



Complete Solution for
Tube and Pipe

6B Series

CNC 6 Axis Tube Bender

Max. Capacity up to Ø168mm
CNC Proportional Servo Bending



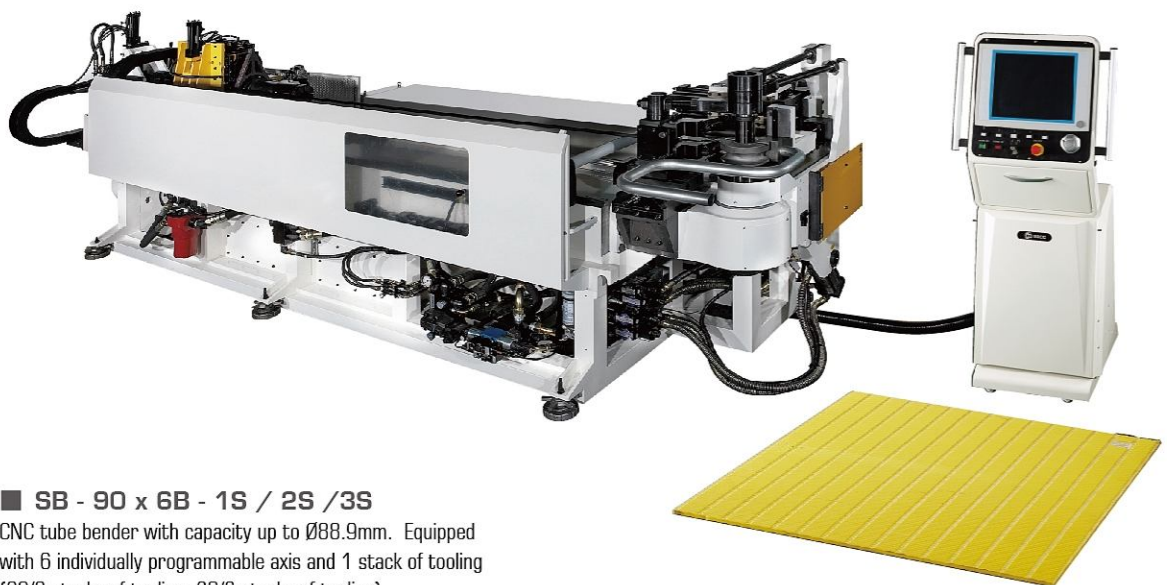
6B Series

CNC Proportional Servo Bending 6 controlled axis with max. Ø168mm capacity

With models that extend up to Ø168mm capacity, the SOCO CNC 6B series tube bender brings the optimal tube bending power and accuracy solutions for the automotive, trucking, buses, boiler, ship building and other heavy industries.

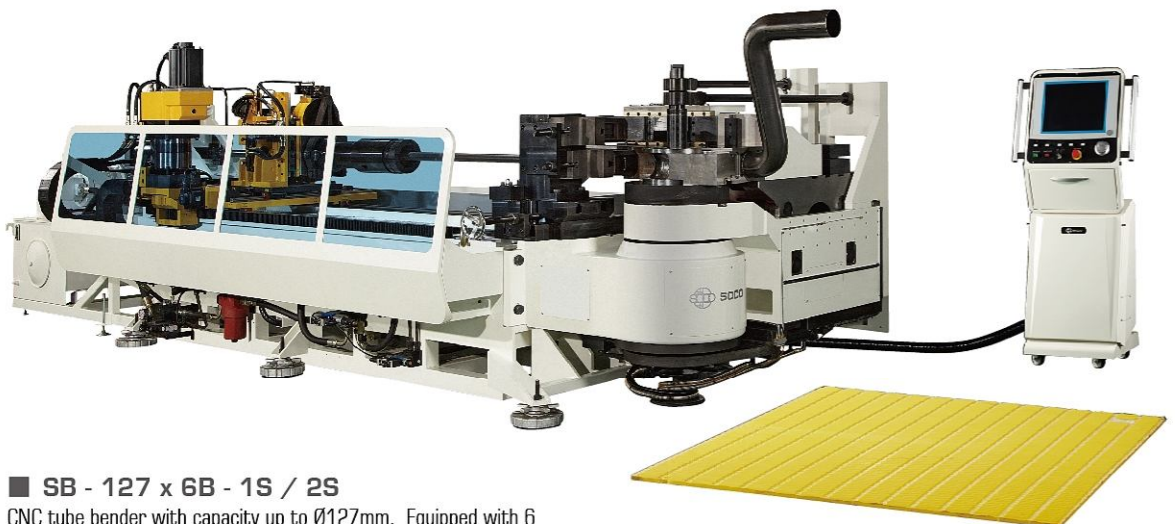
6 servo electric / proportional servo controlled axis

