



Bending

Compressing and stretching machines

SSG series - Compressing and stretching machine for use in workshops and on construction sites

- For manufacturing wheel arches, window frames, rain gutters or door edges for classic vehicles
- For stretching and compressing edge-bent sheet metal
- Clean, fast and low-noise work
- Incl. compression and stretching tools
- Fast and easy tool changes
- Easy to use



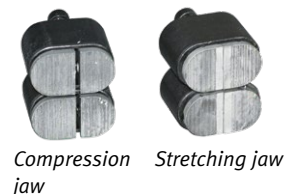
SSG 12

- Force transfer to tools via hand lever
- Figure shows scope of delivery



SSG 16

- Force transfer to tools via foot pedal
- Carriage unit for ease of transport



Scope of supply:

- Basic machine
- Compression jaws
- Stretching jaws

Model	SSG 12	SSG 16
Art. no.	3776102	3776103
Technical data		
Max. sheet thickness	1.2 mm	1.5 mm
Throat	25 mm	153 mm
Dimensions	150 x 50 x 140 mm	1175 x 410 x 920 mm
Weight	5.5 kg	36 kg

* Dimensions without hand lever

Accessories	Art.no.
Compression jaw SET for SSG 12	3776104
Stretching jaw SET for SSG 12	3776105
Compression jaw SET for SSG 16 for metal	3776106
Stretching jaw SET for SSG 16 for metal	3776107
Compression jaw SET for SSG 16 for aluminium	3776108
Stretching jaw SET for SSG 16 for aluminium	3776109



WB 100 – Angle bender for enthusiasts and trade professionals

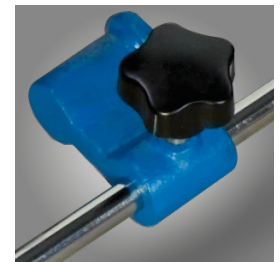
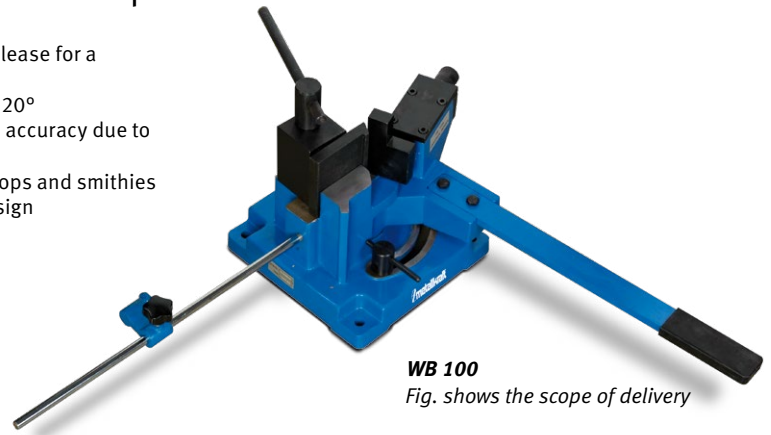
- ▶ For precise cold and hot bending of flat, round and square steel
- ▶ Robust design for bolting onto the workbench
- ▶ Drill holes in cast bed for fastening to the workbench
- ▶ Infinitely adjustable bending stop
- ▶ With eccentric quick release for a rational style of work
- ▶ Bending angles up to 120°
- ▶ High level of repetition accuracy due to bending angle stop
- ▶ Ideal for repair workshops and smithies
- ▶ Particularly rugged design

Model	WB 100
Art. no.	3776101

Technical data	
Cold:	
Flat steel	100 x 5 mm
Round steel bars	18 mm
Square steel bars	16 x 16 mm
Angle steel	60 x 8 mm
Hot:	
Flat steel	100 x 15 mm
Round steel bars	27 mm
Square steel bars	25 x 25 mm
Angle steel	100 x 12 mm
Dimensions	550 x 320 x 240 mm
weight	30 kg

Scope of supply:

- › Angle stop
- › Bending plate
- › Bending lever
- › Material stop



HRB 10 – Hydraulic pipe bender for universal application with 6 bending segments from 1/2" - 2"

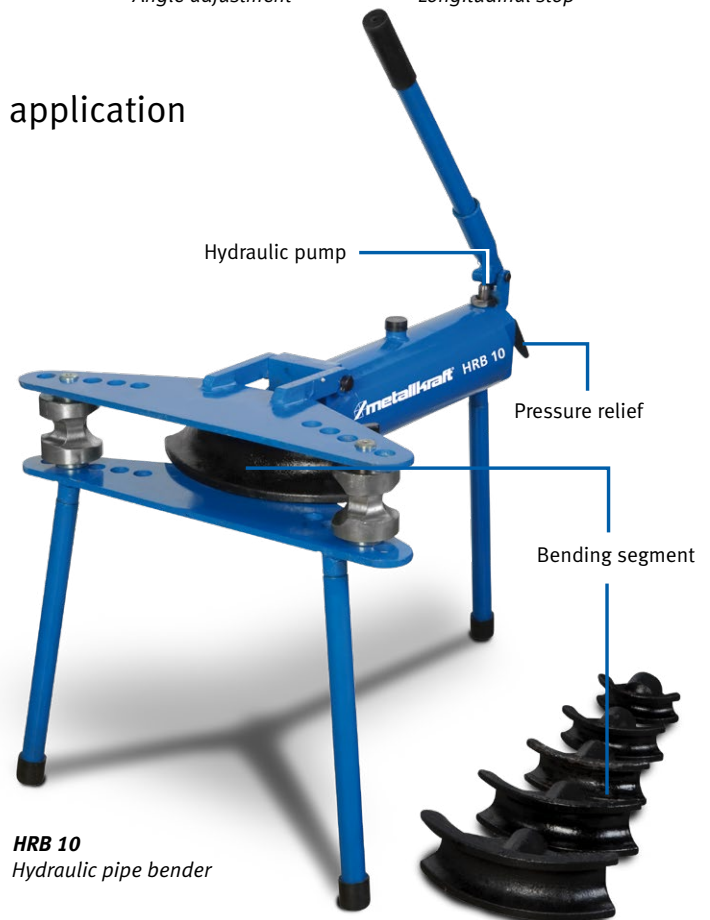
- ▶ Universally deployable for heating, gas, boiling, water, copper and composite pipes
- ▶ Fold-up bending frame for convenient and rational operation
- ▶ With tripod stand for ergonomic work

Scope of supply:

- › Six bending segments: 1/2", 3/4", 1", 1 1/4", 1 1/2", 2"
- › Tripod stand

Model	HRB 10
Art. no.	3777010

Technical data	
Pressure output	10 t
Piston stroke	155 mm
Pipe diameter imperial	1/2; 3/4; 1; 1 1/4; 1 1/2; 2"
Pipe diameter metric	21.3; 26.8; 33.5; 42.3; 48.0; 60.0 mm
Wall thickness	3.25; 3.5; 4.0; 4.0; 4.25; 4.5 mm
Min. bending radii	62; 78; 98; 128; 149; 187 mm
Max. bending angle	90; 90; 90; 120; 120; 120 °
Length	710 mm
Width	590 mm
height	220 mm
Weight	45 kg



Bending segment	Pipe diameter	Wall thickness	Bending radius	Bending angle	Art. no.
1/2"	21.3 mm	3.25 mm	62 mm	0-90 °	3777011
3/4"	26.8 mm	3.50 mm	78 mm	0-90 °	3777012
1"	33.5 mm	4.00 mm	98 mm	0-90 °	3777013
1 1/4"	42.3 mm	4.00 mm	128 mm	0-120 °	3777014
1 1/2"	48.0 mm	4.25 mm	148 mm	0-120 °	3777015
2"	60.0 mm	4.50 mm	187 mm	0-120 °	3777016

Mobile universal bending machine

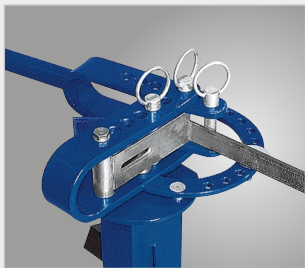
UB 10 – Universal bending machine for angled, round and helical bending of flat and square materials



- Hardened hinges and bearings
- Bending angle stop



- Angle for bending sharp edges in flat materials
- 4 positioning bolts hold the workpiece



- Application flat materials: acute bending



- Two sets of tempered bending rollers in scope of delivery



- Plate rolling in flat materials

- ▶ Cold bending up to an angle of 180°
- ▶ Adjustable bending angle stop for a high level of repetition accuracy
- ▶ Also for helical bending with the UB 11 option
- ▶ With bolt-on base for the workshop

- ▶ Easily transportable, and thus ideal for workshop, on site and in the service vehicle
- ▶ Removable bending unit with optional clamping plate can also be deployed on a vice

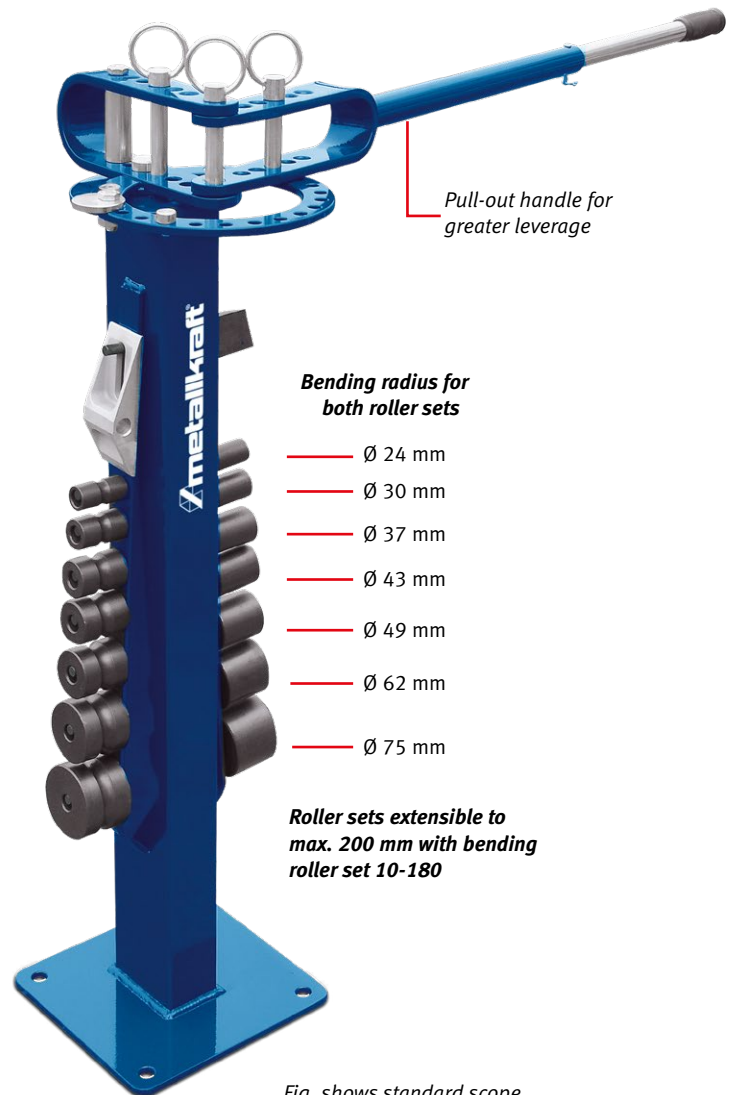
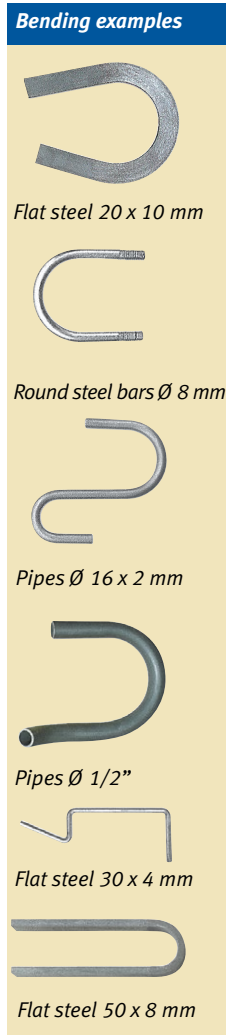


Fig. shows standard scope of delivery

Model	UB 10	
Art. no.	3776010	
Technical data		
Max. bending dimension		
Flat steel: plate rolling	10 x 50 mm	
Flat steel: acute bending	6 x 50 mm	
Weight	32 kg	
Material	Steel/Aluminium/Copper	stainless steel
Round materials	Ø 16 mm	Ø 14 mm
Square materials	16 x 16 mm*	14 x 14 mm*
Pipes	T 3/4"	

