press forces of up to 1,100 tons.

With a length of up to 26 feet, these machines can be used to process extra-large parts or bend smaller workpieces at multiple tool stations.

Another benefit of the TruBend Series 8000 is that the machines can partly be mounted directly on the floor, eliminating the need for expensive foundations.



Concentrated power.

The TruBend Series 8000 comes with a sophisticated automatic crowning system. It even lets you selectively tailor the crowning curve to your specific bending task every 10 inches.

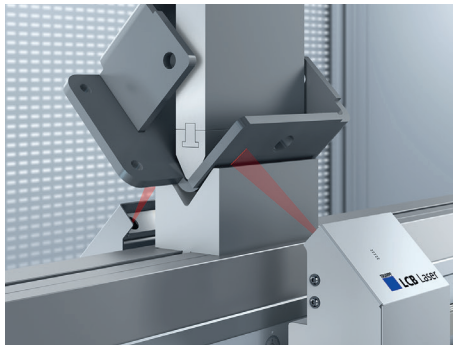
Automatic crowning.

Precise angles from the very first part.

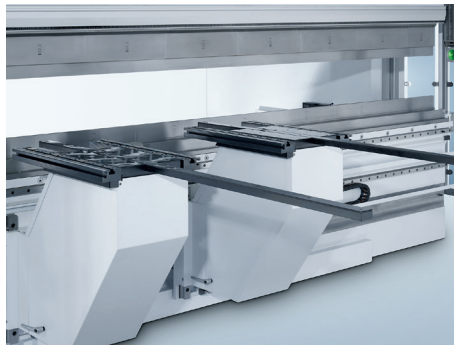
The user-friendly Laser Controlled Bending (LCB) angle measuring system ensures you get exactly the right angle from the very first part of every new series. The optical system works independently of the tool selected.

Designed with the operator in mind.

The multi-touch display makes the machine easy and intuitive to use. Useful functions such as MobileControl reduce travel and keep non-productive time to a minimum. Each bending aid enables you to process parts weighing up to 804 lbs.



Angle measuring system LCB.



Bending aids.

Multi-touch control.

Do you need even more bending force, a greater bending length or a customized bending machine? Regardless of the application, TRUMPF Werkzeugmaschinen Teningen GmbH offers tailor-made solutions to meet your needs.

