

Combined bending and cutting machine/manual brake bending machines

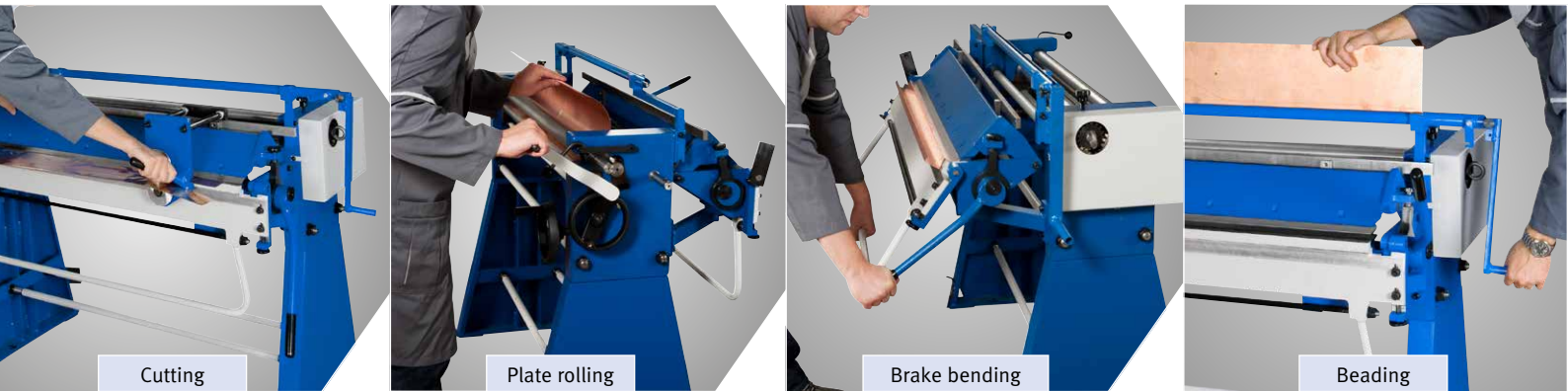
SRWS 1020 KOMBI – Combined machine for roofers for plate rolling, brake bending, cutting and beading

- ▶ 4 machines in 1: Beading machine, plate rolling machine, brake bending machine and roller shears
 - ▶ Ideal for roofers on site, e.g. for creating bay window panelling, flashings, chimney cladding or gutters
- ▶ Sturdy and rugged design
 - ▶ The removable roller shears allow for precise cutting of copper and zinc sheet with a thickness of up to 0.8 mm
 - ▶ Plate rolling function with roller drive via crank and gear
- ▶ With swivel-out top roller
 - ▶ With beading function for sheet metals up to 0.6 mm
 - ▶ Brake bending function with safe clamping of the workpiece due to spring preload of the top beam

For creating bay window panelling, flashings, chimney cladding or gutters with a single machine



1 machine - 4 application options



SRWS KOMBI - Combined machine for plate rolling, brake bending, cutting and beading

Technical specifications	Cutting capacity	Plate rolling capacity	Brake bending capacity	Beading capacity	Dimensions L x W x H in	Weight	Art. no.
SRWS 1020 KOMBI	0.8 mm	1 020 x 1.0 mm	1 020 x 1.5 mm	1 020 x 0.6 mm	1 490 x 850 x 1 300 mm	290 kg	3778001

* Data relate to cutting zinc sheet

HSBM – Manual brake bending machine

- ▶ Inexpensive entry-level models for trades
- ▶ Simple design and rugged manufacture guarantee precise work
- ▶ Safe clamping of the workpiece with clamping device

HSBM 305 HS and HSBM 610 HS

- ▶ Segmented upper beam
- ▶ Ideal for creating any kind of section including boxes with circumferential edge bending
- ▶ User-friendly adjustment of the top beam via eccentric
- ▶ Top beam for U sections with tall bent edges
- ▶ Brake bending via bow handle
- ▶ Easy to transport

HSBM 1020-10

- ▶ User-friendly adjustment of the top beam
- ▶ Brake bending via double handle



HSBM 610 HS

Passageway 25 mm here



HSBM 1020-10

Type	Segmentation
HSBM 305 HS	25-50-50-75-100 mm
HSBM 610 HS	25-50-75-205-255 mm

Model	HSBM 305 HS	HSBM 610 HS	HSBM 1020-10
Art. no.	3772305	3772610	3771020
Technical specifications			
Max. working width	305 mm	610 mm	1 020 mm
Max. sheet thickness*	1.0 mm	1.0 mm	1.0 mm
Max. bending angle	135°	135 °	135 °
Weight	30 kg	42 kg	105 kg
Dimensions	500 x 350 x 410 mm	850 x 360 x 420 mm	1 276 x 550 x 975 mm

* Performance details relate to material with a tensile strength 400 N/mm²; optional hardened tool required for bending VA steel

Accessories for HSBM 1020-10	Art. no.
Tempered top beam	3772700

Manual brake bending machine

HSBM 3200-0.7 – Manual brake bending machine with detachable disc shears

Rugged, versatile and mobile

- ▶ Ideal for roofers and plumbers on site, e.g. for creating bay window panelling, flashings or chimney claddings
- ▶ Chassis and bending machine can be transported separately and easily assembled, and are thus ideal for the building site
- ▶ Chassis height adjustable by 152 mm
- ▶ The removable roller shears allow for precise cutting of aluminium, copper and zinc sheet
- ▶ Simple design and rugged manufacture guarantee precise work

Easy operation and easy on the material

- ▶ Robust clamping of the top jaws via two manual levers
- ▶ Brake bending possible using four manual levers
- ▶ Bending scale from 0 - 120 ° and length scale from 0 - 3 200 mm integrated in the machine
- ▶ Silicone insert on bottom jaws protects the material

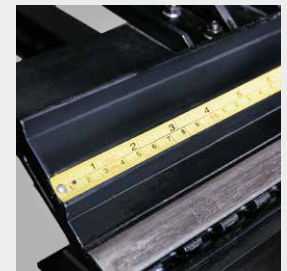
- › Large bending width of 3200 mm and still easy to transport
- › Bending and trimming with a single machine



▶ Scale shows bending angles from 0 - 120°



▶ Disc shears for trimming the finished workpiece to the required length



▶ Length scale from 0 - 3 200 mm in mm and inches



▶ Chassis height-adjustable by 152 mm

Model	HSBM 3200-0,7
Art. no.	3772320
Technical specifications	
Max. working width	3 200 mm
Max. sheet thickness steel 400 N/mm ²	0.7 mm
Max. sheet thickness stainless steel	0.4 mm
Max. sheet thickness aluminium	0.8 mm
Sheet infeed length max.	580 mm
Max. bending angle	155 °
Weight	122 kg
Length x width x height	3 200 x 1 250 x 1 325 mm
Max. height	1 477 mm

*Please turn over for descriptions of the packaging surcharges

flexCAT 3100 EOT-PRO – special vacuum for liquids with oil content and metal chips

- ▶ Easy vacuuming of, e.g., cooling lubricants or coarse metal swarf
- ▶ Ball valve for draining fluids
- ▶ Powder-coated steel frame as additional bump protection
- ▶ Integrated screen strainer system
- ▶ Stainless steel tank is not sensitive to damage from sharp edged metal swarf
- ▶ Large swarf strainer for collecting dry metal swarf
- ▶ Floatation switch for safe stop for full tank in wet vacuuming
- ▶ Metal hose connection on tank with locking mechanism
- ▶ With fill level display and visual fill level monitoring through transparent hose at side
- ▶ Trolley with non-marking fixed rollers at rear,

- and steering rollers with parking brake at front
- ▶ The special seal between the head and the tank is resistant against oil and chemical residues without compromising on flexibility
- ▶ Oil-resistant suction hose resilient to heavy loads and any kind of twisting
- ▶ Suction motors with noise damping to ensure quiet operation
- ▶ Three motors can be separately engaged
- ▶ Motors feature copper windings and "Amperometric Thermo Protection" motor circuit breaker



Stainless steel tank is not sensitive to damage from sharp edged metal swarf

Info & video



Model	flexCAT 3100 EOT-PRO
Art. no.	7003382

Technical specifications	
Vacuum cleaner type	wet & dry
Rating	3 600 W
Air volume	10 500 l/min
Tank volume	100 l
Hose diameter/length	50 mm/3 m
Number of motors	3
Motor cooling	Bypass
Sound pressure level	76 dB(A)
Electrical connection	230 V ~50 Hz
Motor speed	23 400 rpm
Cable length	8.5 m
Negative pressure	242 mbar
Tank material	stainless steel
Dimensions (L x W x H)	850 x 650 x 1 350 mm
Weight	65 kg

Hose and attachment set oil-resistant Ø60 mm



Model	Nozzle set
Art. no.	7013423



Scope of delivery flexCAT 3100 EOT-PRO:

- › Filter kit
- › Nylon filter
- › Screen for the container

Manual brake bending machine

HSBM SB – Manual brake bending machine, heavy-duty version with segmented upper tools

- ▶ Easy to use
- ▶ Segmented upper tools
- ▶ Brake bending function with safe clamping of the workpiece due to preload of the top beam
- ▶ Heavy, compact welded design
- ▶ For easy bending and precise adjustment of the bending angle thanks to stop with scale
- ▶ Very low maintenance requirements



HSBM 2020-20 SB

Type	Segmentation
HSBM 2020-20 SB	25-30-35-40-45-75-100-150-200-200-270-400-400

Accessories HSBM 2020-20 SB	Art. no.
Manual rear stop 0 - 500 mm	3772921
Tempered top tools	3772922

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Bending angle max.	Weight	Dimensions L x W x H in mm	Art. no.			
HSBM 2020-20 SB	2 020 mm	2.0 mm	120 mm	135°	1 020 kg	2 800 x 710 x 1 500	3772920			

*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; tempered top tools are necessary for bending stainless steel (VA);

MBM 1250 – Magnetic swivel bending machine with foot pedal

- ▶ Revolutionary simple, very fast and convenient operation
- ▶ Compact & space-saving
- ▶ Ideal for bending aluminium, copper, steel, stainless steel, etc.
- ▶ Bending angle adjustment to one degree of accuracy up to 170 °
- ▶ Powerful electromagnetic system for optimum bending results
- ▶ Clamping across the entire width guarantees clean bending

- ▶ Segmentation in mm: 25 - 40 - 50 - 70 - 140 - 280 - 700 - 1250
- ▶ Very high bending capacity
- ▶ The main pressure is on the top beam, not on the machine
- ▶ The unique centreless hinges ensure precise force transfer at the bending point
- ▶ Rear stop, segmented top beam and foot pedal included in standard scope of supply

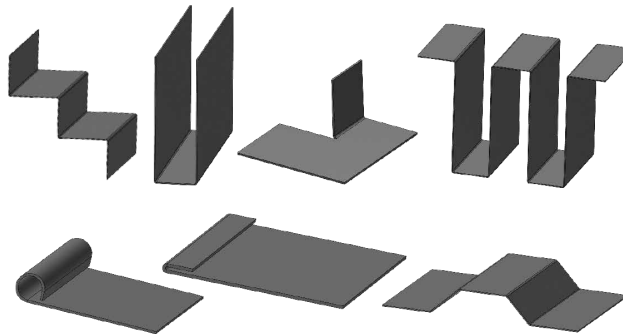


With practical compartments for all individual segments and bending rails



Push in slots for top beam segments

7 of many further bending options:



Model	MBM 1250
Art. no.	3770125

Technical specifications	
Max. bending width	1 250 mm
Holding pressure	6 t
Services	10 A
Dimensions	1 500 x 410 x 390 mm
Thermal protection	70 °C
Weight	150 kg
Workpiece thickness ¹⁾	
Steel sheet ²⁾	1.6 mm ³⁾ / 1.2 mm ⁴⁾
Aluminium sheet	1.6 mm ³⁾ / 1.2 mm ⁴⁾
Copper, zinc, brass sheet	1.6 mm ³⁾ / 1.2 mm ⁴⁾
Stainless steel sheet	1.0 mm ³⁾ / 0.9 mm ⁴⁾

Note: Do not use this machine if you have a pacemaker.

¹⁾ For workpiece lengths of 1250 mm - greater material thickness may be possible for shorter workpieces ²⁾ max. tensile strength 400 N/mm²

³⁾ Bending beam extension - removed

⁴⁾ Bending beam extension installed

Scope of delivery:

- › Bending angle stop
- › Bending beam width extension
- › Rear stop
- › Acute bending rail
- › Narrow acute bending rail
- › Segmented top beam
- › Slotted bending rail
- › 7 bending segments
- › Foot pedal



Extremely fast and easy operation - in just a few steps, you can bend your sheet metal to the desired shape without any major overhead

Step 1

- ▶ Place the workpiece on the magnetic guide and adjust with respect to the bending edge.



Step 2

- ▶ Select the required bending segment, position it on the workpiece and activate the magnet.



Step 3

- ▶ You can set the precise bending angle at the bending stop. Create a bend.



- ▶ Retooling for other bending actions is a matter of just a few steps.



Prepare to be fascinated!

For more information, check out our movie presentation on www.metallkraft.de !

Manual brake bending machines

HSBM N manual brake bending machine – universal deployment, extensible via various attachment kits

- ▶ The workpiece is clamped manually
- ▶ Easy fixing of the set bending angle, thus guaranteeing a high level of repetition accuracy
- ▶ Self-lubricating plain bearings
- ▶ The basic equipment can be converted at any time using optional attachment kits for a high upper beam, a high segmented upper beam, or a high segmented upper beam with a crowbar



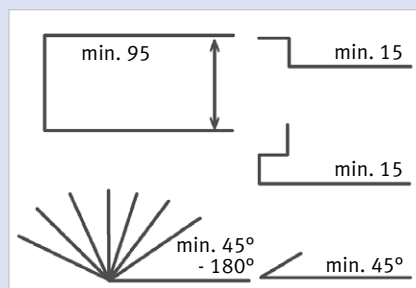
Basic model extension kit (AB)	Max. working width	Max. sheet thickness*	Max. bending angle	Weight	Dimensions (LxWxH) in mm	Art. no.	
HSBM 660 N	660 mm	2.00 mm	135°	56 kg	880 x 570/500 x 970	3770066	
AB 660 H	660 mm	1.80 mm	93°	+ 8 kg	880 x 570/500 x 1060	3770067	
AB 660 HS	660 mm	1.50 mm	93°	10 kg	880 x 570/500 x 1 070	3770068	
HSBM 1050 N	1 050 mm	1.25 mm	135°	78 kg	1 250 x 570/500 x 970	3771050	
AB 1050 H	1 050 mm	1.25 mm	93°	+ 13 kg	1 250 x 570/500 x 1 060	3771051	
AB 1050 HS	1 050 mm	1.20 mm	93°	+ 16 kg	1 250 x 570/500 x 1 070	3771052	
AB 1050 HSG	1 050 mm	1.20 mm	93°	+ 15 kg	1 250 x 570/500 x 1 070	3771053	
HSBM 1300 N	1 300 mm	1.20 mm	135°	88 kg	1 480 x 570/500 x 970	3771300	
AB 1300 H	1 300 mm	1.20 mm	93°	+ 16 kg	1 480 x 570/500 x 1 060	3771301	
AB 1300 HS	1 300 mm	1.20 mm	93°	+ 20 kg	1 480 x 570/500 x 1 070	3771302	
AB 1300 HSG	1 300 mm	1.20 mm	93°	+ 18 kg	1 480 x 570/500 x 1 070	3771303	

*max. values relate to bending soft metals, e.g., aluminium

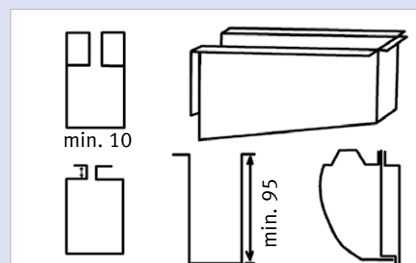
Variant	Description
N	with low top beam
H	with high top beam
S	with segment rail
G	with crow bar

Type	Segmentation
AB 660 HS	25-30-35-40-45-50-75-100-250
AB 1050 HS	25-30-35-40-45-50-75-100-150-200-270
AB 1050 HSG	25-30-35-40-45-50-75-100-150-200-270
AB 1300 HS	25-30-35-40-45-50-75-100-150-200-270-270
AB 1300 HSG	25-30-35-40-45-50-75-100-150-200-270-270