* Bending elements optionally available

Scope of supply:

- › Bending rollers: 2 x Ø 24/30/37/43/49/62/75 mm

Optional accessories UB 10

Model Art. no.
Heating pipe bending roller set 3790001

- For cold bending of heating pipes of sizes G3/8", G1/2", G3/4".
- Set consists of 2 items per size.
- Weight 15 kg

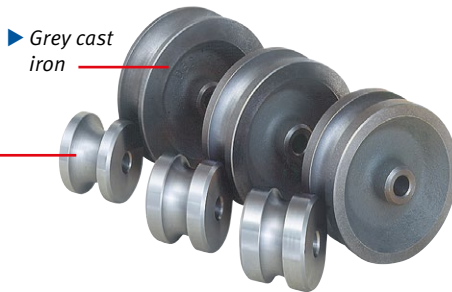
Inner diameter for bend

- G 3/8" 102 mm
- G 1/2" 108 mm
- G 3/4" 112 mm

► Grey cast iron

► Galvanised steel

Bending rollers specially for pipes



Bending roller set 10-180 3790002

- For bending strip steel up to 50 mm width and 7 mm thickness and square materials up to 16 x 16 mm
- Ideal for smithing work
- Set consists of 8 bending rollers
- Extends the bending capacity to Ø 110, 150, 175, 200 mm
- Weight 33 kg



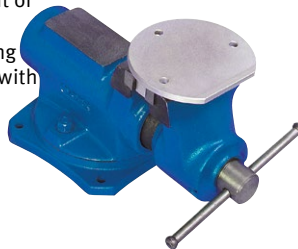
Adjustable stop 10-200 3790003

- Universal, adjustable stop
- For small batch work



Clamping plate 3790004

- For mounting the non-mounted bending unit of the UB 10 on a commercially available vice
- As a simple solution on site, without needing to dismantle the base of the UB 10 and take it with you
- Also usable for RB 30
- Weight 1.5 kg
- Supplied without vice



Conversion kit for UB 10 to RB 30 3790006

- For bending thin-walled pipes
- With bending elements, angle element and guides
- Installation through replacing the bending elements
- Bending elements 6 pcs. : Ø 14, 16, 18, 20, 22, 25 mm
- Weight: 31 kg



Accessories/bending segments from page 95 usable

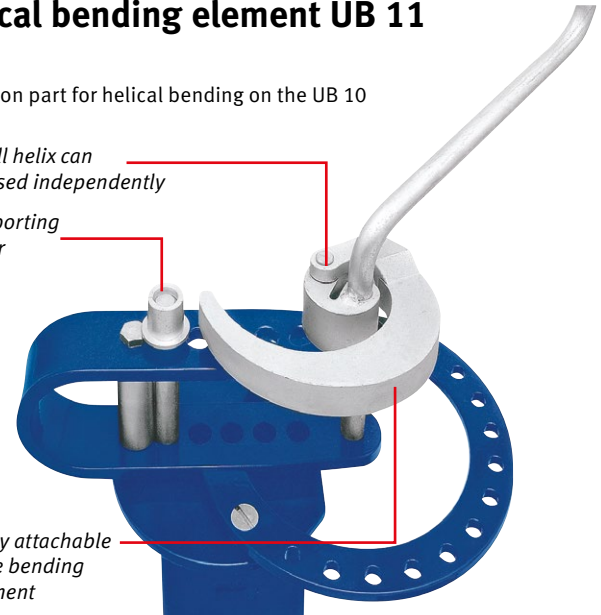
Helical bending element UB 11

- Add-on part for helical bending on the UB 10

- Small helix can be used independently

- Supporting roller

- Easily attachable large bending segment



Bending examples



Large helixes

Small helixes

Model Helical bending element UB 11
Art. no. 3790011

Technical data

Max. material thicknesses

Square	5 x 5 mm
Flat materials	5 x 25 mm
Round materials	Ø 5 mm
Weight	3 kg

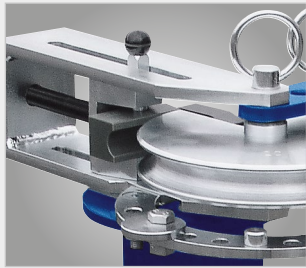
Separate holding handle for helical bending element UB 11 allows operation of the UB 11 also without the UB 10 on a commercially available vice



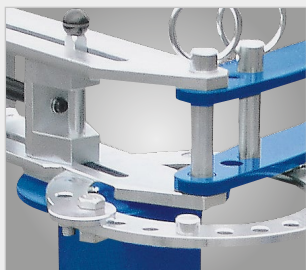
Fig. shows the scope of delivery UB10-280

Model UB 10-280
Art. no. 3790280

Mobile pipe bending machines



- ▶ A special coating on the guide prevents damage to the pipes
- ▶ Fastening screw



- ▶ Bending angle stop for a high level of repetition accuracy
- ▶ Tempered bearings



- ▶ Tempered bolts



- ▶ Space-saving and tidy storage of the bending segments on the base



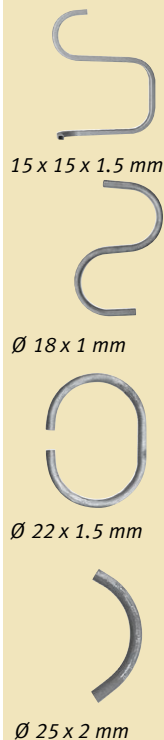
- ▶ Example of combined bending

RB 30 – Pipe bender for cold bending of thin-walled pipes made of brass, copper, steel and other materials

- ▶ Easy cold bending of thin-walled pipes without support elements
- ▶ For bending simple and complex shapes
- ▶ Pull-out handle for greater leverage
- ▶ Easily transportable, ideal for workshop, on site and in the service vehicle
- ▶ Removable bending unit with optional clamping plate can also be deployed on a vice
- ▶ With bolt-on base for the workshop
- ▶ More bending segments



Bending examples



Bending radius standard segments

Size	Radius
Ø14	56 mm
Ø16	64 mm
Ø18	72 mm
Ø20	80 mm
Ø22	88 mm
Ø25	100 mm

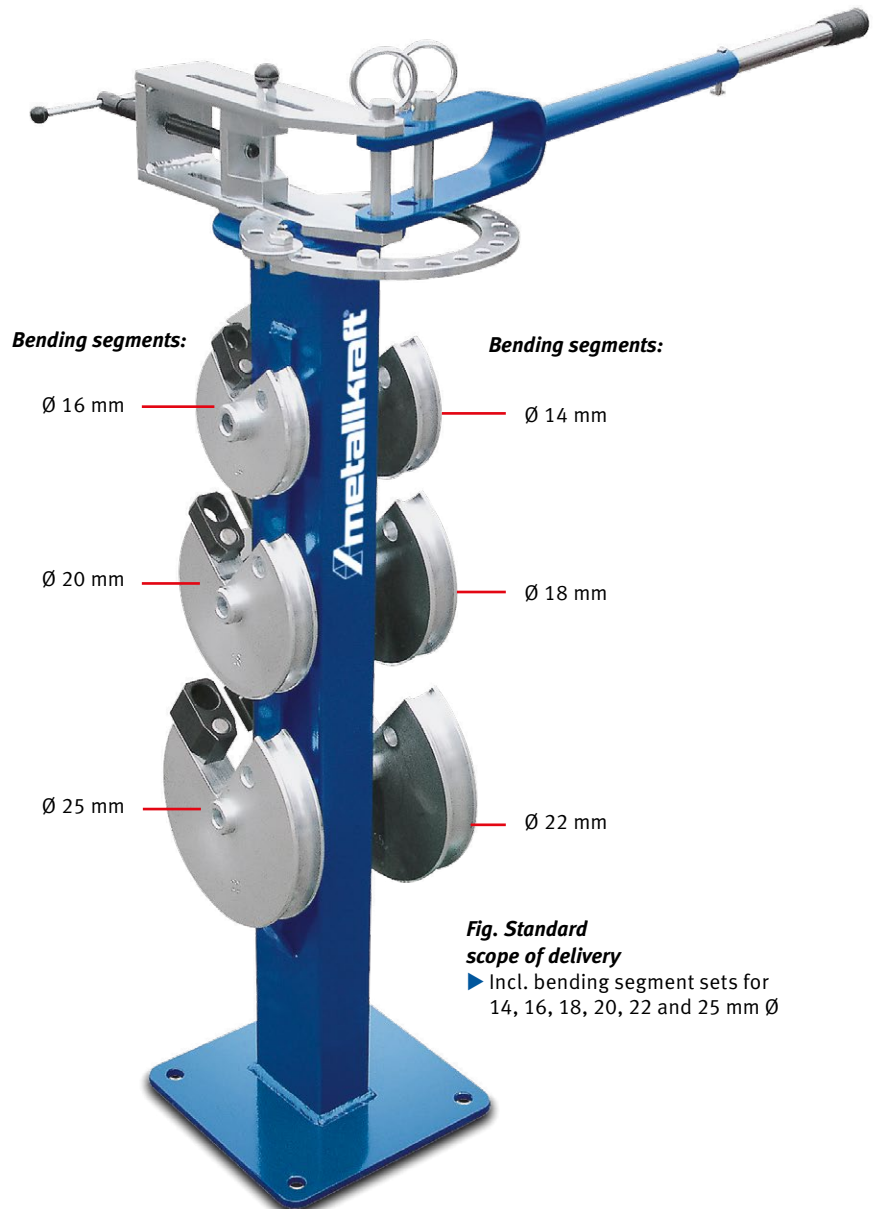


Fig. Standard scope of delivery

- ▶ Incl. bending segment sets for 14, 16, 18, 20, 22 and 25 mm Ø

Model	RB 30		
Art. no.	3776030		
Technical data			
Bending radius standard	4 x Ø of pipe, 56 - 100 mm		
max. wall thickness (Ø 25 mm)	2 mm		
Material	Steel/Aluminium/Copper	stainless steel	
Round materials	Ø 25 x 2 mm	Ø 22 x 2 mm	
Square materials	20 x 20 x 2 mm		

* Bending elements optionally available

Accessories/bending segments from page 95 usable

Scope of supply:

- › Bending segments 6 pcs.: Ø 14, 16, 18, 20, 22, 25 mm

Additional bending segments

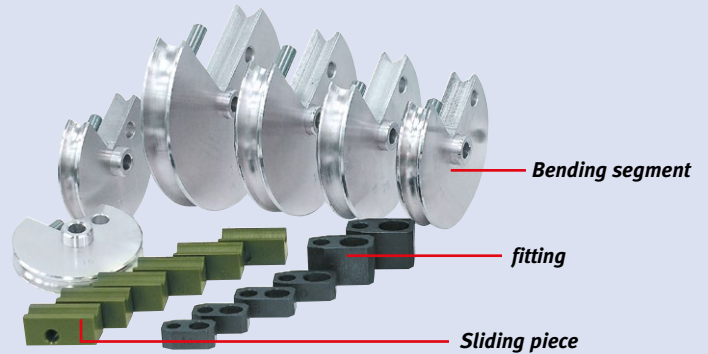
Accessories - bending segment sets (with sliding piece and holder)

Designation	Diameter	Radius	Art. no.
Set Ø 6 R40	6 mm	40 mm	3790105
Set Ø 8 R42	8 mm	42 mm	3790020
Set Ø 10 R42	10 mm	42 mm	3790021
Set Ø 12 R45	12 mm	45 mm	3790022
Set Ø 14 R42	14 mm	42 mm	3790023
Set Ø 14 R56	14 mm	56 mm	3790024
Set Ø 15 R45	15 mm	45 mm	3790025
Set Ø 16 R40	16 mm	40 mm	3790026
Set Ø 16 R48	16 mm	48 mm	3790027
Set Ø 16 R64	16 mm	64 mm	3790028
Set Ø 18 R45	18 mm	45 mm	3790029
Set Ø 18 R54	18 mm	54 mm	3790030
Set Ø 18 R72	18 mm	72 mm	3790031
Set Ø 20 R50	20 mm	50 mm	3790032
Set Ø 20 R60	20 mm	60 mm	3790033
Set Ø 20 R80	20 mm	80 mm	3790034
Set Ø 22 R55	22 mm	55 mm	3790035
Set Ø 22 R66	22 mm	66 mm	3790036
Set Ø 22 R88	22 mm	88 mm	3790037
Set Ø 25 R62.5	25 mm	62.5 mm	3790038
Set Ø 25 R75	25 mm	75 mm	3790039
Set Ø 25 R100	25 mm	100 mm	3790040
Dimensions			
Square set 15x15 R45	15 x 15 mm	45 mm	3790041
Square set 20x20 R60	20 x 20 mm	60 mm	3790042