TRUMPF
TruBend 8400

Technical data

	TruBend 8230	TruBend 8320	TruBend 8400	TruBend 8500	TruBend 8600	TruBend 8800	TruBend 8010
Press force	253 tons	352 tons	440 tons	550 tons	660 tons	880 tons	1100 tons
Bending length	199/ 238 in.	199/ 238 in.	159/199/ 238 in.	159/199/ 238 in.	159/199/ 238 in.	238/278/ 317 in.	238/278/ 317 in.
Width between columns	159/ 199 in.	159/ 199 in.	140/159/ 219 in.	120/159/ 199 in.	120/159/ 199 in.	199/238/ 277 in.	199/159/ 277 in.
Surface-mounted	Yes	Yes	Yes/Yes/–	Yes/–/–	–	–	–
Maximum table/ press beam distance[2]	24/32[1]/ 40[1] in.	24/32[1]/ 40[1] in.	24/32[1]/ 40[1] in.	24/32[1]/ 40[1] in.	24/32[1]/ 40[1] in.	32/ 40[1] in.	32/ 40[1] in.
Usable open height	19/26.5[1]/ 34[1] in.	19/26.5[1]/ 34[1] in.	19/26.5[1]/ 34[1] in.	19/26.5[1]/ 34[1] in.	19/26.5[1]/ 34[1] in.	26.5/ 34[1] in.	26.5/ 34[1] in.
Throat	16.5/24[1] in.	16.5/24[1] in.	16.5/24[1] in.	16.5/24[1] in.	16.5/24[1] in.	16.5/24[1] in.	16.5/24[1] in.
Operating height	46 in.	46 in.	42/46/ 42 in.	42 in.	40 in.	40 in.	38 in.
Inclination of beam	± 0.4 in.	± 0.4 in.	± 0.4 in.	± 0.4 in.	± 0.4 in.	± 0.4 in.	± 0.4 in.
Speeds							
Y rapid	520 in/min	354 in/min	402 in/min	378 in/min	283 in/min	331 in/min	236 in/min
Y working	24 in/min	24 in/min	24 in/min	24 in/min	21 in/min	24 in/min	19 in/min
Y return traverse speed	520 in/min	354 in/min	402 in/min	378 in/min	283 in/min	331 in/min	236 in/min
X axis[3]	2385 in/min	2385 in/min	2385 in/min	2385 in/min	2385 in/min	2385/1890/ 1890 in/min	2385/1890/ 1890 in/min
R axis[3]	472 in/min	472 in/min	472 in/min	472 in/min	472 in/min	472/331/ 331 in/min	472/331/ 331 in/min
Z axis[3]	2835 in/min	2835 in/min	2835 in/min	2835 in/min	2835 in/min	2835/1890/ 1890 in/min	2835/1890/ 1890 in/min
Precision							
Y axis	0.0004 in.	0.0004 in.	0.0004 in.	0.0004 in.	0.0004 in.	0.0004 in.	0.0004 in.
X axis[3]	0.0008 in.	0.0008 in.	0.0008 in.	0.0008 in.	0.0008 in.	0.0008 in.	0.0008 in.
R axis[3]	0.002 in.	0.002 in.	0.002 in.	0.002 in.	0.002 in.	0.002 in.	0.002 in.
Working range							
Y axis stroke	12/20[1]/ 28[1] in.	12/20[1]/ 28[1] in.	12/20[1]/ 28[1] in.	12/20[1]/ 28[1] in.	12/20[1]/ 28[1] in.	20/ 28[1] in.	20/ 28[1] in.
Travel path X axis[3]	24 in.	24 in.	24 in.	24 in.	24 in.	24 in.	24 in.
Max. gauge area[3] in X	40 in.	40 in.	40 in.	40 in.	40 in.	40 in.	40 in.
Travel path R axis[3]	8 in.	8 in.	8 in.	8 in.	8 in.	8 in.	8 in.
User Control	T8000T Multi-touch	T8000T Multi-touch	T8000T Multi-touch	T8000T Multi-touch	T8000T Multi-touch	T8000T Multi-touch	T8000T Multi-touch
Connection values							
Connected load	35 kVA	44 kVA	53 kVA	62 kVA	74 kVA	97 kVA	97 kVA
Oil capacity	106 gal.	106 gal.	159 gal.	159 gal.	185 gal.	264 gal.	264 gal.
Dimensions and weight on request							

[1] Figure relates to extended version (optional).

[2] Values for tool clamp with a maximum load of 110t/ft.

[3] Figures refer to 2-, 4- and 5-axis backgauge.

Subject to alteration. Only specifications in our quote and order confirmation are binding.

TruBend Series 8000 in tandem installation

TruBend Series 8000 in tandem installation: Benefits at a glance.

1. Greater part variety by doubling press force and bending length.
2. Increased capacity by virtue of both machines possessing stand-alone capability.
3. Longer side length due to greater throat depth.
4. Lower setup costs with surface-mounted installation.
5. Greater flexibility through lower tool displacement.

Doubled up to make one flexible large-format machine.

Do you have parts that are 20 or 26 feet long, but you also bend short sheets? Then a flexible solution is exactly what you need: the TruBend 8000 Series tandem installation. Two machines work in sync and allow you to double the bending length and the press force. However, each machine can also be used separately, meaning that you have two machines available for short parts. The result: more capacity, more productivity, more jobs processed.

Easy operation even over 26 feet.

Clever helpers such as MobileControl, multi-touch control, and bending aids are also available in the tandem version. They facilitate work over long distances and make your production highly productive.

Productivity and safety from end to end.

Using the lower tool displacement, you can perform two different bending operations with one tool, even in tandem mode. This increases your part variety while reducing setup times and investment costs. BendGuard efficiently secures the working range over the entire tandem bending length.