Accessories	Art. no.
Acute bending rail	
for HSBM 1 050 N	3790101
for HSBM 1 300 N	3790102
for AB 1050 H	3790103
for AB 1300 H	3790104
Plate rolling rail	
3.0 mm, length 660 mm	3790151
3.0 mm, length 1 050 mm	3790152
3.0 mm, length 1 300 mm	3790153
4.0 mm, length 660 mm	3790161
4.0 mm, length 1 050 mm	3790162
4.0 mm, length 1 300 mm	3790163
5.0 mm, length 660 mm	3790171
5.0 mm, length 1 050 mm	3790172
5.0 mm, length 1 300 mm	3790173
Rear stop	
for HSBM 660	3791660
for HSBM 1050	3791050
for HSBM 1300	3791300
Roller shears	
Suitable HSBM N with lower bending beam	
for HSBM 1 050 N	3791051
for HSBM 1 300 N	3791301



Bending examples
HSBM with low
and high top beam



Bending examples;
HSBM with high top
beam, segment rail or
crowbar



Quality
made in
Europe



Basic machine
HSBM N version

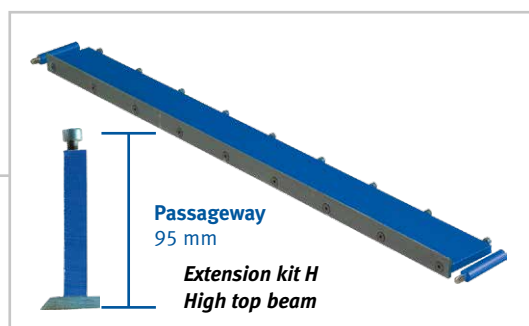
Passageway
25 mm



Optional acute bending rail



Optional plate rolling rail



Passageway
95 mm

Extension kit H
High top beam



HSBM with extension kit
H version



HS extension kit
High segmented top beam



HSBM with extension kit
HS version



HSG extension kit
High segmented top beam with crowbar



HSBM with extension kit
HSG version

Manual brake bending machines

FSBM – Manual brake bending machines with foot pedal operated workpiece clamping

- ▶ Foot pedal operated workpiece clamping leaves both hands free for feeding in the material
- ▶ Different tool variants available E, S2, HS2 and HSG
- ▶ The powerful servo-cylinder facilitates bending
- ▶ Passageway between top + bottom beam up to 25 mm
- ▶ Self-lubricating plain bearings
- ▶ Clamping pressure on the top beam easily adjustable through knurled screws
- ▶ Material thickness setting through knurled screw
- ▶ Adjustable stop for bending angle



FSBM 2020-12 E

With segmented acute bending tools, full-width bending rail and full-width support bed

Model	Max. working width	Max. sheet thickness* Steel 235 N/mm ²	Max. sheet thickness VA steel	Max. bending angle	Weight	Dimensions L x W x H	Art. no.
FSBM 1020-25 E	1 020 mm	2.5 mm	1.5 mm	135°	290 kg	1 350 x 800 x 1 130 mm	3772125
FSBM 1020-20 S2	1 020 mm	2.0 mm	1.2 mm	135°	325 kg	1 350 x 800 x 1 130 mm	3772102
FSBM 1020-20 HSG**	1 020 mm	2.0 mm	1.2 mm	150°	360 kg	1 280 x 620 x 1 200 mm	3770103
FSBM 1270-20 E	1 270 mm	2.0 mm	1.2 mm	135°	340 kg	1 600 x 800 x 1 130 mm	3772127
FSBM 1270-20 HS2	1 270 mm	2.0 mm	1.2 mm	135°	370 kg	1 600 x 800 x 1 130 mm	3772128
FSBM 1520-15 E	1 520 mm	1.5 mm	0.9 mm	135°	415 kg	1 850 x 770 x 1 130 mm	3772129
FSBM 2020-12 E	2 020 mm	1.2 mm	0.7 mm	135°	540 kg	2 290 x 820 x 1 180 mm	3772130

*Performance data for material with tensile strength of 235 N/mm²; bending performance stainless steel (VA) = factor 0.75;

bending performance aluminium = 1.2; tempered top tools are necessary for bending stainless steel (VA);**Segments have a hardness of HRC24-26



FSBM 1270-20 E

With segmented acute bending tools, full-width bending rail and full-width support bed



FSBM 1020-20 S2

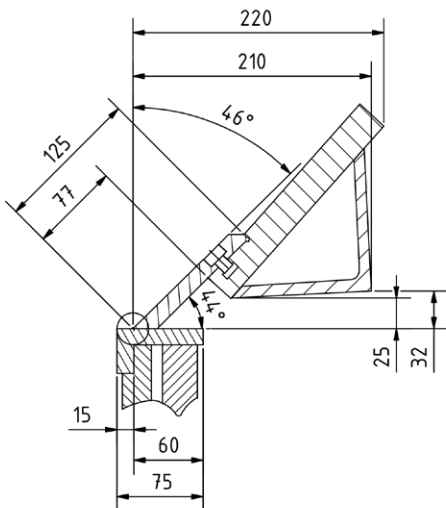
With segmented acute bending tools, segmented bending rail and full-width support bed



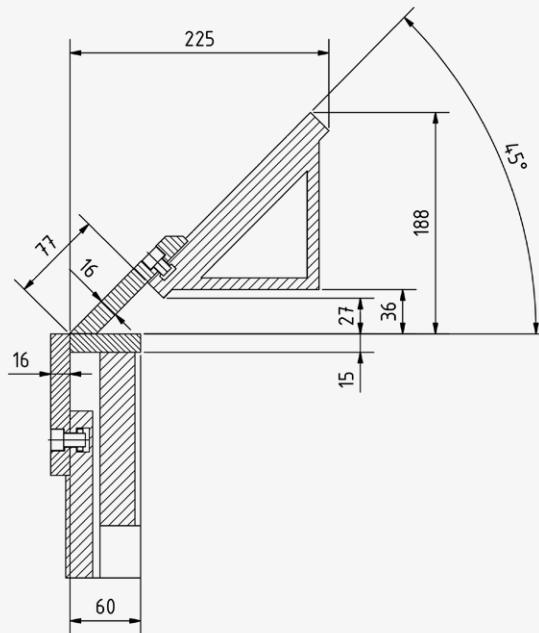
FSBM 1020-20 HSG

With high, segmented top beam, segmented support bed and segmented bending beam as standard

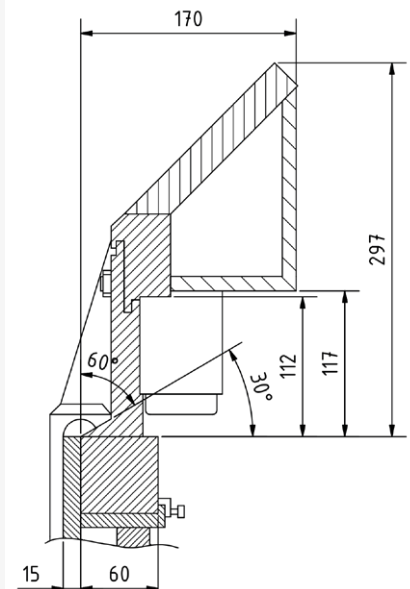
Dimensions E series:



Dimensions S2 / HS2 series:



Dimensions HSG series:



Max. passageway between top tool and support bed 25mm

Type	Segmentation
FSBM 1020-25 E	25-30-35-40-45-50-75-100-150-200-270 mm
FSBM 1020-20 S2	25-30-35-40-45-50-75-100-150-200-270 mm
FSBM 1020-20 HSG	25-30-35-40-45-50-75-100-150-200-270 mm
FSBM 1270-20 E	25-30-35-40-45-50-75-100-150-200-250-270 mm
FSBM 1270-20 HS2	25-30-35-40-45-50-75-100-150-200-250-270 mm
FSBM 1520-15 E	25-30-35-40-45-50-75-100-150-200-250-270 mm
FSBM 2020-12 E	25-30-35-40-45-50-75-100-150-200-250-270-500 mm

Option	Art. no.
Tempered segments FSBM 1020-25 E*	3772702
Tempered segments FSBM 1020-20 S2*	3772701
Tempered segments FSBM 1270-20 E*	3772703
Tempered segments FSBM 1270-20 HS2*	3772703
Tempered segments FSBM 1520-15 E*	3772704

*Only the top tool is tempered

Accessories	Art. no.
Rear stop up to 300 mm New (fits 3772102, 3772125, 3772127, 3772128)	3772720

Manual brake bending machines

HSBM – Manual brake bending machines, heavy-duty versions



- ▶ Easy to use
- ▶ Heavy, compact welded design
- ▶ Very low maintenance requirements
- ▶ With full-width acute bending rail

- ▶ For easy bending and precise adjustment of the bending angle thanks to stop with scale
- ▶ Sheet thickness can be set via bending beam

S models

- ▶ With segmented top tools

SH models

- ▶ With high, segmented crowbar tools

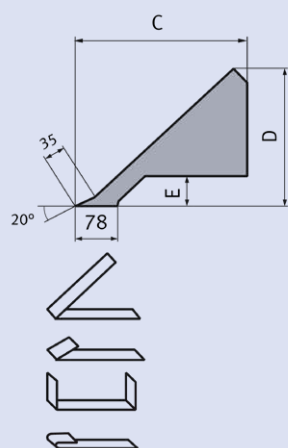


Type	Segmentation HSBM S / HSBM SH
HSBM 1520-20 S / SH	25-30-35-40-45-50-75-100-150-220-250-500
HSBM 2020-20 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400
HSBM 2520-16 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400-500
HSBM 3020-12 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400-500-500

More brake bending machines
available on request!

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Bending angle max.	Weight	Dimensions L x W x H in mm	Art. no.			
HSBM 1520-20	1 520 mm	2.0 mm	140 mm	135°	850 kg	2 680 x 560 x 1 255	3779001			
HSBM 2020-20	2 020 mm	2.0 mm	140 mm	135°	1 130 kg	2 695 x 560 x 1 255	3779002			
HSBM 2520-16	2 520 mm	1.6 mm	140 mm	135°	1 320 kg	3 195 x 560 x 1 255	3779003			
HSBM 3020-12	3 020 mm	1.2 mm	140 mm	135°	1 900 kg	3 695 x 560 x 1 255	3779004			
HSBM 1520-20 S	1 520 mm	2.0 mm	140 mm	135°	850 kg	2 680 x 560 x 1 255	3779010			
HSBM 2020-20 S	2 020 mm	2.0 mm	140 mm	135°	1 080 kg	2 695 x 560 x 1 255	3779011			
HSBM 2520-16 S	2 520 mm	1.6 mm	140 mm	135°	1 320 kg	3 195 x 560 x 1 255	3779012			
HSBM 3020-12 S	3 020 mm	1.2 mm	140 mm	135°	1 900 kg	3 695 x 560 x 1 255	3779013			
HSBM 1520-20 SH	1 520 mm	2.0 mm	140 mm	93°	850 kg	2 680 x 560 x 1255	3779020			
HSBM 2020-20 SH	2 020 mm	2.0 mm	140 mm	93°	1 080 kg	2 695 x 560 x 1 255	3779021			
HSBM 2520-16 SH	2 520 mm	1.6 mm	140 mm	93°	1 320 kg	3 195 x 560 x 1 255	3779022			
HSBM 3020-12 SH	3 020 mm	1.2 mm	140 mm	93°	1 900 kg	3 695 x 560 x 1 255	3779023			

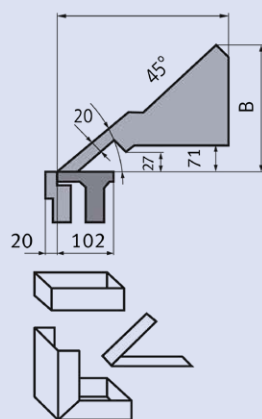
*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);



Dimensions
Bending beam HSBM

L	C	D	E
1500	340	305	49
2000	340	305	49
2500	345	310	49
3000	345	310	49

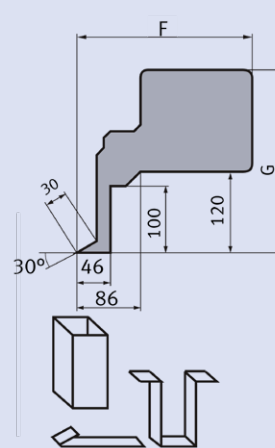
Width of bending rail 20 mm



Dimensions
Bending beam HSBM S

L	A	B
1500	360	335
2000	360	335
2500	370	340
3000	370	340

Width of bending rail 20 mm



Dimensions
Bending beam HSBM SH

L	F	G
1500	290	320
2000	290	320
2500	310	340
3000	310	340

Width of bending rail 20 mm



► Easy, manual adjustment of the bending angle thanks to stop with scale

Accessories



► Roller shears for sheet thicknesses up to 0.8 mm

Accessories



► Rear stop with hand wheel and measuring device



HSBM 3020-12



HSBM 1520-20 S

Accessories HSBM 1520-20 / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
3797000
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
3797010
Roller shears for sheet thicknesses up to 0.8 mm
3797030
Option HSBM 1520-20 / S / SH (ex works only!)
Art. no.
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm
3797020

Accessories HSBM 2020-20 / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
3797001
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
3797011
Roller shears for sheet thicknesses up to 0.8 mm
3797031
Option HSBM 2020-20 / S / SH (ex works only!)
Art. no.
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm
3797021

Accessories HSBM 2520-16 / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
3797002
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
3797012
Roller shears for sheet thicknesses up to 0.8 mm
3797032
Option HSBM 2520-16 / S / SH (ex works only!)
Art. no.
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm
3797022

Accessories HSBM 3020-12 / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
3797003
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
3797013
Roller shears for sheet thicknesses up to 0.8 mm
3797033
Option HSBM 3020-12 / S / SH (ex works only!)
Art. no.
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm
3797023

! Tempering of standard tools on request!

• Tempered acute bending rail and bending rail / Tempered segmented tools and bending rail / Tempered segmented crowbar tools and bending rail

Semi-motorised brake bending machines

MSBM – Semi-motorised brake bending machines, heavy-duty versions, foot-operated



- ▶ Semi-motorised version - manual top beam operation, motorised bending operation
- ▶ Developed for professional use
- ▶ Foot-operated
- ▶ Heavy, compact welded design

- ▶ With full-width acute bending rail
- ▶ With manual bending angle adjustment through ring scale as standard
- ▶ Very low maintenance requirements

S models

- ▶ With segmented top tools

SH models

- ▶ With high, segmented crowbar tools

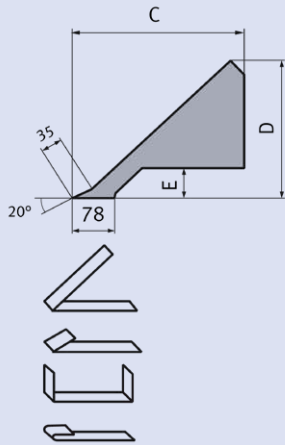


Type	Segmentation MSBM S / MSBM SH
MSBM 1520-30 S / SH	25-30-35-40-45-50-75-100-150-220-250-500
MSBM 2020-25 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400
MSBM 2520-20 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400-500
MSBM 3020-15 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400-500-500

More brake bending machines available on request!