Accessories - bending segment

for RB 30, UB 10 and ERB 60 (bending segment only)

Designation	Diameter	Radius	Art. no.
Segment Ø14 R42	14 mm	42 mm	3790043
Segment Ø16 R40	16 mm	40 mm	3790044
Segment Ø16 R48	16 mm	48 mm	3790045
Segment Ø18 R45	18 mm	45 mm	3790046
Segment Ø18 R54	18 mm	54 mm	3790047
Segment Ø20 R50	20 mm	50 mm	3790048
Segment Ø20 R60	20 mm	60 mm	3790049
Segment Ø22 R55	22 mm	55 mm	3790050
Segment Ø22 R66	22 mm	66 mm	3790051
Segment Ø25 R62.5	25 mm	62.5 mm	3790052
Segment Ø25 R75	25 mm	75 mm	3790053



Extension plate RB 30

- Offsets the bending axis to outside the base
- Allows for bending of long workpieces



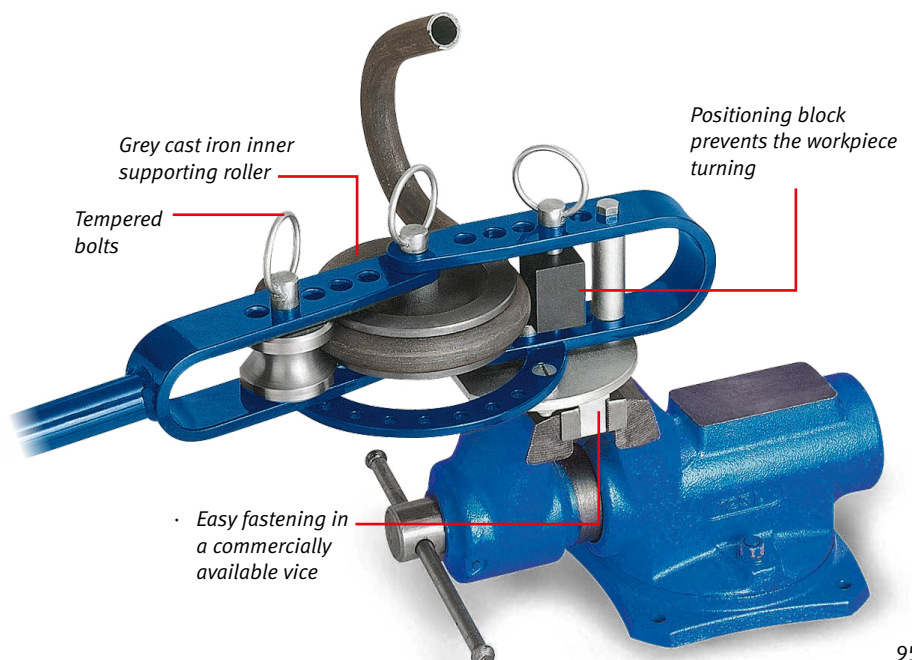
Model	Extension plate RB 30
Art. no.	3790005

Bending unit RB 12 for heating pipes and water pipes up to G3/4"

- Ideal for on the road
- Easy assembly on a commercially available vice
- Cold bending up to an angle of 180°
- Partial bending supported
- Adjustable bending angle stop for a high level of repetition accuracy
- Easy to use

Model	RB 12
Art. no.	3776012

Technical data	
Inner diameter for bend G 3/8"	102 mm
Inner diameter for bend G 1/2"	108 mm
Inner diameter for bend G 3/4"	112 mm
Weight	22 kg



Hydraulic horizontal bending press

New

HBP series – Hydraulic, universally deployable horizontal bending presses with NC control for immersion depth

- ▶ For precise bending of tubular and solid material
- ▶ Durable design of the tools and tool guides in premium, tempered steel
- ▶ Manual operation via two foot pedals for forward and reverse
- ▶ Automatic operation by programming the front and rear positioning endpoints
- ▶ Easy die change thanks to quick release mount
- ▶ Foot pedal with digital display and emergency stop switch

Scope of delivery HBP 10:

- › Bending die 68°;
- Height = 200 mm; R = 5 mm
- › Quick change die 60°; Height = 150 mm; V = 60 mm
- › Foot pedal with digital display
- › Lateral stop 300 mm

Scope of delivery HBP 20:

- › Bending die 68°;
- Height = 200 mm; R = 5 mm
- › Quick change die 60°; Height = 150 mm; V = 60 mm
- › Foot pedal with digital display
- › Lateral stop 300 mm

Scope of delivery HBP 30:

- › Bending die 68°;
- Height = 250 mm; R = 5 mm
- › Quick change die 60°; Height = 250 mm; V = 60 mm
- › Foot pedal with digital display
- › Lateral stop 300 mm

Scope of delivery HBP 40:

- › Bending die 60°;
- Height = 150 mm; R = 6 mm
- › Quick change die 60°; Height = 150 mm; V = 60 mm
- › Foot pedal with digital display
- › Lateral stop 300 mm

Scope of delivery HBP 50:

- › Bending die 68°;
- Height = 300 mm; R = 5 mm
- › Quick change die 60°; Height = 300 mm; V = 60 mm
- › Foot pedal with digital display
- › Lateral stop 300 mm



▶ Control panel with digital display and EMERGENCY STOP switch



HBP 20

- ▶ Robust machine design
- ▶ Manual and automatic mode selectable
- ▶ Easy tool changing thanks to quick release system

Model	HBP 10	HBP 20	HBP 30	HBP 40	HBP 50
Art. no.	3812510	3812520	3812530	3812540	3812550

Technical data	HBP 10	HBP 20	HBP 30	HBP 40	HBP 50
Max. press force	10 t	20 t	30 t	40 t	50 t
Oil tank capacity	12 l	12 l	40 l	40 l	60 l
Bending performance flat material	150 x 8 mm	200 x 12 mm	250 x 18 mm	250 x 24 mm	300 x 15 mm
Bending performance tubular material	42 x 3.2 mm	48 x 4.0 mm	60 x 4.0 mm	60 x 5.0 mm	76 x 4.0 mm
Max. stroke	185 mm	185 mm	285 mm	285 mm	285 mm
Bolt diameter	60 mm	80 mm	80 mm	80 mm	90 mm
Tool height	150 mm	200 mm	250 mm	250 mm	300 mm
Working speed	10 mm/s	10 mm/s	10 mm/s	10 mm/s	10 mm/s
Return speed	10 mm/s	10 mm/s	10 mm/s	10 mm/s	10 mm/s
Table length	450 mm	480 mm	660 mm	660 mm	600 mm
Table width	900 mm	1060 mm	1250 mm	1250 mm	1250 mm
Working height	915 mm	930 mm	930 mm	930 mm	930 mm
Motor output	1.1 kW	2.2 kW	3 kW	4 kW	7.5 kW
Length	900 mm	1150 mm	1250 mm	1250 mm	1400 mm
Width/depth	450 mm	480 mm	650 mm	650 mm	600 mm
height	1130 mm	1200 mm	1250 mm	1250 mm	1500 mm
weight	250 kg	530 kg	1050 kg	1050 kg	1450 kg

New



► With quick release mount and side stop with scale



► Hydraulic pressure adjustable

Pipe bending tools to match all HBP models

	Art. no.
Bending frame and counterholder for pipe bending tools	3888060
Grey cast bending segment 3/8"	3888061
Grey cast bending segment 1/2"	3888062
Grey cast bending segment 3/4"	3888063
Grey cast bending segment 1"	3888064
Grey cast bending segment 1 1/4"	3888065
Grey cast bending segment 1 1/2"	3888066
Grey cast bending segment 2"	3888067

Tempered and polished bending tools (for HBP 10)

Die 85°, H = 150 mm, R = 1 mm	3888101
Die 85°, H = 150 mm, R = 5 mm	3888102
Die 85°, H = 150 mm, R = 10 mm	3888103
Die 30°, H = 150 mm, R = 5 mm	3888104
Bending mandrel 25 x 25 mm - load bearing capacity 6 t/m	3888105
Bending mandrel 30 x 30 mm - load bearing capacity 10 t/m	3888106
Bending mandrel 40 x 40 mm - load bearing capacity 25 t/m	3888107
Quick change multiple die 85°, H = 150 mm	3888120
V = 16/22/35/50 mm, max. material thickness 4 mm	
Quick change mono die 85°, H = 150, V = 63 mm	3888121
Quick change mono die 85°, H = 150, V = 80 mm	3888122
Quick change mono die 85°, H = 150, V = 100 mm	3888123
Quick change mono die 85°, H = 150, V = 125 mm	3888124
Quick change mono die 85°, H = 150, V = 160 mm	3888125
Quick change mono die 45°, H = 150, V = 50 mm	3888126

Bending tool for flat material (for HBP 10)

Bending frame and counterholder	3888150
Bending tool for flat material incl. pins and washers for material 4/6/8 mm	3888151

Straightening tools (for HBP 10)

Straightening beam approx. 800 mm with counterbearing and straightening die	3888155
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Tempered and polished bending tools (for HBP 20)

Die 85°, H = 200 mm, R = 1 mm	3888201
Die 85°, H = 200 mm, R = 5 mm	3888202
Die 85°, H = 200 mm, R = 10 mm	3888203
Die 30°, H = 200 mm, R = 5 mm	3888204
Bending mandrel 25 x 25 mm - load bearing capacity 6 t/m	3888205
Bending mandrel 30 x 30 mm - load bearing capacity 10 t/m	3888206
Bending mandrel 40 x 40 mm - load bearing capacity 25 t/m	3888207
Quick change multiple die 85°, H = 200 mm	3888220
V = 16/22/35/50 mm, max. material thickness 4 mm	
Quick change mono die 85°, H = 200, V = 63 mm	3888221
Quick change mono die 85°, H = 200, V = 80 mm	3888222
Quick change mono die 85°, H = 200, V = 100 mm	3888223
Quick change mono die 85°, H = 200, V = 125 mm	3888224
Quick change mono die 85°, H = 200, V = 160 mm	3888225
Quick change mono die 45°, H = 200, V = 50 mm	3888226

Bending tool for flat material (for HBP 20)

Bending frame and counterholder	3888250
Bending tool for flat material incl. pins and washers for material 4/6/8 mm	3888251

Straightening tools (for HBP 20)

Straightening beam approx. 800 mm with counterbearing and straightening die	3888255
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Tempered and polished bending tools (for HBP 30/40)

	Art. no.
Die 85°, H = 250 mm, R = 1 mm	3888301
Die 85°, H = 250 mm, R = 5 mm	3888302
Die 85°, H = 250 mm, R = 10 mm	3888303
Die 30°, H = 250 mm, R = 5 mm	3888304
Bending mandrel 25 x 25 mm - load bearing capacity 6 t/m	3888305
Bending mandrel 30 x 30 mm - load bearing capacity 10 t/m	3888306
Bending mandrel 40 x 40 mm - load bearing capacity 25 t/m	3888307
Bending mandrel 50 x 50 mm - load bearing capacity 45 t/m	3888308
Quick change multiple die 85°, H = 250 mm	3888320
V = 16/22/35/50 mm, max. material thickness 4 mm	
Quick change mono die 85°, H = 250, V = 63 mm	3888321
Quick change mono die 85°, H = 250, V = 80 mm	3888322
Quick change mono die 85°, H = 250, V = 100 mm	3888323
Quick change mono die 85°, H = 250, V = 125 mm	3888324
Quick change mono die 85°, H = 250, V = 160 mm	3888325
Quick change mono die 45°, H = 250, V = 50 mm	3888326

Bending tool for flat material (for HBP 30/HBP 40)

Bending frame and counterholder	3888350
Bending tool for flat material incl. pins and washers for material 4/6/8 mm	3888351

Straightening tools (for HBP 30/HBP 40)

Straightening beam approx. 800 mm with counterbearing and straightening die	3888355
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Tempered and polished bending tools (for HBP 50)

Die 85°, H = 300 mm, R = 1 mm	3888501
Die 85°, H = 300 mm, R = 5 mm	3888502
Die 85°, H = 300 mm, R = 10 mm	3888503
Die 30°, H = 300 mm, R = 5 mm	3888504
Bending mandrel 25 x 25 mm - load bearing capacity 6 t/m	3888505
Bending mandrel 30 x 30 mm - load bearing capacity 10 t/m	3888506
Bending mandrel 40 x 40 mm - load bearing capacity 25 t/m	3888507
Bending mandrel 50 x 50 mm - load bearing capacity 45 t/m	3888508
Bending mandrel 60 x 60 mm - load bearing capacity 80 t/m	3888509
Quick change multiple die 85°, H = 300 mm	3888520
V = 16/22/35/50 mm, max. material thickness 4 mm	
Quick change mono die 85°, H = 300, V = 63 mm	3888521
Quick change mono die 85°, H = 300, V = 80 mm	3888522
Quick change mono die 85°, H = 300, V = 100 mm	3888523
Quick change mono die 85°, H = 300, V = 125 mm	3888524
Quick change mono die 85°, H = 300, V = 160 mm	3888525
Quick change mono die 45°, H = 300, V = 50 mm	3888526