- Feeding (Y)
- Rotation (B)
- Bending (C)
- Horizontal Movement (X1 and X2)
- Pressure Die Assist (V1) except 168 type



■ SB - 90 x 6B - 1S / 2S / 3S

CNC tube bender with capacity up to Ø88.9mm. Equipped with 6 individually programmable axis and 1 stack of tooling (2S/2 stacks of tooling, 3S/3 stacks of tooling)



■ SB - 127 x 6B - 1S / 2S

CNC tube bender with capacity up to Ø127mm. Equipped with 6 individually programmable axis and 1 stack of tooling (2S/2 stacks of tooling, 3S/3 stacks of tooling)

Machine Features:

- 6 individually programmable axes
- Max. Ø168mm capacity
- Individually controllable pressure die assists for Each Bending Stack
- Programmable 2 speeds early mandrel extraction
- Each axis may be individually programmed during arm return mode
- SOCO proprietary control software with IPC & Touch Screen
- Built-in wiper die, pressure die and clamping die seats
- High accuracy and repeatability ($\pm 0.1\text{mm} / \pm 0.1^\circ$ for all axes)
- Ability for 1D Bending (*) and Roll Bending (**)
- Single and multi-stacks models
- Standard with Automatic Mandrel Lubrication System
- Centralized greasing and lubrication system for all sliding areas

Optional Equipment

- Digital Hydraulic Temperature control unit
- Connection to Local Area Network (LAN)
- SOCO bending simulation and collision detection software

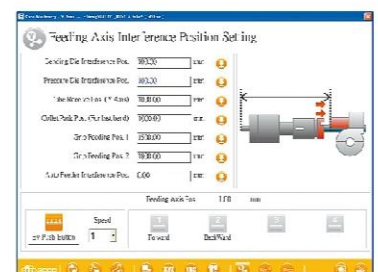
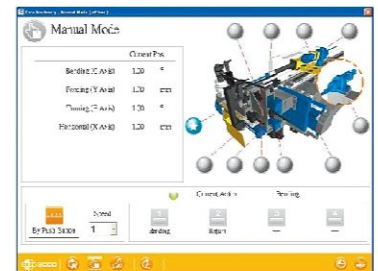
(*) Depending on tube O.D. and elongation ratio

