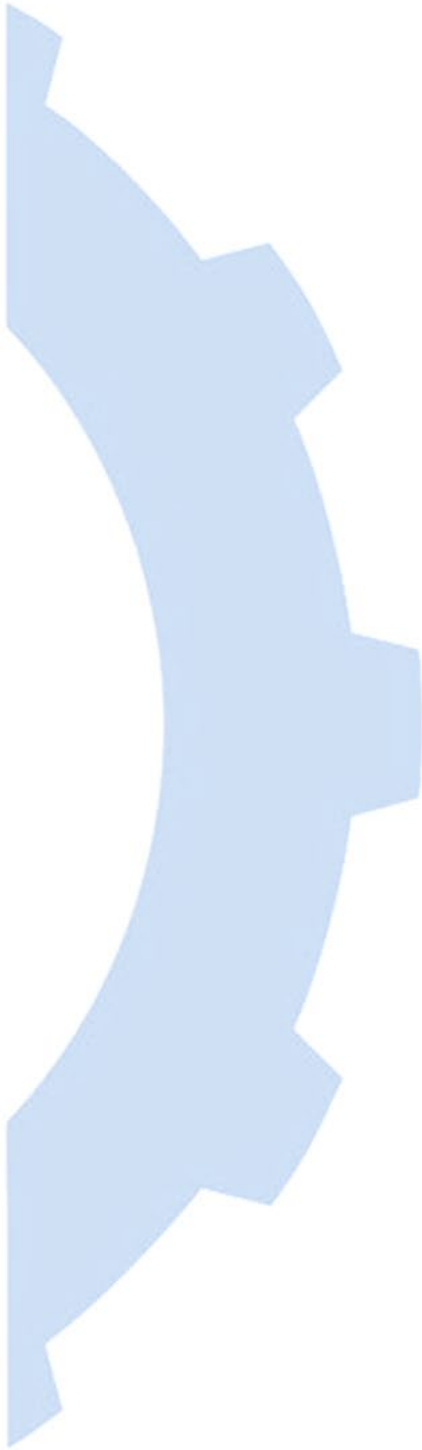


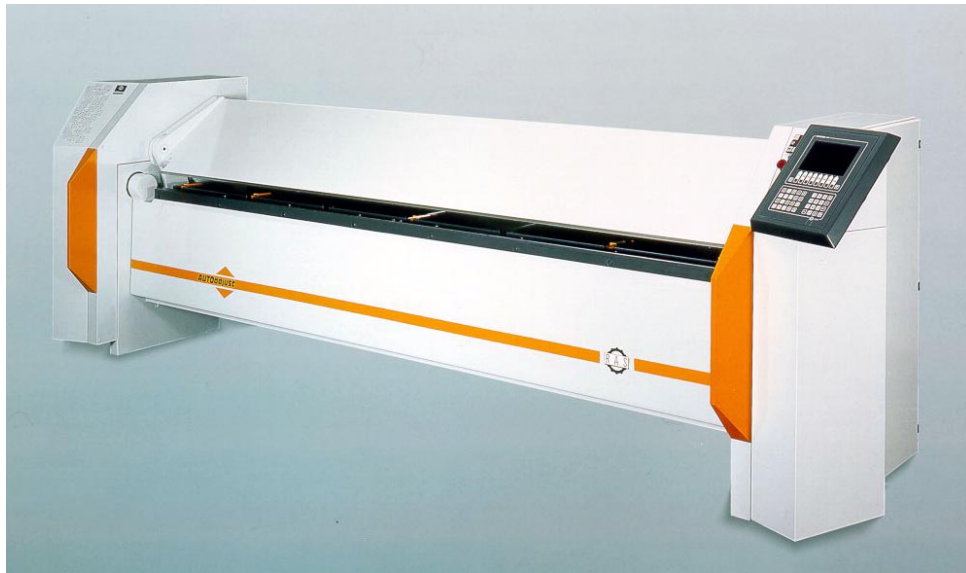


RAS SYSTEMS, LLC

**RAS 61.31 Series TURBObend
1999 Refurbished Model
Metal Folding System**



RAS 61.31 TURBObend Metal Folding Machine



RAS TURBOBEND Metal Folding System with **Varibend 4000** Icon-Based CNC Control including:

- 30° Sharp Blade
- .75" (19 mm) Folding Blade
- .39" (10 mm) Folding Blade
- Backgauge and Integrated Sheet Support System .31" -39.4"

Varibend 4000 Icon-Based CNC Control

The operator selects one of the 24 icons (part shapes) out of the icon library. The control asks for the variables (flange dimensions and angles) for this program. Up to 8 variables can be used in one program. All variables can be named.

After the input is finished, the CNC generates the program for this part including angle, backstop dimension and upper beam stroke. The program also calculates the stretch out dimension needed for shearing.

Other programmable data and functions:

- angle, backstop dimension, downstroke, upstroke, folding beam adjustment, 8 help functions
- program information: name, number, material, thickness, blank dimension, date, status, parts.
- 20 pre-programmed operator "prompt" messages
- parts counter
- operating parameters, i.e., folding beam speed
- angle correction - individual and global

- backstop correction
- incremental or absolute-dimension programming
- DOS based disk-management with optional DNC
- set-up: machine data, machine configuration, system timer, language, inch/mm, screen protector, DNC-license
- full-service diagnostics including oscilloscope

Technical Data TURBOend Folder			
Maximum Sheet Thickness	16 ga/1.5mm	Automatic CNC folding beam adjustment	.05"-.244"
Maximum Length	124"/3150mm	Motor Drive Power Upper Beam	1 hp/.75 kw
Backgauge Depth	0.236" - 39.4" / 6-1000mm	Motor Drive Power Folding Beam	1.5 hp/1.1 kw
Machine Length	170"/4320mm	Down stroke Speed	2"/sec 6mm/sec
Machine Width	55.1"/1400mm	Maximum folding beam speed	80°/sec.
Machine Height	54.33"/1380mm	Maximum backgauge speed	12"/sec.
Working Height	33.5"/850mm	Backgauge Accuracy	± .004"/.15mm
Maximum Upper Beam Upstroke	0 - 4.73" / 0- 120mm	*Standard Electrical Power	230/3/60
Machine Weight	5,500 lbs.	Current Usage	Max. 20 amps