Bending tool for flat material (for HBP 50)

Bending frame and counterholder	3888550
Bending tool for flat material incl. pins and washers for material 4/6/8 mm	3888551

Straightening tools (for HBP 50)

Straightening beam approx. 800 mm with counterbearing and straightening die	3888555
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Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Metal-cutting band saws

Pipe bending machines without mandrels

New

RB series – NC-controlled device with large program memory

- ▶ NC control for adjusting the bending angle
- ▶ Premium, rugged design
- ▶ Up to 50 program memory slots
- ▶ Fast tool change
- ▶ Motorised drive only
- ▶ Automatically moves to starting position



Fig. shows RB 42 with optional chassis

Model	RB 42	RB 54
Art. no.	4300042	4300054
Technical data		
Bending performance tubular material 420 N/mm ²	Ø 42 x 3 mm	Ø 54 x 4 mm
Bending performance tubular material 350 N/mm ²	Ø 42 x 3 mm	Ø 54 x 4 mm
Bending performance tubular material 650 N/mm ²	Ø 30 x 2 mm	Ø 42 x 3 mm
Max. bending radius	100 mm	125 mm
Max. bending angle	180°	180°
Bending speeds	2 rpm	2 rpm
Torque	2341 Nm	2341 Nm
Main motor	0.55 kW	1.1 kW
Electrical connection	400 V/40 Hz	400 V/40 Hz
Dimensions (L x W x H)	600 x 180 x 450 mm	600 x 220 x 470 mm
Weight	94 kg	107 kg

New



Fig. shows RB 54 with optional chassis

Accessories	RB 42	RB 54	Art. no.
Chassis	X	X	4310000
Bending segments consisting of:	RB 42	RB 54	Art. no.
1 bending segment, 2 counter rollers and 1 ring			
Bending segment 1/4" G (13.72 mm)	X	X	4310005
Bending segment 1/2" G (21.3 mm)	X	X	4310006
Bending segment 3/4" G (26.9 mm)	X	X	4310007
Bending segment 1" W (25.4 mm)	X	X	4310008
Bending segment 1" G (33.7 mm)	X	X	4310009
Bending segment 1 1/4" W (31.8 mm)	X	X	4310010
Bending segment 1 1/2" W (38.1 mm)		X	4310015
Bending segment 1 1/2" W (38.1 mm)		X	4310016
Bending segment 2" W (50.8 mm)		X	4310017
Sliding shoes	RB 42	RB 54	Art. no.
1/2" G (Ø21.7 mm) x 3/8" G (Ø17.3 mm)	X	X	4310050
1/4" G (Ø13.8 mm) x 1/8" G (Ø10.5 mm)	X	X	4310051
1" G (Ø34 mm) x 3/4" G (Ø27.2 mm)	X	X	4310052
1" W (Ø35.4 mm) x 1 1/4" W (Ø31.8 mm)	X	X	4310053
1 1/4" W (Ø31.8 mm) x 1 1/2" W (Ø 38.1mm)	X	X	4310054
1 1/4" G (Ø42.25 mm)		X	4310055
1 1/2" W (Ø38.1 mm) x 2" W (Ø50.8 mm)		X	4310056

Pipe bending machines without mandrels

BM series – Pipe bending machines without mandrels made by



- ▶ High-quality, compact and very durable design
- ▶ NC control to adjust bending angles and correction
- ▶ Standard control **SIMPLY**: Enter an angle and a correction value (standard with BM 34-S, BM 42-SP, BM 42-SA, BM 48-S, BM 60-S, BM 76-S)
- ▶ Optional control **EXPERT**: supports entry of bending sequences and storing programs (standard with BM 100-E, BM 125-E, BM 150-E, BM 200-E)
- ▶ High torque thanks to powerful motor with inverter and reduction gear
- ▶ Smart tooling system supporting left and right bending with the same tool – **PATENTED!**
- ▶ Easy removal of bent pipes from the sliding block using innovative spring system – **PATENTED!**
- ▶ Cost-effective wear parts
- ▶ Very short, straight pipe end thanks to optimised tool geometry
- ▶ Change the attachment shaft to use bending tools made by other machine manufacturers.
- ▶ Lower head bending (suitable for BM 42-SP, 42-SA, 48-S, 60-S and 76-S models)
- ▶ Two bending speeds, can be selected using a rotary switch
- ▶ Manually pipe clamping with hand wheel, with counter to ensure high degree of reproducibility
- ▶ Mobile, manual control panel optionally available
- ▶ Low-noise, clean, and temperature-independent work thanks to motorised only drive

- ▶ **Patented tool system**
- ▶ **Lower head bending**
- ▶ **Bending in anti-clockwise/clockwise direction using the same tool kit**
- ▶ **Fully driven by the motor – no hydraulics**



SIMPLY/EXPERT control



BM 34-S



BM 42-SP



BM 42-SA



BM 48-S

Model		BM 34-S	BM 42-SP	BM 42-SA	BM 48-S	BM 60-S	BM 76-S	BM 100-E	BM 125-E	BM 150-E	BM 200-E
Art. no.		3960032	3960042	3960043	3960048	3960060	3960076	3961100	3961125	3961150	3961200
Technical data											
Bending performance											
Ø x wall thickness (420N/mm ²)	mm	33.4 x 3.4	42 x 3	42 x 3	48 x 3.5	60 x 4	76 x 3	101.6 x 5.74	114.3 x 8.56	141.3 x 9.52	168.3 x 10.97
Ø x wall thickness (350N/mm ²)	mm	38 x 2	48 x 1.5	48 x 1.5	48 x 4	64 x 5	70 x 5	114.3 x 4.78	141.3 x 6.55	168.3 x 7.11	219.1 x 6.35
Ø x wall thickness (650N/mm ²)	mm	33.4 x 1.5	42 x 1.5	42 x 1.5	48 x 2	64 x 3	70 x 4	88.9 x 4.78	114.3 x 4.78	141.3 x 6.55	168.3 x 7.11
Ø solid material (420N/mm ²)	mm	22	30	30	34	42	46				100
Max. bending radius	mm	170	260	260	260	380	380	600	700	850	1.100
Max. bending angle	°	180	180	180	180	180	180	180	180	180	180
Bending speeds	rpm	2 and 3	2 and 3	2 and 3	2 and 3	1 and 2	1 and 2	1 and 2	0,98	1	0,8
Torque	Nm	914	1800	1800	2400	8000	10.000	22.000	37.000	70.000	115.000
Bending head projection (C x T)	mm	-	240 x 245	620 x 310	620 x 310	515 x 364	464 x 390	-	-	-	-
Bending head height (A)	mm	-	188	188	188	268	315	-	-	-	-
Type		Portable				Stationary					
Motor output	kW	0,55	0,75	0,75	1,1	1,5	1,8	3	4	7,5	11
Electrical connection	V/Hz	400/50	400/50	400/50	400/50	400/50	400/50	400/50	400/50	400/50	400/50
Weight (approx.)	kg	33	90	110	110	210	306	900	1.200	1.500	2.200
Dimensions											
Length (L)	mm	478	655	700	700	1.000	1.000	800	800	1.000	1.850
Width (B)	mm	268	347	440	440	680	680	1.100	1.200	1.200	1.200
Height (H)	mm	310	550	970	970	1.100	1.100	1.300	1.400	1.600	1.350
options											
Positioning unit 3 m or 6 m		-	-	0	0	0	0	0	0	0	0
Motor-driven deburring unit		-	-	-	0	0	0	-	-	-	-
Expert controls		-	-	0	0	0	0	-	-	-	-

*Please turn over for descriptions of transport surcharges

Custom accessories

- ▶ Positioning units for 3000 mm or 6000 mm with continuously adjustable stop cams and scale to set the longitudinal position
- ▶ Three jaw chuck with stop cams and angle scale
- ▶ To adjust rotations (available for BM 42-SA, 48-S, 60-S, 76-S 110-S, 140-S and 200-E models)
- ▶ Motorised deburring tool (available for BM 48-S, 60-S, 76-S, 100-E, 125E, 150-E und 200-E models)
- ▶ Tool sets for G pipes, OD inch pipes, individual, metric dimensions as well as profiles and flat steel
- ▶ "Expert control" for entering bending sequences and saving programs



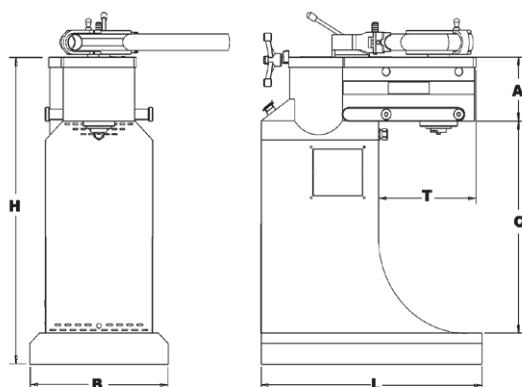
BM 60-S



BM 76-S



BM 200-E



Accessories

	Art. no.
3m positioning units for BM 42/BM 48	3973001
3m positioning units for BM 60/BM 76	3973002
6m positioning units for BM 42/BM 48	3976001
6m positioning units for BM 60/BM 76	3976002
Motor-driven deburring tool for BM 42 SA, 48 and 60*	3970105
Expert controls*	3970100
Attachment for tools of other manufacturers	On request

*Ex works only



Patented sliding block



Anti-clockwise bending



Clockwise bending



Lower head bending



Positioning unit



Holding fixtures for third party tools possible



Motorised deburring tool

Consultancy by Metallkraft

We are always happy to advise you in case of queries. Our product advisors are happy to support you with technical information. Our customers can use our telephone hotline and our info mail address to request qualified information and solutions.

Contact:
Phone: +49 (0)951 96555-171
email: beratung@metallkraft.de



Commissioning & 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	EINWCNOMET
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:**
- Setting up 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.

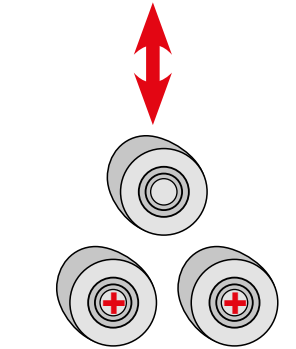
This also applies for any different or additional services, which must be ordered separately on site and will be invoiced on individual basis.

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.