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Bending angle max.	Weight	Dimensions L x W x H in mm	Art. no.
MSBM 1520-30	1 520 mm	3.0 mm	140 mm	1.1 kW	1 060 kg	2 475 x 560 x 1 290	3779030
MSBM 2020-25	2 020 mm	2.5 mm	140 mm	1.1 kW	1 450 kg	2 975 x 560 x 1 290	3779031
MSBM 2520-20	2 520 mm	2.0 mm	140 mm	1.1 kW	1 780 kg	3 475 x 560 x 1 290	3779032
MSBM 3020-15	3 020 mm	1.5 mm	140 mm	1.1 kW	2 200 kg	3 975 x 560 x 1 290	3779033
MSBM 1520-30 S	1 520 mm	3.0 mm	140 mm	1.1 kW	1 060 kg	2 475 x 560 x 1 290	3779040
MSBM 2020-25 S	2 020 mm	2.5 mm	140 mm	1.1 kW	1 450 kg	2 975 x 560 x 1 290	3779041
MSBM 2520-20 S	2 520 mm	2.0 mm	140 mm	1.1 kW	1 780 kg	3 475 x 560 x 1 290	3779042
MSBM 3020-15 S	3 020 mm	1.5 mm	140 mm	1.1 kW	2 200 kg	3 975 x 560 x 1 290	3779043
MSBM 1520-30 SH	1 520 mm	3.0 mm	140 mm	1.1 kW	1 060 kg	2 475 x 560 x 1 290	3779050
MSBM 2020-25 SH	2 020 mm	2.5 mm	140 mm	1.1 kW	1 450 kg	2 975 x 560 x 1 290	3779051
MSBM 2520-20 SH	2 520 mm	2.0 mm	140 mm	1.1 kW	1 780 kg	3 475 x 560 x 1 290	3779052
MSBM 3020-15 SH	3 020 mm	1.5 mm	140 mm	1.1 kW	2 200 kg	3 975 x 560 x 1 290	3779053

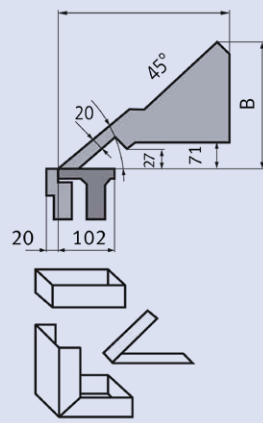
*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);



Dimensions
Bending beam MSBM

L	C	D	E
1500	340	305	49
2000	340	305	49
2500	345	310	49
3000	345	310	49

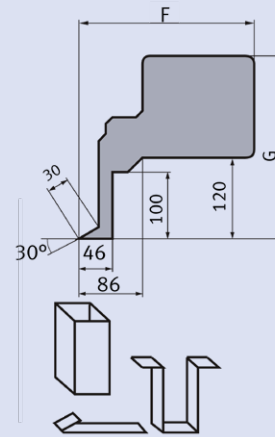
Width of bending rail 20 mm



Dimensions
Bending beam MSBM S

L	A	B
1 500	360	335
2 000	360	335
2 500	370	340
3 000	370	340

Width of bending rail 20 mm



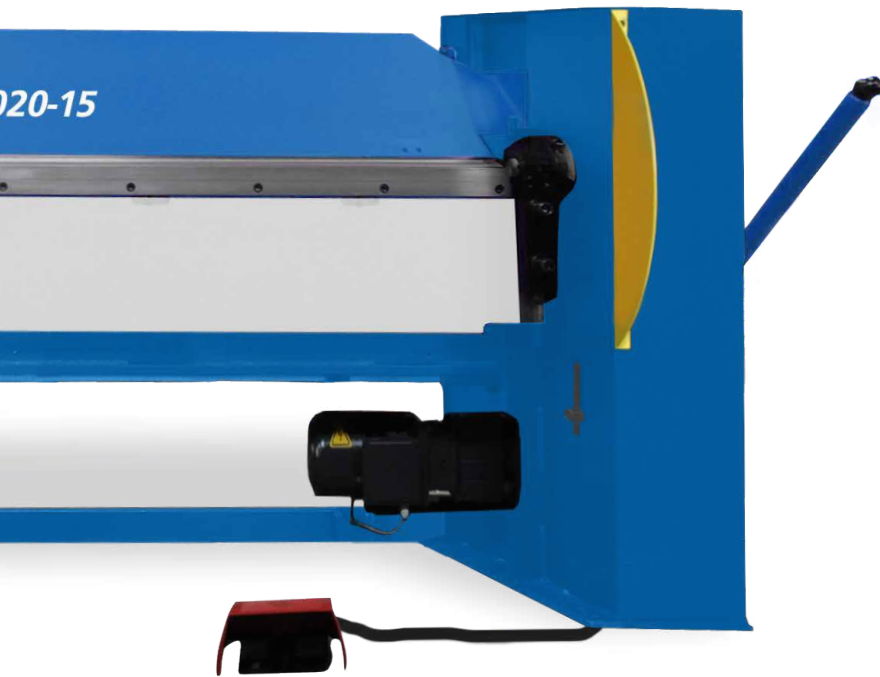
Dimensions
Bending beam MSBM SH

L	F	G
1 500	290	320
2 000	290	320
2 500	310	340
3 000	310	340

Width of bending rail 20 mm



► **Standard control MA**, manual adjustment of bending angle via ring scale on left side of machine



Accessories MSBM 1520-30 / S / SH

Art. no.	
3797005	Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
3797010	Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
3797020	Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm
3797030	Roller shears for sheet thicknesses up to 0.8 mm

Accessories MSBM 2020-25 / S / SH

Art. no.	
3797006	Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
3797011	Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
3797021	Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm
3797031	Roller shears for sheet thicknesses up to 0.8 mm

Accessories MSBM 2520-20 / S / SH

Art. no.	
3797007	Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
3797012	Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
3797022	Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm
3797032	Roller shears for sheet thicknesses up to 0.8 mm

Accessories MSBM 3020-15 / S / SH

Art. no.	
3797008	Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
3797013	Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
3797023	Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm
3797033	Roller shears for sheet thicknesses up to 0.8 mm

Tempering of standard tools on request!

• Tempered acute bending rail and bending rail / Tempered segmented tools and bending rail / Tempered segmented crowbar tools and bending rail

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Metal-cutting band saws

Motorised brake bending machines

MSBM PRO – Motorised brake bending machines, heavy-duty type for sheet thicknesses up to 1.75 mm



- ▶ Suitable for sheet thicknesses up to 1.75 mm
- ▶ Foot-operated
- ▶ Heavy, compact welded design
- ▶ Powerful drive thanks to Lenze motors
- ▶ With full-width acute bending rail
- ▶ With manual bending angle adjustment as standard
- ▶ Very low maintenance requirements
- ▶ Motorised workpiece clamping via foot pedal
- S models**
- ▶ With segmented top tools
- SH models**
- ▶ With high, segmented crowbar tools



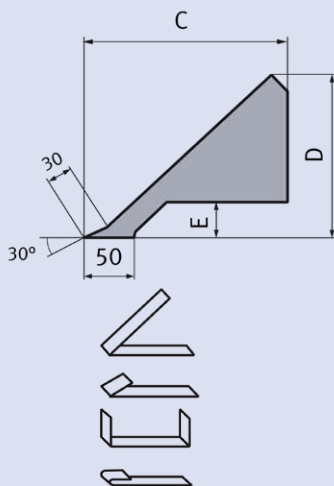
MSBM 2020-15 PRO S

Type	Segmentation MSBM PRO S / MSBM SH
MSBM 1520-17 PRO S / SH	25-30-35-40-45-50-75-100-150-220-250-500
MSBM 2020-15 PRO S / SH	25-30-35-40-45-50-75-100-150-200-270-400-400
MSBM 2520-12 PRO S / SH	25-30-35-40-45-50-75-100-150-200-270-400-400-500
MSBM 3020-10 PRO S / SH	25-30-35-40-45-50-75-100-150-200-270-400-400-500-500

More brake bending machines available on request!

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.
				Beam	Bending			
MSBM 1520-17 PRO	1 520 mm	1.75 mm	110 mm	0.37 kW	0.75 kW	810 kg	2 150 x 700 x 1 100	3779060
MSBM 2020-15 PRO	2 020 mm	1.5 mm	110 mm	0.37 kW	0.75 kW	1 050 kg	2 650 x 700 x 1 100	3779061
MSBM 2520-12 PRO	2 520 mm	1.25 mm	110 mm	0.37 kW	0.75 kW	1 290 kg	3 150 x 700 x 1 100	3779062
MSBM 3020-10 PRO	3 020 mm	1.0 mm	110 mm	0.37 kW	0.75 kW	1 610 kg	3 650 x 700 x 1 100	3779063
MSBM 1520-17 PRO S	1 520 mm	1.75 mm	110 mm	0.37 kW	0.75 kW	810 kg	2 150 x 700 x 1 100	3779070
MSBM 2020-15 PRO S	2 020 mm	1.5 mm	110 mm	0.37 kW	0.75 kW	1 050 kg	2 650 x 700 x 1 100	3779071
MSBM 2520-12 PRO S	2 520 mm	1.25 mm	110 mm	0.37 kW	0.75 kW	1 290 kg	3 150 x 700 x 1 100	3779072
MSBM 3020-10 PRO S	3 020 mm	1.0 mm	110 mm	0.37 kW	0.75 kW	1 610 kg	3 650 x 700 x 1 100	3779073
MSBM 1520-17 PRO SH	1 520 mm	1.75 mm	110 mm	0.37 kW	0.75 kW	810 kg	2 150 x 700 x 1 100	3779080
MSBM 2020-15 PRO SH	2 020 mm	1.5 mm	110 mm	0.37 kW	0.75 kW	1 050 kg	2 650 x 700 x 1 100	3779081
MSBM 2520-12 PRO SH	2 520 mm	1.25 mm	110 mm	0.37 kW	0.75 kW	1 290 kg	3 150 x 700 x 1 100	3779082
MSBM 3020-10 PRO SH	3 020 mm	1.0 mm	110 mm	0.37 kW	0.75 kW	1 610 kg	3 650 x 700 x 1 100	3779083

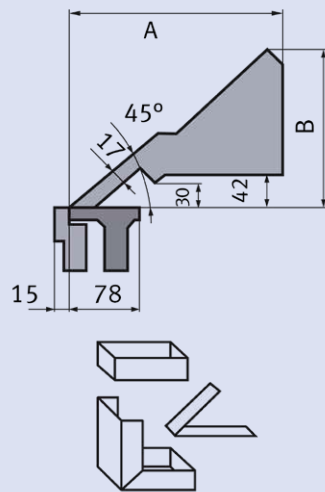
*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);



Dimensions
Bending beam MSBM

L	C	D	E
1 500	225	200	44
2 000	258	232	44
2 500	258	232	44
3 000	262	232	44

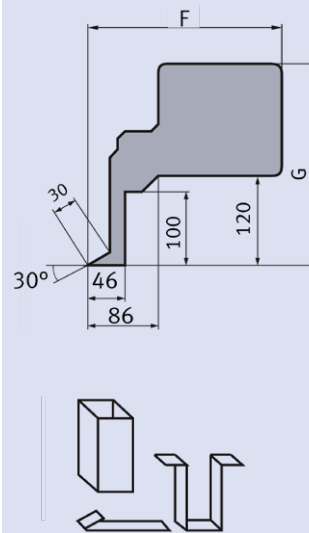
Width of bending rail 15 mm



Dimensions
Bending beam MSBM S

L	A	B
1 500	258	215
2 000	258	215
2 500	310	265
3 000	343	303

Width of bending rail 15 mm



Dimensions
Bending beam MSBM SH

L	F	G
1 500	270	300
2 000	290	320
2 500	290	320
3 000	290	320

Width of bending rail 15 mm

Accessories (all models)

Art. no.
Control PT 1, bending angle adjustment via potentiometer on face side of machine
Control Schneider TM 238, bending angle adjustment via touchscreen on NC control, storing of bending sequences possible

Accessories MSBM 1520-17 PRO / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control PUD, bending angle adjustment via potentiometer PT 1, motorised rear stop with stop fingers and digital position display, 15-1 000 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible

Accessories MSBM 2020-15 PRO / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control PUD, bending angle adjustment via potentiometer PT 1, motorised rear stop with stop fingers and digital position display, 15-1 000 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible

Option



► **Optional control Schneider TM 238**, single-axis control for digital angle input via generously dimensioned touchscreen with the option of storing bending sequences

Accessories MSBM 2520-12 PRO / S / SH

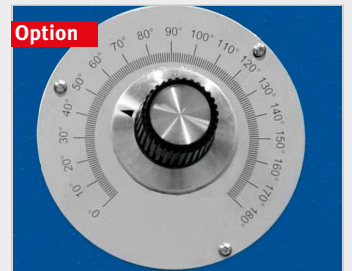
Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control PUD, bending angle adjustment via potentiometer PT 1, motorised rear stop with stop fingers and digital position display, 15-1 000 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible

Accessories MSBM 3020-10 PRO / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control PUD, bending angle adjustment via potentiometer PT 1, motorised rear stop with stop fingers and digital position display, 15-1 000 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible



► **Standard control MA**, manual adjustment of bending angle via ring scale on left side of machine



► **Optional control PT 1** - Manual adjustment of bending angle via potentiometer conveniently from the front of the machine



► **Optional control PUD** with digital display, manual bending angle adjustment and adjustable, motorised rear stop



► **Optional control Schneider CNC2A**, two-axis control for digital angle input and input of the rear stop position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm



Tempering of standard tools on request!

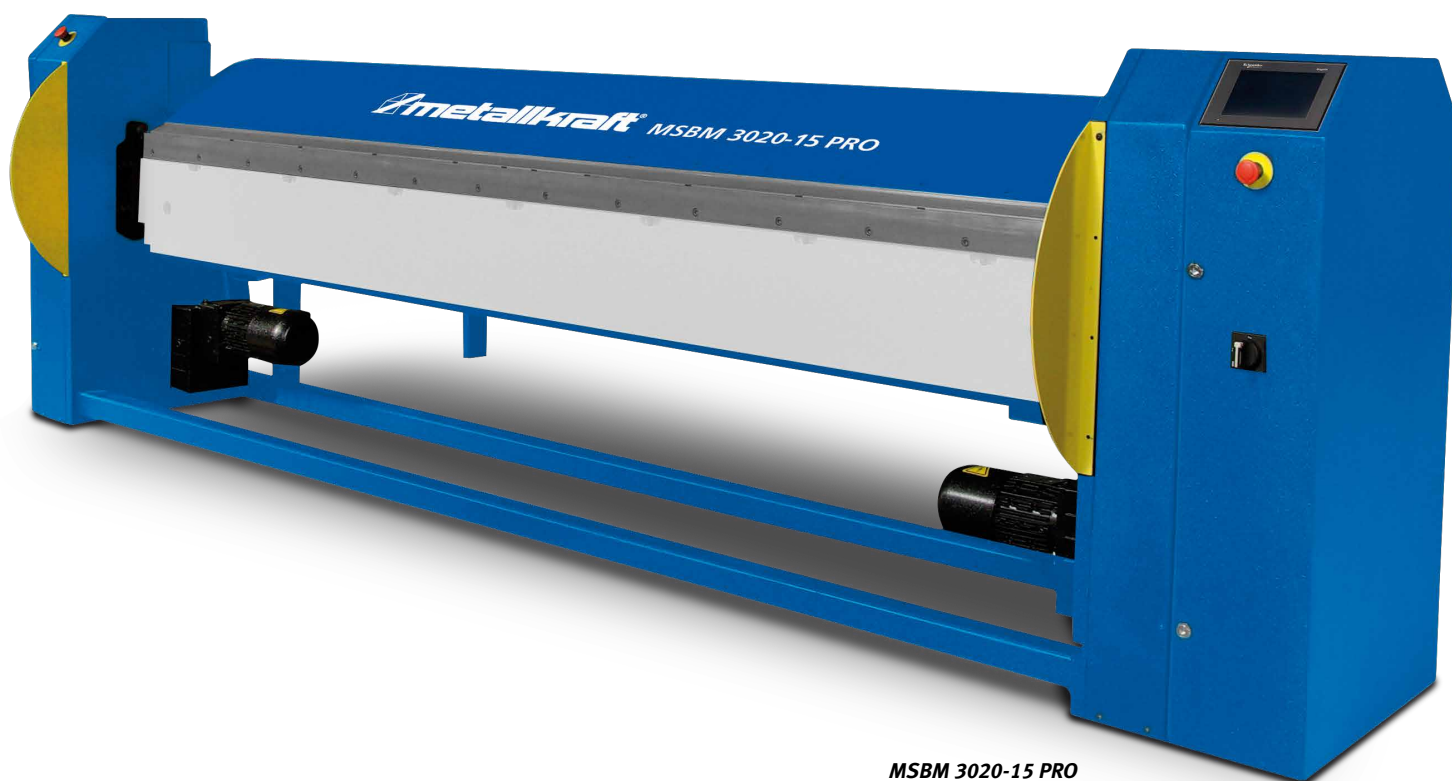
- Tempered acute bending rail and bending rail
- Tempered segmented tools and bending rail
- Tempered segmented crowbar tools and bending rail

Motorised brake bending machines

MSBM PRO – Motorised brake bending machines, heavy-duty type for sheet thicknesses up to 3.5 mm



- ▶ Suitable for sheet thicknesses up to 3.5 mm
- ▶ Foot-operated
- ▶ Heavy, compact welded design
- ▶ Powerful drive thanks to Lenze motors
- ▶ With full-width acute bending rail
- ▶ With manual bending angle adjustment as standard
- ▶ Very low maintenance requirements
- ▶ Motorised workpiece clamping
- S models**
- ▶ With segmented top tools
- SH models**
- ▶ With high, segmented crowbar tools



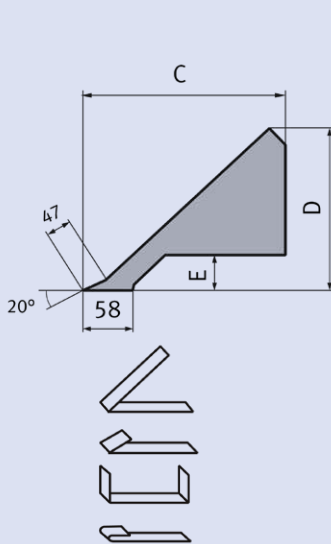
MSBM 3020-15 PRO
With optional control TM 238

Type	Segmentation MSBM PRO S / MSBM SH
MSBM 1020-30 PRO S / SH	25-30-35-40-45-50-75-100-150-220-250
MSBM 1520-30 PRO S / SH	25-30-35-40-45-50-75-100-150-220-250-500
MSBM 2020-25 PRO S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400
MSBM 2520-20 PRO S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400-500
MSBM 3020-15 PRO S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400-500-500

More brake bending machines available on request!