Technical data

Tandem installation	**2 x TruBend 8230 (13 ft)**	**2 x TruBend 8320 (10 ft)**	**2 x TruBend 8400 (13 ft)**	**2 x TruBend 8500 (13 ft)**
Press force	2 x 253 tons	2 x 352 tons	2 x 440 tons	2 x 550 tons
Connected load (approx.)	2 x 35 kVa	2 x 44 kVa	2 x 53 kVa	2 x 62 kVa
Bending length	319 in.	240 in.	319 in.	319 in.
Width between columns	120 in.	81 in.	120 in.	120 in.
Throat depth	32 in.	32 in.	32 in.	32 in.
Length	365 in.	287 in.	368 in.	372 in.

The TruBend 8000 Series is available in four different versions with the right and the left machine type always being the same.

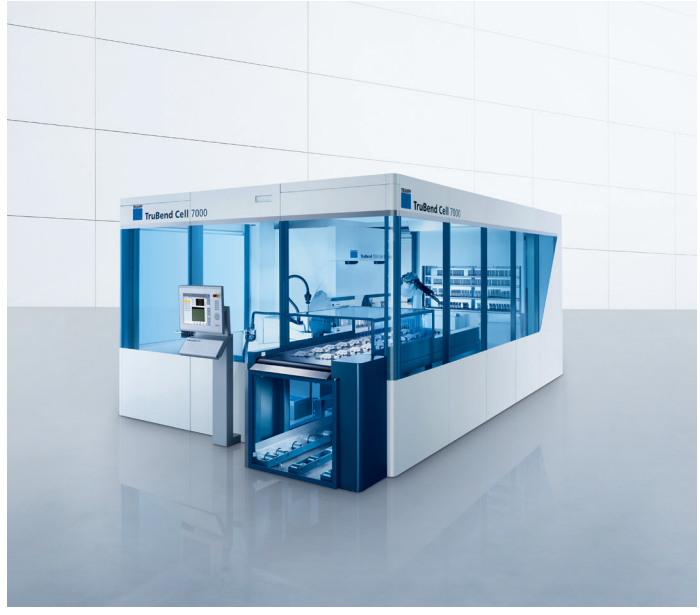
TruBend Cell

Productive all-purpose bending cell.

TruBend Cell 5000 enables you to process parts cost-efficiently and achieve high productivity. The BendMaster relieves the operator of many onerous tasks, especially when processing large and heavy workpieces weighing up to 220 lbs. The bulk of the work is handled by the machine – working around the clock, seven days a week, if necessary. You can always rely on our automated bending solutions to produce parts of a consistently high quality.

Innovative high-speed bending cell.

Ideally suited for the automatic bending of small parts, the TruBend Cell 7000 is the compact solution for fabricators looking to increase their productivity. The innovative bending units are a unique feature of the machine, with their lightweight backgauges and modern drive concept. All in all, the TruBend Cell 7000 is the fastest bending cell in its class.



ToolShuttle

The right tool always at hand.

The ToolShuttle quickly and ergonomically sets up your tools and accommodates 525 linear feet of bending tools. The compact tool storage can directly supply up to two bending machines, with the transfer carriage transporting the tools to the machines.

The tools are stored in drawers and are automatically delivered In the process the tools are delivered in setup position and at the right height, so the operator is optimally assisted. No time is lost looking for and transporting tools, and setup times are reduced to a minimum. With the ToolShuttle every tool setup operation is reduced by 60%.

Bending tools.

Tailored to your requirements.

Bending tools from TRUMPF enable you to meet any challenge, however complex it may be. They are backed by the extensive experience of our experts, who are always there to help you:

- **Customized advice and tailored design solutions.**
- **Development and testing of application-specific systems.**
- **Fast availability.**
- **High precision and a long service life.**
- **A single source for machines and tools.**

The LASERdur process used to harden the tools.

Everything you need from a single source.

Bending tools from TRUMPF live longer.

Precision and quality are the characteristics that count when manufacturing bending tools. Our unique LASERdur technique results in extremely hard-wearing tools. We use a laser hardening process to selectively strengthen tools in those areas that are most subject to wear.

Flexible standard tools.

We offer a range of over 150 punches and dies from which to choose those best suited to your application. And, you are free to decide whether you wish to order a complete set or compile your personal selection. Lightweight tools are available as well.