PRM 10 – Manual or motorised ring bending machines, horizontally and vertically deployable for sections, pipes and solid materials

- ▶ For plate rolling of square materials
- ▶ Stable, design suitable for floor anchoring
- ▶ Two bottom rollers driven by crank

- ▶ Rollers tempered and polished
- ▶ Tempered and polished steel shafts
- ▶ Feed via top roller



PRM 10 M

Scope of supply:

- › Standard bending rollers (see table on right)
- › Mobile foot pedal for clockwise/anti-clockwise operation with emergency off function (PRM 10 E)
- › Straightening rollers
- › Chassis

Model	PRM 10 M	PRM 10 E
Art. no.	3780010	3780011

Technical data

Shaft Ø	30 mm	30 mm
Roller Ø at the top	98 mm	98 mm
Roller Ø at the bottom	118 mm	118 mm
Speed	-	2.5 m/min
Motor output	-	1.1 kW
Electrical connection	-	400 V/50 Hz
Weight	165 kg	230 kg
Dimensions L x W x H	620 x 560 x 1440 mm	700 x 700 x 1400 mm



PRM 10 E



PRM 10 E

Horizontal and vertical working position

PRM 10 E

- ▶ Motorised version
- ▶ Horizontal and vertical working positions
- ▶ Powerful 400-volt motor
- ▶ Clockwise/anti-clockwise operation using foot pedal

Bending performance

PRM 10

Section type	Max. Size mm	Min. bending Ø mm
Bending options with standard bending rollers:		
	20 x 20 10 x 10	500 160
	30 x 10 20 x 5	500 190
	50 x 10 40 x 5	400 160
	35 x 4.5 30 x 4	600 400
	35 x 4.5 30 x 4	600 400
	35 x 4.5 30 x 4	600 400

Bending performance

PRM 10

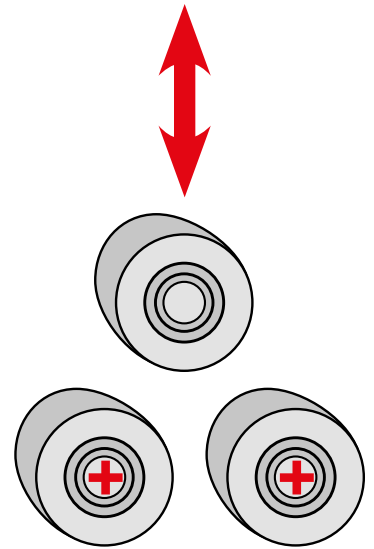
Section type	Max. Size mm	Min. bending Ø mm
Bending options with optional bending rollers:		
	U40x20 U30	700 500
	30 x 30 x 2 20 x 20 x 2	900 600
	38 x 20 x 2 30 x 15 x 1.5	1000 600
	Ø 27 Ø 17	500 160
	Ø 1" x 2 Ø 3/4" x 1.5	800 400
	Ø 33 x 3 Ø 26 x 2.5	700 500
	35 x 35 x 4 30 x 30 x 4	800 400
	35 x 35 x 4 30 x 30 x 4	800 400

Performance data are based on material with a max. yield strength of 24 kg/mm². Bending performance for stainless steel (VA): factor 0.7
*May require additional spacers

Ring bending machine

PRM 31 F – motorised ring bending machine, suitable for horizontal and vertical applications on sections, pipes and solid materials

- ▶ Heavy-duty welded structure made of steel
- ▶ Horizontal and vertical working positions
- ▶ Bottom rollers driven directly by the motor
- ▶ Tempered rollers
- ▶ Shafts made of special steel, hardened and polished
- ▶ Feed via top roller
- ▶ Continuously adjustable, lateral guide rollers
- ▶ Clockwise/anti-clockwise operation using foot pedal
- ▶ Mobile control panel with foot controls



Model	PRM 31 F
Art. no.	3812031

Technical data	
Shaft Ø	30 mm
Roller Ø at the top	148 mm
Roller Ø at the bottom	118 mm
Speed	4 m/min
Motor output	0.75kW
Electrical connection	400 V/50 Hz
Weight	220 kg
Dimensions L x W x H	600 x 800 x 1450 mm

Scope of supply:

- › Standard bending rollers (refer to table on the right for bending options)
- › Mobile foot pedal for clockwise/anti-clockwise operation with emergency off function
- › Straightening rollers
- › Chassis

Custom accessories

Digital indicator for adjustment roller

- › Pipe bending rollers
- › Angle bending rollers
- › Special alignment rollers
- › Section bending rollers
- › Plastic rollers for soft materials
- › Equipment to twist rods
- › Spiral bending tool

PRM 31 F		
Bending performance		
Section type	Max. Size mm	Min. bending Ø mm
Bending option with standard bending rollers:		
	30 x 30 10 x 10	900 200
	50 x 10 20 x 6	800 300
	80 x 15 30 x 6	700 400
	50 x 6 20 x 3	600 400
	50 x 6 20 x 3	600 400

PRM 31 F		
Bending performance		
Section type	Max. Size mm	Min. bending Ø mm
Bending options with optional bending rollers:		
	40 x 3 30 x 2	1200 800
	50 x 30 x 3 40 x 20 x 2	1200 800
	Ø30 Ø10	900 200
	1 1/4" x 2.9 1/4" x 1.8	600 300
	Ø60x1.5 Ø25x1.5	1000 600
	40 x 40 x 5 30 x 30 x 4	600 300
	35 x 35 x 5 30 x 30 x 4	600 300

Performance data are based on material with a max. yield strength of 24 kg/mm². Bending performance for stainless steel (VA): factor 0.7 *May require additional spacers



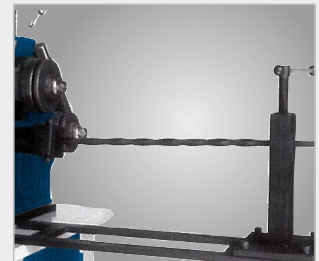
Note

- The machine can be **optionally** equipped with bending rollers to suit your specific requirements
- We can also supply non-standard sizes on request

Accessories	Art. no.
Digital indicator for adjustment roller	3880075
Special guide rollers at the sides, for angle section	3880076
Bending tool to process bars	3880151
Spiral bending tool	3880152
Bending rollers* (please note information below!)	
Steel/iron rollers	
0 - 33.7 mm	3880077
34 - 48.3 mm	3880078
Custom dimensions	

Accessories	Art. no.
Angle rollers made of steel/iron	
30 x 30 x 3 mm	3880080
40 x 40 x 5 mm	3880081
Custom dimensions	
Plastic rollers for aluminium and stainless steel	
0 - 33.7 mm	3880082
34 - 48.3 mm	3880083
49 - 60.3 mm	3880084
Custom dimensions	
Plastic angle rollers for aluminium and stainless steel	
30 x 30 x 3 mm	3880085
40 x 40 x 5 mm	3880086
Custom dimensions	

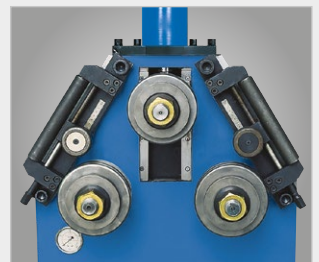
* Price/roller set relates to a dimension from this mm range; state the material dimension you would like to process in your order. Rollers are produced as per these dimensions.



► Optional bending tool to process items including decorative, wrought-iron rods (Fig. similar item)



► Spiral bending application with optional bending tool



► Option: special guide rollers on the sides, for angle sections

Please state the material type you would like to process in your order!

Ring bending machine

PRM 35 F – motorised ring bending machine, suitable for horizontal and vertical applications on sections, pipes and solid materials

- ▶ Heavy-duty welded structure made of steel
- ▶ Horizontal and vertical working positions
- ▶ Motorised bottom rollers
- ▶ Tempered rollers
- ▶ Tempered and polished steel shafts
- ▶ Feed via top roller
- ▶ Continuously adjustable, lateral guide rollers
- ▶ Clockwise/anti-clockwise operation using foot pedal



Model	PRM 35 F
Art. no.	3812035

Technical data	
Shaft Ø	50 mm
Roller Ø at the top	155 mm
Roller Ø at the bottom	155 mm
Speed	4.5 m/min
Motor output	1.5 kW
Electrical connection	400 V/50 Hz
Weight	400 kg
Dimensions in mm	750 x 1000 x 1400

Scope of supply:

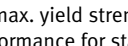
- › Standard bending rollers (refer to table on the right for bending options)
- › Mobile foot pedal for clockwise/anti-clockwise operation with emergency off function
- › Straightening rollers
- › Chassis

Custom accessories

Digital indicator for adjustment roller

- › Pipe bending rollers
- › Angle bending rollers
- › Special alignment rollers
- › Section bending rollers
- › Plastic rollers for soft materials
- › Equipment to twist rods
- › Spiral bending tool

PRM 35 F		
Bending performance		
Section type	Max. Size mm	Min. bending Ø mm
Bending option with standard bending rollers:		
	35 x 35 20 x 20	900 300
	60 x 10 40 x 10	500 400
	100 x 15 60 x 10	450 350
	60 x 7 50 x 6	700 500
	60 x 7 50 x 6	700 500
	60 x 7 50 x 6	700 500
	UPN 80* UPN 30*	1000 700
	UPN 80* UPN 30*	1200 800

PRM 35 F		
Bending performance		
Section type	Max. Size mm	Min. bending Ø mm
Bending options with optional bending rollers:		
	50 x 3 40 x 3	1700 600
	70 x 30 x 2 50 x 40 x 3	1200 1200
	Ø35 Ø30	600 400
	2" x 2.9 1" x 2.3	1000 350
	Ø70x2 Ø30x2	1000 500
	50 x 50 x 5 40 x 40 x 5	800 600
	50 x 50 x 6 30 x 30 x 3	1000 500

Performance data are based on material with a max. yield strength of 24 kg/mm². Bending performance for stainless steel (VA): factor 0.7 *May require additional spacers



Note

- ▶ The machine can be **optionally** equipped with bending rollers to suit your specific requirements
- ▶ We can also supply non-standard sizes on request

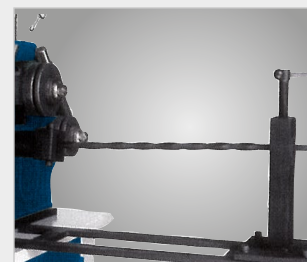


Horizontal and vertical working positions

Accessories	Art. no.
Digital indicator for adjustment roller	3880087
Special guide rollers at the sides, for angle section	3880088
Bending tool to process bars	3880153
Spiral bending tool	3880154
Bending rollers* (please note information below!)	
Steel/iron rollers	
0 - 33.7 mm	3880089
34 - 48.3 mm	3880090
49 - 60.3 mm	3880091
Custom dimensions	

Accessories	Art. no.
Angle rollers made of steel/iron	
30 x 30 x 3 mm	3880092
40 x 40 x 5 mm	3880093
50 x 50 x 6 mm	3880094
Custom dimensions	
Plastic rollers for aluminium and stainless steel	
0 - 33.7 mm	3880095
34 - 48.3 mm	3880096
49 - 60.3 mm	3880097
Custom dimensions	
Plastic angle rollers for aluminium and stainless steel	
30 x 30 x 3 mm	3880098
40 x 40 x 5 mm	3880099
50 x 50 x 6 mm	3880100
Custom dimensions	

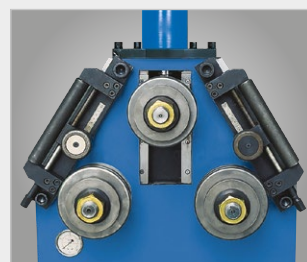
* Price/roller set relates to a dimension from this mm range; state the material dimension you would like to process in your order. Rollers are produced as per these dimensions. **Ex works only



▶ Optional bending tool to process items including decorative, wrought-iron rods (Fig. similar item)



▶ Spiral bending application with optional bending tool



▶ Option: special guide rollers on the sides, for angle sections



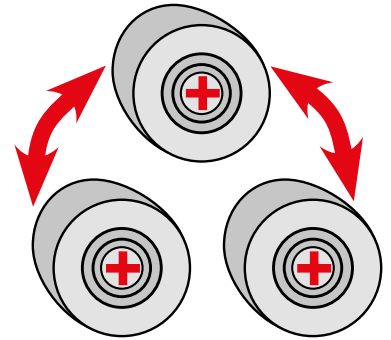
▶ Application ring bending

Please state the material type you would like to process in your order!

Ring bending machine

PRM 40 FH – ring bending machine, suitable for horizontal and vertical applications on sections and pipes, featuring foot controls

- ▶ Heavy-duty cast design
- ▶ Tempered bending rollers
- ▶ Shafts made of special steel, hardened and polished
- ▶ Continuously adjustable, lateral guide rollers
- ▶ All 3 rollers driven via gear
- ▶ Horizontal and vertical working position
- ▶ Suitable for particularly small bending diameters due to bottom roller with orbital feed
- ▶ Mobile control panel with two digital displays for feed rollers
- ▶ Straightening roller as standard for bending angled steel



Model	PRM 40 FH
Art. no.	3812040
Technical data	
Shaft Ø	35 mm
Roller Ø	137 mm
Speed	7 m/min.
Motor output 400 V / 50 Hz	1.1 kW
Electrical connection	400 V/50 Hz
Weight	350 kg
Dimensions L x W x H	1050 x 500 x 1250 mm

Scope of supply:

- › Standard bending rollers (refer to table on the right for bending options)
- › Digital displays for feed rollers
- › Mobile control panel
- › Straightening rollers
- › Chassis

Custom accessories

- Pipe bending rollers
- › Angle bending rollers
- › Special alignment rollers
- › Section bending rollers
- › Plastic rollers for soft materials
- › Equipment to twist rods
- › Spiral bending tool

Bending performance

PRM 40 FH

Section type	Max. Size mm	Min. bending Ø mm
Bending option with standard bending rollers:		
	18 x 18	250
	35 x 8	300
	50 x 12	400
	35 x 35 x 5	400
	30 x 30 x 5	300
	35 x 35 x 5	300
	UPN 40 x 20*	350

Bending performance

PRM 40 FH

Section type	Max. Size mm	Min. bending Ø mm
Bending options with optional bending rollers:		
	UPN 35 x 18*	500
	25 x 25 x 2	450
	30 x 15 x 2.5	500
	Ø22	200
	Ø33.7x2.3	400 200
	Ø40x1.5	500
	35 x 35 x 5	400
	30 x 30 x 4	550

Performance data are based on material with a max. yield strength of 24 kg/mm². Bending performance for stainless steel (VA): factor 0.7 *May require additional spacers



Note

- The machine can be **optionally** equipped with bending rollers to suit your specific requirements
- We can also supply non-standard sizes on request

Accessories	Art. no.
Bending rollers steel-iron	
0 - 33.7 mm	3880270
34 - 48.3 mm	3880271
49 - 60.3 mm	3880272
Custom dimensions	
Angle rollers made of steel/iron	
30 x 30 x 3 mm	3880273
40 x 40 x 5 mm	3880274
50 x 50 x 6 mm	3880275
60 x 60 x 6 mm	3880276
Custom dimensions	

Accessories	Art. no.
Plastic rollers for aluminium and stainless steel	
0 - 33.7 mm	3880277
34 - 48.3 mm	3880278
49 - 60.3 mm	3880279
Custom dimensions	
Plastic angle rollers for aluminium and stainless steel	
30 x 30 x 3 mm	3880280
40 x 40 x 5 mm	3880281
50 x 50 x 6 mm	3880282
60 x 60 x 6 mm	3880283



- Option: NC control with touchscreen and teach-in function



- Standard control panel



- Straightening roller adjustment



- Orbital feed of bottom rollers



- Pressure gauge

Please state the material type you would like to process in your order!