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.
				Beam	Bending			
MSBM 1020-35 PRO	1 020 mm	3.5 mm	140 mm	0.75 kW	1.1 kW	860 kg	1 350 x 710 x 1 160	3779089
MSBM 1520-30 PRO	1 520 mm	3.0 mm	140 mm	0.75 kW	1.1 kW	1 060 kg	2 350 x 710 x 1 160	3779090
MSBM 2020-25 PRO	2 020 mm	2.5 mm	140 mm	0.75 kW	1.1 kW	1 380 kg	2 850 x 710 x 1 160	3779091
MSBM 2520-20 PRO	2 520 mm	2.0 mm	140 mm	0.75 kW	1.1 kW	1 780 kg	3 350 x 710 x 1 160	3779092
MSBM 3020-15 PRO	3 020 mm	1.5 mm	140 mm	0.75 kW	1.1 kW	2 200 kg	3 850 x 710 x 1 160	3779093
MSBM 1020-35 PRO S	1 020 mm	3.5 mm	140 mm	0.75 kW	1.1 kW	860 kg	1 350 x 710 x 1 160	3779099
MSBM 1520-30 PRO S	1 520 mm	3.0 mm	140 mm	0.75 kW	1.1 kW	1 060 kg	2 350 x 710 x 1 160	3779100
MSBM 2020-25 PRO S	2 020 mm	2.5 mm	140 mm	0.75 kW	1.1 kW	1 380 kg	2 850 x 710 x 1 160	3779101
MSBM 2520-20 PRO S	2 520 mm	2.0 mm	140 mm	0.75 kW	1.1 kW	1 780 kg	3 350 x 710 x 1 160	3779102
MSBM 3020-15 PRO S	3 020 mm	1.5 mm	140 mm	0.75 kW	1.1 kW	2 200 kg	3 850 x 710 x 1 160	3779103
MSBM 1020-35 PRO SH	1 020 mm	3.5 mm	140 mm	0.75 kW	1.1 kW	860 kg	1 350 x 710 x 1 160	3779109
MSBM 1520-30 PRO SH	1 520 mm	3.0 mm	140 mm	0.75 kW	1.1 kW	1 060 kg	2 350 x 710 x 1 160	3779110
MSBM 2020-25 PRO SH	2 020 mm	2.5 mm	140 mm	0.75 kW	1.1 kW	1 380 kg	2 850 x 710 x 1 160	3779111
MSBM 2520-20 PRO SH	2 520 mm	2.0 mm	140 mm	0.75 kW	1.1 kW	1 780 kg	3 350 x 710 x 1 160	3779112
MSBM 3020-15 PRO SH	3 020 mm	1.5 mm	140 mm	0.75 kW	1.1 kW	2 200 kg	3 850 x 710 x 1 160	3779113

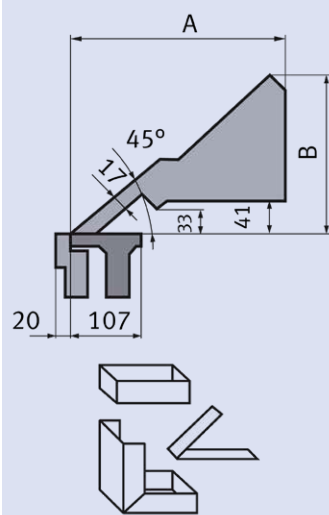
*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);



Dimensions
Bending beam MSBM

L	C	D	E
1 000	380	338	52
1 500	380	338	52
2 000	360	338	52
2 500	360	338	52
3 000	360	338	52

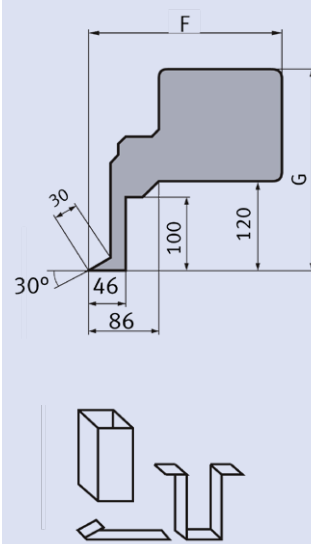
Width of bending rail 20 mm



Dimensions
Bending beam MSBM S

L	A	B
1 000	350	310
1 500	350	310
2 000	350	310
2 500	355	315
3 000	355	315

Width of bending rail 20 mm



Dimensions
Bending beam MSBM SH

L	F	G
1 000	270	300
1 500	290	320
2 000	290	320
2 500	310	340
3 000	310	340

Width of bending rail 20 mm

Accessories (all models)

Art. no.
Control PT 1, bending angle adjustment via potentiometer on face side of machine
Control Schneider TM 238, bending angle adjustment via touchscreen on NC control, storing of bending sequences possible

Accessories MSBM 1020-35 PRO / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible

Accessories MSBM 1520-30 PRO / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible

Accessories MSBM 2020-25 PRO / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible

Accessories MSBM 2520-20 PRO / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible

Accessories MSBM 3020-15 PRO / S / SH

Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1 000 mm
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible



► **Standard control MA**, manual adjustment of bending angle via ring scale on left side of machine



► **Optional control PT 1** - Manual adjustment of bending angle via potentiometer conveniently from the front of the machine



► **Optional control Schneider TM 238**, single-axis control for digital angle input via generously dimensioned touchscreen with the option of storing bending sequences



► **Optional control Schneider CNC2A**, two-axis control for digital angle input and input of the rear stop position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm

Tempering of standard tools on request!

- Tempered acute bending rail and bending rail
- Tempered segmented tools and bending rail
- Tempered segmented crowbar tools and bending rail

Motorised brake bending machines

MSBM PRO – Motorised brake bending machines, heavy-duty type for sheet thicknesses up to 4.0 mm



- ▶ Suitable for sheet thicknesses up to 4.0 mm
- ▶ Foot-operated
- ▶ Heavy, compact welded design
- ▶ Powerful drive thanks to Lenze motors
- ▶ With full-width acute bending rail

- ▶ With manual bending angle adjustment as standard
- ▶ Very low maintenance requirements
- ▶ Motorised workpiece clamping

SH models

- ▶ With high, segmented crowbar tools



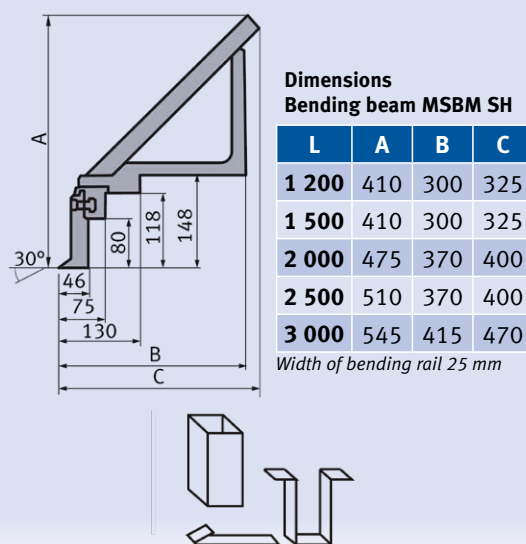
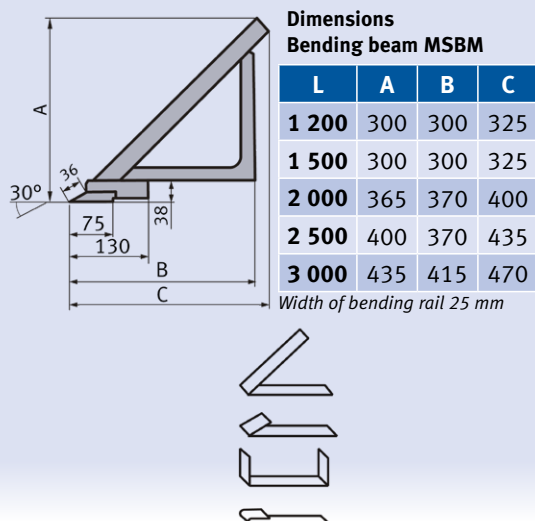
MSBM 3020-20 PRO SH
With optional control PT 1

Type	Segmentation MSBM PRO SH
MSBM 1220-40 PRO SH	25-30-35-40-45-75-100-150-220-500
MSBM 1520-35 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500
MSBM 2020-30 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500
MSBM 2520-25 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500
MSBM 3020-20 PRO SH	25-30-35-40-45-50-75-100-150-220-250-400-400-500-500

Model in **DUO design** featuring full-width acute bending rail and segmented crowbar tools available on request

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.
				Beam	Bending			
MSBM 1220-40 PRO	1 220 mm	4.0 mm	200 mm	0.75 kW	3.0 kW	2 300 kg	2 190 x 1 070 x 1 530	3779119
MSBM 1520-35 PRO	1 520 mm	3.5 mm	200 mm	0.75 kW	3.0 kW	2 700 kg	2 345 x 1 100 x 1 560	3779120
MSBM 2020-30 PRO	2 020 mm	3.0 mm	200 mm	0.75 kW	3.0 kW	3 050 kg	2 935 x 1 100 x 1 560	3779121
MSBM 2520-25 PRO	2 520 mm	2.5 mm	200 mm	0.75 kW	3.0 kW	3 600 kg	3 435 x 1 100 x 1 560	3779122
MSBM 3020-20 PRO	3 020 mm	2.0 mm	200 mm	0.75 kW	3.0 kW	4300 kg	3 935 x 1 100 x 1 560	3779123
MSBM 1220-40 PRO SH	1 220 mm	4.0 mm	90 mm	0.75 kW	3.0 kW	2300 kg	2 190 x 1 070 x 1 530	3779129
MSBM 1520-35 PRO SH	1 520 mm	3.5 mm	90 mm	0.75 kW	3.0 kW	2700 kg	2345 x 1 100 x 1560	3779130
MSBM 2020-30 PRO SH	2 020 mm	3.0 mm	90 mm	0.75 kW	3.0 kW	3 050 kg	2935 x 1 100 x 1560	3779131
MSBM 2520-25 PRO SH	2 520 mm	2.5 mm	90 mm	0.75 kW	3.0 kW	3 600 kg	3435 x 1 100 x 1560	3779132
MSBM 3020-20 PRO SH	3 020 mm	2.0 mm	90 mm	0.75 kW	3.0 kW	4300 kg	3935 x 1 100 x 1560	3779133

*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA)



Accessories (all models)

Accessories (all models)	Art. no.
Control PT 1, bending angle adjustment via potentiometer on face side of machine	3797160
Control Schneider TM 238, bending angle adjustment via touchscreen on NC control, storing of bending sequences possible	3797500

Accessories MSBM 1220-40 PRO / SH

Accessories MSBM 1220-40 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797005
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797010
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797520
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797530
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797540

Accessories MSBM 1520-35 PRO / SH

Accessories MSBM 1520-35 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797010
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797020
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797521
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797531
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797541

Accessories MSBM 2020-30 PRO / SH

Accessories MSBM 2020-30 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797011

Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797021
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797522
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797532
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797542

Accessories MSBM 2520-25 PRO / SH

Accessories MSBM 2520-25 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797012
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797022
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797523
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797533
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797543

Accessories MSBM 3020-20 PRO / SH

Accessories MSBM 3020-20 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797013
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797023
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797524
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797534
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797544

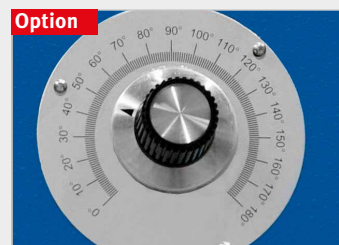


- **Optional CNC control with 3D graphics**, the profiles are drawn by the operator on a generously dimensioned 19" touchscreen; all axis positions and the bending sequence are computed by the control, motorised rear stop with stop fingers, travel range 15-1 000 mm

- Tempering of standard tools on request!**
- Tempered acute bending rail and bending rail
 - Tempered segmented tools and bending rail
 - Tempered segmented crowbar tools and bending rail



- **Standard control MA** - manual adjustment of bending angle via ring scale on left side of machine



- **Optional control PT 1** - Manual adjustment of bending angle via potentiometer conveniently from the front of the machine



- **Optional control Schneider TM 238**, single-axis control for digital angle input via generously dimensioned touchscreen with the option of storing bending sequences



- **Optional control Schneider CNC2A**, two-axis control for digital angle input and input of the rear stop position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm



- **Optional control Schneider CNC3A**, three-axis control for digital angle input, input of the rear stop position and beam opening position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm

Motorised brake bending machines

MSBM PRO – Motorised brake bending machines, heavy-duty type for sheet thicknesses up to 5.0 mm



- ▶ Suitable for sheet thicknesses up to 5.0 mm
- ▶ Foot-operated
- ▶ Heavy, compact welded design
- ▶ Powerful drive thanks to Lenze motors
- ▶ With full-width acute bending rail

- ▶ With manual bending angle adjustment as standard
- ▶ Very low maintenance requirements
- ▶ Motorised workpiece clamping

SH models

- ▶ With high, segmented crowbar tools



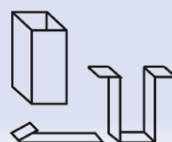
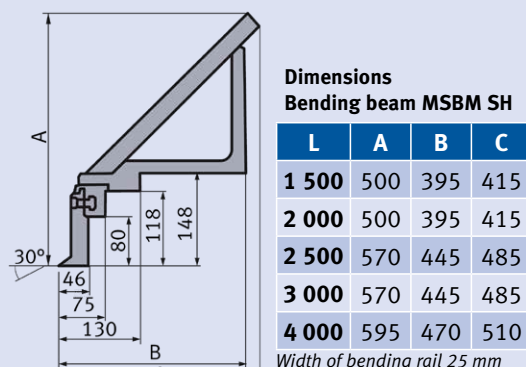
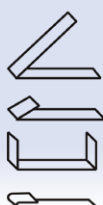
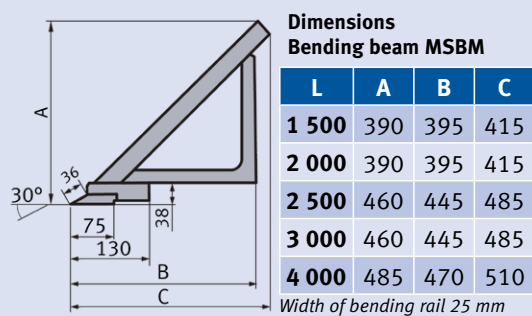
MSBM 3020-30 PRO SH
with optional control PT 1

Type	Segmentation MSBM PRO SH
MSBM 1520-50 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500
MSBM 2020-40 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500
MSBM 2520-35 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500
MSBM 3020-30 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500
MSBM 4020-20 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500-500-500

Model in **DUO design** featuring full-width acute bending rail and segmented crowbar tools available on request