Custom-designed tools.

If your requirements are out of the ordinary, TRUMPF will develop a customized tool solution, just for you. To ensure that it meets the quality requirements for your parts, we will test the tools using the materials you specify and produce prototype parts for you to evaluate.

Measuring tools.

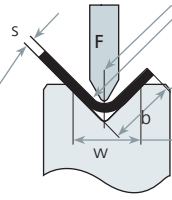
We can provide automeasuring tools based on our proven ACB system for almost every standard tool in our range. Sensor disks incorporated in the forming tool send back measurement data directly from the operating zone. With ACB, you can reproduce angles of the highest accuracy.

Press force calculator.

TRUMPF calculation table.

Calculation table also available as app.

The charts allow you to easily determine the required bending force (F) for a part measuring 1 m (39 in.) in length. The necessary force varies as a function of the sheet thickness (s, vertical scale) and the selected width of the die opening (w, horizontal scale). The tables also show the minimum leg length (b) and the inside radius (Ri) associated with the selected die size (w, width of die opening).



Press force required for 90° air bend

Mild steel 60,000 psi tensile strength

s	0.236 (6)	0.315 (8)	0.394 (10)	0.472 (12)	0.630 (16)	0.787 (20)	0.945 (24)	1.181 (30)	1.575 (40)	1.969 (50)	2.362 (60)	2.756 (70)	3.150 (80)	3.543 (90)	3.937 (100)	4.724 (120)	w
	0.177	0.236	0.295	0.354	0.472	0.591	0.709	0.886	1.181	1.476	1.772	2.067	2.362	2.657	2.952	3.543	b
	0.039	0.051	0.063	0.075	0.102	0.126	0.150	0.189	0.252	0.315	0.378	0.433	0.512	0.551	0.630	0.748	Ri
0.036	2.6	2.0	1.6	1.3	1.0												
0.048	4.6	3.5	2.8	2.3	1.7	1.4											
0.060	7.3	5.5	4.4	3.6	2.7	2.2											t/ft
0.075			6.8	5.7	4.3	3.4	2.8										
0.105				11.1	8.3	6.7	5.6	4.5									
0.120					10.9	8.7	7.3	5.8	4.4								
0.135					13.8	11.0	9.2	7.4	5.5	4.4							
0.188						21.4	17.8	14.3	10.7	8.6	7.1	6.1					
0.250								25.2	18.9	15.1	12.6	10.8	9.5	8.4			
0.313										23.7	19.8	17.0	14.9	13.2	11.9	9.9	
0.375												24.3	21.3	18.9	17.0	14.2	
0.438												33.2	29.0	25.8	23.2	19.4	
0.500													37.8	33.6	30.3	25.2	
0.625															47.3	39.4	

Stainless steel 90,000 psi tensile strength

s	0.236 (6)	0.315 (8)	0.394 (10)	0.472 (12)	0.630 (16)	0.787 (20)	0.945 (24)	1.181 (30)	1.575 (40)	1.969 (50)	2.362 (60)	2.756 (70)	3.150 (80)	3.543 (90)	3.937 (100)	4.724 (120)	w
	0.177	0.236	0.295	0.354	0.472	0.591	0.709	0.886	1.181	1.476	1.772	2.067	2.362	2.657	2.952	3.543	b
	0.039	0.051	0.063	0.075	0.102	0.126	0.150	0.189	0.252	0.315	0.378	0.433	0.512	0.551	0.630	0.748	Ri
0.036	3.9	3.0	2.4	2.0	1.5												
0.048	6.0	5.3	4.2	3.5	2.6	2.1											
0.060	11.0	8.3	6.6	5.4	4.1	3.3											t/ft
0.075			10.2	8.6	6.5	5.1	2.8										
0.105				16.7	12.5	10.1	8.4	6.8									
0.120					16.4	13.1	11.0	8.7	6.6								
0.135					20.7	16.5	13.8	11.1	8.3	6.6							
0.188						32.1	26.7	21.5	16.1	12.9	10.7	9.2					
0.250								37.8	28.4	22.7	18.9	16.2	14.3	12.6			
0.313										35.6	29.7	25.5	22.4	19.8	17.9	14.9	
0.375												36.5	32.0	28.4	25.5	21.3	
0.438												49.8	43.5	38.7	34.8	29.1	
0.500													56.7	50.4	45.5	37.8	
0.625															71.0	59.1	

F in tons
s, w, b, Ri in inches

= optimum die opening

Software:

Programmed for success.