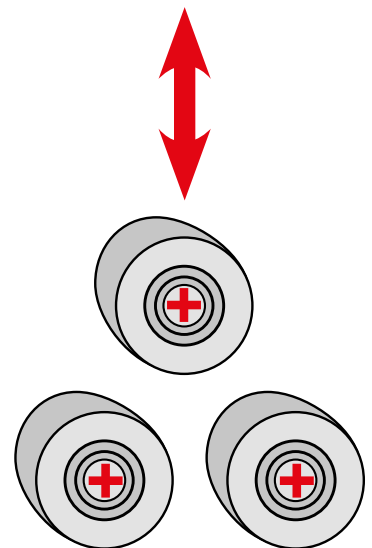
Ring bending machine

PRM 50 FH – hydraulic ring bending machine, suitable for horizontal and vertical applications on sections, pipes and solid materials

- ▶ Heavy-duty welded structure made of steel
- ▶ Horizontal and vertical working positions
- ▶ Hydraulic feed of top roller
- ▶ Digital indicator for adjustment roller
- ▶ All 3 rollers are driven and tempered
- ▶ Continuously adjustable, lateral guide rollers
- ▶ Separate control panel with foot controls



Application ring bending



Model	PRM 50 FH
Art. no.	3812036
Technical data	
Shaft Ø	50 mm
Roller Ø at the top	162 mm
Roller Ø at the bottom	152 mm
Speed	4.5 m/min.
Hydraulic pressure	8 t
Motor output	1.1 kW
Electrical connection	400 V/50 Hz
Weight	500 kg
Dimensions in mm	810 x 950 x 1500

Scope of supply:

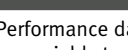
- › Standard bending rollers (refer to table on the right for bending options)
- › Mobile foot pedal for clockwise/anti-clockwise operation with emergency off function
- › Straightening rollers
- › Digital indicator for adjustment roller

Custom accessories

Pipe bending rollers

- › Angle bending rollers
- › Special alignment rollers
- › Section bending rollers
- › Plastic rollers for soft materials

PRM 50 F		
Bending performance		
Section type	Max. Size mm	Min. bending Ø mm
Bending option with standard bending rollers:		
	35 15	600 300
	60 x 10 20 x 10	600 300
	100 x 15 50 x 10	600 300
	60 x 7 30 x 4	800 500
	60 x 7 30 x 4	800 500
	50 x 6 30 x 4	800 400
	UPN 80* UPN 30*	800 400

PRM 50 F		
Bending performance		
Section type	Max. Size mm	Min. bending Ø mm
	UPN 80* UPN 30*	1200 600
Bending options with optional bending rollers:		
	50 x 3 20 x 2	1600 400
	70 x 30 x 3 30 x 15 x 2	1500 400
	35 20	600 300
	2" x 2.9 1 1/2" x 2.3	1000 300
	70 x 2 25 x 1.5	1200 400
	50 x 6 30 x 3	600 400
	50 x 6 30 x 3	900 600

Performance data are based on material with a max. yield strength of 24 kg/mm². Bending performance for stainless steel (VA): factor 0.7
*May require additional spacers



Note

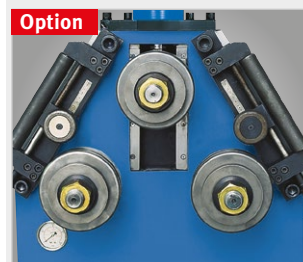
- The machine can be **optionally** equipped with bending rollers to suit your specific requirements
- We can also supply non-standard sizes on request



- Option: NC control with touchscreen and teach-in function



- Digital position display for feed roller



- Option: special guide rollers on the sides, for angle sections

Accessories PRM 50 FH	Art. no.
Special straightening rollers for angled sections	3880102

Bending rollers* for PRM 50 FH (please note information below!)

Steel/iron rollers

0 - 33.7 mm	3880103
34 - 48.3 mm	3880104
49 - 60.3 mm	3880105
Custom dimensions	

Angle rollers made of steel/iron

30 x 30 x 3 mm	3880106
40 x 40 x 5 mm	3880107
50 x 50 x 6 mm	3880108
60 x 60 x 6 mm	3880109
Custom dimensions	

Accessories PRM 50 FH	Art. no.
Plastic rollers for aluminium and stainless steel	
0 - 33.7 mm	3880110
34 - 48.3 mm	3880111
49 - 60.3 mm	3880112
Custom dimensions	

Plastic angle rollers for aluminium and stainless steel

30 x 30 x 3 mm	3880113
40 x 40 x 5 mm	3880114
50 x 50 x 6 mm	3880115
60 x 60 x 6 mm	3880116
Custom dimensions	

Accessories PRM 50	Art. no.
lateral Angle guide	3880161
NC control	3880163

Please state the type of material to be processed with your order!

* Price/roller set relates to a dimension from this mm range; state the material dimension you would like to process in your order. Rollers are produced as per these dimensions.

Ring bending machine

PRM 60 FH – hydraulic ring bending machine, suitable for horizontal and vertical applications on sections, pipes and solid materials

- ▶ Heavy-duty welded structure made of steel
- ▶ Horizontal and vertical working positions
- ▶ Hydraulic feed of top roller
- ▶ Digital indicator for adjustment roller
- ▶ All 3 rollers are driven and tempered
- ▶ Continuously adjustable, lateral guide rollers
- ▶ Separate control panel with foot controls



Application ring bending



Model	PRM 60 FH
Art. no.	3812060
Technical data	
Shaft Ø	60 mm
Roller Ø at the top	215 mm
Roller Ø at the bottom	215 mm
Speed	4 m/min.
Hydraulic pressure	16 t
Motor output	1.5 kW
Electrical connection	400 V/50 Hz
Weight	950 kg
Dimensions in mm	1000 x 1400 x 1650

Scope of supply:

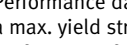
- › Standard bending rollers (refer to table on the right for bending options)
- › Mobile foot pedal for clockwise/anti-clockwise operation with emergency off function
- › Straightening rollers
- › Digital indicator for adjustment roller

Custom accessories

Pipe bending rollers

- › Angle bending rollers
- › Special alignment rollers
- › Section bending rollers
- › Plastic rollers for soft materials

Bending performance PRM 60 F		
Section type	Max. Size mm	Min. bending Ø mm
Bending option with standard bending rollers:		
	50 20	800 400
	80 x 20 40 x 10	1200 400
	120 x 25 50 x 10	600 400
	80 x 9* 40 x 5*	1000 400
	80 x 9 40 x 5	1000 400
	80 x 9 40 x 5	1200 500
	UPN 120* UPN 60*	800 500

Bending performance PRM 60 F		
Section type	Max. Size mm	Min. bending Ø mm
	UPN 120* UPN 60*	1200 600
Bending options with optional bending rollers:		
	70 x 3 40 x 2	1600 500
	80 x 40 x 3 40 x 20 x 2	1400 500
	50 20	800 400
	3" x 3,2 1" x 2,6	1600 500
	100 x 2 60 x 2	1600 500
	70 x 7 40 x 5	1000 500
	70 x 7 40 x 5	1200 600

Performance data are based on material with a max. yield strength of 24 kg/mm². Bending performance for stainless steel: Factor 0.7 *We recommend special bending roller sets for optimal bending results



Note

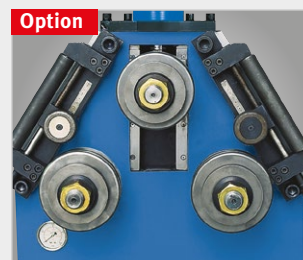
- ▶ The machine can be **optionally** equipped with bending rollers to suit your specific requirements
- ▶ We can also supply non-standard sizes on request



- ▶ Option: NC control with touchscreen and teach-in function



- ▶ Digital position display for feed roller



- ▶ Option: special guide rollers on the sides, for angle sections

Accessories PRM 60 FH	Art. no.	Accessories PRM 50 FH	Art. no.
Special straightening rollers for angled sections	3880161	Plastic rollers for aluminium and stainless steel	
NC control	3880163	0 - 33.7 mm	3880430
Bending rollers* for PRM 60 FH (please note information below!)		34 - 48.3 mm	3880431
Steel/iron rollers		49 - 60.3 mm	3880432
0 - 33.7 mm	3880410	61 - 76.1 mm	3880433
34 - 48.3 mm	3880411	77 - 88.9 mm	3880434
49 - 60.3 mm	3880412	Custom dimensions	
61 - 76.1 mm	3880413	Plastic angle rollers for aluminium and stainless steel	
77 - 88.9 mm	3880414	50 x 50 x 6 mm	3880440
Custom dimensions		60 x 60 x 6 mm	3880441
Angle rollers made of steel/iron		70 x 70 x 6 mm	3880442
50 x 50 x 6 mm	3880420	Custom dimensions	
60 x 60 x 6 mm	3880421		
70 x 70 x 6 mm	3880422		
Custom dimensions			

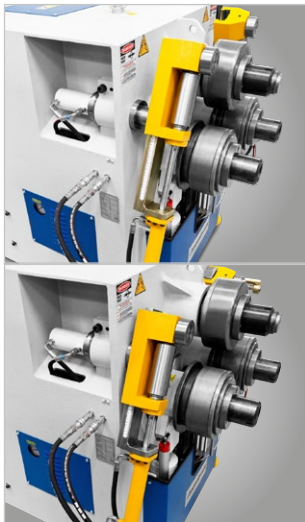
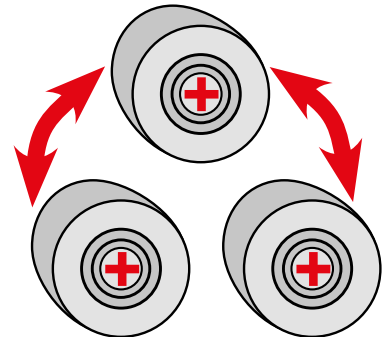
* Price/roller set relates to a dimension from this mm range; state the material dimension you would like to process in your order. Rollers are produced as per these dimensions.

Please state the type of material to be processed with your order!

Ring bending machine

PRM 80 FH – hydraulic ring bending machine, suitable for horizontal and vertical applications on sections, pipes and solid materials

- ▶ Heavy-duty welded structure made of steel
- ▶ Horizontal and vertical working positions
- ▶ All three rollers are driven and tempered
- ▶ Hydraulic feed via two bottom rollers
- ▶ Continuously adjustable, lateral guide rollers
- ▶ Separate control panel with 2 digital displays for two feed rollers



• Lateral mechanical straightening rollers, continuously adjustable



PRM 80 FH

Please state the material type you would like to process in your order!