(**) May be added by request - 2SV models

SOCO i2 CNC Controls

The Most Powerful + User Friendly Tube Bender Software in the World

- 3 Pages Setup – Up and Running in less than 5 minutes
- Graphical Interface for Tube Data + Tooling + Parts Input, with Immediate 3D display of programmed part
- Automatic Tooling Interference Zone Calculation
- Simultaneous Running of up to 4 Different Files
- Action Sequences: Multiple built-in sequences for Automatic Offset moves between bends
- Teach Mode: Interpolation / Simultaneous Movement of multiple programmable axis
- Overmode: Add and Customize movements between bends + special functions
- Data entry for both XYZ and YBC coordinates
- XYZ to YBC / YBC to XYZ coordinates conversion
- 3D display and rotation of parts + Mirroring and Image Reversal
- SOCO IRMS (Internet Remote Monitoring System): Internet Ready True Remote Access from Anywhere: Connect to i2 Controls using any mobile device, computer or laptop (Windows, iOS or Android) from any location with Internet Access
- Actual Screen + Real Time Access to Bending File, with full ability to see, edit and troubleshoot all user created programs
- Live Remote Connection to Manufacturer and Service Support with Ability to Call + Message + Record at the same time
- Maintenance Scheduling Systems
 1. Advanced Table with Detailed Maintenance Items
 2. Customizable Alarms for Daily, Weekly, Quarterly and Yearly Items
 3. Maintenance Records connected to User Login
- Ability to connect to Internal Network, USB and / or Cloud Systems
- Advanced File Management Systems for Parts
- Independent Tool Library allows sharing of tool data to other machines or plants
- User Management:
 1. 3 Security Levels + Ability to Create over 1000 User IDs
 2. Completely Customizable Access by User
 3. Login Control + Hard Key Access
- Access to Machine and Production Data from anywhere using SOCO IRMS
- Bending Simulation and Collision Detection Software (Optional)
- SOCO CAD Reader – Import 3D Files and automatically fill in coordinates and tooling info (Optional)
- Off-Line i2 Controls for Development, Simulation and Data Analysis (Optional)



Specifications / Model		SB-76x6B-1S SB-76x6B-2S SB-76x6B-3S	SB-90x6B-1S SB-90x6B-2S SB-90x6B-3S	SB-110x6B-1S SB-110x6B-2S	SB-127x6B-1S SB-127x6B-2S	SB-168x6B-1S SB-168x6B-2S
Mild Steel Capacity (mm) (CLR1.5D)		Ø76.2 x 2.5t Ø63.5 x 4.2t	Ø88.9 x 2.1t Ø76.2 x 3.5t	Ø110 x 2.8t Ø100 x 4.0t	Ø127 x 4t	Ø168 x 6.8t x CLR2.0D
Stainless Steel Capacity (mm) (CLR1.5D)		Ø76.2 x 2.0t	Ø88.9 x 1.8t	Ø110 x 1.7t Ø100 x 2.8t	Ø127 x 2.5t	Ø168 x 5.5t x CLR2.0D
Max. Bending Radius Difference (R1-R2) (mm)		80 (2S / 3S)	80 (2S / 3S)	100 (2S)	130 (2S)	190 (2S)
Max. Tube Length With Mandrel (mm)		4130	4130	5000	4000	5000
Max. Bending Angle		190°	190°	190°	190°	190°
Max. Draw Bending Radius (mm)		250	250	300	350	550
Accuracy	Bending	± 0.1°	± 0.1°	± 0.1°	± 0.1°	± 0.1°
	Rotation	± 0.1°	± 0.1°	± 0.1°	± 0.1°	± 0.1°
	Feeding (mm)	± 0.1	± 0.1	± 0.1	± 0.1	± 0.1
Dimension (mm) (L x W x H)		5500 x 2100 x 1650 (1S) 5500 x 2100 x 1720 (2S / 3S)	5500 x 2100 x 1650 (1S) 5500 x 2100 x 1720 (2S / 3S)	7300 x 2100 x 1850 (1S) 7300 x 2100 x 1850 (2S)	6800 x 2400 x 2000 (1S) 6800 x 2500 x 2000 (2S)	8500 x 2880 x 2000
Weight (Kg)		6600 / 7100 (1S / 2S & 3S)	7500 / 8000 (1S / 2S & 3S)	9600 / 10200 (1S / 2S)	13600 / 14100 (1S / 2S)	19000 / 19500 (1S / 2S)

* Due to continuous improvements and designs; the manufacturer reserves the right to modify or make any changes of all models without notice.
(a.) Can be extended by special order



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