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.
				Beam	Bending			
MSBM 1520-50 PRO	1 520 mm	5.0 mm	200 mm	1.1 kW	4.0 kW	3 250 kg	2 345 x 1 100 x 1 560	3779128
MSBM 2020-40 PRO	2 020 mm	4.0 mm	200 mm	1.1 kW	4.0 kW	3 900 kg	3 020 x 1 100 x 1 560	3779124
MSBM 2520-35 PRO	2 520 mm	3.5 mm	200 mm	1.1 kW	4.0 kW	4 500 kg	3 620 x 1 100 x 1 560	3779125
MSBM 3020-30 PRO	3 020 mm	3.0 mm	200 mm	1.1 kW	4.0 kW	6 200 kg	4 020 x 1 100 x 1 560	3779126
MSBM 4020-20 PRO	4 020 mm	2.0 mm	90 mm	1.1 kW	4.0 kW	7 000 kg	5 200 x 1 100 x 1 560	3779127
MSBM 1520-50 PRO SH	1 520 mm	5.0 mm	200 mm	1.1 kW	4.0 kW	3 400 kg	2 345 x 1 100 x 1 560	3779138
MSBM 2020-40 PRO SH	2 020 mm	4.0 mm	90 mm	1.1 kW	4.0 kW	3 900 kg	3 020 x 1 100 x 1 560	3779134
MSBM 2520-35 PRO SH	2 520 mm	3.5 mm	90 mm	1.1 kW	4.0 kW	4 500 kg	3 620 x 1 100 x 1 560	3779135
MSBM 3020-30 PRO SH	3 020 mm	3.0 mm	90 mm	1.1 kW	4.0 kW	6 200 kg	4 020 x 1 100 x 1 560	3779136
MSBM 4020-20 PRO SH	4 020 mm	2.0 mm	90 mm	1.1 kW	4.0 kW	7 250 kg	5 200 x 1 100 x 1 560	3779139

*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);



Accessories (all models)	Art. no.
Control PT 1, bending angle adjustment via potentiometer on face side of machine	3797160
Control Schneider TM 238, bending angle adjustment via touchscreen on NC control, storing of bending sequences possible	3797500

Accessories MSBM 1520-50 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797010
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797020
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797550
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797560
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797570

Accessories MSBM 2020-40 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797011
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797021
Control PT 1, bending angle adjustment via potentiometer on face side of machine	3797160
Control Schneider TM 238, bending angle adjustment via touchscreen on NC control, storing of bending sequences possible	3797500
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797551
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797561
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797571



► **Optional CNC control with 3D graphics**, the profiles are drawn by the operator on a generously dimensioned 19" touchscreen; all axis positions and the bending sequence are computed by the control, motorised rear stop with stop fingers, travel range 15-1 000 mm

Accessories MSBM 2520-35 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797012
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797022
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797552
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797562
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797572

Accessories MSBM 3020-30 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797013
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797023
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797553
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797563
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797573

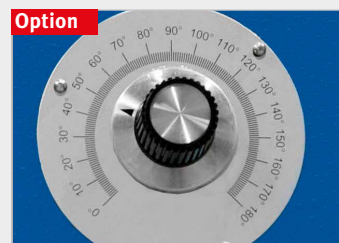
Accessories MSBM 4020-20 PRO / SH	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797014
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797024
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797554
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797564
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797574

Tempering of standard tools on request!

- Tempered acute bending rail and bending rail
- Tempered segmented tools and bending rail
- Tempered segmented crowbar tools and bending rail



► **Standard control MA** - manual adjustment of bending angle via ring scale on left side of machine



► **Optional control PT 1** - Manual adjustment of bending angle via potentiometer conveniently from the front of the machine



► **Optional control Schneider TM 238**, single-axis control for digital angle input via generously dimensioned touchscreen with the option of storing bending sequences



► **Optional control Schneider CNC2A**, two-axis control for digital angle input and input of the rear stop position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm



► **Optional control Schneider CNC3A**, three-axis control for digital angle input, input of the rear stop position and beam opening position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm

Motorised brake bending machines

MSBM PRO – Motorised brake bending machines, heavy-duty type for sheet thickness up to 7.0 mm



- ▶ Suitable for sheet thicknesses up to 7.0 mm
- ▶ Foot-operated
- ▶ Heavy, compact welded design
- ▶ Powerful drive thanks to Lenze motors
- ▶ With full-width acute bending rail
- ▶ With manual bending angle adjustment as standard
- ▶ Very low maintenance requirements
- ▶ Motorised workpiece clamping
- SH models**
- ▶ With high, segmented crowbar tools
- DUO models**
- ▶ Featuring full-width acute bending rail and high segmented crowbar tools

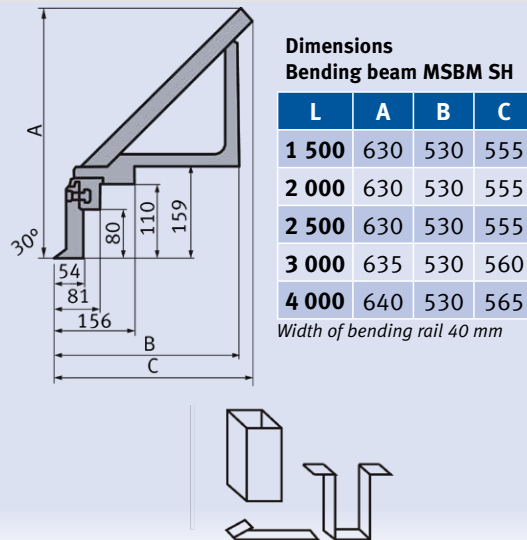
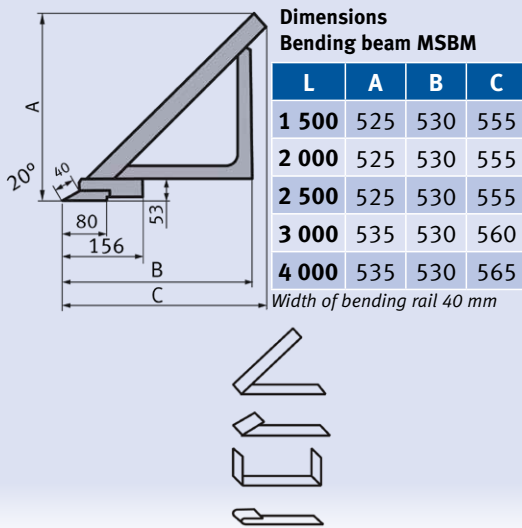


MSBM 2020-60 PRO SH with optional control TM 238

Type	Segmentation MSBM PRO SH
MSBM 1520-70 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500
MSBM 2020-60 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500
MSBM 2520-50 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500
MSBM 3020-40 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500-500
MSBM 4020-20 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500-500-500

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.
				Beam	Bending			
MSBM 1520-70 PRO	1 520 mm	7.0 mm	200 mm	2.2 kW	5.5 kW	4025 kg	2620 x 1160 x 1 590	3779140
MSBM 2020-60 PRO	2 020 mm	6.0 mm	200 mm	2.2 kW	5.5 kW	4650 kg	3120 x 1160 x 1 590	3779141
MSBM 2520-50 PRO	2 520 mm	5.0 mm	200 mm	2.2 kW	5.5 kW	5270 kg	3620 x 1160 x 1 590	3779142
MSBM 3020-40 PRO	3 020 mm	4.0 mm	200 mm	2.2 kW	5.5 kW	6090 kg	4120 x 1160 x 1 590	3779143
MSBM 4020-30 PRO	4 020 mm	3.0 mm	200 mm	2.2 kW	5.5 kW	7460 kg	5120 x 1160 x 1 590	3779144
MSBM 1520-70 PRO SH	1 520 mm	7.0 mm	90 mm	2.2 kW	5.5 kW	4025 kg	2620 x 1160 x 1 590	3779150
MSBM 2020-60 PRO SH	2 020 mm	6.0 mm	90 mm	2.2 kW	5.5 kW	4650 kg	3120 x 1160 x 1 590	3779151
MSBM 2520-50 PRO SH	2 520 mm	5.0 mm	90 mm	2.2 kW	5.5 kW	5270 kg	3620 x 1160 x 1 590	3779152
MSBM 3020-40 PRO SH	3 020 mm	4.0 mm	90 mm	2.2 kW	5.5 kW	6090 kg	4120 x 1160 x 1 590	3779153
MSBM 4020-30 PRO SH	4 020 mm	3.0 mm	90 mm	2.2 kW	5.5 kW	7460 kg	5120 x 1160 x 1 590	3779154
MSBM 1520-70 PRO DUO	1 520 mm	7.0 mm	90/200 mm	2.2 kW	5.5 kW	4025 kg	2620 x 1160 x 1 590	3779220
MSBM 2020-60 PRO DUO	2 020 mm	6.0 mm	90/200 mm	2.2 kW	5.5 kW	4650 kg	3120 x 1160 x 1 590	3779221
MSBM 2520-50 PRO DUO	2 520 mm	5.0 mm	90/200 mm	2.2 kW	5.5 kW	5270 kg	3620 x 1160 x 1 590	3779222
MSBM 3020-40 PRO DUO	3 020 mm	4.0 mm	90/200 mm	2.2 kW	5.5 kW	6090 kg	4120 x 1160 x 1 590	3779223
MSBM 4020-30 PRO DUO	4 020 mm	3.0 mm	90/200 mm	2.2 kW	5.5 kW	7460 kg	5120 x 1160 x 1 590	3779224

*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);



Accessories (all models)	Art. no.
Control PT 1, bending angle adjustment via potentiometer on face side of machine	3797160
Control Schneider TM 238, bending angle adjustment via touchscreen on NC control, storing of bending sequences possible	3797500

Accessories MSBM 1520-70 PRO / SH / DUO	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797010
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797020
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797590
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797610
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797620

Accessories MSBM 2020-60 PRO / SH / DUO	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797011
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797021
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797591
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797611
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797621

Accessories MSBM 2520-50 PRO / SH / DUO	Art. no.
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- **Optional CNC control with 3D graphics**, the profiles are drawn by the operator on a generously dimensioned 19" touchscreen; all axis positions and the bending sequence are computed by the control, motorised rear stop with stop fingers, travel range 15-1 000 mm

Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797012
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797022
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797592
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797612
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797622
Tempering of standard tools for MSBM 2520-50 PRO, tempered acute bending rail, bending rail and support bed	3799132

Accessories MSBM 3020-40 PRO / SH / DUO	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797013
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797023
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797593
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797613
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797623
Tempering of standard tools for MSBM 3020-40 PRO, tempered acute bending rail, bending rail and support bed	3799133

Accessories MSBM 4020-30 PRO / SH / DUO	Art. no.
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797014
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797024
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797594
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797614
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797624

- ! **Tempering of standard tools on request!**
- Tempered acute bending rail and bending rail
 - Tempered segmented tools and bending rail
 - Tempered segmented crowbar tools and bending rail



- **Standard control MA** - manual adjustment of bending angle via ring scale on left side of machine



- **Optional control PT 1** - Manual adjustment of bending angle via potentiometer conveniently from the front of the machine



- **Optional control Schneider TM 238**, single-axis control for digital angle input via generously dimensioned touchscreen with the option of storing bending sequences



- **Optional control Schneider CNC2A**, two-axis control for digital angle input and input of the rear stop position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm



- **Optional control Schneider CNC3A**, three-axis control for digital angle input, input of the rear stop position and beam opening position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm

Motorised brake bending machines

MSBM PRO – Motorised brake bending machines, ultra-heavy-duty type for sheet thicknesses up to 8.0 mm



- ▶ Suitable for sheet thicknesses up to 8 mm
- ▶ Very heavy-duty and durable welded structure
- ▶ Dynamically driven bending beam through two frequency-controlled gear motors
- ▶ Top beam clamping via trapezoid thread
- ▶ Premium Lenze motors
- ▶ Full-width acute bending rail

- ▶ Tools suitable for bending stainless steel
- ▶ Bending angle adjustment via touchscreen NC control
- ▶ Sheet thickness setting manually on the bending beam
- ▶ Manual crowing device on bending beam
- ▶ Operated via double foot pedal with emergency stop function
- ▶ All-motorised machine without hydraulics

SH models

- ▶ With high, segmented crowbar tools

DUO models

- ▶ Featuring full-width acute bending rail and high segmented crowbar tools

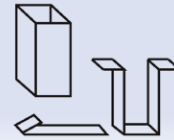
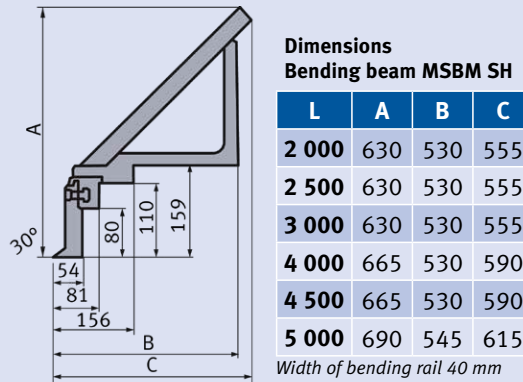
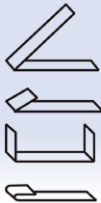
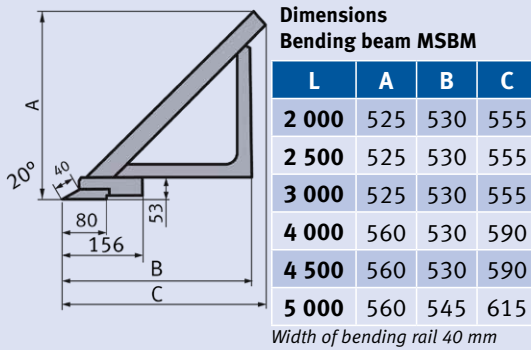


MSBM 2020-80 PRO

Type	Segmentation MSBM PRO SH
MSBM 2020-80 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500
MSBM 2520-70 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500
MSBM 3020-60 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500-500
MSBM 4020-40 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500-500-500
MSBM 4520-30 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500-500-500-500
MSBM 5020-20 PRO SH	25-30-35-40-45-50-75-100-150-220-250-500-500-500-500-500-500-500

Model	Max. working width	Sheet thickness max.*	Passageway between top + bottom beam max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.
				Beam	Bending			
MSBM 2020-80 PRO	2 020 mm	8.0 mm	350 mm	4.0 kW	2 x 4.0 kW	5 380 kg	3 480 x 1 500 x 1 750	3779400
MSBM 2520-70 PRO	2 520 mm	7.0 mm	350 mm	4.0 kW	2 x 4.0 kW	5 900 kg	3 970 x 1 500 x 1 750	3779401
MSBM 3020-60 PRO	3 020 mm	6.0 mm	350 mm	4.0 kW	2 x 4.0 kW	6 550 kg	4 470 x 1 500 x 1 750	3779402
MSBM 4020-40 PRO	4 020 mm	4.0 mm	350 mm	4.0 kW	2 x 4.0 kW	8 130 kg	5 480 x 1 500 x 1 750	3779403
MSBM 4520-30 PRO	4 520 mm	3.0 mm	350 mm	4.0 kW	2 x 4.0 kW	8 980 kg	5 980 x 1 500 x 1 750	3779404
MSBM 5020-20 PRO	5 020 mm	2.0 mm	350 mm	4.0 kW	2 x 4.0 kW	9 840 kg	6 480 x 1 500 x 1 750	3779405
MSBM 2020-80 PRO SH	2 020 mm	8.0 mm	240 mm	4.0 kW	2 x 4.0 kW	5 380 kg	3 480 x 1 500 x 1 750	3779410
MSBM 2520-70 PRO SH	2 520 mm	7.0 mm	240 mm	4.0 kW	2 x 4.0 kW	5 900 kg	3 970 x 1 500 x 1 750	3779411
MSBM 3020-60 PRO SH	3 020 mm	6.0 mm	240 mm	4.0 kW	2 x 4.0 kW	6 550 kg	4 470 x 1 500 x 1 750	3779412
MSBM 4020-40 PRO SH	4 020 mm	4.0 mm	240 mm	4.0 kW	2 x 4.0 kW	8 130 kg	5 480 x 1 500 x 1 750	3779413
MSBM 4520-30 PRO SH	4 520 mm	3.0 mm	240 mm	4.0 kW	2 x 4.0 kW	8 980 kg	5 980 x 1 500 x 1 750	3779414
MSBM 5020-20 PRO SH	5 020 mm	2.0 mm	240 mm	4.0 kW	2 x 4.0 kW	9 840 kg	6 480 x 1 500 x 1 750	3779415
MSBM 2020-80 PRO DUO	2 020 mm	8.0 mm	350/240 mm	4.0 kW	2 x 4.0 kW	5380 kg	3480 x 1 500 x 1750	3779420
MSBM 2520-70 PRO DUO	2 520 mm	7.0 mm	350/240 mm	4.0 kW	2 x 4.0 kW	5900 kg	3970 x 1 500 x 1750	3779421
MSBM 3020-60 PRO DUO	3 020 mm	6.0 mm	350/240 mm	4.0 kW	2 x 4.0 kW	6550 kg	4470 x 1 500 x 1750	3779422
MSBM 4020-40 PRO DUO	4 020 mm	4.0 mm	350/240 mm	4.0 kW	2 x 4.0 kW	8130 kg	5480 x 1 500 x 1750	3779423
MSBM 4520-30 PRO DUO	4 520 mm	3.0 mm	350/240 mm	4.0 kW	2 x 4.0 kW	8980 kg	5980 x 1 500 x 1750	3779424
MSBM 5020-20 PRO DUO	5 020 mm	2.0 mm	350/240 mm	4.0 kW	2 x 4.0 kW	9840 kg	6480 x 1 500 x 1750	3779425

*Performance data for material with tensile strength of 400 N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA)



Accessories MSBM 2020-80 PRO / SH / DUO Art. no.

Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797011
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797021
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797591
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797611
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797621

Accessories MSBM 2520-70 PRO / SH / DUO Art. no.

Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797012
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797022
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797592
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797612
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797622

Accessories MSBM 3020-60 PRO / SH / DUO Art. no.

Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797013
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797023
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797593
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797613
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797623

Accessories MSBM 4020-40 PRO / SH / DUO Art. no.



- **Optional CNC control with 3D graphics**, the profiles are drawn by the operator on a generously dimensioned 19" touchscreen; all axis positions and the bending sequence are computed by the control, motorised rear stop with stop fingers, travel range 15-1 000 mm

Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797014
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797024
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797594
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797614
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797624

Accessories MSBM 4520-30 PRO / SH / DUO Art. no.

Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797015
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797025
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797595
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797615
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797625

Accessories MSBM 5020-20 PRO / SH / DUO Art. no.

Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797016
Rear stop with hand wheel, measuring device and stop fingers 6 - 760 mm	3797026
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of edging sequences possible	3797596
Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1 000 mm, storing of bending sequences possible	3797616
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1 000 mm,	3797626



- **Standard control MA** manual adjustment of bending angle via ring scale on left side of machine



- **Optional control PT 1** - Manual adjustment of bending angle via potentiometer conveniently from the front of the machine



- **Optional control Schneider TM 238**, single-axis control for digital angle input via generously dimensioned touchscreen with the option of storing bending sequences



- **Optional control Schneider CNC2A**, two-axis control for digital angle input and input of the rear stop position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm



- **Optional control Schneider CNC3A**, three-axis control for digital angle input, input of the rear stop position and beam opening position with the option of storing bending sequences, motorised rear stop with stop fingers, travel range 15-1 000 mm

Bending brakes

GBP-E — CNC controlled press brake with 3-axle drive up to 200 t compression force

Standard type

- ▶ Heavy, welded steel construction, stress-free annealing
- ▶ Graphical 2D CNC control DT-10 with generously-dimensioned 10" touchscreen, ergonomically mounted on swivel arm
- ▶ CNC-controlled Y1, Y2 and X axis
- ▶ X axis driven via play-free ball screws
- ▶ Slightly offset top tool and Multi-V die 85°
- ▶ 2 rear stop fingers guided in longitudinal direction on linear rail
- ▶ Manual R axis, height adjustment of rear stop fingers via hand wheels
- ▶ Positioning of top beam with a resolution of 0.01 mm
- ▶ Measuring system decoupled from side stands to compensate for side stand deflection
- ▶ Manual table crowning via hand wheel with counter
- ▶ Solid, low-maintenance guides on the top beam
- ▶ Long throat
- ▶ 2 sheet support arms with T groove and tilting cams
- ▶ Fliessler AKAS II safety device travels with the top beam
- ▶ Fliessler FPSC safety PLC



GBP-E 3050-120

Model	Press force	Bending length (A)	Upright passageway (B)	Rapid traverse	Bending speed	Retraction	Installation height (D)	Motor output
GBP-E 2550-60	60 t	2 550	2150	120 mm/s	9 mm/s	70 mm/s	350 mm	7.5 kW
GBP-E 3050-120	120 t	3 050	2 550	100 mm/s	9 mm/s	77 mm/s	375 mm	11 kW
GBP-E 3050-200	200 t	3 050	2 550	100 mm/s	7 mm/s	73 mm/s	445 mm	15 kW

Model	Stroke (C)	Reach (E)	Rear stop	Table height (F)	Table width (G)	Number of support brackets	Weight	Dimensions (L x W x H) in mm	Art. no.
GBP-E 2550-60	160 mm	250 mm	620 mm	813 mm	104 mm	2 units	4 000 kg	3 750 x 1 100 x 2 350 mm	3828001
GBP-E 3050-120	180 mm	250 mm	620 mm	878 mm	104 mm	2 units	5 900 kg	4 200 x 1 230 x 2 400 mm	3828002
GBP-E 3050-200	210 mm	250 mm	620 mm	858 mm	104 mm	2 units	7950 kg	4 500 x 1390 x 2 520 mm	3828003

- Premium hydraulic components (Bosch/Rexroth, Hydac, Atos)
- Easy operation via mobile foot pedal console with emergency stop
- Electronically monitored side and rear doors
- Hydraulic operation

Custom accessories

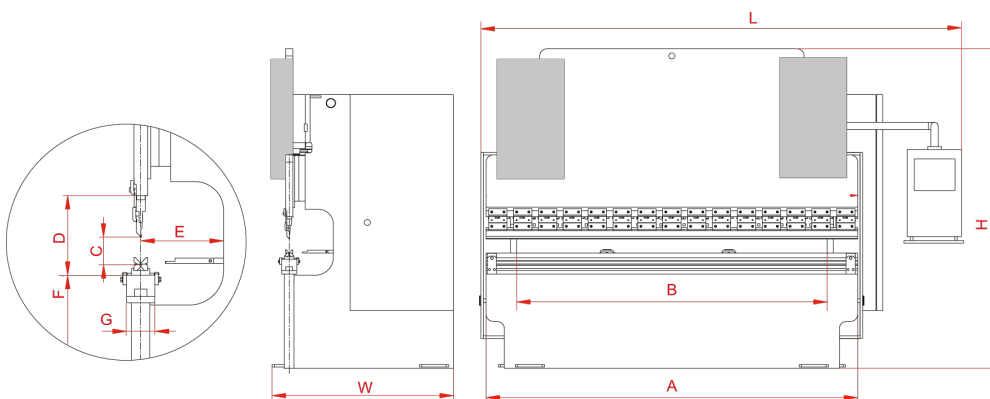
- Additional rear stop fingers
- Additional support arm
- Manual top tool quick release with cam lever



CNC control DT-10 (standard)

The products are drawn on the graphical 2D control, DT-10 with touchscreen – after completing the drawing, the control computes the bending sequences and the matching axis positions

- Y1, Y2 and X axes and the optional R axis with motorised crowning are supported
- 10.1" TFT LCD screen with capacitive touch surface
- Computation of the following functions: bending sequence, stretched length, immersion depth, changeover point, clamping point, compression force, crowning
- Bending tools, top beam, table and stop fingers can be freely drawn for optimum collision monitoring
- Bending sequence simulation
- USB interface for backing up data



► Motorised X axis



► Rear stop fingers on linear guide adjustable laterally and height adjustable via spindles



► Laterally adjustable support arms with 2 fastening positions



► Manual top tool quick release with cam lever (option)

Accessories available on request

- Additional rear stop fingers
- Additional sheet support arm
- Manual top tool quick release

Bending brakes

GBP-R — CNC controlled press brake with 3-axe drive up to 400 t compression force

Standard type

- ▶ Very heavy, rugged welded steel construction, stress-free annealing
- ▶ Graphical 2D CNC control DT-10 with generously-dimensioned 10" touchscreen, ergonomically mounted on swivel arm
- ▶ CNC-controlled Y1, Y2 and X axis
- ▶ X axis 650 mm, guided on linear rails and driven via play-free ball screws (as of GBP-R 4050-400 X axis 750 mm)
- ▶ Two rear stop fingers with double linear guides and generously dimensioned, very rugged aluminium profile
- ▶ Manual R axis, height adjustment of rear stop fingers via hand wheels
- ▶ All rear stop exes, standard and optional, with servo drives
- ▶ Positioning of top beam with a resolution of 0.01 mm
- ▶ Measuring system decoupled from side stands to compensate for side stand deflection
- ▶ Manual table crowning via hand wheel with counter
- ▶ Manual top tool quick release with cam lever and Promecam/Amada system
- ▶ Complete set of Rehfuß top tools
- ▶ Complete set 4x die with V openings 16, 22, 35, 50 mm
- ▶ Solid, low-maintenance quadruple guides on the top beam
- ▶ Large side upright overhang of 410 mm (510 mm for machines of 400 t compression force)
- ▶ 2 sheet support arms with T groove and tilting cams, guided on linear rail in longitudinal direction
- ▶ Fiessler AKAS II safety device travels with the top beam
- ▶ Fiessler FPSC safety PLC
- ▶ Premium hydraulic components (Bosch/Rexroth, Hydac, Atos)
- ▶ Easy operation via mobile foot pedal console with emergency stop
- ▶ Electronically monitored side and rear doors
- ▶ Motorised table crowning, CNC-controlled R axis, CNC-controlled Z1-Z2 axes and alternative CNC-controls optionally available



GBP-R 3050-100 - Figure shows optional motorised table crowning and motorised R axis

Custom accessories

- ▶ Numeric CNC control CybeleC ModEva 15T with graphical support and offline 3D software
- ▶ CNC-controlled X-R-Z1-Z2 stop (not available with DA 58T)
- ▶ CNC-controlled X-R stop
- ▶ CNC-controlled, motorised table crowning to compensate for bending of top beam and table extension of X axis move area to 1 000 mm
- ▶ Additional rear stop fingers and sheet support arms
- ▶ Table groove of 12.7 x 15.8 mm for LVD type plug-in dies
- ▶ Extension of stand reach
- ▶ Quick release top tool TEDA type for vertical removal of the top tools
- ▶ Parking position for support arms
- ▶ Individual punches and dies
- ▶ Control on left side of machine

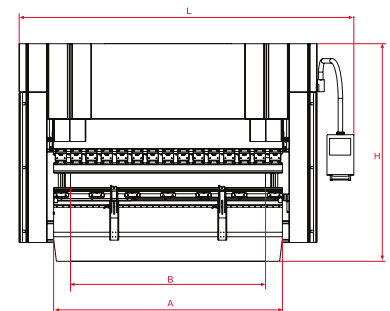
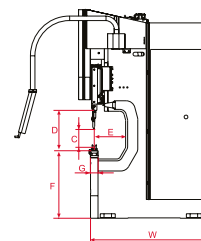


GBP-R 3050-175

CNC control DT-15 (standard)

The products are drawn on the graphical 2D control, DT-15 with touchscreen – after completing the drawing, the control computes the bending sequences and the matching axis positions

- ▶ Y1, Y2, X axes and optional R, Z1, Z2 axes and motorised table crowning are supported
- ▶ 15" TFT LCD screen with capacitive touch surface
- ▶ Computation of the following functions: bending sequence, stretched length, immersion depth, changeover point, clamping point, compression force, crowning
- ▶ Bending tools, top beam, table and stop fingers can be freely drawn for optimum collision monitoring
- ▶ Bending sequence simulation
- ▶ USB interface for backing up data
- ▶ Offline PC software



- (A) Bending length
- (B) Distance between columns
- (C) Stroke
- (D) Installation height
- (E) Throat depth

- (F) Table height
- (G) Table width
- (H) Height
- (L) Length
- (W) Depth



Bending brakes



GBP-R 3050-100 - Figure shows optional motorised table crowning and motorised R axis

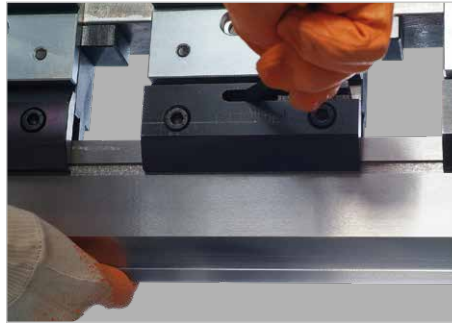
**More models
on request!**

Technical specifications	Press force	Bending length	Upright passageway	Stroke	Installation height	Throat	Rapid traverse	Bending speed	Retraction	Motor output
GBP-R 1250-60	60 t	1 250 mm	1 050 mm	160 mm	400 mm	350 mm	200 mm/s	10 mm/s	110 mm/s	7.5 kW
GBP-R 2050-60	60 t	2 050 mm	1 700 mm	160 mm	400 mm	350 mm	200 mm/s	10 mm/s	110 mm/s	7.5 kW
GBP-R 2550-100	100 t	2 550 mm	2 200 mm	265 mm	530 mm	410 mm	180 mm/s	10 mm/s	120 mm/s	11 kW
GBP-R 3050-100	100 t	3 050 mm	2 600 mm	265 mm	530 mm	410 mm	180 mm/s	10 mm/s	120 mm/s	11 kW
GBP-R 3050-135	135 t	3 050 mm	2 600 mm	265 mm	530 mm	410 mm	160 mm/s	10 mm/s	120 mm/s	15 kW
GBP-R 3050-175	175 t	3 050 mm	2 600 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	18.5 kW
GBP-R 3050-220	220 t	3 050 mm	2 600 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	22 kW
GBP-R 3050-320	320 t	3 050 mm	2 600 mm	365 mm	630 mm	410 mm	100 mm/s	10 mm/s	100 mm/s	37 kW
GBP-R 3750-175	175 t	3 700 mm	3 100 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	18.5 kW
GBP-R 3750-220	220 t	3 700 mm	3 100 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	22 kW
GBP-R 4050-175	175 t	4 050 mm	3 600 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	18.5 kW
GBP-R 4050-220	220 t	4 050 mm	3 600 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	22 kW
GBP-R 4050-320	320 t	4 050 mm	3 600 mm	365 mm	630 mm	410 mm	100 mm/s	10 mm/s	100 mm/s	37 kW
GBP-R 4050-400	400 t	4 050 mm	3 400 mm	365 mm	630 mm	510 mm	100 mm/s	8 mm/s	80 mm/s	37 kW
GBP-R 6050-220	220 t	6 050 mm	5 100 mm	265 mm	530 mm	410 mm	100 mm/s	10 mm/s	100 mm/s	22 kW
GBP-R 6050-320	320 t	6 050 mm	5 100 mm	365 mm	630 mm	410 mm	100 mm/s	10 mm/s	100 mm/s	37 kW
GBP-R 6050-400	400 t	6 050 mm	5 100 mm	365 mm	630 mm	510 mm	100 mm/s	8 mm/s	80 mm/s	37 kW