Model	PRM 80 FH
Art. no.	3812080
Technical data	
Roller ø	245 mm
Roller holder shaft Ø top	80 mm
Roller holder shaft Ø bottom	70 mm
Speed	6 m/min.
Motor output	4 kW
Electrical connection	400 V/50 Hz
Weight	1700 kg
Dimensions in mm	1450 x 1000 x 1400

Scope of supply:

- › Standard bending rollers (refer to table on the right for bending options)
- › Mobile control panel
- › One digital display per bottom feed roller
- › Manual straightening rollers

Custom accessories

- Hydraulic straightening rollers
- › Pipe bending rollers
- › Angle bending rollers
- › Special alignment rollers
- › Section bending rollers
- › Plastic rollers for soft materials
- › NC control

Bending performance

PRM 80 FH

Section type	Max. Size mm	Min. bending Ø mm
Bending option with standard bending rollers:		
	45 15	500 380
	100 x 20 80 x 20 30 x 10	2000 800 300
	125 x 25 60 x 5	600 300
	80 x 9* 25 x 3.5*	800 280
	70 x 8 25 x 3.5	800 280
	70 x 8 25 x 3.5	800 280
	UPN 140* UPN 120* UPN 100*	1600 900 600
	UPN 140* UPN 120* UPN 100*	1600 1000 800

Bending performance

PRM 80 FH

Section type	Max. Size mm	Min. bending Ø mm
Bending options with optional bending rollers:		
	70 x 3 25 x 2	1300 350
	80 x 25 x 3 25 x 15 x 2	800 350
	50 15	500 380
	3" x 5.48 1/2" x 2.77	1200 380
	100 x 2.5 15 x 1	800 380
	80 x 8 30 x 3	800 400
	70 x 7 30 x 3	700 450

Performance data are based on material with a max. yield strength of 24 kg/mm². Bending performance for stainless steel: Factor 0.7 *We recommend special bending roller sets for optimal bending results

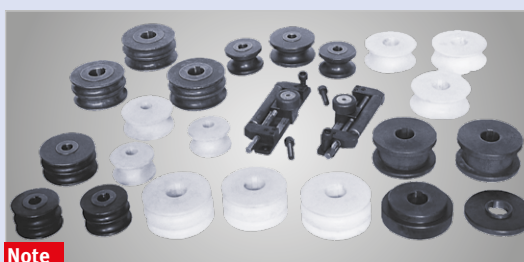


PRM 80 FH in horizontal working position

Accessories PRM 80 FH

	Art. no.
Hydraulic adjustment of the lateral guide rollers	3880170
NC control	3880171

Bending rollers on request



Note

- ▶ The machine can be **optionally** equipped with bending rollers to suit your specific requirements
- ▶ We can also supply non-standard sizes on request

Option



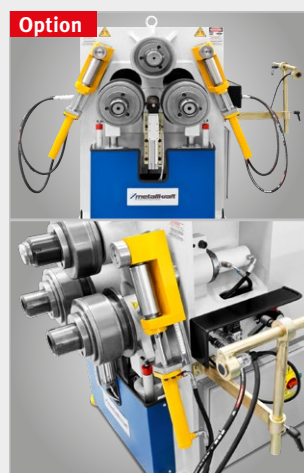
- ▶ Option: NC control with touchscreen and teach-in function

Option

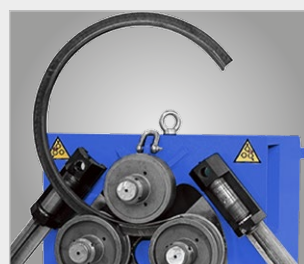


- ▶ Option: two lateral hydraulic guide rollers

Option



- ▶ Option: hydraulic straightening rollers



- ▶ Bending process



- ▶ Bending examples

Ring bending machine

PRM 100 FH – hydraulic ring bending machine, suitable for horizontal and vertical applications on sections, pipes and solid materials

- ▶ Heavy-duty welded structure made of steel
 - ▶ Horizontal and vertical working positions
 - ▶ All three rollers are driven by a hydro-motor
- and planetary gear
 - ▶ Tempered rollers
 - ▶ Hydraulic feed via two bottom rollers
- ▶ Continuously adjustable, lateral guide rollers
 - ▶ Separate control panel with foot controls and 2 digital displays



PRM 100 FH

Please state the material type you would like to process in your order!

Model	PRM 100 FH
Art. no.	3812100
Technical data	
Roller ø	315 mm
Roller holder shaft Ø top	100 mm
Roller holder shaft Ø bottom	100 mm
Speed	7 m/min.
Motor output	7.5 kW
Electrical connection	400 V/50 Hz
Weight	3650 kg
Dimensions in mm	2000 x 1450 x 1700

Scope of supply:

- › Standard bending rollers (refer to table on the right for bending options)
- › Mobile control panel
- › One digital display per bottom feed roller
- › Manual straightening rollers

Custom accessories

- Hydraulic straightening rollers
- › Infinitely adjustable roller speed
 - › Pipe bending rollers
 - › Angle bending rollers
 - › Special alignment rollers
 - › Section bending rollers
 - › Plastic rollers for soft materials
 - › NC control

PRM 100 FH		
Bending performance		
Section type	Max. Size mm	Min. bending Ø mm
Bending option with standard bending rollers:		
	60 15	750 400
	100 x 20 30 x 10	800 400
	200 x 30 160 x 35 80 x 5	1200 800 400
	100 x 11 30 x 4	1000 400
	100 x 11* 30 x 4	1000 400
	90 x 10 30 x 4	1000 400
	UPN 180* UPN 30*	900 400

PRM 100 FH		
Bending performance		
Section type	Max. Size mm	Min. bending Ø mm
Bending options with optional bending rollers:		
	80 x 5 25 x 2	1500 450
	1000 x 40 x 4 25 x 15 x 2	1300 400
	75 15	800 450
	4" x 6.02 1 1/2" x 2.77	1000 450
	125 x 2.5 15 x 1	1400 450
	100 x 12 40 x 4	1000 700
	100 x 10 40 x 4	1000 550

Performance data are based on material with a max. yield strength of 24 kg/mm². Bending performance for stainless steel: Factor 0.7 *We recommend special bending roller sets for optimal bending results



Large machines on request

PRM 100 FH in horizontal working position

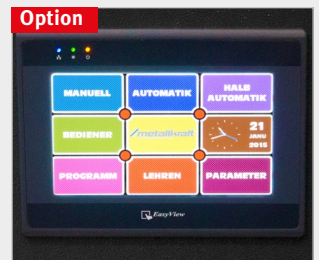
Accessories PRM 100 FH	Art. no.
Hydraulic adjustment of the lateral guide rollers	3880180
NC control	3880181
Continuously variable speed	3880182

Bending rollers on request

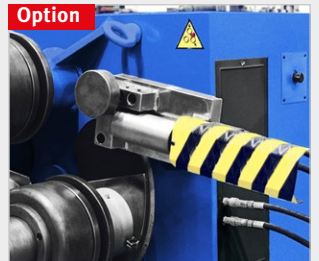


Note

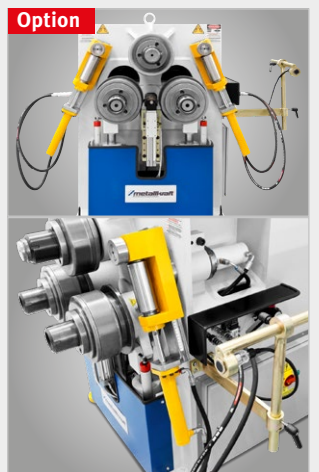
- The machine can be **optionally** equipped with bending rollers to suit your specific requirements
- We can also supply non-standard sizes on request



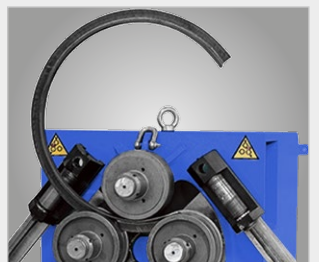
► Option: NC control with touchscreen and teach-in function



► Option: two lateral hydraulic guide rollers



► Option: hydraulic straightening rollers



► Bending process



► Bending example

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Metal-cutting band saws

Sales



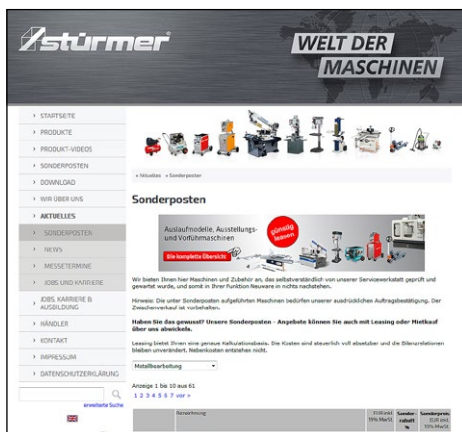
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Bead bending machines

SBM – Manual swage bending machines

- ▶ Heavy-duty and rugged cast iron design
- ▶ Adjustable bottom shafts
- ▶ Special steel shafts
- ▶ Continuously adjustable stop plate

SBM 110-08:

- ▶ 7-part standard roller set

SBM 140-12:

- ▶ 8-part standard roller set

Please state the material type you would like to process in your order!



SBM 110-08



SBM 140-12



Bending rollers type E3

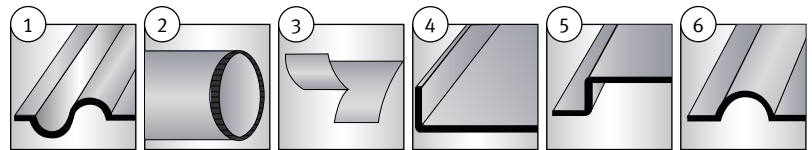
Model	SBM 110-08	SBM 140-12
Art. no.	3814001	3814002

Technical data

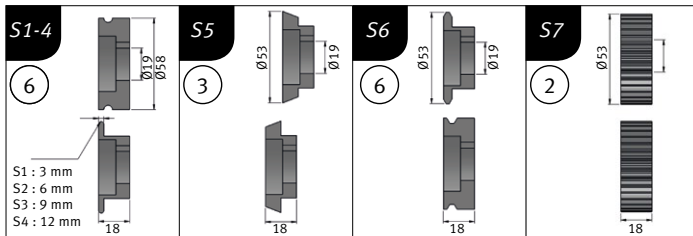
Roller length	110 mm	140 mm
Max. sheet thickness*	0.80 mm	1.2 mm
Roller Ø	52 mm	62 mm
Collar width	80 mm	100 mm
Weight	30 kg	50 kg
Dimensions L x W x H	380 x 180 x 380	560 x 220 x 500

*Performance data for material with tensile strength of 400 N/mm²

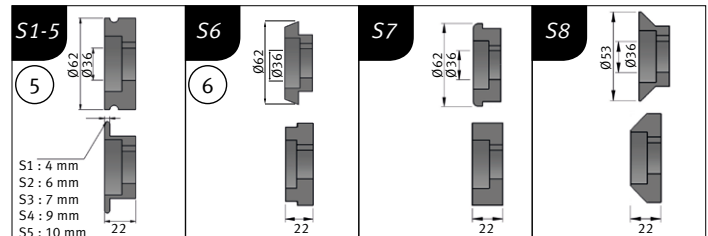
Typical applications



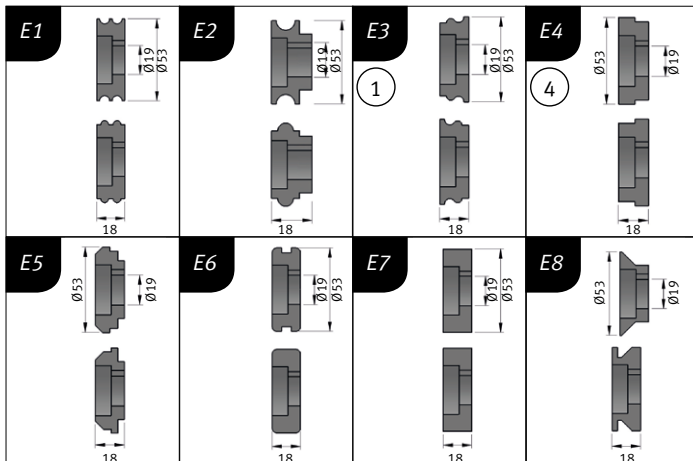
Standard rollers for SBM 110-08 (included in scope of delivery)



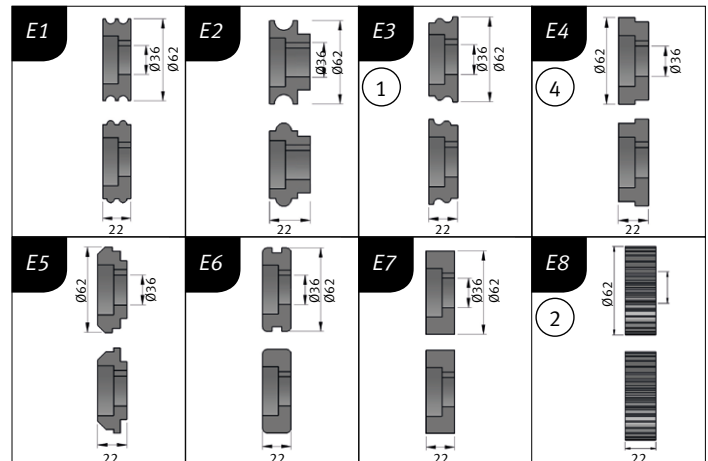
Standard rollers for SBM 140-12 (included in scope of delivery)



Accessory rollers for SBM 110-08



Accessory rollers for SBM 140-12



Accessories SBM 110	Art. no.	Accessories SBM 110	Art. no.
Bending rollers type E1	3880121	Bending rollers type E5	3880125
Bending rollers type E2	3880122	Bending rollers type E6	3880126
Bending rollers type E3	3880123	Bending rollers type E7	3880127
Bending rollers type E4	3880124	Bending rollers type E8	3880128

Accessories SBM 140	Art. no.	Accessories SBM 140	Art. no.
Bending rollers type E1	3880131	Bending rollers type E5	3880135
Bending rollers type E2	3880132	Bending rollers type E6	3880136
Bending rollers type E3	3880133	Bending rollers type E7	3880137
Bending rollers type E4	3880134	Bending rollers type E8	3880138

Bead bending machines

SBM 140-12 E – Motorised swage bending machine

- ▶ Heavy-duty and rugged cast iron design
- ▶ Gear motor with brake system
- ▶ Foot pedal operation
- ▶ Adjustable bottom shaft
- ▶ steel shafts
- ▶ With chassis
- ▶ Continuously adjustable stop plate
- ▶ 8-part standard roller set

Please state the material type you would like to process in your order!