TruTops Boost takes you faster than ever from the geometry to the NC program.

TRUMPF's TruTops Boost is the software solution for designing and programming laser, punching and bending machines that lets you increase your performance at the touch of a button. The software combines all order processing steps, from the geometry through to the completed NC program, in a single all-in-one solution. Its new operating philosophy guides you through the software in a simple, process-oriented manner while allowing you to keep an overview of your orders. Due to its numerous automated functions, the innovative Boost technology also makes you unbeatably fast. With it, you become more profitable and boost your business!

With TruTops Boost you can expand into the world of production control easily with options from TruTops Fab yet without integration effort. This enables you to plan, monitor and control your complete production including your machines and automated equipment.

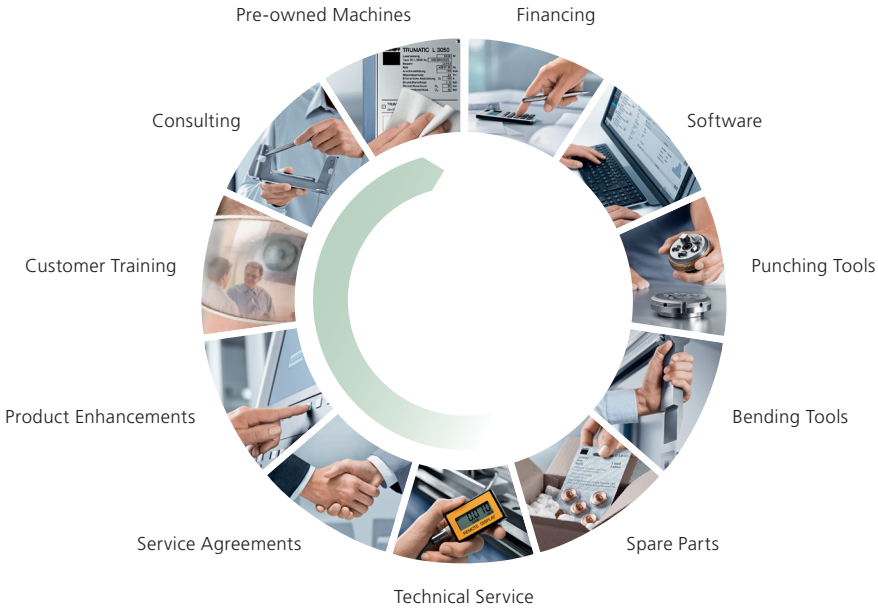
TruTops Boost: Your benefits at a glance.

- From geometry to NC program faster than ever before.
- Everything monitored: Single software solution for all order processes.
- Everything under control: Intuitive user interface supports flexible operation.
- Everything faster: Boost technology with productive automated functions.
- Innovative Boost technology + new operating philosophy = the easy way to enter the world of production control.

TruServices:

Service like no other.

Throughout the lifecycle of your machine.



Regardless of the TRUMPF technology you use, you will always get the best service. With our award-winning spare parts logistics, we guarantee the highest spare parts availability and provide you with all of the products in the shortest time. TRUMPF offers you individual financing solutions quickly and without a lot of paperwork. Our service technicians are highly trained and always available when you need them.

A Service Agreement is the ideal way of ensuring the highest availability of your machine. Should your requirements change, we have flexible upgrade options and technical innovations that will make your machine even better. Our broad range of training courses with experienced trainers and hands-on practice will also give you a head start in understanding and operating your machine.

The TRUMPF Group ranks among the world's leading manufacturers of production technology and industrial lasers. Technical and efficient solutions for our customers have been our focus since 1923. As a leading technology supplier, TRUMPF is a one-stop shop for all of your technology needs: machines, automation, storage technology and services.

TRUMPF is certified according to ISO 9001:2008

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