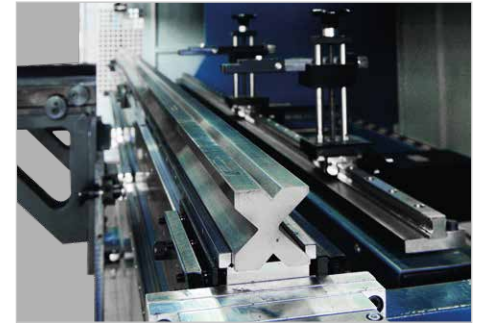
Technical specifications	X axis stroke	X axis speed	Table width	Table height	Support arms/rear stop fingers	Oil tank Capacity	Weight	Dimensions L x W x H	Art. no.
GBP-R 1250-60	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	100 l	3 100 kg	2 300 x 1 200 x 2 350 mm	3821240
GBP-R 2050-60	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	100 l	3 550 kg	3 200 x 1 200 x 2 350 mm	3822510
GBP-R 2550-100	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	100 l	8 650 kg	3 800 x 1 670 x 2 750 mm	3823010
GBP-R 3050-100	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	100 l	9 250 kg	4 200 x 1 670 x 2 750 mm	3823013
GBP-R 3050-135	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	150 l	10 250 kg	4 200 x 1 680 x 2 750 mm	3823017
GBP-R 3050-175	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	250 l	11 250 kg	4 250 x 1 700 x 2 750 mm	3823022
GBP-R 3050-220	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	250 l	12 250 kg	4 250 x 1 770 x 2 900 mm	3823032
GBP-R 3050-320	650 mm	250 mm/s	154 mm	900 mm	2/2 pc.	250 l	17 250 kg	4 300 x 1 820 x 3 230 mm	3823717
GBP-R 3750-175	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	250 l	17 250 kg	4 950 x 1 700 x 2 900 mm	3823722
GBP-R 3750-220	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	250 l	14 100 kg	4 950 x 1 770 x 2 900 mm	3824017
GBP-R 4050-175	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	250 l	12 850 kg	5 250 x 1 700 x 2 750 mm	3824022
GBP-R 4050-220	650 mm	250 mm/s	104 mm	900 mm	2/2 pc.	250 l	14 750 kg	5 250 x 1 770 x 2 900 mm	3824032
GBP-R 4050-320	650 mm	250 mm/s	154 mm	900 mm	2/2 pc.	250 l	20 750 kg	5 300 x 1 910 x 3 230 mm	3824040
GBP-R 4050-400	750 mm	250 mm/s	154 mm	1 040 mm	2/2 pc.	450 l	26 750 kg	5 750 x 2 110 x 3 540 mm	3824060
GBP-R 6050-220	750 mm	250 mm/s	154 mm	1 100 mm	4/4 pc.	250 l	20 590 kg	7 500 x 1 770 x 3 250 mm	3826022
GBP-R 6050-320	750 mm	250 mm/s	154 mm	1 100 mm	4/4 pc.	250 l	28 250 kg	7 500 x 1 910 x 3 450 mm	3826032
GBP-R 6050-400	750 mm	250 mm/s	154 mm	1 220 mm	4/4 pc.	500 l	35 750 kg	7 500 x 2 110 x 3 710 mm	3826040



► Fiessler AKAS II safety device



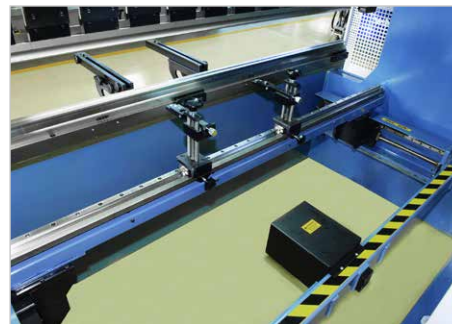
► Manual quick release clamping



► Die mount



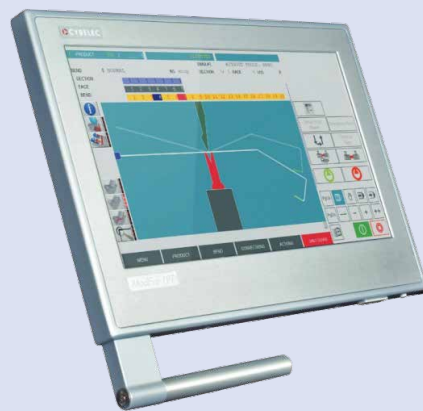
► Sheet support arms displaceable on linear rails



► Rear stop fingers on linear guide adjustable laterally and height adjustable via spindles



► Large installation height
► Large stand reach
► Figure shows motorised table crowning option



CNC control Cybele ModEva 19T

This 3D CNC control is operated via a very large 15" touchscreen. Numeric programming of sections and simultaneous display in a 3D graphic. After creating the section, the bending sequence is automatically computed. The bending sequences are graphically simulated. Crowning is supported.

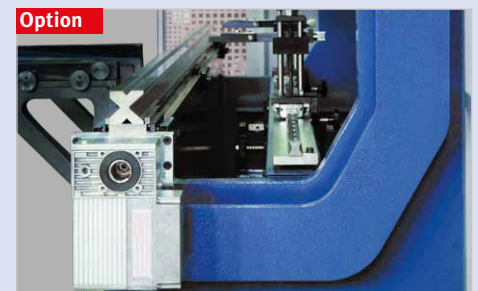
- Up to 12 further optional axes supported in addition to four standard axes (Y1, Y2, X and R) and motorised table crowning
- Automatic computation of the following

functions: bending sequence, rear stop position for known external dimensions, tool safety zones, compression force, bending tolerance, crowning, stretched length, embossing force, radius bending

- Graphical tool and product library
- Collision monitoring
- USB interface for mouse, keyboard and data transfer
- Offline 3D software
- 15" touchscreen



► Motorised R axis



► CNC-controlled, motorised table crowning

Accessories	Art. no.
ModEva 19T 3D with 3D offline software	On request
Delem DA 58T	On request
Prepared for tandem version as of GBP-R 3050-100	3884019

CNC-controlled X-R stop	
for GBP-R 1250-40	3884002
for GBP-R 2050-60/2550-100	3884003
for GBP-R 3050-100/3050-135/ 3050-175/3050-220/3050-320	3884004
for GBP-R 3750-175/3750-220	3884005
for GBP-R 4050-175/4050-220/ 4050-320/4050-400	3884006
CNC-controlled X-R-Z1-Z2 stop	
for GBP-R 1250-60	On request
for GBP-R 2050-60/2550-100	On request
for GBP-R 3050-100/3050-135/ 3050-175/3050-220/3050-320	On request
for GBP-R 3750-175/3750-220	On request
for GBP-R 4050-175/4050-220/ 4050-320/4050-400	On request

Accessories	Art. no.
CNC-controlled motorised table crowning	
for GBP-R 1250-40/2050-60/2550-100	3884011
for GBP-R 3050-100/3050-135/ 3050-175/3050-220/3050-320	3884012
for GBP-R 3750-175/3750-220	3884013
for GBP-R 4050-175/ 4050-220/4050-320/4050-400	3884014

Additional rear stop fingers	
for GBP-R 1250-60/2050-60/ 2550-100/3050-100/3050-135/ 3050-175/3750-175/4050-175	3884015
for GBP-R 3050-220/3050-320/3750-220/4050-220/4050-320/4050-400	3884016

Accessories	Art. no.
Additional support arm	
for GBP-R 1250-40/2050-60/ 2550-100/ 3050-100/3050-135/3050-175/3050-220	3884017
for GBP-R 3050-320/4050-320/4050-400	3884018



► Delem DA 58T

Bending brakes

GBP-S — CNC controlled press brakes with 4 driven axes and motorised crowning

Standard type

- ▶ Very heavy, rugged welded steel construction, stress-free annealing
- ▶ Graphical 3D CNC control Cybele ModEva 19T with generously dimensioned 19" touchscreen, intuitive operation
- ▶ CNC controlled Y1, Y2, X and R axis and motorised table crowning
- ▶ X axis 650 mm, guided on linear rails and driven via play-free ball screws (as of GBPSR 4050-400 X axis 750 mm)
- ▶ 2 rear stop fingers guided in longitudinal direction on double linear rail (4 pcs. as of bending width of 6 050 mm)
- ▶ Motorised R axis, automatic height adjustment of rear stop fingers via ball screw
- ▶ Positioning of top beam with a resolution of 0.01 mm
- ▶ Measuring system decoupled from side stands to compensate for side stand deflection
- ▶ Manual top tool quick release with cam lever and Promecam/Amada system
- ▶ Complete set of Rehfuß top tools
- ▶ Complete set 4x dies
- ▶ Solid, low-maintenance 4x guides on the top beam
- ▶ Large side stand overhang of 410 mm (510 mm for machines of 400t compression force)
- ▶ 2 sheet support arms with T groove and tilting cams, guided on linear rail in longitudinal direction (4 pcs. as of bending width of 6 050 mm)
- ▶ Fiesler AKAS II safety device travels with the top beam
- ▶ Fiesler FPSC safety PLC
- ▶ Premium hydraulic components (Bosch/Rexroth, Hydac, Atos)
- ▶ Easy operation via mobile foot pedal console with emergency stop
- ▶ Electronically monitored side and rear doors
- ▶ Hydraulic operation



GBP-S 3050-175 with
Delta-X option

Custom accessor

- ▶ Graphical 3D CNC control Cybelec ModEva RA Premium
- ▶ Graphical 2D CNC control Delem DA-66T
- ▶ Rear stop Delta X
- ▶ Rear stop X1/X2
- ▶ Rear stop Z1/Z2
- ▶ Rear stop X1/X2-, R1/R2-, Z1/Z2 (tower version)
- ▶ Extension of X axis travel range to 1 000 mm
- ▶ Wila hydraulic workpiece clamping system

- ▶ AKAS 3 m, motorised adjustment of safety laser
- ▶ Motorised, controlled bending aids
- ▶ Pneumatic displacement below tool
- ▶ Additional rear stop fingers and sheet support arms
- ▶ Table groove of 12.7 x 15.8 mm for LVD type plug-in dies
- ▶ Extension of stand reach
- ▶ Extension of piston stroke
- ▶ Quick release top tool Speedtouch type for

- vertical removal of the top tools
- ▶ Parking position for support arms
- ▶ Individual punches and dies
- ▶ Control on left side of machine
- ▶ Prepared for tandem operation

(as of bending width 3 050 mm)



Rear view with optional 6-axis rear stop

Press brake GBP-S

**More models
on request!**



GBP-S 3050-175
with Delta-X option

Technical specifications	Press force	Bending length	Stand passageway	Stroke	Installation height	Throat	Rapid traverse	Bending speed	Retraction	Motor output	X axis stroke	X axis speed
GBP-S 1250-60	60 t	1 250 mm	1 050 mm	265 mm	530 mm	410 mm	200 mm/s	10 mm/s	110 mm/s	7.5	650 mm	500 mm/s
GBP-S 2050-60	60 t	2 050 mm	1 700 mm	265 mm	530 mm	410 mm	200 mm/s	10 mm/s	110 mm/s	7.5	650 mm	500 mm/s
GBP-S 2550-100	100 t	2 550 mm	2 200 mm	265 mm	530 mm	410 mm	180 mm/s	10 mm/s	120 mm/s	11	650 mm	500 mm/s
GBP-S 3050-100	100 t	3 050 mm	2 600 mm	265 mm	530 mm	410 mm	180 mm/s	10 mm/s	120 mm/s	11	650 mm	500 mm/s
GBP-S 3050-135	135 t	3 050 mm	2 600 mm	265 mm	530 mm	410 mm	160 mm/s	10 mm/s	120 mm/s	15	650 mm	500 mm/s
GBP-S 3050-175	175 t	3 050 mm	2 600 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	18.5	650 mm	500 mm/s
GBP-S 3050-220	220 t	3 050 mm	2 600 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	22	650 mm	500 mm/s
GBP-S 3050-320	320 t	3 050 mm	2 600 mm	265 mm	630 mm	410 mm	100 mm/s	10 mm/s	100 mm/s	37	650 mm	500 mm/s
GBP-S 3750-175	175 t	3 700 mm	3 100 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	18.5	650 mm	500 mm/s
GBP-S 3750-220	220 t	3 700 mm	3 100 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	22	650 mm	500 mm/s
GBP-S 4050-175	175 t	4 050 mm	3 600 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	18.5	650 mm	500 mm/s
GBP-S 4050-220	220 t	4 050 mm	3 600 mm	265 mm	530 mm	410 mm	120 mm/s	10 mm/s	100 mm/s	22	650 mm	500 mm/s
GBP-S 4050-320	320 t	4 050 mm	3 600 mm	365 mm	630 mm	410 mm	100 mm/s	10 mm/s	100 mm/s	37	650 mm	500 mm/s
GBP-S 4050-400	400 t	4 050 mm	3 400 mm	365 mm	630 mm	510 mm	100 mm/s	8 mm/s	80 mm/s	37	750 mm	350 mm/s
GBP-S 4050-600	600 t	4 050 mm	3 100 mm	365 mm	700 mm	510 mm	80 mm/s	7 mm/s	80 mm/s	45	750 mm	350 mm/s
GBP-S 6050-220	220 t	6 050 mm	5 100 mm	265 mm	530 mm	410 mm	80 mm/s	10 mm/s	100 mm/s	22	750 mm	350 mm/s
GBP-S 6050-320	320 t	6 050 mm	5 100 mm	365 mm	630 mm	410 mm	100 mm/s	10 mm/s	100 mm/s	37	750 mm	350 mm/s
GBP-S 6050-400	400 t	6 050 mm	5 100 mm	365 mm	630 mm	510 mm	100 mm/s	8 mm/s	80 mm/s	37	750 mm	350 mm/s

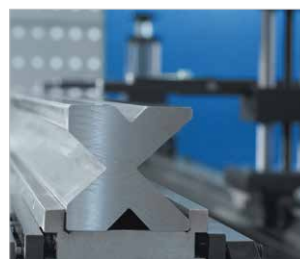
Technical specifications	R axis stroke	R axis speed	Table width	Table height	Crowning	Underfloor	Support arms	Oil tank capacity	Weight approx.	Dimensions L x W x H	Art. no.
GBP-S 1250-60	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	100 l	4 900 kg	2 550 x 1 650 x 2 750 mm	3821241
GBP-S 2050-60	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	100 l	5 600 kg	3 400 x 1 650 x 2 750 mm	3822061
GBP-S 2550-100	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	100 l	8 900 kg	3 800 x 1 670 x 2 750 mm	3822511
GBP-S 3050-100	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	100 l	9 500 kg	4 200 x 1 670 x 2 750 mm	3823011
GBP-S 3050-135	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	150 l	10 500 kg	4 200 x 1 680 x 2 750 mm	3823014
GBP-S 3050-175	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	250 l	11 500 kg	4 250 x 1 700 x 2 750 mm	3823018
GBP-S 3050-220	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	250 l	12 500 kg	4 250 x 1 770 x 2 900 mm	3823023
GBP-S 3050-320	250 mm	350 mm/s	154 mm	900 mm	motorised	-	2/2 pc.	250 l	17 500 kg	4 300 x 1 820 x 3 230 mm	3823033
GBP-S 3750-175	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	250 l	13 000 kg	4 950 x 1 700 x 2 900 mm	3823718
GBP-S 3750-220	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	250 l	14 360 kg	4 950 x 1 770 x 2 900 mm	3823723
GBP-S 4050-175	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	250 l	13 100 kg	5 250 x 1 700 x 2 750 mm	3824018
GBP-S 4050-220	250 mm	350 mm/s	104 mm	900 mm	motorised	-	2/2 pc.	250 l	15 000 kg	5 250 x 1 770 x 2 900 mm	3824023
GBP-S 4050-320	250 mm	350 mm/s	154 mm	900 mm	motorised	-	2/2 pc.	250 l	21 000 kg	5 300 x 1 910 x 3 230 mm	3824033
GBP-S 4050-400	250 mm	300 mm/s	300 mm	1 040 mm	motorised	-	2/2 pc.	450 l	27 000 kg	5 750 x 2 110 x 3 540 mm	3824041
GBP-S 4050-600	250 mm	300 mm/s	300 mm	990 mm	motorised	1 200 mm	2/2 pc.	500 l	40 500 kg	5 650 x 3 250 x 3 825 mm	3824061
GBP-S 6050-220	250 mm	300 mm/s	154 mm	1 100 mm	motorised	-	4/4 pc.	250 l	20 840 kg	7 500 x 1 770 x 3 250 mm	3826023
GBP-S 6050-320	250 mm	300 mm/s	154 mm	1 100 mm	motorised	-	4/4 pc.	250 l	28 500 kg	7 500 x 1 910 x 3 450 mm	3826033
GBP-S 6050-400	250 mm	300 mm/s	300 mm	1 220 mm	motorised	-	4/4 pc.	500 l	36 000 kg	7 500 x 2 110 x 3 710 mm	3826041



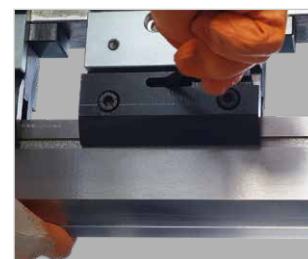
► Motorised table crowning



► R axis (Standard)
► X axis (Standard)