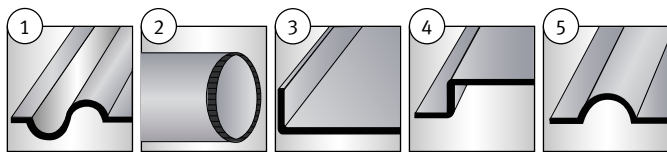
SBM 140-12 E

Model	SBM 140-12 E
Art. no.	3814003

Technical data	
Roller length	140 mm
Max. sheet thickness*	1.2 mm
Roller Ø	62 mm
Collar width	100 mm
Roller speed	32 rpm
Motor output	0.75kW
Electrical connection	400 V/50 Hz
Weight	110 kg
Dimensions L x W x H	900 x 1350 x 450

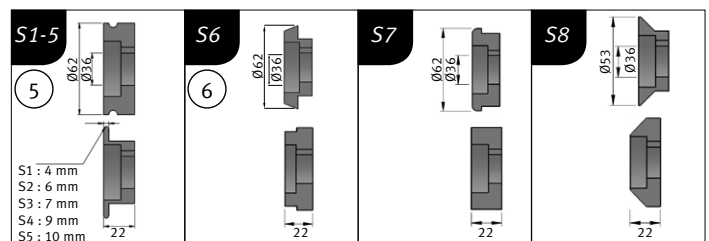
*Performance data for material with tensile strength of 400 N/mm²

Typical applications

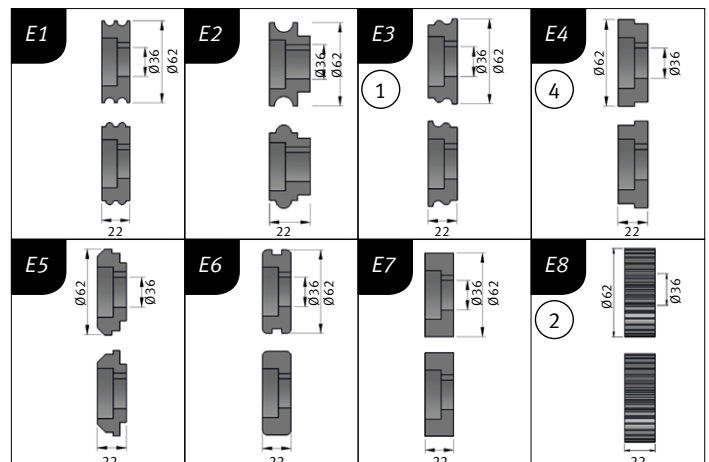


Accessories SBM 140	Art. no.
Bending rollers type E1	3880131
Bending rollers type E2	3880132
Bending rollers type E3	3880133
Bending rollers type E4	3880134
Bending rollers type E5	3880135
Bending rollers type E6	3880136
Bending rollers type E7	3880137
Bending rollers type E8	3880138

Standard rollers for SBM 140-12 E (included in scope of delivery)



Accessory rollers for SBM 140-12 E



SBM E – Motorised swage bending machines

- ▶ Heavy-duty and stable steel design
- ▶ Self-braking motor
- ▶ Foot pedal operation
- ▶ Adjustable bottom shaft
- ▶ Adjustable stop plate
- ▶ Stahl shafts with bronze bushings fitted

- ▶ 4 set standard rollers
- ▶ Chassis



SBM 250-25 E



SBM 300-40 E

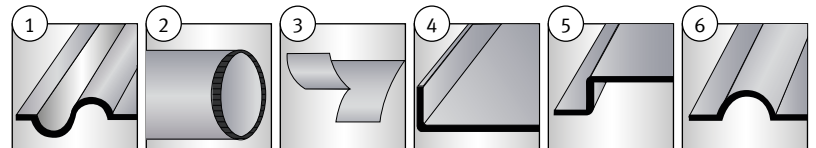
Model	SBM 250-25 E	SBM 300-40 E
Art. no.	3814004	3814005

Please state the material type you would like to process in your order!

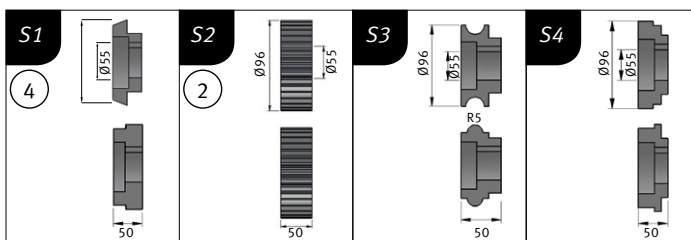
Technical data		
Roller length	250 mm	300 mm
Max. sheet thickness*	2.5 mm	4 mm
Roller Ø	96 mm	126 mm
Collar width	160 mm	200 mm
Roller speed	5 m/min.	5 m/min.
Motor output	1.5 kW	2.2 kW
Electrical connection	400 V/50 Hz	400 V/50 Hz
Weight	350 kg	500 kg
Dimensions L x W x H in mm	1400 x 550 x 1120	1700 x 570 x 1200

*Performance data for material with tensile strength of 400 N/mm²

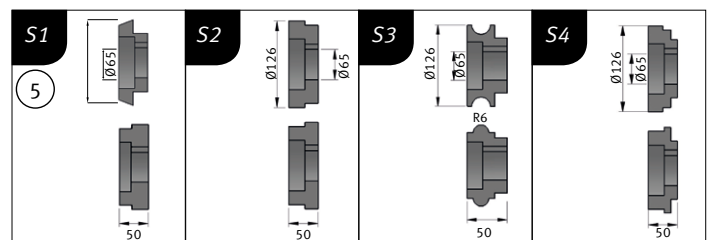
Typical applications



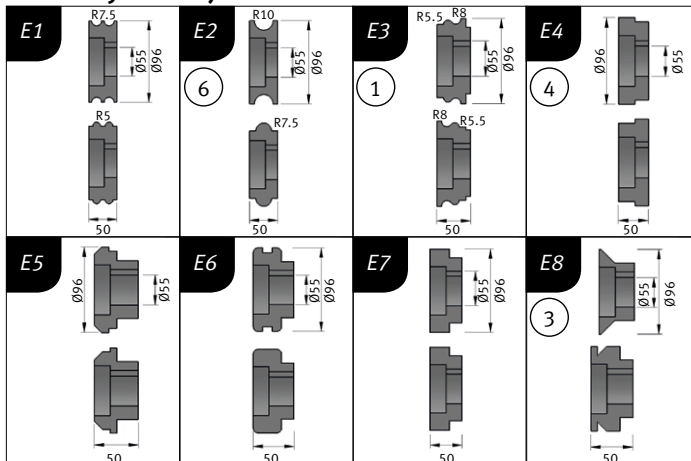
Standard rollers for SBM 250-25 E (included in scope of delivery)



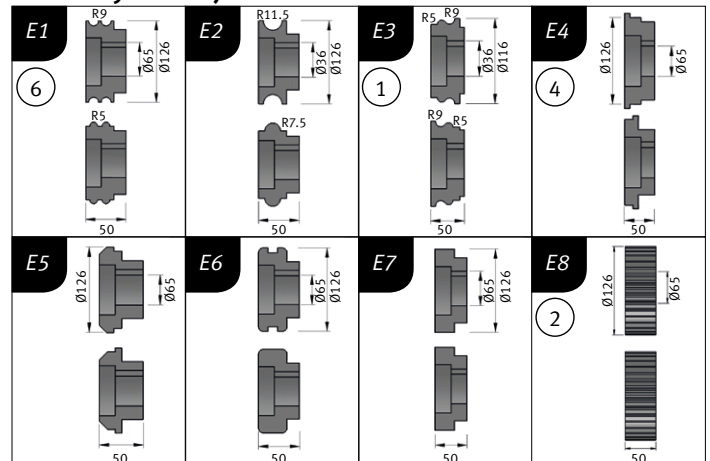
Standard rollers for SBM 300-40 E (included in scope of delivery)



Accessory rollers for SBM 250-25 E



Accessory rollers for SBM 300-40 E



Accessories	Art. no.
SBM 250-25E	
Bending rollers type E1	3880711
Bending rollers type E2	3880712
Bending rollers type E3	3880713
Bending rollers type E4	3880714
Bending rollers type E5	3880715

Accessories	Art. no.
SBM 250-25E	
Bending rollers type E6	3880716
Bending rollers type E7	3880717
Bending rollers type E8	3880718
Surcharge hydraulic top roller*	3880719
*Ex works	

Accessories	Art. no.
SBM 300-40E	
Bending rollers type E1	3880721
Bending rollers type E2	3880722
Bending rollers type E3	3880723
Bending rollers type E4	3880724
Bending rollers type E5	3880725

Accessories	Art. no.
SBM 300-40E	
Bending rollers type E6	3880726
Bending rollers type E7	3880727
Bending rollers type E8	3880728
Surcharge hydraulic top roller*	3880729
*Ex works	

Manual plate rolling machines

RBM – Manual, asymmetric 3-roller plate rolling machines

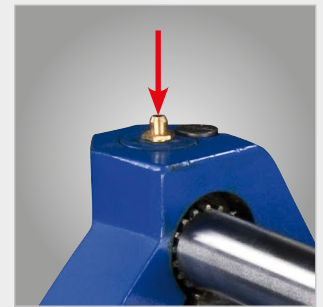
- ▶ Steel rollers
- ▶ Top roller folds out for easier removal of the workpiece
- ▶ Asymmetric roller arrangement for convenient pre-bending
- ▶ Skewing side roller for conical bending
- ▶ Clamping and side roller with wire insert grooves
- ▶ Roller drive via crank and gear
- ▶ Particularly handy and thus suitable for working in cramped conditions
- ▶ Perfectly suited for fine work due to lean shaft thickness
- ▶ 3-roller plate rolling machine for all round parts such as pipes, cylinders, etc.
- ▶ Simple and rugged design



RBM 305 with optional Chassis (Art. no. 3780113)



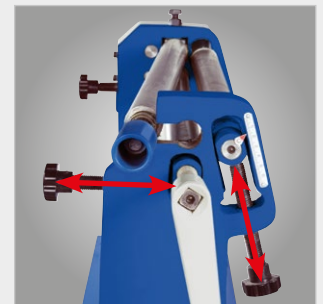
RBM 610-08



▶ Lubrication via lubricating nipple possible (RBM 305)



▶ The upper roller can be swivelled out for easier removal of the finished workpiece



▶ Rear rollers individually adjustable, thus supports conical work
▶ Settings through convenient, generously dimensioned roller adjustment screws

Model	RBM 305	RBM 610-08
Art. no.	3780112	3780618
Technical data		
Max. working width	305 mm	610 mm
Max. sheet thickness	0.80 mm	0.80 mm
Roller Ø	25 mm	38 mm
Bending Ø min.	40 mm	60 mm
Weight	14 kg	37 kg
Dimensions L x W x H	580 x 210 x 255 mm	885 x 220 x 340 mm

*Performance data for material with tensile strength of 400 N/mm²

Accessories SBM 300-40E
Chassis

Art. no.
3780113