► Standard centring rail with optional, tempered and polished Multi-V die



► Manual quick release clamping



► Fiessler AKAS II safety device



► Delta-X axis option



► Options rear stop with Z1 and Z2 axis and Delta-X

Accessories	Art. no.	Accessories	Art. no.	Accessories	Art. no.
3D CNC control	3883997	hydr. quick release clamping top WILA max. 180t/m PowerPack	3885025	mech. quick release clamping bottom WILA max. 200t/m GBP-S 2550-100	3885041
Cybele ModEva RA Premium		hydr. quick release clamping top WILA max. 180t/m PowerPack GBP-S 4050-175/ 4050-220/4050-320/4050-400/4050-600	3885026	mech. quick release clamping bottom WILA max. 200t/m GBP-S 3050-100/3050-135/3050-175/3050-220/3050-320	3885042
2D CNC control Delem DA-66T	3883998	mech. quick release clamping top WILA max. 180t/m GBP-S 1250-40	3885027	mech. quick release clamping bottom WILA max. 200t/m GBP-S 3750-175/3750-220	3885043
3D CNC control Delem DA-69T	3883999	mech. quick release clamping top WILA max. 180t/m GBP-S 2050-60	3885028	mech. quick release clamping bottom WILA max. 200t/m GBP-S 4 050-175/4050-220/4050-320/4050-400/4050-600	3885044
Z1, Z2 axes GBP-S 1250-40/2050-60	3885001	mech. quick release clamping top WILA max. 180t/m GBP-S 2550-100	3885029	WILA PowerPack	3885045
Z1, Z2 axes GBP-S 25100	3885002	mech. quick release clamping top WILA max. 180t/m GBP-S 3050-100/3050-135/3050-175/3050-220/3050-320	3885030	for hydr. quick release clamping	
Z1, Z2 axes GBP-S 30100/30135/30175/30220/30320	3885003	mech. quick release clamping top WILA max. 180t/m GBP-S 3750-175/3750-220	3885031	Stroke 365 mm GBP 3050-100/3050-135/3050-175	3885046
Z1, Z2 axes GBP-S 37175/37220	3885004	mech. quick release clamping top WILA max. 180t/m GBP-S 4050-175/4050-220/4050-320/4050-400/4050-600	3885032	Additional support arms GBP-S 1250-40/2050-40/2050-60/2550-100/3050-100/3050-135/3050-175/3050-220	3884017
Z1, Z2 axes GBP-S 40175/40220/40320/40400/40600	3885005	hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 1250-40	3885033	Additional support arms GBP-S 3050-320/4050-320/4050-400/4050-600	3884018
X1, X2 axes GBP-S 1240/2060	3885006	hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 2050-60	3885034	Manual centralised lubrication system	3885047
X1, X2 axes GBP-S 25100	3885007	hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 2550-100	3885035	Additional rear stop fingers GBP-S 1250-40/2050-40/2050-60/2550-100/3050-100/3050-135/3050-175/3750-175/4050-175	3885048
X1, X2 axes GBP-S 30100/30135/30175/30220/30320	3885008	hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 3050-100/3050-135/3050-175/3050-220/3050-320	3885036	Additional rear stop fingers GBP-S 1250-40/2050-40/2050-60/2550-100/3050-100/3050-135/3050-175/3750-175/4050-175	3885049
X1, X2 axes GBP-S 37175/37220	3885009	hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 3050-100/3050-135/3050-175/3050-220/3050-320	3885037	Depositing zone for support arms (1 metre) GBP-S 3050-100/3050-135/3050-175/3050-220/3750-175/3750-220/4050-175/4050-220/4050-320	3885050
X1, X2 axes GBP-S 40175/40220/40320/40400/40600	3885010	hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 4050-175/4050-220/4050-320/4050-400/4050-600	3885038	Depositing zone for support arms (1 metre) GBP-S 4050-400/4050-600	3885051
R1, R2 axes GBP-S 1240/2060	3885011	mech. quick release clamping bottom WILA max. 200t/m GBP-S 1250-40	3885039	Additional support arms GBP-S 1250-40/2050-60/2550-100/3050-100/3050-135/3050-175/3050-220/3050-320/3750-175/3750-220/4050-175/4050-220/4050-320	3885053
R1, R2 axes GBP-S 25100/30100/30135	3885012	mech. quick release clamping bottom WILA max. 200t/m GBP-S 2050-60	3885040	4050-220/4050-320 Additional support arms GBP-S 4050-400/4050-600	3885054
R1, R2 axes GBP-S 30175/30220/30320	3885013			Preparation for tandem version as of GBP-S 3050-100	3884019
R1, R2 axes GBP-S 37175/37220	3885014				169
R1, R2 axes GBP-S 40175/40220/40320	3885015				
R1, R2 axes GBP-S 40400	3885016				
R1, R2 axes GBP-S 40600	3885017				
X axis = 1 000 mm, with light barrier on rear side	3885018				
Pneumatic height adjustment front support arms	3885019				
man. quick release clamping GBP-S 3750-175/3750-220/4050-175/4050-220	3884010				
hydr. quick release clamping top WILA max. 180t/m PowerPack GBP-S 1250-40	3885021				
hydr. quick release clamping top WILA max. 180t/m PowerPack GBP-S 2 050-60	3885022				
hydr. quick release clamping top WILA max. 180t/m PowerPack GBP-S 2550-100	3885023				
hydr. quick release clamping top WILA max. 180t/m PowerPack	3885024				
GBP-S 3050-100/ 3050-135/3050-175/3050-220/3050-320					

Bending brakes

Accessories for bending brakes GBP



► Manual quick release clamping for fast tool changes (standard for R, S and Servo)



► Hydraulic top tool clamping "WILA" for easy tool changes within seconds (optional)



► Standard centring rail with optional, tempered and polished Multi-V die



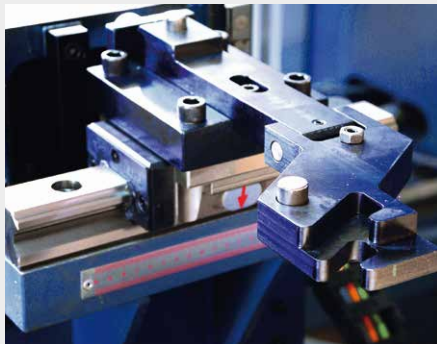
► Movable front support brackets (standard for R, S and Servo)



► CNC-controlled, motorised table crowning (standard for S and Servo series)



► Rear stop system with R axis (standard for S and Servo series)



► Custom design rear stop fingers



► Delta X (option)



► Hydraulic tool clamping (option)

Commissioning & professional initial training

When purchasing a Metallkraft machine, we recommend that customers call in one of our specialists to complete commissioning and provide induction training on site.

Commissioning and initial training for standard machines	Art. no.
	EINWMET
Initial training & training for CNC controls	EINWCNCMET
Duration of commissioning and initial training for custom machines*	EINWGBPMET

* DBM, MBBS, FSM, HTBS, MSBM Pro, controlled PRM and MRB, GBP, LMS 400A and metal band saws with X-control

Commissioning includes:

- Installing the machine
- (Unloading and transporting the machine to the installation location; providing the electrical and pneumatic connections, and the floor anchors or assembly plates are the purchaser's responsibility.)
- Cleaning, tooling and aligning
- Checking all functions

Initial training on the machine includes:

- an exhaustive explanation of the controls
- an explanation of the individual functions
- Setting and explaining the basic parameters
- Explaining the safety instructions as per best practices

For programmable models, additionally:

- an exhaustive explanation of the controls
- an explanation of the individual functions
- Setting and explaining the basic parameters
- Explaining the safety instructions as per best practices

Duration of commissioning and initial training:

8 hours per day, including travel times to and from the site, plus travel expenses at €0.69 per km, plus any charges for overnight stays as applicable.

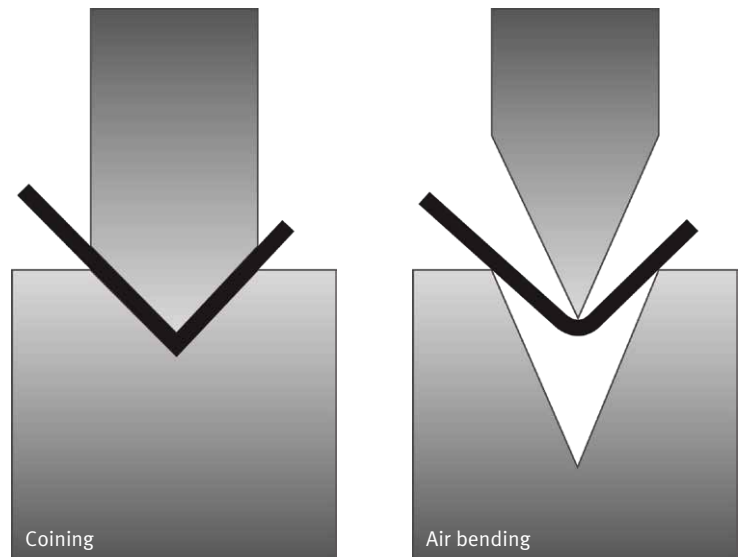
If the initial training time is 8 hours, the travel time is invoiced at €48 /hour.

This also applies for any different or additional services, which must be ordered separately on site and will be invoiced on individual basis.

If the customer requires and requests installation and connecting of the machine, the customer is obliged to support our technician to the best of customer's ability and to provide the required helpers, tools and equipment at customer's own expense.

Coining and air bending - two different types of brake bending

- **Coining** is an edging method in which the sheet is embossed at high pressure between the punch and die. Both the opening angle of the punch and the opening angle of the die are close to 90° here.
- Coining allows for slightly more precise results and less control precision is required.
This method is less flexible, however, because each tool set is designed for precisely one bending angle. And a press force **F** many times higher than in air bending (approx. 3-8 times) is required.
- In **air bending**, in contrast, the sheet only touches the die at the two edges. This method thus requires very precise control (CNC) of the punch to achieve results with sufficient precision.
- The resulting bending radius is mainly determined by the die opening angle **V**. The shape and angle of the punch only have a minor influence on the bending angle.
- The main benefit of air bending is the ability to bend various angles without changing tools. For this reason, it is often preferred to coining.

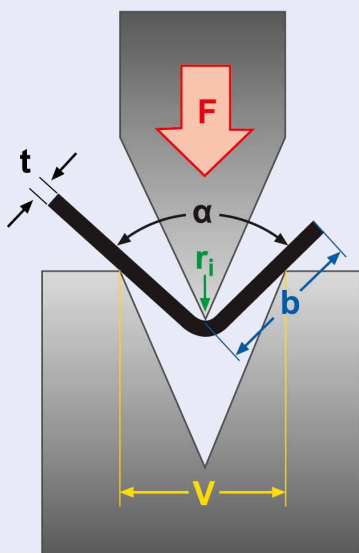


Determining the bending parameters for air bending

Press force table

- Required press force **F** for 90° air bending, tensile strength **R = 42 kg/mm²**

	V in mm	b in mm	ri in mm	t in mm	F t/m															
t	4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
	3	3.5	4	5.5	6.5	8	10.5	13	16.5	21	26	32.5	41	52	65	81.5	104	130	163	b
	0.5	0.7	0.8	1	1.3	1.5	2	2.5	3.2	4.4	5	6.5	8	10	12	15	20	25	37	ri
0.6	6	5	3	2																F t/m
0.8	12	9	7	5	4															
1		15	11	8	6	5														
1.2			18	12	9	7	5													
1.5				21	15	12	8	6												
2					30	23	16	12	9											
2.5						39	27	20	14	11										
3							43	31	23	16	12									
4								60	44	32	23	18								
5									76	54	39	29	22							
6										85	62	45	33	25						
8											121	88	70	46	35					
10												151	109	79	58	44				
12													173	124	91	66	50			
15														213	155	113	81	62		
20															302	220	158	115	89	
25																378	269	197	144	



Material thickness	T
Bending angle	a
Press force	F
Die opening angle	V
Shortest leg length	b
Inner radius	ri

The die opening angle **V** should be 6-12x the material thickness **t**. When selecting the die opening angle **V**, the shortest leg length **b** and the bending angle also need to be taken into consideration. The smaller **V** is, the smaller the inner radius **ri**. The required press force **F** can be computed taking the tensile strength **R** into account. Based on the press force table and using the formulae, you can easily determine the correct values yourself.

Function of the shortest leg length **b** from bending angle α :

$\alpha = 30^\circ$	$b \times 1.6$
$\alpha = 60^\circ$	$b \times 1.1$
$\alpha = 90^\circ$	$b \times 1.0$
$\alpha = 120^\circ$	$b \times 0.9$
$\alpha = 150^\circ$	$b \times 0.7$

Function of the inner radius **ri** from tensile strength **R**:

R = 20 kg/mm² (Al)	$r_i \times 0.8$
R = 42 kg/mm² (Fe)	$r_i \times 1.0$
R = 70 kg/mm² (Inox)	$r_i \times 1.4$

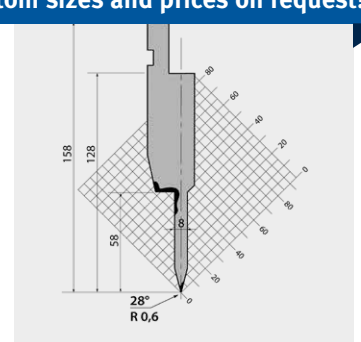
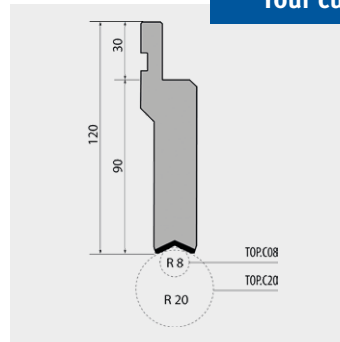
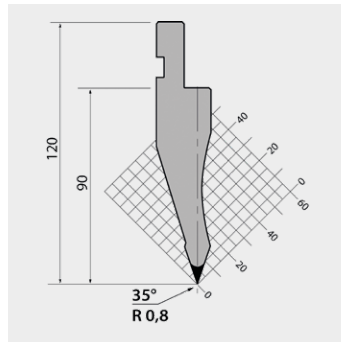
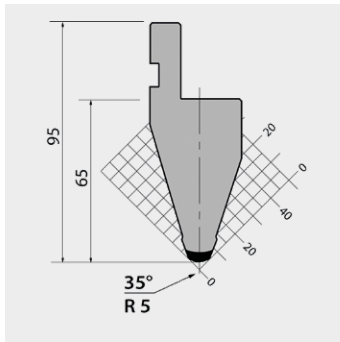
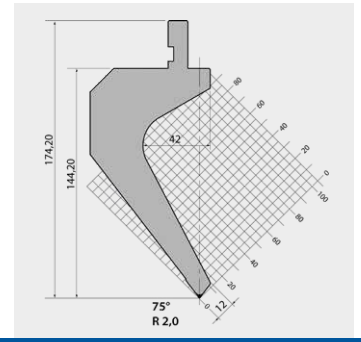
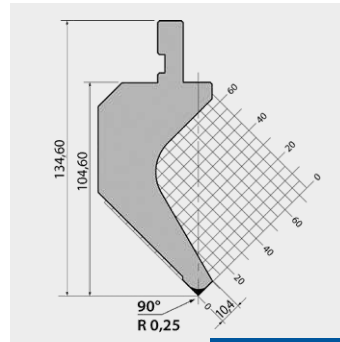
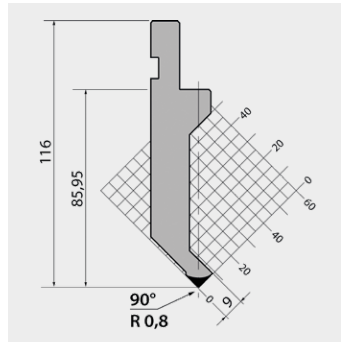
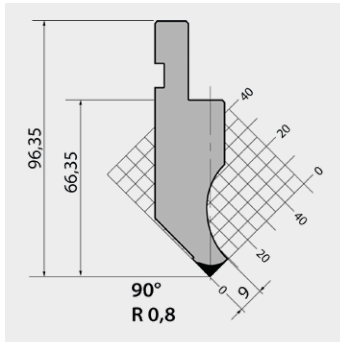
Punches and dies

Matching punches and dies for various applications

A number of examples from our comprehensive range of tools for press brakes are listed here. In addition to our comprehensive offer of standard tools, custom

tools can be tailored to your individual requirements – we are always happy to advise you on the topic of punches and dies.

Examples of top tools:



Your custom sizes and prices on request!

Examples of bottom tools:

