

Magnetic drilling machines
Belt sanders
Surface grinders
Guillotine shears
Notching machines
Profile shears
Punches
Ring bending machines
Plate rolling machines
Folding machines
Bending brakes
Workshop presses
Metal-cutting circular saws
Roller conveyors
Metal band saws
Accessories

Metal working machinery





Sales and service Germany in Hallstadt/Bamberg

Dear Customer,

There are many good reasons for taking a close look at this catalogue!

Do you have exacting requirements in terms of machine quality? But economic efficiency, profitability is an equally important factor for you?

Metallkraft metalworking machines offer excellent quality at an affordable price.

The high quality standard of our machines is founded on carefully selected, quality-conscious, market-leading manufacturers with decades of experience.

Our network of specialist dealers ensures that you always

have a local partner who guarantees the best possible advice, support, and after-sales service.

And, of course, our consultancy and service team is there to help you at any time.

A price comparison among genuinely equivalent and comparable products offers you the assurance that purchasing a brand-name product by Metallkraft gives you a product that stands comparison in terms of ease of use, features, quality, engineering and price-performance and the right purchasing decision for you.

Our professional Metallkraft customer service gives every customer the ability to choose the performance they need from our comprehensive program of services at any time.

Our services can be broken down into the four following modules: inventory and requirements analysis, plant design and advisory services, installation and commissioning, maintenance and after-sales

service.

The METALLKRAFT service field force, and our service partners, ensure reliable, nationwide, on-site service for our customers.



HOTLINE SPARE PARTS ORDERS

Tel. +49 (0) 951/96 555 - 118
Fax +49 (0) 951/96 555 - 119
Email ersatzteile@stuermer-maschinen.de
Direct spare parts availability query: 24h via Partner Portal



SERVICE HOTLINE (REPAIRS, WARRANTY CLAIMS)

**ONLY FOR
SPECIALIST
RETAIL PARTNERS**

Tel. +49 (0) 951/96 555 - 100 Fax +49 (0) 951/96 555 - 111
Email service@stuermer-maschinen.de
Fast order processing & status queries: 24h via our Partner Portal
Our specialist retail partners can contact us as follows:
Monday to Thursday: 0700 – 1700 hours Friday 0700 – 1600 hours

PRODUCT AND IMAGE DATA / STÜRMEER PARTNER PORTAL

Matthias Kundmüller
Tel. +49 (0) 951/96 555 - 790
Fax +49 (0) 951/96 555 - 55
m.kundmueller@stuermer-maschinen.de



APPOINTMENTS DEMO CENTRE

For faster and less complicated registration, mail your complete data to: vorfuehrzentrum@stuermer-maschinen.de

Retailer/Customer name
Reason for visit: demo, training in use, application training, interested in product



ON OUR PARTNER PORTAL

RFQ Repair status
Availability Fast service request
24h service Direct spare parts availability query
Please request your access data here:
<https://partnerportal.stuermer-maschinen.de>



Of course, your METALLKRAFT specialist dealer also offers the following services:

Consultancy by application engineers

You can talk to our application engineers for competent and objective advice prior to your purchase.

Financing

We are always happy to submit a quotation for leasing tailored to your needs with moderate interest rates and manageable monthly instalments.

Introductory training

If so desired, we will install and commission the machine, and train you and your operating staff. Please ask us for a quotation.

Delivery

We deliver to your premises, quickly and at competitive rates.

Service

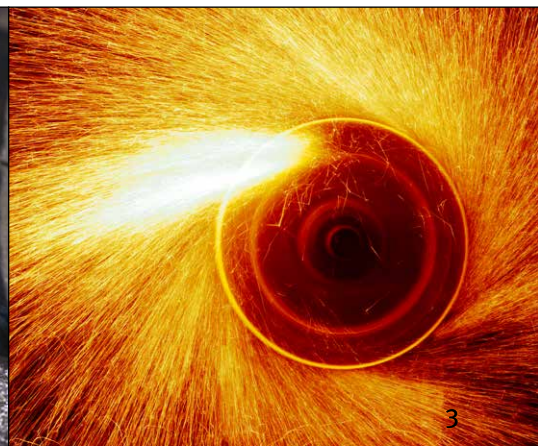
Your specialist dealer offers advice and hands-on support. And you can call our telephone hotline is from Monday to Friday. We offer optimum on-site or bring-in machine service.

Product diversity

We offer a versatile program for any user - from hobby woodworkers to professionals. On top of this, we offer a variety of add-on parts and accessories.



Robert Stürmer *Kilian Stürmer*
Robert Stürmer **Kilian Stürmer**
Head of Sales Managing Director





In early April 2014, operations started in our new logistics centre. At the company site in Pettstadt near Bamberg (15 km from head office) with some 50,000 m², the new logistics centre was created with 20,000 m² of hall floor space: another milestone in the history of the STÜRMER Group.

The objective is to improve delivery quality in all respects, and thus offer our esteemed business partners tangibly increased benefits.

Today, the new processes are established to the extent that the value chain works in a trouble-free way. The conditions have thus been established for orders that are entered on the system before 12.00 hours being picked and packed on the same day, and dispatched on the same day, or the next day depending on availability of the forwarding company.

Our objectives are your benefits!

The most important success factors

- ▶ Rapid availability thanks to high storage capacity
- ▶ Fast loading and turn-around times thanks to storage bay management and path optimisation
- ▶ Ensured quality thanks to scanner-based methods
- ▶ Huge improvement in the permeability of the outgoing goods process

Target:
Minimal
delivery times

Target:
Zero
errors

**Customer
satisfaction**

**Customer
loyalty**
remote data
transmission/
SSCC

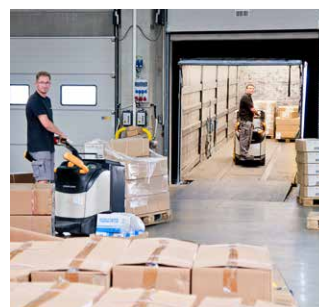
**Assured
stock levels**



The STÜRMER fleet



20,000 m² of warehouse space



Goods inward



Accessories



Our logistics centre stocks more than 345,000 articles. This allows for fast shipment of almost all of our products to Germany and throughout Europe. Qualified staff ensure the orderly delivery of the goods. Every year, more than 100,000 items leave the company's premises, with our own delivery vehicles, by carrier, or by parcel service.

STÜRMER Logistics:

- ▶ Own fleet of 5 trucks
- ▶ 16,000 pallet bays
- ▶ 2,500 bays for small parts
- ▶ 22,000 m² of warehouse space
- ▶ 41 qualified warehouse clerks and trainees
- ▶ Approx. 8,800 shipments per month
- ▶ Approx. 15 m euro worth of goods in stock at all times

More than 345,000 items ready for delivery:

- ▶ Around 20,000 machines
 - ▶ Around 225,000 accessories
 - ▶ Around 100,000 spare parts
- (Date: 30-06-2015)



Wood working machines



AIRCRAFT compressors



Metal working machinery



Outgoing goods



Drilling

Magnetic drilling machines

MB Series	8
Accessories	14

Deburring

Edge deburrer

KE Series	25
-----------	----

Metal grinding

Satin finishing machine

SM 100	32
--------	----

Pipe sanding machine

RSM 620	34
RSM 760	35

Brush deburring sander

BEG 250	36
---------	----

Belt and disc sander

BTS 51	37
--------	----

Extraction units

AS 1400, AS 1600	37
------------------	----

Combined sander

KRBS 101	38
----------	----

Belt sanders

MBSM	40
------	----

Long belt sanding machine

MBSM ESE	42
----------	----

Two-belt grinding machines

MBSM ZB	44
---------	----

Sanding belts for MBSM series

	46
--	----

Precision surface-grinding machine

FSM	48
-----	----

Cutting

Rotary shears

KS 1 (manual)	54
---------------	----

KS2 (motorised)

	54
--	----

Manual guillotine shears

BSS	54/55
-----	-------

Manual precision guillotine shears

TBS	55
-----	----

Manual guillotine shears

TBS New	56
----------------	----

Foot-operated guillotine shears

FTBS 1050-10	57
--------------	----

Precision guillotine shears

FTBS M	58
--------	----

FTBS P

	59
--	----

Motorised guillotine shears

MTBS E	60
MTBS motorised	61
MTBS motorised (heavy duty version)	62

Hydraulic guillotine shears

HTBS-T	64
HTBS-K	66

Notching & punching

Manual pipe notcher

MRA New	70
----------------	----

Notching machines

AKM 100 T	70
AKM V	71

Hydraulic section steel shears/ hole punches

HPS	72
-----	----

Hydraulic hole punches

HLS	76
-----	----

Bending

Pressing and stretching machine

SSG	80
-----	----

Angle bender

WB 100	81
--------	----

Hydraulic pipe bender

HRB 10	81
--------	----

Universal and pipe bending machines

UB 10	82
UB 11	83
RB 30	84
RB 12	85

Pipe bending machines

BM series New	86
----------------------	----

Ring bending machine

PRM	89
-----	----

PRM F

	90 - 93
--	---------

PRM FH

	94 - 103
--	----------

Bead bending machines

SBM	105
-----	-----

SBM E

	116
--	-----

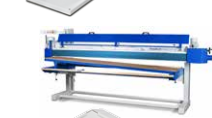
Plate

rolling machines

RBM	108
RBM E	110
RBM E PRO	112
RBM 4 HMS PRO	114
RBM 4-H PRO	116

Combined bending/cutting machines

SRWS KOMBI	118
------------	-----



Manual brake bending machines

HSBM	119
HSBM SB Now	120

Manual gutter bracket bender

REB 1	120
-------	-----

Folding machines

MBM 1250	121
HSBM N	122
FSBM	124
HSBM	126
MSBM PRO	130

Bending brakes

GBP-E	142
GBP-R	144
GBP-S	148
GBP-Servo	152

Presses

Table top workshop presses

WPP T	158
-------	-----

Workshop presses

WPP 159	
WPP BK	160

Workshop presses with electric pump

WPP M	161
-------	-----

Heavy duty workshop presses

WPP HBK	162
WPP MBK	164

Universal frame presses

RP U Now	166
-----------------	-----

Frame presses with unit to bend edges

RP A Now	167
-----------------	-----

Hydraulic C rack presses

HP C Now	168
-----------------	-----

Circular saws

Overview of saws

	169
--	-----

Manual metal-cutting circular saws

HKS 230	178
---------	-----

Metal dry cutter

MTS 356	179
---------	-----

Metal-cutting circular saws

MKS N	180
MKS R	182
MKS	183
MKS H	183

Vertical metal-cutting circular saws

MKS V	184
MKS VH	185
MKS VA	186

Light alloy metal-cutting circular saws

LMS / LMS H / LMS P	188
LMS A	189

Saw blades

	190
--	-----

Universal chassis

UF 230	192
--------	-----

Material supports

MS	192
----	-----



Roller conveyors

Roller and measuring tracks

MRB LC	193
Assembly adapter MRB LC	193
MRB Standard	194
Assembly adapter MRB Standard	195

Band saws

Metal-cutting band saws

MBS	198
-----	-----

Vertical metal-cutting band saws

VMBS	200
------	-----

Explanation of controls

Introducing PEGAS	210
-------------------	-----

BMBS 220 x 250 H-G / CNC-G	212
----------------------------	-----

BMBS 230 x 280 H-DG / HA-DG Now	214
--	-----

BMBS 240 x 280 CNC-G	216
----------------------	-----

BMBS 250 x 315 H-DG / HA-DG	218
-----------------------------	-----

BMBS 300 x 320 H-DG Now	220
--------------------------------	-----

BMBS 300 x 320 HA-DG Now	222
---------------------------------	-----

BMBS 300 x 320 CNC-G Now	224
---------------------------------	-----

BMBS 300 x 320 CNC-DG X 1500 Now	226
---	-----

BMBS 350 x 400 CNC-DG Now	228
----------------------------------	-----

BMBS 360 x 500 H-DG / HA-DG	230
-----------------------------	-----

BMBS 460 x 600 HA-DG	232
----------------------	-----

HMBS 440 x 600 HA-DG Now	234
---------------------------------	-----

HMBS 440 x 600 NC-DG X 2000 Now	236
--	-----

HMBS 500 x 750 HA-DG / HA-DG X	238
--------------------------------	-----

HMBS 500 x 750 HA-DG	240
----------------------	-----

HMBS 600 x 1100 HA-DG X	242
-------------------------	-----

HMBS 300 x 300 CNC X Now	244
---------------------------------	-----

HMBS 400 HA Now	246
------------------------	-----

HMBS 400 CNC Now	248
-------------------------	-----

HMBS 400 x 400 HA X	250
---------------------	-----

HMBS 400 x 400 CNC X	252
----------------------	-----

HMBS 510 x 510 HA X / CNC X	254
-----------------------------	-----

HMBS 550 x 1300 X Now	256
------------------------------	-----

HMBS 700 x 1400 X Now	257
------------------------------	-----

HMBS 600 HA X	258
---------------	-----

HMBS 600 CNC X 2000 Now	260
--------------------------------	-----

HMBS 700 x 750 HA X	262
---------------------	-----

HMBS 700 x 750 CNC X	264
----------------------	-----

HMBS 850 x 1000 HA X / CNC X	266
------------------------------	-----

HMBS 850 x 1000 HA X-VS	268
-------------------------	-----

HMBS 1000 HA X / CNC X 4000	270
-----------------------------	-----

HMBS 1200 x 1400 HA X / CNC X	272
-------------------------------	-----

HVMBS 850 x 1000 Xtreme	274
-------------------------	-----

HVMBS 1200 x 1600 Xtreme	276
--------------------------	-----

HVMBS 1250 x 1600 Portal	278
--------------------------	-----

	280
--	-----

Saw bands

	280
--	-----



Magnetic drilling



Overview **metallkraft**® Magnetic core drilling machines

Metallbearbeitungsmaschinen



MB 351



MB 502 E



MB 502



MB 754



MB 1204



RB 127



MB 351 F



MB 301 auto



MB 202 G

Model	MB 351	MB 502 E	MB 502	MB 754	MB 1204	RB 127	MB 351 F	MB 301 auto	MB 202 G
	Feed Manual	Feed Manual	Feed Manual	Feed Manual	Feed Manual	Feed Manual	Feed Manual	Feed Manual Auto	Feed Manual
Technical specifications									
Keyhole sawing max. Ø	-	-	-	-	-	127 mm	-	-	-
Max. drill Ø / Core drilling	35 mm	50 mm	50 mm	75 mm	120 mm	-	35 mm	35 mm 30 mm	35 mm
Max. drilling depth / Core drilling	50 mm	50 mm	75 mm	50 mm	75 mm	-	30 mm	50 mm 45 mm	50 mm
Max. drill bit Ø/Full drilling ¹	-	-	-	32 mm	32 mm	-	-	13 mm -	13 mm
Max. drilling depth/Full drilling ¹	-	-	-	150 mm	150 mm	-	-	110 mm -	110 mm
Max. drill bit Ø/Full drilling ²	13 mm	13 mm	16 mm	16 mm	16 mm	-	-	-	-
Max. drilling depth/Full drilling ²	140 mm	140 mm	110 mm	110 mm	110 mm	-	-	-	-
Spindle chuck	M 24	Fixed	M 24	MK 3	MK 3	5/8"-16	Fixed	M 24	Fixed
Weldon shaft holder	19 mm	19 mm	19 mm	19 mm	19 mm	-	19 mm	19 mm	19 mm
Speed under load in rpm	330	180/270	230/300	90/120/180/230	120/220/250/450	-	390	330	330
Motor output	1,100 Watts	1,100 Watts	2,000 Watts	2,000 Watts	2,000 Watts	1,100 Watts	1,100 Watts	1,100 Watts	1,100 Watts
Electrical connections	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz
Magnetic foot dimensions	165 x 80 mm	180 x 90 mm	200 x 100 mm	200 x 100 mm	210 x 120 mm	-	165 x 80 mm	165 x 80 mm	180 x 80 mm
Magnetic holding force	15,000 N	17,000 N	32,000 N	32,000 N	32,000 N	-	15,000 N	15,000 N	15,000 N

1) with directly mounted full drill 2) with mounted drill chuck adapter and drill chuck



100 %

Time & costs:
Full drilling

Full drilling:

Pre-drilling usually necessary
Time-consuming tool changes for large drill Ø
Large machining area
High energy expenditure
Poorer drill hole quality (burr)



Savings
up to
40 %

Time & costs:
Core drilling

Core drilling:

no centring or pre-drilling required; the smaller cutting area, makes for far faster work and requires less energy
Drilling to max. 120 mm Ø, also overlapping
Highest quality (burr, surface)
far more cost-efficient than pre-drilling
faster tool changes due to "Lock & Load" system except MB 754/1204

MB – High-quality magnetic core drilling machines for versatile use.

Drilling large diameters economically and rapidly

- ▶ For core drills with 19 mm Weldon shaft
- ▶ Stable drilling guidance thanks to long and especially deep-mounted spindle sleeve guidance
- ▶ Device is earthed and double isolated, hence ideal for building sites
- ▶ High magnetic holding force
- ▶ Highest-quality design
- ▶ The coolant is routed through the drill
- ▶ With quick-release chuck for convenient core drill changing (for MB 351 and 502)
- ▶ Conversion from core to full drilling in just a few actions

- ▶ Safe and reliable function
- ▶ **Special features MB 502**
- ▶ Two speeds
- ▶ with 2,000 Watt motor
- ▶ Max. magnetic holding force of 32,000 N
- ▶ **Special features MB 502 E**
- ▶ 2 speeds
- ▶ Large travel path by the drill head
- ▶ with 1,100 Watt motor
- ▶ Max. magnetic holding force of 17,000 N

- ▶ **Special features MB 754**
- ▶ 4 speeds
- ▶ With 2,000 Watt motor
- ▶ Max. magnetic holding force of 32,000 N
- ▶ With spindle chuck MK 3
- ▶ Clockwise/Anti-clockwise rotation
- ▶ **Special features MB 1204**
- ▶ 4 speeds
- ▶ With 2,000 Watt motor
- ▶ Max. magnetic holding force of 32,000 N
- ▶ Clockwise/Anti-clockwise rotation


MB 351

- ▶ 1 Speed
- ▶ With quick-release chuck
- ▶ 1,100 Watt motor


MB 502 E

- ▶ 2 speeds
- ▶ With quick-release chuck
- ▶ With 1,100 Watt motor
- ▶ Large travel path by the drill head


MB 502

- ▶ Two speeds
- ▶ With 2,000 Watt motor
- ▶ With quick-release chuck
- ▶ Max. magnetic holding force 32,000 N

Model	MB 351	MB 502 E	MB 502	MB 754	MB 1204
Art. no.	3860351	3860500	3860502	3860754	3861204
Technical specifications	Feed Manual	Feed Manual	Feed Manual	Feed Manual	Feed Manual
Max. drill Ø / Core drilling	35 mm	50 mm	50 mm	75 mm	120 mm
Max. drilling depth / Core drilling	50 mm	50 mm	75 mm	50 mm	75 mm
Max. drill Ø / Full drilling ¹	-	-	-	32 mm	32 mm
Max. drilling depth / Full drilling ¹	-	-	-	150 mm	150 mm
Max. drill Ø / Full drilling ²	13 mm	13 mm	16 mm	16 mm	16 mm
Max. drilling depth / Full drilling ²	140 mm	140 mm	110 mm	110 mm	110 mm
Spindle chuck	M 24	Fixed	M 24	MK 3	MK 3
Weldon shaft holder	19 mm	19 mm	19 mm	19 mm	19 mm
Speed under load in rpm	330	180/270	230/300	90/120/180/230	120/220/250/450
Motor output	1,100 Watts	1,100 Watts	2,000 Watts	2,000 Watts	2,000 Watts
Electrical connections	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz
Magnetic foot dimensions	165 x 80 mm	180 x 90 mm	200 x 100 mm	200 x 100 mm	210 x 120 mm
Magnetic holding force	15,000 N	17,000 N	32,000 N	32,000 N	32,000 N
Max. dimension in mm	450 x 330 x 260	330 x 125 x 476	330 x 125 x 476	330 x 125 x 476	330 x 125 x 476
Weight	12.6 kg	15 kg	22.9 kg	24.8 kg	28.3 kg

1) with directly mounted full drill 2) with mounted drill chuck adapter and drill chuck

Scope of supply MB 351, MB 502, MB 754, MB 1204

- ▶ 1 coolant tank and coolant line
- ▶ 1 Protection device
- ▶ Operating tool
- ▶ Plastic carrying case
- ▶ 1 Chain
- ▶ MB 754 also with clearing cotter



**Fastening element
specially for the MB 754
for fastening on pipes**

- ▶ Easy assembly
- ▶ Stable and reliable

Art no. 3867504



MB 754

- ➔ Four speeds
- ➔ With 2,000 Watt motor
- ➔ Max. magnetic holding force 32,000 N
- ➔ With spindle chuck MK 3
- ➔ Clockwise/Anti-clockwise rotation



MB 1204

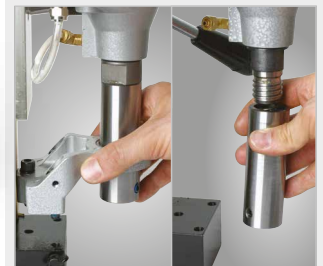
- ➔ Four speeds
- ➔ With 2,000 Watt motor
- ➔ Max. magnetic holding force 32,000 N
- ➔ Clockwise/Anti-clockwise rotation
- ➔ Variable Speed
- ➔ With spindle chuck MK 3



Multiple speed ranges adjustable for the models MB 502, MB 502 E, MB 754 and MB 1204



Quick-release chuck (for MB 351 and MB 502)



Conversion from core to full drilling with just a few actions

Large diameters, drilled more economically and faster than with full drilling



Full drilling:
Pre-drilling usually necessary
Time-consuming tool changes for large drill Ø
Large machining area
High energy expenditure
Poorer drill hole quality (burr)



Core drilling:
no centring or pre-drilling required; the smaller cutting area, makes for far faster work and requires less energy
Drilling up to max. 120 mm Ø, also overlapping highest quality (burr, surface) far more cost-efficient than full drilling faster tool changes thanks to "Lock & Load" system except MB 754/1204

RB – Pipe drilling machine with keyhole saw and low installation height.

MB – High-quality magnetic core drilling machines for versatile use.

- ▶ For core drills with 19 mm Weldon shaft (apart from RB 127)
- ▶ Stable drilling guidance thanks to long and especially deep-mounted spindle sleeve guidance
- ▶ Device is earthed and double isolated, hence ideal for building sites
- ▶ High magnetic holding force (apart from RB 127)
- ▶ Highest-quality design
- ▶ The coolant is routed through the drill (apart from RB 127 and MB 351 F)
- ▶ Conversion from core to full drilling in just a few actions
- ▶ Safe and reliable functions

- ▶ **Special features pipe drill RB 127**
- ▶ Integrated spirit level
- ▶ Cutting holes up to 127 mm possible
- ▶ Horizontal and vertical working position possible
- ▶ Holder for pipes with simple quick-release system and chain
- ▶ Low installation height

- ▶ **Special features MB 351 F**
- ▶ Balanced carrying comfort
- ▶ Operating lever can be used on both sides
- ▶ LED light for dark work areas
- ▶ Practical and lightweight
- ▶ Optimum use in cramped conditions
- ▶ **Special features MB 202 G**
- ▶ Integrated and automatic coolant supply
- ▶ Tapping drill direction of rotation can be changed without changing the direction or stopping of the motor
- ▶ 3 functions: Thread tapping, core drilling and full drilling



- ➔ 1 Speed
- ➔ 1,100 Watt motor
- ➔ Integrated spirit level



- ➔ 1 Speed
- ➔ With quick-release chuck
- ➔ 1,100 Watt motor
- ➔ LED light for dark work areas
- ➔ Operating lever can be used on both sides
- ➔ Optimum use in cramped conditions

Model	RB 127	MB 351 F	MB 301 auto		MB 202 G
Art. no.	3860127	3860350	3860300		3862000
Technical specifications	Feed Manual	Feed Manual	Feed Manual	Feed Auto	Feed Manual
	127 mm	-	-	-	-
Keyhole sawing max. Ø	-	35 mm	35 mm	30 mm	35 mm
Max. drill Ø / Core drilling	-	30 mm	50 mm	45 mm	50 mm
Max. drilling depth / Core drilling	-	-	13 mm	-	13 mm
Max. drill Ø / Full drilling ¹	-	-	110 mm	-	110 mm
Max. drilling depth / Full drilling ¹	5/8"-16	Fixed	M 24		Fixed
Spindle chuck	-	19 mm	19 mm		19 mm
Weldon shaft holder	-	390	330		330
Speed under load in rpm	1,100 Watts	1,100 Watts	1,100 Watts		1,100 Watts
Motor output	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz		230 V/50 Hz
Electrical connections	-	165 x 80 mm	165 x 80 mm		180 x 80 mm
Magnetic foot dimensions	-	15,000 N	15,000 N		15,000 N
Magnetic holding force	319 x 270 x 302	285 x 101 x 200	280 x 205 x 395		280 x 205 x 395
Max. dimension in mm	14.5 kg	10 kg	16.5 kg		13.7 kg
Weight					

1) with mounted drill chuck adapter and drill chuck

Scope of supply RB 127, MB 301 auto, MB 351 F, MB 202 G

- ▶ 1 Coolant tank and coolant pipe (only 301 and 202 G)
- ▶ 1 Protection device
- ▶ Operating tool
- ▶ Plastic carrying case
- ▶ Holder for pipes 32 - 203 mm (RB 127)
- ▶ Integrated spirit level (RB 127)



RB 127
Holder for pipes 32 - 203 mm



MB 301 auto

- ➔ 1 Speed
- ➔ 1,100 Watt motor
- ➔ The factory standard automatic spindle sleeve feed ensures economical and fatigue-free work

MB 301 auto
with automatic
Spindle sleeve feed



MB 202 G

- ➔ Integrated automatic coolant supply
- ➔ Tapping drill direction of rotation can be changed (without changing the direction or stopping of the motor)
- ➔ 3 functions: Thread tapping, core drilling and full drilling



RB 127 with integrated spirit level



MB 351 F with freely adjustable lever



LED light for dark work areas with MB 351 F



Optimum stable drilling guidance thanks to long and especially deep mounted spindle sleeve guidance



Conversion from core to full drilling with just a few actions

Large diameters, drilled more economically and faster than with full drilling



Full drilling:
Pre-drilling usually necessary
Time-consuming tool changes for large drill Ø
Large machining area
High energy expenditure
Poorer drill hole quality (burr)



Core drilling:
no centring or pre-drilling required; the smaller cutting area, makes for far faster work and requires less energy
Drilling to max. 120 mm Ø, also overlapping
Highest quality (burr, surface)
far more cost-efficient than pre-drilling
faster tool changes due to "Lock & Load" system except MB 754/1204

Accessories for Metallkraft magnetic drilling machines

Accessories MB 351



Chuck adapter 1/2" x 20 AG
(also fits MB 502 E)
Art no. 3876001



Drill chuck 1.5 - 13 mm and key (also fits MB 502 E)
Art no. 3876002



Quick release drill chuck M 24*
Art no. 3877351

* allows for use of all core drill models listed in the catalogue

Accessories MB 502



Chuck adapter 1/2" x 20 AG
Art no. 3876004



Drill chuck 1 - 16 mm and key
(not for MB 502 E)
Art no. 3876005



Quick release drill chuck M 27*
Art. no. 3877502



Chuck adapter MB502E
(Only for 3876002, not with 3876005)
Art. no. 3876020

* allows for use of all core drill models listed in the catalogue

Accessories MB 754



Chuck adapter MK 3
Art no. 3876007



Drill chuck 1 - 16 mm and key
Art no. 3876005



Thread tapping chuck M 3 - 12
Art no. 3876017



Thread tapping chuck M 8 - 20
Art no. 3876018

Thread tapping insert

for	Art. no.
M 5	3876009
M 6	3876010
M 8	3876011
M 10	3876012
M 12	3876013
M 16	3876014
M 20	3876015



Core-drill set 6-part
in a practical plastic case
(Ø 12, 14, 18, 16, 20, 22 mm
Length: 25 mm)

Art no. 3873008

Now with 18 mm BLUE-LINE drill bit!

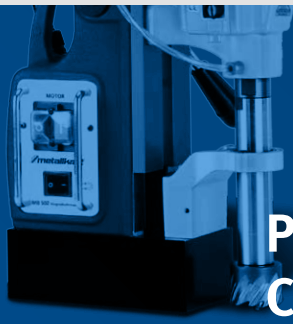


Try a core drill with a universal chuck to our highest quality standard BLUE-LINE with patented Durablue-coating for extreme surface hardness and smoothness. for maximum service life even in dry drilling.

Chipmag swarf remover

For removing magnetic metal swarf for cleaning, e.g., the core drilling interior surface and collecting magnetic small parts
Art no. 3850010,





Product info

Core bit quality



SILVER-LINE



GOLD-LINE



BLUE-LINE



BLUE-LINE PRO



HARD-LINE



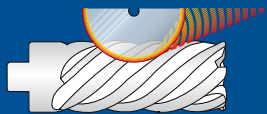
Made of high-alloyed HSS-XE special steel. For extreme hardness at the tip of the tooth (up to 68 HRC). And thus for a long service life.



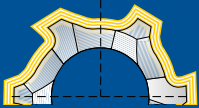
Made of ASP powder steel for drilling of difficult materials like railway tracks, stainless steels, exotic alloys. Always deployable wherever maximum service life is needed.



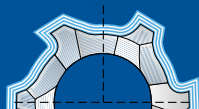
Only a few manufacturers are capable of producing hardened HSS core drills. For Karnasch this is "standard". Only this helps us produce extremely hard tooth tips (68 HRC) but with a flexible core drill.



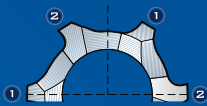
HSS-XE/ASP core drills completely ground from solid material. This finish increases the cutting ability while reducing friction at the same time. For a longer service life.



Gold-Tech surface treatment. The special treatment for a longer service life.



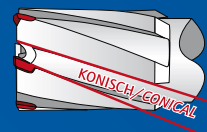
Our premium HSS-XE/ASP core drills + solid drills feature the unique and patented Durablue coating. Extreme surface hardness and smoothness guarantee an amazing service life even under less than optimum conditions like "overhead work", dry drilling, etc.



With HSS-XE/ASP core drills we are not happy with just one cutting edge geometry. Five geometries have been optimally adapted to the various diameters and cutting depths. You can always look forward to the perfect geometry.



Karnasch carbide core drills (Hard-Line) are manufactured with an elaborate pre-/intermediate-/post-cutting geometry. This results in: low-vibration, quiet and easy cutting with longest service lives.







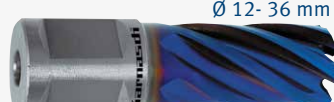





















Karnasch carbide core drills (Hard-Line) are made with a conical helix for a clean chip flow and highest cutting ability even with difficult materials. (heavy duty cutting)



Karnasch carbide core drills (Hard-Line) are exclusively equipped with Sandvik carbide teeth. Our opinion is: Only the best carbide is good enough for Karnasch core drills.

✓	✓	✓		
			✓	
✓	✓	✓	✓	
	✓	✓	✓	
	✓			
		✓	✓	
✓	✓	✓	✓	
				✓
				✓
				✓

<p>Ø 12- 150 mm</p>  <p>HARD-LINE</p> <p>Carbide-tipped core drills The best performing core drill in our product range Excellent for all steels up to 1400 N strength, and for all stainless steels.</p>	 Steel < 1400 N ✓  Stainless steel > 900 N ✓  Grey cast iron ✓  Aluminium > 10% Si ✓  Copper, brass, Tin ✓
<p>Ø 12- 36 mm</p>  <p>BLUE-LINE PRO</p> <p>Powder steel core drills + DURABLU coating. For the most difficult cutting tasks. Good for all steels up to 1400 N strength, and for all stainless steels.</p>	 Steel < 1400 N ✓  Stainless steel > 900 N ✓  Grey cast iron ✓  Aluminium > 10% Si ✓  Copper, brass, Tin ✓
<p>Ø 12- 60 mm</p>  <p>BLUE-LINE</p> <p>Core drills made of HSS-XE special steel + DURABLU coating. The most popular coated core drill for all steels up to 1100 N strength, and for all stainless steels.</p>	 Steel < 1400 N ✓  Stainless steel > 900 N ✓  Grey cast iron ✓  Aluminium > 10% Si ✓  Copper, brass, Tin ✓
<p>Ø 12- 60 mm</p>  <p>GOLD-LINE</p> <p>Core drills made of HSS-XE special steel + GOLD TECH treatment. The most popular non-coated core drill for all steels up to 900 N strength. Also suitable for stainless steel.</p>	 Steel < 1400 N ✓  Stainless steel > 900 N ✓  Aluminium > 10% Si ✓
<p>Ø 12- 60 mm</p>  <p>SILVER-LINE</p> <p>Core drills made of HSS-XE special steel + 7 different cutting geometries. for all steels up to 750 N strength.</p>	 Steel < 750 N ✓  Aluminium > 10% Si ✓  Copper, brass, tin ✓

Feed mm/rev.

Feed for HSS-XE/ASP
Core drill: Silver-Line, Gold-Line,
Blue-Line, Blue-Line Pro

Feed guide values for
HM core drills: Hard-Line

	Steel < 500 N	0.15	0.10
	Steel < 750 N	0.18	0.10
	Steel < 900 N	0.16	0.10-0.12
	Steel < 1200 N	0.16	0.10-0.15
	Steel < 1400 N	0.17	0.16
	Stainless steel	0.10	0.13
	Aluminium	0.25	0.24
	Grey cast iron	0.16	0.08-0.13
	Bronze	0.18	0.12
	Copper	0.21	0.12

Grey cast iron cutting cooling: dry/compressed air
cutting oil is recommended for all other materials!

Instructions for use:

- Centre punching for core drills. For core drills with a diameter of 12-15 mm it is absolutely necessary to create a strong centre mark. Make sure that the tip of the ejector pin is positioned exactly in the middle of the centre mark. Highly recommendable also for all other diameters.
- Speeds for core drills. For HSS core bits 12 - 15 mm, a minimum speed of 450 rpm must be adhered to. For HM core bits, a minimum of approx. 600 rpm would be optimal. If this is not possible, you will need to work at half the recommended feed speed.
- Feed. Always initially drill slowly and carefully to a depth of 1 mm. You can then continue at the normal feed speed. Please take this advice to heart. It will significantly extend the drill's service life.
- Drilling. It may be necessary to repeatedly ventilate the drill depending on the chip flow. This is especially true of cutting depths from approx. 25 mm. If you feel more pronounced resistance or vibrations, please immediately proceed as follows:
 - Exit the borehole while drill is turning.
 - Clean the swarf off the drill and hole (e.g., with a blow-gun)
 - Fill the hole with cooling and lubricating emulsion.
 - Insert the drill into the hole again while it is rotating. Do not change the position of the machine or the workpiece during the entire process.
 - This procedure may need to be repeated depending on the chip flow and drilling depth.
- Cooling. Use only high-performance cutting oils. As of approx. 35mm Ø only use Morse taper seats with automatic internal cooling.

Speeds

Speeds for HSS-XE/ASP core drills
Silver-Line, Gold-Line, Blue-Line, Blue-Line Pro

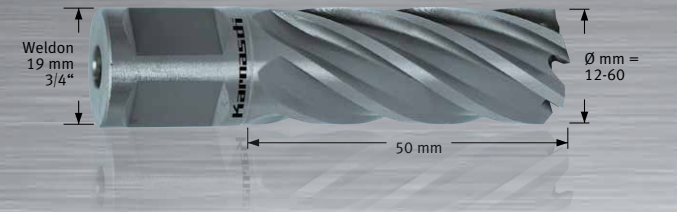
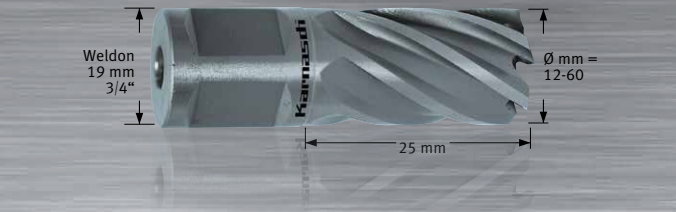


Ø	mm Inches	12-18 7/16" - 11/16"	19-25 3/4" - 1"	26-32 1 1/16" - 1 1/4"	33-39 1 5/16" - 1 9/16"	40-46 1 5/8" - 1 13/16"	47-53 1 7/8" - 2 1/16"	54-60 2 1/8" - 2 3/8"	61-70 2 13/32" - 2 3/4"	71-80 2 51/64" - 3 5/32"	81-90 3 3/16" - 3 9/16"	91-100 3 19/32" - 3 15/16"	101-112 3 31/32" - 4 13/32"	113-124 4 15/32" - 4 7/8"	125-136 4 15/16" - 5 11/32"	137-150 5 13/32" - 5 29/32"
	Steel ◀ 500 N	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
		440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
	Steel ◀ 750 N	530	340	245	195	160	135	115	163	87	77	68	62	55	50	45
		350	250	200	165	140	120	105	90	78	70	63	56	51	46	42
	Steel ◀ 900 N	340	250	185	145	120	100	88	78	67	58	52	47	41	38	34
		265	190	150	125	105	90	80	68	59	53	48	42	39	35	31
	Steel ◀ 1200 N	265	165	125	95	79	67	58	52	44	39	34	31	27	25	22
		175	130	100	80	70	60	53	45	40	35	32	28	26	23	21
	Steel ◀ 1400 N	185	117	85	67	55	47	41	36	30	26	23	21	18	16	16
		125	90	70	57	48	42	37	31	27	24	22	19	17		14
	Stainless steel	320	200	145	115	90	80	70	62	53	46	41	37	32	29	27
		210	150	120	95	85	72	63	54	47	42	38	33	30	28	25
	Aluminium	980	620	455	360	295	250	220	193	165	145	129	116	104	94	85
		655	470	370	305	255	225	195	170	150	130	117	105	95	86	78
	Grey cast iron	480	300	200	175	143	122	106	93	80	70	62	56	50	45	41
		320	230	180	147	125	108	95	81	71	63	57	51	46	42	38
	Bronze	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
		440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
	Copper	1060	670	490	390	320	270	235	205	178	157	138	127	110	100	90
		700	510	400	330	280	240	210	180	160	140	130	115	105	95	85

Rotational speed guide values for HM core bits
Hard-Line



Ø	mm Inches	12-18 7/16" - 11/16"	19-25 3/4" - 1"	26-32 1 1/16" - 1 1/4"	33-39 1 5/16" - 1 9/16"	40-46 1 5/8" - 1 13/16"	47-53 1 7/8" - 2 1/16"	54-60 2 1/8" - 2 3/8"	61-70 2 13/32" - 2 3/4"	71-80 2 51/64" - 3 5/32"	81-90 3 3/16" - 3 9/16"	91-100 3 19/32" - 3 15/16"	101-112 3 31/32" - 4 13/32"	113-124 4 15/32" - 4 7/8"	125-136 4 15/16" - 5 11/32"	137-150 5 13/32" - 5 29/32"
	Steel ◀ 500 N	1060	670	490	390	320	270	235	205	178	157	138	127	110	100	90
		700	510	400	330	280	240	210	180	160	140	130	115	105	95	85
	Steel ◀ 750 N	980	620	450	360	295	250	220	193	165	145	129	115	104	94	85
		655	470	370	300	260	225	195	170	150	130	120	105	95	87	78
	Steel ◀ 900 N	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
		620	450	340	285	240	210	185	160	140	125	110	100	90	81	75
	Steel ◀ 1200 N	795	500	370	290	240	200	175	155	135	117	104	94	84	76	69
		530	380	300	245	265	180	160	135	120	105	95	85	77	70	63
	Steel ◀ 1400 N	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
		440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
	Stainless steel	530	340	245	195	160	135	115	103	87	77	68	62	55	56	45
		350	250	200	165	140	120	105	90	78	70	63	56	51	46	42
	Aluminium	2390	1510	1100	870	715	610	530	470	405	355	315	283	253	229	209
		1590	1150	895	735	625	540	480	410	360	320	285	255	230	210	190
	Grey cast iron	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
		620	450	340	285	240	210	185	160	140	125	110	100	90	81	75
	Bronze	1325	840	615	490	400	340	295	260	225	195	174	157	140	127	116
		885	635	500	410	345	300	265	230	200	175	160	145	130	117	105
	Copper	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
		620	450	340	285	240	210	185	160	140	125	110	100	90	81	75



Ø mm	38720.1255	€	Ø mm	38720.1255	€
12	38720.1255 12		37	38720.1255 37	
13	38720.1255 13		38	38720.1255 38	
14	38720.1255 14		39	38720.1255 39	
15	38720.1255 15		40	38720.1255 40	
16	38720.1255 16		41	38720.1255 41	
17	38720.1255 17		42	38720.1255 42	
18	38720.1255 18		43	38720.1255 43	
19	38720.1255 19		44	38720.1255 44	
20	38720.1255 20		45	38720.1255 45	
21	38720.1255 21		46	38720.1255 46	
22	38720.1255 22		47	38720.1255 47	
23	38720.1255 23		48	38720.1255 48	
24	38720.1255 24		49	38720.1255 49	
25	38720.1255 25		50	38720.1255 50	
26	38720.1255 26		51	38720.1255 51	
27	38720.1255 27		52	38720.1255 52	
28	38720.1255 28		53	38720.1255 53	
29	38720.1255 29		54	38720.1255 54	
30	38720.1255 30		55	38720.1255 55	
31	38720.1255 31		56	38720.1255 56	
32	38720.1255 32		57	38720.1255 57	
33	38720.1255 33		58	38720.1255 58	
34	38720.1255 34		59	38720.1255 59	
35	38720.1255 35		60	38720.1255 60	
36	38720.1255 36				

Ø mm	38720.1265	€	Ø mm	38720.1265	€
12	38720.1265 12		37	38720.1265 37	
13	38720.1265 13		38	38720.1265 38	
14	38720.1265 14		39	38720.1265 39	
15	38720.1265 15		40	38720.1265 40	
16	38720.1265 16		41	38720.1265 41	
17	38720.1265 17		42	38720.1265 42	
18	38720.1265 18		43	38720.1265 43	
19	38720.1265 19		44	38720.1265 44	
20	38720.1265 20		45	38720.1265 45	
21	38720.1265 21		46	38720.1265 46	
22	38720.1265 22		47	38720.1265 47	
23	38720.1265 23		48	38720.1265 48	
24	38720.1265 24		49	38720.1265 49	
25	38720.1265 25		50	38720.1265 50	
26	38720.1265 26		51	38720.1265 51	
27	38720.1265 27		52	38720.1265 52	
28	38720.1265 28		53	38720.1265 53	
29	38720.1265 29		54	38720.1265 54	
30	38720.1265 30		55	38720.1265 55	
31	38720.1265 31		56	38720.1265 56	
32	38720.1265 32		57	38720.1265 57	
33	38720.1265 33		58	38720.1265 58	
34	38720.1265 34		59	38720.1265 59	
35	38720.1265 35		60	38720.1265 60	
36	38720.1265 36				


Ejector pin



6.34 x 77 mm

€
38720.1261


Ejector pin



6.34 x 102 mm


€
38720.1271

SILVER-LINE SET 25



Contents	Ø mm	€
+ 4 ejector pins	14, 16, 18, 20, 22, 26	38720.1474

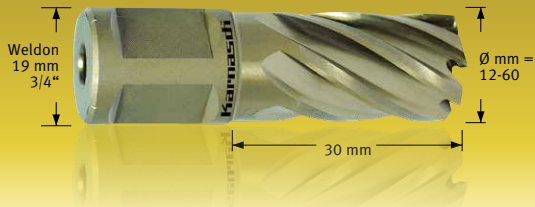
SILVER-LINE SET 50



Contents	Ø mm	€
+ 4 ejector pins	14, 16, 18, 20, 22, 26	38720.1475

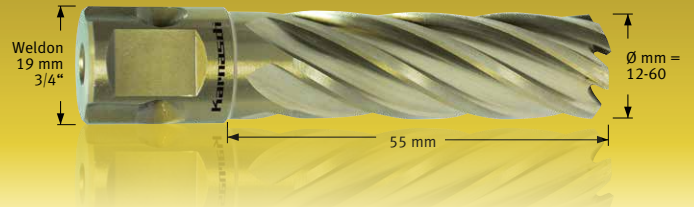
GOLD-LINE 30

WELDON



GOLD-LINE 55

WELDON



Ø mm	38720.1260U	Ø mm	38720.1260U
12	38720.1260U 12	37	38720.1260U 37
13	38720.1260U 13	38	38720.1260U 38
14	38720.1260U 14	39	38720.1260U 39
15	38720.1260U 15	40	38720.1260U 40
16	38720.1260U 16	41	38720.1260U 41
17	38720.1260U 17	42	38720.1260U 42
18	38720.1260U 18	43	38720.1260U 43
19	38720.1260U 19	44	38720.1260U 44
20	38720.1260U 20	45	38720.1260U 45
21	38720.1260U 21	46	38720.1260U 46
22	38720.1260U 22	47	38720.1260U 47
23	38720.1260U 23	48	38720.1260U 48
24	38720.1260U 24	49	38720.1260U 49
25	38720.1260U 25	50	38720.1260U 50
26	38720.1260U 26	51	38720.1260U 51
27	38720.1260U 27	52	38720.1260U 52
28	38720.1260U 28	53	38720.1260U 53
29	38720.1260U 29	54	38720.1260U 54
30	38720.1260U 30	55	38720.1260U 55
31	38720.1260U 31	56	38720.1260U 56
32	38720.1260U 32	57	38720.1260U 57
33	38720.1260U 33	58	38720.1260U 58
34	38720.1260U 34	59	38720.1260U 59
35	38720.1260U 35	60	38720.1260U 60
36	38720.1260U 36		

Ø mm	38720.1270U	Ø mm	38720.1270U
12	38720.1270U 12	37	38720.1270U 37
13	38720.1270U 13	38	38720.1270U 38
14	38720.1270U 14	39	38720.1270U 39
15	38720.1270U 15	40	38720.1270U 40
16	38720.1270U 16	41	38720.1270U 41
17	38720.1270U 17	42	38720.1270U 42
18	38720.1270U 18	43	38720.1270U 43
19	38720.1270U 19	44	38720.1270U 44
20	38720.1270U 20	45	38720.1270U 45
21	38720.1270U 21	46	38720.1270U 46
22	38720.1270U 22	47	38720.1270U 37
23	38720.1270U 23	48	38720.1270U 48
24	38720.1270U 24	49	38720.1270U 49
25	38720.1270U 25	50	38720.1270U 50
26	38720.1270U 26	51	38720.1270U 51
27	38720.1270U 27	52	38720.1270U 52
28	38720.1270U 28	53	38720.1270U 53
29	38720.1270U 29	54	38720.1270U 54
30	38720.1270U 30	55	38720.1270U 55
31	38720.1270U 31	56	38720.1270U 56
32	38720.1270U 32	57	38720.1270U 57
33	38720.1270U 33	58	38720.1270U 58
34	38720.1270U 34	59	38720.1270U 59
35	38720.1270U 35	60	38720.1270U 60
36	38720.1270U 36		

Ejector pin



€
38720.1261

Ejector pin



€
38720.1271

GOLD-LINE SET 30



Contents	Ø mm	€
+ 4 ejector pins	14, 16, 18, 20, 22, 26	38720.1322

GOLD-LINE SET 55



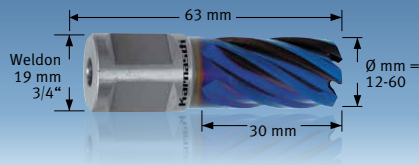
Contents	Ø mm	€
+ 4 ejector pins	14, 16, 18, 20, 22, 26	38720.1332

Suitable for
core drilling
machines

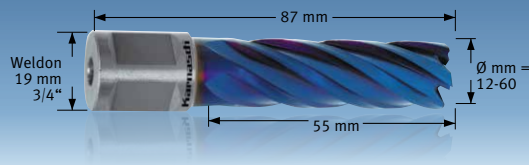
Metallkraft, Alfa-Rotabest + Alfa Rota-Quick, BDS + BDS Keyless, Bektop, Bux, Euroboor, Evolution, Hougen, Jancy, Magbroach, Magtron, Magnetor, Promag, Rotabroach, Ruko + Ruko Easy Lock, Universal...

! All prices are quoted net, plus VAT at the current rate.

BLUE-LINE
30
WELDON



BLUE-LINE
55
WELDON



Ø mm	38720.1312		Ø mm	38720.1312	
12	38720.1312 12		37	38720.1312 37	
13	38720.1312 13		38	38720.1312 38	
14	38720.1312 14		39	38720.1312 39	
15	38720.1312 15		40	38720.1312 40	
16	38720.1312 16		41	38720.1312 41	
17	38720.1312 17		42	38720.1312 42	
18	38720.1312 18		43	38720.1312 43	
19	38720.1312 19		44	38720.1312 44	
20	38720.1312 20		45	38720.1312 45	
21	38720.1312 21		46	38720.1312 46	
22	38720.1312 22		47	38720.1312 47	
23	38720.1312 23		48	38720.1312 48	
24	38720.1312 24		49	38720.1312 49	
25	38720.1312 25		50	38720.1312 50	
26	38720.1312 26		51	38720.1312 51	
27	38720.1312 27		52	38720.1312 52	
28	38720.1312 28		53	38720.1312 53	
29	38720.1312 29		54	38720.1312 54	
30	38720.1312 30		55	38720.1312 55	
31	38720.1312 31		56	38720.1312 56	
32	38720.1312 32		57	38720.1312 57	
33	38720.1312 33		58	38720.1312 58	
34	38720.1312 34		59	38720.1312 59	
35	38720.1312 35		60	38720.1312 60	
36	38720.1312 36				

Ø mm	38720.1313		Ø mm	38720.1313	
12	38720.1313 12		37	38720.1313 37	
13	38720.1313 13		38	38720.1313 38	
14	38720.1313 14		39	38720.1313 39	
15	38720.1313 15		40	38720.1313 40	
16	38720.1313 16		41	38720.1313 41	
17	38720.1313 17		42	38720.1313 42	
18	38720.1313 18		43	38720.1313 43	
19	38720.1313 19		44	38720.1313 44	
20	38720.1313 20		45	38720.1313 45	
21	38720.1313 21		46	38720.1313 46	
22	38720.1313 22		47	38720.1313 47	
23	38720.1313 23		48	38720.1313 48	
24	38720.1313 24		49	38720.1313 49	
25	38720.1313 25		50	38720.1313 50	
26	38720.1313 26		51	38720.1313 51	
27	38720.1313 27		52	38720.1313 52	
28	38720.1313 28		53	38720.1313 53	
29	38720.1313 29		54	38720.1313 54	
30	38720.1313 30		55	38720.1313 55	
31	38720.1313 31		56	38720.1313 56	
32	38720.1313 32		57	38720.1313 57	
33	38720.1313 33		58	38720.1313 58	
34	38720.1313 34		59	38720.1313 59	
35	38720.1313 35		60	38720.1313 60	
36	38720.1313 36				

Ejector pin



€
38720.1261

Ejector pin



€
38720.1271

BLUE-LINE SET 30



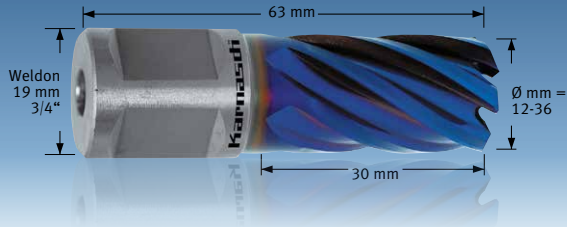
Contents	Ø mm	€
12, 14, 16, 18, 20, 22, 26	14, 16, 18, 20, 22, 26	38720.1325
+ 4 ejector pins		

BLUE-LINE SET 55

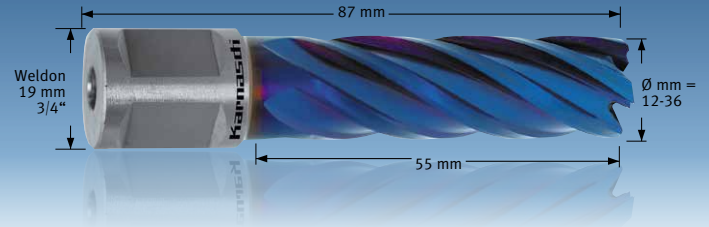


Contents	Ø mm	€
14, 16, 18, 20, 22, 26	14, 16, 18, 20, 22, 26	38720.1328
+ 4 ejector pins		

BLUE-LINE PRO 30 WELDON



BLUE-LINE PRO 55 WELDON



Ø mm	38720.1284		Ø mm	38720.1284	
12	38720.1284 12		25	38720.1284 25	
13	38720.1284 13		26	38720.1284 26	
14	38720.1284 14		27	38720.1284 27	
15	38720.1284 15		28	38720.1284 28	
16	38720.1284 16		29	38720.1284 29	
17	38720.1284 17		30	38720.1284 30	
18	38720.1284 18		31	38720.1284 31	
19	38720.1284 19		32	38720.1284 32	
20	38720.1284 20		33	38720.1284 33	
21	38720.1284 21		34	38720.1284 34	
22	38720.1284 22		35	38720.1284 35	
23	38720.1284 23		36	38720.1284 36	
24	38720.1284 24				

Ø mm	38720.1317		Ø mm	38720.1317	
12	38720.1317 12		25	38720.1317 25	
13	38720.1317 13		26	38720.1317 26	
14	38720.1317 14		27	38720.1317 27	
15	38720.1317 15		28	38720.1317 28	
16	38720.1317 16		29	38720.1317 29	
17	38720.1317 17		30	38720.1317 30	
18	38720.1317 18		31	38720.1317 31	
19	38720.1317 19		32	38720.1317 32	
20	38720.1317 20		33	38720.1317 33	
21	38720.1317 21		34	38720.1317 34	
22	38720.1317 22		35	38720.1317 35	
23	38720.1317 23		36	38720.1317 36	
24	38720.1317 24				

Ejector pin



€
38720.1261

Ejector pin



€
38720.1271

BLUE-LINE PRO SET 30



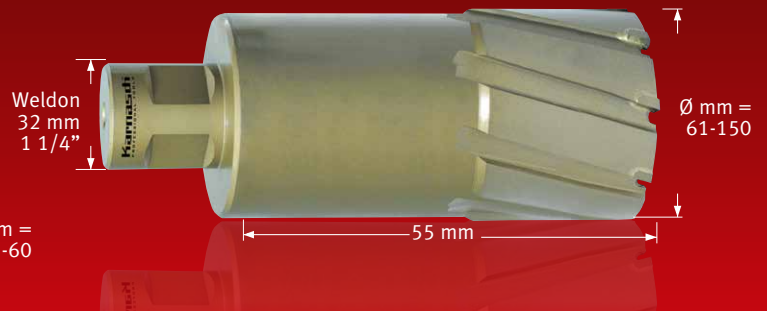
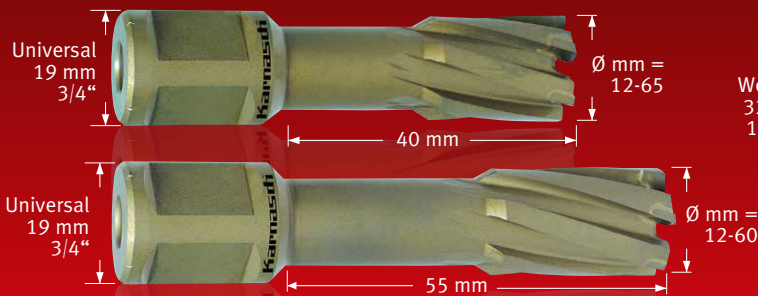
Contents	Ø mm	€
+ 4 ejector pins	14, 16, 18, 20, 22, 26	38720.1331

BLUE-LINE PRO SET 55



Contents	Ø mm	€
+ 4 ejector pins	14, 16, 18, 20, 22, 26	38720.1334

Core bits



Ø mm	38720.1315	Ø mm	38720.1315	Ø mm	38720.1315
12	38720.1315-12	38	38720.1315-38	64	38720.1315-64
13	38720.1315-13	39	38720.1315-39	65	38720.1315-65
14	38720.1315-14	40	38720.1315-40	66*	38720.1315-66
15	38720.1315-15	41	38720.1315-41	67*	38720.1315-67
16	38720.1315-16	42	38720.1315-42	68*	38720.1315-68
17	38720.1315-17	43	38720.1315-43	69*	38720.1315-69
18	38720.1315-18	44	38720.1315-44	70*	38720.1315-70
19	38720.1315-19	45	38720.1315-45	71*	38720.1315-71
20	38720.1315-20	46	38720.1315-46	72*	38720.1315-72
21	38720.1315-21	47	38720.1315-47	73*	38720.1315-73
22	38720.1315-22	48	38720.1315-48	74*	38720.1315-74
23	38720.1315-23	49	38720.1315-49	75*	38720.1315-75
24	38720.1315-24	50	38720.1315-50	76*	38720.1315-76
25	38720.1315-25	51	38720.1315-51	77*	38720.1315-77
26	38720.1315-26	52	38720.1315-52	78*	38720.1315-78
27	38720.1315-27	53	38720.1315-53	79*	38720.1315-79
28	38720.1315-28	54	38720.1315-54	80*	38720.1315-80
29	38720.1315-29	55	38720.1315-55	85*	38720.1315-85
30	38720.1315-30	56	38720.1315-56	90*	38720.1315-90
31	38720.1315-31	57	38720.1315-57	95*	38720.1315-95
32	38720.1315-32	58	38720.1315-58	100*	38720.1315-100
33	38720.1315-33	59	38720.1315-59	105*	38720.1315-105
34	38720.1315-34	60	38720.1315-60	110*	38720.1315-110
35	38720.1315-35	61	38720.1315-61	115*	38720.1315-115
36	38720.1315-36	62	38720.1315-62	120*	38720.1315-120
37	38720.1315-37	63	38720.1315-63		

* as of Ø 66 mm the Weldon 32 mm seat is required

Ø mm	38720.1316	Ø mm	38720.1316	Ø mm	38720.1316
12	38720.1316-12	41	38720.1316-41	74	38720.1316-74
13	38720.1316-13	42	38720.1316-42	75	38720.1316-75
14	38720.1316-14	43	38720.1316-43	76	38720.1316-76
15	38720.1316-15	44	38720.1316-44	77	38720.1316-77
16	38720.1316-16	45	38720.1316-45	78	38720.1316-78
17	38720.1316-17	46	38720.1316-46	79	38720.1316-79
17.5	38720.1316-17,5	47	38720.1316-47	80	38720.1316-80
18	38720.1316-18	48	38720.1316-48	82	38720.1316-82
19	38720.1316-19	49	38720.1316-49	83	38720.1316-83
20	38720.1316-20	50	38720.1316-50	84	38720.1316-84
21	38720.1316-21	51	38720.1316-51	85	38720.1316-85
21.5	38720.1316-21,5	52	38720.1316-52	88	38720.1316-88
22	38720.1316-22	53	38720.1316-53	90	38720.1316-90
23	38720.1316-23	54	38720.1316-54	92	38720.1316-92
23.5	38720.1316-23,5	55	38720.1316-55	95	38720.1316-95
24	38720.1316-24	56	38720.1316-56	100	38720.1316-100
25	38720.1316-25	57	38720.1316-57	103	38720.1316-103
25.5	38720.1316-25,5	58	38720.1316-58	104	38720.1316-104
26	38720.1316-26	59	38720.1316-59	105	38720.1316-105
27	38720.1316-27	60	38720.1316-60	106	38720.1316-106
28	38720.1316-28	61	38720.1316-61	108	38720.1316-108
29	38720.1316-29	62	38720.1316-62	110	38720.1316-110
30	38720.1316-30	63	38720.1316-63	115	38720.1316-115
31	38720.1316-31	64	38720.1316-64	120	38720.1316-120
32	38720.1316-32	65	38720.1316-65	125	38720.1316-125
33	38720.1316-33	66	38720.1316-66	130	38720.1316-130
34	38720.1316-34	67	38720.1316-67	135	38720.1316-135
35	38720.1316-35	68	38720.1316-68	140	38720.1316-140
36	38720.1316-36	69	38720.1316-69	145	38720.1316-145
37	38720.1316-37	70	38720.1316-70	150	38720.1316-150
38	38720.1316-38	71	38720.1316-71		
39	38720.1316-39	72	38720.1316-72		
40	38720.1316-40	73	38720.1316-73		

Ejector pin			
	6.34 x 90 mm	Ø 12- 17 mm	€ 38720.1149
	7.98 x 90 mm	Ø 18- 65 mm	€ 38720.1151
	7.98 x 105 mm	Ø 66- 120 mm	€ 38720.1273

HARD-LINE SET 40			
	Contents	Ø mm 14, 16, 18, 20, 22, 26	€ 38720.1336
	+ 4 ejector pins		

Ejector pin			
	6.34 x 102 mm	Ø 12- 17 mm	€ 38720.1271
	7.98 x 105 mm	Ø 18- 60 mm	€ 38720.1273
	7.98 x 118 mm	Ø 61-150 mm	€ 38720.1272

HARD-LINE SET 55			
	Contents	Ø mm 14, 16, 18, 20, 22, 26	€ 38720.1339
	+ 4 ejector pins		

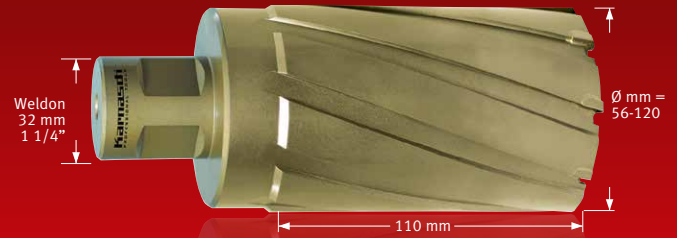
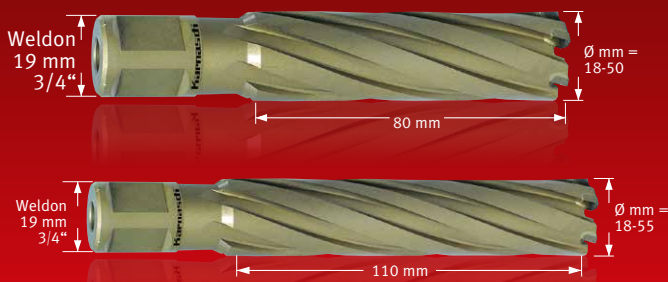
Suitable for
core drilling
machines

Metallkraft, Alfa-Rotabest + Alfa Rota-Quick, BDS + BDS Keyless, Bektap, Bux, Euroboor, Evolution, Hougen, Jancy, Magbroach, Magtron, Magnetor, Promag, Rotabroach, Ruko + Ruko Easy Lock, Universal...

! All prices are quoted net, plus VAT at the current rate.

**HARD-LINE
80
WELDON**

**HARD-LINE
110
WELDON**



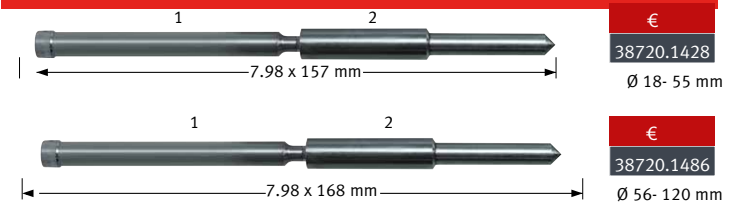
Ø mm	38720.1650	€	Ø mm	38720.1650	€	Ø mm	38720.1650	€	Ø mm	38720.1660	€	Ø mm	38720.1660	€	Ø mm	38720.1660	€
18	387201650-18		43	387201650-43		68	387201650-68		18	387201660-18		43	387201660-43		68	387201660-68	
19	387201650-19		44	387201650-44		69	387201650-69		19	387201660-19		44	387201660-44		69	387201660-69	
20	387201650-20		45	387201650-45		70	387201650-70		20	387201660-20		45	387201660-45		70	387201660-70	
21	387201650-21		46	387201650-46		72	387201650-72		21	387201660-21		46	387201660-46		72	387201660-72	
22	387201650-22		47	387201650-47		73	387201650-73		22	387201660-22		47	387201660-47		73	387201660-73	
23	387201650-23		48	387201650-48		74	387201650-74		23	387201660-23		48	387201660-48		74	387201660-74	
24	387201650-24		49	387201650-49		75	387201650-75		24	387201660-24		49	387201660-49		75	387201660-75	
25	387201650-25		50	387201650-50		76	387201650-76		25	387201660-25		50	387201660-50		76	387201660-76	
26	387201650-26		51	387201650-51		78	387201650-78		26	387201660-26		51	387201660-51		78	387201660-78	
27	387201650-27		52	387201650-52		80	387201650-80		27	387201660-27		52	387201660-52		80	387201660-80	
28	387201650-28		53	387201650-53		82	387201650-82		28	387201660-28		53	387201660-53		82	387201660-82	
29	387201650-29		54	387201650-54		85	387201650-85		29	387201660-29		54	387201660-54		85	387201660-85	
30	387201650-30		55	387201650-55		90	387201650-90		30	387201660-30		55	387201660-55		90	387201660-90	
31	387201650-31		56	387201650-56		95	387201650-95		31	387201660-31		56	387201660-56		95	387201660-95	
32	387201650-32		57	387201650-57		100	387201650-100		32	387201660-32		57	387201660-57		100	387201660-100	
33	387201650-33		58	387201650-58		103	387201650-103		33	387201660-33		58	387201660-58		103	387201660-103	
34	387201650-34		59	387201650-59		104	387201650-104		34	387201660-34		59	387201660-59		104	387201660-104	
35	387201650-35		60	387201650-60		105	387201650-105		35	387201660-35		60	387201660-60		105	387201660-105	
36	387201650-36		61	387201650-61		106	387201650-106		36	387201660-36		61	387201660-61		106	387201660-106	
37	387201650-37		62	387201650-62		108	387201650-108		37	387201660-37		62	387201660-62		108	387201660-108	
38	387201650-38		63	387201650-63		110	387201650-110		38	387201660-38		63	387201660-63		110	387201660-110	
39	387201650-39		64	387201650-64		115	387201650-115		39	387201660-39		64	387201660-64		115	387201660-115	
40	387201650-40		65	387201650-65		120	387201650-120		40	387201660-40		65	387201660-65		120	387201660-120	
41	387201650-41		66	387201650-66					41	387201660-41		66	387201660-66				
42	387201650-42		67	387201650-67					42	387201660-42		67	387201660-67				

Ejector pin, 2-piece

Ejector pin, 2-piece



APPLICATION
Insert part 1 into the core drill shank.
Push part 2 onto part 1. Drill to a cutting depth of approx. 50 mm. Then remove part 2 and continue drilling.



APPLICATION
Insert part 1 into the core drill shank.
Push part 2 onto part 1. Drill to a cutting depth of approx. 50 mm. Then remove part 2 and continue drilling.



Ejector pin, 1-piece

Ejector pin



This one-piece ejector pin can be used in combination with adapter seat Art no. 38720.1291. Drilling depths up to 110 mm in a single work step without changing. Robust and simple.



This one-piece ejector pin can be used in combination with adapter seat Art no. 38720.1291. Drilling depths up to 110 mm in a single work step without changing. Robust and simple.

**Suitable for
core drilling
machines**

Metallkraft, Alfra-Rotabest + Alfra Rota-Quick, BDS + BDS Keyless, Bektop, Bux, Euroboor, Evolution, Hougen, Jancy, Magbroach, Magtron, Magnetor, Promag, Rotabroach, Ruko + Ruko Easy Lock, Universal...

! All prices are quoted net, plus VAT at the current rate.

Seat holder



Quick-Change seat holder **with** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 19 mm (3/4").

Seat holder **with** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 19 mm (3/4").

Lubricants + cutting oil

Heavy-duty cutting oil "MECUTOIL 100". For mixing with water 5% oil = for normal construction steels as well as all NF metals, 10% oil = for steels of higher strength, incl. stainless steels. For difficult machining problems up to 50% oil can be admixed with water. Ideal oil for any machining work. For filling, e.g., into Karnasch cooling pressure cylinders

MORSE-KONUS 2

Morse taper 2

Core drill change within seconds without any tools



€
38720.1303

MORSE-KONUS 2

Morse taper 2



€
38720.1287

MORSE-KONUS 3

Morse taper 3

Core drill change within seconds without any tools



€
38720.1307

MORSE-KONUS 3

Morse taper 3



€
38720.1289

Quick-Change seat holder **without** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 19 mm (3/4").

Seat holder **with** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 32 mm (1 1/4").

MORSE-KONUS 2

Morse taper 2

Core drill change within seconds without any tools



€
38720.1301

MORSE-KONUS 3

Morse taper 3



€
38720.1290

MORSE-KONUS 3

Morse taper 3

Core drill change within seconds without any tools



€
38720.1437

MORSE-KONUS 4

Morse taper 4

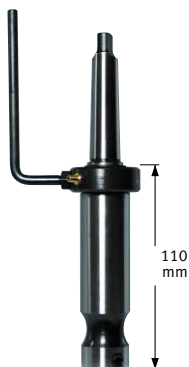


€
38720.1292

MORSE-KONUS 3

Morse taper 3

Extra long seat holder with automatic coolant supply especially for all extra long core drills such as the following series: Gold-Line 80+110, Blue-Line 80+110, Hard-Line 80+110 with universal shank 19 mm (3/4"). With this seat holder you don't need to change the two-piece ejector pins. You can drill as deep as 110 mm in a single work step.



€
38720.1291

Seat holder **without** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 19 mm (3/4").

MORSE-KONUS 2

Morse taper 2



€4
38720.1283



€
38720.1293

Seat holder **without** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 32 mm (1 1/4").

MORSE-KONUS 3

Morse taper 3



€
38720.1286



2.5 kg

€
38760.1100025

10 kg

€
38760.110010

Heavy-duty cutting spray "MECUTSPRAY". Propellant-free thanks to manual pump mechanism. Content 500 ml. The ideal spray for machining work on all steel grades + non-ferrous metals. Bio-degradable as per CC-L-33-T82.



500 ml

€
38760.1150



Universal cutting paste. Paste clings on the tool. Ideal for working in difficult situations, such as "overhead work". For machining work with various steel grades + non-ferrous metals. Free from chlorine.



750 g

750 ml

€
38760.1157

Special cutting wax: Especially for non-ferrous metals like aluminium, copper, brass. Wax clings to the tool. Ideal for, e.g., overhead work. Free from chlorine.



350 g

€
38760.1200



All prices are quoted net, plus VAT at the current rate.

Deburring

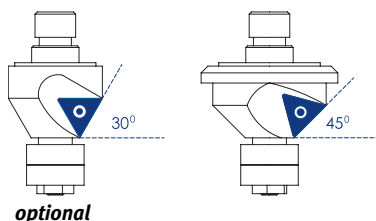


KE 6-2 – Edge deburrer for radii, drill holes, inside and outside edges

- ▶ Ideal for ensuring clean visible edges and preparing welds
- ▶ Handy and powerful device
- ▶ Setting the chamfering height without tool
- ▶ For machining building steel, aluminium and other materials
- ▶ For deburring radii and drill holes from 20 mm diameter
- ▶ With 3-fold turnover plate holder
- ▶ Manual feed
- ▶ Speed from 3,000 to 6,000 rpm continuously variable



KE 6-2 with mounted side handle



optional

Model	KE 6-2
Art. no.	3990007
Technical specifications	
Chamfer angle	45° (optional 30°)
Chamfer width at 45°	0 - 6 mm
Electrical connections	230 V/50 Hz
Output	1,100 Watts
Speed (continuously variable)	3000 - 6000 rpm
Dimensions (L x W x H)	308 x 344 x 273 mm
Weight	4.7 kg

Scope of supply

Plastic case

- ▶ 3-fold turnover plate holder 45°
- ▶ 1x Cutting plate set consisting of three 4x indexing inserts
- ▶ 1x Tool kit
- ▶ 1x Side handle



For ensuring clean visible edges e.g. with steel girders



Chamfer width from 0 to 6 mm continuously variable
Convenient and exact setting of the chamfer width thanks to easy-to-read scale



With 3-fold turnover plate holder

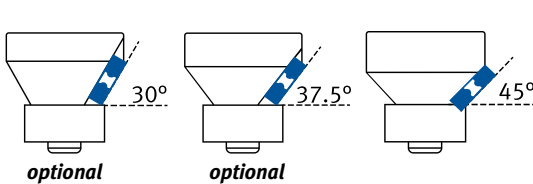


Accessories	Art. no.
① 30° tool holder	3990020
45° tool holder	3990021
Cutting plate set / VE 10	3990022
Guide roller 45°	3990023
Guide roller 30°	3990024

Improved design for easier and better machining

KE 10-2 – Edge deburrer for radii, drill holes, inside and outside edges, up to 10.6 mm chamfer width

- ▶ Ideal for ensuring clean visible edges and preparing welds
- ▶ Handy and powerful device
- ▶ Setting the chamfering height without tool
- ▶ For machining building steel, aluminium and other materials
- ▶ For deburring radii and drill holes from 30 mm diameter
- ▶ With 6-fold turnover plate holder
- ▶ Manual feed
- ▶ Speed from 2,300 to 6,500 rpm continuously variable



Model	KE 10-2
Art. no.	3990012
Technical specifications	
Chamfer angle	45° (optional 30° / 37.5°)
Chamfer width at 45°	0 - 10.6 mm
Electrical connections	230 V/50 Hz
Output	1,800 Watts
Speed (continuously variable)	2300 - 6500 rpm
Dimensions (L x W x H)	485 x 192 x 150 mm
Weight	6.5 kg

Scope of supply
Plastic case
 ▶ 6-fold cutting plate holder 45°
 ▶ 1x Cutting plate set consisting of 6 cutting plates
 ▶ 1x Tool kit
 ▶ 1x Front handle

Accessories	Art. no.
① Cutting plate set (6 pieces)	3991110
Milling head and guide roller 45°	3991111
Milling head and guide roller 30°	3991112
Milling head and guide roller 37.5°	3991113

Suction cups VS 10 - Universal device for small and medium-sized workpieces

- ▶ Easy to move to different locations in production thanks to integrated transport rollers and self-priming underside
- ▶ Height adjustable as standard
- ▶ Simultaneous processing of several small or single large workpieces
- ▶ Flexible use in production

Model	VS 10 with vacuum pump	VS 10 WITHOUT vacuum pump
Art. no.	5405000	5405001

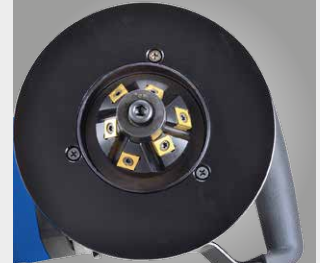
Technical specifications	
Dimensions	630 x 400 x 860 – 1,100 mm
Weight incl. vacuum pump	approx. 25 kg
Extraction performance of vacuum pump	3 m³/h
Electrical connections	220 - 240 V, 50/60 Hz

* PTO for an explanation of the packaging surcharges; details of TVP plus VAT.

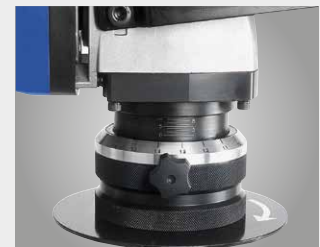
Art. no.	Option
5405005	Different suction cup sizes
5405006	Suction cup version continuously rotatable
5405007	Swivel operation through indexing footswitch
5405008	8 m³/h vacuum pump



For ensuring clean visible edges e.g. with steel girders



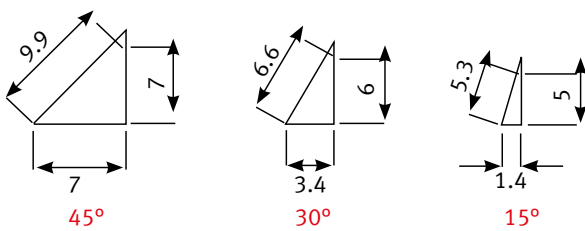
With 6-fold turnover plate holder



Chamfer width from 0 to 10.6 mm continuously variable
 Convenient and exact setting of the chamfer width thanks to easy-to-read scale
 3 chamfer angles 30° / 37.5° / 45°

KE 100 – Edge deburrer for exterior edges, for mobile and stationary use

- ▶ For creating clean visible edges and preparing welds
- ▶ Device for stationary or mobile use
- ▶ Easy and quick change-over from stationary to mobile use with wing nuts and removable foot
- ▶ Tool-free setting of the chamfer depth
- ▶ Standard angle settings at 15°, 30° and 45°
- ▶ Manual feed
- ▶ patented technology
- ▶ Handy and powerful device
- ▶ For machining construction steel, non-ferrous metals and plastics
- ▶ Functional arrangement of the handles allows for safe guiding of the device in mobile operation
- ▶ Guide plate equipped with adjustable ball heads for smooth running of the workpiece
- ▶ Automatic safety shutoff in case of overheating



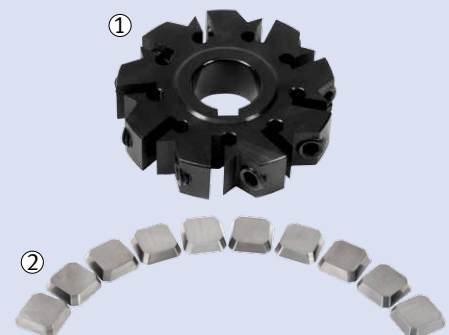
Model	KE 100
Art. no.	3992000
Technical specifications	
Chamfer angle	15° / 30° / 45°
Chamfer width at 15°	approx. 5 mm
Chamfer width at 30°	approx. 6 mm
Chamfer width at 45°	approx. 7 mm
Electrical connections	230 V
Output	750 W
Speed (continuously variable)	2000 - 5000 rpm
Dimensions (L x W x H max.)	360 x 230 x 280 mm
Weight	10.5 kg

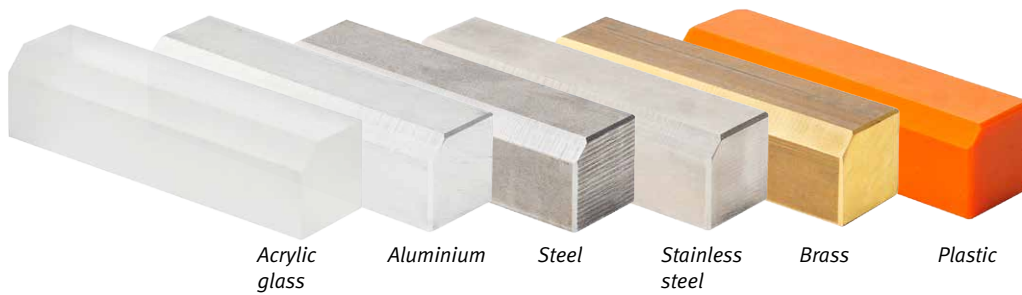
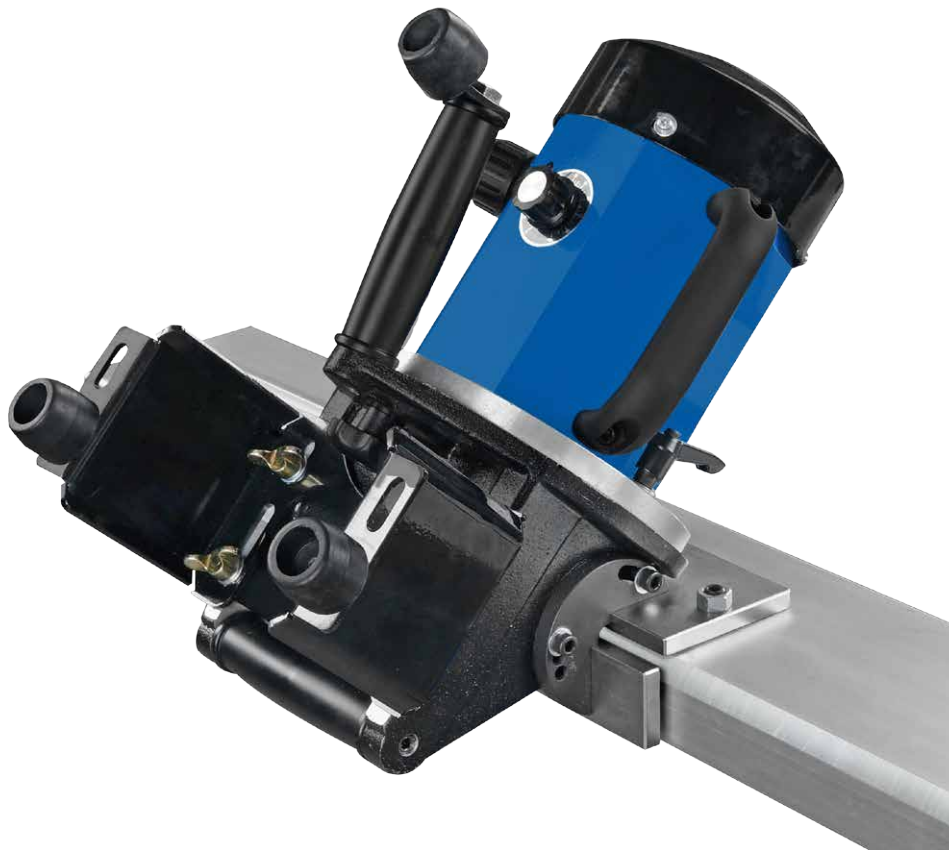
Scope of supply

Edge deburring device KE 100

- ▶ Milling head with cutting plates
- ▶ 3 rubber feet
- ▶ Workpiece slide

Accessories	Art. no.
① Milling head	3992005
② Cutting plate set	3992006





Suitable for machining metals and plastics.

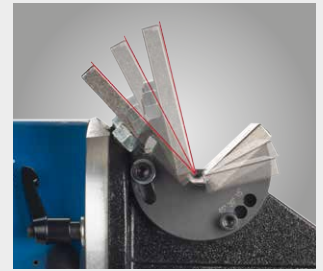
Typical applications



Mobile use



Stationary use



- 3 different standard angle settings 15°, 30° and 45°



- Chamfer width between 5 and 7 mm



- Continuously adjustable speed control supports machining of various materials



- Continuously adjustable chamfer depth setting without tools supported

KE 16-2 – Edge deburrer for visible edges and weld seam preparation with continuous angle adjustment from 15 to 60°. Also suitable for deburring pipes thanks to adjustable guide rollers on the mounting table

- ▶ Tremendous for ensuring clean visible edges and preparing welds
- ▶ Handy and powerful device
- ▶ Setting the chamfering height without tool
- ▶ For machining building steel, aluminium and other materials
- ▶ Also suitable for deburring pipes with Ø 150-350 mm (optionally 300-600 mm) thanks to adjustable guide rollers on the mounting table
- ▶ Continuously adjustable angle adjustment from 0° - 60°
- ▶ With two 6-fold turnover plate holders
- ▶ Manual feed



KE 16-2 with mounted handle



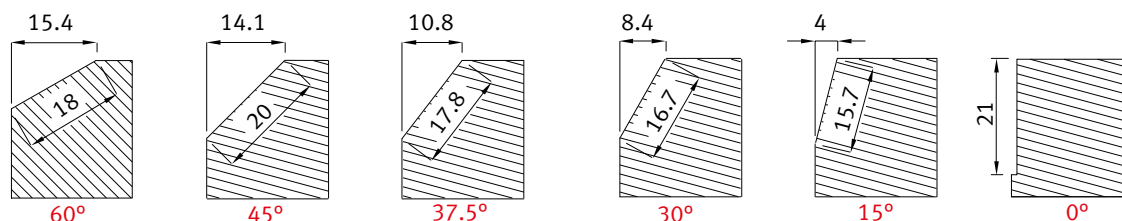
- With two 6-fold turnover plate holders



- Continuously adjustable angle adjustment from 0°-60°
- With two rollers for easier feeding



- Deburring of pipes possible



Model	KE 16-2
Art. no.	3990017

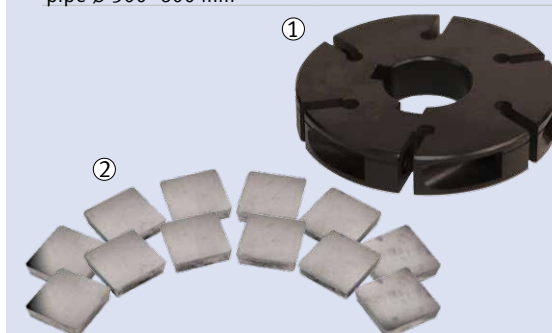
Technical specifications	
Chamfer angle	0 / 15 / 30 / 37.5 / 45 / 60°
Chamfer width at 0°	21 mm
Chamfer width at 15°	15.7 mm
Chamfer width at 30°	16.7 mm
Chamfer width at 37.5°	17.8 mm
Chamfer width at 45°	20 mm
Chamfer width at 60°	18 mm
Pipe diameter	150-350mm (Optionally 300-600mm)
Electrical connections	230 V/50 Hz
Output	1,100 Watts
Speed	3000 rpm
Dimensions (L x W x H)	503 x 350 x 248 mm
Weight	20.1 kg

Scope of supply

Plastic case

- ▶ 2x 6-fold cutting plate holder
- ▶ 1x Cutting plate set consisting of 12 cutting plates
- ▶ 1x Tool kit
- ▶ 1x Front handle

Accessories	Art. no.
① Milling head	3991605
② Cutting plate set (12 pieces)	3991606
Support plate for pipe Ø 300–600 mm	3991607





Metal grinding

SM 100 - Satinising machine for grinding, polishing, satinising, structuring, and for cleaning soiled surfaces, or removing paint residues

- ▶ For grinding, smoothing, brushing, structuring, matting, satinising and polishing
For processing stainless steel, cast iron, aluminium, non-ferrous metals, plastics, etc.
- ▶ Highly resilient motor with soft start and overload protection
- ▶ With constant electronics for constant speed, even under load
- ▶ Adapts perfectly to the workpiece by continuously variable speed adjustment
- ▶ Speed can be set conveniently via thumbwheel on rubberised handle
- ▶ Very robust gear housing
- ▶ Tire-free work thanks to ergonomic two-handed operation
- ▶ With hook and loop fastener for reworking of assembled stainless steel railings



Satin finishing of flat material



Satin finishing of round steel with Velcro non-woven also for e.g. installed stainless steel railings



Easy fixing of the grinding sleeve by pumping up the rubber air roller



Scope of supply SM 100

Model	SM 100
Art. no.	3990100
Technical specifications	
Max. grinding wheel diameter	100 mm
Sanding width min./max.	30 / 100 mm
Shaft seating	Ø 19 mm x 100 mm
Idle speed	1000/2400 rpm
Output	1200 W
Electrical connections	230 V/50 Hz
Weight approx.	4.8 kg

Scope of supply

- ▶ Plastic case
- ▶ Pneumatic rubber roller
- ▶ Air pump for pneumatic rubber roller
- ▶ Grinding sleeve non-woven coarse (Ø 90 x 100 mm)
- ▶ Grinding sleeve 60 grain (100 x 292 mm)
- ▶ Grinding sleeve 100 grain (100 x 292 mm)
- ▶ Grinding sleeve 180 grain (100 x 292 mm)
- ▶ Drive roll for sanding belts
- ▶ Velcro non-woven (40 x 60 mm)
- ▶ Velcro sanding belt 120 grain (40 x 600 mm)
- ▶ Velcro drive belt (30 x 700 mm)
- ▶ Non-woven roller fine (105 x 100 x 19 mm)
- ▶ Spacer ring set 10-part (40 x 19 x 5 mm)



SM 100 with mounted fine non-woven roller



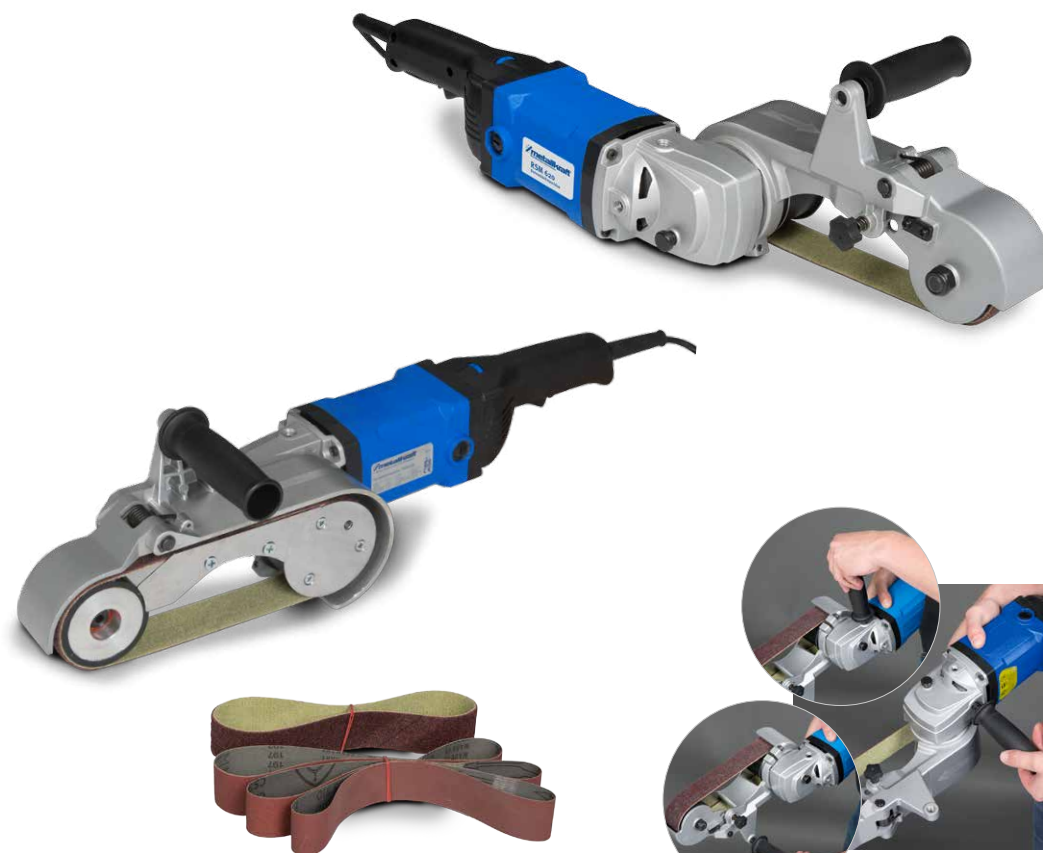
Accessories

	Accessories	Dimensions in mm	Grit size	Art. no.
①	Non-woven wheel	105 x 100 x 19.1	Coarse	3726700
	Non-woven wheel	105 x 100 x 19.1	Medium	3726701
	Non-woven wheel	105 x 100 x 19.1	Fine	3726702
	Non-woven wheel	105 x 100 x 19.1	Very fine	3726703
	Woven/Non-woven combination	104 x 100 x 19.1	40 grain	3726710
	Woven/Non-woven combination	104 x 100 x 19.1	60 grain	3726711
	Woven/Non-woven combination	104 x 100 x 19.1	80 grain	3726712
	Woven/Non-woven combination	104 x 100 x 19.1	100 grain	3726713
	Woven/Non-woven combination	104 x 100 x 19.1	120 grain	3726714
	Woven/Non-woven combination	104 x 100 x 19.1	150 grain	3726715
	Grinding lamella wheel	100 x 100 x 19.1	40 grain	3726720
	Grinding lamella wheel	100 x 100 x 19.1	60 grain	3726721
	Grinding lamella wheel	100 x 100 x 19.1	80 grain	3726722
	Grinding lamella wheel	100 x 100 x 19.1	120 grain	3726723
	Grinding lamella wheel	100 x 100 x 19.1	240 grain	3726724
②	Inflatable			
	Expansion roller	90 x 90		3726809
	Expansion roller	90 x 90 x 19.1		3726735
	Zircon grinding sleeve	90 x 100	180 grain	3726740
	Zircon grinding sleeve	90 x 100	220 grain	3726741
③	Zircon grinding sleeve	90 x 100	40 grain	3726845
	Zircon grinding sleeve	90 x 100	60 grain	3726846
	Zircon grinding sleeve	90 x 100	80 grain	3726847
	Zircon grinding sleeve	90 x 100	120 grain	3726848
④	Non-woven sleeve	90 x 100	Coarse (80 grain)	3726750
	Non-woven sleeve	90 x 100	Medium (120 grain)	3726751
	Non-woven sleeve	90 x 100	Very fine (240 grain)	3726752
	Trizact sleeve	90 x 100	A16	3726760
	Trizact sleeve	90 x 100	A30	3726761
	Trizact sleeve	90 x 100	A45	3726762
	Trizact sleeve	90 x 100	A65	3726763
	Trizact sleeve	90 x 100	A100	3726764
	Trizact band	618 x 40	A16	3726855
	Trizact band	618 x 40	A30	3726856
	Trizact band	618 x 40	A45	3726857
	Trizact band	618 x 40	A65	3726858
	Trizact band	618 x 40	A100	3726859

	Accessories	Dimensions in mm	Grit size	Art. no.
	Grit-permeated Nylon coarse non-woven	100 x 100 x 19.1		3726770
	Steel strand brush Ø 0.3 mm	100 x 100 x 19.1		3726776
	VA wire brush Ø 0.2 mm	100 x 100 x 19.1		3726777
	Plastic brush (grain)	100 x 100 x 19.1	80 grain	3726778
	Plastic brush (grain)	100 x 100 x 19.1	46 grain	3726779
	Polishing disk			
	Normal (7 pieces on SM 100)	100 x 19.1		3726780
	Polishing disk			
	Mirror finish (10 pieces on SM 100)	100 x 19.1		3726781
	Granular rubber wheel	104 x 100 x 19.1	16 grain	3726785
	Granular rubber wheel	104 x 100 x 19.1	46 grain	3726786
	Granular rubber wheel	104 x 100 x 19.1	120 grain	3726787
	Roller for sanding belts	65 x 100 x 19.1		3726791
⑤	Woven fabric sanding belt (open)	600 x 40	60 grain	3726795
	Woven fabric sanding belt (open)	600 x 40	80 grain	3726796
	Woven fabric sanding belt (open)	600 x 40	120 grain	3726797
	Sanding belt for surface finishing (open)	600 x 40	Coarse	3726803
	Sanding belt for surface finishing (open)	600 x 40	Medium	3726804
	Sanding belt for surface finishing (open)	600 x 40	Fine	3726805
	Felt sanding belt (open)	600 x 40		3726806
⑥	Velcro closure for open bands	500 x 30		3726807
	Abrasive roller KIT			3726808
⑦	Non-woven band	618 x 40	80	3726850
	Non-woven band	618 x 40	120	3726851
	Non-woven band	618 x 40	240	3726852
	Zircon corundum band	618 x 40	40	3726860
	Zircon corundum band	618 x 40	60	3726861
	Zircon corundum band	618 x 40	80	3726862
	Zircon corundum band	618 x 40	120	3726863

RSM 620 - Pipe grinding machine with pivoting grinding arm

- ▶ With continuously variable setting of the belt speed for optimum adjustment for various applications
- ▶ Pipe grinding machine with pivoting grinding arm for optimum adjustment to the required grinding position
- ▶ The flexible sanding belt guide allows the sanding belt to adapt to the pipe diameter in hand.
- ▶ Tire-free work thanks to ergonomic two-handed operation
- ▶ Handle can be screwed in at various positions for optimised handling
- ▶ Weld grinding on flat surfaces without tilting or ripple thanks to large contact roller
- ▶ Ideal for grinding of stainless steel welds without blue discolouration due to heat dissipation via the sanding belt
- ▶ Highly resilient motor with soft start and overload protection
- ▶ With constant electronics for constant belt speed, even under load
- ▶ Easy sanding belt replacement without tools
- ▶ Speed can be set conveniently via thumbwheel on the handle



Abrasive for RSM 620 - bands shown included in the scope of supply



Handle can be screwed in at three different positions



Flat material grinding



Satin finishing of vertical round material



Satin finishing of horizontal round material



With pivoting grinding arm for optimum adjustment to the required grinding position

Model	RSM 620	Scope of supply:
Art. no.	3990620	▶ Handle
		▶ Sanding belt 60 grain (40 x 620 mm)
		▶ Sanding belt 100 grain (40 x 620 mm)
		▶ Sanding belt 180 grain (40 x 620 mm)
		▶ Grinding pad coarse (40 x 620 mm)
Technical specifications		
Belt length	620 mm	
Belt width	40 mm	
Pipe Ø min.	15 mm	
Belt speed	15 - 28 m/sec.	
Idle speed	2,300/6,500 rpm	
Output	1500 W	
Electrical connections	230 V/50 Hz	
Weight approx.	5.3 kg	

Accessories	Dimensions in mm	Grit size	Art. no.
Trizact band	618 x 40	A16	3726855
Trizact band	618 x 40	A30	3726856
Trizact band	618 x 40	A45	3726857
Trizact band	618 x 40	A65	3726858
Trizact band	618 x 40	A100	3726859
Non-woven band	618 x 40	80	3726850
Non-woven band	618 x 40	120	3726851
Non-woven band	618 x 40	240	3726852
Zircon corundum band	618 x 40	40	3726860
Zircon corundum band	618 x 40	60	3726861
Zircon corundum band	618 x 40	80	3726862
Zircon corundum band	618 x 40	120	3726863

RSM 760 - Pipe grinding device for handy and flexible use for grinding, polishing and satinising work

- ▶ Pipe grinding device for handy and flexible use for metalworking, steel construction work and railing construction
- ▶ Designed for grinding and polishing pipe constructions
- ▶ Specially suited for grinding, satin finishing and high-gloss polishing of installed railings
- ▶ Ideal for working in cramped conditions, as the handle rotates through 180°
- ▶ Highly resilient motor with soft start and overload protection
- ▶ With constant electronics for constant belt speed, even under load
- ▶ With continuously variable setting of the belt speed for optimum adjustment for various applications
- ▶ Speed can be set conveniently via thumbwheel on the handle
- ▶ Easy sanding belt replacement without tools
- ▶ 360° circumferential grinding in just two steps
- ▶ Premium 270° grinding arm made of lightweight metal with 2 deflection rollers
- ▶ Handle can be screwed in at various positions for optimised handling



Fig. shows complete scope of supply of RSM 760

Model	RSM 760
Art. no.	3990760
Technical specifications	
Max. belt length	760 mm
Belt width	40 mm/20 mm
Pipe Ø min.	15 mm
Belt speed	3 - 12 m/sec.
Idle speed	1600/3200 rpm
Output	1200 W
Electrical connections	230 V/50 Hz
Weight approx.	3.4 kg

Scope of supply

- ▶ Plastic case
- ▶ Grinding pad coarse (40 x 760 mm)
- ▶ 5 pieces sanding belt 120 grain (40 x 760 mm)
- ▶ 5 pieces sanding belt 220 grain (40 x 760 mm)

Accessories	Dimensions in mm	Grit size	Art. no.
Non-woven band	760 x 40	80	3726865
Non-woven band	760 x 40	120	3726866
Non-woven band	760 x 40	240	3726867
Non-woven band	760 x 40	400	3726868
Trizact band	760 x 40	A16	3726870
Trizact band	760 x 40	A30	3726871
Trizact band	760 x 40	A45	3726872
Trizact band	760 x 40	A65	3726873
Trizact band	760 x 40	A100	3726874
Zircon corundum band	760 x 40	40	3726880
Zircon corundum band	760 x 40	60	3726881
Zircon corundum band	760 x 40	80	3726882
Zircon corundum band	760 x 40	120	3726883
Zircon corundum band	760 x 40	220	3726884



Handle for ergonomic work can be screwed in at various positions



Perfect for grinding and polishing pipe constructions



Only two work steps necessary for 360° circumference grinding



Especially suitable for processing installed railings

BEG – Universal brush deburring device



- ▶ With shaft-mounted round brush as standard (250 x 40 x 24 mm with 0.5 mm Ø wire) for processing steel
- ▶ With adjustable prism workpiece support
- ▶ Large sight protection glass for protection against sparks and flying swarf
- ▶ S version with extraction unit incl. separate motor and filter bar



Large sight protection glass



With adjustable prisms workpiece support



BEG 250

Emergency off switch foot-operable



BEG 250 S

Filter bag in scope of supply (BEG 250 S)

Model	BEG 250	BEG 250 S
Art. no.	3730250	3730251
Technical specifications		
Brush dimensions	Ø 250 x 40 mm	Ø 250 x 40 mm
Brush bore hole	Ø 24 mm	Ø 24 mm
Brush speed	3000 rpm	3000 rpm
Motor output	2.2 kW	2.2 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz
Extraction performance	-	8.5 m³/min
Dimensions (L x W x H)	420 x 500 x 1120 mm	440 x 600 x 1120 mm
Weight	50 kg	60 kg

Accessories	Art. no.
Round brush 250 x 30mm	3730260
Wire Ø 0.2 mm for steel	
Round brush 250 x 30mm	3730261
Wire Ø 0.3 mm for steel	
Round brush 250 x 30mm	3730264
Wire Ø 0.2 mm for stainless steel	
Round brush 250 x 30mm	3730265
Wire Ø 0.3 mm for stainless steel	
Replacement filter bag (for BEG 250 S only)	3722150

BTS 51 – Combined belt and disc grinding machine with swivelling grinding arm

- ▶ Pneumatic sanding belt tension manually adjustable
- ▶ Fine adjustment for parallel belt run
- ▶ 2 sanding tables, swivelling via clamping lever
- ▶ With sanding belt (80 grain) and sanding disc (80 grain) as standard
- ▶ Powerful motor
- ▶ With extraction port on spark trap as standard
- ▶ Sanding belt changed within seconds thanks to simple operation
- ▶ Can easily be fixed on the workbench



Model	BTS 51
Art. no.	3700051

Technical specifications	
Sanding belt dimensions	50 x 1000 mm
Sanding disc Ø	150 mm
Belt speed	22 m/sec.
Drive wheel Ø	152 mm
Contact wheel Ø	75 mm
Dimensions graphite support	160 x 60 x 1.5 mm
Motor output	750 W
Electrical connections	230 V/50 Hz
Dimensions in mm	375 x 230 x 620
Weight	20 kg

Accessories	Art. no.	PU
Graphite support BTS 51	3721001	(PU 10)
Sanding belt 1000 x 50 mm 40 grain	3721004	(PU 10)
Sanding belt 1000 x 50 mm 60 grain	3721006	(PU 10)
Sanding belt 1000 x 50 mm 80 grain	3721008	(PU 10)
Sanding belt 1000 x 50 mm 100 grain	3721010	(PU 10)
Velcro support Ø 150 mm	5911001	(PU 10)
Sanding disc Velcro Ø 150 mm 60 grain	5911506	(PU 10)
Sanding disc Velcro Ø 150 mm 80 grain	5911508	(PU 10)
Sanding disc Velcro Ø 150 mm 100 grain	5911510	(PU 10)
Sanding disc Velcro Ø 150 mm 120 grain	5911512	(PU 10)
Sanding disc Velcro Ø 150 mm 150 grain	5911515	(PU 10)
Sanding disc Velcro Ø 150 mm 180 grain	5911518	(PU 10)

AS 1400 - Extractor set suitable for MBSM 100-130 and MBSM 100-130-2 AS 1600 - Extractor set suitable for MBSM 75-200-2 and MBSM 150-200-2

- ▶ Fast and easy filter replacement
- ▶ Large catchment container with fast access via drawer
- ▶ Compact and stable housing
- ▶ High-capacity interior
- ▶ Effective extraction

- AS 1600**
- ▶ Additionally with dust bag



AS 1400



Scope of supply AS 1400:

- ▶ 4x hose clamp Ø 70 - 90 mm
- ▶ 1x extraction hose Ø 75 mm/ 1 m
- ▶ 1x extraction hose Ø 75 mm/ 2 m

Scope of supply AS 1600:

- ▶ 1x Dust bag
- ▶ 4x hose clamps 100 - 120 mm
- ▶ 1x extraction hose Ø 100 mm/ 1 m
- ▶ 1x extraction hose Ø 100 mm/ 2 m



AS 1600

Model	AS 1400	AS 1600
Art. no.	3922011	3922000
Technical specifications		
Motor output	0.37 kW	0.75 kW
Electrical connections	230 V/50 Hz	400 V/50 Hz
Extraction duct	2 x Ø 75 mm	2 x Ø 100 mm
Suction performance without dust bag/hoses	600 m³/h	1,800 m³/h
Suction performance with dust bag/hoses	-	1,520 m³/h
Dimensions without dust bag	920 x 590 x 850 mm	490 x 560 x 1170 mm
Dimensions with dust bag	-	870 x 560 x 1170 mm
Weight	58 kg	31 kg

Hoses (AS 1400)	Art. no.
1x extraction hose Ø 75 mm/ 1 m	3922012
1x extraction hose Ø 75 mm/ 2 m	3922013
Accessories (AS 1400)	Art. no.
Replacement filter	3922014
Hoses (AS 1600)	Art. no.
1x extraction hose Ø 100 mm/ 2 m	3922004
Accessories (AS 1600)	Art. no.
Dust collection bag	3922002

KRBS 101 – Combined pipe, section and belt grinding machine

- ▶ Convenient operation thanks to easily adjustable clamping device
- ▶ The rotating clamping jaws on the clamping device allow for safe clamping of square tubes, round tubes and flat steel
- ▶ Adjustable grinding angle from 30° - 90° and from 0° - 60°
- ▶ Thanks to the optimised quick-release holder, the tension pulley can be easily and quickly replaced without tools
- ▶ Long service life thanks to larger and improved roller bearing
- ▶ Practical tension pulley holders integrated in substructure
- ▶ Comprehensive range of tension pulleys for grinding different pipe diameters available as accessories
- ▶ Fast change-over between pipe grinding and belt grinding possible
- ▶ Powerful motor
- ▶ Almost all settings can be made without tools (operating tool included in scope of supply)
- ▶ Large, folding protection pane with optimised view field
- ▶ Optimum adjustment to material in question thanks to 2 belt speeds (15 m/s perfect for stainless steel and aluminium, 30 m/s perfect for steel)
- ▶ With two easily removable swarf catchment containers
- ▶ Extraction port (Ø 100 mm) available for extraction systems
- ▶ Extraction systems available as accessories
- ▶ Improved design, vibration-reduced substructure

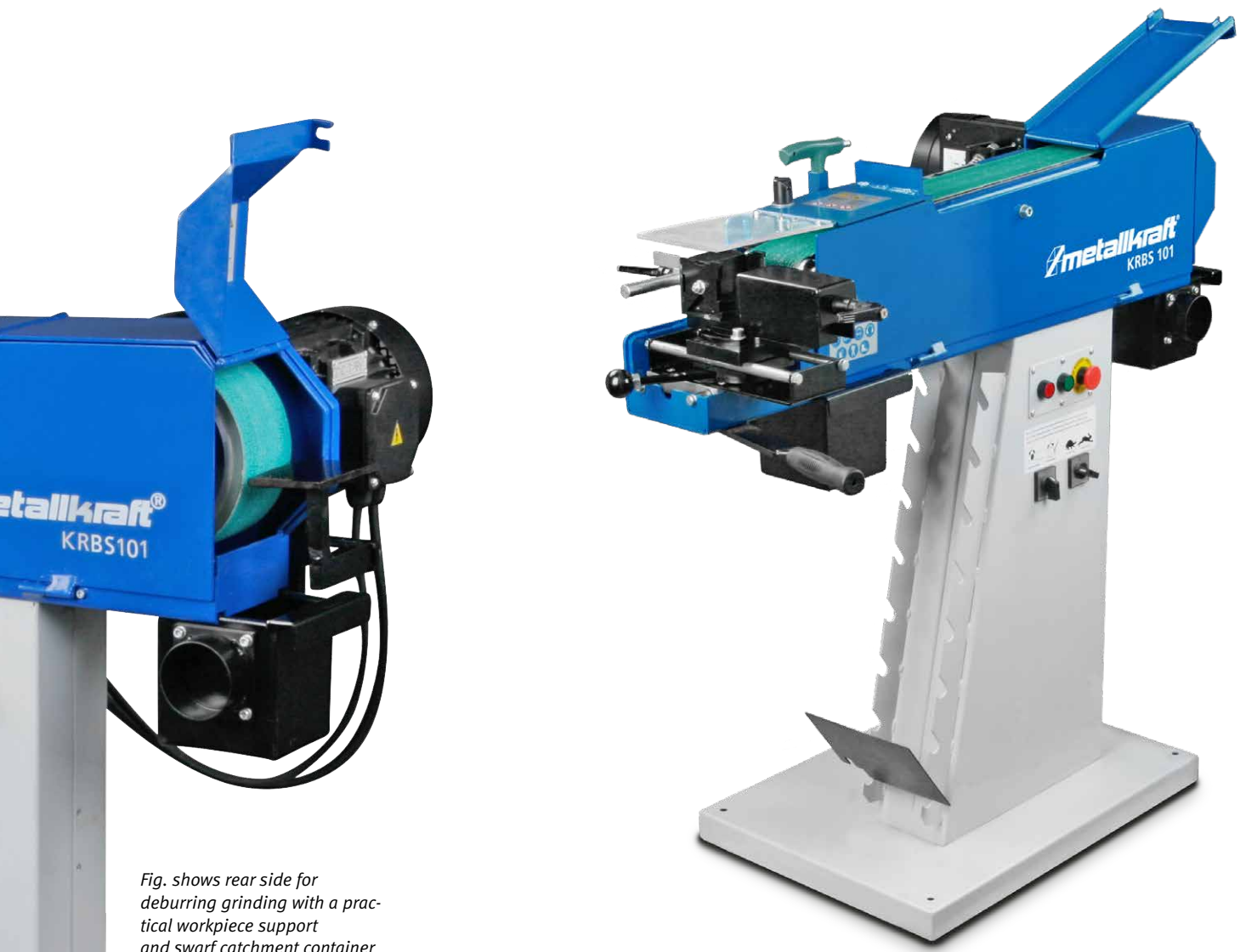


Fig. shows rear side for deburring grinding with a practical workpiece support and swarf catchment container

Model	KRBS 101
Art. no.	3921001
Technical specifications	
Belt dimensions	100 x 2000 mm
Motor output	2.5 kW/3.3 kW
Electrical connections	400 V/50 Hz
Motor speed	1400/2800 rpm
Belt speed	15–30 m/s
Grindable diameter	20 - 76 mm
Adjustable grinding angle	30 - 90 ° (0° - 60°)
Extraction port Ø	2 x 100 mm
Dimensions L x W x H	1250 x 750 x 1140 mm
Weight	159 kg

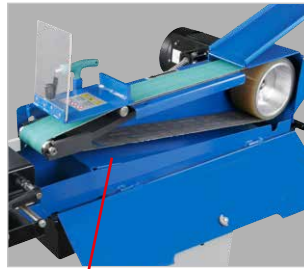
Scope of supply KRBS 101:

- ▶ 1 x Standard grinding belt 36 grain
- ▶ 2 x Swarf catchment containers
- ▶ 1 x Spanner
- ▶ 1 x Grinding roll 42 mm

Accessories	Art. no.
Roller for 3/8" pipe	3723050
Roller for 1/2" pipe	3723051
Roller for 22 mm pipe	3723052
Roller for 3/4" pipe	3723053
Roller for 28 mm pipe	3723054
Roller for 1" pipe	3723055
Roller for 34 mm pipe	3723056
Roller for 1 1/4" pipe	3723057
Roller for 44 mm pipe	3723058
Roller for 1 1/2" pipe	3723059
Roller for 50 mm pipe	3723060
Roller for 2" pipe	3723061
Roller for 62 mm pipe	3723062
Roller for 2 1/2" pipe	3723063
Roller for 78 mm pipe	3723064



► Large flat grinding surface with tool stop



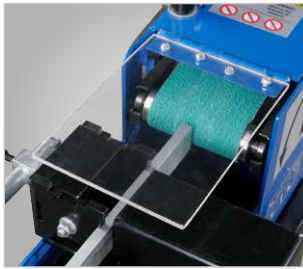
► The baffle guides the grinding dust optimally to the rear swarf discharge point



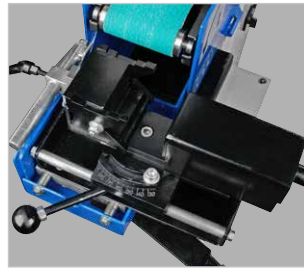
► Cross-cut fence adjustable without tools (only for 90°)



► Easy height adjustment of grinding belt without tools



► Large, folding protection pane with optimised view field



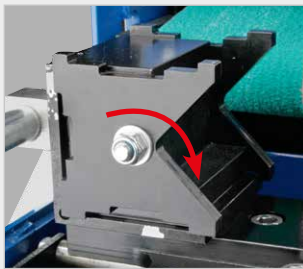
► Safe and easy workpiece guidance thanks to easily adjustable clamping device



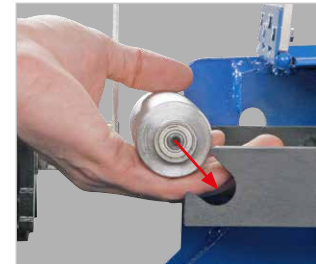
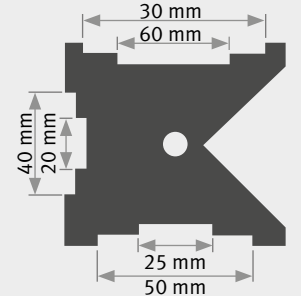
► Grinding angle of 30-90° adjustable based on scale



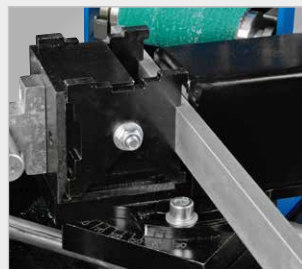
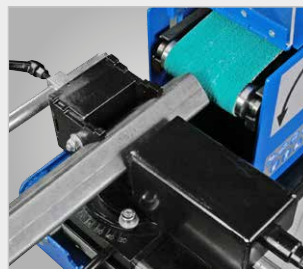
► With integrated grinding roller holder for optionally available grinding rollers with various diameters



The rotating clamping jaws on the clamping device allow for safe clamping of square tubes, round tubes and flat steel
The prism jaws allow for clamping of round tubes and square tubes.
The additional clamping sections allow for precise clamping of workpieces such as flat steel or square tubes



► Thanks to the optimised quick-release holder, the grinding roller can be easily and quickly replaced without tools



► Both swarf catchment containers are easily removable



Optional extraction unit AS 1600 (see page 37).



Optional extraction unit for KRBS 101 Art. no. 3705101

Scope of supply:
2 woven filter bags, metal hose, 4 hose clamps

Grinding belt 2000 x 100 mm		Art. no.	PU
40 grain	Grinding aluminium	3724740	10
60 grain	Grinding aluminium	3724760	10
100 grain	Grinding aluminium	3724710	10
120 grain	Grinding aluminium	3724712	10
40 grain	Grinding stainless steel	3724840	10
60 grain	Grinding stainless steel	3724860	10
100 grain	Grinding stainless steel	3724810	10
120 grain	Grinding stainless steel	3724812	10



MBSM - Belt grinding machines

- ▶ Metal belt grinders for grinding surfaces, edges, and for rounding
- ▶ Powerful motors and vibration-free action for best grinding results
- ▶ Protective screen folds away
- ▶ Grinding belt changed within seconds thanks to quick-release system
- ▶ Large grinding belt surface as upper grinding belt cover can be folded away
- ▶ Usable with or without extractor
- ▶ With 2 extraction ports - one direct on the spark box, one on the rear roller
- ▶ Continuous planing surface after removing attachment parts - allows for grinding of long workpieces
- ▶ Easy adjustment of belt action thanks to adjustment screw
- ▶ automatic re-tensioning of the grinding belt thanks to spring-supported belt tensioning system
- ▶ **MBSM 100-130 and MBSM 100-130-2** can be used as a workbench and upright model (using the optional chassis)
- ▶ **MBSM 100-130-2, 75-200-2 and 150-200-2** with two belt speeds - for grinding steel and stainless steel
- ▶ **MBSM 75-200 and MBSM 150-200-2** continuously variable grinding unit

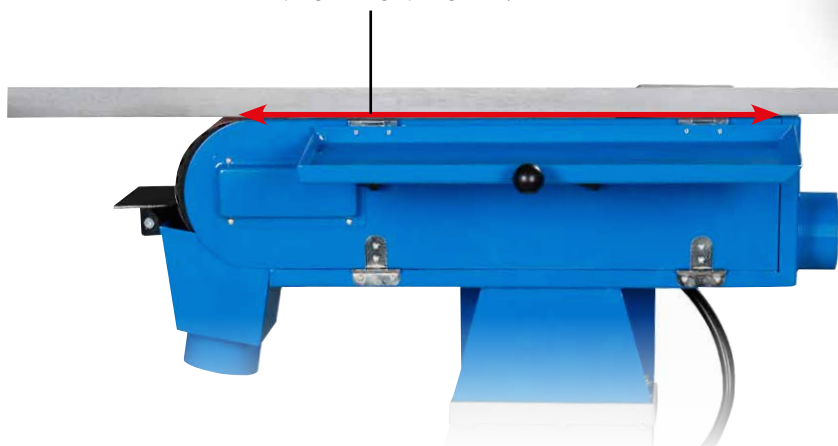


MBSM 100-130-2
With optional chassis



MBSM 100-130
▶ 230 Volt model with a single belt speed
▶ Standard scope of supply for use as a desktop model

- ▶ For all models, continuous planing surface thanks to removable attachment parts
- ▶ Allows for grinding of long workpieces



Model	MBSM 100-130	MBSM 100-130-2	MBSM 75-200-1 (230 V)	MBSM 75-200-1 (400 V)	MBSM 75-200-2	MBSM 150-200-2
Art. no.	3921226	3921225	3922070	3922071	3922075	3922150
Technical specifications						
Grinding width	100 mm	100 mm	75 mm	75 mm	75 mm	150 mm
Belt speed	19 m/s	9.5–19 m/s	29 m/s	29 m/s	14.5–29 m/s	14.5–29 m/s
Motor output	1.5 kW	1.5 kW	3 kW	3 kW	1.5/2.2 kW	2.2/2.8 kW
Electrical connections	230 V/50 Hz	400 V/50 Hz	230 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Grinding belt dimensions	100 x 1220 mm	100 x 1220 mm	75 x 2000 mm	75 x 2000 mm	75 x 2000 mm	150 x 2000 mm
Contact wheel Ø	130 mm	130 mm	200 mm	200 mm	200 mm	200 mm
Extraction port Ø	73 mm	73 mm	100 mm	100 mm	100 mm	100 mm
Dimensions in mm (L x W x H)	690 x 390 x 360	690 x 390 x 360	1070 x 340 x 950	1070 x 340 x 950	1070 x 340 x 950	1070 x 415 x 950
Weight	37 kg	37 kg	72 kg	72 kg	72 kg	90 kg



MBSM 150-200-2

MBSM 75-200-2

**Matching extraction units
on page 37**



*Swarf catchment container,
easily removable
(Fig. MBSM 150-200-2)*



*Fast grinding belt replacement
thanks to quick-clamping system
(Fig. MBSM 150-200-2)*



*Extraction port Ø 100 mm
(Fig. MBSM 150-200-2)*



*generously dimensioned contact
and drive wheels
(Fig. MBSM 150-200-2)*

Accessories MBSM 100-130 / Art. no.

MBSM 100-130-2

Optional chassis	3921227
Contact wheel	3921222
Graphite support	3921230

Grinding belts 100 x 1220 mm

40 grain	PU 10	3726040
60 grain	PU 10	3726060
80 grain	PU 10	3726080
120 grain	PU 10	3726120

Standard set 100 x 1220 mm 73.90

*consisting of: 3x 40 grain,
4x 80 grain, 3x 120 grain*

Grinding belts 100 x 1220 mm

for extreme spot load

40 grain	PU 10	3727040
60 grain	PU 10	3727060
80 grain	PU 10	3727080
120 grain	PU 10	3727120

Woven fabric set 100 x 1220 mm 74.90

*consisting of: 3x 40 grain,
4x 80 grain, 3x 120 grain*

Accessories MBSM 75-200-2 Art. no.

Contact wheel	3922076
Graphite support	3921231

Grinding belts 75 x 2000 mm

40 grain	PU 10	3722004
60 grain	PU 10	3722006
80 grain	PU 10	3722008
120 grain	PU 10	3722009

Standard set 75 x 2000 mm 85.90

*consisting of: 3x 40 grain,
4x 80 grain, 3x 120 grain*

Grinding belts 75 x 2000 mm

for extreme spot load

24 grain	PU 10	3722022
36 grain	PU 10	3722023
40 grain	PU 10	3722024
60 grain	PU 10	3722026

Woven fabric set 75 x 2000 mm 107.90

*consisting of: 4x 24 grain,
3x 40 grain, 3x 60 grain*

Accessories MBSM 150-200-2 Art. no.

Contact wheel	3922151
Graphite support	3921232

Grinding belts 150 x 2000 mm

40 grain	PU 10	3722014
60 grain	PU 10	3722016
80 grain	PU 10	3722018
120 grain	PU 10	3722019

Standard set 150 x 2000 mm 157.90

*consisting of: 3x 40 grain,
4x 80 grain, 3x 120 grain*

Grinding belts 150 x 2000 mm

for extreme spot load

24 grain	PU 10	3723022
36 grain	PU 10	3723023
40 grain	PU 10	3723024
50 grain	PU 10	3723025
60 grain	PU 10	3723026

Woven fabric set 150 x 2000 mm 217.90

*consisting of: 4x 24 grain,
3x 40 grain, 3x 60 grain*

MBSM ESE - Long belt grinding machine with pivoting grinding unit for surface grinding and edge grinding of long workpieces

- ▶ For use in the metalworking industry for grinding, structuring and polishing tasks, especially with stainless steel
- ▶ 225 mm, balanced belt rollers for optimum, low-vibration drive action
- ▶ Continuously variable band speed 4.5 – 27 m/s thanks to frequency inverter
- ▶ With electrical table height adjustment
- ▶ With a divided fold-up table, drawer grinding unit and integrated work table lighting
- ▶ Smooth action grinding table even when loaded
- ▶ Easy adjustment of grinding belt
- ▶ Roller grinding shoe for less annealing discolouration during grinding
- ▶ CW/CCW sense of direction as standard

Converts from surface to edge grinding within seconds and without tools!



MBSM 2505 ESE
With pivoted grinding unit
for edge grinding

Model	MBSM 1505 ESE	MBSM 2505 ESE	MBSM 3005 ESE
Art. no.	3704015	3704025	3704030
Technical specifications			
Work table dimensions	1,500 x 800 mm	2,500 x 800 mm	3,000 x 800 mm
Work table height adjustment	540 mm	540 mm	540 mm
Work table transverse stroke	700 mm	700 mm	700 mm
Grinding shoe dimensions	270 x 150 mm	270 x 150 mm	270 x 150 mm
Continuously variable belt speed	4.5–27 m/s	4.5–27 m/s	4.5–27 m/s
Motor output	3 kW (4.0 PS)	3 kW (4.0 PS)	3 kW (4.0 PS)
Electrical connections	400V / 50 Hz / P 2	400V / 50 Hz / P 2	400V / 50 Hz / P 2
Drive roller diameter	225 mm	225 mm	225 mm
Grinding belt dimensions	5,020 x 150 mm	7,000 x 150 mm	8,000 x 150 mm
Machine dimensions	2,500 x 1,300 x 1,450 mm	4,000 x 1,300 x 1,450 mm	4,500 x 1,300 x 1,450 mm
Weight	470 kg	516 kg	530 kg
Extraction port diameter	160 mm	160 mm	160 mm

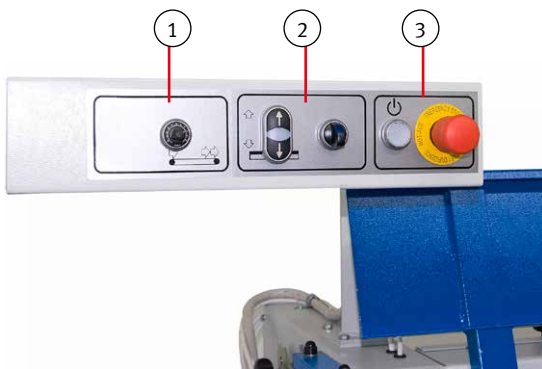


Quality
made in
Europe

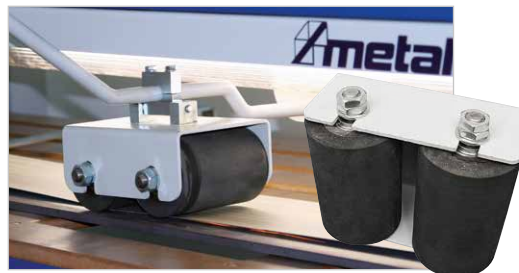


MBSM 2505 ESE

Can be used as a long belt grinding machine



- ▶ Ergonomic control panel at eye level
- ▶ Easy operation from the front
- ▶ With emergency stop switch (3), electrical table height adjustment (2) and potentiometer for continuously variable belt speed(1)



- ▶ Grinding shoe with two large rubber rollers for less friction warming (annealing colour)
- ▶ Also suitable for workpieces with bevelled edges due to pivoting grinding shoe bearing



Application grinding stainless steel grinding belt deployed 120 grain for surface structuring

Applications

- ▶ For processing aluminium*, steel and stainless steel
- ▶ Structuring finishing of metal surfaces
- ▶ Silk matt or silky lustre finishing with non-woven fabric belt
- ▶ Grinding of long welds
- ▶ Cleaning of surfaces with annealing discolouration after welding

Important notice

- ▶ *Note the high risk of deflagration for aluminium grinding!

Matching grinding agents are listed after the two-belt grinding machines.

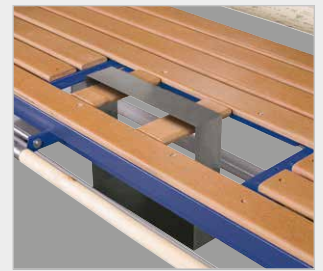


Accessories

Sliding shoe with graphite support

Art. no.

0532556



- with drawer sanding unit as factory standard
- divided, folding table for special edge sanding applications



- Grinding table with stop rail as standard



- Pivoting unit with quick-release clamping system
- 3.0 kW motor



- 225 mm, balanced belt rollers for optimum, low-vibration drive action



Sliding shoe with graphite support, specially designed for fine grinding, Art. no. 0532556

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Band saws

MBSM ZB - premium two-belt grinding machine for pre- and fine grinding in a single work process

- ▶ For grinding, structuring and polishing tasks, especially with stainless steel
- ▶ The special design with raised reversing unit (triangular) provides for an unobstructed and thus safe work area
- ▶ 225 mm, balanced belt rollers for optimum, low-vibration drive action
- ▶ Continuously variable band speed 8 – 30 m/s thanks to frequency inverter
- ▶ With electrical table height adjustment
- ▶ With integrated work table lighting
- ▶ Integrated extraction port for connecting an external extraction unit (Ø 200 mm)
- ▶ Pneumatic belt tensioning, individually controlled for both belts
- ▶ Both grinding shoes pivoting
- ▶ First grinding shoe with large grooved contact roller for less heat development (less annealing colour)
- ▶ Second grinding shoe with graphite support, specially suited for fine grinding
- ▶ Maximum occupational safety thanks to state-of-the-art safety devices such as automatic shut-off in case of belt break and automatic shut-off in case of uncontrolled snap-back of grinding shoe



MBSM 2000 ZB

Model Art. no.	MBSM 2000 ZB 3702000	MBSM 3000 ZB 3703000	MBSM 4000 ZB 3704000
Technical specifications			
Table dimensions	2500 x 1000 mm	3500 x 1000 mm	4500 x 1000 mm
Workspace dimensions	2000 x 1000 mm	3000 x 1000 mm	4000 x 1000 mm
Work table transverse stroke	900 mm	900 mm	900 mm
Work table lift	500 mm	500 mm	500 mm
max. feed height	700 mm	700 mm	700 mm
Continuously variable belt speed	8-30 m/s	8-30 m/s	8-30 m/s
Motor output	4 kW (5.5 PS)	4 kW (5.5 PS)	4 kW (5.5 PS)
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Drive roller diameter	225 mm	225 mm	225 mm
Grinding belt dimensions	150 x 7200 mm	150 x 9250 mm	150 x 11300 mm
Extraction port diameter	200 mm	200 mm	200 mm
Recommended extraction speed	28 m/s	28 m/s	28 m/s
Recommended extraction units output	3500 m ³ /h	3500 m ³ /h	3500 m ³ /h
Operating supply pressure	6 bar	6 bar	6 bar
Dimensions in mm (L x W x H)	2300 x 3900 x 1900	2300 x 4900 x 2100	2300 x 5900 x 2350
Weight	1350 kg	1550 kg	1900 kg



Quality
made in
Europe

The advance two-belt design supports
pre-grinding and fine-grinding in a single
operation



All important controls are located at eye level and thus
easily accessible



MBSM 2000 ZB

Matching grinding agents can be
found on the following pages.



• Displaceable grinding shoe



• Optional vacuum workpiece
clamping unit

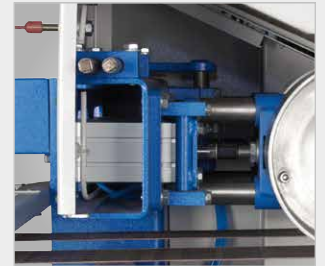


• Grinding belt replacement
in seconds thanks to ease of
access and pneumatic belt
tensioning system



Magnetic drilling

• Maximum occupational safety
thanks to state-of-the-art safety
equipment



Deburring

• Pneumatic belt tensioning,
individually controlled for
both belts



Cutting

• Compressed air maintenance
unit with integrated pressure
regulator, water separator
and oiler

Notching & punching



Bending

• Generously dimensioned
extraction port (Ø 200 mm)

Presses



Circular saws

• Control panel for grinding
belt tension

Roller conveyors

Band saws

Grinding and non-woven fabric belts for metal long belt grinding machines MBSM ESE



Grinding belts for MBSM 1505 ESE Dimensions: 150 x 5020 mm PU = 10

Grain	Art. no.
for aluminium grinding*	
80	3721180
100	3721110
120	3721112
150	3721115
180	3721118
220	3721122
240	3721124
For stainless steel and steel grinding	
80	3721280
100	3721210
120	3721212
150	3721215
180	3721218
220	3721222
240	3721224
For stainless steel pre-grinding**	
80	3721380
120	3721412
150	3721515
For stainless steel pre-grinding***	
80	3721680
100	3721610
120	3721612
150	3721615
180	3721618
Specially for steel grinding	
80	3721880
100	3721810
120	3721812
150	3721815
180	3721818
220	3721822
240	3721824

Grinding belts for MBSM 2505 ESE Dimensions: 150 x 7000 mm PU = 10

Grain	Art. no.
for aluminium grinding*	
80	3725080
100	3725010
120	3725012
150	3725015
180	3725018
220	3725022
240	3725024
For stainless steel and steel grinding	
40	3723040
80	3723080
100	3723010
120	3723012
150	3723015
180	3723018
220	3723032
240	3723034
For stainless steel pre-grinding**	
80	3723180
120	3723112
For stainless steel pre-grinding***	
40	3723240
80	3723280
100	3723210
120	3723212
150	3723215
180	3723218
Specially for steel grinding	
80	3723580
100	3723510
120	3723512
150	3723515
180	3723518
220	3723522
240	3723524

Grinding belts for MBSM 3005 ESE Dimensions: 150 x 8000 mm PU = 10

Grain	Art. no.
for aluminium grinding*	
80	3724080
100	3724010
120	3724012
150	3724015
180	3724018
220	3724022
240	3724024
For stainless steel and steel grinding	
80	3724180
100	3724110
120	3724112
150	3724115
180	3724118
220	3724122
240	3724124
For stainless steel pre-grinding**	
80	3724280
120	3724212
For stainless steel pre-grinding***	
80	3724380
100	3724310
120	3724312
150	3724315
180	3724318
Specially for steel grinding	
80	3724680
100	3724610
120	3724612
150	3724615
180	3724618
220	3724622
240	3724624

Non-woven fabric belts for MBSM 1505 ESE Dimensions: 150 x 5020 mm PU = 1

Grain	Art. no.
for all materials	
Coarse	3721701
Medium	3721702
Fine	3721703

Non-woven fabric belts for MBSM 2505 ESE Dimensions: 150 x 7000 mm PU = 1

Grain	Art. no.
for all materials	
Coarse	3723301
Medium	3723302
Fine	3723303

Non-woven fabric belts for MBSM 3005 ESE Dimensions: 150 x 8000 mm PU = 1

Grain	Art. no.
for all materials	
Coarse	3724401
Medium	3724402
Fine	3724403

* Due to the high risk of deflagration, ensure that only wet grinding is performed on aluminium!

** With polyester support, perfectly suited if the contact pressure for grinding is very high, or for wet grinding

*** With softer woven support made of cotton

Grinding and non-woven fabric belts for two-belt metal grinding machines MBSM ZB



Grinding belts for MBSM 2000 ZB Dimensions: 150 x 7200 mm PU = 10

Grain	Art. no.
for aluminium grinding*	
80	3722380
120	3722312
180	3722318
220	3722322
240	3722324
For stainless steel and steel grinding	
80	3723380
100	3723310
180	3723318
220	3723322
240	3723324
For stainless steel pre-grinding**	
80	3725680
100	3725610
120	3725612
For stainless steel pre-grinding***	
80	3725280
100	3725210
120	3725212
150	3725215
180	3725218
Specially for steel grinding	
80	3723880
100	3723810
120	3723812
150	3723815
180	3723818
220	3723822
240	3723824

Grinding belts for MBSM 3000 ZB Dimensions: 150 x 9250 mm PU = 10

Grain	Art. no.
for aluminium grinding*	
80	3722480
120	3722412
180	3722418
220	3722422
240	3722424
For stainless steel and steel grinding	
80	3723480
100	3723410
180	3723418
220	3723422
240	3723424
For stainless steel pre-grinding**	
80	3725780
100	3725710
120	3725712
For stainless steel pre-grinding***	
80	3725380
100	3725310
120	3725312
150	3725315
180	3725318
Specially for steel grinding	
80	3723980
100	3723910
120	3723912
150	3723915
180	3723918
220	3723922
240	3723924

Grinding belts for MBSM 4000 ZB Dimensions: 150 x 11300 mm PU = 10

Grain	Art. no.
for aluminium grinding*	
80	3722880
120	3722812
180	3722818
220	3722822
240	3722824
For stainless steel and steel grinding	
80	3723680
100	3723610
180	3723618
220	3723622
240	3723624
For stainless steel pre-grinding**	
80	3725880
100	3725810
120	3725812
For stainless steel pre-grinding***	
80	3725480
100	3725410
120	3725412
150	3725415
180	3725418
Specially for steel grinding	
80	3724580
100	3724510
120	3724512
150	3724515
180	3724518
220	3724522
240	3724524

Non-woven fabric belts for MBSM 1505 ESE Dimensions: 150 x 5020 mm PU = 1

Grain	Art. no.
for all materials	
Coarse	3726201
Medium	3726202
Fine	3726203

Non-woven fabric belts for MBSM 2000 ZB

Dimensions: 150 x 7200 mm
PU = 1

Grain	Art. no.
for all materials	
Coarse	3726301
Medium	3726302
Fine	3726303

Non-woven fabric belts for MBSM 3000 ZB

Dimensions: 150 x 9250 mm
PU = 1

Grain	Art. no.
for all materials	
Coarse	3726401
Medium	3726402
Fine	3726403

Non-woven fabric belts for MBSM 4000 ZB

Dimensions: 150 x 11300 mm
PU = 1

Grain	Art. no.
for all materials	
Coarse	3726501
Medium	3726502
Fine	3726503

* Due to the high risk of deflagration, ensure that only wet grinding is performed on aluminium!

** With polyester support, perfectly suited if the contact pressure for grinding is very high, or for wet grinding

*** With softer woven support made of cotton

FSM – Precision grinding machines with NC controlled vertical feed

- ▶ For precision surface grinding work in industrial applications
- ▶ Maximum stiffness and stability thanks to stress-free tempered and hardened cast iron design to ensure maximum precision
- ▶ IP65 protection halogen lighting
- ▶ With automatic centralised lubrication system for all guide rails and spindles
- ▶ Electro-magnetic clamping plate for holding the workpiece incl. automatic degaussing function
- ▶ Premium spindle with precision taper roller bearings (roundness precision 2 µm)
- ▶ Flat V guides, hand-shaved and coated "Turcite-B" guarantee extremely uniform, low-friction movement and maximum precision
- ▶ Second grinding wheel flange



FSM 2550

- ➔ Grinding area: 250 x 500 mm
- ➔ Grinding wheel: 180 x 13 x 31.7 mm
- ➔ Max. workpiece weight: 190 kg

Standard equipment

- ▶ Electro-magnetic clamping plate
- ▶ Automatic degaussing unit
- ▶ Grinding wheel flange
- ▶ Grinding wheel
- ▶ Balancing mandrel
- ▶ Parallel dressing unit
- ▶ Levelling feet
- ▶ Operating tool
- ▶ Halogen work lamp (IP65)
- ▶ Coolant system

Model	FSM 1545	FSM 2045	FSM 2550
Art. no.	3931545	3932045	3932550
Technical specifications			
Size of clamping plate	150 x 450 mm	200 x 450 mm	250 x 500 mm
max. distance between distance and table	450 mm	450 mm	500 mm
Traversing speed of table	5/25 m/min	5/25 m/min	5/25 m/min
Max. workpiece weight	110 kg	110 kg	190 kg
Spindle speed	2900 rpm	2900 rpm	2900 rpm
Size of grinding wheel	180 x 13 x 31.7	180 x 13 x 31.7 mm	180 x 13 x 31.7 mm
Spindle motor output	1.5 kW	1.5 kW	1.5 kW
Hydraulic pump motor output	0.75 kW	0.75 kW	0.75 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Dimensions (L x W x H)	1900 x 1300 x 1700 mm	2080 x 1200 x 1800 mm	2250 x 1400 x 1800 mm
Weight	900 kg	950 kg	1350 kg



FSM 3060

- ➔ Grinding area: 300 x 600 mm
- ➔ Grinding wheel: 355 x 38 x 127 mm
- ➔ Max. workpiece weight: 215 kg



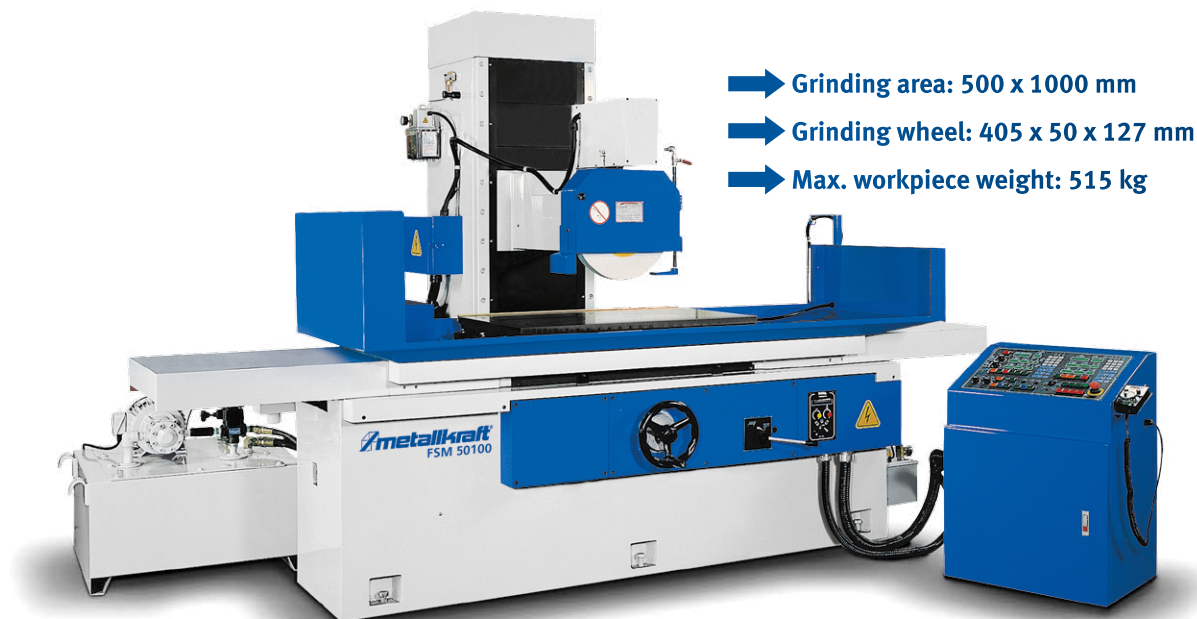
FSM 4080

Layout and function

1. Halogen work lamp
2. Coolant nozzle
3. Electromagnetic clamping plate
4. Adjustable cams longitudinal feed
5. Control panel
6. Hand wheel grinding wheel Y axis
7. Hydraulic power unit
8. Transverse carriage
9. Hand wheel carriage Z axis
10. Base
11. Hand wheel table X axis
12. Coolant return line
13. Table
14. Grinding wheel
15. Splash guard
16. Cover for grinding wheel
17. Column

Model	FSM 3060	FSM 4080
Art. no.	3933060	3934080
Technical specifications		
Size of clamping plate	300 x 600 mm	400 x 800 mm
max. distance between distance and table	500 mm	550 mm
Traversing speed of table	5/25 m/min	5/25 m/min
Max. workpiece weight	215 kg	250 kg
Spindle speed	1450 rpm	1450 rpm
Size of grinding wheel in mm	355 x 38 x 127 mm	405 x 50 x 127 mm
Spindle motor output	3.75 kW	3.75 kW
Hydraulic pump motor output	0.75 kW	1.5 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz
Dimensions (L x W x H)	2650 x 1550 x 1800 mm	3450 x 2050 x 1900 mm
Weight	1700 kg	3250 kg

FSM – Precision grinding machines with NC controlled vertical feed



FSM 50100

- ➔ Grinding area: 500 x 1000 mm
- ➔ Grinding wheel: 405 x 50 x 127 mm
- ➔ Max. workpiece weight: 515 kg



FSM 60150

- ➔ Grinding area: 600 x 1500 mm
- ➔ Grinding wheel: 405 x 50 x 127 mm
- ➔ Max. workpiece weight: 880 kg

More models on request!

Model	FSM 50100	FSM 60150	FSM 70200
Art. no.	3935010	3936015	3937020
Technical specifications			
Size of clamping plate	500 x 1000 mm	600 x 1500 mm	700 x 2000 mm
max. distance between distance and table	600 mm	600 mm	600 mm
Traversing speed of table	5 - 25 m/min	5/25 m/min	5/25 m/min
Max. workpiece weight	515 kg	880 kg	880 kg
Spindle speed	1450 rpm	1450 rpm	1450 rpm
Size of grinding wheel	405 x 50 x 127 mm	405 x 50 x 127 mm	405 x 50 x 127 mm
Spindle motor output	7.46 kW	7.46 kW	7.46 kW
Hydraulic pump motor output	2.24 kW	3.73 kW	3.73 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Dimensions (L x W x H)	4600 x 2300 x 2040 mm	4800 x 2450 x 2040 mm	6000 x 2550 x 2040 mm
Weight	6000 kg	7500 kg	9000 kg

Accessories for precision surface grinders FSM

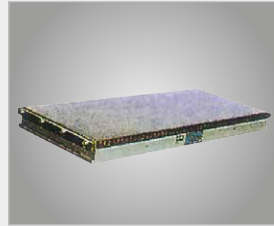
(Article numbers and prices on next page)



Fine adjustment for transverse/vertical feed



Grinding wheel flange



Electrical permanent magnet clamping plate



Degaussing unit for workpieces



Automatic degaussing unit for magnetic clamping unit



Parallel dressing unit



With Halogen work lamp (IP65) as standard



Automatic adjustment of transverse feed with control panel switch



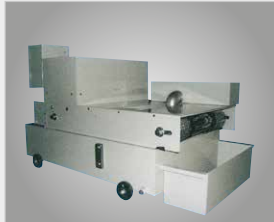
Extraction unit 0.37 kW



Extraction mechanism and cooling system



Magnetic separator and cooling system



Automatic paper belt filter and cooling system



Automatic paper belt filter with magnetic separator and cooling system

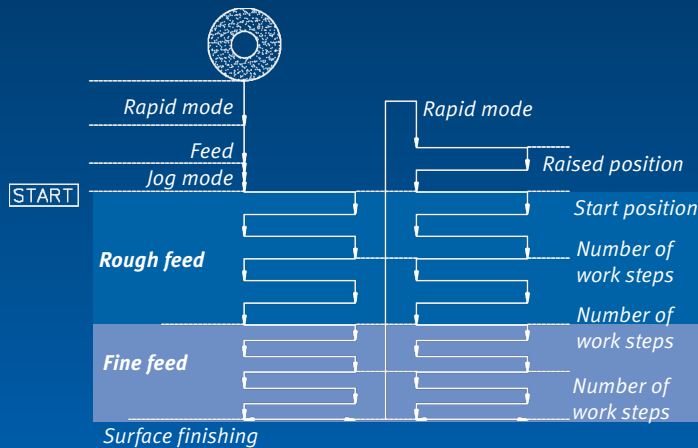


Vertical rapid motion



Full splash guard (factory standard)

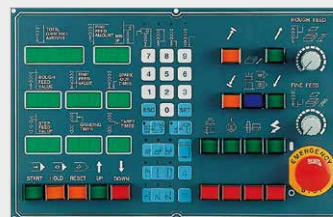
Autom. feed system type AD 5 as standard



Rear splash guard

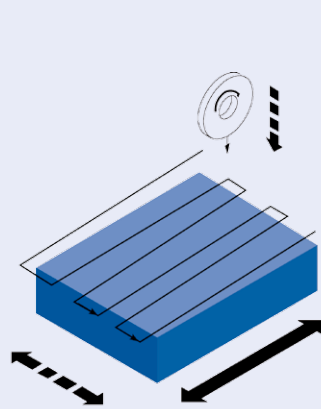


Splash guard front and sides

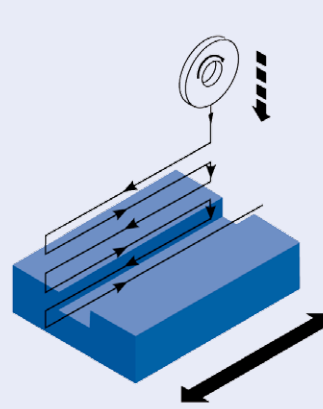


Accessories see next page!

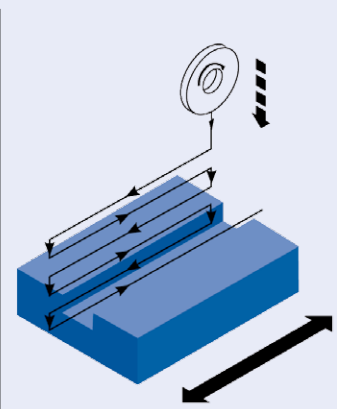
The FSM series models are equipped with automatic feed control (AD 5). Various grinding cycles are available – see diagram on right. The grinding wheel feed can be individually configured to match the workpiece. The overall grinding dimension is divided into rough and fine feed areas; the feed steps can be freely entered with a minimum resolution of up to 0.001 mm depending on the application. The ability to program idle movements after a certain number of feed steps, and cycles for grinding finishing after reaching the grinding dimension guarantees excellent grinding results.



Surface grinding with feed at start point



Groove grinding with feed at start point



Groove grinding with feed at start and end point

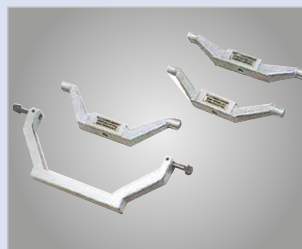
Accessories and grinding wheels for precision surface grinders FSM

Optional accessories FSM 2550 (only available from factory)	Art. no.
Permanent magnet clamping plate 250 x 500 mm	3939001
Electro-magnetic clamping plate fine pol. 250 x 500 mm	3939002
NC controlled parallel dressing and equalising unit	3939003
Automatic adjustment of transverse feed	3939004
Ball screw for transverse feed	3939005
Fine adjustment for transverse feed	3939006
Fine adjustment for vertical feed	3939007
Vertical rapid motion	3939008
Rear splash guard	3939009
Splash guard front and sides	3939010
Full splash guard	3939018
Balancing unit	3939019
Accessories FSM 2550 (retrofittable)	
Extraction unit	3939012
Extraction mechanism and cooling system	3939013
Magnetic separator and cooling system	3939014
Automatic paper belt filter and cooling system	3939015
Automatic paper belt filter with magnetic separator and cooling system	3939016
Grinding wheel flange	3939017
Angle dresser	3939020
Radius dresser	3939021
Toolmaker's vice	3939022
Sinus grinding machine vice	3939023
Shape dresser	3939024
Sanding discs FSM 2550	
For non-tempered and tempered material	
180 x 13 x 31.75 mm (43 A 46/60 HI 14 V 5 SF) for high-alloy, tempered steels as of 62 HRC	3939300
180 x 13 x 31.75 mm (48 A 46/60 EF 14 VN F) for non-ferrous metal and carbide	3939301
180 x 13 x 31.75 mm (10 C 46/60 H 14 V)	3939302
CBN disc for tool steels as of 45 HRC shape 14 A 1 (175-u12-x4-31.75 B 126 C 75)	3939305
Diamond disc for carbide and ceramics shape 14 A 1 (175-u12-x4-31.75 D 126 C 75)	3939306

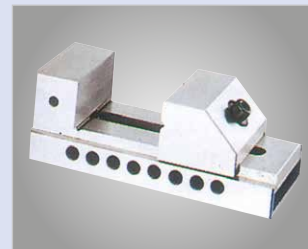
Optional accessories FSM 3060 (only available from factory)	Art. no.
Electro-magnetic clamping plate fine pol. 300 x 600 mm	3939101
NC controlled parallel dressing and equalising unit	3939102
Automatic adjustment of transverse feed	3939103
Ball screw for transverse feed	3939104
Fine adjustment for transverse feed	3939105
Fine adjustment for vertical feed	3939106
Vertical rapid motion	3939107
Rear splash guard	3939108
Splash guard front and sides	3939109
Full splash guard	3939116
Balancing unit	3939117
Accessories FSM 3060 (retrofittable)	
Extraction mechanism and cooling system	3939111
Magnetic separator and cooling system	3939112
Automatic paper belt filter and cooling system	3939113
Automatic paper belt filter with magnetic separator and cooling system	3939114
Grinding wheel flange	3939115
Angle dresser	3939118
Radius dresser	3939119
Toolmaker's vice	3939120
Sinus grinding machine vice	3939121
Shape dresser	3939122
Sanding discs FSM 3060	
For non-tempered and tempered material	3939310
355 x 38 x 127 mm (43 A 46/60 HI 14 V 5 SF) for high-alloy, tempered steels as of 62 HRC	3939311
355 x 38 x 127 mm (48 A 46/60 EF 14 VN F) for non-ferrous metal and carbide	3939312
355 x 38 x 127 mm (10 C 46/60 H 14 V)	
CBN disc for tool steels as of 45 HRC shape 1 A 1 (350-T25-x4-127 B 126 C 75)	3939315
Diamond disc for carbide and ceramics shape 1 A 1 (350-T25-x4-127 D 126 C 75)	3939316

Optional accessories FSM 4080 (only available from factory)	Art. no.
Electro-magnetic clamping plate fine pol. 400 x 800 mm	3939201
Parallel dressing unit hydraulic	3939202
NC controlled parallel dressing and equalising unit	3939203
Automatic adjustment of transverse feed	3939204
Fine adjustment for transverse feed	3939205
Fine adjustment for vertical feed	3939206
Vertical rapid motion	3939207
Rear splash guard	3939208
Splash guard front and sides	3939209
Full splash guard	3939215
Balancing unit	3939216
Accessories FSM 4080 (retrofittable)	
Magnetic separator and cooling system	3939211
Automatic paper belt filter and cooling system	3939212
Automatic paper belt filter with magnetic separator and cooling system	3939213
Grinding wheel flange	3939214
Angle dresser	3939217
Radius dresser	3939218
Toolmaker's vice	3939219
Sinus grinding machine vice	3939220
Shape dresser	3939221
Sanding discs FSM 4080	
For non-tempered and tempered material	3939320
406 x 50 x 127 mm (43 A 46/60 HI 14 V 5 SF) for high-alloy, tempered steels as of 62 HRC	3939321
406 x 50 x 127 mm (48 A 46/60 EF 14 VN F) for non-ferrous metal and carbide	3939322
406 x 50 x 127 mm (10 C 46/60 H 14 V)	
CBN disc for tool steels as of 45 HRC shape 1 A 1 (400-T25-x4-127 B 126 C 75)	3939325
Diamond disc for carbide and ceramics shape 1 A 1 (400-T25-x4-127 D 126 C 75)	3939326

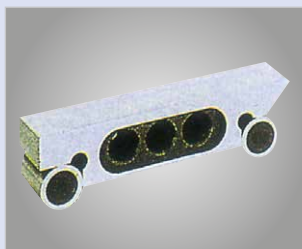
More accessories on request.



Radius dresser



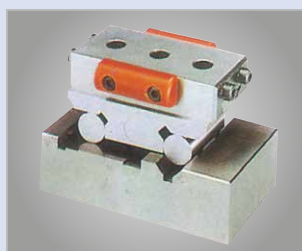
Toolmaker's vice



Sinus grinding machine vice



Shape dresser



Angle dresser



automatic balancing unit (factory standard)



Cutting

KS – circular shears for steel up to 2.0 mm

- ▶ Suitable for cutting metals, cardboard and other materials
- ▶ Extremely stable and rugged design made of cast iron
- ▶ Knife made of cold-worked steel K2379, bronze bearings
- ▶ Knives re hardened, adjustable and can be sharpened

KS 2

- ▶ motorised
- ▶ self-braking motor
- ▶ Central lubrication
- ▶ Inner diameter cutting system
- ▶ Mobile control panel with foot pedal



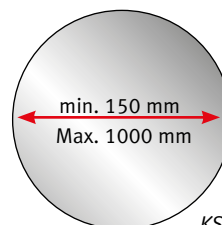
KS 1



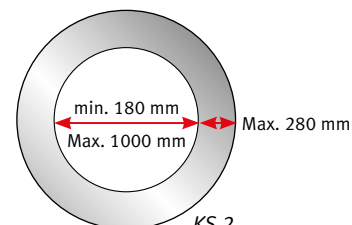
KS 2

Model	KS 1	KS 2
Art. no.	3811001	3811002
Technical specifications		
Max. cutting diameter	1000 mm	1000 mm
Max. cutting thickness	1.0 mm	2 mm
Cutting speed	-	7.5 m/min.
Motor output	-	1.1 kW
Electrical connections	-	400 V/50 Hz
Reach depth	600 mm	700 mm
Reach	200 mm	280 mm
Weight	45 kg	350 kg
Dimensions (L x W x H)	1200 x 200 x 350 mm	1400 x 400 x 1150 mm

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



KS 1



KS 2

Accessories KS 1	Art. no.
Set of spare blades	3880150
Accessories KS 2	
Set of spare blades	3880156

BSS 1000 - Guillotine shears for sheet metal, paper and other materials, foldable chassis

- ▶ Ideal for craftsmen on the road
- ▶ Robust and stable design
- ▶ Compact dimensions due to foldable chassis
- ▶ Easy to transport for steel sheet up to 1.2 mm and rolls with a width of up to 1020 mm
- ▶ The standard hold-down unit ensures good cutting results
- ▶ An optimal price-performance ratio



BSS 1000
with foldable chassis



Model	BSS 1000
Art. no.	3741100
Technical specifications	
Max. cutting width	1020 mm
Max. sheet thickness*	1.20 mm
Dimensions in mm	1830 x 550 x 1225
Weight	97 kg

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

Accessories	Art. no.
Lateral stop BSS 1000	3760110
Replacement knife BSS 1000	3760111



BSS - Manual guillotine shears, heavy-duty type

- ▶ For steel sheet up to 1.5 mm and rolls with a width of up to 1250 mm
- ▶ Extremely stable and heavy design made of cast iron
- ▶ Open construction type
- ▶ Large cast work table
- ▶ The standard hold-down unit ensures good cutting results
- ▶ Removable mitre stop on work table
- ▶ Lateral stop adjustable via crank
- ▶ An optimal price-performance ratio



BSS
Manual guillotine shears

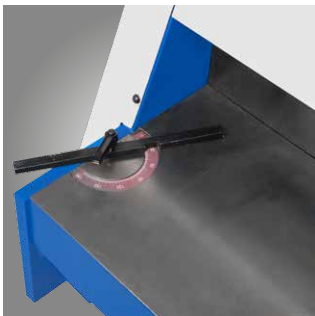
Model	BSS 1020 E	BSS 1250 E
Art. no.	3816001	3816002
Technical specifications		
Max. cutting width	1050 mm	1250 mm
Max. sheet thickness*	1.50 mm	1.50 mm
Stop area	0 - 550 mm	0 - 550 mm
Rear stop width	790 mm	790 mm
Work table	600 x 1280	600 x 1530
Dimensions in mm	2000 x 850 x 1500	2450 x 1000 x 1820
Weight	435 kg	490 kg

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

Accessories	Art. no.
Replacement knife BSS 1020	3880300
Replacement knife BSS 1250	3880301

TBS - Manual precision guillotine shears

- ▶ For cutting metals, paper, plastic and other materials
- ▶ With mitre stop at front
- ▶ Tempered knife
- ▶ Rear stop with scale



TBS
Manual precision guillotine shears

Model	TBS 650-12 T	TBS 1050-10 T
Art. no.	3776165	3776111
Technical specifications		
Max. working width	650 mm	1050 mm
Max. sheet thickness*	1.25 mm	1.00 mm
Rear stop area	0 - 500 mm	0 - 500 mm
Weight	100 kg	160 kg
Dimensions in mm	970 x 470 x 540	1370 x 480 x 580

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



With rear stop 500 mm as standard

Accessories	Art. no.
Standard knife TBS 650-12 T	3760065
Standard knife TBS 1050-10 T	3761050

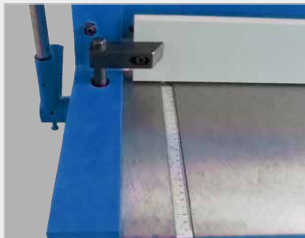


TBS - Manual guillotine shears

- ▶ Suitable for cutting construction steel, aluminium, copper, zinc, plastic
- ▶ Premium knife made of steel with a hardness of HRC55-60
- ▶ Equipped with two operating handles
- ▶ With front support surface with scale and adjustable rear stop
- ▶ 800 mm table height
- ▶ 485 mm rear stop



· Adjustable rear stop



· With integrated, easy-to-read scale



Model	TBS 1500-15	TBS 2000-12
Art. no.	3746150	3746200

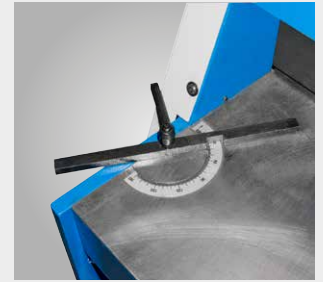
Technical specifications		
Max. working width	1500 mm	2000 mm
Max. sheet thickness*	1.5 mm	1.25 mm
Rear stop	485 mm	485 mm
Weight	480 kg	545 kg
Dimensions	1900 x 1150 x 1120 mm	2400 x 1150 x 1120 mm

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

Option	Art. no.
Knife set for cutting stainless steel for TBS 1500-15	3746905
Knife set for cutting stainless steel for TBS 2000-12	3746906
Replacement knife set TBS 1500-15	3746900
Replacement knife set TBS 2000-12	3746901

FTBS 1050-10 – Foot-operated guillotine shears

- ▶ Stable and rugged welded design
- ▶ Suitable for cutting metals, paper and other materials
- ▶ Foot operation means that both hands are free for feeding in the material
- ▶ Premium knife
- ▶ Adjustable angle stop with millimetre scale
- ▶ The hold-down unit is simultaneously for finger protection, thus ensuring maximum safety
- ▶ 500 mm rear stop



Adjustable angle stop with millimetre scale

Model	FTBS 1050-10
Art. no.	3772910

Technical specifications	
Working width	1050 mm
Sheet thickness*	1.00 mm
Rear stop	500 mm
Dimensions	1160 x 730 x 930 mm
Weight	175 kg

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

Scope of supply

- ▶ Rear stop 0-500 mm
- ▶ Angle stop with millimetre scale
- ▶ Foot pedal

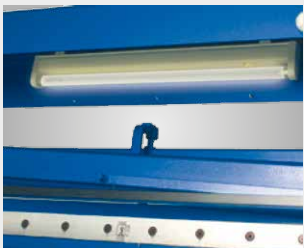
Accessories	Art. no.
Replacement knife	3772911

FTBS M - Manually supported guillotine shears with foot operation, universally deployable in industrial and trade applications

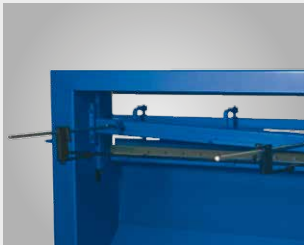
- ▶ Stable and rugged welded design
- ▶ Suitable for cutting metals, paper and other materials
- ▶ Foot operation means that both hands are free for feeding in the material
- ▶ generously dimensioned Plexiglas view window
- ▶ Premium steel blade bar
- ▶ Slotted guide system
- ▶ Easy adjustment of the knife via eight screws
- ▶ Rubberised material hold-down unit prevents workpiece slipping
- ▶ The hold-down unit is simultaneously for finger protection, maximum distance hold-down unit to work table 5 mm, thus ensuring maximum safety
- ▶ Adjustable angle stop with millimetre scale
- ▶ Cutting line lighting 230 V and Plexiplate as standard
- ▶ An optimal price-performance ratio



· Adjustable angle stop (included in scope of supply)



· With cutting line lighting as standard



· With rear stop as standard



FTBS 1300-12 M

FTBS M - Manual foot-operated guillotine shears

Model	FTBS 1050-12 M	FTBS 1300-12 M
Art. no.	3753012	3753013

Technical specifications		
Max. working width	1030 mm	1300 mm
Max. sheet thickness*	1.25 mm	1.25 mm
Cutting angle	3°	3°
Rear stop	550 mm	550 mm
Lateral stop	200 mm	200 mm
Cuts per min.	-	-
Weight	148 kg	200 kg
Dimensions L x W x H	1380 x 880 x 1300	1790 x 510 x 1290
TPFR **	TPFR 3 = €59.00	TPFR 3 = €59.00

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

**See reverse for explanations of transport cost surcharges. Price TPFR plus VAT

Accessories	Art. no.
Replacement knife FTBS 1050-12 M	3760312
Replacement knife FTBS 1300-12 M	3760313

FTBS P - Pneumatic guillotine shears with foot operation, universally deployable in industrial and trade applications

- ▶ P version with 2 pneumatic servo-cylinders and footswitch
- ▶ Stable and rugged welded design
- ▶ Suitable for cutting metals, paper and other materials
- ▶ Foot operation means that both hands are free for feeding in the material
- ▶ Generously dimensioned Plexiglas view window
- ▶ Premium steel knife
- ▶ Slotted guide system
- ▶ Easy adjustment of the knife via eight screws
- ▶ Rubberised material hold-down unit prevents workpiece slipping
- ▶ The hold-down unit is simultaneously for finger protection, maximum distance hold-down unit to work table 5 mm, thus ensuring maximum safety
- ▶ Adjustable angle stop with millimetre scale
- ▶ Cutting line lighting 230 V as standard
- ▶ An optimal price-performance ratio



FTBS 1050-15 P



· With safety equipment as standard

FTBS P - pneumatic foot-operated guillotine shears

Model	FTBS 1050-15 P	FTBS 1050-20 P	FTBS 1300-15 P	FTBS 1300-20 P	FTBS 2000-12 P
Art. no.	3754015	3754020	3755015	3755020	3756012
Technical specifications					
Max. working width	1030 mm	1030 mm	1330 mm	1330 mm	2020 mm
Max. sheet thickness*	1.50 mm	2.00 mm	1.50 mm	2.00 mm	1.25 mm
Cutting angle	3°	3°	3°	3°	2°
Rear stop	550 mm	550 mm	550 mm	550 mm	550 mm
Lateral stop	200 mm	200 mm	200 mm	200 mm	200 mm
Cuts per min.	22	15	21	14	12
Weight	270 kg	280 kg	300 kg	310 kg	420 kg
Dimensions L x W x H	1490 x 1250 x 1290	1490 x 1250 x 1290	1790 x 1250 x 1290	1790 x 1250 x 1290	2480 x 1360 x 1290
TPFR **	TPFR 3 = €59.00	TPFR 3 = €59.00	TPFR 3 = €59.00	TPFR 3 = €59.00	TPFR 5 = €100.00

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

**See reverse for explanations of transport cost surcharges. Price TPFR plus VAT

Accessories	Art. no.
Replacement blade FTBS 1050	3760312
Replacement blade FTBS 1300	3760313
Replacement blade FTBS 2000	3760314

MTBS – Motorised guillotine shears with steel chute at front and rear

- ▶ Suitable for cutting metals and other materials
- ▶ Heavy-duty, stress-free welded steel design
- ▶ Premium knife
- ▶ Two long support arms for large workpieces
- ▶ Cutting line lighting and slots in upper cover plate for an optimum view of the cutting edge for cutting along marks
- ▶ Manual rear stop 600 mm with adjustment option with millimetre precision
- ▶ Light barrier for rear stop area
- ▶ Foot operation means that both hands are free for feeding in the material

*MTBS 1250-30 E (Similar to fig.)*

Model	MTBS 1250-30 E	MTBS 1250-40 E	MTBS 2050-30 E
Art. no.	3757123	3757124	3757203
Technical specifications			
Working width	1250 mm	1250 mm	2050 mm
Max. sheet thickness*	3 mm	4 mm	3 mm
Cutting angle	2.0°	2.4°	2.0°
Rear stop	600 mm	600 mm	600 mm
Strokes per min.	30	30	30
Motor output	3.0 kW	4.0 kW	4.0 kW
Weight	980 kg	1220 kg	1540 kg
Dimensions (L x W x H)	1770 x 1970 x 1100 mm	1820 x 2090 x 1200 mm	2580 x 2090 x 1200 mm
Transport packaging flat rate*	TPFR 5 = €100.00	TPFR 5 = €100.00	TPFR 5 = €100.00

*Performance data for material with tensile strength of 400N/mm²; cutting capacity stainless: factor 0.5

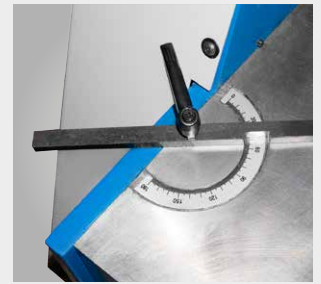
** See page 71 for an explanation of the packaging surcharges, details of TVP plus VAT. Technical and visual changes reserved.

MTBS - Motorised guillotine shears

- ▶ Stable and rugged welded design
- ▶ Suitable for cutting metals, paper and other materials
- ▶ Premium knife
- ▶ Adjustable angle stop with millimetre scale
- ▶ The hold-down unit is simultaneously for finger protection, thus ensuring maximum safety
- ▶ 500 mm rear stop



MTBS 1050-10
With optional chassis



Adjustable angle stop with millimetre scale

Model	MTBS 1050-10
Art. no.	3772915

Technical specifications	
Working width	1050 mm
Max. sheet thickness*	1.00 mm
Rear stop	500 mm
Strokes per minute	55 per minute
Motor output	0.75 kW
Electrical connections	400 V/50 Hz
Dimensions	1400 x 65 x 650 mm
Weight	238 kg

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

Scope of supply

- ▶ Rear stop 0 - 500 mm
- ▶ Angle stop with millimetre scale
- ▶ Protective grille

Accessories	Art. no.
Replacement knife	3772916
Chassis	3772917

MTBS - Motorised guillotine shears, heavy-duty type, foot-operated

Standard type

- ▶ Heavy-duty, stress-free welded steel design
- ▶ Low-noise cutting operation thanks to brake motor and gear unit
- ▶ Motorised rear stop 750 mm (MTBS-D)
- ▶ Rear stop drive with play-free ball screws and linear guides (MTBS-D)
- ▶ Manual rear stop 550 mm (MTBS)
- ▶ All moving parts with low-maintenance bearings
- ▶ Premium knife, suitable for cutting stainless steel
- ▶ Digital position display for motorised rear stop (MTBS-D)
- ▶ Cutting kerf adjustment at front side of machine (MTBS-D)
- ▶ Slot guided upper beam
- ▶ Operated via mobile foot switch with emergency stop switch
- ▶ Rear stop area safeguarded by light barrier
- ▶ Hold-down bar with plastic inserts
- ▶ 1 angle stop with scale and 2 sheet support arms



Electrical adjustment of rear stop

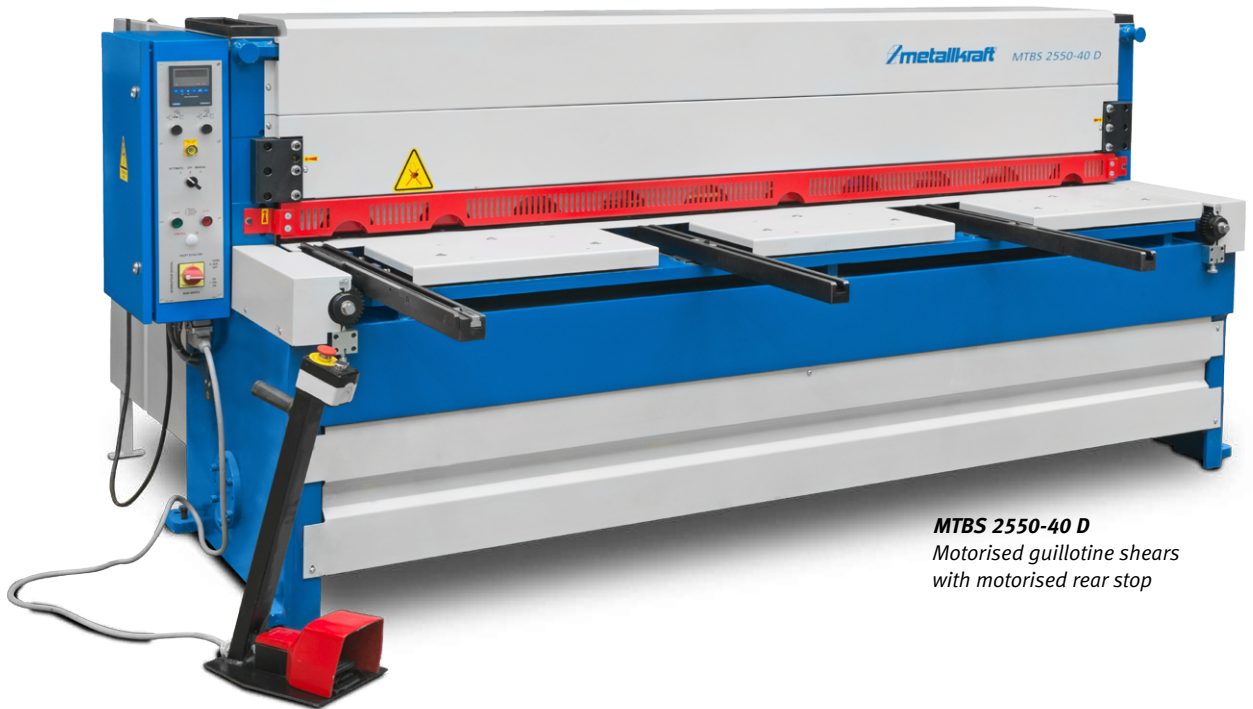
Selector switch for setup or normal operation

Motor on

Motor off

Mains power indicator

Main switch



MTBS 2550-40 D
Motorised guillotine shears
with motorised rear stop

MTBS - motorised guillotine shears with manual rear stop

Technical specifications	Max. working width	Max. sheet thickness*	Cutting angle	Rear stop	Cuts per min.	Motor output	Weight	Dimensions L x W x H	Art. no.		
MTBS 1350-30	1350 mm	3.0 mm	2° 30'	550 mm	35	3.0 kW	1100 kg	1700 x 1350 x 1200	3815101		
MTBS 2050-30	2050 mm	3.0 mm	2° 12'	550 mm	35	3.0 kW	1300 kg	2400 x 1350 x 1200	3815102		
MTBS 2550-25	2550 mm	2.5 mm	1° 30'	550 mm	35	3.0 kW	1400 kg	2860 x 1350 x 1200	3815103		

MTBS D - motorised guillotine shears with motorised rear stop

Technical specifications	Max. working width	Max. sheet thickness*	Cutting angle	Rear stop	Cuts per min.	Motor output	Weight	Dimensions L x W x H	Art. no.		
MTBS 2050-40 D	2050 mm	4.0 mm	1° 30'	750 mm	42	7.5 kW	2800 kg	2550 x 2260 x 1330	3815201		
MTBS 2550-40 D	2550 mm	4.0 mm	1° 30'	750 mm	42	7.5 kW	3230 kg	3050 x 2260 x 1330	3815202		
MTBS 3100-40 D	3100 mm	4.0 mm	1° 30'	750 mm	42	7.5 kW	3730 kg	3650 x 2260 x 1330	3815203		

*Performance data for material with tensile strength of 400N/mm² Please turn over for descriptions of the transport surcharges, Price TPFR plus VAT

Custom accessories

- ▶ Pneumatic thin sheet support device
- ▶ Motorised rear stop (standard with MTBS-D)
- ▶ NC control for motorised rear stop (MTBS-D)
- ▶ Motorised rear stop 1000 mm
- ▶ Cutting line lighting (MTBS-D)
- ▶ Mitre stop
- ▶ Extended angle stop with scale and sheet support arms



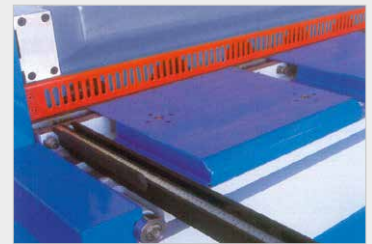
Option *

NC controller D-Touch 7 for MTBS

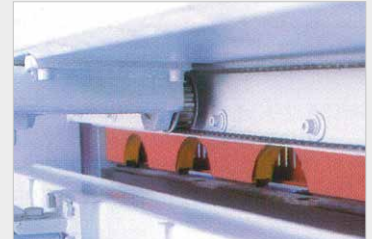
- ▶ Unlimited program and single cut definition
- ▶ Automatic machine stop on reaching the programmed cuts
- ▶ Display of completed and programmed steps



MTBS 2050-30
Motorised guillotine shears with manual rear stop



- Support table with ball transfer units ensure easy feeding that is gentle on the material (MTBS-D)



- Motorised rear stop 750 mm (MTBS-D) (optionally also with 1000 mm MTBS-D)



- The pneumatic thin sheet support device prevents the sheet bending after the cutting edge when cutting thin material and thus guarantees maximum stop precision (optional)



- Manual rear stop with adjustment option with millimetre precision (MTBS)

Accessories	Art. no.
Lateral stop with T grooves, scale and tilt stop 2000 mm	3880001
Lateral stop with T grooves, scale and tilt stop 3000 mm	3880002
Extension for angle stop 2000 mm	3880003
Extension for angle stop 3000 mm	3880004
Adjustable angle stop 0-180°	3880005
Replacement knife MTBS 1350-30	3880036
Replacement knife MTBS 2050-30	3880037
Replacement knife MTBS 2550-25	3880038
Replacement blade MTBS 2050-40 D	3880046
Replacement blade MTBS 2550-40 D	3880047
Replacement blade MTBS 3100-40 D	3880048
Cutting line lighting for D models (only for 3815201, 3815202 and 3815203)	3880044

Surcharge for optional equipment	Art. no.
Pneumatic thin sheet support device for	
MTBS 1350	3880006
MTBS 2050/ MTBS 2050 D	3880007
MTBS 2550/ MTBS 2550 D	3880008
MTBS 3100/ MTBS 3100 D	3880009
Motorised rear stop 750 mm with digital display MTBS	3880010
Motorised rear stop 1000 mm for	
for MTBS	3880013
for MTBS D	3880014
NC controller D-Touch 7 for MTBS	3880000

*Optional equipment is not retrofittable

HTBS-T - Hydraulically NC-controlled guillotine shears, heavy-duty type

Standard type

- ▶ Very heavy welded steel design
- ▶ Low cutting angle for optimum results
- ▶ Motorised rear stop 1000 mm
- ▶ Rear stop driven via play-free ball screws, guided on linear rails
- ▶ Rear stop easily positioned via NC controller D-Touch 7
- ▶ Divided fold-up finger protection grille, 1000 mm
- ▶ Ergonomically arranged, pivoting control panel
- ▶ Operated via mobile foot switch with emergency stop switch
- ▶ Manual cutting kerf adjustment via lever with scale on right side of machine
- ▶ Rear stop area safeguarded by light barrier
- ▶ Lighting with cutting line display as silhouette
- ▶ Hold-down unit arranged close to cutting edge
- ▶ Easy handling of sheet metal via ball transfer units in table
- ▶ One angle stop 1500 mm and two sheet support arms 1000 mm (three sheet support arms for machines as of 4 m)
- ▶ Premium knife, suitable for cutting stainless steel
- ▶ Premium components by Bosch, Rexroth, Hydac, Siemens, Telemecanique



HTBS-T 3100-100
Hydraulic guillotine shears

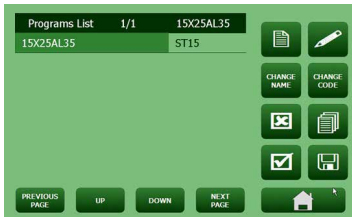
Model HTBS-T	3100-60	3100-100	3100-130	3100-160	3100-200	4100-60	4100-130
Art. no.	3825306	3825310	3825313	3825316	3825320	3825406	3825413

Technical specifications	3100-60	3100-100	3100-130	3100-160	3100-200	4100-60	4100-130
Cutting length (A)	3100 mm	3100 mm	3100 mm	3100 mm	3100 mm	4100 mm	4100 mm
Cutting performance (450 N/mm ²)	6 mm	10 mm	13 mm	16 mm	20 mm	6 mm	13 mm
Cutting performance (700 N/mm ²)	4 mm	6 mm	8 mm	10 mm	13 mm	4 mm	8 mm
Stand reach (D)	50 mm	50 mm	50 mm	50 mm	50 mm	50 mm	50 mm
max. strokes per minute for full cutting length	15	13	13	10	6	12	8
Cutting angle	1.30°	1.30°	1.45°	2°	2°	1.30°	1.45°
Cutting kerf adjustment min.	0.05 mm	0.05 mm	0.05 mm	0.07 mm	0.09 mm	0.05 mm	0.05 mm
Cutting kerf adjustment max.	0.75 mm	1.05 mm	1.45 mm	1.80 mm	2.20 mm	0.75 mm	1.45 mm
Table height (C)	865 mm	865 mm	845 mm	818 mm	886 mm	865 mm	818 mm
Table depth (B)	500 mm	580 mm	600 mm	550 mm	570 mm	580 mm	550 mm
Table length (R)	3515 mm	3515 mm	3550 mm	3580 mm	3670 mm	4510 mm	4620 mm
Number of hold-down units	16	16	16	14	14	20	18
Hold-down unit pressure	14 t	22 t	37 t	61 t	77 t	17 t	62 t
Rear stop adjustment range	1000 mm	1000 mm	1000 mm	1000 mm	1000 mm	1000 mm	1000 mm
Motor output rear stop	0.75 kW	0.75 kW	0.75 kW	0.75 kW	0.75 kW	0.75 kW	0.75 kW
Rear stop speed	120 mm/sec.	120 mm/sec.	120 mm/sec.	120 mm/sec.	120 mm/sec.	120 mm/sec.	120 mm/sec.
Drive output	15 kW	22 kW	30 kW	37 kW	45 kW	15 kW	30 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Oil tank capacity	200 l	200 l	330 l	410 l	450 l	200 l	330 l
Number of support brackets	2	2	2	2	2	3	3
Length (L)	4110 mm	4200 mm	4280 mm	4550 mm	4450 mm	5230 mm	5350 mm
Depth (W1)	2200 mm	2250 mm	2300 mm	2250 mm	2260 mm	2300 mm	2250 mm
Overall depth (W)	3700 mm	3600 mm	3600 mm	3825 mm	3400 mm	3600 mm	3850 mm
Height (H)	2100 mm	2100 mm	2350 mm	2250 mm	2450 mm	2150 mm	2250 mm
Weight	7650 kg	9300 kg	12500 kg	15000 kg	21700 kg	11750 kg	16300 kg

All hydraulic guillotine shears are supplied with oil.

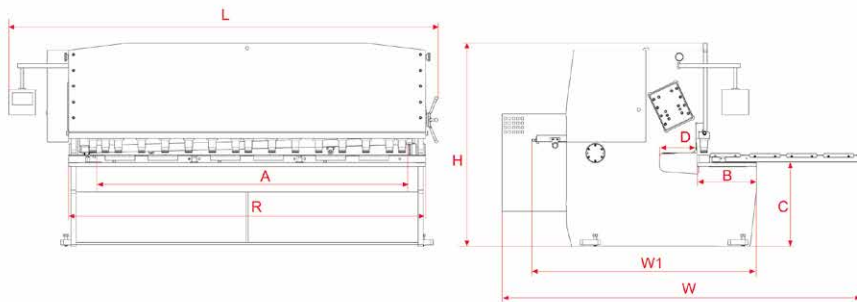
Custom accessor

- ▶ Pneumatic thin sheet support device with one or two levels
- ▶ Motorised cutting kerf adjustment
- ▶ Laser cutting line display
- ▶ Light barrier instead of finger protection grille
- ▶ Removable mitre stop
- ▶ Extended angle stop with scale and sheet support arms
- ▶ Transfer balls for angle stop and sheet support arms



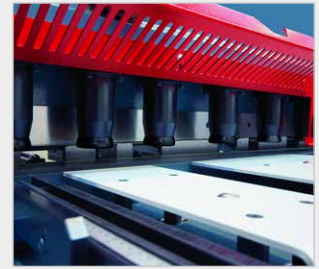
(C)NC controller D-Touch 7:

- ▶ Anti-reflexion coated rugged 7" colour touchscreen control panel
- ▶ Easy positioning to the desired dimension
- ▶ Unlimited program and single cut definitions
- ▶ Unlimited material definitions in the material library
- ▶ Intuitive menu-guided operation
- ▶ Separate displays for ACTUAL and TARGET values
- ▶ Rear stop move out function
- ▶ Positioning accuracy 0.1 mm
- ▶ Cut length validation via configurable stroke length
- ▶ Cut counter
- ▶ Control of machine accessories (e.g., optional sheet support device) and motorised cutting kerf adjustment



- (A) Cut length
- (B) Table depth
- (C) Working height
- (D) Reach
- (H) Height
- (L) Length
- (W) Depth
- (R) Table length

Accessories	Art. no.	Accessories	Art. no.
Safety light barrier instead of finger protection grille	3883001	Rear stop swivels up hydraulically	3883017
Reach 350 mm HTBS-T 3100-60/4100-60	3883002	HTBS-T 3100-160/3100-200/4100-130	
Reach 350 mm HTBS-T 3100-100/3100-130	3883003	Support arm L=2m (1 pc.)	3883018
Reach 500 mm HTBS-T 3100-60	3883004	Support arm L=3m (1 pc.)	3883019
Reach 500mm HTBS-T 3100-100/HTBS-T 3100-130/ HTBS-T 4100-60	3883005	Support arm extension L=2m (1 pc.)	3883020
Reach 500 mm HTBS-T 3100-160/4100-130	3883006	Support arm extension L=3m (1 pc.)	3883021
Reach 500 mm HTBS-T 3100-200	3883007	Angle stop extension L=2m (1 pc.)	3883022
Pneumatic thin sheet support device "Standard" HTBS-T 3100-60/3100-100/3100-130	3883008	Angle stop extension L=3m (1 pc.)	3883023
Pneumatic thin sheet support device "Standard" HTBS-T 3100-160/3100-200	3883009	Angle stop (1500 mm) on right side	3883024
Pneumatic thin sheet support device "Standard" HTBS-T 4100-60/4100-130	3883010	Balls for support arms/ angle stop price per ball	3883025
Pneumatic thin sheet support device "two-level" HTBS-T 3100-60/3100-100	3883011	Adjustable angle stop 0-180°	3883026
Pneumatic thin sheet support device "two-level" HTBS-T 3100-130	3883012	motorised cutting kerf adjustment	3883027
Pneumatic thin sheet support device "two-level" HTBS-T 3100-160	3883013	Laser cutting line	3883028
Pneumatic thin sheet support device "two-level" HTBS-T 4100-60	3883014	1 set replacement blades HTBS-T 3100-60	3883029
Pneumatic thin sheet support device "two-level" HTBS-T 4100-130	3883015	1 set replacement blades HTBS-T 3100-100	3883030
Rear stop 1250 mm	3883016	1 set replacement blades HTBS-T 3100-130	3883031
		1 set replacement blades HTBS-T 3100-160	3883032
		1 set replacement blades HTBS-T 3100-200	3883033
		1 set replacement blades HTBS-T 4100-60	3883034
		1 set replacement blades HTBS-T 4100-130	3883035
		Manual centralised lubrication system	3883036



Finger protection

- Fold-up finger protection on first metre



Rear stop

- Fold-up rear stop for over length cutting



pneum. support device for thin sheet (option)



Cutting kerf adjustment device

- There is a central adjusting lever on the machine frame that is used to adjust the cutting kerf by reference to a scale. This provides a fast and easy approach to changing settings and making the correct adjustments for the material and thickness and thus achieve the best possible cut quality.

HTBS-K - Hydraulic CNC guillotine shears

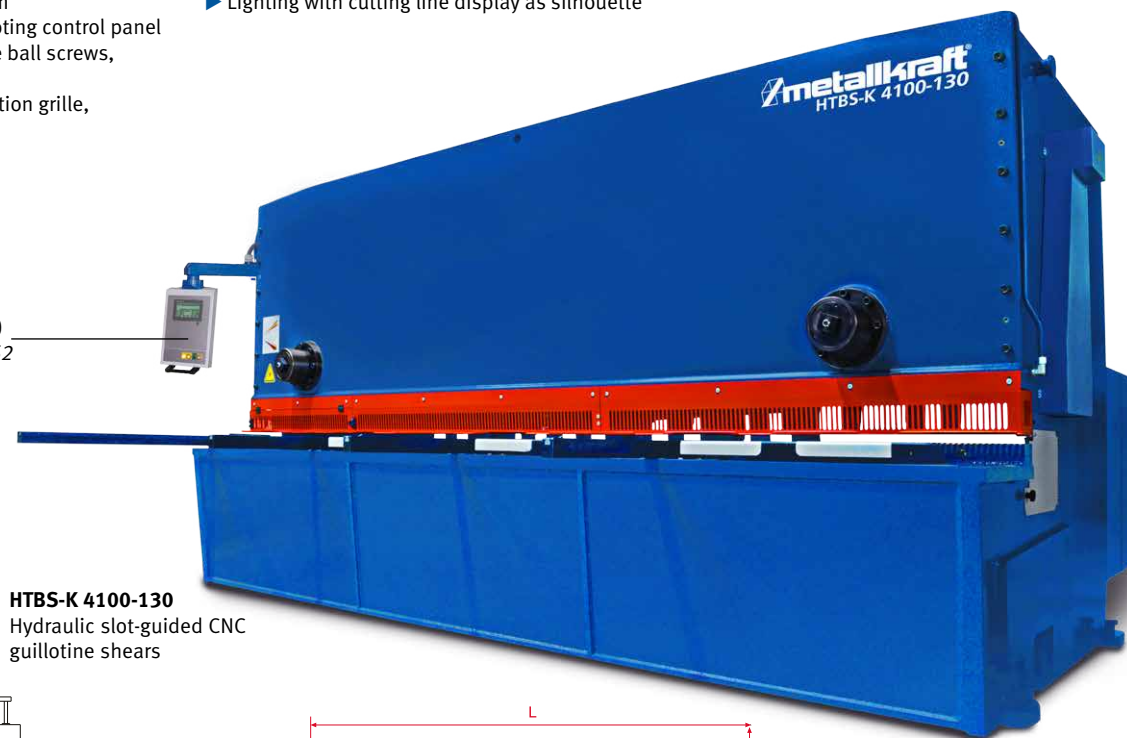
Standard type

- ▶ Very heavy welded steel design
- ▶ CNC controller D-Touch 7
- ▶ automatic, hydraulic cutting angle adjustment via D-Touch 7
- ▶ automatic, motorised cutting kerf adjustment via D-Touch 7
- ▶ Motorised rear stop 1000 mm
- ▶ Ergonomically arranged, pivoting control panel
- ▶ Rear stop driven via play-free ball screws, guided on linear rails
- ▶ Divided fold-up finger protection grille, 1000 mm

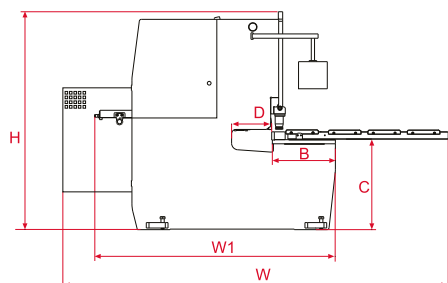
- ▶ Hold-down unit arranged close to cutting edge
- ▶ Operated via mobile foot switch with emergency stop switch
- ▶ One angle stop 1500 mm and two sheet support arms 1000 mm (three sheet support arms for machines as of 4 m)
- ▶ Rear stop area safeguarded by light barrier
- ▶ Lighting with cutting line display as silhouette

- ▶ Easy handling of sheet metal via ball transfer units in table
- ▶ Premium components by Bosch, Rexroth, Hydac, Siemens, Atos
- ▶ Premium knife, suitable for cutting stainless steel

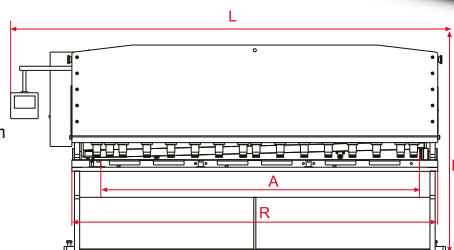
DT7 (D-Touch 7)
more on page 62



HTBS-K 4100-130
Hydraulic slot-guided CNC
guillotine shears



- (L) Length
- (W) Overall depth
- (W1) Depth
- (R) Table length



- (A) Cut length
- (B) Table depth
- (C) Working height
- (D) Reach
- (H) Height

Model HTBS-K	3100-60	3100-100	3100-130	3100-160	3100-200	4100-60	4100-130	4100-160	4100-200
Art. no.	3826306	3826310	3826313	3826316	3826320	3826406	3826413	3826416	3826420

Technical specifications	3100-60	3100-100	3100-130	3100-160	3100-200	4100-60	4100-130	4100-160	4100-200
Cutting length (A)	3080 mm	3080 mm	3080 mm	3080 mm	3080 mm	4080 mm	4080 mm	4080 mm	4080 mm
Cutting performance (450 N/mm ²)	6 mm	10 mm	13 mm	16 mm	20 mm	6 mm	13 mm	16 mm	20 mm
Cutting performance (700 N/mm ²)	4 mm	8 mm	10 mm	13 mm	16 mm	4 mm	10 mm	10 mm	16 mm
Stand reach (D)	350 mm	350 mm	350 mm	350 mm	350 mm	350 mm	350 mm	350 mm	350 mm
max. strokes per minute for full cutting length	20	20	17	12	12	20	13	9	8
min. max. cutting angle	0.3°-2°	0.3°-2°	0.3°-2°30'	0.3°-2°30'	0.3°-2°30'	0.3°-2°	0.3°-2°30'	2°30'	2°30'
Table height (C)	820 mm	820 mm	835 mm	840 mm	840 mm	820 mm	835 mm	1000 mm	1000 mm
Table depth (B)	494 mm	554 mm	559 mm	554 mm	580 mm	494 mm	589 mm	630 mm	630 mm
Table length (R)	3280 mm	3360 mm	3380 mm	3420 mm	3460 mm	4400 mm	4400 mm	4385 mm	4405 mm
Number of hold-down units	16	16	17	14	14	20	20	17	21
Min. max. pressure of hold-down units	4-20 t	4-20 t	8-40 t	11-55 t	17-83 t	4-20 t	10-48 t	50-100 t	50-100 t
Speed Rear stop	200 mm/sec	200 mm/sec	200 mm/sec	200 mm/sec	200 mm/sec	200 mm/sec	200 mm/sec	200 mm/sec	200 mm/sec
Drive output	11 kW	22 kW	30 kW	45 kW	45 kW	11 kW	30 kW	45 kW	45 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Oil tank capacity	125 l	180 l	300 l	400 l	500 l	125 l	300 l	400 l	500 l
Length (l)	4100 mm	3800 mm	4200 mm	4130 mm	4100 mm	5150 mm	6200 mm	5890 mm	5900 mm
Depth (W1)	2050 mm	2050 mm	2100 mm	2210 mm	2300 mm	2100 mm	2150 mm	2100 mm	2200 mm
Overall depth (W)	3650 mm	3550 mm	3560 mm	3820 mm	3700 mm	3550 mm	3560 mm	3625 mm	3775 mm
Height (H)	1950 mm	2150 mm	2450 mm	2570 mm	2650 mm	2050 mm	2550 mm	2950 mm	2950 mm
Weight	7500 kg	9300 kg	12900 kg	18000 kg	21500 kg	12000 kg	16500 kg	23600 kg	29000 kg

All hydraulic guillotine shears are supplied with oil.

More models on request.

Custom accessor

- ▶ Pneumatic thin sheet support device with one or two levels
- ▶ Laser cutting line display
- ▶ Light barrier instead of finger protection grille
- ▶ Removable mitre stop
- ▶ Extended angle stop with scale and sheet support arms
- ▶ Transfer balls for angle stop and sheet support arms



Size example HTBS-K 10000-130

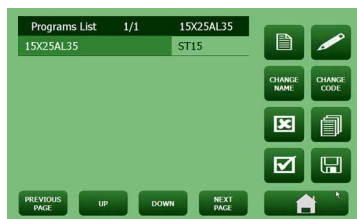
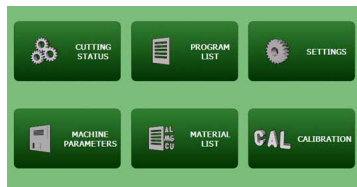


Accessories for hydraulic CNC guillotine shears



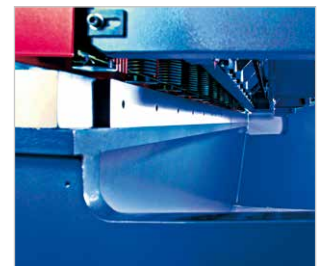
(C)NC controller D-Touch 7:

- ▶ Anti-reflexion coated rugged 7" colour touchscreen control panel
- ▶ Easy positioning to the desired dimension
- ▶ Unlimited program and single cut definitions
- ▶ Unlimited material definitions in the material library
- ▶ Intuitive menu-guided operation
- ▶ Separate displays for ACTUAL and TARGET values
- ▶ Rear stop move out function
- ▶ Cutting kerf compensation
- ▶ Positioning accuracy 0.1 mm
- ▶ Cut length validation via configurable stroke length
- ▶ Cut counter
- ▶ Control of machine accessories (e.g., optional sheet support device) and motorised cutting kerf adjustment



Finger guard

Fold-up finger guard for first metre



Reach

supports cutting of steel sheets longer than the cutting length (A)



Finger guard

by means of safety light barrier (option)

Accessories	Art. no.
Safety light barrier (instead of finger guard)	3883040
Reach 500 mm 3100-60 CNC	3883041
Reach 500 mm	3883042
HTBS-K 3100-100/3100-130/4100-60 CNC	
Reach 500 mm	3883043
HTBS-K 3100-160/4100-130/4100-160 CNC	
Reach 500 mm HTBS-K 3100-200/4100-200 CNC	3883044
Pneumatic thin sheet support device	3883045
Standard HTBS-K 3100-60/3100-100/3100-130	
Pneumatic thin sheet support device	3883046
Standard HTBS-K 3100-160/3100-200	
Pneumatic thin sheet support device	3883047
Standard HTBS-K 4100-60/4100-130	
Pneumatic thin sheet support device	3883048
two-level HTBS-K 3100-60/3100-100	
Pneumatic thin sheet support device	3883049
two-level HTBS-K 3100-130	
Pneumatic thin sheet support device	3883050
two-level HTBS-K 3100-160	
Pneumatic thin sheet support device	3883051
two-level HTBS-K 4100-60	
Pneumatic thin sheet support device	3883052
two-level HTBS-K 4100-130	
Pneumatic thin sheet support device return to sender	3883053
max. 6mm HTBS-K 3100-60/3100-100/3100-130	
Pneumatic thin sheet support device return to sender	3883054
max. 6mm HTBS-K 3100-160	
Pneumatic thin sheet support device return to sender	3883055
max. 6mm HTBS-K 4100-60/4100-130	
Pneumatic thin sheet support device return to sender	3883056
max. 6mm HTBS-K 4100-160	
Sheet holding device with conveyor belt and	3883057
waste container HTBS-K 3100-60/3100-100/3100-130	

Accessories	Art. no.
Sheet holding device with conveyor belt and	
waste container HTBS-K 3100-160	3883058
Sheet holding device with conveyor belt and	
waste container HTBS-K 4100-60/4100-130	3883059
Sheet holding device with conveyor belt and	
waste container HTBS-K 4100-160	3883060
Stack conveyor HTBS-K 3100-60/3100-100/3100-130	3883061
Stack conveyor HTBS-K 3100-160	3883062
Stack conveyor HTBS-K 4100-60/4100-130	3883063
Stack conveyor HTBS-K 4100-160	3883064
Rear stop 1250 mm	3883065
Rear stop swivels up hydraulically HTBS-K 3100-	
160/3100-200/4100-130/4100-160/4100-200	3883066
Adjustable angle stop 0-180°	3883067
Support arm L=2m (1 pc.)	3883068
Support arm L=3m (1 pc.)	3883069
Support arm extension L=2m (1 pc.)	3883070
Support arm extension L=3m (1 pc.)	3883071
Angle stop extension L=2m (1 pc.)	3883072
Angle stop extension L=3m (1 pc.)	3883073
Angle stop (1500 mm) on right side	3883074
Laser cutting line	3883075
1 replacement knife set HTBS-K 3100-60	3883076
1 replacement knife set HTBS-K 3100-100	3883077
1 replacement knife set HTBS-K 3100-130	3883078
1 replacement knife set HTBS-K 3100-160	3883079
1 replacement knife set HTBS-K 3100-200	3883080
1 replacement knife set HTBS-K 4100-60	3883081
1 replacement knife set HTBS-K 4100-130	3883082
1 replacement knife set HTBS-K 4100-160	3883083
1 replacement knife set HTBS-K 4100-200	3883084
Manual centralised lubrication system	3883085



Notching & punching

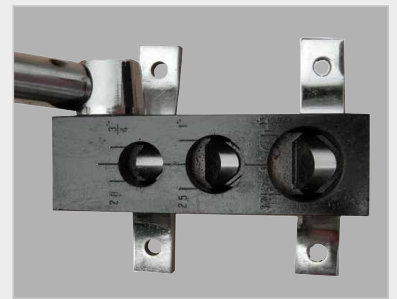
MRA - Manual pipe notcher

- ▶ For notching pipes up to 3 mm wall thickness
- ▶ up to three different sizes (MRA 2)
- ▶ Can be used both horizontally and vertically
- ▶ Low force application
- ▶ Very light

Model	MRA 2	MRA 3
Art. no.	3772992	3772993
Technical specifications		
Pipe diameter	28 / 34 / 43 mm	50 / 61 mm
Wall thickness*	Max. 3 mm	Max. 3 mm
Notcher dimensions without lever	195 x 160 x 80 mm	205 x 160 x 105 mm
Notcher dimensions with lever	1060 x 160 x 80 mm	1090 x 160 x 105 mm
Weight	8 kg	15 kg

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

New



• up to three different sizes (MRA 2)

Option	Art. no.
Replacement knife set MRA 2	3772996
Replacement knife set MRA 3	3772997

AKM 100 T - Manual notching machine

- ▶ Fast and easy straight notching with burr-free cut and without deformation of the cut edges possible
- ▶ Rugged grey cast iron design
- ▶ Adjustable stops with scale for convenient working

Model	AKM 100T
Art. no.	3770512
Technical specifications	
Cutting performance*	3 mm
Cutting area	100 x 100 mm
Cutting angle	90°
Work table	380 x 280 mm
Weight	90 kg
Stroke adjustment	30 mm
Dimensions L x W x H	450 x 390 x 1020 mm

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



AKM 100T
Manual notching machine



Rugged steel design



Easy scale setting

Accessories	Art. no.
Replacement knife	3880701

AKM V - Hydraulic notching machines with adjustable angle of 30 - 140°

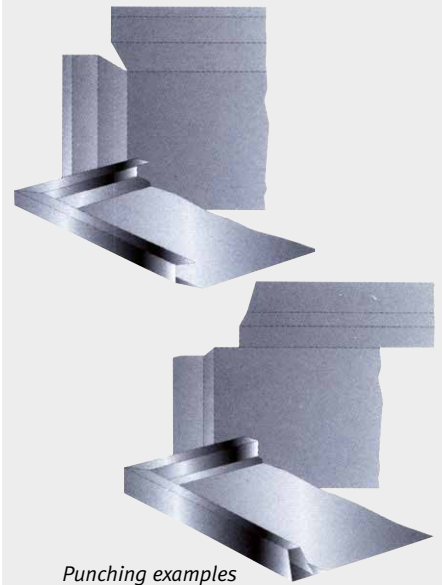
- ▶ Heavy and stable welded design
- ▶ Precision steel table with recessed scale and T grooves for precise adjustment of the stops
- ▶ Stops adjustable $\pm 45^\circ$
- ▶ Fast angle adjustment of blades via hand wheels
- ▶ Drawer for cut-off waste
- ▶ Easy operation via foot pedal
- ▶ Premium knives, also suitable for cutting stainless steel
- ▶ Time-saving stroke adjustment for adapting the cutting length
- ▶ With two hydraulic hold-down units



AKM V - Series
With adjustable angle



Work table with T grooves and recessed scales
Hydraulic hold-down unit



Punching examples

AKM V- notching machine with variable angle adjustment

Technical specifications	Cutting performance 30°	Cutting performance 60°	Cutting area in mm	Cutting angle	Oil reservoir content	Motor output	Electrical connections	Weight	Dimensions L x W x H	Article no.		
AKM 200-60 V	6 mm	4 mm	200 x 200	30 - 140°	50 l.	4.0 kW	400 V/50 Hz	1000 kg	1050 x 900 x 1300	3817005		

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

Accessories	Art. no.
Replacement knives (1 set)	3880019

HPS - combined hydr. steel section shears/hole punches with up to 5 processing stations and foot operation

- ▶ Punching station, flat steel shears, angled steel shears, steel section shears, as of HPS 45S with notching station
- ▶ DS series with two work cylinders and two foot pedals for working with the punching station and steel section shears at the same time
- ▶ Continuously variable stroke length setting
- ▶ Larger reach for punching station with 620 mm optionally available as of HPS 55DS
- ▶ Heavy and stable welded design
- ▶ With notching knife as standard as of HPS 45S
- ▶ With powerful 400 Volt motor
- ▶ Optional V notching knife, extra-large punching unit and longer reach for punching station available on request
- ▶ Two-stage foot pedal for inching operation



HPS 45S



HPS 55DS

Important note

Delivered as standard with Mubea holder, on request, the machines can be delivered with other popular tool holders

Benefits of punching compared with drilling

- ▶ Huge time savings cycle times
- ▶ No chips
- ▶ No cooling

Technical specifications	HPS 40S	HPS 45S	HPS 60S	HPS 55DS	HPS 65DS	HPS 85DS	HPS 115DS	HPS 175DS
Art. no.	3819040	3819045	3819060	3819055	3819065	3819085	3819115	3819175
Punching station								
Pressure	40 t	45 t	60 t	55 t	65 t	85 t	115 t	175 t
Ø in max. sheet thickness**	Ø 20 x 15 mm Ø 30 x 10 mm	Ø 22 x 15 mm Ø 38 x 8 mm	Ø 28 x 15 mm Ø 38 x 11 mm	Ø 20 x 20 mm Ø 40 x 10 mm	Ø 26 x 20 mm Ø 57 x 10 mm	Ø 33 x 20 mm Ø 57 x 10 mm	Ø 34 x 26 mm Ø 55 x 16 mm	Ø 40 x 32 mm Ø 57 x 22 mm
Reach	175 mm	175 mm	220 mm	255 mm	305 mm	355 mm	355 mm	625 mm
Stroke	50 mm	50 mm	55 mm	60 mm	55 mm	80 mm	80 mm	80 mm
Stroke/min.	20	20	25	25	25	25	25	22
Hole punch working height	970 mm	935 mm	955 mm	1030 mm	1030 mm	1080 mm	1110 mm	1130 mm
Steel bar shears								
Round/square in mm	Ø 30 / 25	Ø 30 / 25	Ø 40 / 35	Ø 40 / 40	Ø 45 / 45	Ø 50 / 50	Ø 55 / 50	Ø 65 / 50
Angled steel shears								
90° cut in mm	80 x 80 x 8	100 x 100 x 10	120 x 120 x 12	120 x 120 x 12	120 x 120 x 12	150 x 150 x 15	150 x 150 x 15	200 x 200 x 15
45° cut in mm	50 x 6 mm	70 x 6	80 x 8	70 x 10	70 x 10	80 x 8	80 x 10	80 x 10
Working height	1100 mm	1140 mm	1155 mm	1130 mm	1140 mm	1200 mm	1215 mm	1130 mm
Tin shears								
Max. material thickness	200 x 13 mm	200 x 15 mm	200 x 20 mm	200 x 20 mm	300 x 20 mm	380 x 20 mm	380 x 25 mm	380 x 30 mm
Max material size	300 x 6 mm	300 x 12 mm	300 x 15 mm	300 x 15 mm	375 x 15 mm	480 x 15 mm	600 x 15 mm	600 x 20 mm
Knife length	356 mm	316 mm	317 mm	317 mm	380 mm	482 mm	610 mm	610 mm
Angled cut	80 x 10 mm	80 x 10 mm	80 x 10 mm	80 x 15 mm	100 x 15 mm	120 x 15 mm	120 x 15 mm	120 x 15 mm
Working height	980 mm	935 mm	955 mm	900 mm	900 mm	940 mm	935 mm	810 mm
Notching station								
Max. material thickness	-	8 mm	10 mm	10 mm	10 mm	13 mm	13 mm	16 mm
Width	-	35 mm	42 mm	45 mm	45 mm	52 mm	60 mm	60 mm
Depth	-	75 mm	100 mm	90 mm	90 mm	100 mm	100 mm	100 mm
Motor output	3 kW	4 kW	4 kW	5.5 kW	5.5 kW	7.5 kW	11 kW	11 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Net weight	580 kg	1165 kg	1440 kg	1520 kg	1600 kg	2315 kg	2920 kg	6000 kg
Dimensions in mm	1100 x 800 x 1520	1430 x 950 x 1780	1520 x 950 x 1780	1500 x 950 x 1880	1700 x 950 x 1880	1920 x 950 x 2040	2040 x 950 x 2180	2730 x 1150 x 2280
Optional equipment								
Reach	-	-	-	620 mm	620 mm	620 mm	620 mm	-
U-I profile cutter	76 x 38 mm	80 x 45 mm	80 x 45 mm	120 x 58 mm	120 x 58 mm	160 x 74 mm	200 x 90 mm	300 x 125 mm
T profile cutter	38 x 6 mm	40 x 5 mm	80 x 9 mm	80 x 9 mm	90 x 11 mm	100 x 11 mm	120 x 13 mm	150 x 15 mm
V notching tools in mm	100 x 100 x 8	100 x 100 x 10	100 x 100 x 10	100 x 100 x 10	100 x 100 x 10	100 x 100 x 13	100 x 100 x 13	100 x 100 x 16

All hydraulic steel section shears are delivered with oil. **Performance data for material with tensile strength of 400N/mm² ***Extra-large punching unit option required

Scope of supply
HPS 40S

Punching station
Flat steel shears
Angled steel shears
Steel section shears with round and square knife
Punch mount with bayonet closure
Punch and die reducers
No. 1, No. 2, No. 3, No. 30, No. 45, No. 60
Punch and flat steel shears with adjustable stops
Hook wrench
Foot pedal
Hydraulic oil

Scope of supply
HPS 45S/ HPS 60S

Punching station
Flat steel shears
Angled steel shears
Steel section shears with round and square knife
Notching station
Punch mount with bayonet closure
Punch and die reducers
No. 1, No. 2, No. 3, No. 30, No. 45 and No. 60
Punch, flat steel shears and notcher with adjustable stops
Hook wrench
Foot pedal
Hydraulic oil

Scope of supply
HPS 55DS / HPS 65DS /
HPS 85DS / HPS 115DS / HPS 175DS

Punching station
Flat steel shears
Angled steel shears
Steel section shears with round and square knife
Notching station
Work light
Electrical contact stop
Punch mount with bayonet closure
Punch and die reducers
No. 1, No. 2, No. 3, No. 30, No. 45 and No. 60
Punch with adjustable stop and scale, flat steel shears and notcher with adjustable stops
Hook wrench
2 working cylinders and 2 foot pedals
Hydraulic oil



HPS 45S



• Punching station



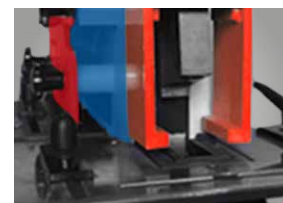
• Angled steel shears



• Flat steel shears



• Steel bar shears /
Steel bar knives



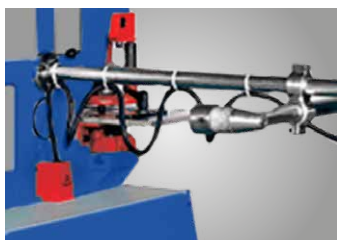
• Notching station
(as of HPS 45S)



HPS 115DS



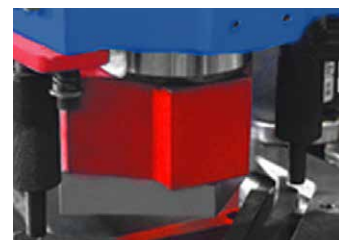
HPS 175DS



· Electrical contact stop
(standard as of HPS 55DS)



· Work light standard
as of HPS 55DS



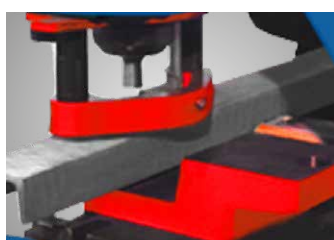
· Optional V notching knife
available as of HPS 45S

Accessories for hydraulic section steel shears

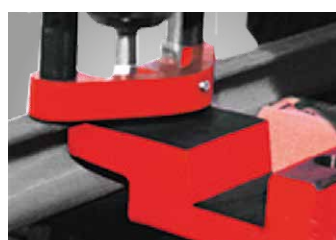
Replacement knife set for flat steel station	Art. no.	Knife set for IPN sections	Art. no.	Edge bending unit	Art. no.
for HPS 40S and 45S	3887010	for HPS 40S and 45S	3887050	Edge bending unit 100 x 12 mm for HPS 45S	3887090
for HPS 60S	3887011	for HPS 60S	3887051	Edge bending unit 150 x 12 mm for HPS 60S	3887091
for HPS 55DS and 65DS	3887012	for HPS 55DS and 65DS	3887052	Edge bending unit 250 x 15 mm for HPS 55DS and 65DS	3887092
for HPS 85DS	3887013	for HPS 85DS	3887053	Edge bending unit 500 x 3 mm for HPS 55DS and 65DS	3887093
for HPS 115DS	3887014	for HPS 115DS	3887054	Edge bending unit 250 x 20 mm for HPS 85DS	3887094
for HPS 175DS	3887015	for HPS 175DS	3887055	Edge bending unit 500 x 3 mm for HPS 85DS	3887095
Replacement knife set for angled steel station		Knife set for UPN sections		Edge bending unit 250 x 22 mm for HPS 115DS	3887096
for HPS 40S and 45S	3887020	for HPS 40S and 45S	3887060	Edge bending unit 500 x 3 mm for HPS 115DS	3887097
for HPS 60S	3887021	for HPS 60S	3887061	Edge bending unit 250 x 25 mm for HPS 175DS	3887098
for HPS 55DS and 65DS	3887022	for HPS 55DS and 65DS	3887062	Edge bending unit 700 x 4 mm for HPS 175DS	3887099
for HPS 85DS	3887023	for HPS 85DS	3887063	Die block for U section	
for HPS 115DS	3887024	for HPS 115DS	3887064	for HPS 40S and 45S	3887105
for HPS 175DS	3887025	for HPS 175DS	3887065	for HPS 60S	3887106
Replacement knife set for steel bar station		Knife set for T sections		for HPS 55DS and 65DS	3887107
for HPS 40S and 45S	3887026	for HPS 40S and 45S	3887070	for HPS 85DS	3887108
for HPS 60S	3887027	for HPS 60S	3887071	for HPS 115DS	3887109
for HPS 55DS and 65DS	3887028	for HPS 55DS and 65DS	3887072	for HPS 175DS	3887110
for HPS 85DS	3887029	for HPS 85DS	3887073	620 mm reach for punching station	
for HPS 115DS	3887030	for HPS 115DS	3887074	for HPS 55DS	3887120
for HPS 175DS	3887031	for HPS 175DS	3887075	for HPS 65DS	3887121
Replacement knife set for notching station		V knife set 100 x 100 mm for notching station		for HPS 85DS	3887122
for HPS 45S	3887040	for HPS 45S	3887080	for HPS 115DS	3887123
for HPS 60S	3887041	for HPS 60S	3887081	<i>Only available ex works</i>	
for HPS 55DS and 65DS	3887042	for HPS 55DS and 65DS	3887082		
for HPS 85DS	3887043	for HPS 85DS	3887083		
for HPS 115DS	3887044	for HPS 115DS	3887084		
for HPS 175DS	3887045	for HPS 175DS	3887085		



Various steel section knives, die blocks and special punches and dies available on request



• Optional die block for U sections



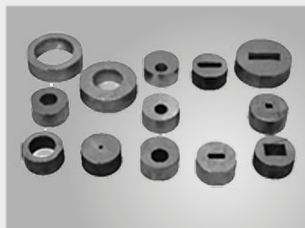
• Optional die block for angled steel



• Optional edge bending unit for flat steel (available as of HPS 45S)



• Optional punching unit for large diameters



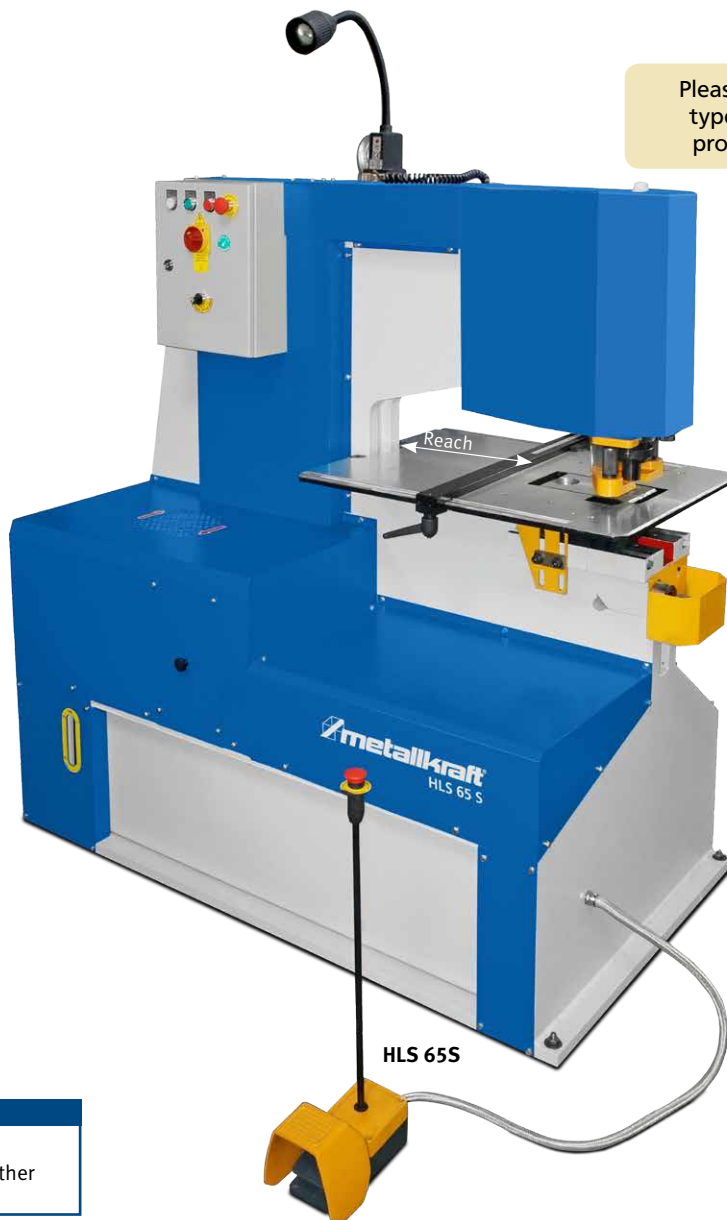
· Various optional punching tools on request

HLS - Hydraulic foot-operated hole punches from 65 to 175 t punching pressure

- ▶ For punching sheet metal, flat and U steels
- ▶ Heavy and stable welded design
- ▶ Punching table with scale and stops
- ▶ Particularly long reach of 625 mm
- ▶ Time-saving, continuously adjustable stroke setting

- ▶ With powerful motor
- ▶ Continuously variable stroke length setting
- ▶ Die block with second mount for processing UPN sections

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



Scope of supply HLS

Punch mount with bayonet closure
Punch and die reducers No. 1, No. 2, No. 3, No. 30, No. 45 and No. 60
Stop with scale
Work light
Foot pedal
Hook wrench
Hydraulic oil

Important note

Delivered as standard with Mubea holder,
on request, the machines can be delivered with other popular tool holders

Model	HLS 65S	HLS 85S	HLS 115S	HLS 175S
Art. no.	3818065	3818085	3818115	3818175
Technical specifications				
Pressure	65 t	85 t	115 t	175 t
Ø in max. sheet thickness**	Ø 26 x 20 mm Ø 57 x 10*** mm	Ø 33 x 20 mm Ø 57 x 12*** mm	Ø 34 x 26 mm Ø 55 x 16*** mm	Ø 40 x 32 mm Ø 57 x 22*** mm
Reach	625 mm	625 mm	625 mm	625 mm
Stroke	55 mm	80 mm	80 mm	80 mm
Stroke/min.	22	21	21	21
Hole punch working height	950 mm	950 mm	950 mm	950 mm
Motor output	5.5 kW	7.5 kW	11 kW	11 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Dimensions in mm	1600 x 900 x 1800	1850 x 950 x 1920	2000 x 950 x 1970	2700 x 1120 x 2160
Weight	2440 kg	3270 kg	3760 kg	5270 kg
Optional				
Sheet metal bending max.	500 x 3 mm	500 x 3 mm	700 x 3 mm	700 x 4 mm

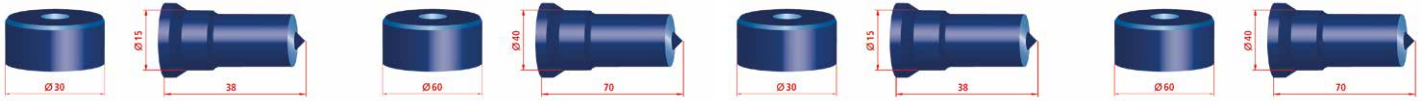
Please turn over for descriptions of the transport surcharges. **Performance data for material with tensile strength of 400N/mm² *Extra-large punching unit option required

Punches and dies for Mubea hole punches

- ▶ The actual dimension of the punch determines the size of the hole to be punched
- ▶ The actual dimension of the die opening

depends mainly on the material thickness to be processed and is a function of the actual dimension of the punch plus an allowance for

- ▶ cutting (= 2x cutting kerf).
- ▶ The cutting play should normally be around 10% of the material thickness.



Round punch

Round die

Round punch No.1

Round punch No.2

Round punch No.3

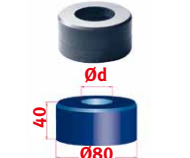
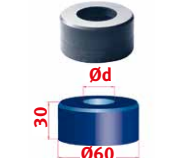
Round punch No.4

Round die No.30

Round die No.45

Round die No.60

Round die No.80



Ød (mm)
3.0
3.5
4.0
4.5
5.0
5.5
6.0
6.5
7.0
7.5
8.0
8.5
9.0
9.5
10.0
10.5
11.0
11.5
12.0
12.5
13.0
13.5
14.0
14.5
15.0

Ød (mm)
14.0
15.0
15.5
16.0
16.5
17.0
17.5
18.0
18.5
19.0
19.5
20.0
20.5
21.0
21.5
22.0
22.5
23.0
23.5
24.0
24.5
25.0
25.5
26.0
26.5
27.0
27.5
28.0
28.5
29.0
29.5
30.0

Ød (mm)
30.5
31.0
32.0
33.0
34.0
35.0
36.0
37.0
38.0
39.0
40.0

Ød (mm)
41.0
42.0
43.0
44.0
45.0
46.0
47.0
48.0
49.0
50.0

Ød (mm)
3.2
3.7
4.2
4.7
5.2
5.7
6.2
6.7
7.2
7.7
8.2
8.7
9.2
9.7
10.2
10.7
11.2
11.7
12.2
12.7
13.2
13.7
14.2
14.7
15.2
15.7

Ød (mm)
14.7
15.2
15.7
16.2
16.7
17.2
17.7
18.2
18.7
19.2
19.7
20.2
20.7
21.2
21.7
22.2
22.7
23.2
23.7
24.2
24.7
25.2
25.7
26.2
26.7
27.2
27.7
28.2
28.7
29.2
29.7
30.2
30.7
31.2
31.7
32.2
32.7

Ød (mm)
32.2
32.7
33.2
33.7
34.2
34.7
35.2
35.7
36.2
36.7
37.2
37.7
38.2
38.7
39.2
39.7
40.2
40.7
41.2
41.7
42.2

Ød (mm)
42.7
43.2
43.7
44.2
44.7
45.2
45.7
46.2
46.7
47.2
47.7
48.2
48.7
49.2
49.7
50.2
50.7
51.2

Art. no.: 38893 +
Ø d (mm)

Slotted hole punch

Slotted hole die

Slotted hole punch No.2

Slotted hole punch No.3

Slotted hole punch No.4

Slotted hole die No.30

Slotted hole die No.45



w x l (mm)
5.0 x 10.0
5.0 x 15.0
5.0 x 20.0
5.0 x 25.0
5.5 x 11.0
5.5 x 15.0
5.5 x 20.0
5.5 x 25.0
6.5 x 13.0
6.5 x 20.0
6.5 x 25.0
6.5 x 30.0
7.0 x 15.0
7.0 x 20.0
7.0 x 25.0
7.0 x 30.0
8.0 x 13.0
8.0 x 20.0
8.0 x 25.0
8.0 x 30.0
9.0 x 13.0
9.0 x 18.0
9.0 x 20.0
9.0 x 25.0
9.0 x 30.0
9.5 x 20.0
9.5 x 25.0
9.5 x 30.0

w x l (mm)
9.0 x 40.0
11.0 x 35.0
11.0 x 40.0
13.5 x 35.0
13.5 x 40.0
14.0 x 35.0
14.0 x 40.0
16.0 x 35.0
16.0 x 40.0
17.5 x 35.0
17.5 x 40.0
19.0 x 35.0
19.0 x 40.0
20.5 x 35.0
20.5 x 40.0
22.5 x 35.0
22.5 x 40.0
25.5 x 40.0
26.0 x 40.0
27.0 x 40.0

w x l (mm)
11.0 x 45.0
11.0 x 50.0
13.5 x 50.0
17.5 x 50.0
20.5 x 50.0
22.5 x 50.0
24.0 x 50.0
25.5 x 50.0
26.0 x 50.0
27.0 x 50.0

w x l (mm)
5.3 x 10.3
5.3 x 15.3
5.8 x 11.3
5.8 x 15.3
6.0 x 11.0
6.0 x 16.0
6.5 x 12.0
6.5 x 16.0
6.8 x 13.3
7.3 x 15.3
7.5 x 14.0
8.0 x 16.0
8.3 x 13.3
9.0 x 14.0
9.3 x 13.3
10.0 x 14.0
10.8 x 15.3
11.5 x 16.0

w x l (mm)
5.3 x 20.3
5.3 x 25.3
5.8 x 20.3
5.8 x 25.3
6.0 x 21.0
6.0 x 26.0
6.5 x 21.0
6.5 x 26.0
6.8 x 20.3
6.8 x 25.3
7.3 x 20.3
7.3 x 25.3
7.3 x 30.3
7.5 x 21.0
7.5 x 26.0
7.5 x 31.0
8.0 x 21.0
8.0 x 26.0
8.0 x 31.0
8.3 x 20.3
8.3 x 25.3
8.3 x 30.3
9.0 x 21.0
9.0 x 26.0
9.0 x 31.0
9.3 x 18.3
9.3 x 20.3
9.3 x 25.3
9.3 x 30.3
9.8 x 20.3
9.8 x 25.3

w x l (mm)
9.8 x 30.3
10.0 x 19.0
10.0 x 21.0
10.0 x 26.0
10.0 x 31.0
10.5 x 21.0
10.5 x 26.0
10.5 x 31.0
10.8 x 21.3
10.8 x 25.3
10.8 x 30.3
11.3 x 20.3
11.3 x 25.3
11.3 x 30.3
11.5 x 22.0
11.5 x 26.0
11.5 x 31.0
12.0 x 21.0
12.0 x 26.0
12.0 x 31.0
12.3 x 20.3
12.3 x 25.3
12.3 x 30.3
13.0 x 21.0
13.0 x 26.0
13.0 x 31.0
13.3 x 20.3
13.3 x 25.3
13.3 x 30.3
13.8 x 20.3
13.8 x 25.3
13.8 x 30.3

Art. no.: 38894 +
w x l (mm)

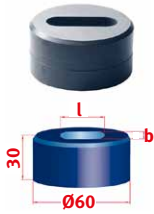
Slotted hole die

Art. no.: 38894 + w x l (mm)

Square punch

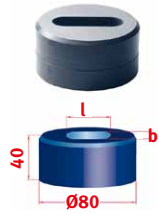
Art.-No.: 38895 + s (mm)

Slotted hole die No.60



w x l (mm)	
9.3 x 40.3	19.3 x 35.3
10.0 x 41.0	19.3 x 40.3
11.3 x 40.3	20.0 x 36.0
12.0 x 41.0	20.0 x 41.0
13.8 x 35.3	20.8 x 35.3
13.8 x 40.3	20.8 x 40.3
14.3 x 35.3	21.5 x 36.0
14.3 x 40.3	21.5 x 41.0
14.5 x 36.0	22.8 x 35.3
14.5 x 41.0	22.8 x 40.3
15.0 x 36.0	23.5 x 36.0
15.0 x 41.0	23.5 x 41.0
16.3 x 35.3	24.3 x 40.3
16.3 x 40.3	25.0 x 41.0
17.0 x 36.0	26.3 x 40.3
17.0 x 41.0	26.5 x 41.0
17.8 x 35.3	27.0 x 41.0
17.8 x 40.3	27.3 x 40.3
18.5 x 36.0	28.0 x 41.0
18.5 x 41.0	

Slotted hole die No.80



w x l (mm)	
11.3 x 45.3	
11.3 x 50.3	
12.0 x 46.0	
12.0 x 51.0	
13.8 x 50.3	
14.5 x 51.0	
17.8 x 50.3	
18.5 x 51.0	
20.8 x 50.3	
21.5 x 51.0	
22.8 x 50.3	
23.5 x 51.0	
24.3 x 50.3	
25.0 x 51.0	
25.8 x 50.3	
26.3 x 50.3	
26.5 x 51.0	
27.0 x 51.0	
27.3 x 50.3	
28.0 x 51.0	

Square punch No.2



s (mm)
4.0
5.0
6.0
7.0
8.0
9.0
10.0
11.0
12.0
13.0
14.0
15.0
16.0
17.0
18.0
19.0
20.0

Square punch No.3



s (mm)
21.0
22.0
23.0
23.5
24.0
24.5
25.0
25.5
26.0
26.5
27.0
27.5
28.0

Square punch No.4

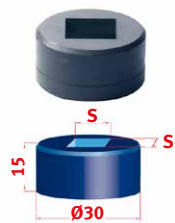


s (mm)
28.5
29.0
29.5
30.0
30.5
31.0
31.5
32.0
32.5
33.0
33.5
34.0
34.5
35.0

Square die

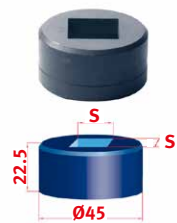
Art.-No.: 38896 + s (mm)

Square die No.30



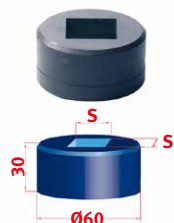
s (mm)	
4.2	8.2
4.7	8.7
5.2	9.2
5.7	9.7
6.2	10.2
6.7	10.7
7.2	11.2
7.7	

Square die No.45



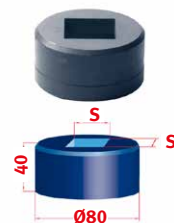
s (mm)	
11.7	17.7
12.2	18.2
12.7	18.7
13.2	19.2
13.7	19.7
14.2	20.2
14.7	20.7
15.2	21.2
15.7	21.7
16.2	22.2
16.7	22.7
17.2	23.2

Square die No.60



s (mm)	
23.2	26.7
23.7	27.2
24.2	27.7
24.7	28.2
25.2	28.7
25.7	29.2
26.2	

Square die No.80



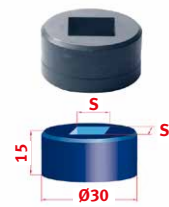
s (mm)	
28.7	32.7
29.2	33.2
29.7	33.7
30.2	34.2
30.7	34.7
31.2	35.2
31.7	35.7
32.2	

How to order:

Select a suitable die or punch and combine the matching article number with the selected size. In this case (cf. right), a customer wants to order a square die with a size of (s) 5.7 mm. The resulting article number for the order is **388965,7**

Square die

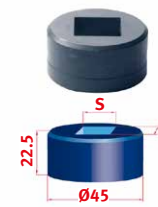
Square die



s (mm)	
4.2	8.2
4.7	8.7
5.2	9.2
5.7	9.7

Art.-No.: 38896 + s (mm)

Square die



s (mm)	
11.7	17.7
12.2	18.2
12.7	18.7
13.2	19.2

Custom and intermediate sizes and non-standard shapes **on request** (3889399)

! We are always happy to advise you on the subject of dies and punches, e.g.,

- Which punch matches which die?
- What size do I need for my application?
- What material can I punch?

Prices on request!
Contact:
(0951) 96555-171
beratung@metallkraft.de



Bending

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 oldtimers
- ▶ 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



Compression jaw Stretching jaw

SSG 16

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

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

* Dimensions without hand lever

Scope of supply:

- ▶ Basic machine
- ▶ Compression jaws
- ▶ Stretching jaws

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 specifications

Cold:

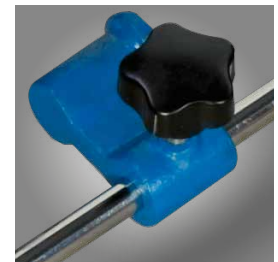
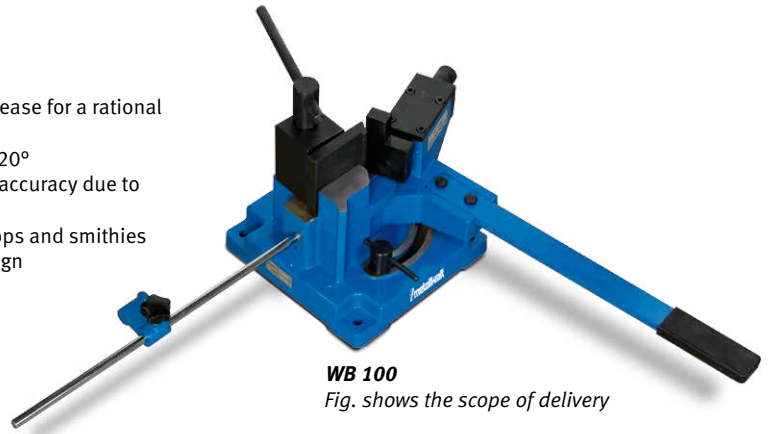
Flat steel	100 x 8 mm
Round steel bars	22 mm
Square steel bars	20 x 20 mm

Hot:

Flat steel	100 x 15 mm
Round steel bars	27 mm
Square steel bars	25 x 25 mm
Dimensions in mm	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 range with 6 bending segments from 1/2" - 2"

- ▶ Bending range 1/2" - 2"
- ▶ Incl. 6 bending segments (1/2" - 3/4" - 1" - 1 1/4" - 1 1/2" - 2")
- ▶ With fold-up bending frame for convenient and rational operation
- ▶ Universally deployable for heating, gas, boiler and water pipes, cooper tube and composite pipes
- ▶ 10 to pressure output
- ▶ With tripod stand for an ergonomic approach



Model	HRB 10
Art. no.	3777010

Technical specifications

Pressure output	10 t
Bending forms	1/2" - 3/4" - 1" - 1 1/4" - 1 1/2" - 2"
Number of legs	3
Piston stroke	155 mm
Dimensions	710 x 590 x 220 mm
Weight	45 kg

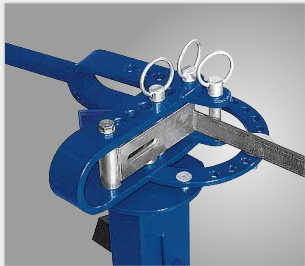
Bending segment	Pipe radius	Wall thickness	Bending radius	Bending angle	Art. no.
1/2"	21.3 mm	3.25 mm	62 mm	0-90 °	3777011
3/4"	26.9 mm	3.50 mm	78 mm	0-90 °	3777012
1"	33.7 mm	4.00 mm	98 mm	0-90 °	3777013
1 1/4"	42.4 mm	4.00 mm	128 mm	0-120 °	3777014
1 1/2"	48.3 mm	4.25 mm	148 mm	0-120 °	3777015
2"	60.3 mm	4.50 mm	187 mm	0-120 °	3777016



- All hinges tempered
- Tempered 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 supply

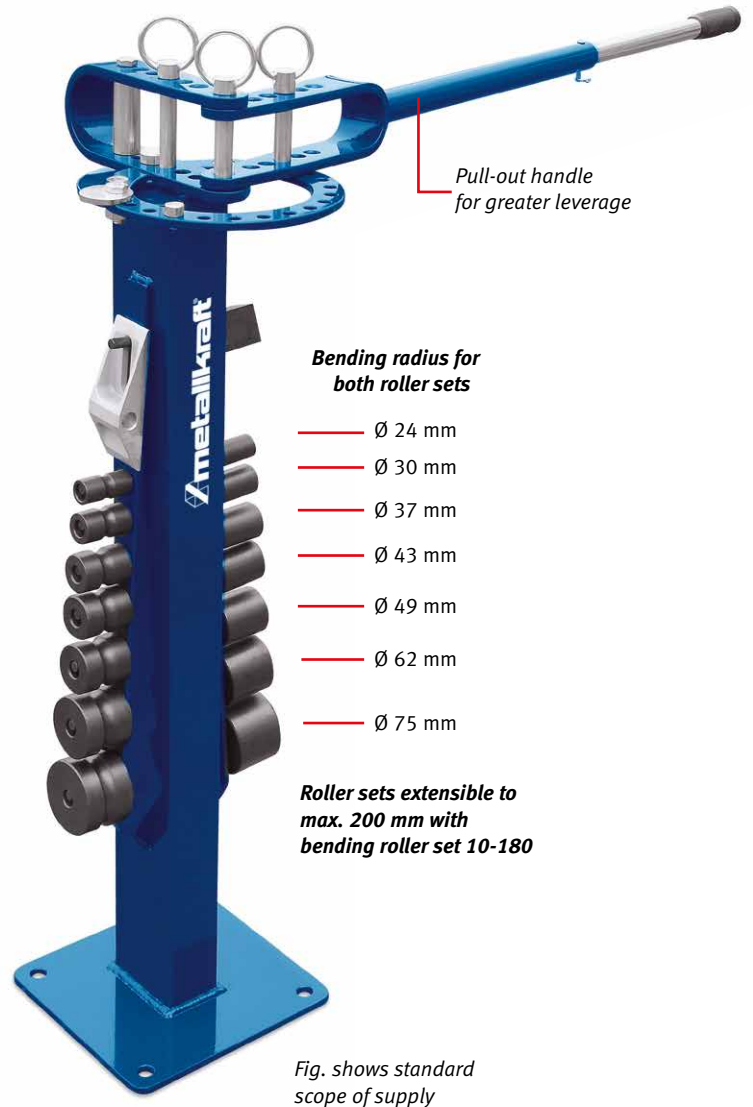
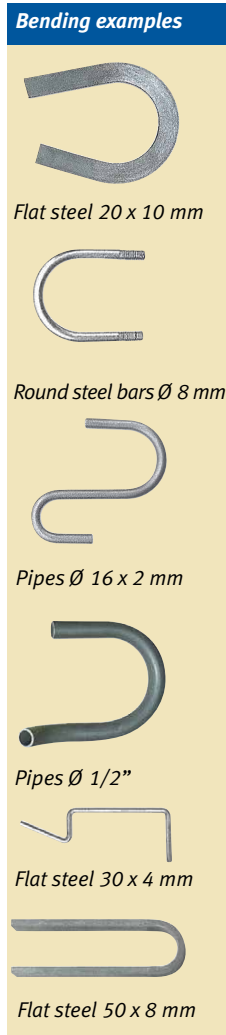


- plate rolling in flat materials

UB 10 - Universal bending machine for angled, round and helical bending of flat and square 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, ideal for workshop, on site and in the service vehicle
- ▶ Removable bending unit with optional clamping plate can also be deployed on a vice



Model	UB 10	
Art. no.	3776010	
Technical specifications		
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

► Galvanised steel

► Grey cast iron

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

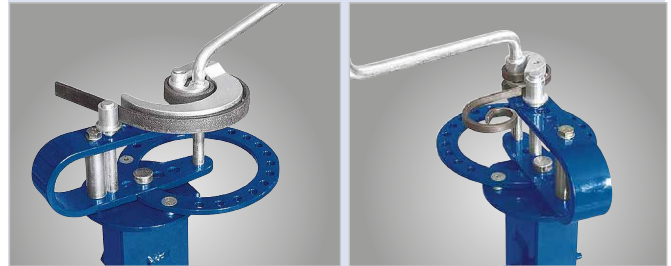
Helical bending element UB 11

- Add-on part for helical bending on the UB 10
- For helical bending
- 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 specifications	
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 without the UB 10 on a commercially available vice

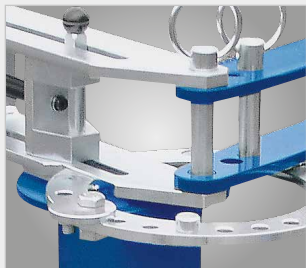


Fig. shows the scope of delivery UB10-280

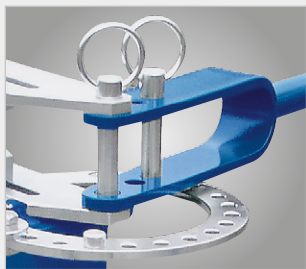
Model	UB 10-280
Art. no.	3790280



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



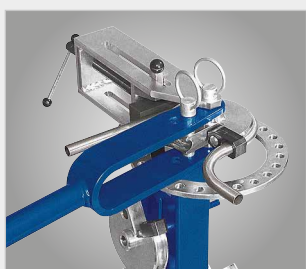
- Bending angle stop for a high level of repetition accuracy
- Tempered bearings



- Tempered bolts



- Space-saving and tidy storage of the bending segments in the base



- Example of combined bending

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

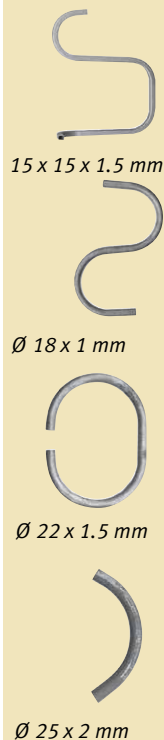
- ▶ Easy cold bending of thin-walled pipes without support elements
- ▶ For bending simple and complex shapes
- ▶ Pull-out handle for greater leverage
- ▶ Easily transportable, ideal for workshop, on site and in the service vehicle

- ▶ Removable bending unit with optional clamping plate, can thus also be deployed on a vice
- ▶ With bolt-on base for the workshop
- ▶ More bending segments



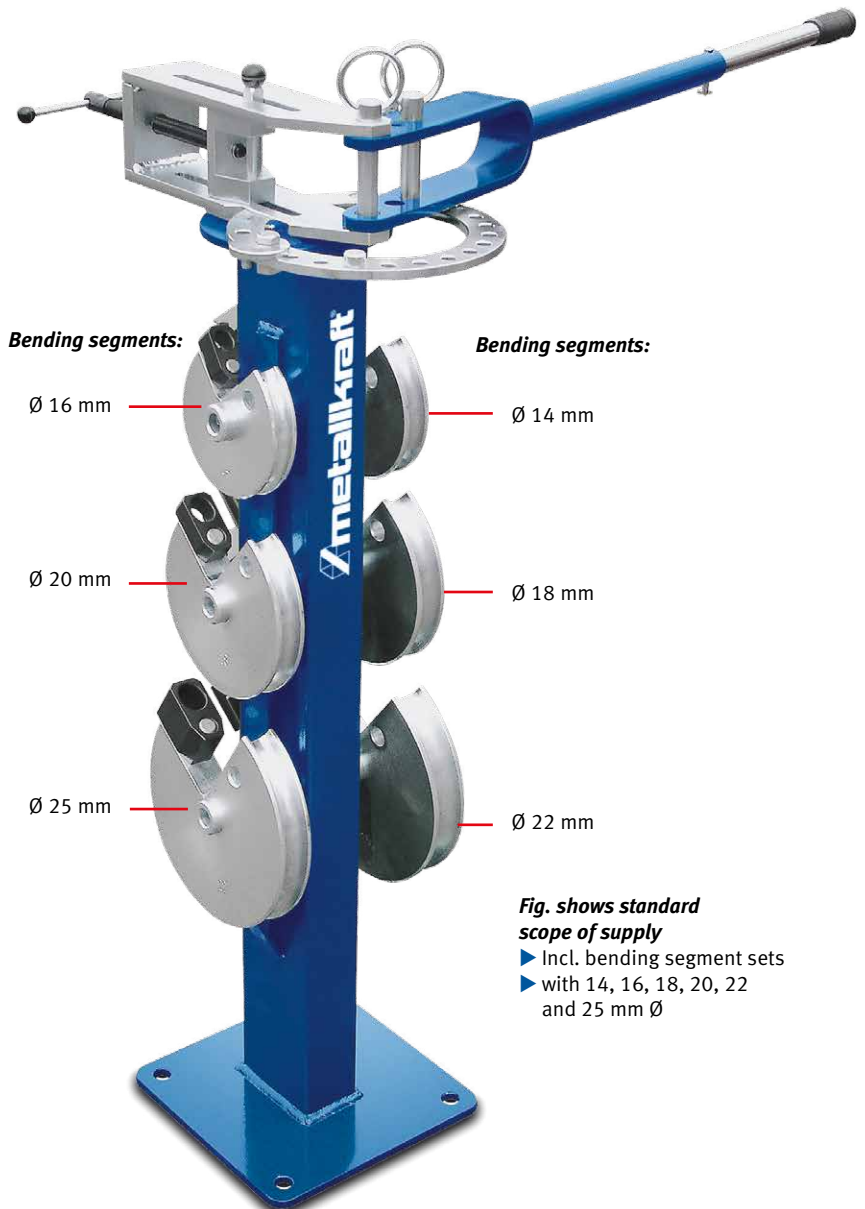
Quality made in Europe

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



Bending segments:

Ø 16 mm

Ø 20 mm

Ø 25 mm

Bending segments:

Ø 14 mm

Ø 18 mm

Ø 22 mm

Fig. shows standard scope of supply

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

Model	RB 30	
Art. no.	3776030	
Technical specifications		
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

Scope of supply:

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

Accessories/bending segments from page 85 usable

Additional bending segments

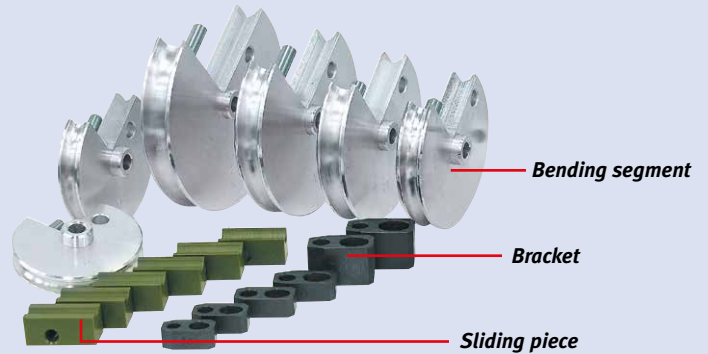
Accessories - bending segment sets (with sliding piece and holder)

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



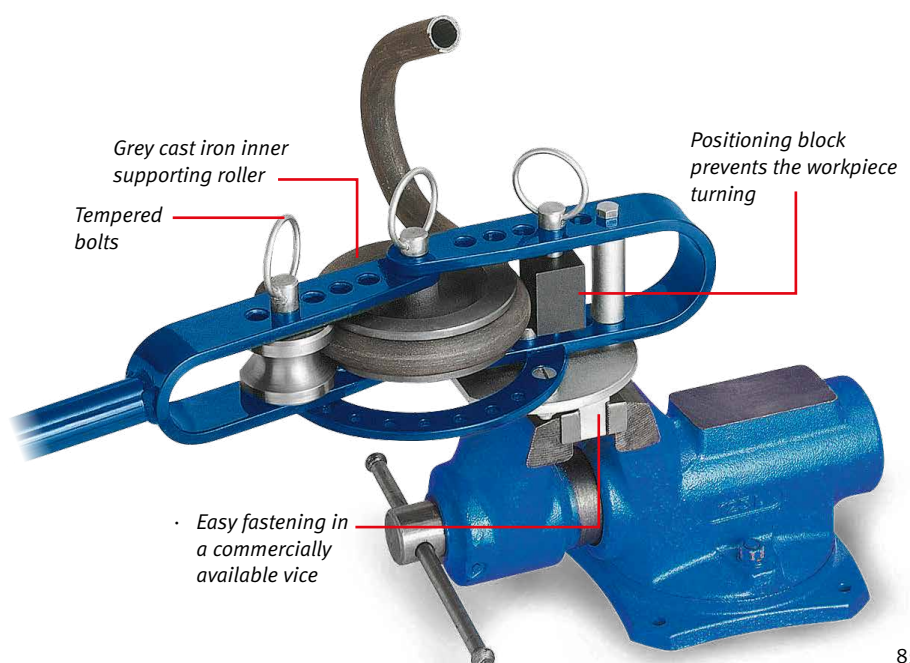
Model	Extension plate RB 30
Art. no.	3790005

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

- ▶ Ideal for mobile use and on the construction site.
- ▶ Easy assembly on a commercially available vice
- ▶ Cold bending up to an angle of 180°
- ▶ Partial bending is also supported
- ▶ Adjustable bending angle stop for a high level of repetition accuracy
- ▶ Very easy to use

Model	RB 12
Art. no.	3776012

Technical specifications	
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



BM series – pipe bending machines without mandrels

made by

MACKMA

IL GRUPPO MASSARO



- ▶ High-quality, compact and very durable design
- ▶ NC control to adjust bending angles and correction
- ▶ Standard control **Simply** (bei BM 34-S, BM 42-SP, BM 42-SA, BM 48-S, BM 60-S, BM 76-S): enter an angle and an offset
- ▶ 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
- ▶ Sophisticated tool system:
- ▶ Bending towards the left and right using the same tool (the tool rotates, bending towards the left or right using rotary switch) – **PATENTED!**
- ▶ Simple 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. If customers already own tools from another manufacturer, they can also use them with their new Mackma machine (corresponding shafts optionally available, on the basis of other manufacturers' tool geometry this will then result in either anti-clockwise or clockwise bending)
- ▶ 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 clamp pipes using a hand wheel, with counter to safeguard a high degree of reproducibility
- ▶ Mobile, manual control panel optionally available
- ▶ Purely motor-driven – no hydraulic components. This results in low-noise, clean operation, independent of temperatures (no oil changes, leaks)
- ▶ Machine completely produced in Italy
- ▶ Very competitive prices
- ▶ Short delivery times for machines and tools
- ▶ 24-month manufacturer's warranty



SIMPLY/EXPERT control

- ▶ Excellent price-performance ratio
- ▶ Patented tool system
- ▶ Lower head bending
- ▶ Bending in anti-clockwise/clockwise direction using the same tool kit
- ▶ High-quality machines made in Italy
- ▶ 24-month manufacturer's warranty
- ▶ Fully driven by the motor – no hydraulics



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 specifications											
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 connections	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

New

Custom accessories

- ▶ Positioning units for 3000 mm or 6000 mm with continuously adjustable stop cams and scale to set the longitudinal position as well as a self-centring 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 inch pipes (1"=37.7mm), for OD inch pipes (1"=25.4mm) or individual, metric dimensions as well as profiles and flat steel available
- ▶ "Expert controls" to enter bending sequences and save programs (8 bends per program, max. 100 programs)



BM 60-S



BM 100-E

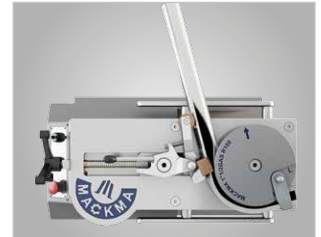


BM 200-E

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	
Bending tool package for steel pipes BM 34-S	3970000
D3/8" x R 36, D1/2" x R 46, D3/4" x R 56, D1" x R 82	
Bending tool package for steel pipes BM 42-S	3970001
D1/2" x R 67; D3/4" x R 82, D1" x R 112, D1 1/4" x R 130	
Bending tool package for steel pipes BM 48-S	3970002
D1/2" x R 67, D3/4" x R 82, D1" x R 112, D1 1/4" x R 130, D1 1/2" x R 150	
Bending tool package for steel pipes BM 60-S	3970003
D1/2" x R 67, D3/4" x R 82, D1" x R 112, D1 1/4" x R 130, D1 1/2" x R 150, D2" x R 190	
Bending tool package for steel pipes BM 76-S	3970004
D1/2" x R 67, D3/4" x R 82, D1" x R 112, D1 1/4" x R 130, D1 1/2" x R 150, D2" x R 190	
1" = 33.7 mm, bending tools for additional pipe diameters, bending radii and materials 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 will 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	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:
- ▶ 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, can be anchored to the floor
- ▶ Two bottom rollers driven by crank
- ▶ Rollers tempered and polished
- ▶ Tempered and polished steel shafts
- ▶ Feed via top roller

- PRM 10 E**
- ▶ Motorised version
 - ▶ Suitable for horizontal and vertical processing
 - ▶ Powerful 400-volt motor
 - ▶ Clockwise/anti-clockwise operation using foot pedal



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

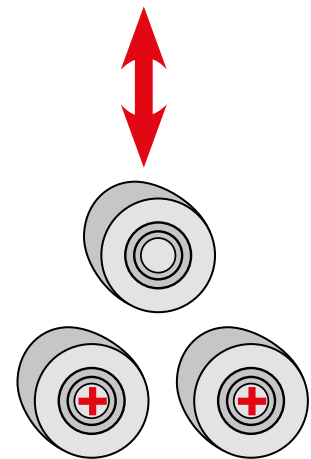
Technical specifications		
Shaft Ø	30 mm	30 mm
Roller Ø at the top	98 mm	98 mm
Roller Ø at the bottom	118 mm	118 mm
Weight	165 kg	230 kg
Dimensions	620 x 560 x 1440 mm	700 x 700 x 1400 mm



PRM 10 E







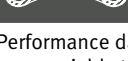


PRM 10 E
Horizontal and vertical working position



Bending performance

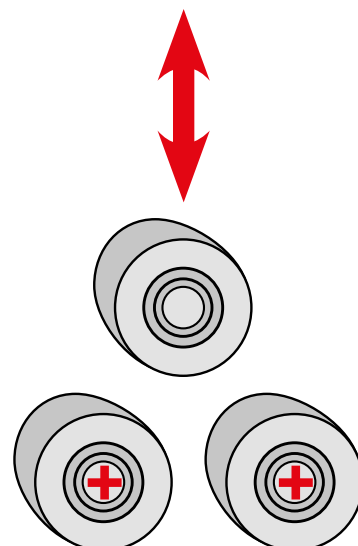
PRM 10

Section type	max. size mm	min. bending Ø mm
Bending option with standard bending rollers:		
	20 10	500 160
	30 x 10 20 x 10	500 300
	50 x 10 30 x 10	400 300
	30 x 2 20 x 2	900 600
	38 x 20 x 2 30 x 15 x 1.5	1000 600
	20 10	500 160
	30 x 2 20 x 2	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

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
- ▶ Suitable for horizontal and vertical processing
- ▶ Bottom rollers driven directly by the motor
- ▶ Tempered rollers
- ▶ Shafts made of special steel, hardened and polished
- ▶ Feed via top roller
- ▶ Lateral guide rollers, continuously adjustable
- ▶ 2 driven rollers
- ▶ Clockwise/anti-clockwise operation using foot pedal
- ▶ Mobile control panel with foot controls



Model	PRM 31 F
Art. no.	3812031
Technical specifications	
Shaft Ø	30 mm
Roller Ø at the top	148 mm
Roller Ø at the bottom	118 mm
Speed	4 m/min.
Motor output	0.75 kW
Electrical connections	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

Bending performance

PRM 31 F

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
	50 x 6 20 x 3	600 400

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 1/2" 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	

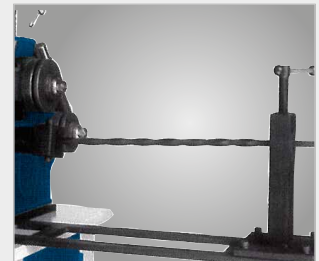
Plastic rollers for aluminium and stainless steel

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!

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

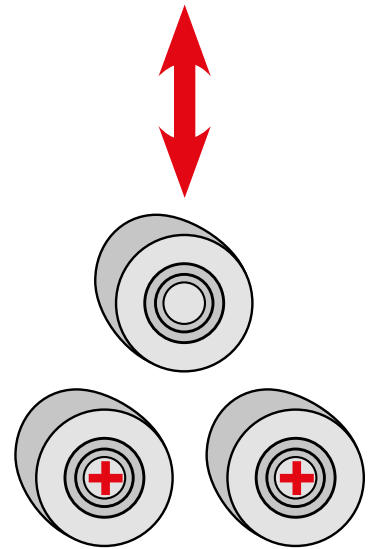
Circular saws

Roller conveyors

Band saws

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
- ▶ Suitable for horizontal and vertical processing
- ▶ Motorised bottom rollers
- ▶ Tempered rollers
- ▶ Tempered and polished steel shafts
- ▶ Feed via top roller
- ▶ Lateral guide rollers, continuously adjustable
- ▶ Clockwise/anti-clockwise operation using foot pedal











Model	PRM 35 F
Art. no.	3812035
Technical specifications	
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 connections	400 V/50 Hz
Weight	400 kg
Dimensions in mm	750 x 1000 x 1400

Scope of supply







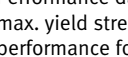
- ▶ Standard bending rollers (refer to table on the right for bending options)
- ▶ Mobile foot pedal for clockwise/anti-clockwise operation with emergency off function
- ▶ Straightening rollers
- ▶ Chassis

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

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



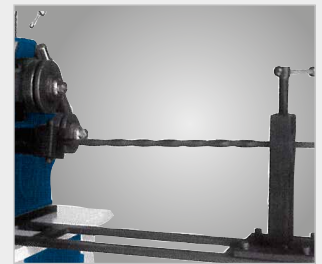
Note

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

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	

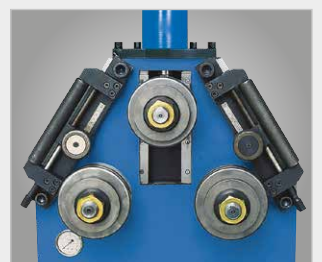
* Price/roller set relates to a dimension from this mm range; state the material dimension you would like to process in your order. Rollers are produced as per these dimensions. **Ex works only



- 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



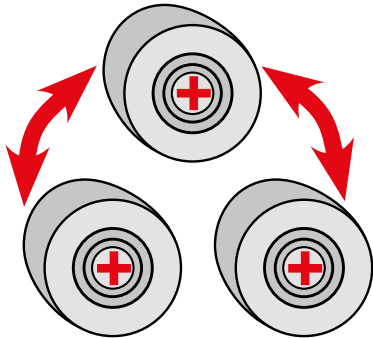
- Application ring bending

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



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
 - ▶ Lateral guide rollers, continuously adjustable
- ▶ 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 specifications	
Shaft Ø	35 mm
Roller Ø	137 mm
Speed	7 m/min.
Motor output 400 V / 50 Hz	1.1 kW
Electrical connections	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
	UPN 35 x 18*	500

Bending options with optional bending rollers:

	25 x 25 x 2	450
	30 x 15 x 2.5	500
	Ø22	200
	Ø33.7"x2.3	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

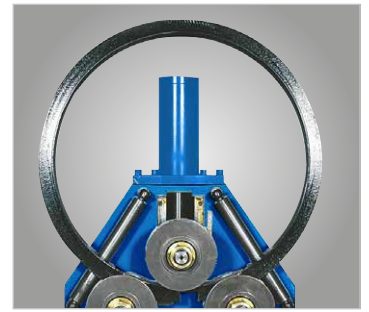


- Pressure gauge

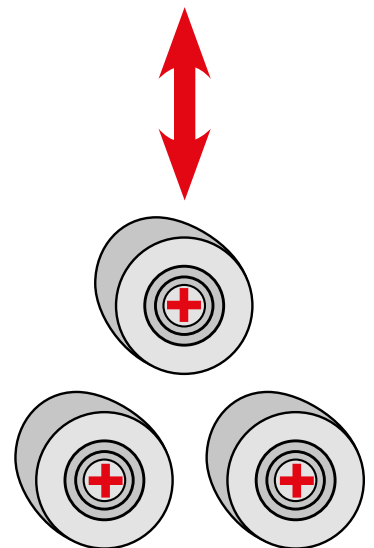
Please state the material type you would like to process in your order!

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
- ▶ Lateral guide rollers, continuously adjustable
- ▶ Separate control panel with foot controls



Application ring bending











Model	PRM 50 FH
Art. no.	3812036
Technical specifications	
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 connections	400 V/50 Hz
Weight	500 kg
Dimensions in mm	810 x 950 x 1500

Scope of supply







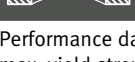
- ▶ Standard bending rollers (refer to table on the right for bending options)
- ▶ Mobile foot pedal for clockwise/anti-clockwise operation with emergency off function
- ▶ Straightening rollers
- ▶ Digital indicator for adjustment roller

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
	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 1/2" 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



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

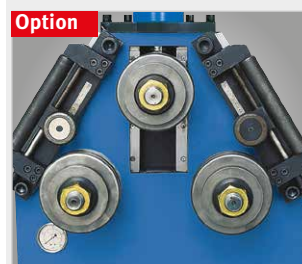


- Digital position display for feed roller



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: Special guide rollers on the sides, for angle sections

Accessories PRM 50 FH	Art. no.	Accessories PRM 50 FH	Art. no.	Accessories PRM 50	Art. no.
Special straightening rollers for angled sections	3880102	Plastic rollers for aluminium and stainless steel		lateral Angle guide	3880161
		0 - 33.7 mm	3880110	NC control	3880163
		34 - 48.3 mm	3880111		
		49 - 60.3 mm	3880112		
		Custom dimensions			
Bending rollers* for PRM 50 FH (please note information below!)		Plastic angle rollers for aluminium and stainless steel			
Steel/iron rollers		30 x 30 x 3 mm	3880113		
0 - 33.7 mm	3880103	40 x 40 x 5 mm	3880114		
34 - 48.3 mm	3880104	50 x 50 x 6 mm	3880115		
49 - 60.3 mm	3880105	60 x 60 x 6 mm	3880116		
Custom dimensions		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					

* 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.

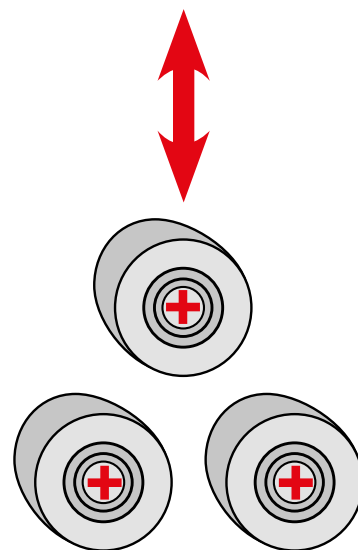
Please state the material type you would like to process in your order!

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
- ▶ Lateral guide rollers, continuously adjustable
- ▶ Separate control panel with foot controls



Application ring bending











Model	PRM 60 FH
Art. no.	3812060
Technical specifications	
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 connections	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

PRM 60 F		
Bending performance		
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
	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 (VA): factor 0.7

*May require additional spacers



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

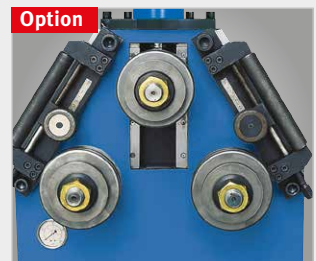


- Digital position display for feed roller



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: special guide rollers on the sides, for angle sections

Accessories PRM 60 FH Art. no.

Special straightening rollers for angled sections 3880161
NC control 3880163

Bending rollers* for PRM 60 FH (please note information below!)

Steel/iron rollers

0 - 33.7 mm 3880410
34 - 48.3 mm 3880411
49 - 60.3 mm 3880412
61 - 76.1 mm 3880413
77 - 88.9 mm 3880414
Custom dimensions

Angle rollers made of steel/iron

50 x 50 x 6 mm 3880420
60 x 60 x 6 mm 3880421
70 x 70 x 6 mm 3880422
Custom dimensions

Accessories PRM 50 FH Art. no.

Plastic rollers for aluminium and stainless steel

0 - 33.7 mm 3880430
34 - 48.3 mm 3880431
49 - 60.3 mm 3880432
61 - 76.1 mm 3880433
77 - 88.9 mm 3880434
Custom dimensions

Plastic angle rollers for aluminium and stainless steel

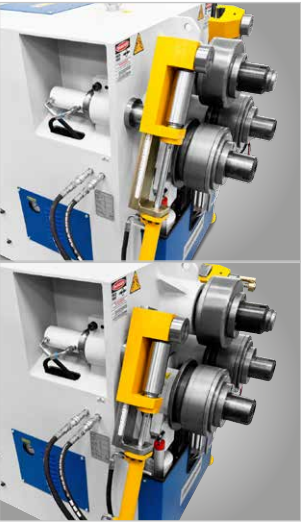
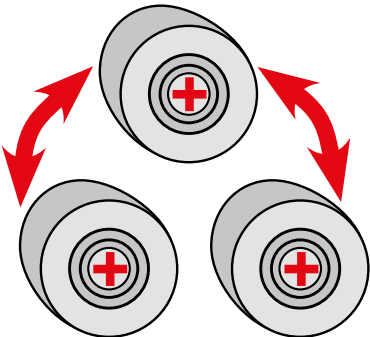
50 x 50 x 6 mm 3880440
60 x 60 x 6 mm 3880441
70 x 70 x 6 mm 3880442
Custom dimensions

* 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 material type you would like to process in your order!

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
- ▶ Lateral mechanical straightening rollers, continuously adjustable
 - ▶ Separate control panel with 2 digital displays for two feed rollers



Lateral mechanical straightening rollers, continuously adjustable



PRM 80 FH









Model	PRM 80 FH
Art. no.	3812080
Technical specifications	
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 connections	400 V/50 Hz
Weight	1700 kg
Dimensions in mm	1450 x 1000 x 1400

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







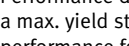
- Scope of supply
- ▶ Standard bending rollers (refer to table on the right for bending options)
 - ▶ Mobile control panel
 - ▶ One digital display per bottom feed roller
 - ▶ Manual straightening rollers
- Custom accessories
- ▶ Hydraulic straightening rollers
 - ▶ Pipe bending rollers
 - ▶ Angle bending 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 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
	100 x 2.5 15 x 1	1200 380
	3 x 5.48 1/2 x 2.77	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 (VA): factor 0.7
*May require additional spacers



PRM 80 FH in horizontal working position

Accessories PRM 50 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



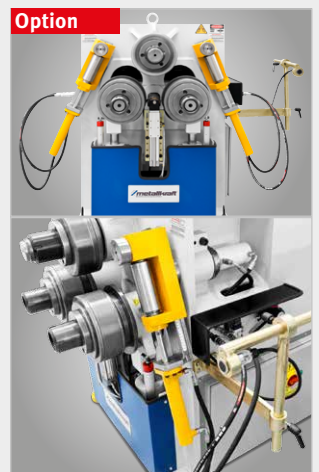
- Option: NC control with touchscreen and teach-in function

Option



- Option: two lateral hydraulic guide rollers

Option



- Option: hydraulic straightening rollers



- Bending process



- Bending examples

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
 - ▶ Suitable for horizontal and vertical processing
 - ▶ All three rollers are driven by a hydro-motor and planetary gear
- ▶ Tempered rollers
 - ▶ Hydraulic feed via two bottom rollers
 - ▶ Lateral mechanical straightening rollers, continuously adjustable
- ▶ Separate control panel with foot controls and 2 digital displays



PRM 100 FH









Model	PRM 100 FH
Art. no.	3812100
Technical specifications	
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 connections	400 V/50 Hz
Weight	3650 kg
Dimensions in mm	2000 x 1450 x 1700

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







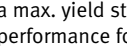
- Scope of supply**
- ▶ Standard bending rollers (refer to table on the right for bending options)
 - ▶ Mobile control panel
 - ▶ One digital display per bottom feed roller
 - ▶ Manual straightening rollers
- Custom accessories**
- ▶ Hydraulic straightening rollers
 - ▶ Infinitely adjustable roller speed
 - ▶ Pipe bending rollers
 - ▶ Angle bending rollers
 - ▶ Special alignment rollers
 - ▶ Section bending rollers
 - ▶ Plastic rollers for soft materials
 - ▶ NC control

Bending performance

PRM 100 FH

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
	UPN 180* UPN 30*	1000 400

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
	125 x 2.5 15 x 1	1400 450
	4 x 6.02 1/2 x 2.77	1000 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 (VA): factor 0.7
*May require additional spacers

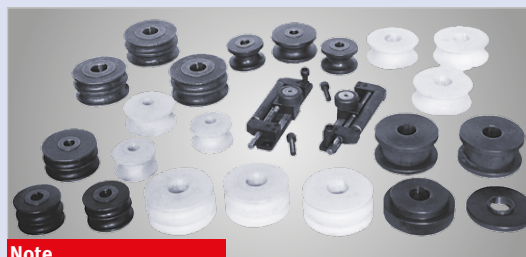


PRM 100 FH in horizontal working position

Large machines on request

Accessories PRM 50 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



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

Option



- Option: two lateral hydraulic guide rollers

Option



- Option: hydraulic straightening rollers



- Bending process



- Bending example

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Band saws

Sales



Sales of Metallkraft end-of-line models, used machines and machines with minor defects

Check out our special offer platform for
**end-of-line models, machines with transport
damage,
seconds, one-offs, demonstrators and sample
machines**
from our product range.

The machines and accessories offered here have been
checked and serviced by our service workshop.

Always up-to-date: **automatic
update** of the articles every two hours.

Articles can be reserved via a user-friendly form.

**View and reserve special offer articles at
attractive prices online at any time!**

Bezeichnung	EUR (inkl. MwSt.)	Sonderpreis (inkl. MwSt.)	Sonderpreis (excl. MwSt.)
D 420x1000 wsl. DPA 2000 OPTIM-Drehmaschine	15.876,11	20%	12.700,89 Detail zur Anfrage
OPTIM T9 5620V Drehmaschine	29.100,00	30%	20.400,00 Detail zur Anfrage
Artikel-Nr.: 3401180PA001SP			
OPTIM T9 5620V / 230V OPTIM-Drehmaschine	2.606,10	20%	2.084,88 Detail zur Anfrage
Artikel-Nr.: 34027001-SP1			
Unterbau 0250x4000	273,70	20%	218,96 Detail zur Anfrage
Artikel-Nr.: 3440427001SP			
Unterbau D 240 / D 260	415,31	30%	290,72 Detail zur Anfrage
Artikel-Nr.: 3440400001SP			
3-Backendrehfutter 200 mm D1-6 Cernik OPTIM	291,55	35%	189,51 Detail zur Anfrage
Artikel-Nr.: 3440722001SP			
3-Backendrehfutter 250 mm D1-6 Cernik OPTIM	391,51	30%	274,06 Detail zur Anfrage



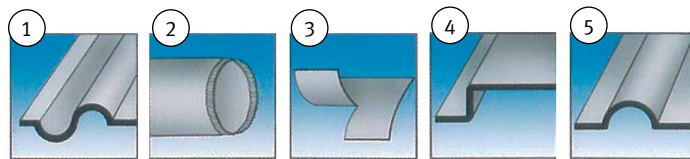
Look here for the Metallkraft special offer platform:
www.metallkraft.de/sonderposten

SBM – Manual bead bending machines

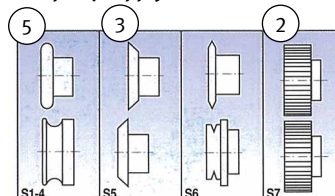
- ▶ Heavy-duty and rugged cast iron design
- ▶ handy and easy to use
- ▶ adjustable bottom shafts
- ▶ steel shafts
- ▶ adjustable stop plate

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

Typical applications

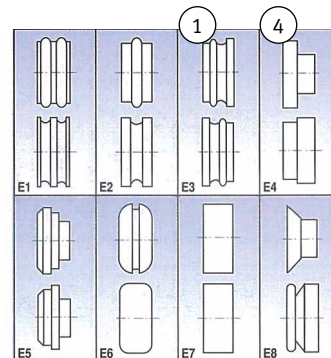


Scope of supply SBM 110-08



S1-4: Standard rollers for
Ø 3/6/8/10 mm

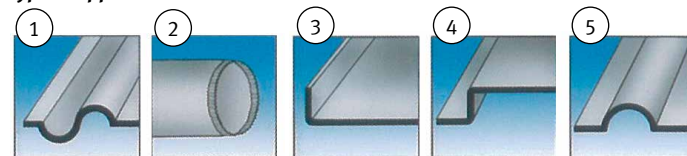
Accessories SBM 110-08



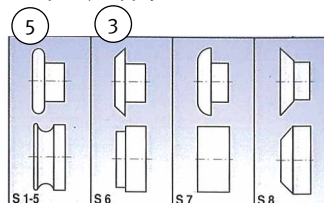
Accessories SBM 110

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

Typical applications

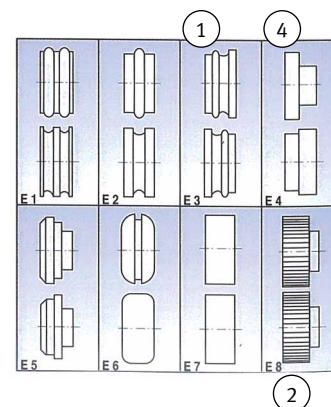


Scope of supply SBM 140-12



S1-5: Standard rollers for
Ø 4/6/7/9/10 mm

Accessories SBM 140-12



Accessories SBM 140

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



SBM 110-08



SBM 140-12

Model	SBM 110-08	SBM 140-12
Art. no.	3814001	3814002
Technical specifications		
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 400N/mm²

SBM 140-12 E - Motorised bead bending machine

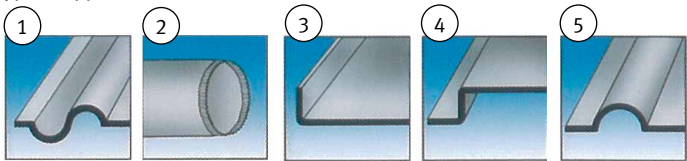
- ▶ Heavy-duty and rugged cast iron design
- ▶ self-braking motor
- ▶ Foot pedal operation
- ▶ Adjustable bottom shaft
- ▶ steel shafts
- ▶ 8 set standard rollers
- ▶ With chassis
- ▶ adjustable stop plate

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

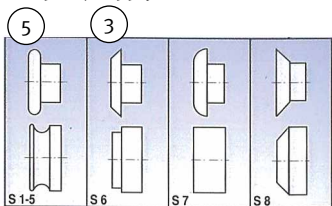


SBM 140-12 E

Typical applications

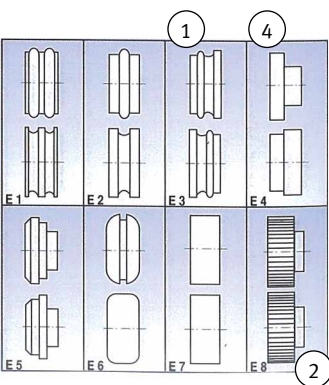


Scope of supply SBM 140-12



S1-5: Standard rollers for Ø 4/6/7/9/10 mm

Accessories SBM 140-12



Model	SBM 140-12 E
Art. no.	3814003

Technical specifications	
Roller length	140 mm
Max. sheet thickness*	1.2 mm
Roller Ø	62 mm
Collar width	100 mm
Roller speed	32 rpm
Motor output	0.75 kW
Electrical connections	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 400N/mm²

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

SBM E – Motorised bead bending machines

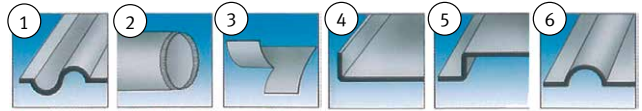
- ▶ heavy-duty and stable steel design
- ▶ self-braking motor
- ▶ Foot pedal operation
- ▶ Adjustable bottom shaft
- ▶ adjustable stop plate
- ▶ Stahl shafts with bronze bushings fitted
- ▶ 4 set standard rollers
- ▶ With chassis



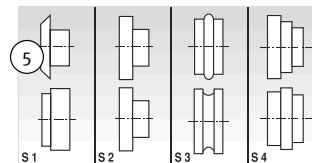
Model	SBM 250-25 E	SBM 300-40 E
Art. no.	3814004	3814005
Technical specifications		
Roller length	250 mm	300 mm
Max. sheet thickness*	2.5 mm	4 mm
Roller Ø	96 mm	126 mm
Collar width	160 mm	200 mm
Roller speed	5 m/min.	5 m/min.
Motor output	1.5 kW	2.2 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz
Weight	350 kg	500 kg
Dimensions L x W x H	1400 x 550 x 1120 mm	1700 x 570 x 1200 mm

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

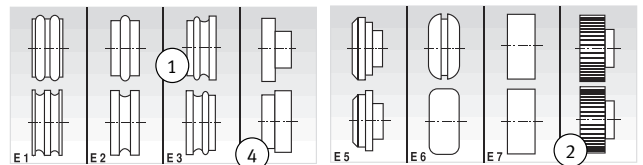
Typical applications



Scope of supply SBM 250-25E



Accessories SBM 250-25E

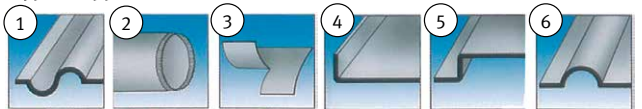


Accessories SBM 250-25E

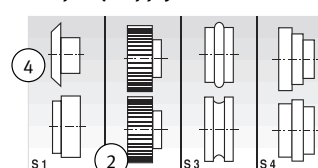
Art. no.
Bending rollers type E1
Bending rollers type E2
Bending rollers type E3
Bending rollers type E4
Bending rollers type E5
Bending rollers type E6
Bending rollers type E7
Bending rollers type E8
Surcharge hydraulic top roller*

*Ex works

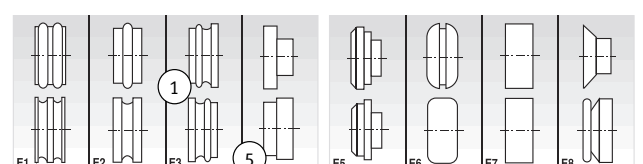
Typical applications



Scope of supply SBM 300-40E



Accessories SBM 300-40E



Accessories SBM 300-40E

Art. no.
Bending rollers type E1
Bending rollers type E2
Bending rollers type E3
Bending rollers type E4
Bending rollers type E5
Bending rollers type E6
Bending rollers type E7
Bending rollers type E8
Surcharge hydraulic top roller*

*Ex works

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

RBM – Manual, asymmetric 3-roller plate rolling machines

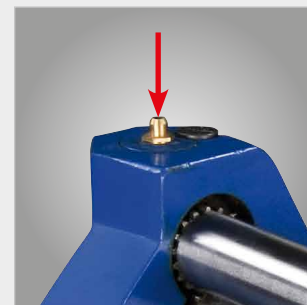
- ▶ Steel rollers
- ▶ Top roller folds out for easier removal of the workpiece
- ▶ Asymmetric roller arrangement for convenient pre-bending
- ▶ Skewing side roller for conical bending
- ▶ Clamping and side roller with wire insert grooves
- ▶ Roller drive via crank and gear
- ▶ Particularly handy and 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)



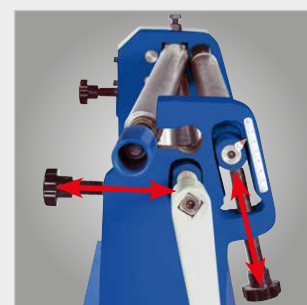
RBM 610-08



- 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 specifications		
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 400N/mm²

Accessories SBM 300-40E
Chassis

Art. no.
3780113

RBM – motorised, asymmetric 3-roller plate rolling machines

- ▶ Heavy-duty and rugged cast iron design
- ▶ asymmetric 3-roller system for convenient pre-bending
- ▶ Top roller swivels out
- ▶ Roller driven via crank
- ▶ Suitable for bending wires with diameters of 3, 5 and 8 mm
- ▶ Fast clamping of the sheet via a lever



RBM 1000-20 Eco

RBM 1050-22

RBM - manually driven plate rolling machines

Technical specifications	Bending width	Max. sheet thickness*	Roller Ø	Bending Ø min.	Weight	Dimensions L x W x H	Art. no.		
RBM 1000-20 Eco	1000 mm	2.0 mm	60 mm	100 mm	200 kg	1542 x 550 x 1040	3781301		
RBM 1050-10	1050 mm	1.0 mm	56 mm	84 mm	185 kg	1400 x 700 x 1120	3813101		
RBM 1050-22	1050 mm	2.0 mm	75 mm	115 mm	300 kg	1400 x 700 x 1160	3813103		
RBM 1550-10	1550 mm	1.0 mm	68 mm	102 mm	350 kg	2430 x 700 x 1160	3813104		

*Performance data for material with tensile strength of 400N/mm²; conical bending performance = factor 0.5; bending performance aluminium = 1.2; bending performance stainless steel (VA) = factor 0.75; the optional tempered rollers are necessary for bending stainless steel (VA) ** Please turn over for descriptions of the packaging surcharges; TPF prices excluding VAT.

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

Accessories	Art. no.
Tempered rollers RBM 1050-10	3880071
Tempered rollers RBM 1050-22	3880073
Tempered rollers RBM 1550-10	3880074

RBM E – motorised, asymmetric 3-roller plate rolling machines

- ▶ Heavy-duty and rugged cast iron design
- ▶ asymmetric 3-roller system with swivel-out top roller
- ▶ Conical bending option
- ▶ Safety device emergency stop bar or emergency stop rip cord
- ▶ Clamping and side roller with wire insert grooves as standard
- ▶ Operation via foot pedal
- ▶ The upper roller can be swivelled out for easier removal of the finished workpiece
- ▶ Feeding of side roller by hand wheel (for the RBM 1301-15 E by means of a latching lever)
- ▶ Convenient clamping and feed via lever in each case
- ▶ User-friendly
- ▶ Powerful 400-volt motor
- ▶ Optional tempered rollers



RBM 1301-15E

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

RBM E - motorised plate rolling machine

New

Model	RBM 1050-30E	RBM 1270-25E	RBM 1301-15E	RBM 1550-20E	RBM 2050-15E
Art. no.	3813201	3813202	3813113	3813203	3813204
Technical specifications					
Bending width	1050 mm	1270 mm	1300 mm	1550 mm	2050 mm
Max. sheet thickness*	3.0 mm	2.5 mm	1.5 mm	2.0 mm	1.5 mm
Roller Ø	90 mm	90 mm	75 mm	90 mm	95 mm
Motor output	1.1 kW	1.1 kW	1.5 kW	1.5 kW	1.5 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Dimensions L x W x H	1630 x 700 x 1200	1850 x 700 x 1200	1860 x 700 x 1160	2130 x 700 x 1200	2630 x 700 x 1200
Weight	480 kg	520 kg	400 kg	580 kg	665 kg

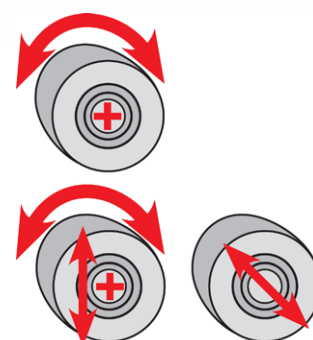
*Performance data for material with tensile strength of 400N/mm²; conical bending performance = factor 0.5; bending performance aluminium = 1.2; bending performance stainless steel (VA) = factor 0.75; the optional tempered rollers are necessary for bending stainless steel (VA) ** Please turn over for descriptions of the packaging surcharges; TPFR prices excluding VAT.



RBM 1270-25E



• Digital position display for feed roller



Note
Machine cannot be retrofitted with accessories, only with orders for new machines

Accessories RBM 1050-30E	Art. no.
Tempered rollers	3880059
motorised side roller feed	3880060
Digital indicator for adjustment roller	3880061

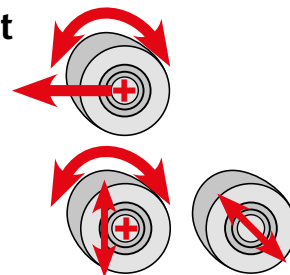
Accessories RBM 1270-25E	Art. no.
Tempered rollers	3880062
motorised side roller feed	3880063
Digital indicator for adjustment roller	3880064

Accessories RBM 1550-20E	Art. no.
Tempered rollers	3880065
motorised side roller feed	3880066
Digital indicator for adjustment roller	3880067

Accessories RBM 2050-15E	Art. no.
Tempered rollers	3880068
motorised side roller feed	3880069
Digital indicator for adjustment roller	3880070

RBM E PRO - Motorised plate rolling machines, heavy-duty type for sheet thicknesses up to 5 mm

- ▶ Heavy-duty welded steel construction
- ▶ Driven top and clamping rollers
- ▶ Top roller swivels out
- ▶ Manual feed of clamping and side roller
- ▶ Roller drive via powerful electric motor and gear
- ▶ Wire grooves on the clamping roller
- ▶ Safety device emergency stop rip cord
- ▶ With mobile control panel and foot pedal



RBM 2050-30 E PRO with motorised side roller option and digital display for side roller



• Top roller swivels out



• Control panel with digital display and manual operation (option)

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

RBM E Pro - motorised plate rolling machines

Model	RBM 1270-40E Pro	RBM 1550-40E Pro	RBM 2050-30E Pro
Art. no.	3813301	3813302	3813303
Technical specifications			
Bending width	1270 mm	1550 mm	2050 mm
Max. sheet thickness*	4 mm	4 mm	3 mm
Roller Ø	120 mm	140 mm	130 mm
Bending Ø min.	180 mm	210 mm	195 mm
Speed	3 m/min.	3.5 m/min.	3.5 m/min.
Motor output	2.2 kW	2.2 kW	2.2 kW
Electrical connections	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
Weight	1115 kg	1350 kg	1500 kg
Dimensions L x W x H	2470 x 750 x 1000	2470 x 750 x 1000	3200 x 750 x 1000
Transport packaging flat rate*	TPFR 5 = €100	TPFR 5 = €100	TPFR 5 = €100

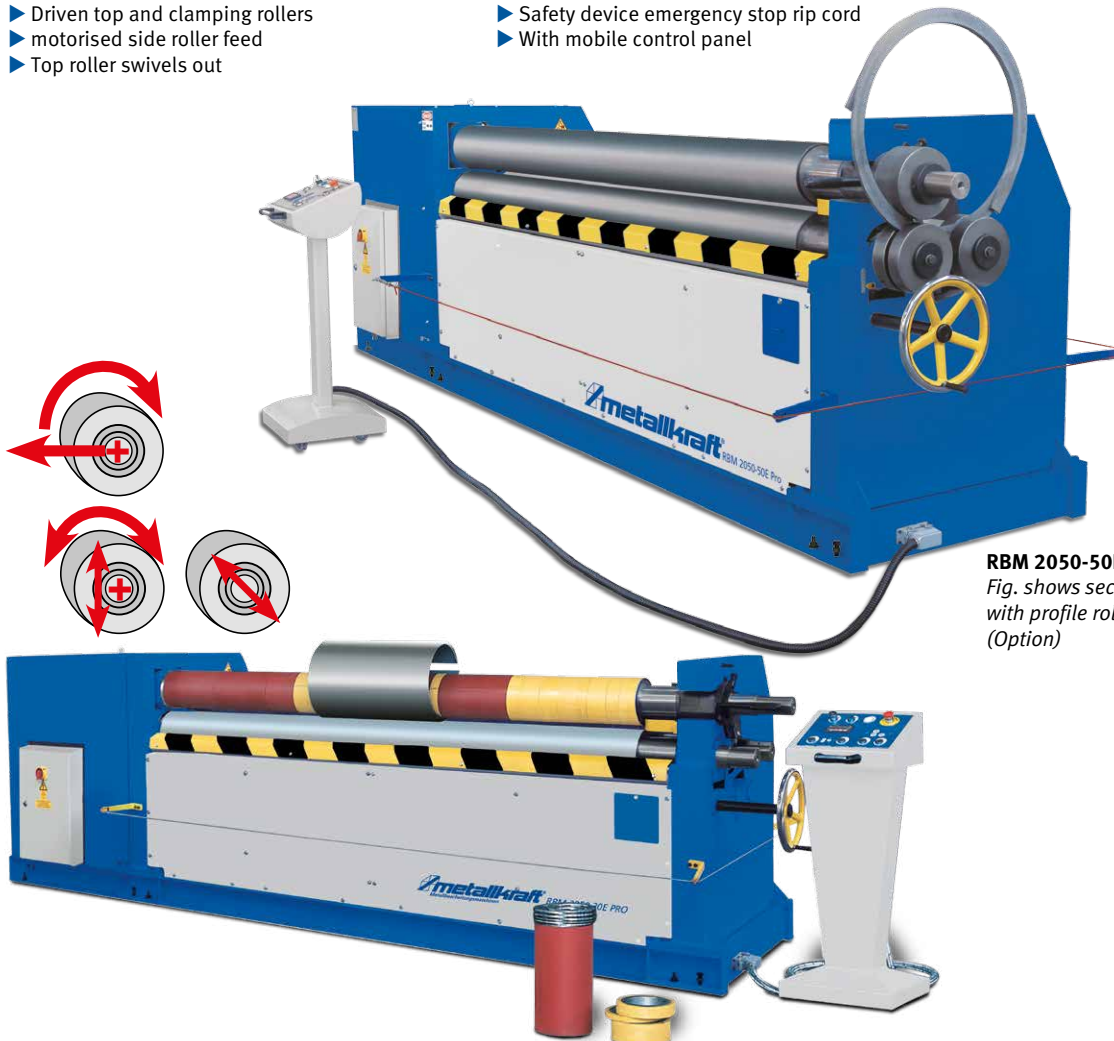
*Performance data for material with tensile strength of 400N/mm²; conical bending performance = factor 0.5; bending performance aluminium = 1.2; bending performance stainless steel (VA) = factor 0.75; the optional tempered rollers are necessary for bending stainless steel (VA) ** Please turn over for descriptions of the packaging surcharges; TPFR prices excluding VAT.

More models on request!

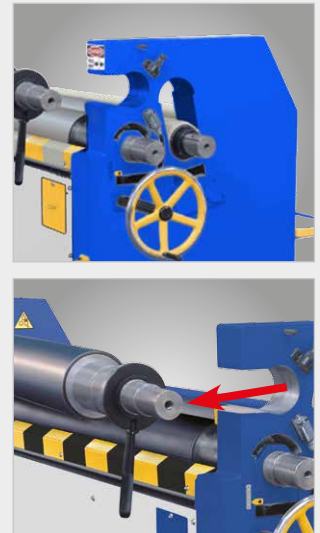
Accessories RBM 1270-40E Pro		Accessories RBM 2050-30E Pro		Note
Art. no.		Art. no.		
Tempered rollers for stainless steel*	3880050	Tempered rollers for stainless steel*	3880056	Machine cannot be retrofitted with accessories, only with orders for new machines
motorised side roller feed	3880051	motorised side roller feed	3880057	
Digital display for side roller	3880052	Digital display for side roller	3880058	
Accessories RBM 1550-40E Pro				
Art. no.				
Tempered rollers for stainless steel*	3880053			
motorised side roller feed	3880054			
Digital display for side roller	3880055			

RBM E PRO - Motorised round bending machines, heavy-duty type with motorised feed for sheet thicknesses up to 6 mm

- ▶ Heavy-duty welded steel construction,
- ▶ Driven top and clamping rollers
- ▶ motorised side roller feed
- ▶ Top roller swivels out
- ▶ Roller drive via powerful electric motor and gear
- ▶ Safety device emergency stop rip cord
- ▶ With mobile control panel



RBM 2050-50E Pro
Fig. shows section bending
with profile rollers
(Option)



Top roller swivels out

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

RBM E Pro - motorised plate rolling machines

Model	Bending width	Pre-bending performance max.*	Bending performance max.*	Roller Ø	Roller speed	Bending Ø min.	Motor output	Weight	Dimensions L x W x H in mm	Art. no.
RBM 1550-60E Pro	1550 mm	5 mm	6 mm	130 mm	3.2 m/min.	195 mm	2.2 kW	1400 kg	3250 x 650 x 1020	3813314
RBM 2050-50E Pro	2050 mm	4 mm	5 mm	150 mm	3.4 m/min.	225 mm	3.0 kW	1885 kg	3750 x 680 x 1040	3813315
RBM 2050-60E Pro	2050 mm	5 mm	6 mm	170 mm	3.8 m/min.	255 mm	4.0 kW	2100 kg	3850 x 720 x 1050	3813316
RBM 2550-40E Pro	2550 mm	3 mm	4 mm	150 mm	3.4 m/min.	225 mm	3.0 kW	2150 kg	4250 x 650 x 1020	3813317
RBM 2550-60E Pro	2550 mm	5 mm	6 mm	190 mm	4.3 m/min.	285 mm	4.0 kW	3400 kg	4700 x 950 x 1300	3813318
RBM 3050-60E Pro	3050 mm	5 mm	6 mm	220 mm	5.0 m/min.	330 mm	5.5 kW	6000 kg	5200 x 1150 x 1400	3813319

*Performance data for material with tensile strength of 400N/mm²; conical bending performance = factor 0.5; bending performance aluminium = 1.2; bending performance stainless steel (VA) = factor 0.75; the optional tempered rollers are necessary for bending stainless steel (VA)

Accessories RBM 1550-60E Pro	Art. no.	Accessories RBM 2550-40E Pro	Art. no.	Note
Digital display for side roller	3880220	Digital display for side roller	3880220	Machine cannot be retrofitted with accessories, only with orders for new machines
Motorised clamping roller feed	3880221	Motorised clamping roller feed	3880221	
Tempered rollers for stainless steel	3880225	Tempered rollers for stainless steel	3880234	
Extended roller ends for section bending	3880226	Extended roller ends for section bending	3880235	More models on request!
Section bending rollers	3880227	Section bending rollers	3880236	
Accessories RBM 2050-50E Pro	Art. no.	Accessories RBM 2550-60E Pro	Art. no.	
Digital display for side roller	3880220	Digital display for side roller	3880220	
Motorised clamping roller feed	3880221	Motorised clamping roller feed	3880221	
Tempered rollers for stainless steel	3880228	Tempered rollers for stainless steel	3880237	
Extended roller ends for section bending	3880229	Extended roller ends for section bending	3880238	
Section bending rollers	3880230	Section bending rollers	3880239	
Accessories RBM 2050-60E Pro	Art. no.	Accessories RBM 3050-60E Pro	Art. no.	
Digital display for side roller	3880220	Digital display for side roller	3880220	
Motorised clamping roller feed	3880221	Motorised clamping roller feed	3880221	
Tempered rollers for stainless steel	3880231	Tempered rollers for stainless steel	3880240	
Extended roller ends for section bending	3880232	Extended roller ends for section bending	3880241	
Section bending rollers	3880233	Section bending rollers	3880242	

RBM 4 HMS PRO – Hydraulic 4-roller plate rolling machines

- ▶ Heavy-duty and durable welded designed
- ▶ Linear feed of clamping and side rollers by hydraulic cylinders
- ▶ Induction tempered rollers, suitable for bending stainless steel
- ▶ Top roller driven by hydro-motor and planetary gear; the motion is transferred to the clamping roller by means of drive shafts
- ▶ Machine protected against overload

- ▶ Three digital displays (2 x side rollers, 1 x clamping roller)
- ▶ Hydraulic safety chuck for easy removal of finished workpieces
- ▶ Mobile control panel
- ▶ Conical bending device
- ▶ Hydraulic balancing system to ensure parallelism
- ▶ Safety emergency stop rip cord

Optional accessories

- ▶ Teach-in NC control
- ▶ Mechanical aux. crane
- ▶ Hydraulic side supports
- ▶ Continuously variable bending speed adjustment

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

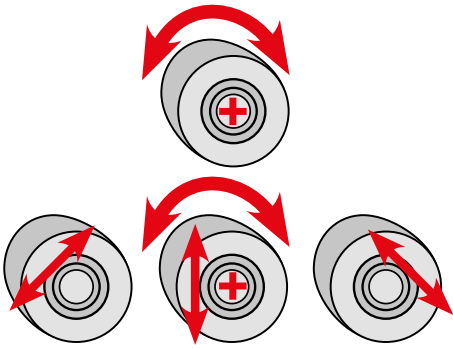


RBM 1550-110 4 HMS PRO

RBM 4 HMS PRO – Hydraulic 4-roller plate rolling machines

RBM 4 HMS PRO	Working width mm	Pre-bending performance* mm	Bending performance* mm	Ø Top roller mm	Smallest bending Ø* mm	Motor output kW	Bending speed m/min	Length mm	Width mm	Height mm	Weight kg	Art. no.
1550-65	1550	3.5/4.5	4.5/6.5	150	225/750	2.2 & 1.5	6	3300	1150	1110	2370	3813346
1550-110	1550	7/9	9/11	200	300/1000	4.0 & 1.5	6	3350	1350	1290	3250	3813347
1550-150	1550	10/12	12/15	250	375/1250	7.5 & 1.5	5	3500	1500	1370	4650	3813348
2050-60	2050	3/4	4/6	150	225/750	2.2 & 1.5	6	3800	1150	1110	2800	3813349
2050-80	2050	4/6	6/8	180	270/900	3.0 & 1.5	5	3850	1350	1290	3300	3813350
2050-100	2050	6/8	8/10	200	300/1000	4.0 & 1.5	6	3850	1350	1290	3750	3813351
2050-120	2050	8/10	10/12	250	375/1250	7.5 & 1.5	5	4000	1500	1370	5350	3813352
2050-220	2050	15/18	18/22	300	450/1500	11	1.5/5	4400	1800	1950	6500	3813353
2550-60	2550	3/4	4/6	180	270/900	3.0 & 1.5	5	4350	1350	1290	3700	3813354
2550-80	2550	4/6	6/8	200	300/1000	4.0 & 1.5	6	4350	1350	1290	4250	3813355
2550-100	2550	6/8	8/10	250	375/1250	7.5 & 1.5	5	4500	1500	1370	6100	3813356
2550-180	2550	12/15	15/18	300	450/1500	11	1.5/5	4900	1800	1950	7500	3813357
3050-60	3050	3/4	4/6	200	300/1000	4.0 & 1.5	6	4850	1350	1290	4750	3813358
3050-90	3050	5/7	7/9	250	375/1250	7.5 & 1.5	5	5000	1500	1370	6800	3813359
3050-150	3050	10/12	12/15	300	450/1500	11	1.5/5	5400	1800	1950	8500	3813360
4050-80	4050	4/6	6/8	275	410/1375	11	1.5/5	6400	1600	1800	9000	3813361

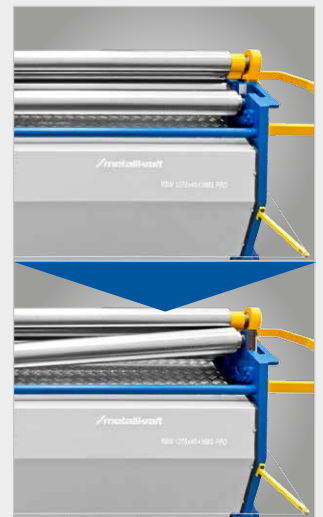
*Performance data for material with tensile strength of 400N/mm² at 1.5 x top roller Ø, 5 x top roller Ø; conical bending performance = factor 0.5; bending performance aluminium = 1.2; bending performance stainless steel (VA) = factor 0.75.



Optional accessories
• Teach-in NC control



Hydraulic safety chuck for easy removal of finished workpieces



Conical bending device



Safety emergency stop rip cord

More models and accessories on request

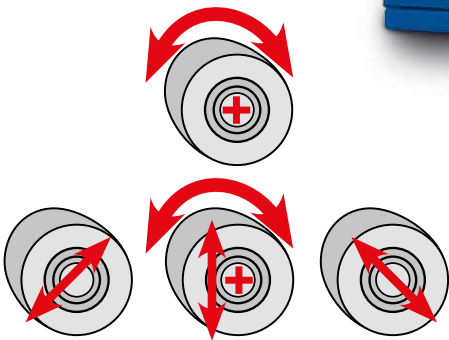
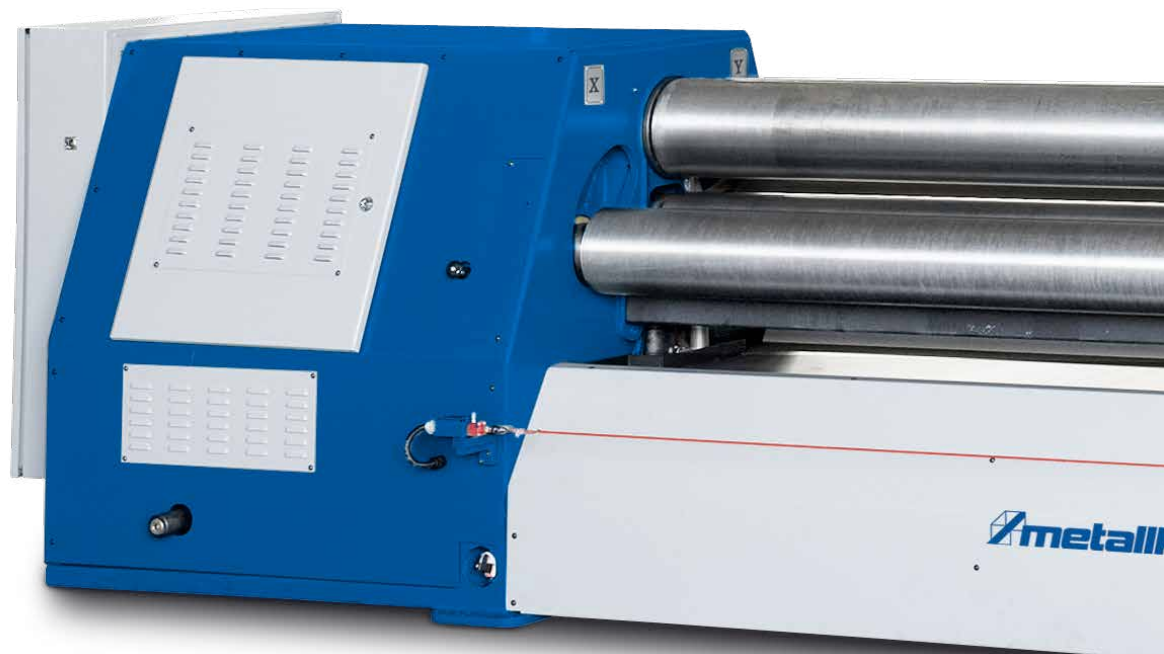
Can we help you?

Your local specialist retailer is more than happy to help you with any issues. We will also be more than happy to support you and provide you with a list of specialist retailers where you are; **contact: +49(0)951 96555-171**
beratung@metallkraft.de



RBM 4-H PRO – Hydraulic 4-roller plate rolling machines, heavy-duty version

- ▶ Heavy and torsion free welded steel design
- ▶ Top and clamping roller driven by hydro-motors and planetary gears
- ▶ Hydraulic safety chuck for easy removal of finished workpieces
- ▶ All rollers run in taper roller bearings with bronze seats
- ▶ Induction tempered rollers
- ▶ With conical bending device
- ▶ With 2 speeds as standard
- ▶ Electronic adjustment of the side rollers
- ▶ Parallelism of the bottom roller is guaranteed by a solid torsion shaft
- ▶ Bottom roller hydraulically adjustable
- ▶ Electrical and hydraulic overload protection
- ▶ Mobile control panel with digital display
- ▶ All hydraulic components by quality manufacturers, e.g., "REXROTH"



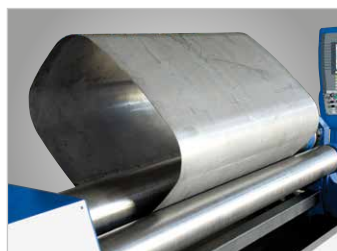
RBM 4 H PRO – Hydraulic 4-roller plate rolling machines

Technical specifications	Working width mm	Pre-bending performance* mm	Bending performance* mm	Ø Top roller mm	Motor output kW	Bending speed m/min	Length mm	Width mm	Height mm	Weight kg	Art. no.
RBM 2050-60 4-H Pro	2050 mm	4 mm	6 mm	170 mm	5.5 kW	0.978 m/min.	3540	970	1140	3030 kg	3813500
RBM 2050-100 4-H Pro	2050 mm	8 mm	10 mm	210 mm	7.5 kW	0.792 m/min.	3830	1160	1180	4940 kg	3813501
RBM 2050-130 4-H Pro	2050 mm	10 mm	13 mm	230 mm	11 kW	0.792 m/min.	3830	1160	1180	5280 kg	3813502
RBM 2550-100 4-H Pro	2550 mm	8 mm	10 mm	230 mm	11 kW	0.792 m/min.	4330	1160	1180	5920 kg	3813503
RBM 2550-130 4-H Pro	2550 mm	10 mm	13 mm	270 mm	15 kW	0.756 m/min.	4760	1660	1590	10600 kg	3813504
RBM 2550-200 4-H Pro	2550 mm	16 mm	20 mm	330 mm	22 kW	0.756 m/min.	4760	1660	1590	12100 kg	3813505
RBM 3100-130 4-H Pro	3100 mm	10 mm	13 mm	300 mm	15 kW	0.756 m/min.	5310	1660	1590	12300 kg	3813506
RBM 3100-200 4-H Pro	3100 mm	16 mm	20 mm	360 mm	22 kW	0.906 m/min.	5560	2060	2050	19000 kg	3813507
RBM 3100-250 4-H Pro	3100 mm	20 mm	25 mm	400 mm	30 kW	0.906 m/min.	5560	2060	2050	20800 kg	3813508
RBM 4100-80 4-H Pro	4100 mm	6 mm	8 mm	300 mm	11 kW	0.756 m/min.	6310	1660	1590	14600 kg	3813509

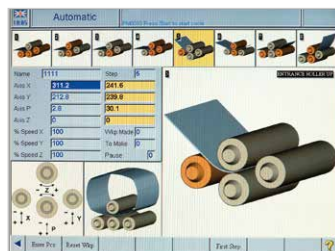
*Performance data for material with tensile strength of 400N/mm² at 1.5 x top roller Ø, 5 x top roller Ø; conical bending performance = factor 0.5; bending performance aluminium = 1.2; bending performance stainless steel (VA) = factor 0.75.

Machines with bending performance up to 140 mm on request

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



Precise polycentric bending (with optional CNC control)



Screen menu of the optional CNC control



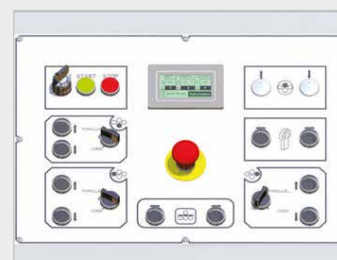
RBM 2050-100 4-H PRO
(Fig. with optional CNC control)



Hydraulic safety chuck for easy removal of finished workpieces



Parallelism of the bottom roller is guaranteed by a solid torsion shaft



Standard control

Accessories RBM 2050-60 4-H Pro to RBM 4100-80 4-H Pro Art. no.

CNC control	3880928
NC control	3880929
Adjustable roller speed	3880938
Mechanical crane - radius 2 m, load bearing capacity 1.5 t	3880945
Mechanical crane - radius 3 m, load bearing capacity 4 t	3880946
Mechanical crane - radius 3 m, load bearing capacity 6 t	3880947
Material feed table	3880948

Accessories RBM 2050-60 4-H Pro Art. no.

Polished rollers	3880930
Hydraulic side support	3880939

Accessories RBM 2050-100 4-H Pro Art. no.

Polished rollers	3880931
Hydraulic side support	3880939

Accessories RBM 2050-130 4-H Pro Art. no.

Polished rollers	3880932
Hydraulic side support	3880939

Accessories RBM 2550-100 4-H Pro Art. no.

Polished rollers	3880933
Hydraulic side support	3880940

Accessories RBM 2550-130 4-H Pro Art. no.

Polished rollers	3880934
Hydraulic side support	3880940

Accessories RBM 2550-200 4-H Pro Art. no.

Polished rollers	3880935
Hydraulic side support	3880941

Accessories RBM 3100-130 4-H Pro Art. no.

Polished rollers	3880936
Hydraulic side support	3880941

Accessories RBM 3100-200 4-H Pro Art. no.

Hydraulic side support	3880942
------------------------	---------

Accessories RBM 2050-60 4-H Pro Art. no.

Hydraulic side support	3880943
------------------------	---------

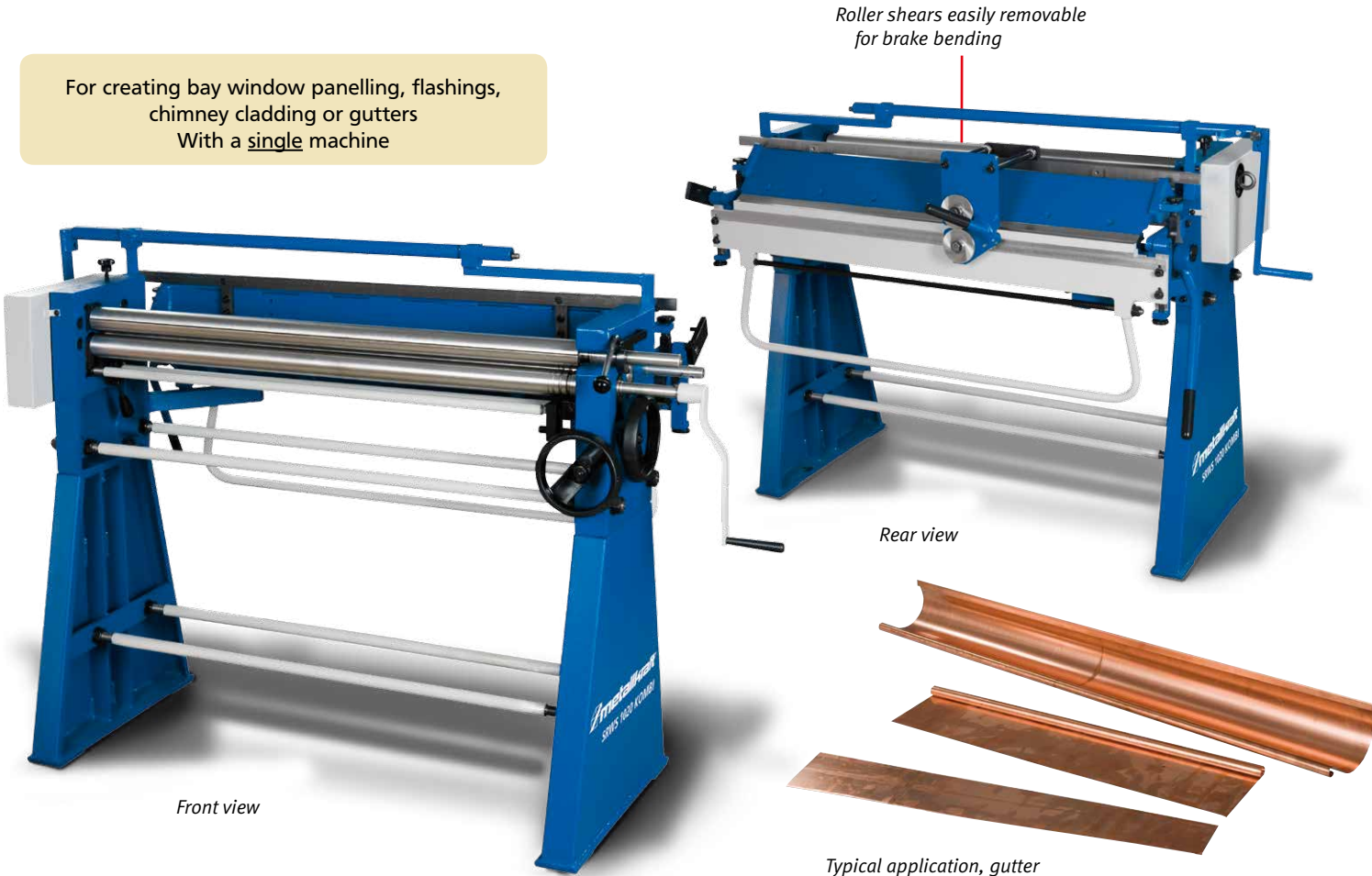
Accessories RBM 4100-80 4-H Pro Art. no.

Polished rollers	3880937
Hydraulic side support	3880944

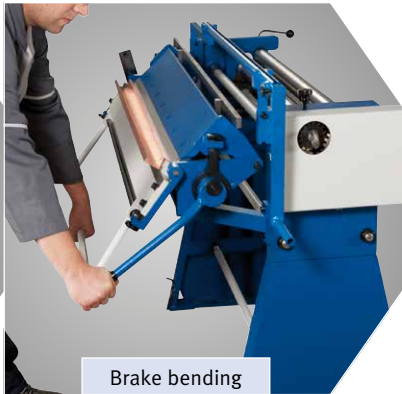
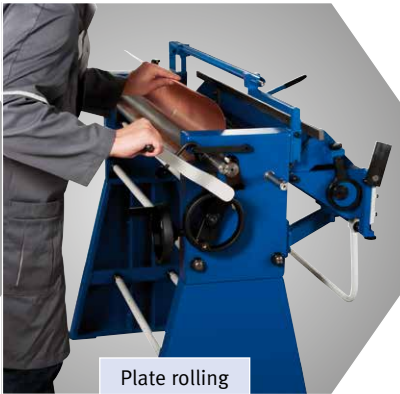
SRWS 1020 KOMBI - Combined machine for roofers for plate rolling, brake bending, cutting and beading

- ▶ 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 (LxWxH) in	Weight	Art. no.	
SRWS 1020 KOMBI	0.8 mm	1020 x 1.0 mm	1020 x 1.5 mm	1020 x 0.6 mm	1490 x 850 x 1300 mm	290 kg	3778001	

* Data relate to cutting zinc sheet

HSBM – Manual brake bending machine

- ▶ Ideal for creating any kind of section including boxes with circumferential edge bending (HSBM 610HS)
- ▶ Low-budget entry level model for trade workers
- ▶ Simple design and rugged manufacture guarantee precise work
- ▶ Safe clamping of the sheet through clamping device

HSBM 305 HS/610 HS:

- ▶ Fast, user-friendly adjustment of the top beam via excenter
- ▶ Brake bending with bending beam via bow handle

- ▶ With top beam for U sections with tall bent edges
- ▶ With 5x segmentation of top beam 25/50/75/205/255 mm
- ▶ Easy to transport
- HSBM 1020-10 HS:**
 - ▶ Easy adjustment of the top beam
 - ▶ Brake bending via double handle
 - ▶ Safe clamping of the sheet through clamping device

HSBM 2200 - 0.7 and HSBM 3000 - 0.6

- ▶ 2 machines in 1: manual brake bending machine and roller shears
- ▶ Ideal for roofers on site, e.g. for creating bay window panelling, flashings, chimney cladding or gutters
- ▶ The removable roller shears allow for precise cutting of copper and zinc sheet
- ▶ Optionally with beading function for beading sheet metal
- ▶ Brake bending function with safe clamping of the workpiece due to preload of the top beam



HSBM 610 HS

Passageway 25 mm here



HSBM 1020-10

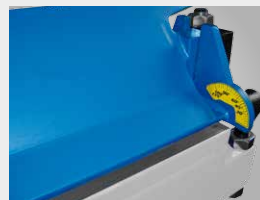


HSBM 2200-0.7



Quality
made in
Europe

HSBM 2200-0.7



Angle display
· from 0° - 135°



Roller shears
· With hand lever for trimming the finished workpiece to the required length

Model	HSBM 305 HS	HSBM 610 HS	HSBM 1020-10	HSBM 2200-0.7	HSBM 3000-0.6
Art. no.	3772305	3772610	3771020	3779200	3779300
Technical specifications					
Max. working width	305 mm	610 mm	1020 mm	2200 mm	3000 mm
Max. sheet thickness	1.0 mm	1.0 mm	1.0 mm	0.7 mm	0.6 mm
Max. bending angle	135°	135°	135°	135°	135°
Weight	30 kg	42 kg	105 kg	120 kg	400 kg
Dimensions mm	500 x 350 x 410	850 x 360 x 420	1276 x 550 x 975	2380 x 1050 x 1050	3230 x 1050 x 1050

Accessories for HSBM 2200

	Art. no.
Manual bending roller	3799000
Beading function	3799002
2030 mm	

Accessories for HSBM 1020-10*

	Art. no.
Tempered segments	3772700

*only top beam is tempered

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	Working width Max.	Sheet thick-ness* max.*	Passageway between top + bottom beam Max.	Bending angle Max.	Weight	Dimensions	Art. no. LxWxH in mm		
HSBM 2020-20 SB	2020 mm	2.0 mm	120 mm	135°	1020 kg	2800 x 710 x 1500	3772920		

*Performance data for material with tensile strength of 400N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; tempered top tools are necessary for bending stainless steel (VA);**Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT

REB 1 - Manual gutter bracket bender

- ▶ Excellent stability

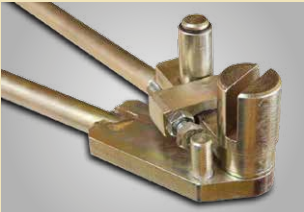
▶ Adjustable stop for uniform bending angles of gutter bracket

▶ High power transfer

▶ Long handles, thus high leverage with low force application



Typical application



Model	REB 1
Art. no.	3799001

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

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

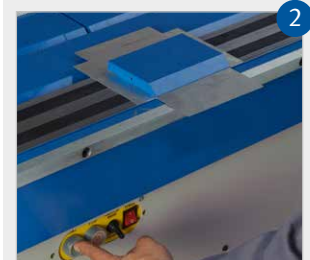
Step 1

- 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.

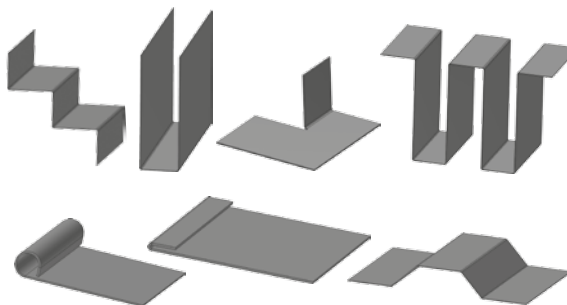


With practical compartments for all individual segments and bending rails



Push in slots for top beam segments

7 of many further bending options:



Model	MBM 1250
Art. no.	3770125

Technical specifications	
Max. bending width	1250 mm
Holding pressure	6 t
Output	10 A
Dimensions	1500 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⁾
Aluminum 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 400N/mm²

³⁾ Bending beam extension - removed

⁴⁾ Bending beam extension installed

Scope of supply:

- ▶ 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



Prepare to be fascinated!

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

HSBM N - Universally deployable, manual brake bending machines, extensible with a variety of extension 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 versions of the manual brake bending machines can be retrofitted with matching extension kits (AB) at any time**



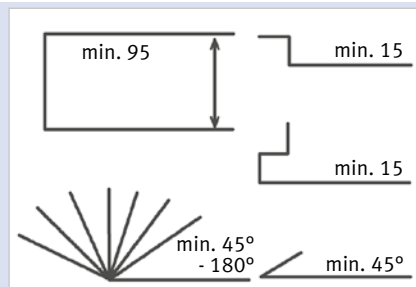
Easily convertible to other bending rails!

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 1070	3770068	
AB 660 HSG	660 mm	1.50 mm	93°	+ 9 kg	880 x 570/500 x 1070	3770069	
HSBM 1050 N	1050 mm	1.25 mm	135°	78 kg	1250 x 570/500 x 970	3771050	
AB 1050 H	1050 mm	1.25 mm	93°	+ 13 kg	1250 x 570/500 x 1060	3771051	
AB 1050 HS	1050 mm	1.20 mm	93°	+ 16 kg	1250 x 570/500 x 1070	3771052	
AB 1050 HSG	1050 mm	1.20 mm	93°	+ 15 kg	1250 x 570/500 x 1070	3771053	
HSBM 1300 N	1300 mm	1.20 mm	135°	88 kg	1480 x 570/500 x 970	3771300	
AB 1300 H	1300 mm	1.20 mm	93°	+ 16 kg	1480 x 570/500 x 1060	3771301	
AB 1300 HS	1300 mm	1.20 mm	93°	+ 20 kg	1480 x 570/500 x 1070	3771302	
AB 1300 HSG	1300 mm	1.20 mm	93°	+ 18 kg	1480 x 570/500 x 1070	3771303	

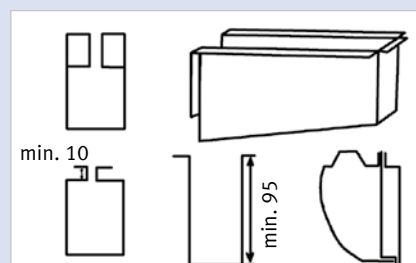
*max. values relate to bending soft metals, e.g., aluminium

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

Accessories	Art. no.
Acute bending rail for HSBM 660 N	3790096
Acute bending rail for HSBM 1050 N	3790101
Acute bending rail for HSBM 1300 N	3790102
Acute bending rail for HSBM 1050 H	3790103
Acute bending rail for HSBM 1300 H	3790104
Plate rolling rail 3.0 mm (width 660)	3790151
Plate rolling rail 3.0 mm (width 1050)	3790152
Plate rolling rail 3.0 mm (width 1300)	3790153
Plate rolling rail 4.0 mm (width 660)	3790161
Plate rolling rail 4.0 mm (width 1050)	3790162
Plate rolling rail 4.0 mm (width 1300)	3790163
Plate rolling rail 5.0 mm (width 660)	3790171
Plate rolling rail 5.0 mm (width 1050)	3790172
Plate rolling rail 5.0 mm (width 1300)	3790173
Rear stop for HSBM 660	3791660
Rear stop for HSBM 1050	3791050
Rear stop for HSBM 1300	3791300
Roller shears for HSBM 1050	3791051
Roller shears for HSBM 1300	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

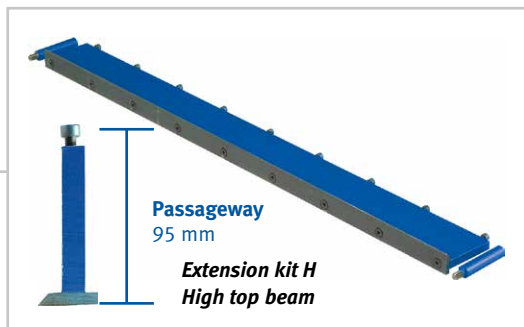
Passageway
25 mm



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

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Band saws

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
- ▶ Wide 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*	Max. bending angle	Weight	Dimensions (LxWxH) in mm	Art. no.	
FSBM 1020-25 E	1020 mm	2.5 mm	135°	285 kg	1348 x 850 x 1175	3772125	
FSBM 1020-20 S2	1020 mm	2.0 mm	135°	280 kg	1400 x 950 x 1200	3772102	
FSBM 1020-20 HSG	1020 mm	2.0 mm	150° (93°)	340 kg	1460 x 930 x 1420	3770103	
FSBM 1270-20 E	1270 mm	2.0 mm	135°	315 kg	1600 x 950 x 1175	3772127	
FSBM 1270-20 HS2	1270 mm	2.0 mm	135°	350 kg	1600 x 950 x 1175	3772128	
FSBM 1520-15 E	1520 mm	1.5 mm	135°	385 kg	1960 x 710 x 1300	3772129	
FSBM 2020-12 E	2020 mm	1.2 mm	135°	490 kg	2470 x 940 x 1320	3772130	

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

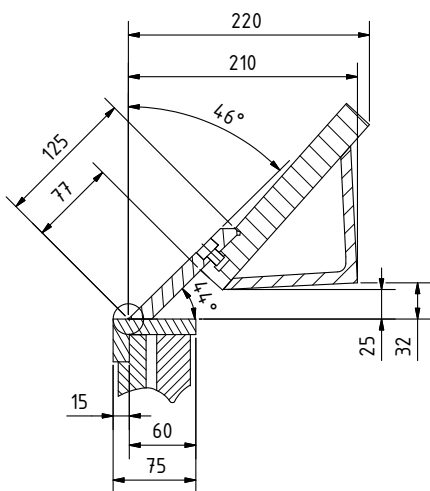
With segmented acute bending tools, segmented bending rail and full-width support bed



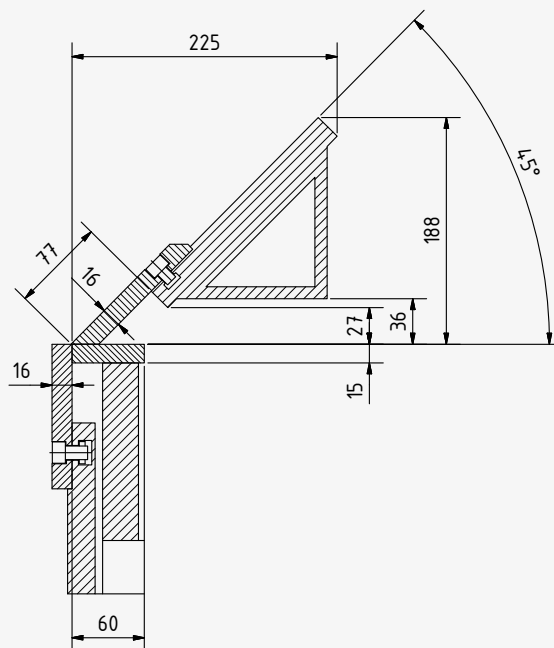
FSBM 1020-20 HSG

With segmented crowbar tools, segmented bending rail and segmented support bed

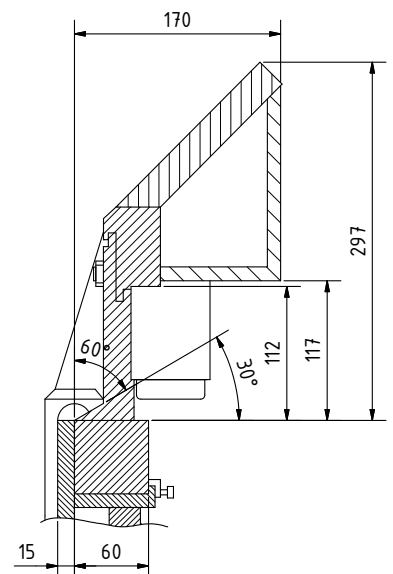
Dimensions E series:



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

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
Tempered segments FSBM 2020-12 E*	3772705

*Only the top tool is tempered

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

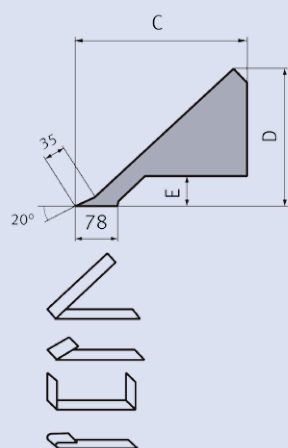


Type	Segmentation HSBM S / HSBM SH
HSBM 1520-20 S / SH	25-30-35-40-45-50-75-100-150-220-250-500
HSBM 2020-20 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400
HSBM 2520-16 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400-500
HSBM 3020-12 S / SH	25-30-35-40-45-50-75-100-150-200-200-270-400-400-500-500

More brake bending machines
available on request!

Model	Working width Max.	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	1520 mm	2.0 mm	140 mm	135°	850 kg	2680 x 560 x 1255	3779001		
HSBM 2020-20	2020 mm	2.0 mm	140 mm	135°	1130 kg	2695 x 560 x 1255	3779002		
HSBM 2520-16	2620 mm	1.6 mm	140 mm	135°	1320 kg	3195 x 560 x 1255	3779003		
HSBM 3020-12	3020 mm	1.2 mm	140 mm	135°	1900 kg	3695 x 560 x 1255	3779004		
HSBM 1520-20 S	1520 mm	2.0 mm	140 mm	135°	850 kg	2680 x 560 x 1255	3779010		
HSBM 2020-20 S	2020 mm	2.0 mm	140 mm	135°	1080 kg	2695 x 560 x 1255	3779011		
HSBM 2520-16 S	2620 mm	1.6 mm	140 mm	135°	1320 kg	3195 x 560 x 1255	3779012		
HSBM 3020-12 S	3020 mm	1.2 mm	140 mm	135°	1900 kg	3695 x 560 x 1255	3779013		
HSBM 1520-20 SH	1520 mm	2.0 mm	140 mm	93°	850 kg	2680 x 560 x 1255	3779020		
HSBM 2020-20 SH	2020 mm	2.0 mm	140 mm	93°	1080 kg	2695 x 560 x 1255	3779021		
HSBM 2520-16 SH	2620 mm	1.6 mm	140 mm	93°	1320 kg	3195 x 560 x 1255	3779022		
HSBM 3020-12 SH	3020 mm	1.2 mm	140 mm	93°	1900 kg	3695 x 560 x 1255	3779023		

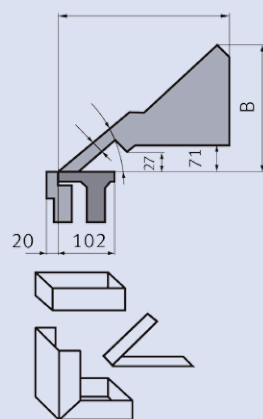
*Performance data for material with tensile strength of 400N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);**Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT



**Dimensions
Bending beam HSBM**

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

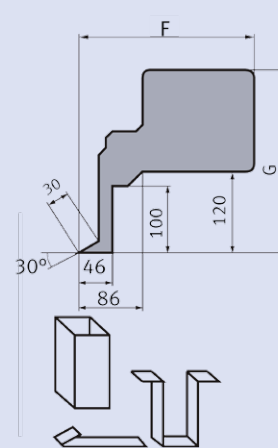
Width of bending rail 20 mm



**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



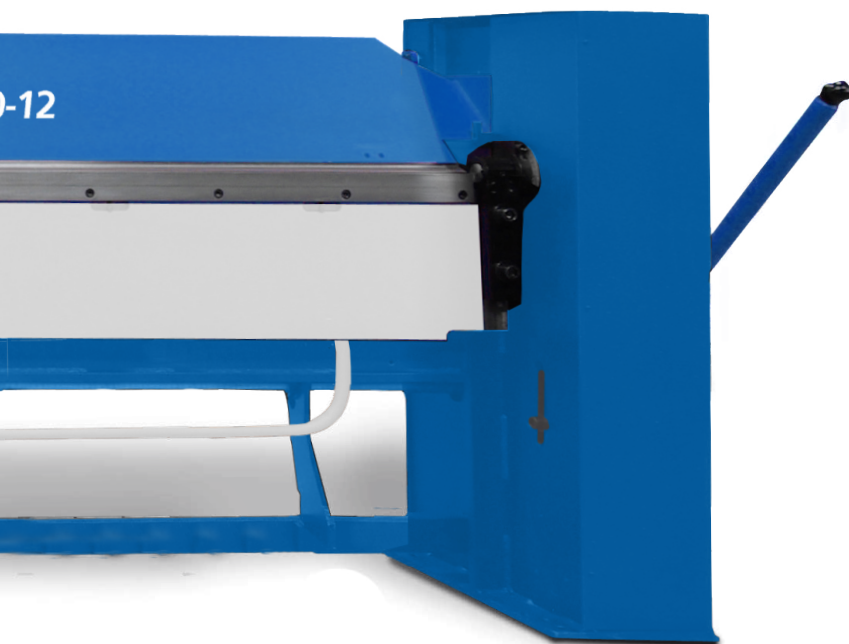
**Dimensions
Bending beam HSBM SH**

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



HSBM 3020-12

Accessories HSBM 1520-20 / S / SH	Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797000
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797010
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm	3797020
Roller shears for sheet thicknesses up to 0.8 mm	3797030

Accessories HSBM 2020-20 / S / SH	Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797001
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797011
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm	3797021
Roller shears for sheet thicknesses up to 0.8 mm	3797031

Accessories HSBM 2520-16 / S / SH	Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797002
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797012
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm	3797022
Roller shears for sheet thicknesses up to 0.8 mm	3797032

Accessories HSBM 3020-12 / S / SH	Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797003
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797013
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm	3797023
Roller shears for sheet thicknesses up to 0.8 mm	3797033

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

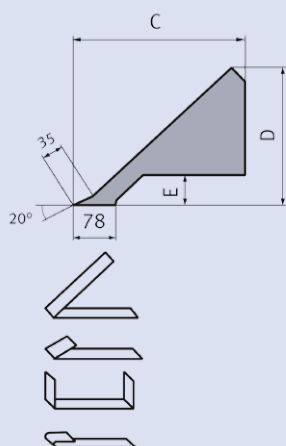


Type	Segmentation MSBM S / MSBM SH
MSBM 1520-30 S / SH	25-30-35-40-45-50-75-100-150-220-250-500
MSBM 2020-25 S / SH	25-30-35-40-45-50-75-100-150-200-270-400-500
MSBM 2520-20 S / SH	25-30-35-40-45-50-75-100-150-200-270-400-500
MSBM 3020-15 S / SH	25-30-35-40-45-50-75-100-150-200-270-400-500

More brake bending machines available on request!

Model	Working width Max.	Sheet thickness* max.*	Passageway between top + bottom beam Max.	Motor output Bending	Weight	Dimensions L x W x H in mm	Art. no.		
MSBM 1520-30	1520 mm	3.0 mm	140 mm	1.1 kW	1060 kg	2475 x 560 x 1290	3779030		
MSBM 2020-25	2020 mm	2.5 mm	140 mm	1.1 kW	1450 kg	2975 x 560 x 1290	3779031		
MSBM 2520-20	2520 mm	2.0 mm	140 mm	1.1 kW	1780 kg	3475 x 560 x 1290	3779032		
MSBM 3020-15	3020 mm	1.5 mm	140 mm	1.1 kW	2200 kg	3975 x 560 x 1290	3779033		
MSBM 1520-30 S	1520 mm	3.0 mm	140 mm	1.1 kW	1060 kg	2475 x 560 x 1290	3779040		
MSBM 2020-25 S	2020 mm	2.5 mm	140 mm	1.1 kW	1450 kg	2975 x 560 x 1290	3779041		
MSBM 2520-20 S	2520 mm	2.0 mm	140 mm	1.1 kW	1780 kg	3475 x 560 x 1290	3779042		
MSBM 3020-15 S	3020 mm	1.5 mm	140 mm	1.1 kW	2200 kg	3975 x 560 x 1290	3779043		
MSBM 1520-30 SH	1520 mm	3.0 mm	140 mm	1.1 kW	1060 kg	2475 x 560 x 1290	3779050		
MSBM 2020-25 SH	2020 mm	2.5 mm	140 mm	1.1 kW	1450 kg	2975 x 560 x 1290	3779051		
MSBM 2520-20 SH	2520 mm	2.0 mm	140 mm	1.1 kW	1780 kg	3475 x 560 x 1290	3779052		
MSBM 3020-15 SH	3020 mm	1.5 mm	140 mm	1.1 kW	2200 kg	3975 x 560 x 1290	3779053		

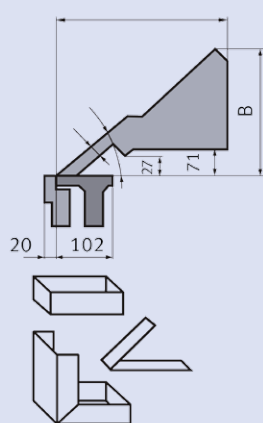
*Performance data for material with tensile strength of 400N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);**Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT



Dimensions
Bending beam HSBM

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

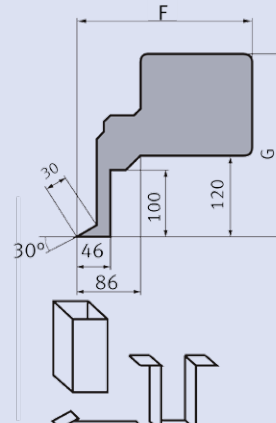
Width of bending rail 20 mm



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



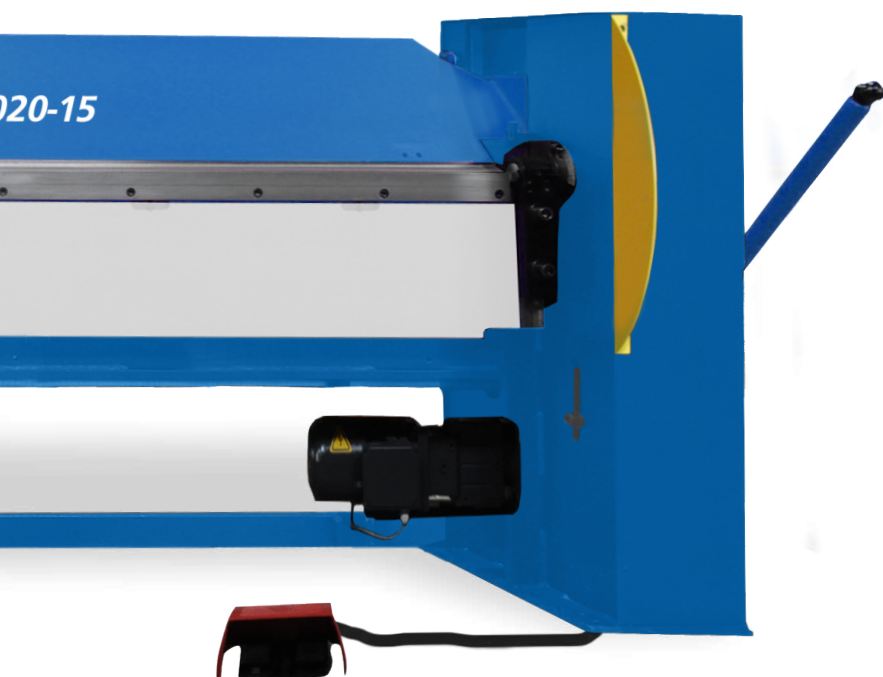
Dimensions
Bending beam HSBM SH

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

Width of bending rail 20 mm



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



Accessories MSBM 1520-30 / S / SH	Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797005
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797010
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm	3797020
Roller shears for sheet thicknesses up to 0.8 mm	3797030

Accessories MSBM 2020-25 / S / SH	Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797006
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797011
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm	3797021
Roller shears for sheet thicknesses up to 0.8 mm	3797031

Accessories MSBM 2520-20 / S / SH	Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797007
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797012
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm	3797022
Roller shears for sheet thicknesses up to 0.8 mm	3797032

Accessories MSBM 3020-15 / S / SH	Art. no.
Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797008
Rear stop with hand wheel, measuring device and full-width beam, 75 - 760 mm	3797013
Rear stop, hand wheel, measuring device and stop fingers 6 - 760 mm	3797023
Roller shears for sheet thicknesses up to 0.8 mm	3797033

! 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

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
- S models**
- ▶ With segmented top tools
- SH models**
- ▶ With high, segmented crowbar tools



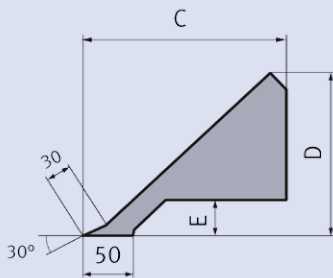
MSBM 2020-15 PRO S

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	25-30-35-40-45-50-75-100-150-200-270-400-500
MSBM 2520-12 PRO S / SH	25-30-35-40-45-50-75-100-150-200-270-400-500
MSBM 3020-10 PRO S / SH	25-30-35-40-45-50-75-100-150-200-270-400-500-500

More brake bending machines available on request!

Model	Working width Max.	Sheet thickness* max.*	Passageway between top + bottom beam Max.	Motor output Beam Bending	Weight	Dimensions L x W x H in mm	Art. no.		
MSBM 1520-17 PRO	1520 mm	1.75 mm	110 mm	0.37 kW 0.75 kW	810 kg	2150 x 700 x 1100	3779060		
MSBM 2020-15 PRO	2020 mm	1.5 mm	110 mm	0.37 kW 0.75 kW	1050 kg	2650 x 700 x 1100	3779061		
MSBM 2520-12 PRO	2520 mm	1.25 mm	110 mm	0.37 kW 0.75 kW	1290 kg	3150 x 700 x 1100	3779062		
MSBM 3020-10 PRO	3020 mm	1.0 mm	110 mm	0.37 kW 0.75 kW	1610 kg	3650 x 700 x 1100	3779063		
MSBM 1520-17 PRO S	1520 mm	1.75 mm	110 mm	0.37 kW 0.75 kW	810 kg	2150 x 700 x 1100	3779070		
MSBM 2020-15 PRO S	2020 mm	1.5 mm	110 mm	0.37 kW 0.75 kW	1050 kg	2650 x 700 x 1100	3779071		
MSBM 2520-12 PRO S	2520 mm	1.25 mm	110 mm	0.37 kW 0.75 kW	1290 kg	3150 x 700 x 1100	3779072		
MSBM 3020-10 PRO S	3020 mm	1.0 mm	110 mm	0.37 kW 0.75 kW	1610 kg	3650 x 700 x 1100	3779073		
MSBM 1520-17 PRO SH	1520 mm	1.75 mm	110 mm	0.37 kW 0.75 kW	810 kg	2150 x 700 x 1100	3779080		
MSBM 2020-15 PRO SH	2020 mm	1.5 mm	110 mm	0.37 kW 0.75 kW	1050 kg	2650 x 700 x 1100	3779081		
MSBM 2520-12 PRO SH	2520 mm	1.25 mm	110 mm	0.37 kW 0.75 kW	1290 kg	3150 x 700 x 1100	3779082		
MSBM 3020-10 PRO SH	3020 mm	1.0 mm	110 mm	0.37 kW 0.75 kW	1610 kg	3650 x 700 x 1100	3779083		

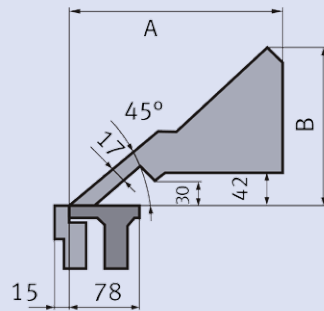
*Performance data for material with tensile strength of 400N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);**Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT



Dimensions
Bending beam MSBM

L	C	GB	E
1500	225	200	44
2000	258	232	44
2500	258	232	44
3000	262	232	44

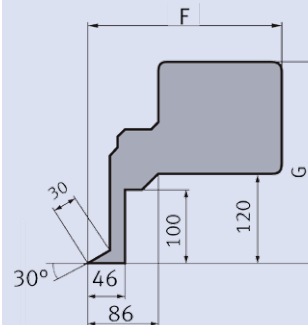
Width of bending rail 15 mm



Dimensions
Bending beam MSBM S

L	A	B
1500	258	215
2000	258	215
2500	310	265
3000	343	303

Width of bending rail 15 mm



Dimensions
Bending beam MSBM SH

L	F	G
1500	270	300
2000	290	320
2500	290	320
3000	290	320

Width of bending rail 15 mm



- **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 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 15-1000 mm

Accessories MSBM 1520-17 PRO / S / SH Art. no.

Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm 3797005

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 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 PUD, bending angle adjustment via potentiometer PT 1, motorised rear stop with stop fingers and digital position display, 15-1000 mm 3797040

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797505

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797506

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797507

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797508

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797509

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797510

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797511

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797512

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797513

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797514

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797515

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797516

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797517

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797518

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797519

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797520

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797521

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797522

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797523

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797524

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797525

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797526

Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797527

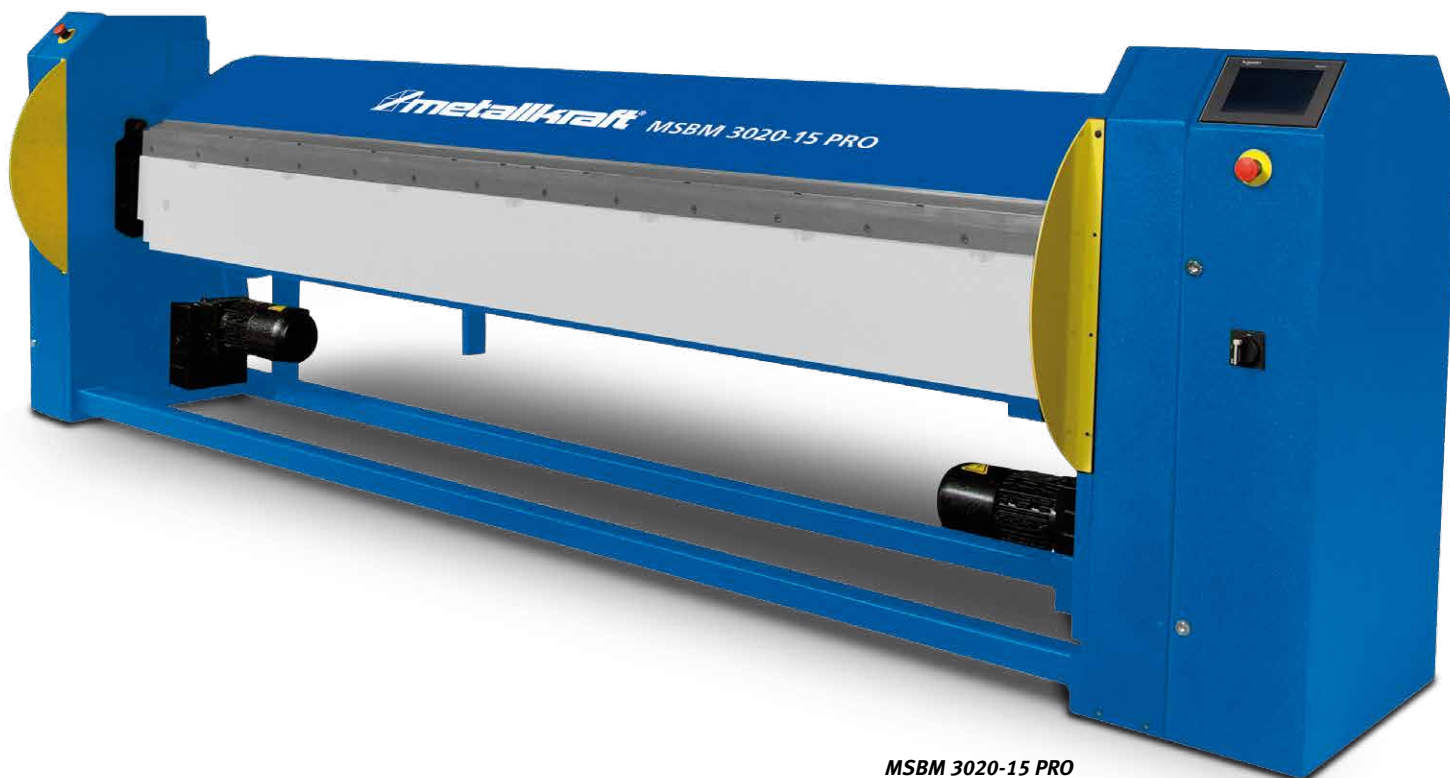
Tempering of standard tools on request!

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

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



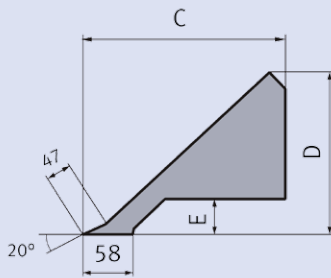
MSBM 3020-15 PRO
With optional control TM 238

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	25-30-35-40-45-50-75-100-150-200-270-400-400
MSBM 2520-20 PRO S / SH	25-30-35-40-45-50-75-100-150-200-270-400-400-500
MSBM 3020-15 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	Working width Max.	Sheet thickness* max.*	Passageway between top + bottom beam Max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.		
				Beam	Bending					
New MSBM 1020-35 PRO	1020 mm	3.5 mm	140 mm	0.75 kW	1.1 kW	860 kg	1350 x 710 x 1160	3779089		
MSBM 1520-30 PRO	1520 mm	3.0 mm	140 mm	0.75 kW	1.1 kW	1060 kg	2350 x 710 x 1160	3779090		
MSBM 2020-25 PRO	2020 mm	2.5 mm	140 mm	0.75 kW	1.1 kW	1380 kg	2850 x 710 x 1160	3779091		
MSBM 2520-20 PRO	2520 mm	2.0 mm	140 mm	0.75 kW	1.1 kW	1780 kg	3350 x 710 x 1160	3779092		
MSBM 3020-15 PRO	3020 mm	1.5 mm	140 mm	0.75 kW	1.1 kW	2200 kg	3850 x 710 x 1160	3779093		
New MSBM 1020-35 PRO S	1020 mm	3.5 mm	140 mm	0.75 kW	1.1 kW	860 kg	1350 x 710 x 1160	3779099		
MSBM 1520-30 PRO S	1520 mm	3.0 mm	140 mm	0.75 kW	1.1 kW	1060 kg	2350 x 710 x 1160	3779100		
MSBM 2020-25 PRO S	2020 mm	2.5 mm	140 mm	0.75 kW	1.1 kW	1380 kg	2850 x 710 x 1160	3779101		
MSBM 2520-20 PRO S	2520 mm	2.0 mm	140 mm	0.75 kW	1.1 kW	1780 kg	3350 x 710 x 1160	3779102		
MSBM 3020-15 PRO S	3020 mm	1.5 mm	140 mm	0.75 kW	1.1 kW	2200 kg	3850 x 710 x 1160	3779103		
New MSBM 1020-35 PRO SH	1020 mm	3.5 mm	140 mm	0.75 kW	1.1 kW	860 kg	1350 x 710 x 1160	3779109		
MSBM 1520-30 PRO SH	1520 mm	3.0 mm	140 mm	0.75 kW	1.1 kW	1060 kg	2350 x 710 x 1160	3779110		
MSBM 2020-25 PRO SH	2020 mm	2.5 mm	140 mm	0.75 kW	1.1 kW	1380 kg	2850 x 710 x 1160	3779111		
MSBM 2520-20 PRO SH	2520 mm	2.0 mm	140 mm	0.75 kW	1.1 kW	1780 kg	3350 x 710 x 1160	3779112		
MSBM 3020-15 PRO SH	3020 mm	1.5 mm	140 mm	0.75 kW	1.1 kW	2200 kg	3850 x 710 x 1160	3779113		

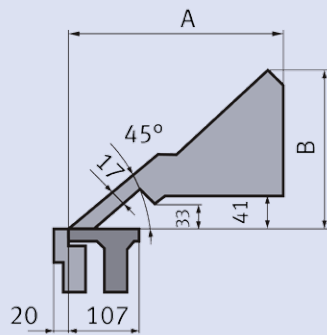
*Performance data for material with tensile strength of 400N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA);**Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT



Dimensions
Bending beam MSBM

L	C	GB	E
1000	380	338	52
1500	380	338	52
2000	360	338	52
2500	360	338	52
3000	360	338	52

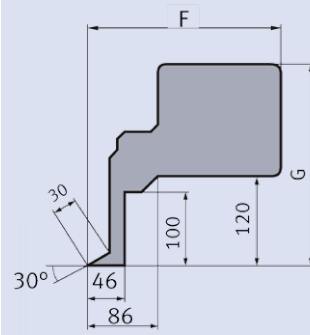
Width of bending rail 20 mm



Dimensions
Bending beam MSBM S

L	A	B
1000	350	310
1500	350	310
2000	350	310
2500	355	315
3000	355	315

Width of bending rail 20 mm



Dimensions
Bending beam MSBM SH

L	F	G
1000	270	300
1500	290	320
2000	290	320
2500	310	340
3000	310	340

Width of bending rail 20 mm

Accessories MSBM 1020-35 PRO / S / SH Art. no.

Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797005
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 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, 15-1000 mm, storing of edging sequences possible	3797504

Accessories MSBM 1520-30 PRO / S / SH Art. no.

Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797005
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 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, 15-1000 mm, storing of edging sequences possible	3797505

Accessories MSBM 2020-25 PRO / S / SH Art. no.

Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797006
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, 15-1000 mm, storing of edging sequences possible	3797506

Accessories MSBM 2520-20 PRO / S / SH Art. no.

Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797007
--	---------

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 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, 15-1000 mm, storing of edging sequences possible	3797507

Accessories MSBM 3020-15 PRO / S / SH Art. no.

Rear stop with two arms, T grooves and tilting cams, 100 - 1000 mm	3797008
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 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, 15-1000 mm, storing of edging sequences possible	3797508



· **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 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 15-1000 mm

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



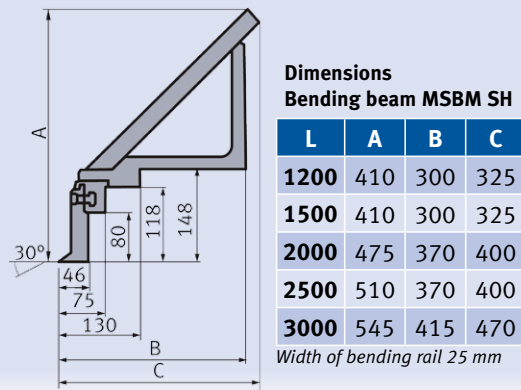
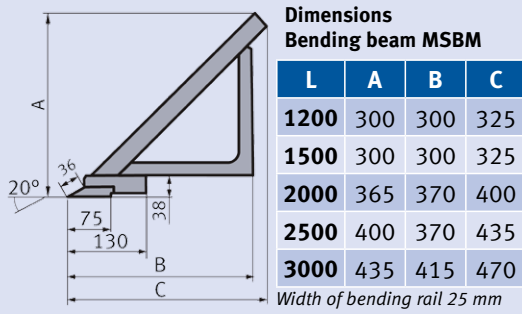
MSBM 3020-20 PRO SH
With optional control PT 1

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	Working width Max.	Sheet thickness* max.*	Passageway between top + bottom beam Max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.		
				Beam	Bending					
New MSBM 1220-40 PRO	1220 mm	4.0 mm	200 mm	0.75 kW	3.0 kW	2300 kg	2190 x 1070 x 1530	3779119		
MSBM 1520-35 PRO	1520 mm	3.5 mm	200 mm	0.75 kW	3.0 kW	2700 kg	2345 x 1100 x 1560	3779120		
MSBM 2020-30 PRO	2020 mm	3.0 mm	200 mm	0.75 kW	3.0 kW	3050 kg	2935 x 1100 x 1560	3779121		
MSBM 2520-25 PRO	2520 mm	2.5 mm	200 mm	0.75 kW	3.0 kW	3600 kg	3435 x 1100 x 1560	3779122		
MSBM 3020-20 PRO	3020 mm	2.0 mm	200 mm	0.75 kW	3.0 kW	4300 kg	3935 x 1100 x 1560	3779123		
New MSBM 1220-40 PRO SH	1220 mm	4.0 mm	90 mm	0.75 kW	3.0 kW	2300 kg	2190 x 1070 x 1530	3779129		
MSBM 1520-35 PRO SH	1520 mm	3.5 mm	90 mm	0.75 kW	3.0 kW	2700 kg	2345 x 1100 x 1560	3779130		
MSBM 2020-30 PRO SH	2020 mm	3.0 mm	90 mm	0.75 kW	3.0 kW	3050 kg	2935 x 1100 x 1560	3779131		
MSBM 2520-25 PRO SH	2520 mm	2.5 mm	90 mm	0.75 kW	3.0 kW	3600 kg	3435 x 1100 x 1560	3779132		
MSBM 3020-20 PRO SH	3020 mm	2.0 mm	90 mm	0.75 kW	3.0 kW	4300 kg	3935 x 1100 x 1560	3779133		
MSBM 2020-40 PRO SH	2020 mm	4.0 mm	90 mm	1.1 kW	4.0 kW	3900 kg	3020 x 1100 x 1560	3779134		

*Performance data for material with tensile strength of 400N/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);**Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT



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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797530
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797540
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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797531
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797541
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 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 2020-30 PRO / SH	Art. no.
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797532
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797542
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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797533
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797543
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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797534
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797544



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 15-1000 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 15-1000 mm



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 15-1000 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

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



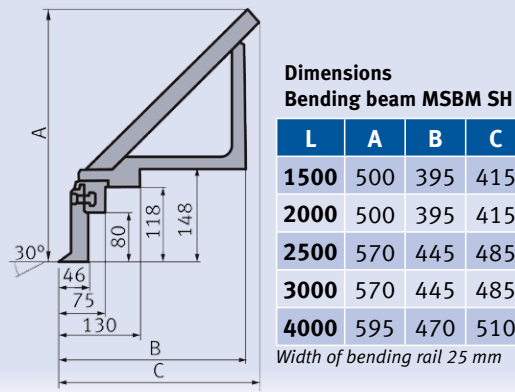
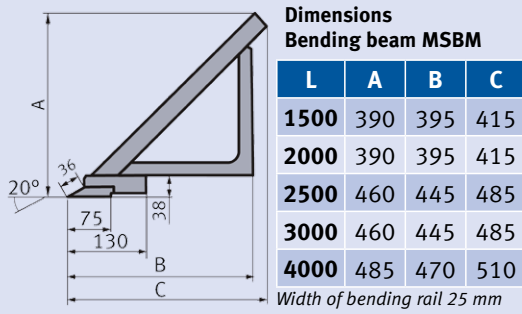
MSBM 3020-30 PRO SH
with optional control PT 1

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	Working width Max.	Sheet thickness* max.*	Passageway between top + bottom beam Max.	Motor output		Weight	Dimensions L x W x H in mm	Art. no.		
				Beam	Bending					
New MSBM 1520-50 PRO	1520 mm	5.0 mm	200 mm	1.1 kW	4.0 kW	3250 kg	2345 x 1100 x 1560	3779128		
New MSBM 2020-40 PRO	2020 mm	4.0 mm	200 mm	1.1 kW	4.0 kW	3900 kg	3020 x 1100 x 1560	3779124		
New MSBM 2520-35 PRO	2520 mm	3.5 mm	200 mm	1.1 kW	4.0 kW	4500 kg	3620 x 1100 x 1560	3779125		
New MSBM 3020-30 PRO	3020 mm	3.0 mm	200 mm	1.1 kW	4.0 kW	6200 kg	4020 x 1100 x 1560	3779126		
New MSBM 4020-20 PRO	4020 mm	2.0 mm	90 mm	1.1 kW	4.0 kW	7000 kg	5200 x 1100 x 1560	3779127		
New MSBM 1520-50 PRO SH	1520 mm	5.0 mm	200 mm	1.1 kW	4.0 kW	3400 kg	2345 x 1100 x 1560	3779138		
New MSBM 2020-40 PRO SH	2020 mm	4.0 mm	90 mm	1.1 kW	4.0 kW	3900 kg	3020 x 1100 x 1560	3779134		
New MSBM 2520-35 PRO SH	2520 mm	3.5 mm	90 mm	1.1 kW	4.0 kW	4500 kg	3620 x 1100 x 1560	3779135		
New MSBM 3020-30 PRO SH	3020 mm	3.0 mm	90 mm	1.1 kW	4.0 kW	6200 kg	4020 x 1100 x 1560	3779136		
New MSBM 4020-20 PRO SH	4020 mm	2.0 mm	90 mm	1.1 kW	4.0 kW	7250 kg	5200 x 1100 x 1560	3779139		

*Performance data for material with tensile strength of 400N/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);**Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT



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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797560
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797561
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797571
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 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 2520-35 PRO / SH	Art. no.
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797562
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797563
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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	3797160
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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797564
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797574



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 15-1000 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 15-1000 mm



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 15-1000 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

MSBM PRO - Motorised brake bending machines, heavy-duty type for sheet thicknesses 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

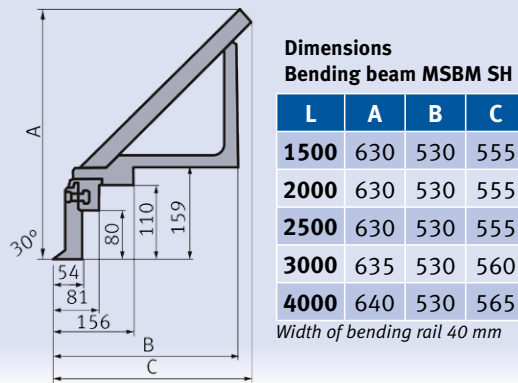
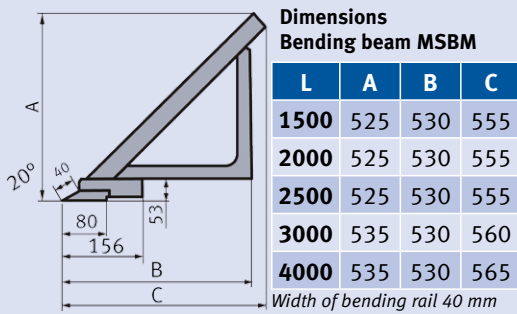


MSBM 2020-60 PRO SH with optional control TM 238

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	Working width Max.	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	1520 mm	7.0 mm	200 mm	2.2 kW	5.5 kW	4025 kg	2620 x 1160 x 1590	3779140		
MSBM 2020-60 PRO	2020 mm	6.0 mm	200 mm	2.2 kW	5.5 kW	4650 kg	3120 x 1160 x 1590	3779141		
MSBM 2520-50 PRO	2520 mm	5.0 mm	200 mm	2.2 kW	5.5 kW	5270 kg	3620 x 1160 x 1590	3779142		
MSBM 3020-40 PRO	3020 mm	4.0 mm	200 mm	2.2 kW	5.5 kW	6090 kg	4120 x 1160 x 1590	3779143		
MSBM 4020-30 PRO	4020 mm	3.0 mm	200 mm	2.2 kW	5.5 kW	7460 kg	5120 x 1160 x 1590	3779144		
MSBM 1520-70 PRO SH	1520 mm	7.0 mm	90 mm	2.2 kW	5.5 kW	4025 kg	2620 x 1160 x 1590	3779150		
MSBM 2020-60 PRO SH	2020 mm	6.0 mm	90 mm	2.2 kW	5.5 kW	4650 kg	3120 x 1160 x 1590	3779151		
MSBM 2520-50 PRO SH	2520 mm	5.0 mm	90 mm	2.2 kW	5.5 kW	5270 kg	3620 x 1160 x 1590	3779152		
MSBM 3020-40 PRO SH	3020 mm	4.0 mm	90 mm	2.2 kW	5.5 kW	6090 kg	4120 x 1160 x 1590	3779153		
MSBM 4020-30 PRO SH	4020 mm	3.0 mm	90 mm	2.2 kW	5.5 kW	7460 kg	5120 x 1160 x 1590	3779154		
New MSBM 1520-70 PRO DUO	1520 mm	7.0 mm	90 / 200 mm	2.2 kW	5.5 kW	4025 kg	2620 x 1160 x 1590	3779220		
New MSBM 2020-60 PRO DUO	2020 mm	6.0 mm	90 / 200 mm	2.2 kW	5.5 kW	4650 kg	3120 x 1160 x 1590	3779221		
New MSBM 2520-50 PRO DUO	2520 mm	5.0 mm	90 / 200 mm	2.2 kW	5.5 kW	5270 kg	3620 x 1160 x 1590	3779222		
New MSBM 3020-40 PRO DUO	3020 mm	4.0 mm	90 / 200 mm	2.2 kW	5.5 kW	6090 kg	4120 x 1160 x 1590	3779223		
New MSBM 4020-30 PRO DUO	4020 mm	3.0 mm	90 / 200 mm	2.2 kW	5.5 kW	7460 kg	5120 x 1160 x 1590	3779224		

*Performance data for material with tensile strength of 400N/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);**Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT



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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible 3797610

CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible 3797611

CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm, 3797621

Accessories MSBM 2520-50 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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible 3797612

CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible 3797613

CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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 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

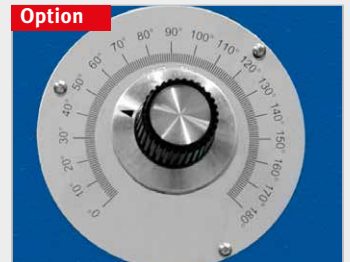
Control Schneider CNC2A, bending angle and rear stop adjustment via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of edging sequences possible 3797594

Control Schneider CNC3A, bending angle, rear stop and upper beam opening via touchscreen on NC control, motorised rear stop with stop fingers, 15-1000 mm, storing of bending sequences possible 3797614

CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm, 3797624



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 15-1000 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 15-1000 mm



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 15-1000 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

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

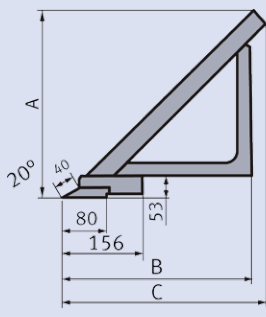


MSBM 2020-80 Pro

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	Working width Max.	Sheet thickness* max.*	Passageway between top + bottom beam Max.	Motor output Beam Bending	Weight	Dimensions L x W x H in mm	Art. no.		
New MSBM 2020-80 PRO	2020 mm	8.0 mm	350 mm	4.0 kW 2 x 4.0 kW	5380 kg	3480 x 1500 x 1750	3779400		
New MSBM 2520-70 PRO	2520 mm	7.0 mm	350 mm	4.0 kW 2 x 4.0 kW	5900 kg	3970 x 1500 x 1750	3779401		
New MSBM 3020-60 PRO	3020 mm	6.0 mm	350 mm	4.0 kW 2 x 4.0 kW	6550 kg	4470 x 1500 x 1750	3779402		
New MSBM 4020-40 PRO	4020 mm	4.0 mm	350 mm	4.0 kW 2 x 4.0 kW	8130 kg	5480 x 1500 x 1750	3779403		
New MSBM 4520-30 PRO	4520 mm	3.0 mm	350 mm	4.0 kW 2 x 4.0 kW	8980 kg	5980 x 1500 x 1750	3779404		
New MSBM 5020-20 PRO	5020 mm	2.0 mm	350 mm	4.0 kW 2 x 4.0 kW	9840 kg	6480 x 1500 x 1750	3779405		
New MSBM 2020-80 PRO SH	2020 mm	8.0 mm	240 mm	4.0 kW 2 x 4.0 kW	5380 kg	3480 x 1500 x 1750	3779410		
New MSBM 2520-70 PRO SH	2520 mm	7.0 mm	240 mm	4.0 kW 2 x 4.0 kW	5900 kg	3970 x 1500 x 1750	3779411		
New MSBM 3020-60 PRO SH	3020 mm	6.0 mm	240 mm	4.0 kW 2 x 4.0 kW	6550 kg	4470 x 1500 x 1750	3779412		
New MSBM 4020-40 PRO SH	4020 mm	4.0 mm	240 mm	4.0 kW 2 x 4.0 kW	8130 kg	5480 x 1500 x 1750	3779413		
New MSBM 4520-30 PRO SH	4520 mm	3.0 mm	240 mm	4.0 kW 2 x 4.0 kW	8980 kg	5980 x 1500 x 1750	3779414		
New MSBM 5020-20 PRO SH	5020 mm	2.0 mm	240 mm	4.0 kW 2 x 4.0 kW	9840 kg	6480 x 1500 x 1750	3779415		
New MSBM 2020-80 PRO DUO	2020 mm	8.0 mm	350 / 240 mm	4.0 kW 2 x 4.0 kW	5380 kg	3480 x 1500 x 1750	3779420		
New MSBM 2520-70 PRO DUO	2520 mm	7.0 mm	350 / 240 mm	4.0 kW 2 x 4.0 kW	5900 kg	3970 x 1500 x 1750	3779421		
New MSBM 3020-60 PRO DUO	3020 mm	6.0 mm	350 / 240 mm	4.0 kW 2 x 4.0 kW	6550 kg	4470 x 1500 x 1750	3779422		
New MSBM 4020-40 PRO DUO	4020 mm	4.0 mm	350 / 240 mm	4.0 kW 2 x 4.0 kW	8130 kg	5480 x 1500 x 1750	3779423		
New MSBM 4520-30 PRO DUO	4520 mm	3.0 mm	350 / 240 mm	4.0 kW 2 x 4.0 kW	8980 kg	5980 x 1500 x 1750	3779424		
New MSBM 5020-20 PRO DUO	5020 mm	2.0 mm	350 / 240 mm	4.0 kW 2 x 4.0 kW	9840 kg	6480 x 1500 x 1750	3779425		

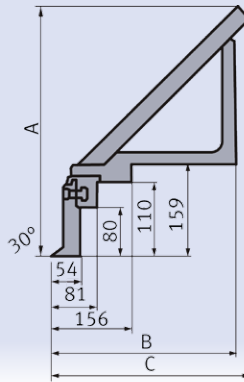
*Performance data for material with tensile strength of 400N/mm²; bending performance stainless steel (VA) = factor 0.75; bending performance aluminium = 1.2; optional tempering of the material is necessary for bending stainless steel (VA); **Transport and packaging lump sum: please turn over for descriptions of the transport and surcharges; price TPFR plus VAT



**Dimensions
Bending beam MSBM**

L	A	B	C
2000	525	530	555
2500	525	530	555
3000	525	530	555
4000	560	530	590
4500	560	530	590
5000	560	545	615

Width of bending rail 40 mm



**Dimensions
Bending beam MSBM SH**

L	A	B	C
2000	630	530	555
2500	630	530	555
3000	630	530	555
4000	665	530	590
4500	665	530	590
5000	690	545	615

Width of bending rail 40 mm

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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797611	
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797612	
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797613	
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797623	
Accessories MSBM 4020-40 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797614
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797615
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 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, 15-1000 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, 15-1000 mm, storing of bending sequences possible	3797616
CNC control FF101 with 3D graphics, 19" touchscreen, motorised rear stop with stop fingers, 15-1000 mm,	3797626



Standard 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 15-1000 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 15-1000 mm



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 15-1000 mm

GBP-R — CNC controlled press brake with 3-axe 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

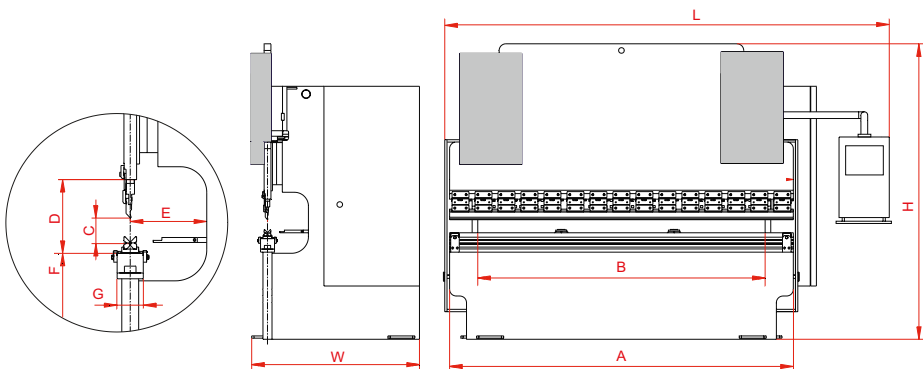
- ▶ Manual table crowning via hand wheel with counter
- ▶ Solid, low-maintenance guides on the top beam
- ▶ Long reach
- ▶ 2 sheet support arms with T groove and tilting cams
- ▶ Fiesler AKAS II safety device travels with the top beam
- ▶ Fiesler FPSC safety PLC



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



GBP-E 3050-120

Model	Pressing force (t)	Bending length (A)	Stand passageway (B)	Rapid motion (mm/sec.)	Bending speed (mm/sec.)	Return (mm/sec.)	Installation height (mm) (D)	Motor output (kW)	Stroke (mm) (C)	Overhang depth (mm) (E)	Rear stop (mm)	Table height (mm) (F)
GBP-E 2550-60	60	2550	2150	120	9	70	350	7.5	160	250	620	813
GBP-E 3050-120	120	3050	2550	100	9	77	375	11	180	250	620	878
GBP-E 3050-200	200	3050	2550	100	7	73	445	15	210	250	620	858

- 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



• Fiessler AKAS II safety device



• 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)

Table width (mm) (G)	Number of support brackets	Weight (kg)	Dimensions (L x W x H) in mm (L x W x H)	Art. no.	
104	2	4000	3750 x 1100 x 2350	3828001	
104	2	5900	4200 x 1230 x 2400	3828002	
104	2	7950	4500 x 1390 x 2520	3828003	

Accessories available on request

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

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

Standard type

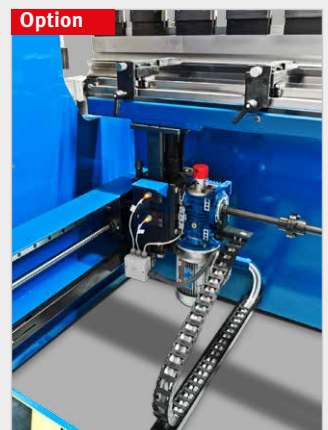
- ▶ Very heavy, rugged welded steel construction, stress-free annealing
- ▶ Graphical 2D CNC control DT-10 with generously-dimensioned 10" touchscreen, ergonomically mounted on swivel arm
- ▶ CNC-controlled Y1, Y2 and X axis
- ▶ X axis 650 mm, guided on linear rails and driven via play-free ball screws (as of GBP-R 4050-400 X axis 750 mm)
- ▶ 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
- ▶ 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 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
- ▶ Finessler AKAS II safety device travels with the top beam
- ▶ Finessler 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-R 3050-135 with motorised table crowning and motorised R axis options

Custom accessories

- ▶ Numeric CNC control Cybelec DNC 880S with graphical support and offline PC software
- ▶ CNC-controlled, motorised R axis
- ▶ CNC-controlled, motorised table crowing to compensate for bending of top beam and table
- ▶ Extension of X axis travel range to 1000 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



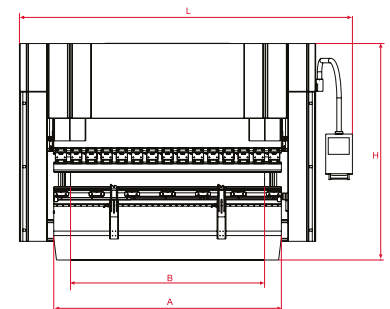
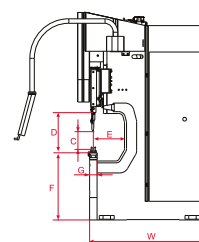
Option
· Motorised R axis option



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 crowing 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, crowing
- ▶ 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

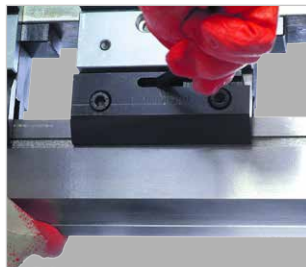


- (A) Bending length
- (B) Distance between columns
- (C) Stroke
- (D) Installation height
- (E) Reach depth

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



· Fiessler AKAS II safety device



· Manual quick release clamping



· Die mount



· Large installation height
· Large stand reach



GBP-R 3050-135 with motorised table crowning and motorised R axis options

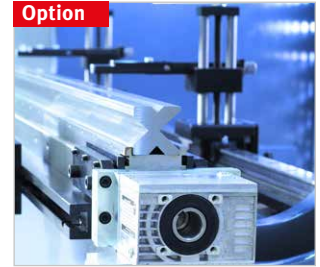
Model	Press force	Bending length	Stand passageway	Stroke	Installation height	Reach	Rapid mode	Bending speed	Retraction	Motor output	X axis stroke	X axis speed	Table width	Table height
	t	mm	mm	mm	mm	mm	mm/s	mm/s	mm/s	kW	mm	mm/s	mm	mm
GBP-R 1250-60	60	1250	1050	160	400	350	200	10	110	7.5	650	250	104	900
GBP-R 2050-60	60	2050	1700	160	400	350	200	10	110	7.5	650	250	104	900
GBP-R 2550-100	100	2550	2200	265	530	410	180	10	120	11	650	250	104	900
GBP-R 3050-100	100	3050	2600	265	530	410	180	10	120	11	650	250	104	900
GBP-R 3050-135	135	3050	2600	265	530	410	160	10	120	15	650	250	104	900
GBP-R 3050-175	175	3050	2600	265	530	410	120	10	100	18.5	650	250	104	900
GBP-R 3050-220	220	3050	2600	265	530	410	120	10	100	22	650	250	104	900
GBP-R 3050-320	320	3050	2600	365	630	410	100	10	100	37	650	250	154	900
GBP-R 3750-175	175	3700	3100	265	530	410	120	10	100	18.5	650	250	104	900
GBP-R 3750-220	220	3700	3100	265	530	410	120	10	100	22	650	250	104	900
GBP-R 4050-175	175	4050	3600	265	530	410	120	10	100	18.5	650	250	104	900
GBP-R 4050-220	220	4050	3600	265	530	410	120	10	100	22	650	250	104	900
GBP-R 4050-320	320	4050	3600	365	630	410	100	10	100	37	650	250	154	900
GBP-R 4050-400	400	4050	3400	365	630	510	100	8	80	37	750	250	154	1040
GBP-R 6050-220	220	6050	5100	265	530	410	100	10	100	22	750	250	154	1100
GBP-R 6050-320	320	6050	5100	365	630	410	100	10	100	37	750	250	154	1100
GBP-R 6050-400	400	6050	5100	365	630	510	100	8	80	37	750	250	154	1220



· Sheet support arms displaceable on linear rails



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



· Motorised table crowning option



CNC control CybeleC DNC 880 S (option)

The convenient CNC control 880S supports numeric programming of sections and simultaneous display in a 2D graphic. After creating the section, the bending sequence is automatically determined and all axis positions computed. The bending sequences are graphically simulated.

- ▶ Supports up to four axes (Y1, Y2, X and R) as well as motorised table crowning
- ▶ Automatic computation of the edge depth, compression force, crowning, rear stop position for known external dimensions, bending sequence, stop depth, stop height and stretched length
- ▶ Collision warning
- ▶ Bending speed, holding time, and retraction time programmable
- ▶ Offline 2D software
- ▶ Graphical display of bending sequence during operation
- ▶ Graphical product and tool library
- ▶ 10" colour display
- ▶ USB interface for mouse, keyboard and data transfer
- ▶ Windows XP operating system

Support arms/ rear stop fingers	Oil tank Capacity	Weight approx.	Dimensions L x W x H	Art. no.	
Pc.	l	kg	mm		
2/2	100	3100	2300 x 1200 x 2350	3821240	
2/2	100	3550	3200 x 1200 x 2350	3822510	
2/2	100	8650	3800 x 1670 x 2750	3823010	
2/2	100	9250	4200 x 1670 x 2750	3823013	
2/2	150	10250	4200 x 1680 x 2750	3823017	
2/2	250	11250	4250 x 1700 x 2750	3823022	
2/2	250	12250	4250 x 1770 x 2900	3823032	
2/2	250	17250	4300 x 1820 x 3230	3823717	
2/2	250	17250	4950 x 1700 x 2900	3823722	
2/2	250	14100	4950 x 1770 x 2900	3824017	
2/2	250	12850	5250 x 1700 x 2750	3824022	
2/2	250	14750	5250 x 1770 x 2900	3824032	
2/2	250	20750	5300 x 1910 x 3230	3824040	
2/2	450	26750	5750 x 2110 x 3540	3824060	
4/4	250	20590	7500 x 1770 x 3250	3826022	
4/4	250	28250	7500 x 1910 x 3450	3826032	
4/4	500	35750	7500 x 2110 x 3710	3826040	

Accessories	Art. no.
CNC control CybeleC DNC 880 S	3884001
R axis GBP-R 1250-40/2050-40	3884002
R axis GBP-R 2050-60/2550-100	3884003
R axis GBP-R 3050-100/3050-135/ 3050-175/3050-220/3050-320	3884004
R axis GBP-R 3750-175/3750-220	3884005
R axis GBP-R 4050-175/4050-220/ 4050-320/4050-400	3884006
X axis 1000 mm	3884007
CNC-controlled, motorised table crowning GBP-R 1250-40/ 2050-40/2050-60/2550-100	3884011
CNC-controlled, motorised table crowning GBP-R 3050-100/ 3050-135/3050-175/3050-220/3050-320	3884012
CNC-controlled, motorised table crowning GBP-R 3750-175/3750-220	3884013
CNC-controlled, motorised table crowning GBP-R 4050-175/ 4050-220/4050-320/4050-400	3884014
Additional rear stop fingers GBP-R 1250-40/2050-40/ 2050-60/2550-100/3050-100/ 3050-135/3050-175/3750-175/4050-175	3884015
Additional rear stop fingers GBP-R 3050-220/3050-320/3750-220/ 4050-220/4050-320/4050-400	3884016
Additional support arms GBP-R 1250-40/ 2050-40/ 2050-60/ 2550-100/ 3050-100/ 3050-135/3050-175/3050-220	3884017
GBP-R 3050-320/4050-320/4050-400	3884018
Prepared for tandem version as of GBP-R 3050-100	3884019

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

Standard type

- ▶ Very heavy, rugged welded steel construction, stress-free annealing
- ▶ Graphical 3D CNC control Cybelec ModEva RA with generously dimensioned 15" 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 6050 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
- ▶ Solid, low-maintenance 4x guides on the top beam
- ▶ Large side stand 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 (4 pcs. as of bending width of 6050 mm)
- ▶ Fieessler AKAS II safety device travels with the top beam
- ▶ Fieessler 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



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



GBP-S 3050-175 with Delta-X option

Custom accessories

- ▶ 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 1000 mm
- ▶ Wila hydraulic workpiece clamping system
- ▶ AKAS 3M, 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 3050 mm)



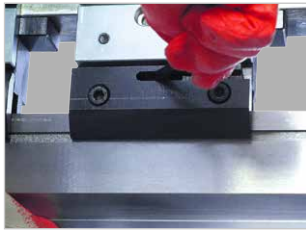
Rear view with optional 6-axis rear stop



CNC control Cybelec ModEva 15T

The 3D CNC control Modeva 15T with extra large 15" touchscreen monitor. 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



• Manual quick release clamping



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



• Flessler AKAS II safety device



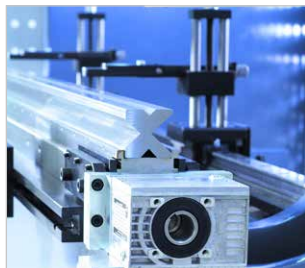
• Delta-X axis option



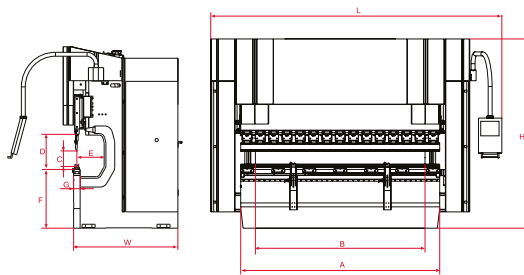
Model GBP-S	Press force	Bending length	Stand passageway	Stroke	Instal- lation height	Reach	Rapid mode	Bending speed	Retraction	Motor output	X axis stroke	X axis speed	R axis stroke	R axis speed	Table width	Table height	Crowning	Under- floor	Support arms
	t	mm	mm	mm	mm	mm	mm/s	mm/s	mm/s	kW	mm	mm/s	mm	mm/s	mm	mm		mm	Pc.
1250-60	60	1250	1050	265	530	410	200	10	110	7.5	650	500	250	350	104	900	motorised	-	2/2
2050-60	60	2050	1700	265	530	410	200	10	110	7.5	650	500	250	350	104	900	motorised	-	2/2
2550-100	100	2550	2200	265	530	410	180	10	120	11	650	500	250	350	104	900	motorised	-	2/2
3050-100	100	3050	2600	265	530	410	180	10	120	11	650	500	250	350	104	900	motorised	-	2/2
3050-135	135	3050	2600	265	530	410	160	10	120	15	650	500	250	350	104	900	motorised	-	2/2
3050-175	175	3050	2600	265	530	410	120	10	100	18.5	650	500	250	350	104	900	motorised	-	2/2
3050-220	220	3050	2600	265	530	410	120	10	100	22	650	500	250	350	104	900	motorised	-	2/2
3050-320	320	3050	2600	265	630	410	100	10	100	37	650	500	250	350	154	900	motorised	-	2/2
3750-175	175	3700	3100	265	530	410	120	10	100	18.5	650	500	250	350	104	900	motorised	-	2/2
3750-220	220	3700	3100	265	530	410	120	10	100	22	650	500	250	350	104	900	motorised	-	2/2
4050-175	175	4050	3600	265	530	410	120	10	100	18.5	650	500	250	350	104	900	motorised	-	2/2
4050-220	220	4050	3600	265	530	410	120	10	100	22	650	500	250	350	104	900	motorised	-	2/2
4050-320	320	4050	3600	365	630	410	100	10	100	37	650	500	250	350	154	900	motorised	-	2/2
4050-400	400	4050	3400	365	630	510	100	8	80	37	750	350	250	300	300	1040	motorised	-	2/2
4050-600	600	4050	3100	365	700	510	80	7	80	45	750	350	250	300	300	990	motorised	1200	2/2
6050-220	220	6050	5100	265	530	410	80	10	100	22	750	350	250	300	154	1100	motorised	-	4/4
6050-320	320	6050	5100	365	630	410	100	10	100	37	750	350	250	300	154	1100	motorised	-	4/4
6050-400	400	6050	5100	365	630	510	100	8	80	37	750	350	250	300	300	1220	motorised	-	4/4



- R axis (Standard)
- X axis (Standard)



- Motorised table crowning



- (A) Bending length
(B) Distance between columns
(C) Stroke
(D) Installation height
(E) Reach depth
(F) Table height
(G) Table width
(H) Height
(L) Length
(W) Depth

Oil tank capacity	Weight approx.	Dimensions L x W x H	Art. no.
l	kg	mm	
100	4900	2550 x 1650 x 2750	3821241
100	5600	3400 x 1650 x 2750	3822061
100	8900	3800 x 1670 x 2750	3822511
100	9500	4200 x 1670 x 2750	3823011
150	10500	4200 x 1680 x 2750	3823014
250	11500	4250 x 1700 x 2750	3823018
250	12500	4250 x 1770 x 2900	3823023
250	17500	4300 x 1820 x 3230	3823033
250	13000	4950 x 1700 x 2900	3823718
250	14360	4950 x 1770 x 2900	3823723
250	13100	5250 x 1700 x 2750	3824018
250	15000	5250 x 1770 x 2900	3824023
250	21000	5300 x 1910 x 3230	3824033
450	27000	5750 x 2110 x 3540	3824041
500	40500	5650 x 3250 x 3825	3824061
250	20840	7500 x 1770 x 3250	3826023
250	28500	7500 x 1910 x 3450	3826033
500	36000	7500 x 2110 x 3710	3826041

**More models
on request!**

Accessories

3D CNC control Cybelec ModEva RA Premium	3883997
2D CNC control Delem DA-66T	3883998
3D CNC control Delem DA-69T	3883999
Z1, Z2 axes GBP-S 1250-40/2050-60	3885001
Z1, Z2 axes GBP-S 25100	3885002
Z1, Z2 axes GBP-S 30100/30135/30175/30220/30320	3885003
Z1, Z2 axes GBP-S 37175/37220	3885004
Z1, Z2 axes GBP-S 40175/40220/40320/40400/40600	3885005
X1, X2 axes GBP-S 1240/2060	3885006
X1, X2 axes GBP-S 25100	3885007
X1, X2 axes GBP-S 30100/30135/30175/30220/30320	3885008
X1, X2 axes GBP-S 37175/37220	3885009
X1, X2 axes GBP-S 40175/40220/40320/40400/40600	3885010
R1, R2 axes GBP-S 1240/2060	3885011
R1, R2 axes GBP-S 25100/30100/30135	3885012
R1, R2 axes GBP-S 30175/30220/30320	3885013
R1, R2 axes GBP-S 37175/37220	3885014
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 = 1000 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 2050-60	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	
hydr. quick release clamping top WILA max. 180t/m PowerPack	3885025
hydr. quick release clamping top WILA max. 180t/m PowerPack	3885026
GBP-S 4050-175/4050-220/4050-320/4050-400/4050-600	
mech. quick release clamping top WILA max. 180t/m GBP-S 1250-40	3885027
mech. quick release clamping top WILA max. 180t/m GBP-S 2050-60	3885028
mech. quick release clamping top WILA max. 180t/m GBP-S 2550-100	3885029
mech. quick release clamping top WILA max. 180t/m GBP-S 3050-100/3050-135/3050-175/3050-220/3050-320	3885030
mech. quick release clamping top WILA max. 180t/m GBP-S 3750-175/3750-220	3885031
mech. quick release clamping top WILA max. 180t/m GBP-S 4050-175/4050-220/4050-320/4050-400/4050-600	3885032
hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 1250-40	3885033
hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 2050-60	3885034
hydr. quick release clamping bottom WILA max. 200t/m PowerPack GBP-S 2550-100	3885035
hydr. quick release clamping bottom WILA max. 200t/m PowerPack	3885036
GBP-S 3050-100/3050-135/3050-175/3050-220/3050-320	
hydr. quick release clamping bottom WILA max. 200t/m PowerPack	3885037
GBP-S 3750-175/3750-220	
hydr. quick release clamping bottom WILA max. 200t/m PowerPack	3885038
GBP-S 4050-175/4050-220/4050-320/4050-400/4050-600	
mech. quick release clamping bottom WILA max. 200t/m GBP-S 1250-40	3885039
mech. quick release clamping bottom WILA max. 200t/m GBP-S 2050-60	3885040
mech. quick release clamping bottom WILA max. 200t/m GBP-S 2550-100	3885041
mech. quick release clamping bottom WILA max. 200t/m	3885042
GBP-S 3050-100/3050-135/3050-175/3050-220/3050-320	
mech. quick release clamping bottom WILA max. 200t/m	3885043
GBP-S 3750-175/3750-220	
mech. quick release clamping bottom WILA max. 200t/m	3885044
GBP-S 4050-175/4050-220/4050-320/4050-400/4050-600	
WILA PowerPack for hydr. quick release clamping	3885045
Stroke 365mm GBP 3050-100/3050-135/3050-175	3885046
Additional support arms GBP-S 1250-40/2050-40/2050-60/2550-100/3050-100/3050-135/3050-175/3050-220	3884017
Additional support arms GBP-S 3050-320/4050-320/4050-400/4050-600	3884018
Manual centralised lubrication system	3885047
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
Additional rear stop fingers GBP-S GBP-S 3050-220/3050-320/3750-220/4050-220/4050-320/4050-400/4050-600	3885049
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
Depositing zone for support arms (1 metre) GBP-S 4050-400/4050-600	3885051
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
Additional support arms GBP-S 4050-400/4050-600	3885054
4050-220/4050-320 Additional support arms GBP-S 4050-400/4050-600	
Prepared for tandem version as of GBP-S 3050-100	3884019

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Band saws

GBP-Servo – CNC-controlled press brake for energy-saving, fast and low-noise operation

Standard type

▶ Latest energy-saving technology ensures low power consumption:

- 60% less power consumption with 15 cycles per hour
- 62% less power consumption in standby mode
- 44% less power consumption during the pressing cycle

- ▶ User-friendly 3D control Cybelec ModEva 15T, ergonomically mounted on swivel arm
- ▶ CNC controlled Y1, Y2, X and R axis and motorised table crowning
- ▶ X axis, guided on linear rails and driven via play-free ball screws
- ▶ Motorised R axis, guided on linear rails, rack and pinion driven

- ▶ Automatic, motorised table crowing to compensate for bending of top beam and tables
- ▶ 2 rear stop fingers with multiple stop positions guided in longitudinal direction on linear rail
- ▶ Positioning of top beam with a resolution of 0.01 mm



GBP-Servo 3050-175 with optional WILA clamping system and robot connection

Model		GBP-SERVO 2550-100	GBP-SERVO 3050-100	GBP-SERVO 3050-135	GBP-SERVO 3050-175
Art. no.		3827001	3827002	3827003	3827004

Technical specifications					
Press force	ton	100	100	135	175
Bending length	mm	2550	3050	3050	3050
Stand passageway	mm	2200	2600	2600	2600
Rapid mode	mm/sec	200	200	200	180
Bending speed	mm/sec	10	10	10	10
Retraction	mm/sec	200	200	180	160
Installation height	mm	530	530	530	530
Table width	mm	104	104	104	104
Table height	mm	900	900	900	900
Stroke	mm	265	265	265	265
Reach depth	mm	410	410	410	410
Support brackets	Quantity	2	2	2	2
Motor output	kW	2 x 3.6	2 x 3.6	2 x 4	2 x 5.5
Oil tank capacity	l	80	80	80	120
Dimensions	mm	3800 x 1670 x 2750	4200 x 1670 x 2750	4200 x 1680 x 2750	4250 x 1700 x 2750
Weight	kg	8900	9500	10500	11500

- ▶ Measuring system decoupled from side stands to compensate for side stand deflection
- ▶ Manual top tool quick release with cam lever and intermediate pieces, Promecam/Amada system (machines from 400t press output with heavy-load support)
- ▶ Solid, low-maintenance 4x guides on the top beam
- ▶ Large side stand overhang
- ▶ 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
- ▶ Hydraulic operation

Custom accessories

- ▶ CNC control Cybelec ModEva RA Premium with touchscreen
- ▶ Graphical 2D CNC control Delem DA-66T with touchscreen
- ▶ Graphical 3D CNC control Delem 69T with touchscreen
- ▶ Motorised, controlled Z1, Z2 axes
- ▶ Motorised, controlled X1, X2 axes
- ▶ Motorised, controlled R1, R2 axes
- ▶ Extension of X axis travel range to 1000 mm (rear safeguard with light barrier instead of door)

- ▶ Quick release top tool Speed Grip for vertical removal of the top tools
- ▶ Wila hydraulic workpiece clamping system
- ▶ Additional rear stop fingers and sheet support arms
- ▶ Gesteuerte Biegehilfen
- ▶ Extension of stand reach
- ▶ Parking position for support arms
- ▶ Manual or motorised centralised lubrication system
- ▶ Individual punches and dies
- ▶ Control on left side of machine

Accessories GBP Servo

	Art. no.
3D CNC control Cybelec ModEva RA Premium	3883997
2D CNC control Delem DA-66T	3883998
3D CNC control Delem DA-69T	3883999
CNC control Cybelec ModEva 15S 3D touchscreen + CyCad 2D DXF conversion SW (all models)	3886000
Z1, Z2 axes for 2550-100	3886001
Z1, Z2 axes for 3050-100, 3050-135, 3050-175	3886002
X1, X2 axes for 2550-100	3886003
X1, X2 axes for 3050-100, 3050-135, 3050-175	3886004
R1, R2 axes for 2550-100, 3050-100, 3050-135	3886005
R1, R2 axes for 3050-175	3886006
Delta X axis, +250 mm stroke CNC-controlled (all models)	3886007
X axis 1000 mm - return protection with light barrier (all models)	3886008
AP3-AP4 bending aids with movable guide rails - motorised height adjustable Transport capacity of 125kg each (all models)	3886009
pneumatic height adjustment front support arms (all models)	3886010
hydraulic quick release clamping top WILA max. 180 t/m for 2550-100	3886013
hydraulic quick release clamping top WILA max. 180 t/m for 3050-100, 3050-135, 3050-175	3886014
hydraulic quick release clamping bottom WILA max. 200 t/m for 2550-100	3886015
hydraulic quick release clamping bottom WILA max. 200 t/m for 3050-100, 3050-135, 3050-175	3886016
WILA PowerPack for hydraulic quick release clamping (all models)	3886017
Additional support arms (all models)	3886018
Manual centralised lubrication system for 2550-100	3886019
Manual centralised lubrication system for 3050-100, 3050-135, 3050-175	3886020
Additional rear stop fingers (all models)	3886021
Laser angle measuring system (all models)	3886022
Storage area for support brackets 1000 mm for 3050-100, 3050-135, 3050-175	3886023
Preparation for tandem version for 3050-100, 3050-135, 3050-175	3886024



• Fiessler AKAS II safety device



• CNC-controlled, motorised table crowning



• R axis (Standard)
• X axis (Standard)



• 2 movable front support brackets (standard)

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



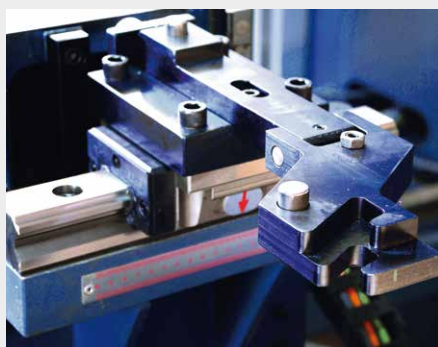
► Movable front support brackets (standard for R, S and Servo)



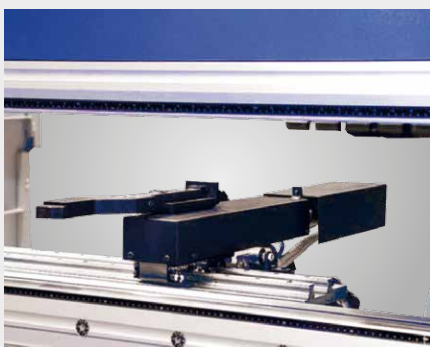
► CNC-controlled, motorised table crowning (standard for S and Servo series)



► 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	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:

- 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.

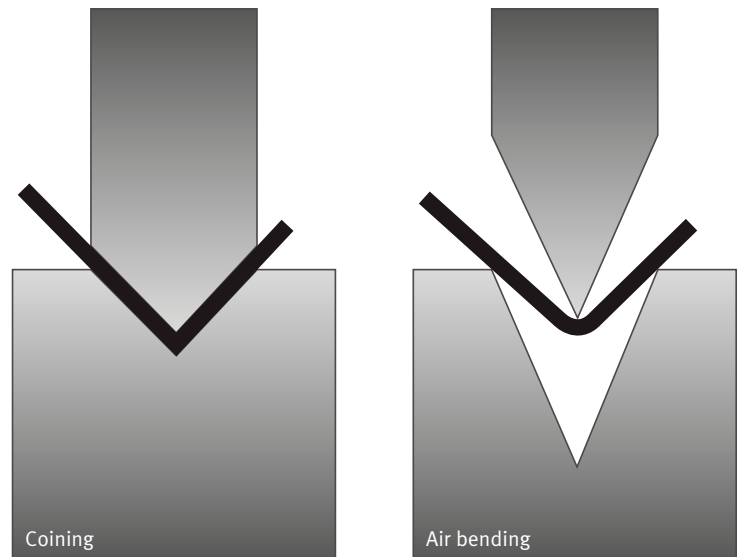
If the initial training time is 8 hours, the travel time is invoiced at 48 €/hour.

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.

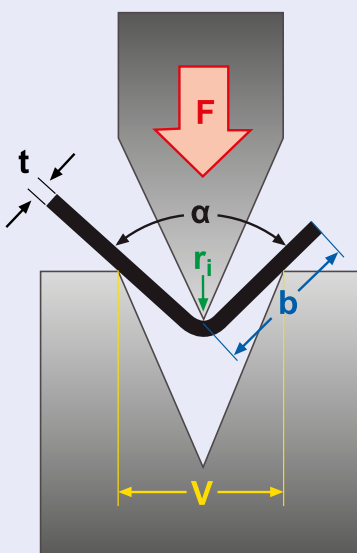


Determining the bending parameters for air bending

Press force table

- Required press force F for 90° air bending, tensile strength $R = 42 \text{ kg/mm}^2$

	V in mm		b in mm		r _i in mm		t in mm		F in t/m												V
t	4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	250	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	37	r _i
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	α
Press force	F
Die opening angle	V
Shortest leg length	b
Inner radius	r _i

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 r_i . 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 r_i from tensile strength R :

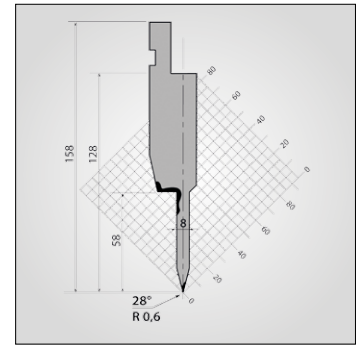
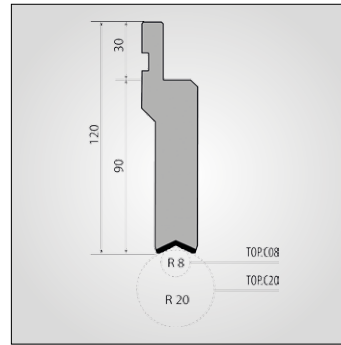
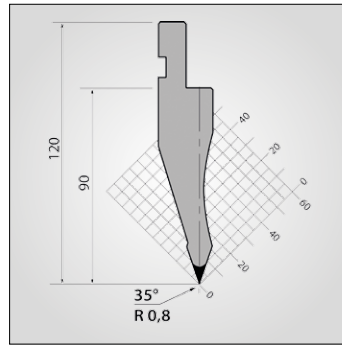
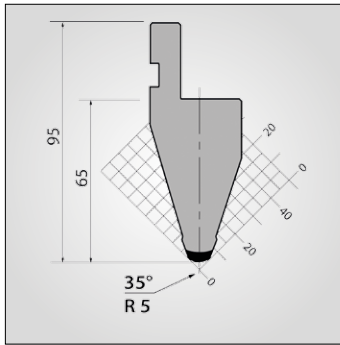
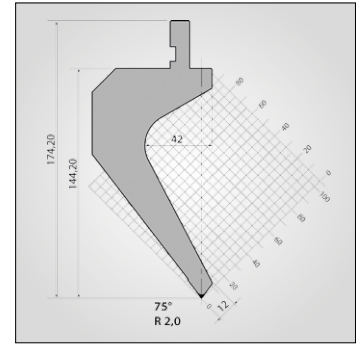
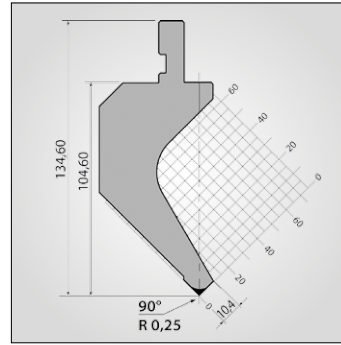
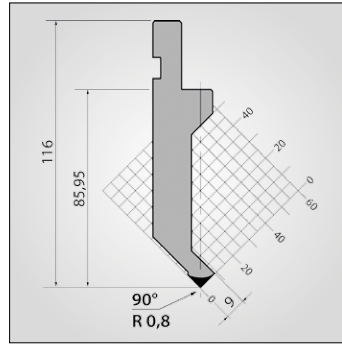
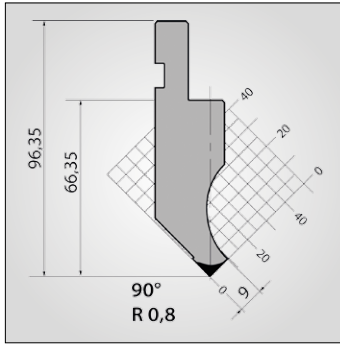
$R = 20 \text{ kg/mm}^2$ (Al)	$r_i \times 0.8$
$R = 42 \text{ kg/mm}^2$ (Fe)	$r_i \times 1.0$
$R = 70 \text{ kg/mm}^2$ (Inox)	$r_i \times 1.4$

Matching punches and dies for various applications

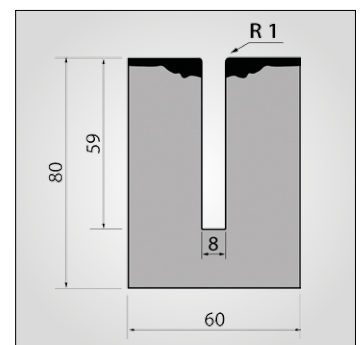
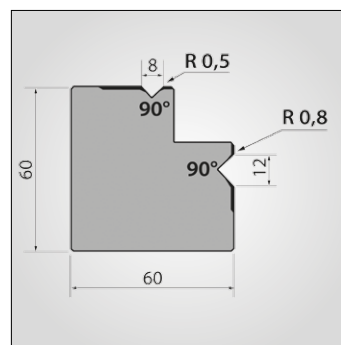
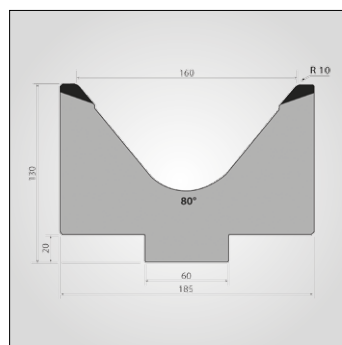
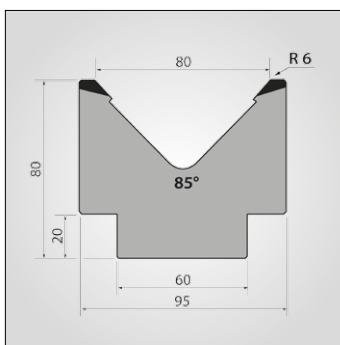
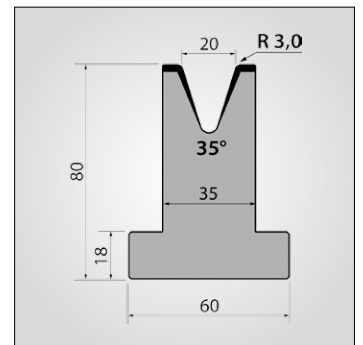
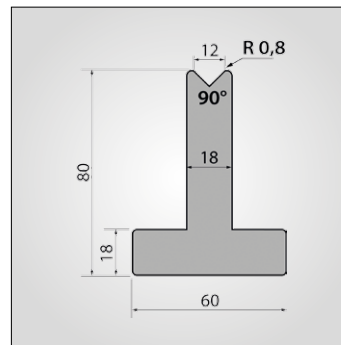
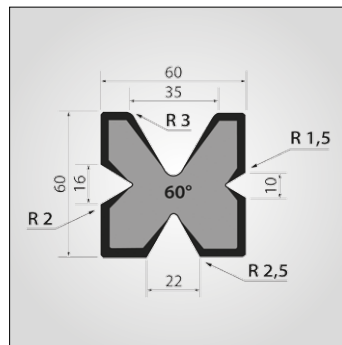
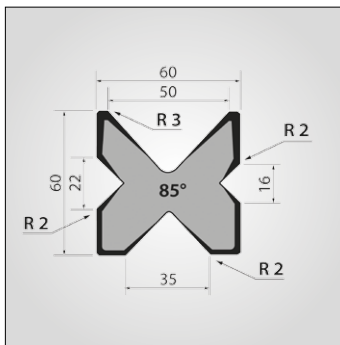
A number of examples from our comprehensive range of tools for press brakes are listed here. In addition to our comprehensive offer of standard tools, custom

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:



Examples of bottom tools:



**Your required sizes;
prices on request!**



Presses

WPP 15 T - Hydraulic table workshop press with hand pump and moving cylinder



- For all repair and assembly work, e.g.: straightening axles, subframes, shafts, etc.; pressing bearings, bolts and bushings in and out; pressing and crimping work; load tests and weld sample testing, etc.
- Sturdy welded design
- Rugged frame with holes for adjusting the work table

- Reliable, high-precision hydraulics, made in Europe
- Manual pressure build up by actuating the pump lever
- With automatic piston return
- With chrome-plated cylinder pistons
- Pressing pressure can be read off on gauge
- with safety valve for overload protection

- includes a 2-part prism set for insert-placing round materials
- For processing flat materials, pressing in bearings, bolts and similar, please use the optional perforated plate



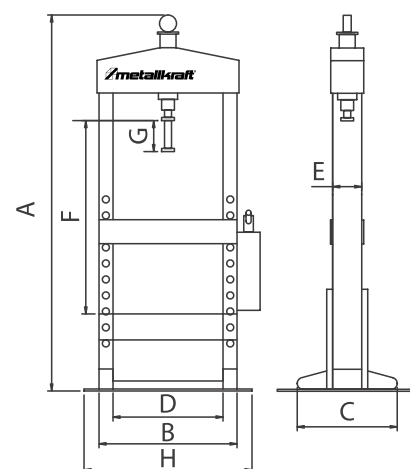
WPP 15 T

- Table workshop press
- with lever

Scope of supply

2-part prism set for insert-placing round materials

Model	WPP 15 T
Art. no.	4001115
Technical specifications	
Output	15 t
max. load on prism jaw	3.5 t
Weight	105 kg

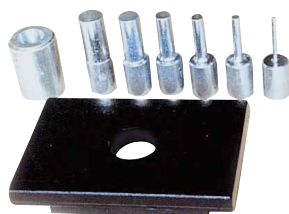


Dimensions

A - Height	1350 mm
B - Width without pump	690 mm
C - Depth	500 mm
D - Clear width	550 mm
E - Depth of hole frame	150 mm
F - Clear height	550 mm
G - Piston stroke	160 mm
H - Width with pump	900 mm



For processing flat materials, pressing in bearings, bolts and similar, please use the optional perforated plate for WPP 15 T, Art. no. 4104005.



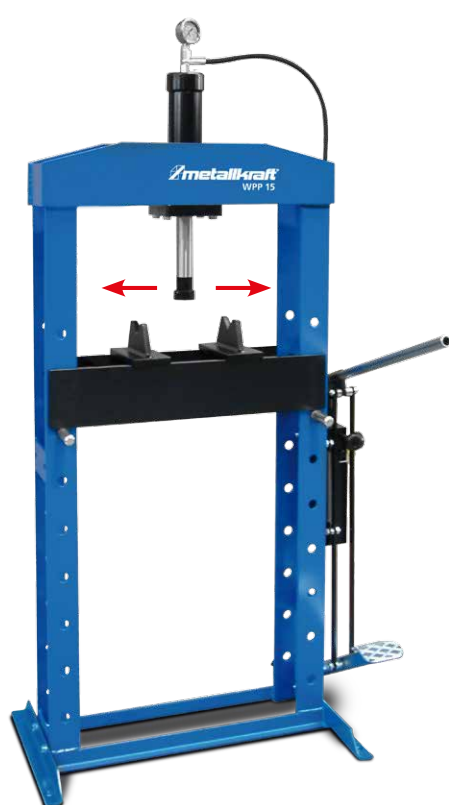
6-part punching mandrel set with perforated plate, Ø 29, 24, 18, 14, 10, 5 mm

Accessories	Art. no.
6-part punching mandrel set with perforated plate	4101115
Perforated plate	4104005

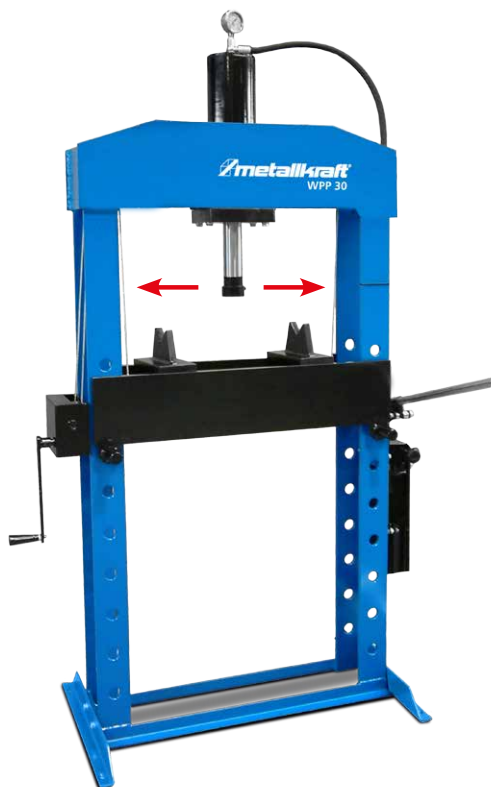
WPP - Hydraulic workshop presses with moving cylinder and hand pump



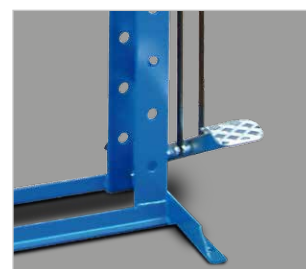
- ▶ For all repair and assembly work, e.g.: straightening axles, subframes, shafts, etc.; pressing bearings, bolts and bushings in and out; pressing and crimping work; load tests and weld sample testing, etc.
- ▶ Sturdy welded design
- ▶ Rugged frame with holes for adjusting the work table
- ▶ Reliable, high-precision hydraulics, made in Europe
- ▶ With chrome-plated cylinder pistons
- ▶ Pressing pressure can be read off on gauge
- ▶ With automatic piston return
- ▶ With safety valve for overload protection
- ▶ For processing flat materials, pressing in bearings, bolts and similar, please use the optional perforated plate



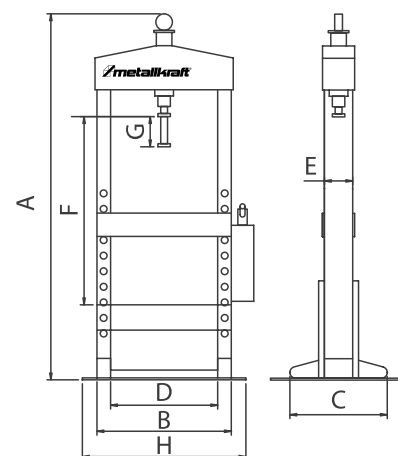
WPP 15
With optional foot pedal



WPP 30



Accessories retrofit set
Foot pedal for pump



Scope of supply

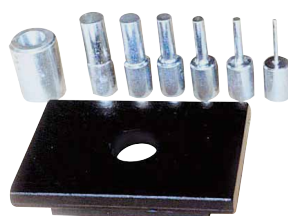
2-part prism set for insert-placing round materials

- ▶ Winch for lifting and lowering the table (for WPP 30)

Model	WPP 15	WPP 20	WPP 30
Art. no.	4001015	4001020	4001030
Technical specifications			
Output	15 t	20 t	30 t
max. load on prism jaw	3.5 t	5 t	7.5 t
Weight	120 kg	140 kg	230 kg

Dimensions in mm	WPP 15	WPP 20	WPP 30
A - Height	1890 mm	1900 mm	1980 mm
B - Width without pump	620 mm	770 mm	890 mm
C - Depth	600 mm	600 mm	600 mm
D - Clear width	500 mm	610 mm	710 mm
E - Depth of hole frame	150 mm	150 mm	150 mm
F - Clear height	1000 mm	1000 mm	1000 mm
G - Piston stroke	160 mm	160 mm	160 mm
H - Width with pump	900 mm	950 mm	1150 mm

! For processing flat materials, pressing in bearings, bolts and similar, please use the optional perforated plate



6-part punching mandrel set with perforated plate, Ø 29, 24, 18, 14, 10, 5 mm

Accessories	Art. no.
6-part punching mandrel set with perforated plate for WPP 15	4101115
for WPP 20	4101020
for WPP 30	4101030
Perforated plate for WPP 15 and WPP 20	4104005
Perforated plate for WPP 30	4104006
Retrofit set foot pedal for pump without assembly for WPP 15 and WPP 20	4101021

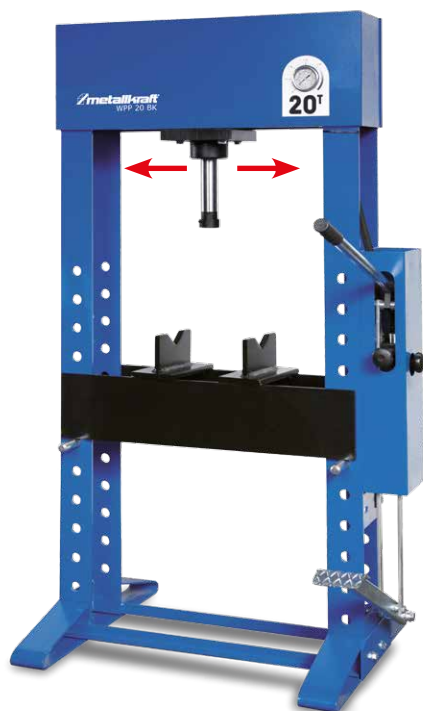
WPP BK – Hydraulic workshop presses with hand and foot pump moving cylinder



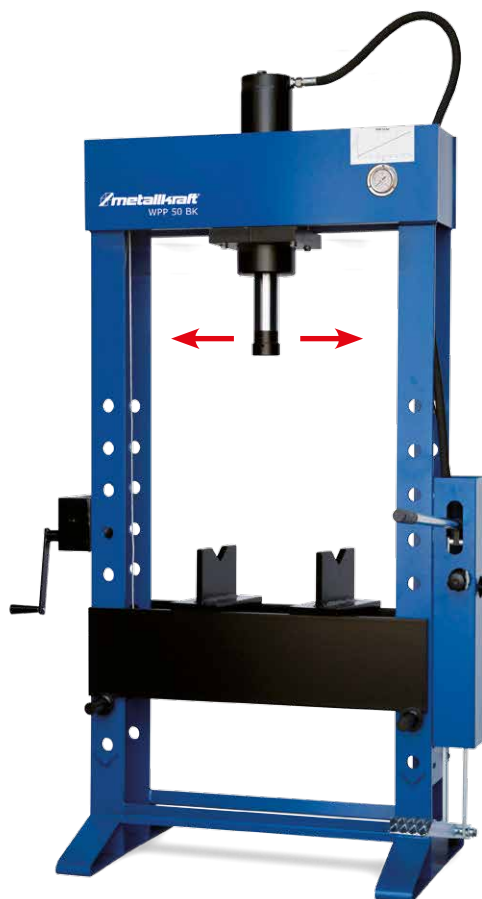
- ▶ For all repair and assembly work, e.g.: straightening axles, subframes, shafts, etc.; pressing bearings, bolts and bushings in and out; pressing and crimping work; load tests and weld sample testing, etc.
- ▶ Sturdy welded design

- ▶ Rugged frame with holes for adjusting the work table
- ▶ Reliable, high-precision hydraulics, made in Europe
- ▶ Pressure build up by actuating the hand or foot pump lever

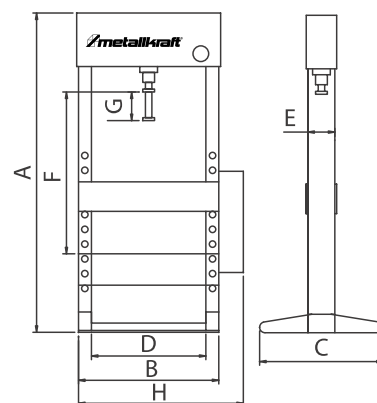
- ▶ Both hands free for fixing the workpiece thanks to foot pump
- ▶ Pressing pressure can be read off on gauge
- ▶ With automatic piston return
- ▶ With safety valve for overload protection



WPP 20 BK



WPP 50 BK



Scope of supply

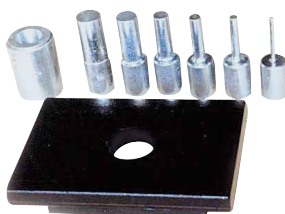
- ▶ 2-part prism set for insert-placing round materials
- ▶ Hand and foot lever
- ▶ Winch for lifting and lowering the table (for WPP 30 BK, WPP 50 BK)

Model	WPP 20 BK	WPP 30 BK	WPP 50 BK
Art. no.	4002020	4002030	4002050
Technical specifications			
Output	20 t	30 t	50 t
max. load on prism jaw	5 t	7.5 t	12.5 t
Weight	210 kg	280 kg	360 kg
Transport packaging flat rate*	TPFR 2 = €39.00	TPFR 5 = €100.00	TPFR 5 = €100.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



For processing flat materials, pressing in bearings, bolts and similar, please use the optional perforated plate

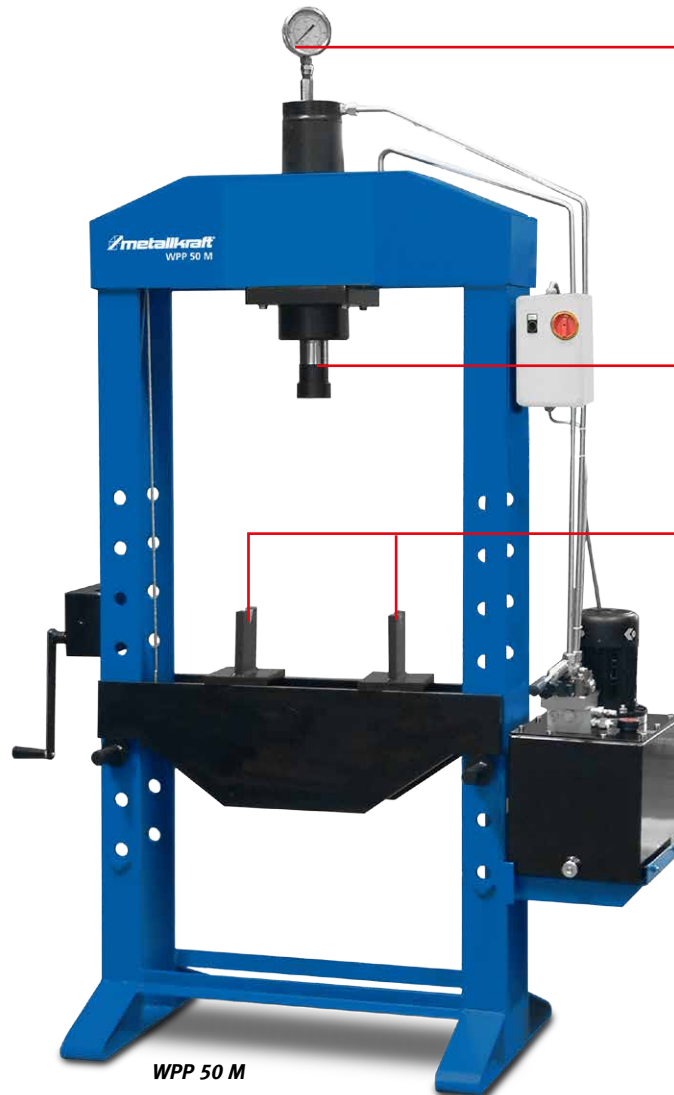


6-part punching mandrel set with perforated plate, Ø 29, 24, 18, 14, 10, 5 mm

Accessories	Art. no.
6-part punching mandrel set with perforated plate for WPP 20 BK	4102020
for WPP 30 BK	4102030
for WPP 50 BK	4102050
Perforated plate for WPP 20 BK	4104002
Perforated plate for WPP 30 BK	4104003
Perforated plate for WPP 50 BK	4104004

WPP 50 M – Hydraulic workshop press with electric pump and double-action cylinder

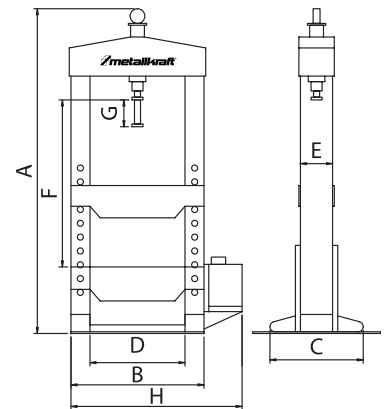
- ▶ For all repair and assembly work, e.g.: straightening axles, subframes, shafts, etc.; pressing bearings, bolts and bushings in and out; pressing and crimping work; load tests and weld sample testing, etc.
- ▶ Sturdy welded design
- ▶ Rugged frame with holes for height adjustment of the press table
- ▶ With automatic switch-over from accelerated
- ▶ idle speed to slower working speed of the cylinder
- ▶ Reliable, high-precision hydraulics, made in Europe
- ▶ With safety valve for overload protection



▶ Pressing pressure can be read off on gauge

▶ Equipped with double-action cylinder

- ▶ includes a 2-part prism set for insert-placing round materials
- ▶ For processing flat materials, pressing in bearings, bolts and similar, please use the optional perforated plate



- Scope of supply**
2-part prism set for insert-placing round materials
- ▶ Hand lever
 - ▶ Winch for lifting and lowering the table
 - ▶ Steel chain for table height adjustment

Model	WPP 50 M
Art. no.	4003050

Technical specifications	
Output	50 t
max. load on prism jaw	12.5 t
Slow feed	1.7 mm/sec.
Fast feed	20 mm/sec.
Motor output	1.5 kW
Mains connection 50 Hz	400 V
Weight	420 kg

Transport packaging flat rate* **TPFR 2 = €39.00**

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

Dimensions	WPP 50 M
A - Height	2290 mm
B - Width without pump	985 mm
C - Depth	650 mm
D - Clear width	790 mm
E - Depth of hole frame	210 mm
F - Clear height	1050 mm
G - Piston stroke	250 mm
H - Width with pump	1350 mm



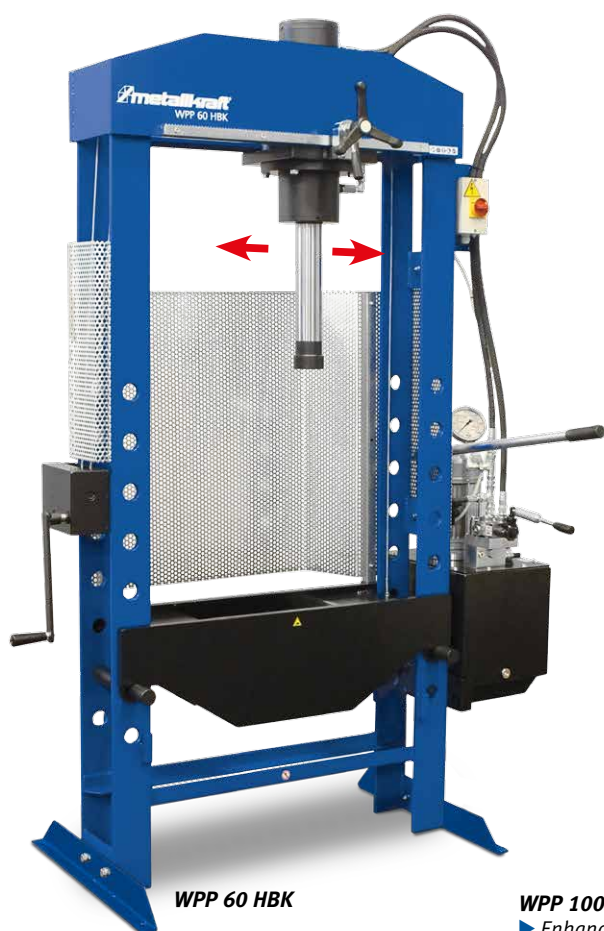
optional 6-part punching mandrel set Ø 29, 24, 18, 14, 10, 5 mm

Accessories	Art. no.
6-part punching mandrel set with	4102050
perforated plate for WPP 50 M	
Perforated plate for WPP 50 M	4104004

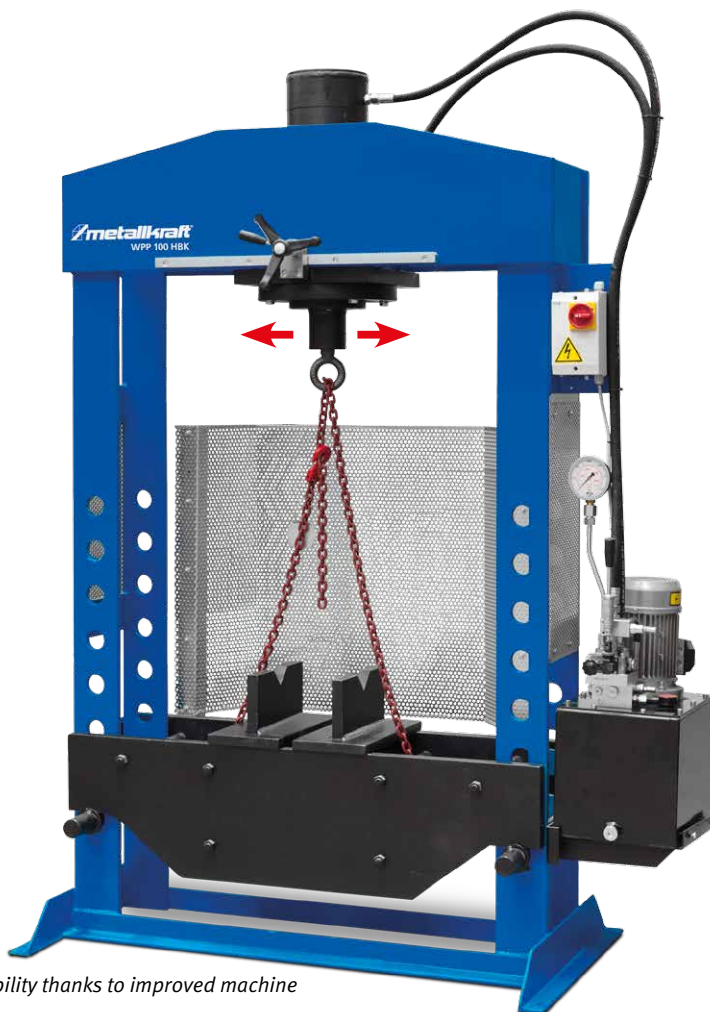
WPP HBK - Heavy, hydraulic workshop presses with moving piston and two piston feed speeds



- ▶ Equally suited to assembly and straightening work, workpiece testing, or pressing bearings and other components in or out
- ▶ Ideal for technical workshops, repair shops and technical training institutions
- ▶ With two piston feed speeds and pressure control via throttle screw
- ▶ Pressure gauge for pressure display
- ▶ Heavy, welded machine frame made of steel sections to absorb the incident press force of the cylinder
- ▶ The hydraulics work with great precision in both electric and manual mode
- ▶ Adjustment of the cylinder via rack on hand wheel
- ▶ Heavy-duty and durable welded designed
- ▶ Comprehensive range of accessories



WPP 60 HBK



WPP 100 HBK

- ▶ Enhanced stability thanks to improved machine foot design
- ▶ Cylinder adjustment via handle and hand wheel
- ▶ Pressure gauge on machine side

Model	WPP 60 HBK	WPP 100 HBK	WPP 100 HBK D 1500	WPP 160 HBK	WPP 160 HBK D 1500	WPP 200 HBK
Art. no.	4013060	4013100	4013101	4013160	4013161	4013200

Technical specifications						
Output	60 t	100 t	100 t	160 t	160 t	200 t
Press speed	1.5 mm/s	1.5 mm/s	1.5 mm/s	1.5 mm/s	1.5 mm/s	1.2 mm/s
Feed speed	10 mm/s	10 mm/s	10 mm/s	10 mm/s	10 mm/s	10 mm/s
Motor output	1.5 kW	1.5 kW	1.5 kW	1.5 kW	1.5 kW	4 kW
Power connection	400 V	400 V	400 V	400 V	400 V	400 V
Weight	480 kg	980 kg	1280 kg	1480 kg	1820 kg	2700 kg
Dimensions						
A - Height	2290 mm	2280 mm	2280 mm	2450 mm	2450 mm	2600 mm
B - Width without pump	990 mm	1290 mm	1790 mm	1320 mm	1820 mm	1900 mm
C - Width with pump	1350 mm	1600 mm	2100 mm	1950 mm	2450 mm	2450 mm
D - Depth	650 mm	850 mm	850 mm	1000 mm	1000 mm	1100 mm
E - Clear width	790 mm	1030 mm	1530 mm	1020 mm	1520 mm	1500 mm
F - Clear height	1000 mm	1000 mm	1000 mm	1020 mm	1020 mm	1000 mm
G - Depth of hole frame	180 mm	265 mm	265 mm	300 mm	300 mm	400 mm
H - Piston stroke	300 mm	320 mm	320 mm	400 mm	400 mm	400 mm
I - Cylinder traverse stroke	450 mm	600 mm	1000 mm	500 mm	950 mm	800 mm



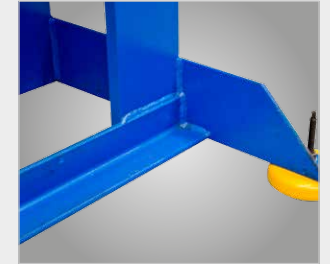
Quality
made in
Europe



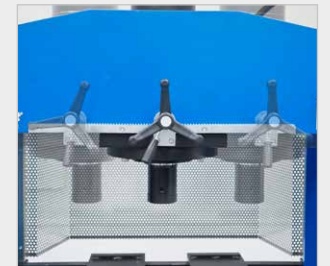
WPP 160 HBK



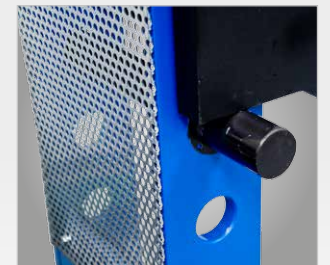
· Convenient and clear-cut operation of the hydraulic power unit



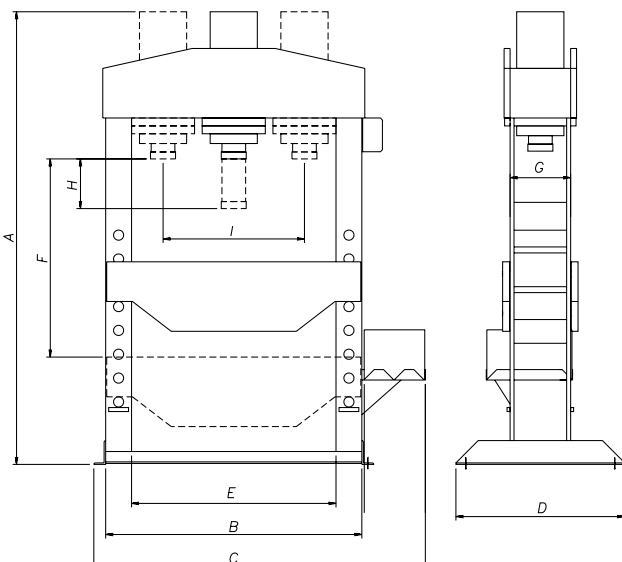
· Sturdy frame and flatter design at the same time



· Fast and easy adjustment of the cylinder via rack and hand wheel



· Easy table height adjustment thanks to hydraulic cylinder and fastening bolts



Accessories

	Art. no.
Prism block set* for WPP 60 HBK	4105060
Prism block set* for WPP 100 HBK	4105100
Prism block set* for WPP 160 HBK	4105160
Prism block set* for WPP 200 HBK	4100200

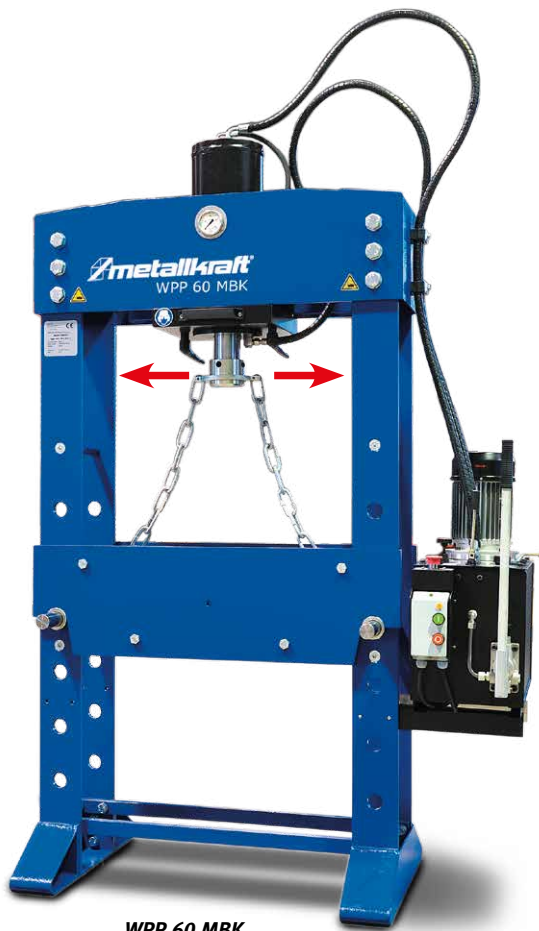


*** Set includes 2 prism blocks**

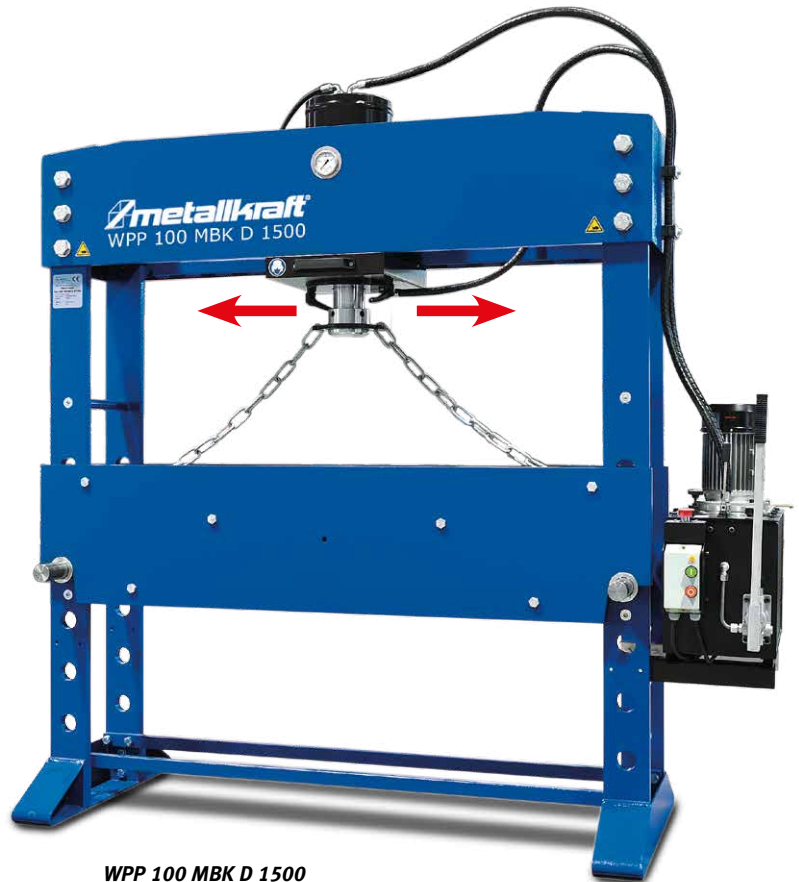
WPP 60 HBK loadable with 30 tonnes per block
WPP 100 HBK loadable with 50 tonnes per block
WPP 160 HBK loadable with 80 tonnes per block
WPP 200 HBK loadable with 100 tonnes per block

WPP MBK - Heavy, hydraulic workshop presses with moving cylinder and two piston feed speeds

- ▶ Equally suited to assembly and straightening work, workpiece testing, or pressing bearings and other components in or out
- ▶ Ideal for technical workshops, repair shops and technical training institutions
- ▶ Heavy, welded machine frame made of steel sections to absorb the incident press force of the cylinder
- ▶ With two piston feed speeds and pressure control
- ▶ The hydraulics work with great precision in both electric and manual mode
- ▶ Easy height adjustment of the heavy work table without using force thanks to hydraulic cylinder
- ▶ With motorised piston return
- ▶ Piston with removable base
- ▶ Pressure gauge integrated in frame
- ▶ **D 1500 models with large clearance width of 1500 mm**



WPP 60 MBK



WPP 100 MBK D 1500

Scope of supply

- ▶ Hand lever
- ▶ Steel chain for table height adjustment
- ▶ Support bolts

Technical specifications	WPP 60 MBK	WPP 100 MBK	WPP 100 MBK D 1500	WPP 160 MBK	WPP 160 MBK D 1500	WPP 200 MBK
Art. no.	4012060	4012100	4012101	4012160	4012161	4012200
Output	60 t	100 t	100 t	160 t	160 t	200 t
Press speed	2.1 mm/s	2.5 mm/s	2.5 mm/s	2.4 mm/s	2.4 mm/s	1.8 mm/s
Feed speed	8.7 mm/s	7.5 mm/s	7.5 mm/s	7.5 mm/s	7.5 mm/s	5.7 mm/s
Motor output	1.5 kW	2.2 kW	2.2 kW	3 kW	3 kW	3 kW
Power connection	400 V	400 V	400 V	400 V	400 V	400 V
Weight	540 kg	970 kg	1145 kg	1195 kg	1430 kg	1690 kg



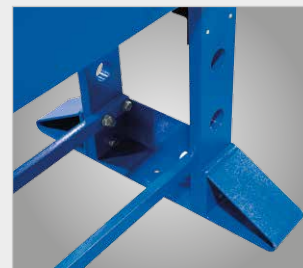
- Chain for table height adjustment attached to cylinder via sturdy flange



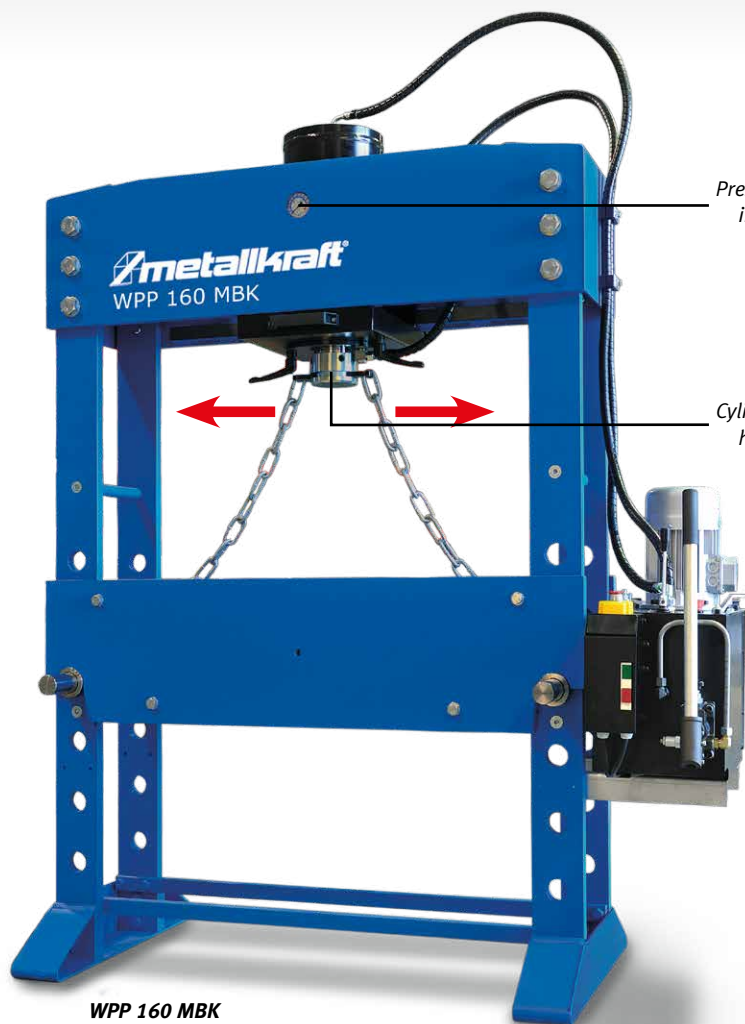
- Easy table height adjustment thanks to hydraulic cylinder and fastening bolts



- Convenient and clear-cut operation of the hydraulic power unit

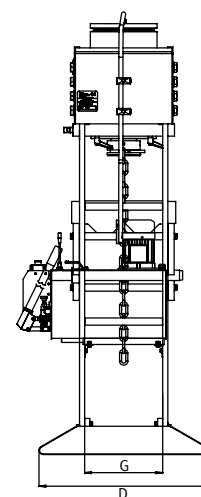
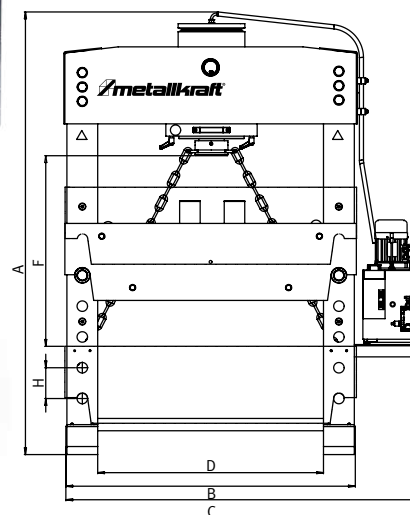


- Sturdy frame and flatter design at the same time



Pressure gauge integrated in frame

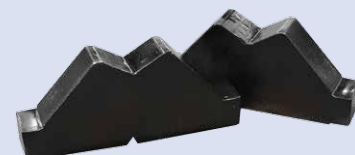
Cylinder adjustment via handle



Dimensions	WPP 60 MBK	WPP 100 MBK	WPP 100 MBK D 1500	WPP 160 MBK	WPP 160 MBK D 1500	WPP 200 MBK
A - Height	2120 mm	2140 mm	2140 mm	2200 mm	2270 mm	2270 mm
B - Width without pump	1000 mm	1350 mm	1750 mm	1410 mm	1810 mm	1610 mm
C - Width with pump	1315 mm	1665 mm	2065 mm	1725 mm	2125 mm	1925 mm
D - Depth	695 mm	755 mm	755 mm	825 mm	825 mm	865 mm
E - Clear width	750 mm	1100 mm	1500 mm	1100 mm	1500 mm	1300 mm
F - Clear height	750 mm	750 mm	750 mm	750 mm	750 mm	750 mm
G - Depth of hole frame	260 mm	300 mm	300 mm	380 mm	380 mm	410 mm
Piston stroke	400 mm	400 mm	400 mm	400 mm	400 mm	400 mm
H - Hole spacing	150 mm	150 mm	150 mm	150 mm	150 mm	150 mm

Accessories	Art. no.
Prism block set* for WPP 60 MBK	4100060
Prism block set* for WPP 100 MBK	4100100
Prism block set* for WPP 160 MBK	4100160

*** Set includes 2 prism blocks**
WPP 60 MBK loadable with 30 tonnes per block
WPP 100 MBK loadable with 50 tonnes per block
WPP 160 MBK loadable with 80 tonnes per block



RP U – universal frame presses

- ▶ Universally applicable frame press suitable for individual bending, pressing, embossing, calibrating or cutting tools
- ▶ Very heavy-duty and durable welded structure
- ▶ Reinforced top beam to safeguard the unit is in parallel
- ▶ Large support surface with T grooves and central bore
- ▶ Large ramming plate with T grooves
- ▶ Top and bottom end position of the piston stroke can be adjusted continuously using cams
- ▶ Pressure can be adjusted continuously
- ▶ Pressure gauge shows pressing pressure
- ▶ Height-adjustable worktop
- ▶ Device to adjust the table height
- ▶ Two-hand operation and foot pedal
- ▶ Hydraulic operation

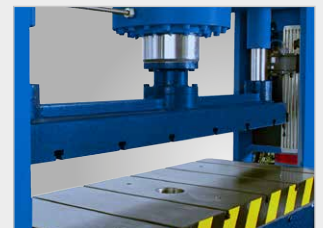
Can we help you?

Your local specialist retailer is more than happy to help you with any issues. We will also be more than happy to support you and provide you with a list of specialist retailers where you are; **contact:**
+49(0)951 96555-171
beratung@metallkraft.de



Fig. shows RP U 1520-150

Technical specifications	RP U 1020-100	RP U 1020-150	RP U 1520-100	RP U 1520-150
Art. no.	4021010	4021015	4021510	4021515
Technical specifications				
Press force	100 t	150 t	100 t	150 t
Working width	1020 mm	1020 mm	1520 mm	1520 mm
Piston stroke	300 mm	300 mm	300 mm	300 mm
Max Working Pressure	263 bar	244 bar	263 bar	244 bar
Min. installation height	325 mm	275 mm	325 mm	275 mm
Max. installation height	680 mm	610 mm	680 mm	610 mm
Hole distance for table adjustment	190 mm	190 mm	190 mm	190 mm
Rapid mode	9 mm/s	9 mm/s	9 mm/s	9 mm/s
Pressing mode	5 mm/s	5 mm/s	5 mm/s	5 mm/s
Retraction	10 mm/s	10 mm/s	10 mm/s	10 mm/s
Table size	500 x 1020 mm	600 x 1020 mm	500 x 1520 mm	600 x 1520 mm
Table bore Ø	100 mm	100 mm	100 mm	100 mm
Motor output	7.5 kW	11 kW	7.5 kW	11 kW
Length	2110 mm	2110 mm	2630 mm	2630 mm
Width	1000 mm	1000 mm	1000 mm	1000 mm
Height	2275 mm	2450 mm	2275 mm	2450 mm
Weight	1900 kg	2400 kg	2500 kg	3100 kg



RP A – frame press with unit to bend edges

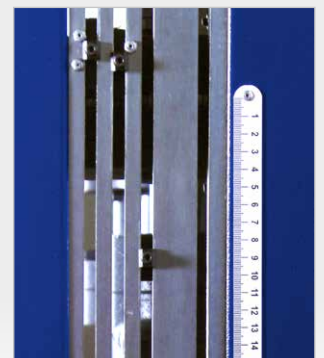
- ▶ Very heavy-duty and durable welded structure
- ▶ Reinforced top beam to safeguard the unit is in parallel
- ▶ Cranked tool at the top
- ▶ 5x die with V openings 10, 20, 30, 40 and 65mm (see page 161 for press force table)
- ▶ Top and bottom end position of the piston stroke can be adjusted continuously using cams
- ▶ Suitable to bend edges on very thick plates, bending long sheet metal panels and calibrating plates
- ▶ Pressure can be adjusted continuously
- ▶ Pressure gauge shows pressing pressure
- ▶ Height-adjustable worktop
- ▶ Two-hand operation and foot pedal
- ▶ Hydraulic operation



Fig. shows RP A 1520-150

Technical specifications	RP A 1020-100	RP A 1020-150	RP A 1520-100	RP A 1520-150
Art. no.	4021611	4021615	4021651	4021655

Technical specifications				
Press force	100 t	150 t	100 t	150 t
Working width	1020 mm	1020 mm	1520 mm	1520 mm
Piston stroke	300 mm	300 mm	300 mm	300 mm
Max Working Pressure	263 bar	244 bar	263 bar	244 bar
Min. installation height	325 mm	275 mm	325 mm	275 mm
Max. installation height	680 mm	610 mm	680 mm	610 mm
Hole distance for table adjustment	190 mm	190 mm	190 mm	190 mm
Rapid mode	9 mm/s	9 mm/s	9 mm/s	9 mm/s
Pressing mode	5 mm/s	5 mm/s	5 mm/s	5 mm/s
Retraction	10 mm/s	10 mm/s	10 mm/s	10 mm/s
Table size	500 x 1020 mm	600 x 1020 mm	500 x 1520 mm	600 x 1520 mm
Table bore Ø	100 mm	100 mm	100 mm	100 mm
Motor output	7.5 kW	11 kW	7.5 kW	11 kW
Length	2110 mm	2110 mm	2630 mm	2630 mm
Width	1000 mm	1000 mm	1000 mm	1000 mm
Height	2275 mm	2450 mm	2275 mm	2450 mm
Weight	1900 kg	2400 kg	2500 kg	3100 kg



HP C – hydraulic C rack presses

- ▶ C rack presses for universal use – bending, embossing, punching and pressing with individual tools
- ▶ Operated using a mobile, two-hand control panel
- ▶ Top beam reinforced four times
- ▶ Table and ram plate with T grooves to attach equipment and tools
- ▶ Continuously adjust the pressure
- ▶ Pressure gauge to read out the adjusted pressing force



Can we help you?

Your local specialist retailer is more than happy to help you with any issues. We will also be more than happy to support you and provide you with a list of specialist retailers where you are;
contact: +49(0)951 96555-171
beratung@metallkraft.de



Machines with higher speeds, larger tables and ram plates as well as deep die cushions on request

Fig. shows HP C 100

Technical specifications	HP C 30	HP C 60	HP C 100	HP C 150
Art. no.	4022030	4022060	4022100	4022150

Technical specifications				
Press force	30 t	60 t	100 t	150 t
Piston stroke	200 mm	250 mm	300 mm	300 mm
Rapid mode	54 mm/s	26 mm/s	17,5 mm/s	10 mm/s
Pressing mode	18 mm/s	8,5 mm/s	5,5 mm/s	3,5 mm/s
Return	90 mm/s	47 mm/s	37 mm/s	22 mm/s
Installation height	400 mm	450 mm	500 mm	500
Table size	450 x 700 mm	500 x 750 mm	700 x 1,100 mm	700 x 1,100 mm
Ram plate size	380 x 500 mm	430 x 500 mm	420 x 680 mm	500 x 750 mm
Hole Ø in the centre of the table	80 mm	100 mm	120 mm	120 mm
Motor output	7,5 kW	7,5 kW	7,5 kW	7,5 kW
Length	1,880 mm	1,820 mm	1,935 mm	2,300 mm
Width	850 mm	960 mm	1,300 mm	1,400 mm
Height	2,250 mm	2,400 mm	2,750 mm	2,750 mm
Weight	3,400 kg	4,000 kg	5,400 kg	7,700 kg
Transport packaging flat rate*	TPFR 6 = €200.00	TPFR 6 = €200.00	TPFR 6 = €200.00	TPFR 6 = €200.00

Scope of supply
Mobile control panel
 · Hydraulic operation

Model range overview. Metal-cutting circular saws and metal-cutting band saws

- ▶ The following pages provide an overview of all Metallkraft circular saws, band saws, and horizontal band saws.
- ▶ Based on the coloured marking, you can see at a glance if the saw is manual, semi-automatic or automatic.

Explanation of the colour scheme:

Manual

Semi-automatic

Automatic

Metallkraft saw bands

▶ You will find an overview of our saw bands on page 280 of this catalogue. This is also where you will find information on the fundamental dos and don'ts of sawing.

▶ Of course, you will always find the matching saw bands on offer along with the individual machines.

▶ We are always happy to perform sample cutting for your special material.

▶ Call us for details!

Important information:

▶ Please note the instructions prefixed with these exclamation marks; they point to in-depth information.



Roller conveyors and accessories

▶ Naturally, we also offer a large range of roller conveyors and accessories for our saws.

▶ You will find them in the catalogue right next to the individual machines.

▶ We are always happy to give you advice on the right configuration for your task.

HKS 230



Clamping range MKS 230

	○	□	□
90°	-	82	-
45°	-	56	-
60° +	-	-	-

MTS 356



Clamping range MTS 356

	○	□	□
0°	132	120 x 120	100 x 180
39°, left	105	90 x 90	120 x 90
45°, right	105	90 x 90	120 x 90

MKS 250 N



Clamping range MKS 250 N

	●	○	□	□
90°	40	70	70 x 70	55 x 95
45°	35	65	55 x 55	50 x 60
45° +	35	65	55 x 55	50 x 60

MKS 255 N



Clamping range MKS 255 N

	●	○	□	□
90°	40	70	70 x 70	55 x 95
45°	35	65	55 x 55	50 x 60
45° +	35	65	55 x 55	50 x 60

MKS 275 N



Clamping range MKS 275 N

	●	○	□	□
90°	45	80	80 x 80	100 x 70
45°	40	80	70 x 70	80 x 70
45° +	40	80	70 x 70	80 x 70

MKS 315 N



Clamping range MKS 315 N

	●	○	□	□
90°	55	90	80 x 80	115 x 70
45°	50	80	70 x 70	70 x 70
45° +	50	80	70 x 70	70 x 70

MKS 315 R / 316 R



Clamping range MKS 315 R / 316 R

	●	○	□	▭
90°	55	90	80 x 80	115 x 70
45°	50	80	70 x 70	70 x 70
45° +	50	80	70 x 70	70 x 70

MKS 350 / MKS 351



Clamping range MKS 350

	●	○	□	▭
90°	60	110	100 x 100	120 x 80
45°	55	80	80 x 80	80 x 80
45° +	55	80	80 x 80	80 x 80

MKS 350 H



Clamping range MKS 350 H

	●	○	□	▭
90°	60	110	100 x 100	120 x 80
45°	55	80	80 x 80	80 x 80
45° +	55	80	80 x 80	80 x 80

MKS 315 V / MKS 316 V



Clamping range MKS 315 V

	●	○	□	▭
90°	70	100	90 x 90	135 x 80
45°	70	100	90 x 90	100 x 80
45° +	70	100	90 x 90	100 x 80
60° +	70	80	70 x 70	70 x 80

MKS 350 V



Clamping range MKS 350 V

	●	○	□	▭
90°	100	100	90 x 90	170 x 90
45°	100	100	90 x 90	125 x 90
45° +	100	100	90 x 90	125 x 90
60° +	90	90	90 x 90	90 x 90

MKS 315 VH



Clamping range MKS 315 VH

	●	○	□	▭
90°	70	100	90 x 90	135 x 80
45°	70	100	90 x 90	100 x 80
45° +	70	100	90 x 90	100 x 80
60° +	70	80	70 x 70	70 x 80

MKS 350 VH



Clamping range MKS 350 VH

	●	○	□	▭
90°	100	100	90 x 90	170 x 90
45°	100	100	90 x 90	125 x 90
45° +	100	100	90 x 90	125 x 90
60° +	90	90	90 x 90	90 x 90

LMS 400 H



Clamping range LMS 400 H

	●	○	□	▭
90°	60	140	110 x 110	180 x 100
45°	60	120	100 x 100	150 x 100
45° +	60	120	100 x 100	150 x 100

LMS 400 P



Clamping range LMS 400 P

	●	○	□	▭
90°	60	140	110 x 110	180 x 100
45°	60	120	100 x 100	150 x 100
45° +	60	120	100 x 100	150 x 100

MKS 315 R / 316 R



Clamping range LMS 400 A

	●	○	□	▭
90°	60	130	110 x 110	180 x 100
45°	-	-	-	-
45° +	-	-	-	-

MBS



Clamping range MBS 105

	○	□	▭
90°	105	101	101 x 105
45°	70	70	70 x 70
45° +	-	-	-



Clamping range MBS 125

	○	□	▭
90°	125	125	130 x 125
45°	80	80	80 x 80
45° +	50	50	50 x 50



Clamping range MBS 150 / MBS 155 K

	○	□	▭
90°	150	140	150 x 140
45°	100	90	100 x 90
45° +	70	65	65 x 70

BMBS 220 x 250 H-G



Clamping range BMBS 220 x 250 H-G

mm	□ 0°	▭ 45°	▭ 60°	▭ ^b _{a x b}
○	220	160	90	X
●	120 *	85 *	55 *	X
▭	230 x 190	160 x 90	90 x 90	230 x 120

* recommended values

BMBS 230 x 280 H-DG



Clamping range BMBS 230 x 280 H-DG

mm	□ 0°	▭ 45°	▭ 60°	▭ ^b _{a x b}
○	220	160	90	X
●	120 *	85 *	55 *	X
▭	230 x 190	160 x 90	90 x 90	230 x 120

* recommended values

BMBS 230 x 280 H-DG



Clamping range BMBS 230 x 280 H-DG

mm	□ 0°	▭ 45°	▭ 60°	▭ 45°	▭ ^b _{a x b}
○	230	190	125	185	X
●	150 *	110 *	80 *	110 *	X
▭	280 x 180	180 x 170	120 x 110	180 x 120	120 x 180

* recommended values

BMBS 240 x 280 CNC-G



Clamping range BMBS 240 x 280 CNC-G

mm	□ 0°	▭ 45°	▭ 60°	▭ ^b _{a x b}
○	240	190	120	X
●	150 *	110 *	80 *	X
▭	280 x 220	190 x 170	120 x 150	280 x 120

* recommended values









BMBS 250 x 315 H-DG



BMBS 250 x 315 HA-DG



Clamping range BMBS 250 x 315 H-DG / 250 x 315 HA-DG









mm					
	250	190	120	170	-
	150*	110*	80*	110*	-
	290 x 200	190 x 140	120 x 140	200 x 70	200 x 120

* recommended values

BMBS 300 x 320 H-DG



Clamping range BMBS 300 x 320 H-DG









mm					
	300	300	200	280	-
	180*	110*	80*	110*	-
	320 x 300	305 x 250	200 x 200	260 x 200	230 x 160

* recommended values

BMBS 300 x 320 HA-DG



Clamping range BMBS 300 x 320 HA-DG








mm					
	300	300	200	240	X
	180 *	110 *	80 *	110 *	X
	320 x 300	300 x 250	200 x 200	260 x 200	230 x 120

* recommended values

BMBS 300 x 320 CNC-G



Clamping range BMBS 300 x 320 CNC-G









mm				
	300	300	200	X
	180 *	110 *	80 *	X
	320 x 300	300 x 250	200 x 200	230 x 120

* recommended values

BMBS 300 x 320 CNC-DG X 1500



Clamping range BMBS 300 x 320 CNC-DG X 1500








mm					
	300	300	200	240	X
	180 *	110 *	80 *	150 *	X
	320 x 300	300 x 250	200 x 200	260 x 200	260 x 200

* recommended values

BMBS 350 x 400 CNC-DG



Clamping range BMBS 350 x 400 CNC-DG

mm				
	350	320	320	X
	250 *	180 *	180 *	X
	400 x 350	330 x 120	330 x 120	400 x 210

* recommended values





BMBS 360 x 500 H-DG



BMBS 360 x 500 HA-DG



Clamping range BMBS 360 x 500 H-DG / BMBS 360 x 500 HA-DG





mm	0°	45°	60°	45°	60°	 b
	360	350	270	360	310	X
	250 *	180 *	130 *	180 *	130 *	X
	500 x 360	400 x 180	270 x 320	400 x 190	310 x 170	500 x 220

* recommended values

BMBS 460 x 600 HA-DG



Clamping range BMBS 460 x 600 HA-DG





mm	0°	45°	60°	45°	60°	 b
	460	460	320	460	320	X
	4000 *	280 *	200 *	280 *	190 *	X
	600 x 460	490 x 200	340 x 160	470 x 220	320 x 220	610 x 250

* recommended values

HMBS 440 x 600 HA-DG



Clamping range HMBS 440 x 600 HA-DG





mm	0°	45°	60°	45°	60°	 b
	470	475	330	475	305	x
	250*	180*	130*	180*	130*	x
	610 x 410	490 x 415	320 x 410	495 x 415	305 x 425	610 x 255

* recommended values

HMBS 440 x 600 NC-DG X 2000



Clamping range HMBS 440 x 600 NC-DG X 2000

mm	0°	45°	60°	45°	60°	 b
	470	470	330	470	305	x
	250*	180*	130*	180*	130*	x
	610 x 410	490 x 415	320 x 410	495 x 415	305 x 425	610 x 255





* recommended values

HMBS 500 x 750 HA-DG



HMBS 500 x 750 HA-DG X

Clamping range HMBS 500 x 750 HA-DG (X)





mm	0°	45°	60°	45°	60°	 b
	500	500	330	500	300	X
	400 *	280 *	200 *	280 *	190 *	X
	750 x 480	500 x 480	330 x 480	500 x 480	300 x 480	750 x 260

* recommended values

HMBS 500 x 750 NC-DG X 2000



Clamping range HMBS 500 x 750 NC-DG X 2000










mm	0°	45°	60°	45°	60°	 b
	500	500	330	500	300	X
	400 *	280 *	200 *	280 *	190 *	X
	750 x 480	500 x 480	330 x 480	500 x 480	300 x 480	750 x 260

* recommended values

HMBS 600 x 1100 HA-DG X



Clamping range HMBS 600 x 1100 HA-DG (X)






mm	 0°	 45°	 60°	 45°	 60°	 a x b
	620	620	500	650	490	X
	550 *	400 *	300 *	400 *	300 *	X
	1100 x 600	750 x 600	500 x 600	740 x 600	470 x 600	1100 x 400 700 x 400*

* recommended values

HMBS 300 x 300 CNC X



Clamping range HMBS 300 x 300






mm	 0°	 a x b
	300	X
	250 *	X
	300 x 300	300 x 220

* recommended values

HMBS 400 HA



Clamping range HMBS 400 HA






mm	 0°	 a x b
	410	X
	250 *	X
	400 x 400	400 x 340

* recommended values

HMBS 400 CNC



Clamping range HMBS 400 CNC






mm	 0°	 a x b
	410	X
	250 *	X
	400 x 400	400 x 340

* recommended values

HMBS 400 x 400 HA X



Clamping range HMBS 400 x 400






mm	 0°	 a x b
	400	X
	400 *	X
	400 x 400	400 x 250

* recommended values

HMBS 400 x 400 CNC X



Clamping range HMBS 400 x 400





mm	 0°	 a x b
	400	X
	400 *	X
	400 x 400	400 x 250

* recommended values

HMBS 510 x 510 HA X



Clamping range HMBS 510 x 510 HA X





mm	0°	
	510	X
	510 *	X
	510 x 530	500 x 450

* recommended values

HMBS 510 x 510 CNC X



Clamping range 510 x 510 CNC X





mm	0°	
	510	X
	510 *	X
	510 x 530	500 x 450

* recommended values

HMBS 550 x 1300 X



Clamping range





mm	0°	
	650	X
	510 *	X
	1300 x 550	1300 x 450

* recommended values

HMBS 600 HA X



Clamping range

mm	0°	
	600	X
	400 *	X
	600 x 510	600 x 415

* recommended values





HMBS 600 CNC X 2000/6000



HMBS 700 x 750 HA X



Clamping range HMBS 700 x 750 HA X





mm	0°	
	700	x
	700 *	x
	750 x 700	750 x 450

* recommended values

HMBS 700 x 750 CNC X



Clamping range HMBS 700 x 750 CNC X






mm	0°	
	700	x
	700 *	x
	750 x 700	750 x 450

* recommended values

HMBS 850 x 1000 HA X



Clamping range

mm		
	850	x
	850 *	x
	1000 x 850	1000 x 610






* recommended values

HMBS 850 x 1000 CNC X

HMBS 850 x 1000 HA X-VS



Clamping range

mm		
	850	x
	850	x
	850 x 850	850 x 610

* recommended values






HMBS 1000 HA X



HMBS 1000 CNC X 4000








Clamping range

mm	
	1000
	550 *
	1000 x 960
	1000 x 650

* recommended values

Clamping range

mm	
	1000
	550 *
	1000 x 960
	1000 x 650





* recommended values

HMBS 1200 x 1400 HA X



HMBS 1200 x 1400 CNC X

Clamping range

mm	
	1200
	1200 *
	1200 x 1400





* recommended values

HVMB 850 x 1000 Xtreme





HVMB 1250 x 1600 Portal

HVMB 1200 x 1600 Xtreme





Clamping range

mm	
	850
	1000 x 850
	2000 x 850

Clamping range

mm	
	1200
	1600 x 1200
	1600 x 3000

Clamping range

mm	
	1250
	1600 x 1250
	1600 x ...



VMBS



VMBS	1408	1610	1610 E	2012 E	2012HE	2613	2613E	3612	3612E
Reach	356 mm	396 mm	396 mm	508 mm	508 mm	658 mm	658 mm	915 mm	915 mm
max. cutting height	205 mm	255 mm	255 mm	305 mm	305 mm	330 mm	330 mm	305 mm	305 mm

Circular saws



Important notice

We exclusively use steam-treated saw blades (HSS DM 05).

What does steam treatment achieve? Steaming at 500°C achieves controlled oxidation. A ferric oxide layer (Fe_3O_2) is created on the surface of the saw blades, thus improving the sliding quality while at the same time protecting against corrosion. Additionally, internal stresses in the blade are eliminated, thus reducing the risk of breakage and significantly improving the service life. This is why you should always order saw blades by METALLKRAFT.

HKS 230 – Metal hand-held circular saw for workshops and building sites when cutting aluminium, steel and stainless steel

- ▶ The ideal machine for assembly shops, facade builders, locksmiths, repair workshops, trade fair constructors etc.
- ▶ Ideal for applications where angle grinders are not strong enough or cannot work cleanly
- ▶ Cuts stainless steel without burrs
- ▶ Cuttings conduct the heat away, hence only low heat formation during cutting
- ▶ Highly resilient motor with soft start and overload protection
- ▶ Immersion in the material possible
- ▶ Uncomplicated and rapid cutting depth setting based on a precise and easy-to-read scale
- ▶ Stable and robust structure
- ▶ Handle can be screwed in at two different positions for convenient handling of the saw in any position
- ▶ Easy to use



- Uncomplicated and rapid cutting depth setting based on a precise and easy-to-read scale



- Rapid saw blade change by gear locking pin



- With twofold guided parallel limit stop for exact cut guidance



- Continuously adjustable and convenient setting of the mitre angle; grid division at 0°, 15°, 30° and 45°



- Handle can be converted so that the saw can be safely guided parallel to the cutting plane

Model	HKS 230 *
Art. no.	3840231

Technical specifications	
Motor output 230 V / 50 Hz	1.7 kW
Speeds	2200 rpm
Cutting range 90° □ / Wall thickness	80 mm
Cutting range 45° □ / Wall thickness	56 mm
Max. saw blade diameter	Ø 230 mm
Saw blade bore	Ø 25.4 mm
Saw blade thickness	2 mm
Dimensions (LxWxH)	620 x 320 x 270 mm
Weight	7.1 kg

* Machine is supplied in sturdy plastic case without saw blade

Saw blades specially designed for the machines and the specific applications:



Steel



Aluminium



Stainless steel

Saw blades Ø 230 x 25.4 mm	Blade thickness	Number of teeth	Art. no.
Steel	2.0 mm	48	3850231
Aluminium	2.4 mm	80	3850232
Stainless steel	1.8 mm	60	3850233

MTS 356 - Metal dry cutting, sawing metal without coolant

- ▶ Extremely stable and robust structure
- ▶ Easy to transport
- ▶ For virtually burr-free sawing of sections and pipes made of steel, iron, copper, brass, aluminium, plastics, composite materials and stainless steel, without needing a coolant
- ▶ For use in metalworking, carpentry, interior fitting, etc.
- ▶ Soft-start motor for easier handling on switching on the saw
- ▶ Includes prism clamping jaws for clamping pipes as standard equipment
- ▶ Easily adjustable clamps
- ▶ Stable thanks to die-cast aluminium feet
- ▶ Angle for mitre cuts
- ▶ right 45°, left 39°
- ▶ With length stop for precise cutting
- ▶ With spindle lock for easy saw blade replacement



*Chassis
foldable
Art no. 3630000*

Scope of supply

- 4, 6 and 8 mm Allen key
- Protective goggles
- 1 Prism clamping jaw
- Without saw blade

Model		MTS 356
Art. no.		3840355

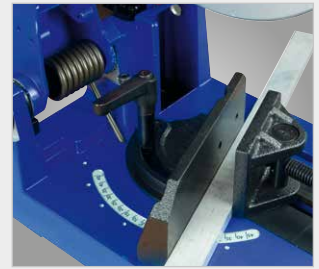
Technical specifications		
Motor output 230 V / 50 Hz		2.2 kW
Speeds		1300 rpm
Cutting range 0°	<input type="checkbox"/>	100 x 180 mm (H x W)
Cutting range 0°	<input type="checkbox"/>	120 x 120 mm
Cutting range 0°	<input type="checkbox"/>	132 mm
Cutting range right 45°, left 39°	<input type="checkbox"/>	120 x 90 mm (H x W)
Cutting range right 45°, left 39°	<input type="checkbox"/>	90 x 90 mm
Cutting range right 45°, left 39°	<input type="checkbox"/>	105 mm
Saw blade diameter		Ø 355 mm
Weight		23.5 kg



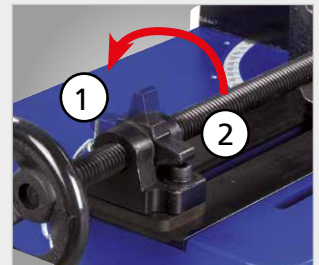
*Prism clamping jaw
1 piece included in
scope of supply*



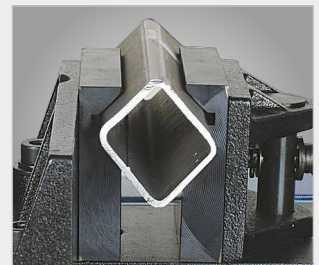
Accessories	Number of teeth	Art. no.
Chassis MTS 356		3630000
Prism clamping jaw		3850355
Saw blades Ø 355 x 2.4 x 25.4 mm		
Steel	80	3853504
Aluminium	80	3853502
Stainless steel	90	3853503
Saw blades Ø 305 x 2.4 x 25.4 mm		
Steel	60	3853051



- Mitre angle easy to read off the scale
- Vice continuously adjustable swivel from right 45°, left 39°
- Easily adjustable clamps



- Saw equipped with quick-release vice, by changing over the toggle lever between the quick-release (Pos. 1) and clamping (Pos. 2)



- Prism vice for pipes
- (second prism jaws optional, art. no. 3850355)

Manual metal-cutting circular saws with one and two speeds, and swivelling saw head and vice for mitre cuts

- ▶ For steel
- ▶ two cutting speeds
- ▶ Reduction gear, runs in oil bath for low noise
- ▶ automatic diaphragm coolant pump with coolant filter as standard
- ▶ moving guard ensures optimum safety while cutting
- ▶ Control handle with safety switch

- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch and overload protection
- ▶ machine head swivels through 45° anti-clockwise

- ▶ **Equipment as of MKS 250 N:**
- ▶ As of MKS 250 swivelling machine head 45° anti-clockwise and 45° clockwise
- ▶ Vice swivels through 45° anti-clockwise and 45° clockwise
- ▶ Quick release vice with double clamping device guarantees precise and virtually burr-free cutting



MKS 250 N
Standard scope of supply



MKS 255 N

- ▶ Double vice, swivelling from -45° to +45° with quick release

Scope of supply:

- ▶ Coolant system
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ Without saw blade
- ▶ without chassis

Model	MKS 250 N	MKS 255 N	MKS 275 N
Art. no.	3620251	3620253	3620275
Technical specifications			
Motor output 50 Hz	0.9 kW / 230 V	0.95/1.32 kW / 400 V	1.1/1.5 kW / 400 V
Speeds	40 rpm	40/80 rpm	40/80 rpm
Vice jaw width	100 mm	100 mm	105 mm
Saw blade diameter	Ø 250 mm	Ø 250 mm	Ø 275 mm
Run-in height incl. chassis	970 mm	970 mm	970 mm
Dimensions (L x W x H) in mm	800 x 830 x 755	800 x 830 x 755	830 x 900 x 1025
Weight	83 kg	83 kg	98 kg

Cutting capacity MKS 250 N / MKS 255 N

	●	○	□	▭
90°	40	70	70 x 70	55 x 95
45°	35	65	55 x 55	50 x 60
45° +	35	65	55 x 55	50 x 60

Cutting capacity MKS 275 N

	●	○	□	▭
90°	45	65	65 x 65	85 x 60
45°	40	60	40 x 40	40 x 60
45° +	40	60	40 x 40	40 x 60

Cutting capacity MKS 275 N optionally with saw blade 315 N

	●	○	□	▭
90°	45	80	80 x 80	100 x 70
45°	40	80	70 x 70	80 x 70
45° +	40	80	70 x 70	80 x 70



• Quick release vice swivelling through 45° anti-clockwise and 45° clockwise

MKS 275 N

Scope of supply:

- ▶ Coolant system
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ Without saw blade
- ▶ without chassis

Micro-dosing unit standard equipment
Universally deployable for minimal lubrication of
tool blades and forming tools. Separate air and
spraying agent lines avoid dripping

- ▶ With extra large lubricant tank,
frequency-controlled pump and spray head

Micro-dosing unit MD 11

- ▶ For circular saws and band saws

Micro-dosing unit MD 12, special features

- ▶ Filter pressure regulator with water separator
- ▶ Robust sheet steel housing
- ▶ Coaxial hose with flexible steel jacket



MD 11



MD 12

Accessories

	Art. no.
Machine chassis MKS 250 N/255 N/275 N	3642571
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000

Saw blades MKS 250/255 N

HSS saw blade DM05 Ø250x2x32 mm t4 ¹⁾	3652504
HSS Sägeblatt DM05 Ø250x2x32 mm t6 ¹⁾	3652506

Saw blades MKS 275 N

HSS saw blade DM05 Ø275x2.5x32 mm t4 ¹⁾	3652754
HSS saw blade DM05 Ø275x2.5x32 mm t6 ¹⁾	3652756
HSS saw blade DM05 Ø275x2.5x32 mm t8 ¹⁾	3652758

¹⁾t = tooth spacing ²⁾Price without installation on the saw



Chipmag swarf remover

• magnetic Art. no. 3850010

Manual metal-cutting circular saws with 315 mm saw blade, one and two speeds, and swivelling saw head and vice for mitre cuts



- ▶ Two cutting speeds
- ▶ swivelling machine head by 45° anti-clockwise and 45° clockwise
- ▶ Reduction gear running in oil bath
- ▶ automatic diaphragm coolant pump with coolant filter as standard
- ▶ Quick release vice with burr-prevention unit, swivelling through 45° anti-clockwise and 45° clockwise

- ▶ Vice longitudinally displaceable, and thus suitable for longitudinal cutting and slotting
- ▶ moving guard ensures optimum safety while cutting
- ▶ Control handle with safety switch
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch and overload protection

Equipment MKS 315 R / MKS 316 R

- ▶ with adjustable slip clutch, thus ruling out breaking of the saw blade
- ▶ **MKS 316 R low-speed, and thus perfect for working with stainless steel**



Quick release vice swivelling through 45° anti-clockwise and 45° clockwise



MKS 315 N

Scope of supply:

- ▶ Coolant system
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ Without saw blade
- ▶ without chassis



MKS 315 R / MKS 316 R

Scope of supply

- ▶ Coolant system with filter
- ▶ Material support arm with roller
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ Without saw blade
- ▶ without chassis

Model	MKS 315 N	MKS 315 R	MKS 316 R
Art. no.	3620303	3621315	3621316
Technical specifications			
Motor output 50 Hz/400 V	1.5-2.2 kW	1.5-2.2 kW	1.32-1.91 kW
Speeds	40/80 rpm	40/80 rpm	20/40 rpm
Vice jaw width	120 mm	120 mm	120 mm
Saw blade diameter	Ø 315 mm	Ø 315 mm	Ø 315 mm
Run-in height incl. chassis	1015 mm	1015 mm	1015 mm
Length	1000 mm	1000 mm	1000 mm
Width	1150 mm	1150 mm	1150 mm
Height	1475 mm	1475 mm	1475 mm
Weight	165 kg	170 kg	170 kg

Cutting capacity MKS 315 N

	●	○	□	▭
90°	55	90	80 x 80	115 x 70
45°	50	80	70 x 70	70 x 70
45° +	50	80	70 x 70	70 x 70

Cutting capacity MKS 315 R / 316 R

	●	○	□	▭
90°	65	90	85 x 85	120 x 70
45°	60	80	70 x 70	80 x 70
45° +	60	80	70 x 70	80 x 70

Accessories

Accessories	Art. no.
Machine chassis	3643171
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020
Micro-dosing unit assembly	9002000

Saw blades MKS 315 N/315 R/316 R

HSS saw blade DM05 Ø315x2.5x32 mm t4 ¹⁾	3653154
HSS saw blade DM05 Ø315x2.5x32 mm t6 ¹⁾	3653156
HSS saw blade DM05 Ø315x2.5x32 mm t8 ¹⁾	3653158

Saw blades for stainless steel MKS 315 R

HSS-E saw blade Ø315x2.5x32 mm t4 ¹⁾	3653254
HSS-E saw blade Ø315x2.5x32 mm t6 ¹⁾	3653256

¹⁾ t = tooth spacing



Chipmag swarf remover magnetic Art. no. 3850010

MKS 350 - manual metal-cutting circular saw with 350 mm saw blade

MKS 350 H - semi-automatic version



- ▶ Stable and robust structure
- ▶ two cutting speeds standard
- ▶ machine head swivels through 45° anti-clockwise and 90° clockwise
- ▶ Reduction gear running in oil bath
- ▶ includes diaphragm coolant pump with filter
- ▶ double vice with counter vice and burr-prevention jaws guarantees precise and burr-free cutting
- ▶ Vice longitudinally displaceable, and thus suitable for longitudinal cutting and slotting
- ▶ Quick release vice swivelling through 45° anti-clockwise and 45° clockwise

- ▶ adjustable blade protection clutch
- ▶ moving guard ensures optimum safety while cutting
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch and overload protection
- ▶ Control handle with safety switch
- ▶ **MKS 351 R low-speed, and thus perfect for working with stainless steel**

Semi-automatic mode MKS 350 H

- ▶ Motor is activated and vice closes
- ▶ Saw head lowered for cutting
- ▶ Saw head returns to original position and motor stops
- ▶ Vice opens



Quick release vice swivelling through 45° anti-clockwise and 45° clockwise



MKS 350 / MKS 351

Scope of supply:

- ▶ Coolant system
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ Without saw blade
- ▶ without chassis



MKS 350 H

Scope of supply:

- ▶ Coolant system
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ Without saw blade
- ▶ incl. chassis

Model	MKS 350	MKS 351	MKS 350 H
Art. no.	3621350	3621351	3620352
Technical specifications			
Motor output 400 V / 50 Hz	1.8-2.4 kW	1.5-2.2 kW	1.8-2.4 kW
Speeds	40/80 rpm	20/40 rpm	40/80 rpm
Vice jaw width	120 mm	120 mm	120 mm
Saw blade diameter	Ø 350 mm	Ø 350 mm	Ø 350 mm
Run-in height incl. chassis	1025 mm	1025 mm	1040 mm
Length	1000 mm	1000 mm	1000 mm
Width	1200 mm	1200 mm	1200 mm
Height	1475 mm	1475 mm	1475 mm
Weight	210 kg	210 kg	280 kg

Cutting capacity MKS 350 / MKS 351 / MKS 350 H

	●	○	□	▭
90°	60	110	100 x 100	120 x 80
45°	55	80	80 x 80	80 x 80
45° +	55	80	80 x 80	80 x 80

Accessories	Art. no.
Machine chassis MKS 350/351	3643171
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000
Saw blades MKS 350/351/350 H	
HSS saw blade DM05Ø 350x2.5x32 mm t4 ¹⁾	3653504
HSS saw blade DM05Ø 350x2.5x32 mm t6 ¹⁾	3653506
Saw blades for stainless steel MKS 351	
HSS-E saw blade Ø350x2.5x32 mm t4 ¹⁾	3653514
HSS-E saw blade Ø350x2.5x32 mm t6 ¹⁾	3653516

¹⁾t = tooth spacing ²⁾Price without installation on the saw



Chipmag swarf remover magnetic Art. no. 3850010

MKS 315 V - manual vertical metal-cutting circular saw with 315 mm saw blade**MKS 350 V - manual vertical metal-cutting circular saw with 350 mm saw blade****MKS 316 V - low-speed version for cutting stainless steel**

- ▶ Stable and robust structure
- ▶ easy and trouble-free operation
- ▶ two cutting speeds
- ▶ Vertically guided machine head, with dovetail guide and adjustable wedge bar, swivelling 45° anti-clockwise and 60° clockwise, with stops at -45°, 0°, -45°, 60°
- ▶ Adjustable depth stop for vertical stroke of saw head
- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Coolant pump with coolant filter
- ▶ Coolant jet distribution for improved saw blade lubrication
- ▶ laterally displaceable vice with burr-prevention unit
- ▶ Chip breaker for cleaning the blade
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch and overload protection
- ▶ Control handle with safety switch

Accessories**Chipmag swarf remover**

· magnetic Art. no. 3850010

**Scope of supply MKS 315V, 316V, 350 V**

- ▶ Coolant system with filter
- ▶ Material support arm with roller
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ Swarf remover T4
- ▶ Without saw blade

Model	MKS 315 V	MKS 316 V	MKS 350 V
Art. no.	3622315	3622316	3622350
Technical specifications			
Motor output 400 V / 50 Hz	1.3-1.8 kW	1.3-1.9 kW	1.9-2.5 kW
Speeds	33/66 rpm	17/34 rpm	36/72 rpm
Vice jaw width	160 mm	160 mm	185 mm
Saw blade diameter	Ø 315 mm	Ø 315 mm	Ø 350 mm
Run-in height incl. chassis	910 mm	910 mm	905 mm
Length	1500 mm	1500 mm	1050 mm
Width	650 mm	650 mm	1000 mm
Height	1700 mm	1700 mm	1850 mm
Weight	270 kg	270 kg	450 kg

Cutting capacity MKS 315 V, 316 V

	●	○	□	▭
90°	70	100	90 x 90	135 x 80
45°	70	100	90 x 90	100 x 80
45° +	70	80	70 x 70	70 x 80

Cutting capacity MKS 350 V

	●	○	□	▭
90°	100	100	90 x 90	170 x 90
45°	100	100	90 x 90	125 x 90
45° +	90	90	90 x 90	90 x 90

Accessories	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000
Spraying agent 5 l, micro-dosing unit	3608020
Saw blades MKS 315 V/316 V	
HSS saw blade DM05 Ø 315x2.5x32 mm t4 ¹⁾	3653154
HSS saw blade DM05 Ø 315x2.5x32 mm t6 ¹⁾	3653156
HSS saw blade DM05 Ø 315x2.5x32 mm t8 ¹⁾	3653158
Saw blades for stainless steel MKS 316 V	
HSS-E saw blade Ø 315x2.5x32 mm t4 ¹⁾	3653254
HSS-E saw blade Ø 315x2.5x32 mm t6 ¹⁾	3653256
Saw blades MKS 350 V	
HSS saw blade DM05 Ø 350x2.5x32 mm t4 ¹⁾	3653504
HSS saw blade DM05 Ø 350x2.5x32 mm t6 ¹⁾	3653506
HSS saw blade DM05 Ø 350x2.5x32 mm t8 ¹⁾	3653508
HSS saw blade DM05 Ø 350x2.5x32 mm t10 ¹⁾	3653510

¹⁾ t = tooth spacing ²⁾ Price without installation on the saw**Chip remover for MKS 315/350 V**

051/24 for Ø 315, 350 mm t4	03620512404
051/24 for Ø 315, 350 mm t6	03620512406
051/24 for Ø 315, 350 mm t8	03620512408
051/24 for Ø 315, 350 mm t10	03620512410

MKS 315 VH - semi-automatic vertical metal-cutting circular saw with 315 mm saw blade

MKS 350 VH - semi-automatic vertical metal-cutting circular saw with 350 mm saw blade



- ▶ Stable and robust structure
- ▶ easy and trouble-free operation
- ▶ two cutting speeds
- ▶ Vertically guided machine head, with dovetail guide and adjustable wedge bar, swivelling 45° anti-clockwise and 60° clockwise, with stops at -45°, 0°, -45°, 60°
- ▶ Adjustable depth stop for vertical stroke of saw head
- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Coolant pump with coolant filter

- ▶ Coolant jet distribution for improved saw blade lubrication
- ▶ laterally displaceable pneumatic quick release vice with burr-prevention unit
- ▶ Chip breaker for cleaning the blade
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch, undervoltage trip and overload protection

Semi-automatic mode

- ▶ Vice closes and motor is activated
- ▶ Saw head lowered for cutting
- ▶ Motor stops and saw head returns to original position
- ▶ Vice opens



MKS 315 VH



MKS 350 VH

Scope of supply

- ▶ MKS 315: Material support arm with roller
- ▶ MKS 350: Material roller conveyor 1000 mm
- ▶ Cross-cut fence 500 mm

- ▶ Operating tool
- ▶ Swarf remover T4
- ▶ Without saw blade
- ▶ Coolant system with filter

Model	MKS 315 VH	MKS 350 VH
Art. no.	3623315	3623350
Technical specifications		
Motor output 3 x 400 V/50 Hz	1.3-1.8 kW	1.9-2.5 kW
Speeds	33/66 rpm	36/72 rpm
Clamping width machine vice	160 mm	185 mm
Saw blade diameter	Ø 315 mm	Ø 350 mm
Run-in height incl. chassis		905 mm
Dimensions (L x W x H) in mm	1500 x 650 x 2000	2640 x 1200 x 2000
Weight	300 kg	480 kg
Height	1700 mm	1700 mm
Weight	270 kg	270 kg

Cutting capacity MKS 315 VH

	●	○	□	□
90°	70	100	90 x 90	135 x 80
45°	70	100	90 x 90	100 x 80
45° +	70	100	90 x 90	100 x 80
60° +	70	80	70 x 70	70 x 80

Cutting capacity MKS 350 VH

	●	○	□	□
90°	100	100	90 x 90	170 x 90
45°	100	100	90 x 90	125 x 90
45° +	100	100	90 x 90	125 x 90
60° +	90	90	90 x 90	90 x 90

Accessories	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000
Spraying agent 5 l, micro-dosing unit	3608020
Saw blades MKS 315 V/316 V	
HSS saw blade DM05 Ø 315x2.5x32 mm t4 ¹⁾	3653154
HSS saw blade DM05 Ø 315x2.5x32 mm t6 ¹⁾	3653156
HSS saw blade DM05 Ø 315x2.5x32 mm t8 ¹⁾	3653158
Saw blades MKS 350 V	
HSS saw blade DM05 Ø 350x2.5x32 mm t4 ¹⁾	3653504
HSS saw blade DM05 Ø 350x2.5x32 mm t6 ¹⁾	3653506
HSS saw blade DM05 Ø 350x2.5x32 mm t8 ¹⁾	3653508
HSS saw blade DM05 Ø 350x2.5x32 mm t10 ¹⁾	3653510
¹⁾ t = tooth spacing ²⁾ Price without installation on the saw	

Chip remover for MKS 315 VH/350 VH

051/24 for Ø 315, 350 mm t4	03620512404
051/24 for Ø 315, 350 mm t6	03620512406
051/24 for Ø 315, 350 mm t8	03620512408
051/24 for Ø 315, 350 mm t10	03620512410

MKS 315 VA - Automatic hydro-pneumatic vertical metal-cutting circular saw with CNC control

Arguments that impress in terms of quality, performance and price.

- ▶ stable and robust structure
- ▶ easy and intuitive use
- ▶ two cutting speeds
- ▶ Vertically guided machine head, with dovetail guide and adjustable wedge bar, swivelling 45° anti-clockwise and 60° clockwise, with stops at 45°, 0°, -45°, -60°
- ▶ Adjustable depth stop for vertical stroke of saw head
- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Coolant pump with coolant filter

- ▶ Coolant jet distribution for improved saw blade lubrication
- ▶ laterally displaceable pneumatic quick release vice with burr-prevention unit
- ▶ Chip breaker T6 for cleaning the blade
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch, undervoltage trip and overload protection
- ▶ The control unit has 49 programs, each with up to 99 individual steps

Automatic mode

- ▶ Material feed
- ▶ Vice closes and motor is activated
- ▶ Coolant pump activated
- ▶ Saw head lowered for cutting
- ▶ Feed carriage returns to the defined dimension
- ▶ Saw head returns to original position
- ▶ Vice opens
- ▶ Cycle repeats



MKS 315 VA

Scope of supply

- ▶ Machine chassis
- ▶ Coolant system with filter
- ▶ Material roller conveyor 1000 mm
- ▶ Operating tool
- ▶ User's Manual
- ▶ Swarf remover T4
- ▶ Without saw blade

Model	MKS 315 VA
Art. no.	3624315

Technical specifications	
Motor output 3 x 400 V/50 Hz	1.3/1.8 kW
Speeds	33/66 rpm
Clamping width machine vice	120 mm
Saw blade diameter	Ø 315 mm
Dimensions (L x W x H)	3500 x 1500 x 2000 mm
Weight	550 kg

Cutting capacity MKS 315 VA

	●	○	□	▭
90°	70	100	90 x 90	120 x 80
45°	70	90	80 x 80	80 x 80
45° +	70	90	80 x 80	80 x 80
60° +	70	80	70 x 70	70 x 80

Accessories	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000

Saw blades MKS 315 VA

HSS saw blade DM05 Ø 315x2.5x32 mm t4 ¹⁾	3653154
HSS saw blade DM05 Ø 315x2.5x32 mm t6 ¹⁾	3653156
HSS saw blade DM05 Ø 315x2.5x32 mm t8 ¹⁾	3653158

¹⁾ t = tooth spacing ²⁾ Price without installation on the saw

Chip remover for MKS 315 VA

051/24 for Ø 315, 350 mm t4	03620512404
051/24 for Ø 315, 350 mm t6	03620512406
051/24 for Ø 315, 350 mm t8	03620512408
051/24 for Ø 315, 350 mm t10	03620512410

MKS 350 VA - Automatic hydraulic vertical metal-cutting circular saw with CNC control

Arguments that impress in terms of quality, performance and price.

- ▶ stable and robust structure
- ▶ easy and intuitive use
- ▶ the control unit has 49 programs, each with up to 99 individual steps
- ▶ two cutting speeds
- ▶ Vertically guided machine head, with dovetail guide and adjustable wedge bar, swivelling 45° anti-clockwise and 45° clockwise, with stops at 45°, 0°, -45°
- ▶ Adjustable depth stop for vertical stroke of saw head

- ▶ Reduction gear, runs in oil bath for low noise
- ▶ Coolant pump with coolant filter
- ▶ Coolant jet distribution for improved saw blade lubrication
- ▶ laterally displaceable hydraulic quick release vice with burr-prevention unit
- ▶ Chip breaker T6 for cleaning the blade
- ▶ Low-voltage electrical system, 24 Volt, with emergency off switch, main switch, speed selection switch, undervoltage trip and overload protection

Automatic mode

- ▶ Material feed
- ▶ Vice closes and motor is activated
- ▶ Activation of coolant pump; saw head lowered for cutting
- ▶ Feed carriage returns to the defined dimension
- ▶ Saw head returns to original position
- ▶ Vice opens
- ▶ Cycle repeats



Scope of supply

- ▶ Machine chassis
- ▶ Coolant system with filter
- ▶ Material roller conveyor 1000 mm
- ▶ User's Manual
- ▶ Swarf remover T4
- ▶ Without saw blade

Cutting capacity MKS 315 VH

Model	MKS 350 VA
Art. no.	3624350

Technical specifications	
Motor output 3 x 400 V/50 Hz	1.9-2.5 kW
Speeds	25/50 rpm
Clamping width machine vice	185 mm
Saw blade diameter	Ø 350 mm
Dimensions (L x W x H)	3500 x 1500 x 2000 mm
Weight	900 kg

Cutting capacity MKS 350 VA

	●	○	□	▬
90°	100	120	100 x 100	170 x 100
45°	100	120	100 x 100	130 x 100
45° +	100	120	100 x 100	130 x 100
60° +	-	-	-	-

Accessories	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000

Saw blades MKS 315 VA

HSS saw blade DM05 Ø 350x2.5x32 mm t4 ¹⁾	3653504
HSS saw blade DM05 Ø 350x2.5x32 mm t6 ¹⁾	3653506
HSS saw blade DM05 Ø 350x2.5x32 mm t8 ¹⁾	3653508
HSS saw blade DM05 Ø 350x2.5x32 mm t10 ¹⁾	3653510

¹⁾ t = tooth spacing ²⁾ Price without installation on the saw

Chip remover for MKS 350 VA

051/24 for Ø 315, 350 mm t4	03620512404
051/24 for Ø 315, 350 mm t6	03620512406
051/24 for Ø 315, 350 mm t8	03620512408
051/24 for Ø 315, 350 mm t10	03620512410

LMS 400 / LMS 400 H / LMS 400 P - manual and semi-automatic light alloy metal-cutting circular saws with 400 mm saw blade



- ▶ Circular sawing machines for cutting full material and profiles made of aluminium and light alloys
- ▶ Stable and robust structure
- ▶ easy and trouble-free operation
- ▶ precise cutting
- ▶ saw head swivels through 45° anti-clockwise and 45° clockwise
- ▶ easy rotation of the saw head by 45° thanks to positioning pins, e.g., compound cut
- ▶ rotary plate with bearings
- ▶ sawing shaft with bearings

LMS 400

- ▶ manual version
- ▶ two manual vices with plastic covered aluminium jaws
- ▶ saw head swivels 45° anti-clockwise for compound cut

LMS 400 H

- ▶ semi-automatic version
- ▶ two pneumatic quick release vices with plastic covered aluminium jaws

LMS 400 P

- ▶ saw head swivels 45° anti-clockwise for compound cut
- ▶ two pneumatic vices with plastic covered aluminium jaws
- ▶ Control handle with safety switch



LMS 400
Shown with optional chassis



LMS 400 H



LMS 400 P
Shown with optional chassis

Scope of supply LMS 400

- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ without chassis
- ▶ Without saw blade

Scope of supply LMS 400 H

- ▶ Material support arm with roller
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ Without saw blade

Scope of supply LMS 400 P

- ▶ two pneumatic quick release vices
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool
- ▶ without chassis
- ▶ Without saw blade

Model	LMS 400	LMS 400 H	LMS 400 P
Art. no.	3625400	3625401	3625402

Technical specifications

Motor output 3 x 400 V/50 Hz	2.2 kW	2.2 kW	2.2 kW
Speeds	3000 rpm	3000 rpm	3000 rpm
Clamping width machine vice	220 mm	220 mm	220 mm
Saw blade diameter	Ø 400 mm	Ø 400 mm	Ø 400 mm
Run-in height incl. chassis	855 mm	855 mm	855 mm
Dimensions (L x W x H) in mm	1500 x 1000 x 900	1500 x 1000 x 1600	1500 x 1000 x 1600
Weight	160 kg	210 kg	210 kg

Cutting capacity LMS 400 / LMS 400 H / LMS 400 P

	●	○	□	▭
90°	60	140	110 x 110	180 x 100
45°	60	120	100 x 100	150 x 100
45° +	60	120	100 x 100	150 x 100
60° +	70	80	70 x 70	70 x 80

Micro-dosing unit standard equipment

Universally deployable for minimal lubrication of tool blades and forming tools

- Separate air and spraying agent lines avoid dripping
- With extra large lubricant tank, frequency-controlled pump and spray head

Micro-dosing unit MD 11

- For circular saws and band saws



MD 11

Micro-dosing unit MD 12, special features

- Filter pressure regulator with water separator
- Robust sheet steel housing
- Coaxial hose with flexible steel jacket



MD 12

Accessories

Accessories	Art. no.
Machine chassis LMS 400	3644071
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000

Saw blades MKS 315 VA

HM saw blade Ø 400 x 4.0 x 32 mm t96 3654048

¹⁾ Price without installation on the saw

LMS 400 A - automatic light alloy metal-cutting saw with 400 mm saw blade



- ▶ automatic circular sawing machine for cutting full material and profiles made of aluminium and light alloys
- ▶ Stable and robust structure
- ▶ easy and intuitive use
- ▶ precise cutting
- ▶ rotary plate with bearings
- ▶ three pneumatic quick release vices with Teflon jaws
- ▶ Automatic mode
- ▶ Material feed
- ▶ Vice closes and motor is activated
- ▶ Coolant pump activated
- ▶ Saw head is lowered until the cut is complete
- ▶ Feed carriage returns to the defined dimension
- ▶ Saw head returns to original position
- ▶ Vice opens
- ▶ Cycle repeats



Scope of supply

- ▶ Material roller conveyor 1000 mm
- ▶ Cross-cut fence 500 mm
- ▶ Operating tool

Model	LMS 400 A
Art. no.	3625404
Technical specifications	
Motor output 3 x 400 V/50 Hz	2.2 kW
Speeds	3000 rpm
Clamping width machine vice	180 mm
Saw blade diameter	Ø 400 mm
Run-in height incl. chassis	910 mm
Dimensions (L x W x H)	3800 x 1600 x 1700 mm
Weight	510 kg
Transport packaging flat rate*	TPFR 3 = € 59.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

Cutting capacity LMS 400 A

	●	○	□	▭
90°	60	130	110 x 110	180 x 100
45°	-	-	-	-
45° +	-	-	-	-
60° +	-	-	-	-

Accessories	Art. no.
Coolant concentrate 5 l	3601751
Chipmag (swarf remover)	3850010
Micro-dosing unit MD 11 - 24V AC	3608011
Micro-dosing unit MD 12 - 24V AC	3608012
Micro-dosing unit assembly	9002000

Saw blades MKS 315 VA

HM saw blade Ø 400 x 4.0 x 32 mm t96	3654048
HM saw blade Ø 400 x 3.0 x 32 mm t84	3654049

¹⁾ Price without installation on the saw



Chipmag swarf remover
magnetic Art. no. 3850010

Saw blades for all Metalkraft circular saws

HKS 230		Art. no.
Saw blade for steel	Ø 230 x 2.0 x 25.4 mm	3850231
Saw blade for aluminium	Ø 230 x 2.4 x 25.4 mm	3850232
Saw blade for stainless steel	Ø 230 x 1.8 x 25.4 mm	3850233
MTS 356		
Saw blade for steel	Ø 355 x 2.4 x 25.4 mm t80	3853504
Saw blade for aluminium	Ø 355 x 2.4 x 25.4 mm t80	3853502
Saw blade for stainless steel	Ø 355 x 2.4 x 25.4 mm t90	3853503
Saw blade for steel	Ø 305 x 2.4 x 25.4 mm t60	3853051
MKS 250 N, MKS 255 N		
HSS saw blade DM05	Ø 250 x 2 x 32 mm t4	3652504
HSS saw blade DM05	Ø 250 x 2 x 32 mm t6	3652506
MKS 275 N		
HSS saw blade DM05	Ø 275 x 2.5 x 32 mm t4	3652754
HSS saw blade DM05	Ø 275 x 2.5 x 32 mm t6	3652756
HSS saw blade DM05	Ø 275 x 2.5 x 32 mm t8	3652758
MKS 315 N, MKS 315 R, MKS 316 R		
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t4	3653154
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t6	3653156
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t8	3653158
Saw blades for stainless steel MKS 315 R		
HSS -E saw blade	Ø 315 x 2.5 x 32 mm t4	3653254
HSS -E saw blade	Ø 315 x 2.5 x 32 mm t6	3653256
MKS 350, MKS 351, MKS 350 H		
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t4	3653504
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t6	3653506

Saw blades for stainless steel MKS 351		Art. no.
HSS -E saw blade	Ø 350 x 2.5 x 32 mm t4	3653514
HSS -E saw blade	Ø 350 x 2.5 x 32 mm t6	3653516
MKS 315 V, MKS 316 V		
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t4	3653154
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t6	3653156
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t8	3653158
Saw blades for stainless steel MKS 316 V		
HSS -E saw blade	Ø 315 x 2.5 x 32 mm t4	3653254
HSS -E saw blade	Ø 315 x 2.5 x 32 mm t6	3653256
MKS 350 V		
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t4	3653504
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t6	3653506
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t8	3653508
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t10	3653510
MKS 315 VH		
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t4	3653154
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t6	3653156
HSS saw blade DM05	Ø 315 x 2.5 x 32 mm t8	3653158
MKS 350 VH		
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t4	3653504
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t6	3653506
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t8	3653508
HSS saw blade DM05	Ø 350 x 2.5 x 32 mm t10	3653510
LMS 400, LMS 400 H, LMS 400 A		
HM saw blade	Ø 400 x 4.0 x 32 mm t96	3654048
HM saw blade	Ø 400 x 4.0 x 32 mm t84	3654049

Teeth per inch (t)

When selecting a suitable saw blade for cutting a material, it is important to pay attention to the correct number of teeth per inch, which is a prerequisite for good cutting results. A rule of thumb states that the lowest teeth per inch figure should be selected that still allows for good swarf discharge from the cutting zone. This rule does not help you find the right tpi, but it does explain the logic of the right choice.

The following parameters must be known for the selection: 1. Cross section of the material, 2. Material type, 3. Application or cutting method

Cutting speed and feed

Choosing the right saw blade speed and feed rate is decisive to optimising the cutting process. There is a close relationship between the two speeds. For example, if the saw blade speed is too high compared to the saw's feed speed, the workpiece will be polished rather than cut. The saw blade will overheat and wear without providing cutting performance.

The following table contains recommendations for the correct use of our metal-cutting circular saw blades; of course, the values are only approximate guidelines:

	Steels up to 1500 N/m²	Steels up to 1800 N/m²	Steels up to 1200 N/m²	Stainless steels	Cast iron	Aluminium	Bronze/copper	Brass
Pipes/sections wall thickness				Teeth per inch t (mm)				
up to 1 mm	3	3	3	3	-	4	4	4
1-1.5 mm	4	4	3	4	-	5	5	5
1.5 - 2 mm	5	4	4	5	-	6	6	6
2 - 3 mm	5	5	5	5	-	7	7	7
from 3 mm	6	6	5	6	-	8	8	8
Full materials cross cutting				Teeth per inch t (mm)				
10 - 20 mm	5	5	5	5	5	6	6	8
20 - 40 mm	8	6	6	6	6	8	8	10
40 - 60 mm	10	10	8	8	8	12	10	12
60 - 90 mm	12	12	10	11	11	16	13	14
90 - 110 mm	14	14	12	14	14	18	15	17
110 - 130 mm	16	16	14	16	16	20	17	19
130 - 150 mm	18	16	14	16	16	20	19	20
Teeth per inch t (mm)				Feed A (mm/min) for full materials pipes/sections				
3	350-450	250-350	90-160	70-150	350-550	-	-	-
4	300-400	200-300	80-140	60-130	280-440	-	-	-
5	250-350	150-250	70-130	55-110	210-350	-	-	-
6	200-300	100-180	60-120	50-90	180-300	-	1400-2000	2000-4000
8	150-250	80-130	35-90	40-75	140-250	4500-8500	1000-1600	1500-3200
10	100-200	70-100	40-80	35-65	120-180	3800-6000	700-1200	1000-2500
12	80-150	65-90	35-65	30-55	90-150	3000-5000	550-850	800-1800
14	70-130	60-80	25-50	20-50	75-125	2800-4600	500-700	700-1400
16	50-120	55-70	15-40	15-35	65-110	2500-3700	400-600	600-1000
Saw blade Ø				rpm				
250 mm	40-65	25-50	20-30	15-25	40-65	750-1100	250-380	500-700
300 mm	30-55	20-45	15-25	10-20	30-55	650-950	210-320	430-640
315 mm	30-50	20-40	15-25	10-20	30-50	600-900	200-300	400-600
350 mm	25-45	20-35	15-25	10-20	25-45	550-820	180-270	350-550
400 mm	20-40	15-30	10-20	8-15	20-40	470-720	160-240	300-480



Roller conveyors

Unicraft UF 230 - universal chassis for moving saws, grinding machines, drilling machines, planing machines, etc.



- ▶ load up to 230 kg
- ▶ for easy transport and relocation of your machines
- ▶ safe and stable design
- ▶ fast and easy assembly
- ▶ Wheels rotate through 360° for ease of movement
- ▶ With vibration damping feet
- ▶ With two steering rollers and clasp brake as factory standard
- ▶ grid supports various size settings, thus allowing for universal deployment

Model	UF 230
Art. no.	6190230

Technical specifications	
Minimum size square	280 x 280 mm
Maximum size square	890 x 890 mm
Minimum size rectangular	430 x 280 mm
Maximum size rectangular	1290 x 480 mm
Hole spacing	25 mm
Load-bearing capacity	230 kg



Material stand MS 3 - continuously height-adjustable, loadable up to 700 kg

- ▶ for supporting long and heavy workpieces
- ▶ universally deployable, for example, on metal-cutting circular saws, band saws, other woodworking machines, etc.
- ▶ Roller support, continuously adjustable and clampable
- ▶ safe workpiece support due to solid steel rollers with high load-bearing capacity
- ▶ heavy three-leg cast iron version for highest loads

Model	MS 3	MS 3 V
Art. no.	3660700	3660705

Technical specifications		
Load-bearing capacity	700 kg	700 kg
Roller width	400 mm	2 x 130 mm
Min./max. height	580 / 970 mm	580 / 970 mm
Type	Steel rollers	Steel rollers
Roller diameter	52 mm	52 mm



MS 3



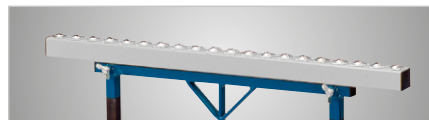
MS 3 V

Material stand MS 4 - continuously adjustable

- ▶ different roller types available
- ▶ Roller support, continuously adjustable
- ▶ extra wide support
- ▶ Universally deployable



MS 4 R



MS 4 K

Model	MS 4	MS 4 R	MS 4 K
Art. no.	3660110	3660111	3660112

Technical specifications			
Load-bearing capacity	500 kg	500 kg	500 kg
Length	700 mm	980 mm	1000 mm
Min./max. height	760 / 1030 mm	700 / 960 mm	700 / 960 mm
Type	Plastic roller	Multi-directional roller track	Ball transfer track
Roller diameter	90 mm	-	-



4ms

MRB LC - the roller and measuring track system with a lightweight design and a load-bearing capacity of 100 kg pro metre of roller conveyor

- ▶ Roller and measuring track system for precise sawing, drilling or milling of lighter wood metal and plastic sections
- ▶ Sub-structure made of solid 3 mm steel sections, painted and with adjustable feet
- ▶ Idler rollers made of galvanised steel (optionally also available with plastic idler rollers)

Especially for MRB LC-B and MRB LC-E

The stop carriage is 4x roller borne, and thus easy to move manually

- ▶ Stop arm is adjustable and can be tilted to the rear
- ▶ The maximum measuring length is the track length minus the stop length
- ▶ MRB LC-B: 250 mm

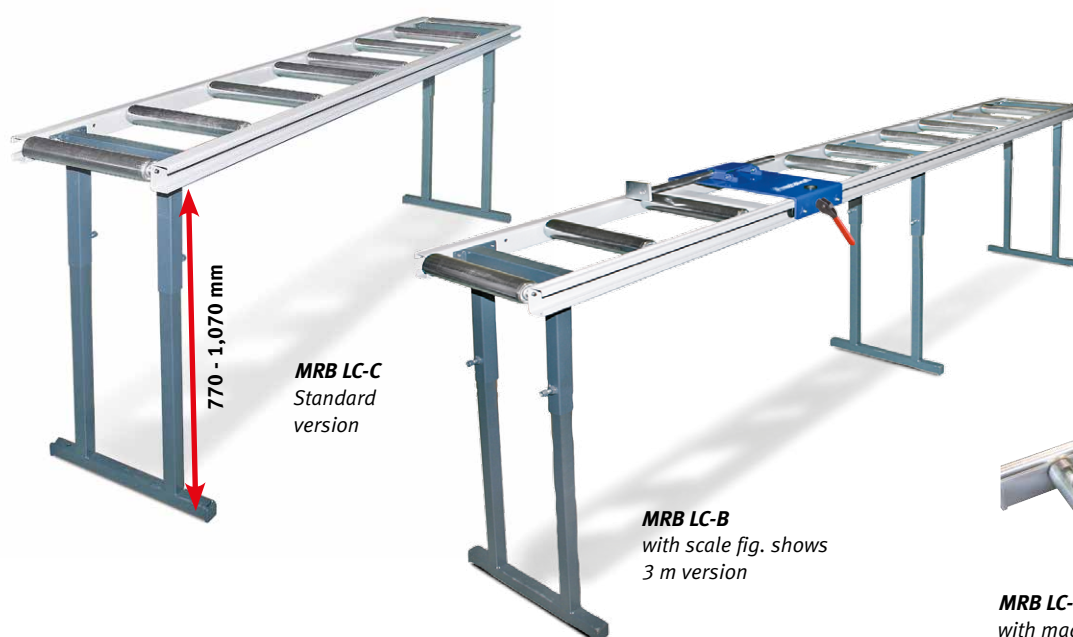
MRB LC-E: 250 mm



Quality Made in Germany



MRB LC-B: supplied with magnifying glass as standard for easier reading off of the millimetre scale



MRB LC-E

with magnetic strip, length measuring unit with digital display and 4x roller borne stop carriage

Technical data MRB LC series

Roller diameter	50 mm
Shaft diameter	8 mm
usable roller width	300 mm
load-bearing capacity per metre	100 kg/m
Working height	770 - 1,070 mm

Optional

Additional supporting leg for MRB LC-C, LC-B and LC-E Art. no. 3663000

Plastic rollers (surcharge per metre) Art. no. 3669990 for LC roller conveyors

MRB LC-C

Feed roller conveyor without cross-cut fence and without measuring system

Length	Roller conveyor feet	Art. no.
2 m	2	3662320
3 m	3	3662330
4 m	3	3662340
5 m	4	3662350
6 m	5	3662360

MRB LC-B

Stop track with cross-cut fence, manual measuring system with mm scale and magnifying glass for reading off, stop adjustable and can be tilted to the rear

Length	Roller conveyor feet	Art. no.
2 m	2	3662220
3 m	3	3662230
4 m	3	3662240
5 m	4	3662250
6 m	5	3662260

MRB LC-E

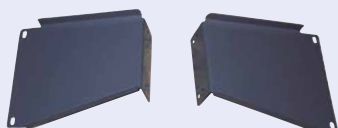
Roller conveyor with cross-cut fence, magnetic tape measuring system with digital display, otherwise as per MRB LC-B

Length	Roller conveyor feet	Art. no.
2 m	2	3662420
3 m	3	3662430
4 m	3	3662440
5 m	4	3662450
6 m	5	3662460

* Transport/insurance packaging TVP 3 = 59.00 € plus VAT per roller conveyor is required for roller conveyors with a length of 2 - 4 m

** Transport/insurance packaging TVP 4 = 79.00 € plus VAT per roller conveyor is required for roller conveyors with a length of 5 - 8 m

Assembly adapter



for stable fastening of MRB LC series roller conveyors to Metalkraft metal-cutting circular saws The adapters are specially designed for installation on the right or left of the saws

Assembly adapter

Saw type	Assembly position	Art. no.
MKS 250 N	right	3672201
MKS 250 N	left	3672101
MKS 315 N	right	3672202
MKS 315 N	left	3672102
MKS315V	right	3672204
MKS315V	left	3672104

Saw type	Assembly position	Art. no.
MKS350 V	right	3672205
MKS350 V	left	3672105
LMS400	right	3672203
LMS400	left	3672103
LMS 400 PRO	right	3672206
LMS 400 PRO	left	3672106

MRB standard - the roller and measuring track system with a robust design and a load-bearing capacity of 300 kg pro metre of roller conveyor

- ▶ sturdy U-shaped, closed design made from 3 mm sheet metal sections.
 - ▶ Idler rollers made of galvanised steel
 - ▶ all roller conveyors in the MRB Standard series are also available with plastic idler rollers (see plastic rollers at the bottom of the next page)
 - ▶ Ball-bearing borne idler rollers
- The maximum measuring length is the track length minus the stop length

MRB Standard A: 450 mm
MRB Standard BKF: 400 mm
MRB Standard B, EP: 260 mm

Technical specifications	
Roller diameter	60 mm
Shaft diameter	15 mm
Usable roller width	250 / 350 mm
load-bearing capacity per metre	300 kg/m
Height-adjustable feet	+/- 60 mm
Working height	880 mm

MRB Standard C

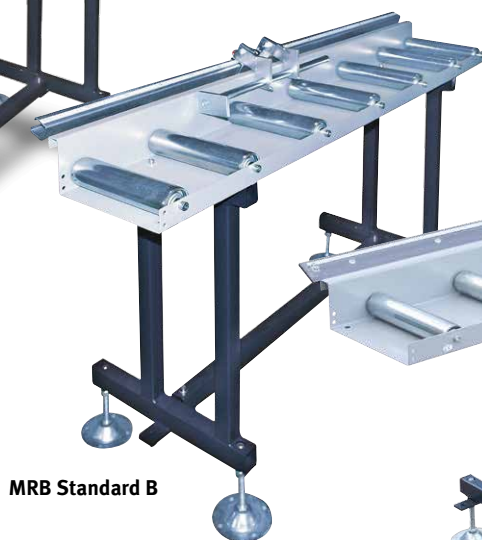
- ▶ Feed/discharge roller conveyors
- ▶ Roller conveyors without a scale and stop with lateral guides



MRB Standard C

MRB Standard B

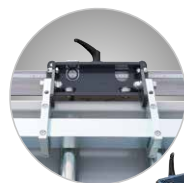
- ▶ With with length measuring unit
- ▶ Roller and measuring track with mm scale, manual measuring system with C guide profile and adjustable folding stop



MRB Standard B

MRB Standard BKF

- ▶ Precision flat steel guide attached to rear of roller conveyor
- ▶ sturdy, 6x ball bearing borne material stop carriage, easy action, manually adjustable and clampable
- ▶ Stop carriage with magnifying glass facilitates reading off the mm scale
- ▶ robust stop arm mounted on stop carriage; adjustable up to tool (0 point)



MRB Standard BKF

MRB Standard C

MRB Standard C - track width 300 mm (usable roller width 250 mm)

Length	Roller track feet	Art. no.	
1 m	2	3661311	
2 m	2	3661312	
3 m	3	3661313	
4 m	3	3661314	
5 m	4	3661315	
6 m	5	3661316	
7 m	5	3661317	
8 m	6	3661318	

MRB Standard C - track width 400 mm (usable roller width 350 mm)

Length	Roller track feet	Art. no.	
1 m	2	3661321	
2 m	2	3661322	
3 m	3	3661323	
4 m	3	3661324	
5 m	4	3661325	
6 m	5	3661326	
7 m	5	3661327	
8 m	6	3661328	

MRB Standard B - track width 300 mm (usable roller width 250 mm)

Length	Roller track feet	Art. no.	
1 m	2	3661211	
2 m	2	3661212	
3 m	3	3661213	
4 m	3	3661214	
5 m	4	3661215	
6 m	5	3661216	
7 m	5	3661217	
8 m	6	3661218	

MRB Standard B - track width 400 mm (usable roller width 350 mm)

Length	Roller track feet	Art. no.	
1 m	2	3661221	
2 m	2	3661222	
3 m	3	3661223	
4 m	3	3661224	
5 m	4	3661225	
6 m	5	3661226	
7 m	5	3661227	
8 m	6	3661228	

MRB Standard BKF - track width 300 mm (usable roller width 250 mm)

Length	Roller track feet	Art. no.	
1 m	2	3661231	
2 m	2	3661232	
3 m	3	3661233	
4 m	3	3661234	
5 m	4	3661235	
6 m	5	3661236	
7 m	5	3661237	
8 m	6	3661238	

MRB Standard BKF - track width 400 mm (usable roller width 350 mm)

Length	Roller track feet	Art. no.	
1 m	2	3661241	
2 m	2	3661242	
3 m	3	3661243	
4 m	3	3661244	
5 m	4	3661245	
6 m	5	3661246	
7 m	5	3661247	
8 m	6	3661248	

* Transport/insurance packaging TVP 4 = 79.00 € plus VAT per roller conveyor is required for roller conveyors with a length of 2 – 4 m

** Transport/insurance packaging TVP 5 = 100.00 € plus VAT per roller conveyor is required for roller conveyors with a length of 5 – 8 m

Assembly adapters on Metallkraft metal-cutting circular saws

The adapters are specially designed for installation on the right or left of the saws for the MRB Standard series on Metallkraft metal-cutting circular saws **Please state your sawing machine type with your order.**

For assembly of the MRB Standard models (300 mm):

Saw type	Assembly pos.	Art. no.
MKS250N	right	3671211
MKS250N	left	3671111
MKS 315 N	right	3671212
MKS 315 N	left	3671112
MKS315V	right	3671214
MKS315V	left	3671114
MKS350 V	right	3671215
MKS350 V	left	3671115
LMS400	right	3671213
LMS400	left	3671113

For assembly of the MRB Standard models (400 mm):

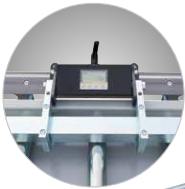
Saw type	Assembly pos.	Art. no.
MKS 250 N	right	3671221
MKS 250 N	left	3671121
MKS315N	right	3671222
MKS315N	left	3671122
MKS315V	right	3671224
MKS315V	left	3671124
MKS350 V	right	3671225
MKS350 V	left	3671125
LMS400	right	3671223
LMS400	left	3671123

Please state installation side and height with order!
Working height up to 1020 mm possible with optional foot plate.

On request:
Working height as of 1020 mm extensible as factory option
▶ also with 500 mm track width

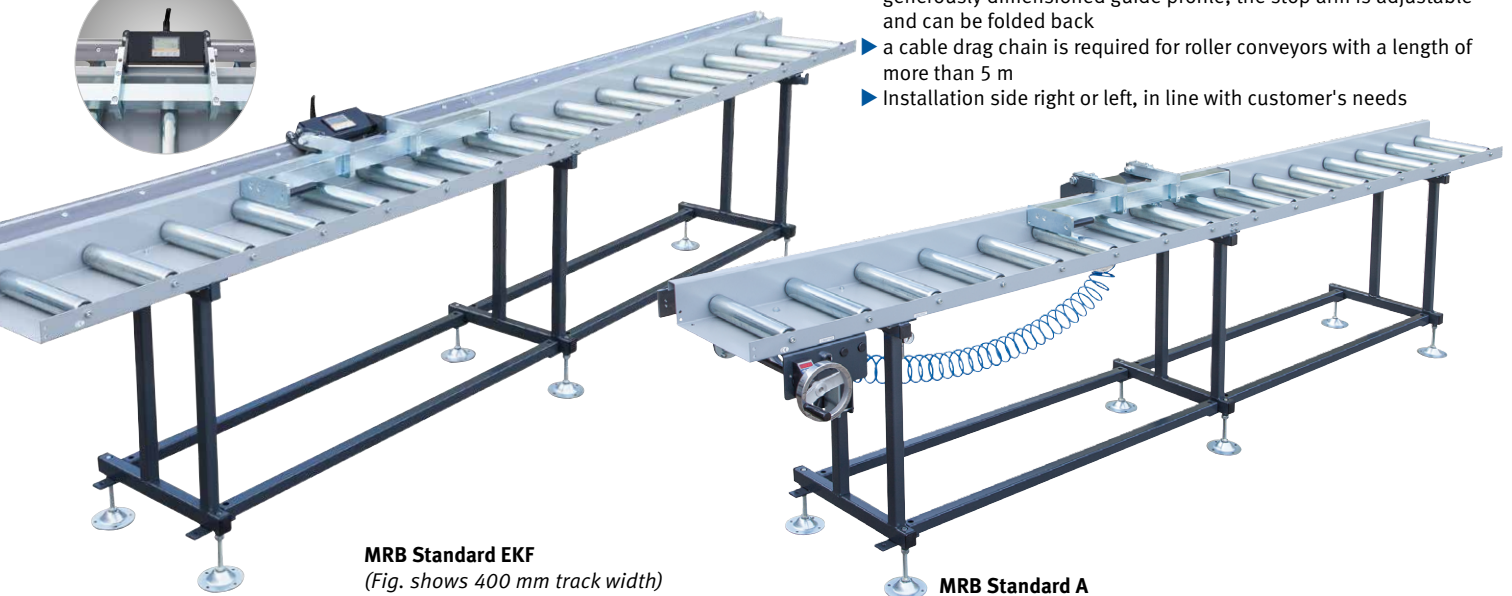
MRB Standard EKF

- ▶ As per MRB Standard BKF
- ▶ With with length measuring unit and digital dimension display system
- ▶ Roller and measuring track with battery operated LCD display and magnetic strip measuring system



MRB Standard A

- ▶ Length measuring unit with handwheel adjustment
- ▶ Roller and measuring track with LED dimension display (mm), incl. mains adapter 230 V
- ▶ Measuring stop adjustable via handwheel from workplace, with pneumatic brake for dimensional fixing
- ▶ robust material stop carriage, 12x ball-bearing borne, movable on generously dimensioned guide profile; the stop arm is adjustable and can be folded back
- ▶ a cable drag chain is required for roller conveyors with a length of more than 5 m
- ▶ Installation side right or left, in line with customer's needs



MRB Standard EKF
(Fig. shows 400 mm track width)

MRB Standard A

MRB Standard EKF - track width 300 mm (usable roller width 250 mm)

Length	Roller track feet	Art. no.
1 m	2	3661711
2 m	2	3661712
3 m	3	3661713
4 m	3	3661714
5 m	4	3661715
6 m	5	3661716
7 m	5	3661717
8 m	6	3661718

MRB Standard A - track width 300 mm (usable roller width 250 mm)

Length	Roller track feet	Art. no.
2 m	2	3661112
3 m	3	3661113
4 m	3	3661114
5 m	4	3661115
6 m	5	3661116
7 m	5	3661117
8 m	6	3661118

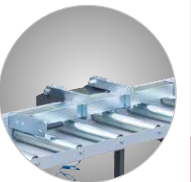
MRB Standard EKF - track width 400 mm (usable roller width 350 mm)

Length	Roller track feet	Art. no.
1 m	2	3661721
2 m	2	3661722
3 m	3	3661723
4 m	3	3661724
5 m	4	3661725
6 m	5	3661726
7 m	5	3661727
8 m	6	3661728

MRB Standard A - track width 400 mm (usable roller width 350 mm)

Length	Roller track feet	Art. no.
2 m	2	3661122
3 m	3	3661123
4 m	3	3661124
5 m	4	3661125
6 m	5	3661126
7 m	5	3661127
8 m	6	3661128

- ▶ 5-digit LED dimension display for continuous checking of the current stop carriage state with millimetre accuracy
- ▶ Position display with hollow shaft rotary encoder mounted directly on the drive shaft
- ▶ Measuring precision: 2/10 mm
- ▶ 900 mm stop arm length
- ▶ Guide plate adjustable to zero point; can be folded to the rear manually
- ▶ Multiply ball bearing-borne and thus free from play



Option foot plate with spindle M 16 x 250 mm
For height adjustment up to 1020 mm
● Art. no. 3679000

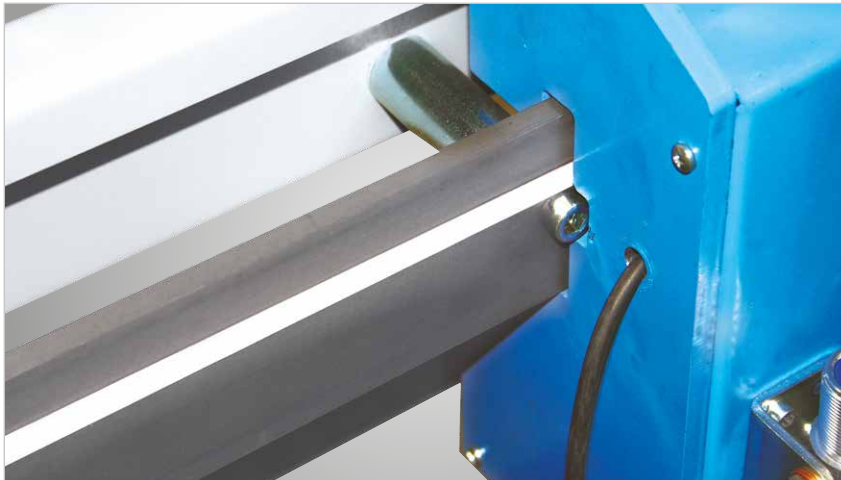
Plastic rollers (surcharge per metre)

	Art. no.
for MR Standard roller conveyors with a track width of 300 mm	3669991
for MR Standard roller conveyors with a track width of 400 mm	3669992

* Transport/insurance packaging TVP 4 = 79.00 € plus VAT per roller conveyor is required for roller conveyors with a length of 2 – 4 m

** Transport/insurance packaging TVP 5 = 100.00 € plus VAT per roller conveyor is required for roller conveyors with a length of 5 – 8 m

Optional accessories - extension of the roller and measuring track MRB Standard for more effective and time-saving work



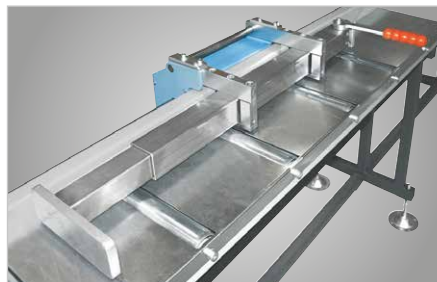
- ▶ Direct magnetic belt measuring system
- ▶ Delivery of direct magnetic belt measuring system including display unit Z58
- ▶ Independent stop carriage and length measuring drives
- ▶ Dimension is displayed via display unit Z58
- ▶ Sensor head mounted directly on the stop carriage
- ▶ Dimensional and repetition accuracy ± 0.1 mm per metre
- ▶ Cable and air ducting via energy drag chain

Length	Art. no.	
2 m	3672232	
3 m	3672233	
4 m	3672234	
5 m	3672235	
6 m	3672236	
7 m	3672237	
8 m	3672238	



Display unit Z58

- ▶ for convenient reading off of the set values thanks to 1/10 mm LED display
- ▶ receives the input signals via magnetised pole ring and a sensor head attached directly to the drive shaft
- ▶ Measuring accuracy of ± 0.2 mm per metre
- ▶ easy to read off
- ▶ Art. no. 3672220;



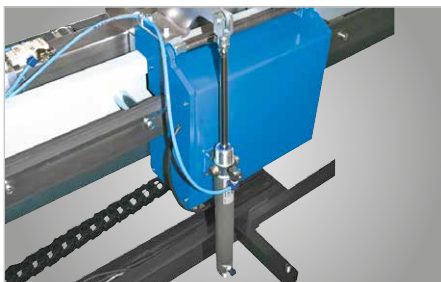
Spring-loaded stop arm SZ 05

- ▶ with spring-loaded material stop arm
- ▶ adjustable to the 0 point
- ▶ swivels to the rear manually
- ▶ equipped with an eccentric lever for adjusting the release action
- ▶ Art. no. 3672221;



Pneumatic arm retractor

- ▶ **only available in combination with spring loaded stop arm SZ 05**
- ▶ ideal for mitre cuts
- ▶ avoids the workpiece skewing
- ▶ pneumatic arm retraction (release) from the material stop
- ▶ Release stroke 10 mm
- ▶ Art. no. 3672222;



Material arm pneumatically swivelling

- ▶ Device for pneumatically swivelling the material arm to the rear
- ▶ a pneumatic cylinder handles this task; easy and convenient operation from the central control panel
- ▶ Art. no. 3672223;



Cover sheet galvanised zinc coated

- ▶ Cover plate for assembly between the idler rollers
- ▶ galvanised zinc coated
- ▶ removable
- ▶ Price per metre of sheet metal
- ▶ Art. no. 3672224;



Optional roller conveyor feet for table heights up to 1020 mm

- ▶ Option foot plate with spindle M 16 x 250 mm
- ▶ Raises the working height up to 1020 mm
- ▶ Art. no. 3679000;

Band saws



Metallkraft MBS - particularly quiet and precise mitre metal-cutting band saws. Ideal for use on the construction site and on the road

- ▶ Ideal for sawing steel, aluminium, copper, PVC and Teflon
- ▶ Continuously adjustable, electronic speed control from 30-80 m/min.
- ▶ Extremely low noise - up to 60% quieter than comparable band saws
- ▶ Low vibration and wear thanks to special gearbox with two large hardened steel gears
- ▶ Guaranteed cutting precision of max. 0.3 mm run-out over 100 mm cut length
- ▶ Each machine is individually precision tested in Italy
- ▶ DC drive motor, low speed and carbon brushes for up to 10x longer service life
- ▶ Electronic temperature and amperage draw monitoring prevents overload
- ▶ Cast band pulleys with ground running surface, without rubber supports, thus suitable for dry and wet cutting
- ▶ Massive saw bow made of cast aluminium (retroactively adjustable as of MBS 125) and with robust transport protection
- ▶ Two moving, adjustable saw band guides with chip scraper made of metal
- ▶ Very stable base plate with anti-slip feet
- ▶ Easy to service as all components are easily accessible
- ▶ Includes material stop and bi-metal saw band
- ▶ MBS 155 K with chassis, coolant device and coolant baffle plate
- ▶ Saw band with 10 – 14 teeth included in scope of supply



MBS 105



MBS 125



MBS 150

Manual

Technical specifications	MBS 105	MBS 125	MBS 150	MBS 155 K
Art. no.	3630105	3630125	3630150	3630152
Technical specifications				
Motor output 230 V / 50 Hz	850 W	1200 W	1.5 kW	1.5 kW
Saw band speed	30 – 80 m/min.	30 – 80 m/min.	30 – 80 m/min.	30 – 80 m/min.
Saw blade dimensions	1335 x 13 x 0.65 mm	1440 x 13 x 0.65 mm	1735 x 13 x 0.65 mm	1735 x 13 x 0.65 mm
Dimensions (L x W x H)	720 x 320 mm	720 x 320 mm	1000 x 390 mm	1000 x 390 mm
Weight	18 kg	19 kg	30 kg	86 kg

Cutting capacity MBS 105

	○	□	▬
90°	105	101	101 x 105
45°	70	70	70 x 70
45° +	-	-	-

Cutting capacity MBS 125

	○	□	▬
90°	125	125	130 x 125
45°	80	80	80 x 80
45° +	50	50	50 x 50

Cutting capacity MBS150 / MBS 155 K

	○	□	▬
90°	150	140	150 x 140
45°	100	90	100 x 90
45° +	70	65	65 x 70



- ▶ Two large tempered steel gearwheels for maximum service life
- ▶ DC drive motor, low speed and carbon brushes for up to 10x longer service life



MBS 155 K



Fig. shows MBS 105 on machine chassis MUG 1



Fig. shows MBS 150 on universal work table UWT 3200 with clamped workpiece



- Cast wheels with ground running surfaces and tapered roller bearings
- Without rubber supports and thus suitable for cutting with cooling (saw band does not slip off)
- Saw band tensioning at front, adjustable via handwheel



- 2x adjustable saw band guide, instead of just one
- Swarf scraper made of metal instead of felt to avoid wear



- Saw bow retroactively adjustable as of MBS 125



- Mitre square precisely adjustable; can be read off on scale



- Continuously variable speed control from 30-80 m/min.

Saw bands MBS 105	Art. no.
Bi-metal 1335 x 13 x 0.65 mm M 42 Z 6-10	3650011
Bi-metal 1335 x 13 x 0.65 mm M 42 Z 10-14	3650012

Saw bands MBS 150/ MBS 155 K	Art. no.
Bi-metal 1735 x 13 x 0.65 mm M 42 Z 6-10	3650017
Bi-metal 1735 x 13 x 0.65 mm M 42 Z 10-14	3650018

Saw bands MBS 125	Art. no.
Bi-metal 1440 x 13 x 0.65 mm M 42 Z 6-10	3650014
Bi-metal 1440 x 13 x 0.65 mm M 42 Z 10-14	3650015

Accessories	Art. no.
Universal workbench UWT 3200*	5900020
Machine chassis MUG 1**	3630000
High performance spray "Mecutspray" 500ml	38760.1150

"Chipmag" – Magnetic swarf removal device 3850010
 *only fits MBS 150 without installation adapter; adapter Art. no. 3630125-1 required for installation on the MBS 125.
 ** only fits MBS 105, MBS 125, MBS 150, MTS 356, OPTI S 100G (Optimum)

Saw band sets	Art. no.
for MBS 105	3650020

consisting of:
 1 x saw band BI-M 1335 x 13 x 0.65 t6/10°
 1 x saw band BI-M 1335 x 13 x 0.65 t6-10
 1 x saw band BI-M 1335 x 13 x 0.65 t10-14

for MBS 125	3650021
-------------	---------

consisting of:
 1 x saw band BI-M 1440 x 13 x 0.65 t6/10°
 1 x saw band BI-M 1440 x 13 x 0.65 t6-10
 1 x saw band BI-M 1440 x 13 x 0.65 t10-14

MBS 150/155K	3650022
--------------	---------

consisting of:
 1 x saw band BI-M 1735 x 13 x 0.9 t6/10°
 1 x saw band BI-M 1735 x 13 x 0.9 t6-10
 1 x saw band BI-M 1735 x 13 x 0.9 t10-14



VMBS - Vertical metal band saws with a robust and proven design including band welding unit, e models with electrical table feed

- ▶ Extremely robust design; entire machine body made of steel
- ▶ User-friendly operating concept
- ▶ With workplace lighting
- ▶ Tilting work table made of cast iron
- ▶ Continuously variable speed
- ▶ Band tensioning and band speed display
- ▶ Dust protection system for swarf
- ▶ Integrated band welding unit with annealing, cutting and grinding unit
- ▶ With rip fence

Manual



VMBS 1408



VMBS 1610

➡ With 2-gear drive



VMBS 1610E

➡ With 2-gear drive
➡ With electric table feed

Models	New	VMBS 1408	VMBS 1610	VMBS 1610E
Art. no.		3951407	3951610	3951611
Technical specifications				
Reach		356 mm	396 mm	396 mm
max. cutting height		205 mm	255 mm	255 mm
Table size		500 x 500 mm	550 x 600 mm	550 x 600 mm
Table size additional table		-	-	-
Working height		990 mm	1000 mm	1000 mm
Table swivel range left/right		12°/15°	12°/15°	5°/ 5°
Table swivel range front/rear		8°/8°	8°/8°	-
Saw band length		2880 mm	3140 mm	3140 mm
max. saw band width		13 mm	16 mm	16 mm
Saw band speed (1st gear)		20 - 80 m/min	20 - 80 m/min	20 - 80 m/min
Saw band speed (2nd gear)		-	250 - 1000 m/min	250 - 1000 m/min
Saw band welding device performance		13 mm	16 mm	16 mm
Wheel Ø		368 mm	408 mm	408 mm
Ø Additional wheel at top		-	-	-
Motor output 400 V / 50 Hz		0.75 kW	1.5 kW	1.5 kW
Table displacement stroke		-	-	300 mm
Dimensions		850 x 600 x 1740 mm	940 x 675 x 1840 mm	940 x 675 x 1840 mm
Weight		275 kg	410 kg	435 kg

Saw bands for band saws	Art. no.	€ plus VAT
VMBS 1408 (bi-metal M 42)		
2880 x 10 x 0.9 mm 10-14 Vario	3651110	
2880 x 13 x 0.65 mm 6-10 Vario	3651210	
2880 x 13 x 0.65 mm 8-12 Vario	3651212	
2880 x 13 x 0.65 mm 10-14 Vario	3651214	
VMBS 1610 / VMBS 1610 E (bi-metal M 42)		
3140 x 13 x 0.65 mm 6-10 Vario	3651310	
3140 x 13 x 0.65 mm 8-12 Vario	3651312	
3140 x 13 x 0.65 mm 10-14 Vario	3651314	



· Mitre stop for mitre cuts



· Manual material feed



· Circle cutting unit



· Magnifying glass



· Workplace lighting



VMBS 2012 H



VMBS 2012 HE



· Saw band guide height-adjustable via hand wheel

- ➔ With 2-gear drive
- ➔ With circle cutting unit
- ➔ With mitre stop for mitre cuts
- ➔ With manual material feed
- ➔ Saw band guide height-adjustable via hand wheel

- ➔ With 2-gear drive
- ➔ With electric table feed
- ➔ With circle cutting unit
- ➔ With mitre stop for mitre cuts
- ➔ Saw band guide height-adjustable via hand wheel

Models	New VMBS 2012 H	VMBS 2012 HE
Art. no.	3952011	3952012

Technical specifications		
Reach	508 mm	508 mm
max. cutting height	305 mm	305 mm
Table size	600 x 700 mm	600 x 700 mm
Table size additional table	-	-
Working height	1016 mm	1016 mm
Table swivel range left/right	10°/45°	10°/45°
Table swivel range front/rear	-	-
Saw band length	4030 mm	4030 mm
max. saw band width	27 mm	27 mm
Saw band speed (1st gear)	15 - 125 m/min	15 - 125 m/min
Saw band speed (2nd gear)	165 - 1500 m/min	165 - 1500 m/min
Saw band welding device performance	19 mm	19 mm
Wheel Ø	515 mm	515 mm
Ø Additional wheel at top	-	-
Motor output 400 V / 50 Hz	2.2 kW	2.2 kW
Table displacement stroke	-	300 mm
Dimensions	1090 x 810 x 2030 mm	1090 x 810 x 2030 mm
Weight	590 kg	625 kg

Saw bands for band saws	Art. no.	€ plus VAT
VMBS 2012/ VMBS 2012E (bi-metal M 42)		
4030 x 13 x 0.65 mm 6-10 Vario	3651710	
4030 x 13 x 0.65 mm 8-12 Vario	3651712	
4030 x 13 x 0.65 mm 10-14 Vario	3651714	
4030 x 20 x 0.9 mm 6-10 Vario	3651720	
4030 x 20 x 0.9 mm 8-12 Vario	3651722	
4030 x 20 x 0.9 mm 10-14 Vario	3651724	
4030 x 27 x 0.9 mm 6-10 Vario	3651730	
4030 x 27 x 0.9 mm 8-12 Vario	3651732	
4030 x 27 x 0.9 mm 10-14 Vario	3651734	

VMBS - Vertical metal band saws with a robust and proven design including band welding unit, e models with electrical table feed

- ▶ Extremely robust design; entire machine body made of steel
- ▶ User-friendly operating concept
- ▶ With workplace lighting
- ▶ Tilting work table made of cast iron
- ▶ Continuously variable speed
- ▶ Band tensioning and band speed display
- ▶ Dust protection system for swarf
- ▶ Integrated band welding unit with annealing, cutting and grinding unit
- ▶ With rip fence

Manual



VMBS 2613

- ➔ With 2-gear drive
- ➔ With circle cutting unit
- ➔ With mitre stop for mitre cuts
- ➔ With manual material feed
- ➔ Saw band guide height-adjustable via hand wheel



VMBS 2613E

- ➔ With 2-gear drive
- ➔ With electric table feed
- ➔ With circle cutting unit
- ➔ With mitre stop for mitre cuts
- ➔ Saw band guide height-adjustable via hand wheel

Models	New VMBS 2613	New VMBS 2613E
Art. no.	3952612	3952613

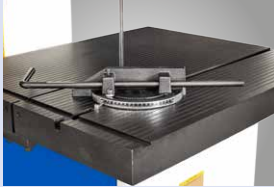
Technical specifications		
Reach	658 mm	658 mm
max. cutting height	330 mm	330 mm
Table size	600 x 700 mm	600 x 700 mm
Table size additional table	-	-
Working height	1000 mm	1000 mm
Table swivel range left/right	10°/45°	10°/45°
Table swivel range front/rear	-	-
Saw band length	4680 mm	4680 mm
max. saw band width	27 mm	27 mm
Saw band speed (1st gear)	15 - 125 m/min	15 - 125 m/min
Saw band speed (2nd gear)	165 - 1500 m/min	165 - 1500 m/min
Saw band welding device performance	19 mm	19 mm
Wheel Ø	665 mm	665 mm
Ø Additional wheel at top	-	-
Motor output 400 V / 50 Hz	2.2 kW	2.2 kW
Table displacement stroke	-	300 mm
Dimensions	1340 x 810 x 2190 mm	1340 x 810 x 2190 mm
Weight	665 kg	710 kg

Saw bands for band saws	Art. no.	€ plus VAT
-------------------------	----------	------------

VMBS 2613 / VMBS 2613 E (bi-metal M 42)

4680 x 13 x 0.65 mm 6-10 Vario	3651810	
4680 x 13 x 0.65 mm 8-12 Vario	3651812	
4680 x 13 x 0.65 mm 10-14 Vario	3651814	
4680 x 20 x 0.9 mm 6-10 Vario	3651820	
4680 x 20 x 0.9 mm 8-12 Vario	3651822	
4680 x 20 x 0.9 mm 10-14 Vario	3651824	
4680 x 27 x 0.9 mm 6-10 Vario	3651830	
4680 x 27 x 0.9 mm 8-12 Vario	3651832	
4680 x 27 x 0.9 mm 10-14 Vario	3651834	

New



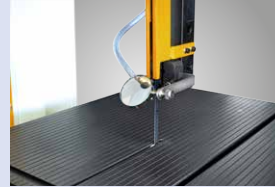
· Mitre stop for mitre cuts



· Manual material feed



· Circle cutting unit



· Magnifying glass



· Workplace lighting



VMBS 3612

- ➔ With 2-gear drive
- ➔ With circle cutting unit
- ➔ With mitre stop for mitre cuts
- ➔ With manual material feed
- ➔ Saw band guide height-adjustable via hand wheel



VMBS 3612E

- ➔ With 2-gear drive
- ➔ With electric table feed
- ➔ With circle cutting unit
- ➔ With mitre stop for mitre cuts
- ➔ Saw band guide height-adjustable via hand wheel

Models	New VMBS 3612	New VMBS 3612E
Art. no.	3953611	3953612

Technical specifications		
Reach	915 mm	915 mm
max. cutting height	305 mm	305 mm
Table size	600 x 700 mm	600 x 700 mm
Table size additional table	450 x 700 mm	450 x 700 mm
Working height	1016 mm	1016 mm
Table swivel range left/right	10°/45°	10°/45°
Table swivel range front/rear	-	-
Saw band length	5020 mm	5020 mm
max. saw band width	27 mm	27 mm
Saw band speed (1st gear)	15 - 125 m/min	15 - 125 m/min
Saw band speed (2nd gear)	165 - 1500 m/min	165 - 1500 m/min
Saw band welding device performance	19 mm	19 mm
Wheel Ø	515 mm	515 mm
Ø Additional wheel at top	368 mm	368 mm
Motor output 400 V / 50 Hz	2.2 kW	2.2 kW
Table displacement stroke	-	-
Dimensions	1760 x 810 x 2060 mm	1760 x 810 x 2060 mm
Weight	800 kg	835 kg

Saw bands for band saws	Art. no.	€ plus VAT
-------------------------	----------	------------

VMBS 3612 / VMBS 3612 E (bi-metal M 42)

5020 x 13 x 0.65 mm 6-10 Vario	3651910	
5020 x 13 x 0.65 mm 8-12 Vario	3651912	
5020 x 13 x 0.65 mm 10-14 Vario	3651914	
5020 x 20 x 0.9 mm 6-10 Vario	3651920	
5020 x 20 x 0.9 mm 8-12 Vario	3651922	
5020 x 20 x 0.9 mm 10-14 Vario	3651924	
5020 x 27 x 0.9 mm 6-10 Vario	3651930	
5020 x 27 x 0.9 mm 8-12 Vario	3651932	
5020 x 27 x 0.9 mm 10-14 Vario	3651934	

The various industrial type band saw operating concepts - user friendly and clear cut



BMBS 230 x 280 H-DG



BMBS 300 x 320 CNC-G



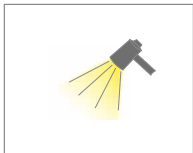
BMBS 300 x 320 HA-DG



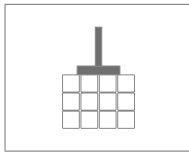
HMBS 500 x 750 HA-DG X



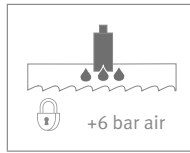
Explanation of the various equipment and accessory details:



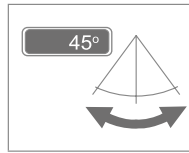
Workplace lighting



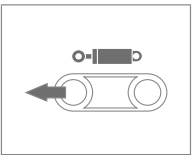
hydr. bundle clamping unit



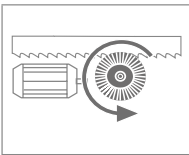
Micro-spraying system



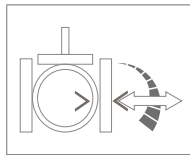
Digital angle display on saw arm



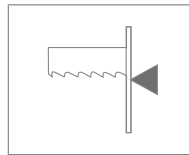
Hydraul. band tensioning unit



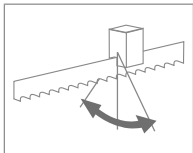
Motorised swarf brush



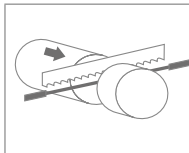
Pressure regulator on vice



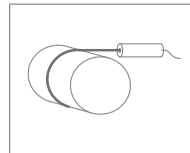
Display for lowering speed at control panel (mm/min)



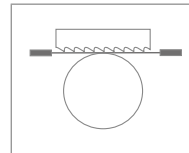
Cut path monitoring



Material start sensor



Cutting line laser



Autom., zero-contact setting of upper working position



Explanation of the METALLKRAFT designations Band saws with heavy-duty industrial design

BMBS	Swivel frame Metal Band Saws
HMBS	Horizontal Metal Band Saws
HVMB	Horizontal/Vertical Metal Band Saws
G	Machine cuts simple mitres (G)
DG	Machine cuts Double mitres (G)
H	Saw with partially hydraulically controlled functions
HA	(H) Semi-Automatic machine
NC	Partially automated NC operation
CNC	Automated CNC operation
X	advanced electronics taking the material properties into consideration



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.

	Art. no.
Commissioning and initial training for standard machines	EINWMET
Initial training & training for CNC controls	EINWCNCMET
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.

The control panel on our H models

Function of our H models:

The Version H saws have a hydraulic cylinder that controls lowering of the saw arm. The operator can switch between manual mode and gravity mode with a selector switch. In manual mode, the sawing arm is lowered by hand. In gravity

mode, the sawing action is started by pressing a pushbutton; the saw arm is lowered through its own weight; the lowering speed can be regulated using a choke valve under the control panel. The cut is executed at the selected band speed, and the saw band stops automatically after

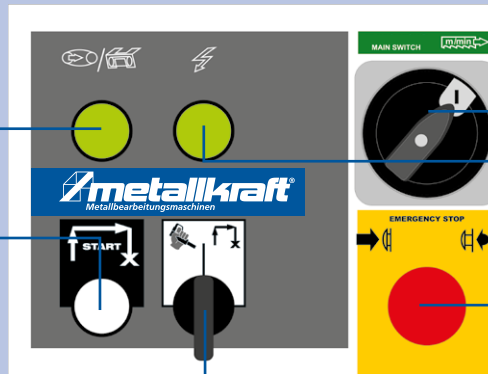
completing the cutting action. The saw arm is always lifted manually. The lowering cylinder automatically shuts off on reaching the top end position.

Standard

- ▶ Check lamp for saw band tension and indicator lamp:
- ▶ - lit green when the band tension is correct and the saw band cover is closed

- ▶ Start of cycle - pressing the button starts the sawing action.

- ▶ Switch for switching the mode
Work mode switches between manual and gravity mode (lowering of the saw arm through its own weight)



- ▶ Switch for selecting the band speed in 2 stages, e.g.: Position 1: 35 m/min., Position 2: 70 m/min.
- ▶ This switch is the main switch at the same time

- ▶ Indicator lamp shows whether the machine is switched on at the main switch

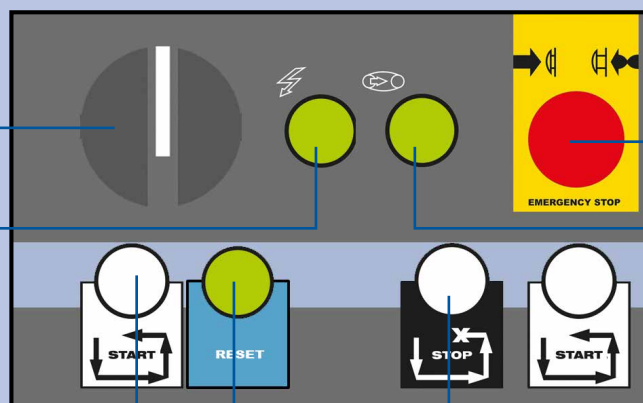
- ▶ Emergency off switch - switches the machine off during a cycle

BMBS 360 x 500 H-DG

- ▶ Switch for selecting the belt speed in 2 stages, e.g.,:
- ▶ Position 1: 35 m/min.
- ▶ Position 2: 70 m/min.
- ▶ Check lamp for saw band tension
- ▶ - lit green when the band tension is correct and the saw band cover is closed

- ▶ Start of cycle - pressing the button starts the sawing action.

- ▶ RESET button



- ▶ Emergency off switch - switches the machine off during a cycle

- ▶ Indicator lamp shows whether the machine is switched on at the main switch

- ▶ Stop switch - switches the machine off during a cycle

The control panel on the semi-automatic (HA) machines

Function of the semi-automatic machines:

The Version HA sawing machine have hydraulic functions that support a semi-automatic mode of operation. After starting the machine, the vice automatically clamps the workpiece. The saw cut

is performed at the selected band speed. The lowering motion automatically stops at the bottom end position; the saw arm moves to its top end position. The vice opens automatically so that the operator only needs to move the material.

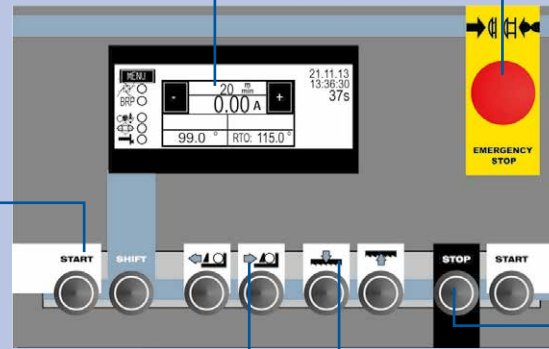
The sawing action can be interrupted at any time by enabling the stop function. The band is freed and the saw arm moves out of the cutting channel without opening the vice or switching off the machine.

- ▶ Large digital display with functions such as:
 1. MENU button for actuating various menu items shown on the screen
 2. Workpiece/cut counter
 3. BRP display*
 4. Status display for hydraulic system
 5. Saw band tensioning display
 6. Saw arm position display
 7. Saw band speed display

- ▶ Start of cycle - pressing the button starts the saw's processing cycle. The saw arm must be in the top end position for this to happen.

- ▶ Vice control - if the vice is still open before the cycle starts, the control unit automatically closes it after starting the cycle, and opens it again after completing the work step.

- ▶ Saw arm control - controls the up and down motion of the saw arm



- ▶ Emergency off switch - switches the machine off during a cycle

Control field

START

- in semi-automatic mode, for starting the cut
- For safety reasons, both start buttons must be pressed at the same time

- Interrupts the cut in any position
- The cycle continues after pressing the Start button

STOP

*BRP - saw band monitoring

The BRP display is activated if a maximum value of the saw band motor in Amperes is exceeded. The sawing frame stops the feed motion while the saw band continues to run and discharges the swarf from the cutting channel. Once the load on the saw band has been reduced to a minimum, the sawing process continues normally.

The control panel on the semi- and fully-automatic CNC versions

Saws with CNC control can be operated in semi- and fully-automatic mode.

Function of the semi-automatic machines:

In semi-automatic mode, the saw works as stated in the function description for semi-automatic

machines.

Fully-automatic operating mode:

Nine different tasks can be programmed on the fully-automatic CNC versions. The program contains the steps and cut lengths for each task. The work

steps for feeding in the material are automatically computed by a processor. It is possible to call up various cutting sequences and automatically run programs with different cutting lengths one after another.

Small display

- Shows whether the machine is running in fully- or semi-automatic mode



- ▶ If the display is off, the machine is running in semi-automatic mode



- ▶ Display 1 to 9 for automatic mode; the figures shown the selected program

- ▶ Information display
- ▶ You can select which values to show in the large display;



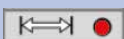
- ▶ Saw band condition



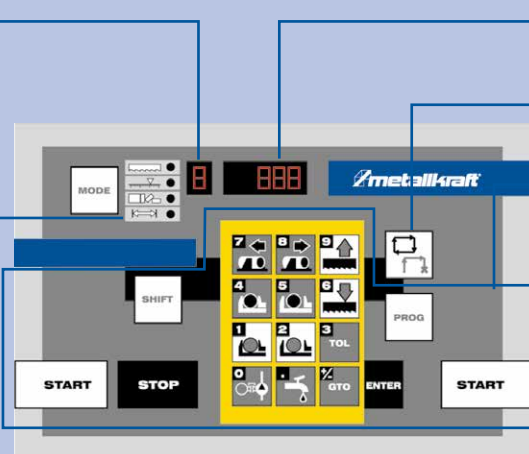
- ▶ Current position of feed vice



- ▶ Workpiece/cut counter



- ▶ Selected cut length



Large display

- ▶ The values selected in the information display are shown here.

- ▶ Button for selecting semi- or fully-automatic mode

Control field

PROG

Program selection from 1-9 (only in automatic mode)

ENTER

Confirms selected values in semi-automatic mode, for starting the cut in fully-automatic mode, for starting the program

START

For safety reasons, both start buttons must be pressed at the same time

Interrupts the cut in any position

in fully-automatic mode, the cycle continues after pressing the Start button

STOP

GTO TOL

Control field (continued)

Feed control (HA mode)

Setting the tolerance for cut lengths

*BRP - saw band monitoring

The BRP display is activated if a maximum value of the saw band motor in Amperes is exceeded. The sawing frame stops the feed motion while the saw band continues to run and discharges the swarf from the cutting channel. Once the load on the saw band has been reduced to a minimum, the sawing process continues normally.

The control panel on the control unit of our X models

CNC-X control function

The CNC-X control is an extension of the CNC version. It has all of the CNC version's features. In addition to this, the CNC X-Version offers the user 99 program memory slots with up to 20 setting options for cut parameters per individual program. The X version has a 64-bit control unit as standard.

This allows for:

- ▶ automatic control of saw arm movements depending on the material
- ▶ electronic setting of the saw arm's top and bottom positions
- ▶ monitoring the saw band and feed speeds based on a display

The X control has a PC interface for connecting external components.



Fig. swivelling
Control panel HVMBS 1200 x 1600 Xtreme

Screen

- ▶ Screen for displaying the menu items and values

Stop button

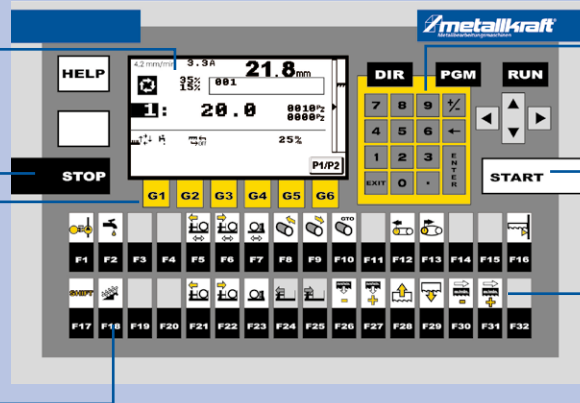
- ▶ for stopping the cycle

Menu buttons G1 - G6

- ▶ For actuating the various menu items shown on the screen

Control keys F1 - F32

- ▶ These keys are used to select the functions symbolised by the button labels



Keypad

- ▶ Keypad for entering values and navigating the menus

Start button

- ▶ For starting the cycle and setting the zero point

Pictograms

- ▶ Symbolise the functions that can be actuated with the buttons below them

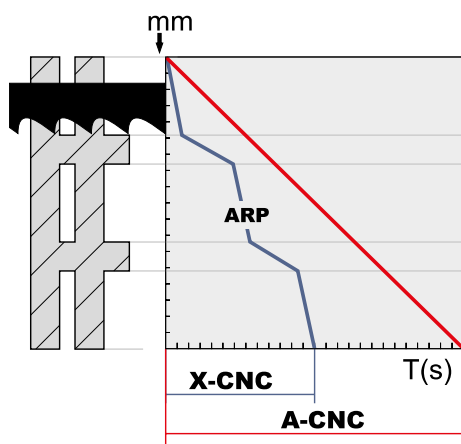
X versions of semi-automatic HA saws:

- ▶ The larger semi-automatic saws can also be supplied with the X extension.
- ▶ These are versions that do not use metrology to monitor the material feed and cannot be set up automatically. The length setting is performed manually by the operator.

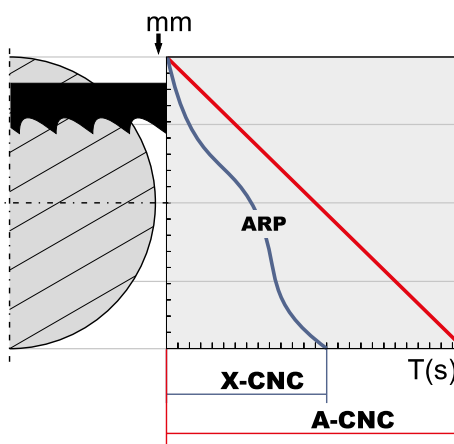
- ▶ The X version of our semi-automatic saws also has a 64-bit control unit as standard.
- ▶ This allows for:
- ▶ automatic control of saw arm movements depending on the material's current cutting resistance value

- ▶ electronic setting of the saw arm's top and bottom end positions
- ▶ Cutting speed, cutting pressure and workpiece feed control via a display
- ▶ The X control has a PC interface for connecting external control components.

Function of the ARP system for high precision cuts and a long service life



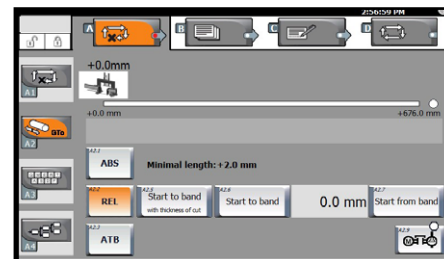
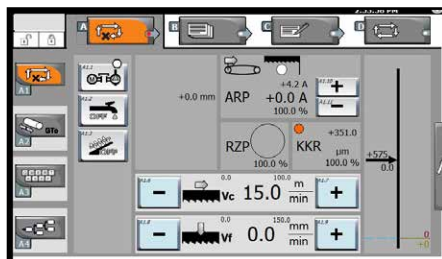
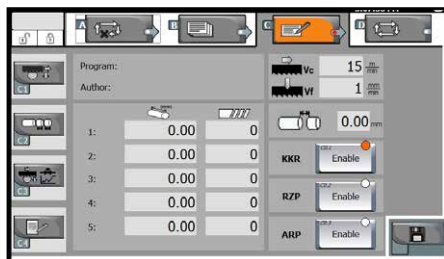
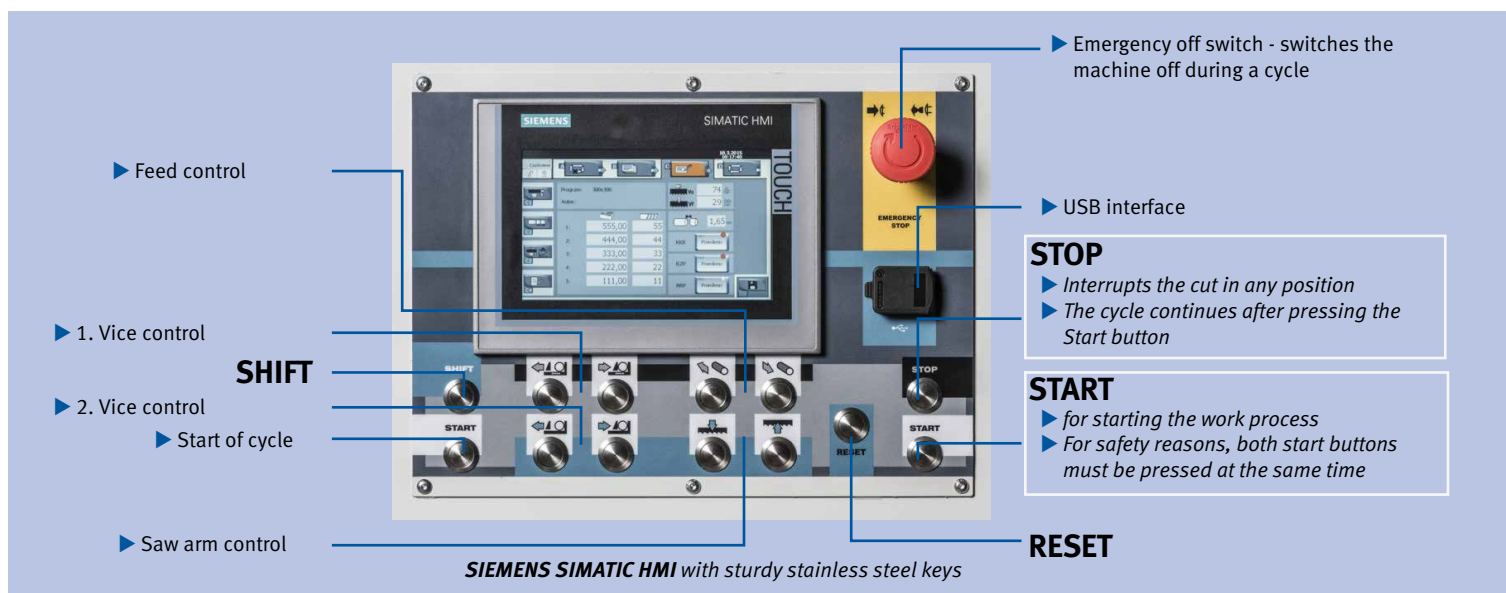
The ARP system ensures automatic control of saw arm movements depending on the material's current cutting resistance value based on the cutting forces that occur. As the resistance increases, the ARP system automatically reduces the lower speed, thus ensuring optimum cutting results with a high degree of angular precision.



As the resistance drops, the ARP accelerates the lowering speed. The automatically optimised lowering speed automates the work process and increases the saw blade's service life. The ARP system is delivered with all X version saws.
This helps you save money with improved cutting results, and you benefit from the improved saw band service life.



The control panel of our X models for 90° cuts

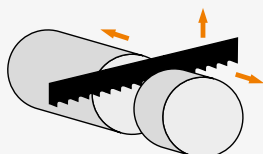


- ▶ User-friendly environment:
- ▶ The control system communicates with the machine operator in the operator's native language
- ▶ Graphical touchscreen with intuitive control and understandable pictograms
- ▶ Four windows for optimising the required parameters for a quick start of operations
- ▶ Technical description
- ▶ Data transmission option via the USB interface
- ▶ Multiple access levels protected by user accounts
- ▶ Easy uploading of new software versions

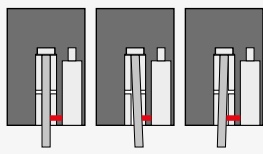
- ▶ **Function description:**
- ▶ The control system supports creating up to 1000 programs with cutting parameters. Each program can be quickly found with a search filter (depending on the quality of the material, order number, number of workpieces, cut lengths, cutting data and much more).
- ▶ **KKR mode (option):** Cutting path control permanently measures the straightness of the cut
- ▶ **ARP mode:** The automatic cut feed control has been further optimised so that the operator only need to set the load stages (Amperes) during the cut. We recommend using this function when cutting materials with different wall thicknesses (cross cut).

- ▶ **RZP mode:** Cut feed control by setting the cutting zones to match the cross-section shape and size of the material to be processed (recommended with HM saw bands)
- ▶ **Setting up the material feed:**
- ▶ Normal, staged, *TOF* (= incremental), *CMU* (= feed with automatic opening of the cutting zone)
- ▶ **Improved GTO mode:**
- ▶ Feed to the selected position. Functions: ABS, REL, ATB
- ▶ **ATB mode:**
- ▶ Automatic movement of the material into the cutting zone, without needing to perform a pilot cut after inserting new material into the machine.

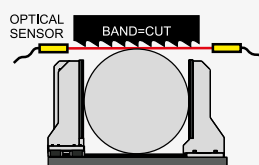
Available as a factory option for the models HMBS 300 x 300 CNC, HMBS 400 x 400 CNC, HMBS 510 x 510 CNC, HMBS 700 x 750 CNC, HMBS 850 x 1000 CNC:



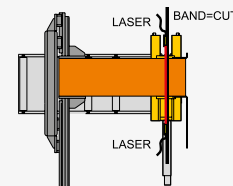
- **ATB:** Automatic opening of the cutting zone. The saw band moves out of the cutting channel in a zero-contact operation, thus ensuring a longer saw band service life (suitable for HM bands).



- **KKR:** Cut path monitoring,
The saw band guide has sensors
that monitor the cut path. If the cut
deviates, this information is sent to
the control and the cutting speed is
reduced.



- *Automatic detection of the top material end point: two sensors send a signal to the hydraulics once the light barrier reaches the top end point of the material. The control then switches from fast running to processing speed.*



- ▶ *Automatic material start detection: a laser detects the start of the material (0 position of the control).*

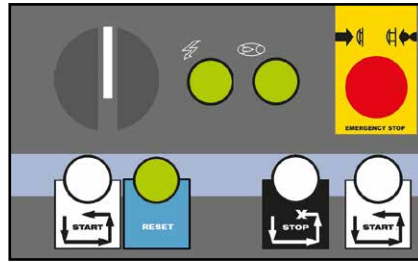
The control panels on our H models



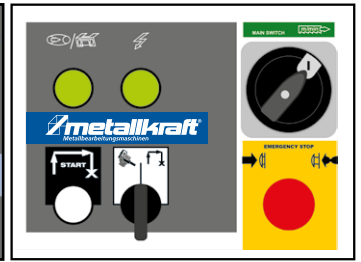
BMBS 220 x 250 H-G



BMBS 250 x 315 H-DG

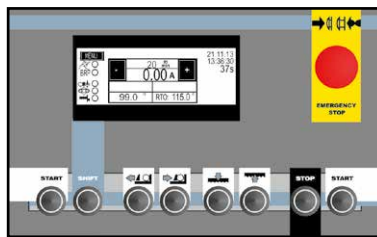


BMBS 300 x 320 H-DG
BMBS 360 x 500 H-DG

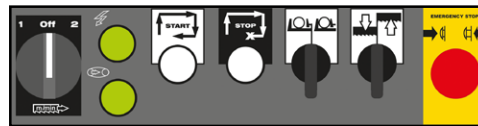


BMBS 230 x 280 H-DG

The control panels on our HA models

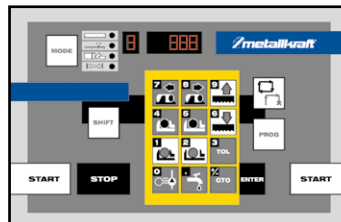


BMBS 230 x 280 HA-DG
BMBS 360 x 500 HA-DG
BMBS 460 x 600 HA-DG
HMBS 440 x 600 HA-DG
HMBS 500 x 750 HA-DG
HMBS 400 HA



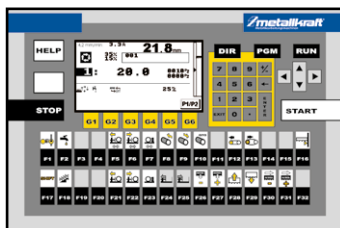
BMBS 250 x 315 HA-DG

The control panels on our CNC models

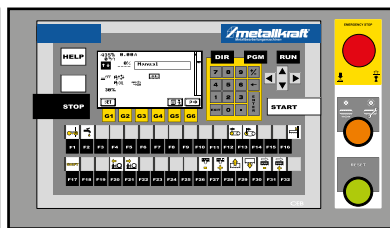


BMBS 220 x 250 CNC-G
BMBS 240 x 280 CNC-G
BMBS 350 x 400 CNC-G
BMBS 300 x 320 CNC-G
HMBS 400 CNC

The control panels on our X models



BMBS 300 x 320 CNC-DG X 1500
HMBS 440 x 600 NC-DG X 2000
HMBS 500 x 750 HA-DG X
HMBS 500 x 750 NC-DG X 2000
HMBS 600 x 1100 HA-DG X
HMBS 510 x 510 HA X-S
HMBS 550 x 1300 X
HMBS 600 HA X
HMBS 600 CNC X 2000



HMBS 700 x 1400 X
HMBS 1000 HA X
HMBS 1000 CNC X 4000
HMBS 1200 x 1400 HA X
HMBS 1200 x 1400 CNC X
HVMB 850 x 1000 Xtreme
HVMB 1200 x 1600 Xtreme
HVMB 1250 x 1600 Portal



HMBS 300 x 300 CNC X
HMBS 400 x 400 HA X
HMBS 400 x 400 CNC X
HMBS 510 x 510 HA X
HMBS 510 x 510 CNC X
HMBS 700 x 750 HA X
HMBS 700 x 750 CNC X
HMBS 850 x 1000 HA X
HMBS 850 x 1000 CNC X
HMBS 850 x 1000 HA-X-VS



Our Partner Pegas was founded in **1990** by the engineer Joseph Gonda. PEGAS is short for **Pepa Gonda** and (Czech "**a**" sons. From the outset, the company has focused on assembling and selling metal-cutting band saws and circular saws. In **1991**, the family-owned business PEGAS-QUATTRO GmbH was founded; the "quattro" here stands for the four family members.

1993 – The company opens up its own facility in Ruprechtov and increases production. The company expands into metal construction; a cutting shop with premium equipment means that new types of band saws can be tested.

1994 – Semi-automatic sawing machines from the PROFESIONAL series are developed; business activities are extend to Slovakia and Poland.

2000 – PEGAS is ISO 2000 certified; the first automatic saws are developed, and the country looks to further European countries.

2001 – Two large-scale column saws in the HERKULES series are built; the company goes through a boom in business and development. A new site is purchases in Slavkov u Brna and the company name is changed to PEGAS-GONDA GmbH.



Assembly of swivel frame saws

2003 – Band saw production is completely relocated to Slavkov; the largest Czech band saw, the GOLEM 1600 x 1200 (with the ability to cut blocks of machine steel vertically and horizontally) is built.

2004 – In five facilities with a floor space of 7000 m², 65 employees create the full range of 40 band saw types with cutting dimensions from 100 – 1600 mm; 80% of production is delivered abroad. The main activity is serial production of band saws, however, the company also works intensively on developing new saws, improving the current range, and developing custom saws.



Showroom



Assembly shops for 2-column models



Magnetic drills

Deburring

Metal grinding



CNC laser machines and CNC lathes



Welding shop

Cutting

Notching & punching

2005 – PEGAS starts to modernise: new CNC machines are purchased, and there is a push towards building new production facilities. Expansion into new markets abroad pushes forward. At the international mechanical engineering fair in Brno, PEGAS presents new band saw types, including the 850x100 GOLEM, 500x500 HERKULES and a completely new model range.

2006 – Building work on a new production facility starts; the car park for the steadily increasing number of staff is extended, and new saw types are launched: 510x510 HERKULES, 290x290 A-CNC, and the unique 1200x1600 GOLEM and 1250x1600 PORTAL sawing machines. The 1200x1600 saw is a huge success at the international mechanical engineering fair in Brno, where it is exhibited to the general public for the first time. The machine wins the gold medal for the best exhibit at the fair, and is also praised by TECHNIK+MARKT (a trade journal) and nominated in the contest for the product of the year.

2007 – In March of this year, the company celebrated the 15th anniversary of its founding; it builds a new production facility to mark the occasion. The new, premium premises again help to speed up assembly.

2009 – Pegas-Gonda's state-of-the-art technology means that the engineering company can shift to 100% in-house production. The biggest benefit of in-house research and development is, in particular, being able to respond quickly to customer requirements in the field of tailored solutions. The speed and quality of design in Design and Engineering are based on future-orientated CAD 3 software tools; three-dimensional components are routed directly through the CNC processing centres.

Annual production increases to 8,000 band saws. Five new models are developed, and a belt driven chip conveyor is introduced.

2011 – The modernisation drive of the company site pushes on; in particular the drives and routes inside the complex are modernised, thus improving the quality and efficiency of saw shipment.

Pegas products are exhibited and presented at more than 20 of the major engineering fairs each year.

Thanks to many investments in development of the state-of-the-art production facilities (supported by CNC lathes, CNC laser machines, welding robots) and many optimisations in manufacturing, Pegas-Gonda s.r.o. has achieved an excellent market position and established itself as a stable, traditionally managed enterprise on the domestic and international markets.

Bending

Presses

Circular saws

Roller conveyors

Band saws

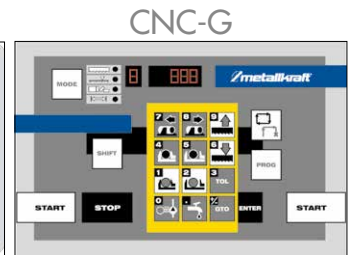
BMBS 220 x 250 H-G / BMBS 220 x 250 CNC-G

Hydraulic swivel frame metal-cutting band saw for mitre cuts of up to +60°. CNC-G: Fully-automatic

Manual

Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Horizontally swivelling saw arm
- ▶ 2-pole saw band motor with saw band speeds of 30 and 65 m/min.
- ▶ Saw band tension monitoring - electro-mechanically via micro-switches
- ▶ When the saw arm lifts, the solenoid valve locks the lowering cylinder in top position, thus removing the need for additional locking on the cylinder
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ After completing the cutting action, the saw band automatically stops in the bottom end position.
- ▶ Saw arm lowering through gravity or manually (H-G only)
- ▶ With continuously variable, constant saw arm lowering speed via hydraulic cylinder (H-G only)
- ▶ A fully-hydraulic system controls both vices, the material feed movement and the saw arm work steps (CNC-G only)



! For an exhaustive explanation of the controls, see pages 205 – 209

! For an exhaustive explanation of the controls, see pages 205 – 209



BMBS 220 x 250 H-G

Scope of supply

- ▶ Saw band
- ▶ Coolant pump
- ▶ Operating tool
- ▶ Adjustable stop (for H-G only)
- ▶ Swarf clearing brush (for CNC-G only)



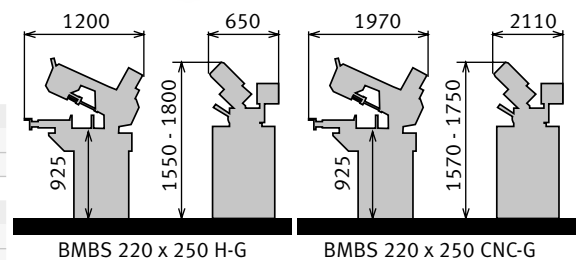
BMBS 220 x 250 CNC-G

! We are always happy to perform sample cutting for your material. Call us for details!

Model	BMBS 220 x 250 H-G	BMBS 220 x 250 CNC-G
Art. no.	3680001	3690066

Technical specifications		
Motor output 3 x 400 V/50 Hz	0.75-1.1 kW	0.75-1.1 kW
Speed stages	2	2
Saw band speeds	30/65 m/min.	30/65 m/min.
Saw band dimensions	2450 x 27 x 0.9 mm	2450 x 27 x 0.9 mm
Dimensions (L x W x H) in mm	1200 x 650 x 1800	1970 x 2110 x 1800
Table height material feed	925 mm	925 mm
Weight	270 kg	550 kg
Max. feed length for 1 x feed unit	-	500 mm
Min. remaining workpiece length CNC operation	-	250 mm**
Transport packaging flat rate*	TPFR 4 = € 79.00	

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT. ** Recommended minimum value. This value can change depending on the weight of surface of the material to be cut.



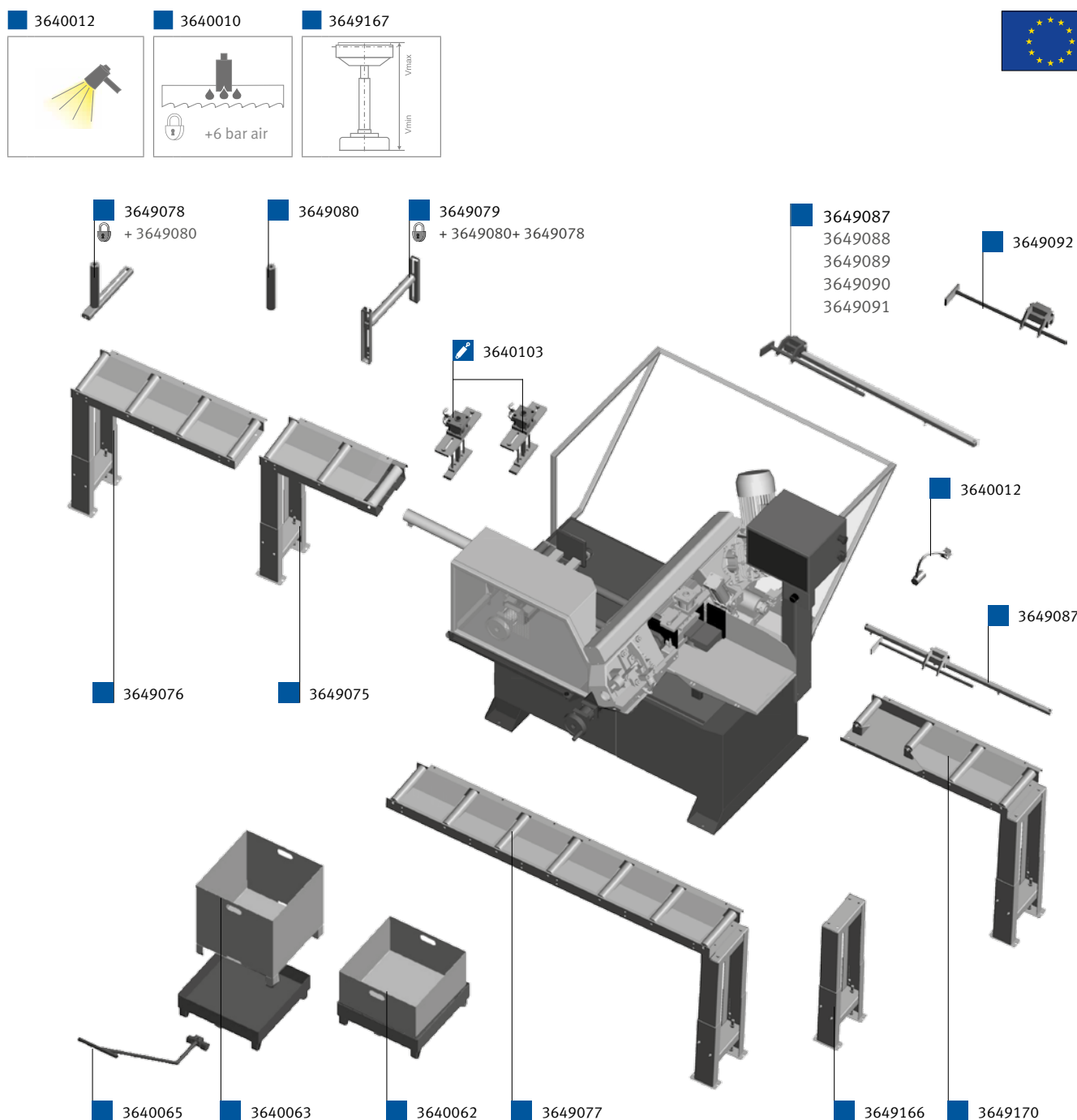
BMBS 220 x 250 H-G

BMBS 220 x 250 CNC-G

Clamping range

mm	0°	45°	60°	b a x b
220	160	90	X	
120 *	85 *	55 *	X	
230 x 190	160 x 90	90 x 90	230 x 120	

* recommended values



Optional accessories (only available from factory)	Art. no.
Micro-spraying system	3640010
Workplace lighting (for CNC-G only)	3640012
Motor + gearbox for cutting stainless steel (23/46 m/min.)	3640076
Accessories for CNC-G	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Roller conveyors 290 mm (incl. legs)	
1000 x 290 mm, roller conveyor 200 kg/m	3649076
2000 x 290 mm, roller conveyor 200 kg/m	3649077
Connecting roller conveyor f. 60° cuts between saw and roller conveyor incl. connecting parts	3649170
700 x 290 mm feed roller conveyor (for CNC-G only)*	3649075

Accessories, roller conveyors 290 mm	Art. no.
lateral Steering roll 200 mm, mobile	3649078
(requires: 3649080*)	
lateral Guide roller 200 mm, rigid	3649080
Horizontal bundle clamping roller 290 mm	3649079
(requires: 3649080* + 3649078*)	
Additional leg for increasing the load bearing capacity	3649166
Roller support, height-adjustable, width 290 mm, load-bearing capacity 200 kg	3649167
1m folding stop with measuring scale (H-G only)	3649087
2m folding stop with measuring scale (H-G only)	3649088
3m folding stop with measuring scale (H-G only)	3649089
4m folding stop with measuring scale (H-G only)	3649090
5m folding stop with measuring scale (H-G only)	3649091
additional stop (H-G only)	3649092
M42 saw bands	
2450 x 27 x 0.9 mm 5-8 tpi Sprint	3655122
2450 x 27 x 0.9 mm 10-14 tpi Sprint	3655123
2450 x 27 x 0.9 mm 3-4 tpi Sprint Plus	3655120
2450 x 27 x 0.9 mm 2-3 tpi Sprint Plus	3655121
2450 x 27 x 0.9 mm 4-6 tpi Sprint-Medium-VS	3655119

* must be ordered with your order!

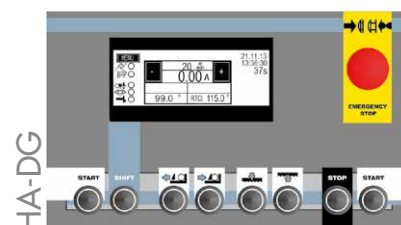
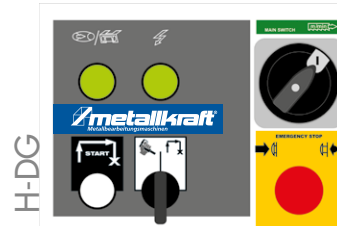
BMBS 230 x 280 H-DG / BMBS 230 x 280 HA-DG

New

Hydraulic swivel frame metal-cutting band saw for mitre cuts from +60° to -45°, HA version fully-hydraulic with semi-automatic mode of operation

Manual

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ Saw band tension monitoring - electro-mechanically via micro-switches
- ▶ with cooling system on the saw band guides
- ▶ with swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ When the saw arm lifts, the solenoid valve locks the lowering cylinder in top position, thus removing the need for additional locking on the cylinder (H-DG)
- ▶ Continuously variable band speed (HA-DG)
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ After completing the cutting action, the saw band automatically stops
- ▶ Saw arm lowering manually or through deadweight (H-DG)
- ▶ BRP - saw band monitoring (HA-DG)
- ▶ After starting the cutting cycle, the vice automatically clamps - after completing the action, it returns to its original position (HA-DG)



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

- ▶ Saw band
- ▶ Coolant pump
- ▶ Operating tool
- ▶ Vice with quick release
- ▶ Cut probe (HA-DG)
- ▶ Swivelling control panel (HA-DG)

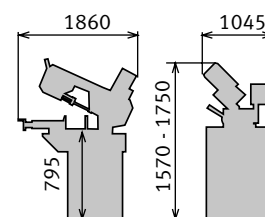
! We are always happy to perform sample cutting for your material. Call us for details!

New









New

Model	BMBS 230 x 280 H-DG	BMBS 230 x 280 HA-DG
Art. no.	3680013	3690026
Technical specifications		
Motor output 3 x 400 V/50 Hz	0.75-1.1 kW	1.5 kW
Speed stages	2	Continuously variable
Saw band speeds	35/70 m/min.	20 – 100 m/min.
Saw band dimensions	2720 x 27 x 0.9 mm	2720 x 27 x 0.9 mm
Dimensions (L x W x H)	1650 x 885 x 1860 mm	1860 x 1045 x 1750 mm
Table height material feed	795 mm	795 mm
Weight	280 kg	395 kg
min. remaining workpiece length	22 mm	22 mm
Transport packaging flat rate*	TPFR 4 = € 79.00	TPFR 4 = € 79.00

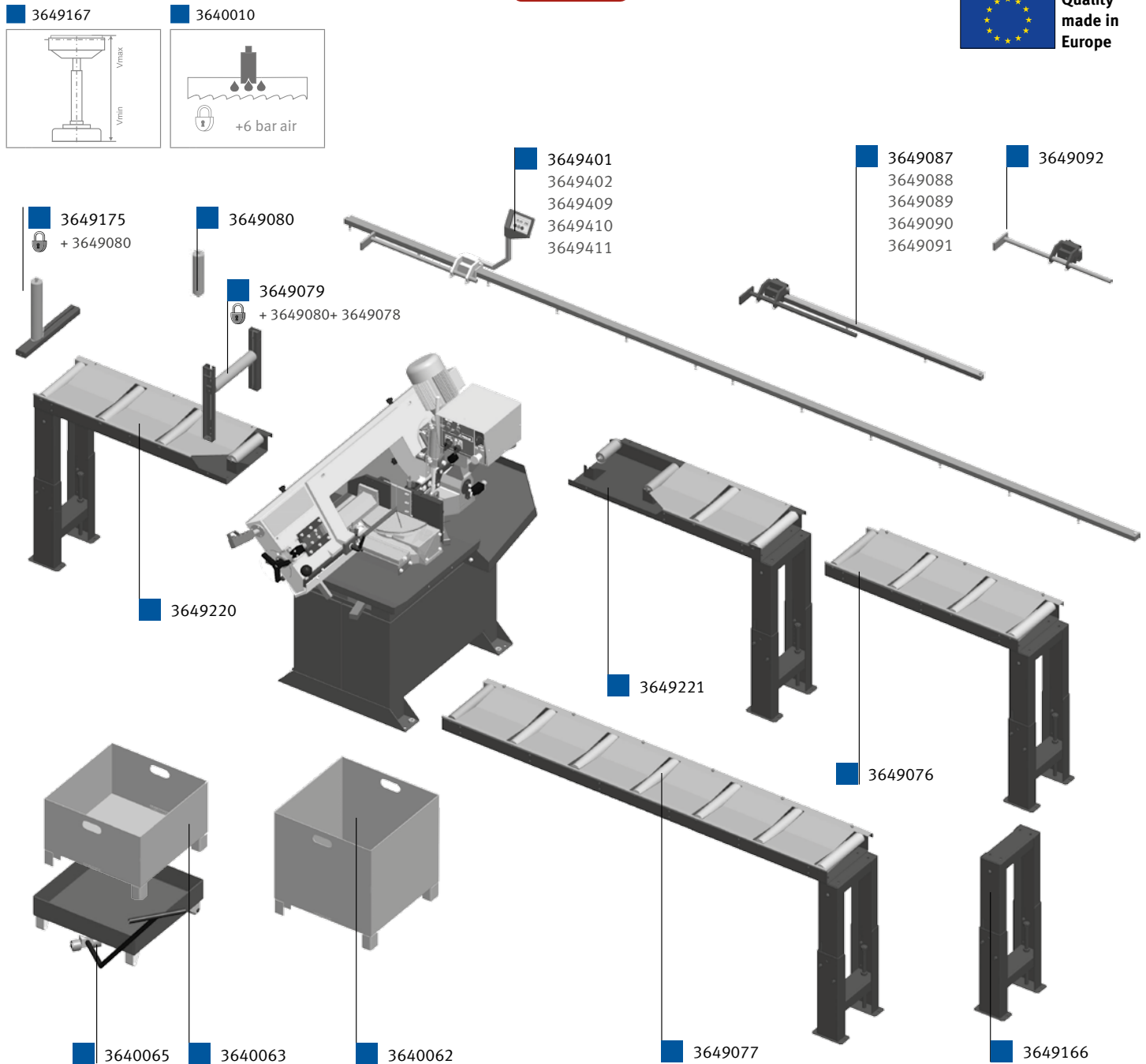
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

clamping range					
mm	 0°	 45°	 60°	 45°	 ^b _a a x b
	230	195	125	185	X
	150 *	110 *	80 *	110 *	X
	280 x 180	180 x 170	120 x 110	180 x 120	180 x 120

* recommended values



Optional accessories (only available from factory)	Art. no.	Accessories, roller conveyors 290 mm	Art. no.
Micro-spraying system	3640010	2m folding stop with measuring scale (requires: 3649077*)	3649088
Accessories		3m folding stop with measuring scale	3649089
Workpiece container	3640062	4m folding stop with measuring scale	3649090
Swarf container	3640063	5m folding stop with measuring scale	3649091
Trolley for swarf container and workpiece container	3640065	additional stop	3649092
Roller conveyor width 290 mm		1m stop with digital measuring display	3649401
1000 x 290 mm, roller conveyor 200 kg/m	3649076	2m stop with digital measuring display	3649402
2000 x 290 mm, roller conveyor 200 kg/m	3649077	3m stop with digital measuring display	3649409
Connecting roller conveyor 1000 x 290 mm feed side	3649220	4m stop with digital measuring display	3649410
Connecting roller conveyor 1000 x 290 mm discharge side	3649221	5m stop with digital measuring display	3649411
Accessories, roller conveyors 290 mm		Saw bands	
lateral Steering roll 200 mm, mobile (requires: 3649080*)	3649078	Saw band 2720x27x0.9 5-8 tpi M42 Sprint	3655508
lateral Guide roller 200 mm, rigid	3649080	Saw band 2720x27x0.9 6-10 tpi M42 Sprint	3655510
Horizontal bundle clamping roller 290 mm (requires: 3649080* + 3649078*)	3649079	Saw band 2720x27x0.9 10-14 tpi M42 Sprint	3655514
Additional leg for increasing the load bearing capacity	3649166	Saw band 2720x27x0.9 2-3 tpi M42 Sprint Plus	3655603
Roller support, height-adjustable, width 290 mm, load-bearing capacity 200 kg	3649167	Saw band 2720x27x0.9 3-4 tpi M42 Sprint Plus	3655604
1m folding stop with measuring scale (requires: 3649076*)	3649087	Saw band 2720x27x0.9 4-6 tpi M42 Sprint-Medium-VS	3655606
		Saw band 2720x27x0.9 2-3 tpi M51 Sprint Plus	3655703
		Saw band 2720x27x0.9 3-4 tpi M51 Sprint Plus	3655704
		Saw band 2720x27x0.9 4-6 tpi M51 Sprint Plus	3655706

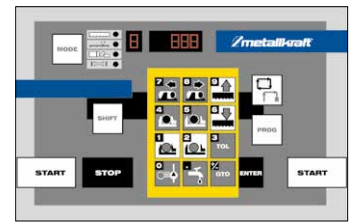
* must be ordered with your order!

BMBS 240 x 280 CNC-G

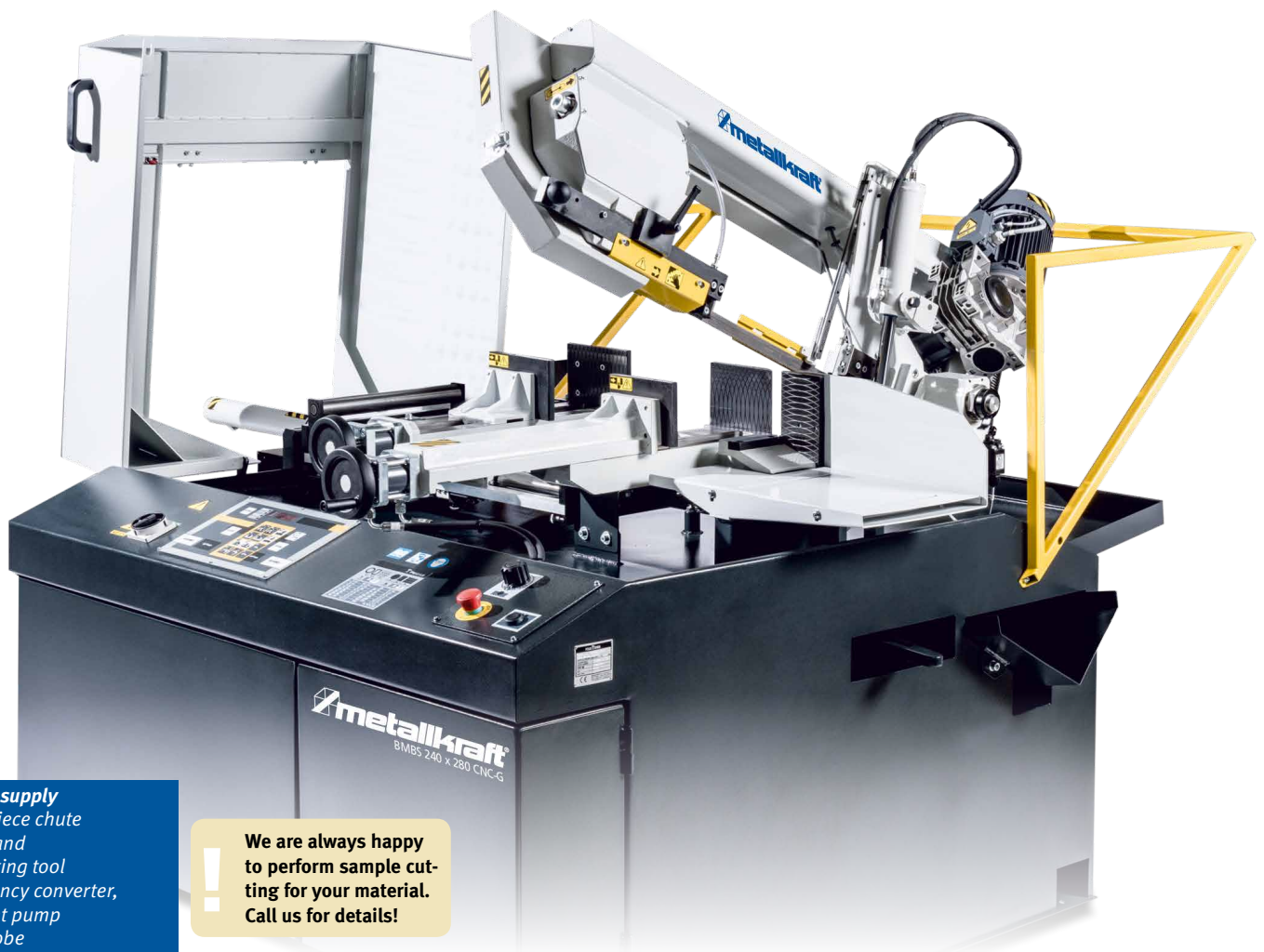
Fully-automatic hydraulic swivel frame metal-cutting band saw for mitre cuts of up to +60°

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ A fully-hydraulic system controls both vices, the material feed movement and the saw arm work steps
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor
- ▶ Motor includes overload protection
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Micro-switches control the upper and lower end positions of the saw arm
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Includes frequency converter for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ BRP - saw band monitoring

Automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

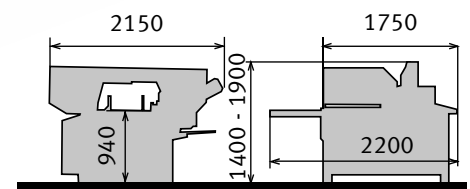
- ▶ Workpiece chute
- ▶ Saw band
- ▶ Operating tool
- ▶ Frequency converter,
- ▶ Coolant pump
- ▶ Cut probe

! We are always happy to perform sample cutting for your material. Call us for details!





Model	BMBS 240 x 280 CNC-G
Art. no.	3690045

Technical specifications	
Motor output 3 x 400 V/50 Hz	2.4 kW
Speed stages	Continuously variable
Saw band speeds	20 – 100 m/min.
Saw band dimensions	2980 x 27 x 0.9 mm
Dimensions (L x W x H)	2150 x 2200 x 1900 mm
Table height material feed	940 mm
Weight	800 kg
max. feed length for 1 x feed unit	500 mm
min. remaining workpiece length CNC/HA operation	170 - 20 mm
Transport packaging flat rate*	TPFR 5 = € 100.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.** Recommended minimum value. This value can change depending on the weight of surface of the material to be cut.



Clamping range

mm	0°	45°	60°	 $\frac{b}{a \times b}$
	240	190	120	X
	150 *	110 *	80 *	X
	280 x 220	190 x 170	120 x 150	280 x 120

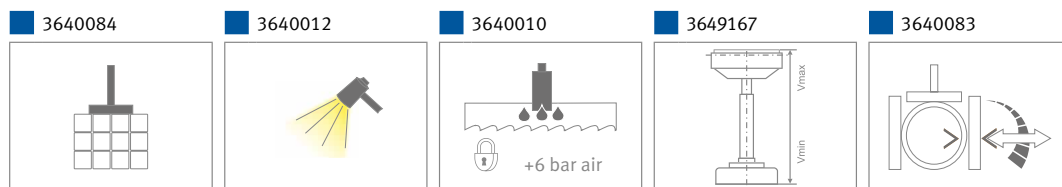
* recommended values



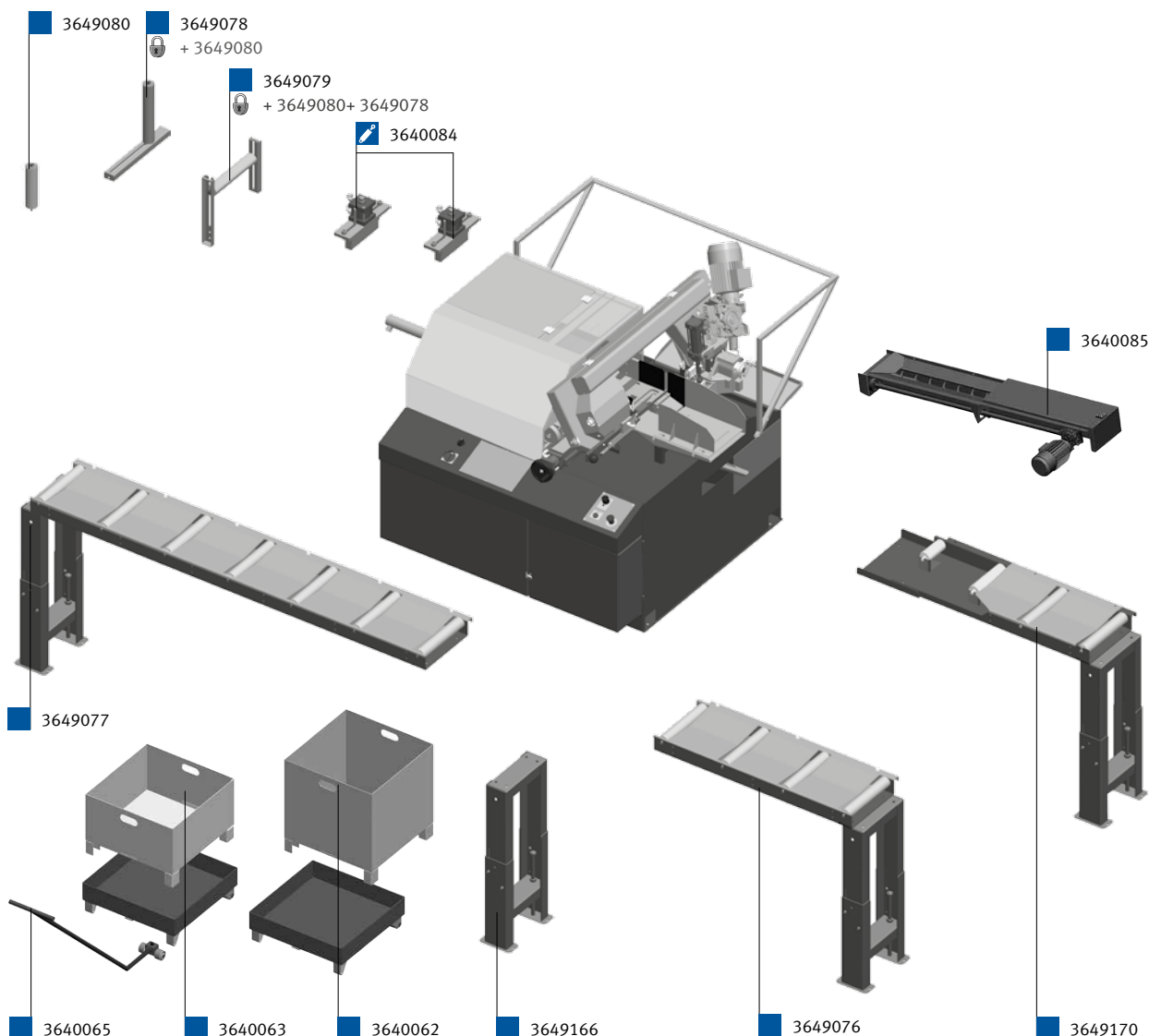
Bundle cutting with clamping device



max. bundle cut $\frac{b}{a \times b}$



S mm	Vmin mm	Vmax mm
290	760	980



Optional accessories (only available from factory)	Art. no.	Accessories, roller conveyors 290 mm	Art. no.
Pressure regulator on vice	3640083	Lateral guide roller 200 mm, moving (requires: 3649080*)	3649078
Hydr. bundle clamping unit	3640084	lateral Guide roller 200 mm, rigid	3649080
Swarf conveyor	3640085	Horizontal bundle clamping roller 290 mm (requires: 3649080* + 3649078*)	3649079
Micro-spraying system	3640010	Additional leg for increasing the load bearing capacity	3649166
Workplace lighting	3640012	Roller support, height-adjustable, width 290 mm, load-bearing capacity 200 kg	3649167
Accessories		M42 saw bands	
Workpiece container	3640062	2980 x 27 x 0.9 mm 3-4 tpi Sprint Plus	3655013
Swarf container	3640063	2980 x 27 x 0.9 mm 2-3 tpi Sprint Plus	3655115
Trolley for swarf container and workpiece container	3640065	2980 x 27 x 0.9 mm 4-6 tpi Sprint-Medium-VS	3655116
Roller conveyors 290 mm		2980 x 27 x 0.9 mm 5-8 tpi Sprint	3655206
1000 x 290 mm, roller conveyor 200 kg/m	3649076	2980 x 27 x 0.9 mm 10-14 tpi Sprint	3655207
2000 x 290 mm, roller conveyor 200 kg/m	3649077	* must be ordered with your order!	
Connecting roller conveyor f. 60° cuts between saw and roller conveyor incl. connecting parts	3649170		

BMBS 250 x 315 H-DG / BMBS 250 x 315 HA-DG

Hydraulic swivel frame metal-cutting band saw for mitre cuts from +60° to -45°, HA version fully-hydraulic with semi-automatic mode of operation

Manual

Semi-automatic

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ When the saw arm lifts, the solenoid valve locks the lowering cylinder in top position, thus removing the need for additional locking on the cylinder
- ▶ Saw band tension monitoring - electro-mechanically via micro-switches
- ▶ with cooling system on the saw band guides
- ▶ with swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Saw arm lowering manually or through deadweight (H-DG)
- ▶ After completing the cutting action, the saw band automatically stops
- ▶ After starting the cutting cycle, the vice automatically clamps - after completing the action, it returns to its original position (HA-DG)



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

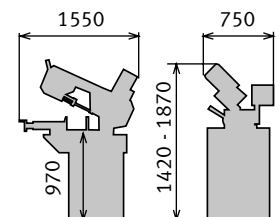
- ▶ Saw band
- ▶ Operating tool
- ▶ Cross-cut fence 1 metre
- ▶ Swarf brush
- ▶ Coolant pump

We are always happy to perform sample cutting for your material. Call us for details!

Model	BMBS 250 x 315 H-DG	BMBS 250 x 315 HA-DG
Art. no.	3680007	3690093

Technical specifications		
Motor output 3 x 400 V/50 Hz	0.75-1.1 kW	0.75-1.1 kW
Speed stages	2	2
Saw band speeds	37/74 m/min.	37/74 m/min.
Saw band dimensions	2825 x 27 x 0.9 mm	2825 x 27 x 0.9 mm
Dimensions (L x W x H)	1550 x 750 x 1870 mm	1550 x 750 x 1870 mm
Table height material feed	970 mm	970 mm
Weight	380 kg	420 kg
min. remaining workpiece length	14 mm	14 mm
Transport packaging flat rate*	TPFR 4 = € 79.00	TPFR 4 = € 79.00

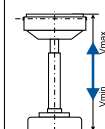
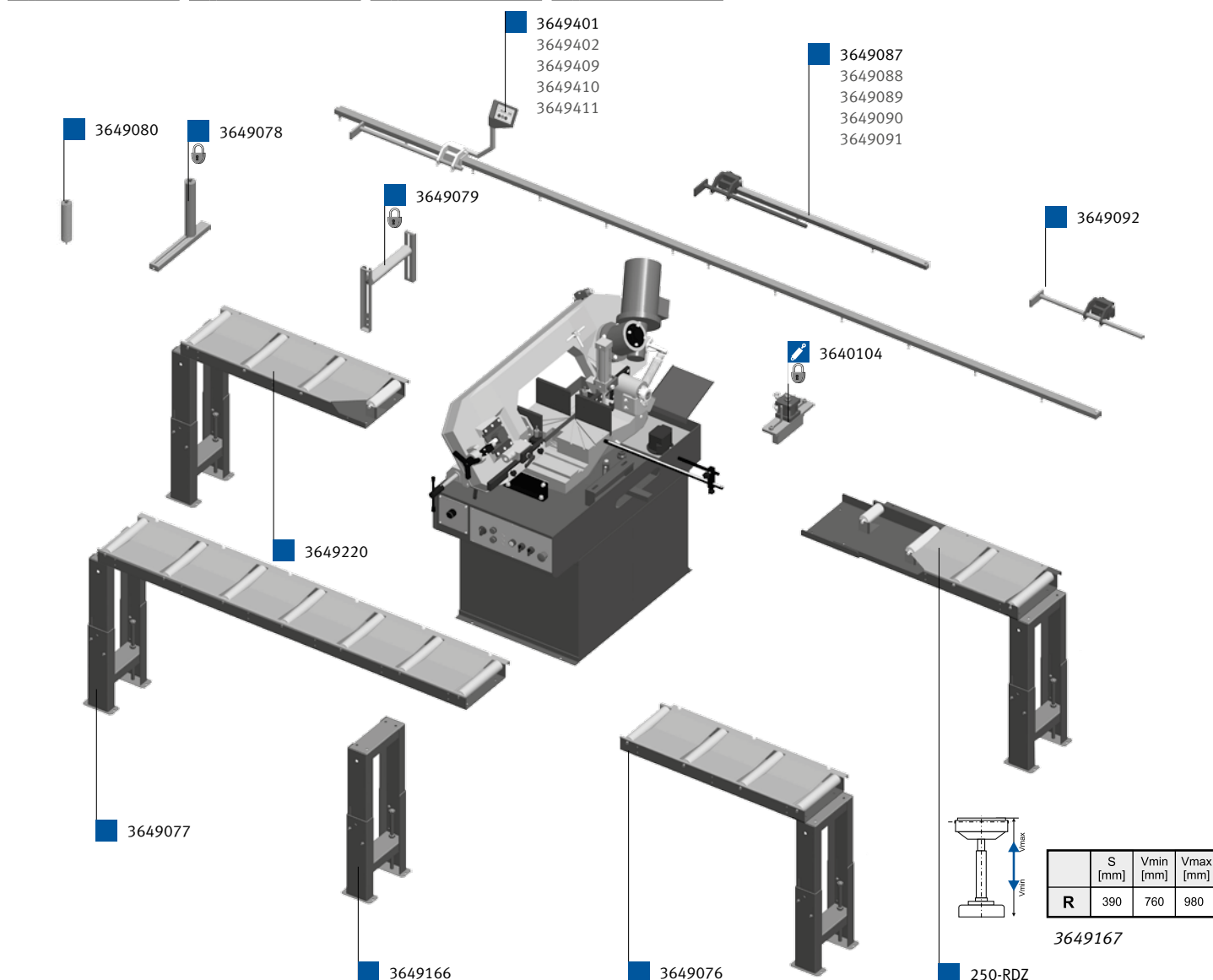
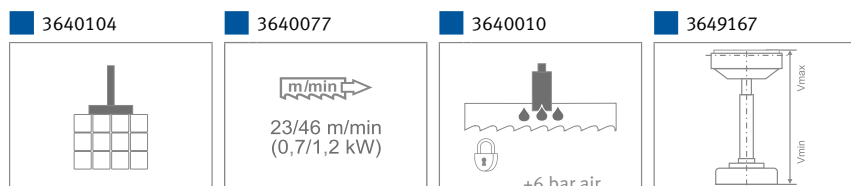
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range BMBS 250 x 315 H-DG / 250 x 315 HA-DG

mm	0°	45°	60°	45°	a ^b
250	250	190	120	170	-
150*	150*	110*	80*	110*	-
290 x 200	190 x 140	120 x 140	200 x 70	200 x 120	-

* recommended values



	S [mm]	Vmin [mm]	Vmax [mm]
R	390	760	980

3649167

Optional accessories (only available from factory)	Art. no.
Micro-spraying system	3640010
Motor + gearbox for cutting stainless steel (23/46 m/min.)	3640077
Hydraul. Bundle clamping unit (for HA-DG only)	3640104
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Roller conveyors 290 mm (incl. legs)	
1000 x 290 mm, roller conveyor 200 kg/m	3649076
2000 x 290 mm, roller conveyor 200 kg/m	3649077
1000 x 290 mm connecting roller conveyor feed side	3649220
1000 x 290 mm connecting roller conveyor discharge side	3649221
Accessories, roller conveyors 290 mm	
Lateral guide roller, moving (requires: 3649080*)	3649078
Lateral guide roller, rigid	3649080

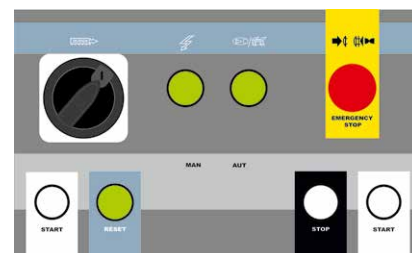
Accessories, roller conveyors 290 mm	Art. no.
Horizontal bundle clamping roller 290 mm (requires: 3649080* + 3649078*)	3649079
Additional leg for increasing the load bearing capacity	3649166
Roller support, height-adjustable, width 290 mm, load-bearing capacity 200 kg	3649167
1m folding stop with measuring scale	3649087
2m folding stop with measuring scale	3649088
3m folding stop with measuring scale	3649089
4m folding stop with measuring scale	3649090
5m folding stop with measuring scale	3649091
additional stop	3649092
1m stop with digital measuring display	3649401
2m stop with digital measuring display	3649402
3m stop with digital measuring display	3649409
4m stop with digital measuring display	3649410
5m stop with digital measuring display	3649411
M42 saw bands	
2825 x 27 x 0.9 mm 3-4 tpi Sprint Plus	3655220
2825 x 27 x 0.9 mm 2-3 tpi Sprint Plus	3655221
2825 x 27 x 0.9 mm 4-6 tpi Sprint-Medium-VS	3655219
2825 x 27 x 0.9 mm 5-8 tpi Sprint	3655222
2825 x 27 x 0.9 mm 10-14 tpi Sprint	3655223

* must be ordered with your order!

Hydraulic swivel frame metal-cutting band saw for mitre cuts from +60° to -45°.

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ With hydraulically controlled sawing functions
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor
- ▶ Motor includes overload protection
- ▶ Ball-bearing borne turntable
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Swivelling saw arm from +60° to -45°
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Vice with manual material clamping unit and quick release unit for lateral adjustment of the vice

Manual



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Cross-cut fence 1 metre
- ▶ Swarf clearing brush
- ▶ Swivelling control panel
- ▶ Coolant pump

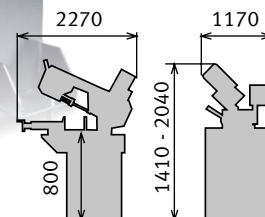
! We are always happy to perform sample cutting for your material. Call us for details!

Model	BMBS 300 x 320 H-DG
Art. no.	3680012

Technical specifications

Motor output 3 x 400 V/50 Hz	1.4-2.0 kW
Speed stages	2
Saw band speeds	35/70 m/min.
Saw band dimensions	3660 x 27 x 0.9 mm
Dimensions (L x W x H)	2270 x 1170 x 2040 mm
Table height material feed	800 mm
Weight	548 kg
min. remaining workpiece length	30 mm
Transport packaging flat rate*	TPFR 4 = € 79.00

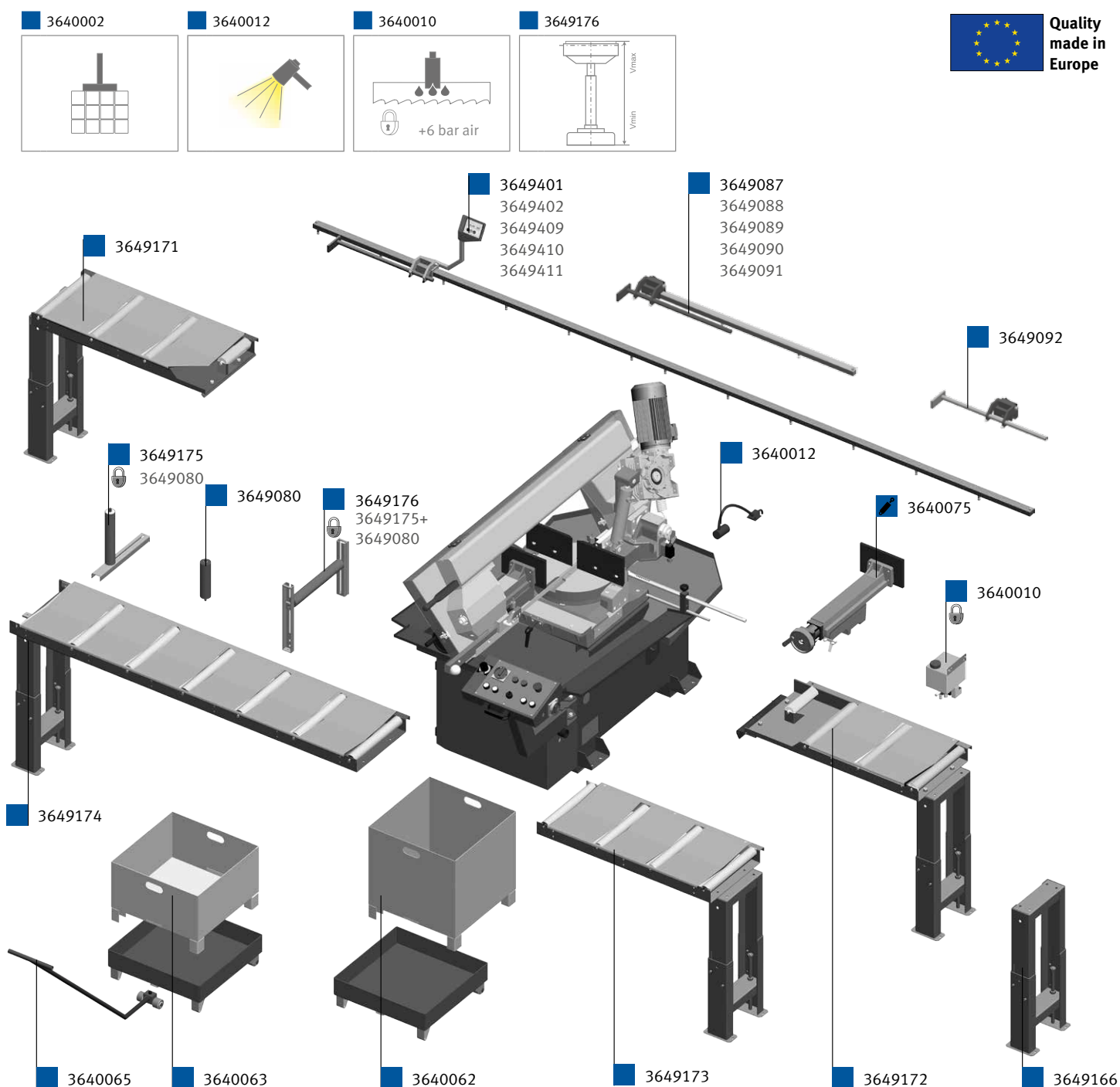
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°	45°	60°	45°	a ^b
	300	300	200	280	-
	180*	110*	80*	110*	-
	320 x 300	305 x 250	200 x 200	260 x 200	230 x 160

* recommended values



Optional accessories (only available from factory)	Art. no.
Workplace lighting	3640012
Micro-spraying system	3640010
Manual bundle clamping unit	3640002
Vice downstream of cut	3640075
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Roller conveyors 390 mm	
Connecting roller conveyor 390 mm feed side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649171
Connecting roller conveyor 390 mm discharge side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649172
1000 x 390 mm, roller conveyor 200 kg/m	3649173
2000 x 390 mm, roller conveyor 200 kg/m	3649174

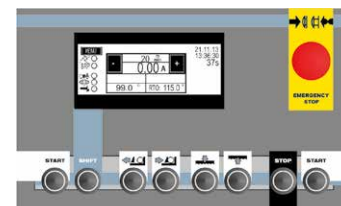
Accessories, roller conveyors 390 mm	Art. no.
lateral Steering roll 200 mm, mobile (requires: 3649080*)	3649175
lateral Guide roller 200 mm, rigid	3649080
Horizontal bundle clamping roller 390 mm (requires: 3649080 + 3649175)	3649176
Additional leg for increasing the load bearing capacity	3649166
Roller support, height-adjustable, width 390 mm, load-bearing capacity 200 kg	3649177
1 m folding stop with measuring scale	3649087
2 m folding stop with measuring scale	3649088
3 m folding stop with measuring scale	3649089
4 m folding stop with measuring scale	3649090
5 m folding stop with measuring scale	3649091
1 m stop with digital measuring display	3649401
2 m stop with digital measuring display	3649402
3 m stop with digital measuring display	3649409
4 m stop with digital measuring display	3649410
5 m stop with digital measuring display	3649411
additional stop	3649092

* must be ordered with your order!

Semi-automatic swivel frame metal-cutting band saw for mitre cuts of +60° up to -45° with frequency converter

Semi-automatic

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ With completely hydraulically controlled sawing functions
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor
- ▶ Motor includes overload protection
- ▶ Ball-bearing borne turntable
- ▶ After starting the cutting cycle, the vice automatically clamps - after completing the action, it returns to its original position (HA-DG)
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Swivelling saw arm from +60° to -45°
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ With frequency converter for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ BRP - saw band monitoring
- ▶ Hydraulic vice with manual quick release for lateral adjustment
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ No need to adjust the top end point



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

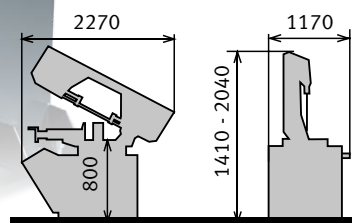
- ▶ Saw band
- ▶ Operating tool
- ▶ Cross-cut fence 1 metre
- ▶ Cut probe
- ▶ Swivelling control panel
- ▶ Coolant pump

! We are always happy to perform sample cutting for your material. Call us for details!

Model	BMBS 300 x 320 HA-DG
Art. no.	3690041

Technical specifications	
Motor output 3 x 400 V/50 Hz	2.4 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min.
Saw band dimensions	3660 x 27 x 0.9 mm
Dimensions (L x W x H)	2270 x 1170 x 2040 mm
Table height material feed	800 mm
Weight	585 kg
min. remaining workpiece length	30 mm
Transport packaging flat rate*	TPFR 4 = € 79.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°	45°	60°	45°	b a x b
	300	300	200	240	X
	180 *	110 *	80 *	110 *	X
	320 x 300	300 x 250	200 x 200	260 x 200	230 x 120

* recommended values



Bundle cutting with clamping device

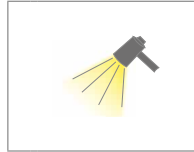


max. bundle cut a x b

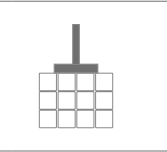
3640150



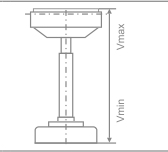
3640012



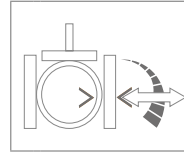
3640086



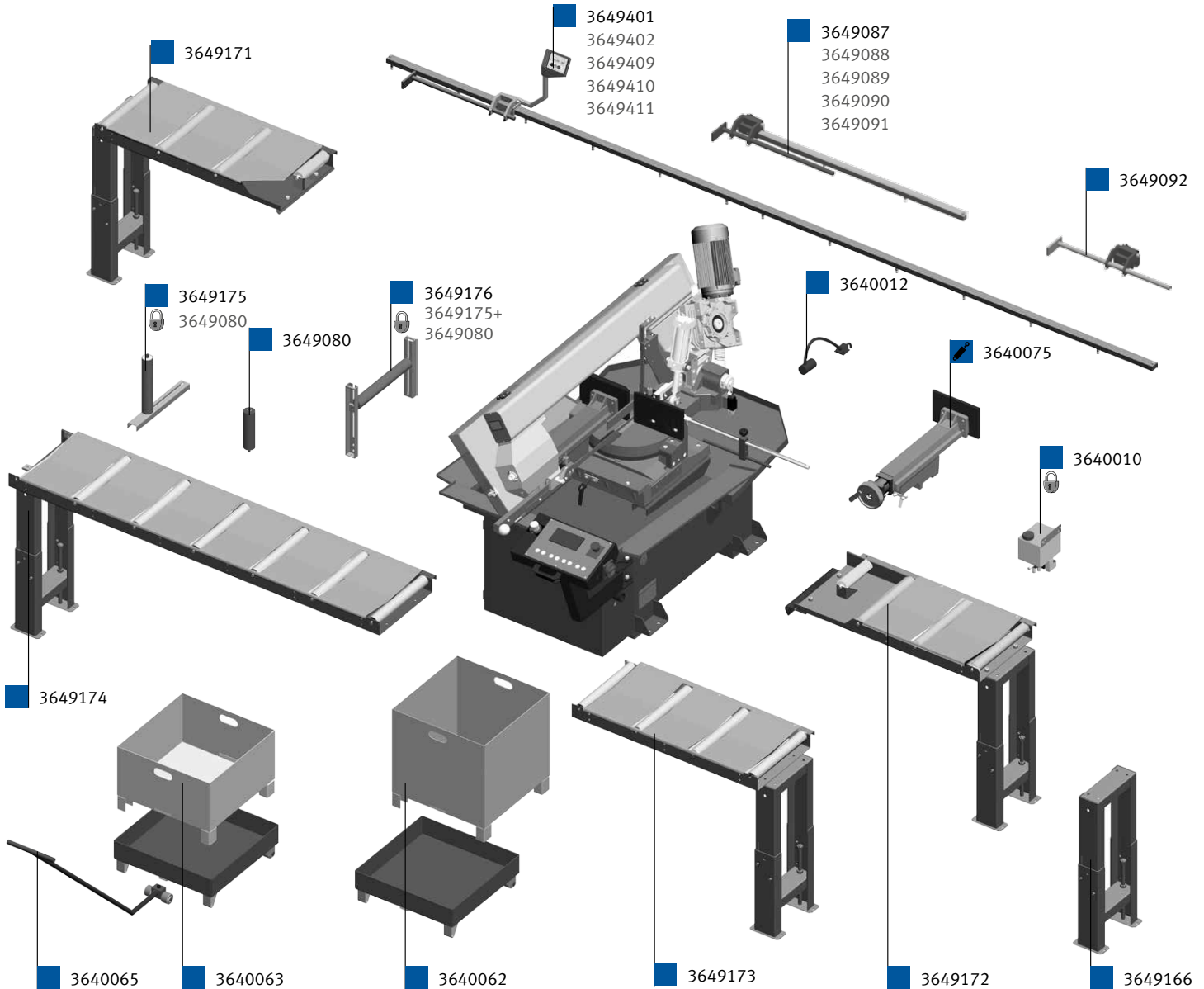
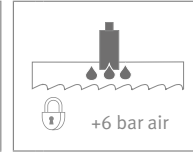
3649177



3640069



3640010



Optional accessories (only available from factory)

Art. no.	
3640012	Workplace lighting
3640010	Micro-spraying system
3640069	Pressure regulator on vice
3640086	Hydr. bundle clamping unit for HA version
3640150	Digital angle display on saw arm
3640107	Vice downstream of cut with hydraulic material clamping

Accessories

3640062	Workpiece container
3640063	Swarf container
3640065	Trolley for swarf container and workpiece container

Roller conveyors 390 mm

3649171	Connecting roller conveyor 390 mm feed side, f. 60° cuts between saw and roller conveyor, 200 kg/m
3649172	Connecting roller conveyor 390 mm discharge side, f. 60° cuts between saw and roller conveyor, 200 kg/m
3649173	1000 x 390 mm, roller conveyor 200 kg/m
3649174	2000 x 390 mm, roller conveyor 200 kg/m

Accessories, roller conveyors 390 mm

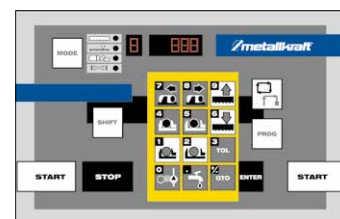
Art. no.	
3649175	lateral Guide roller 200 mm, moving (requires 3649080)
3649080	lateral Guide roller 200 mm, rigid
3649176	Horizontal bundle clamping roller 390 mm (requires: 3649080 + 3649175)
3649166	Additional leg for increasing the load bearing capacity
3649177	Roller support, height-adjustable, width 390 mm, load-bearing capacity 200 kg
3649087	1 m folding stop with measuring scale
3649088	2 m folding stop with measuring scale
3649089	3 m folding stop with measuring scale
3649090	4 m folding stop with measuring scale
3649091	5 m folding stop with measuring scale
3649401	1 m stop with digital measuring display
3649402	2 m stop with digital measuring display
3649409	3 m stop with digital measuring display
3649410	4 m stop with digital measuring display
3649411	5 m stop with digital measuring display
3649092	additional stop

* must be ordered with your order!

Fully-automatic CNC-controlled swivel frame metal-cutting band saw for mitre cuts of up to +60°

- ▶ Hydraulically controlled system for both vices, the material feed motion and the saw arm's up and down motion
- ▶ Ball-bearing borne turntable
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ BRP - saw band monitoring
- ▶ The jaws on the two vices are equipped with long stroke hydraulic cylinders as standard; this removes the need to preset to the material cross-section to be cut

Automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



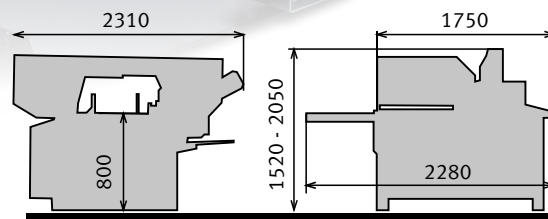
Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Digital angle display
- ▶ Cut probe
- ▶ Swarf brush
- ▶ Swivelling control panel
- ▶ With band tension monitoring
- ▶ Long stroke cylinder on both vices
- ▶ Frequency converter,
- ▶ Coolant pump





Model	BMBS 300 x 320 CNC-G
Art. no.	3690055

Technical specifications	
Motor output 3 x 400 V/50 Hz	2.4 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min.
Saw band dimensions	3660 x 27 x 0.9 mm
Dimensions (L x W x H)	2310 x 2710 x 2050 mm
Table height material feed	800 mm
Weight	800 kg
Remaining piece length	(CNC) 115+20 mm (HA)
Transport packaging flat rate*	TPFR 4 = € 79.00

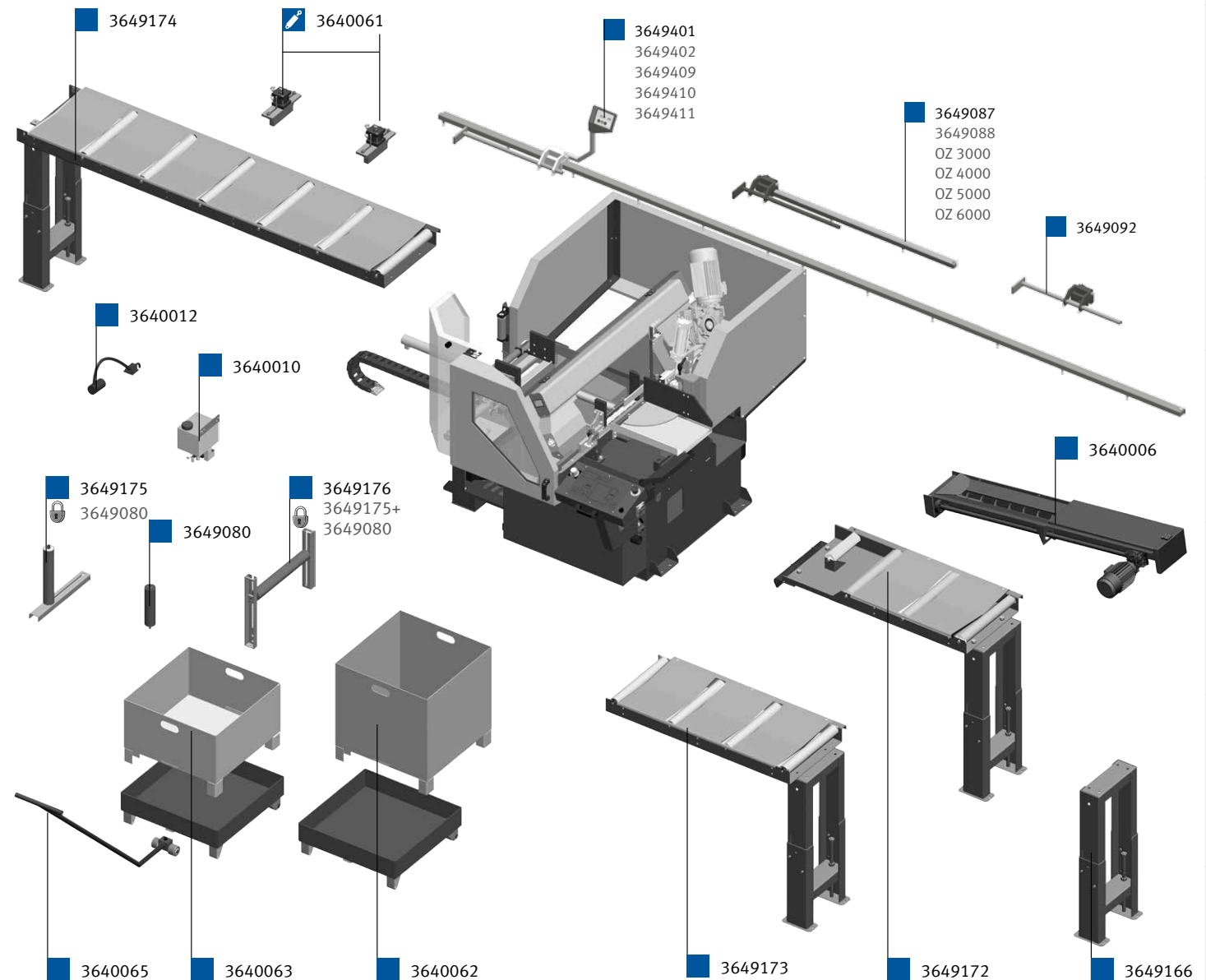
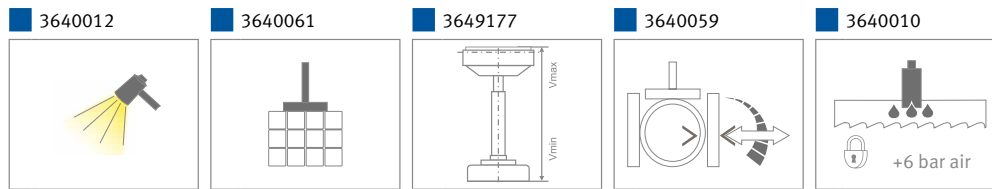
We are always happy to perform sample cutting for your material. Call us for details!



Clamping range

mm	0°	45°	60°	 a x b
	300	300	200	X
	180 *	110 *	80 *	X
	320 x 300	300 x 250	200 x 200	230 x 120

* recommended values



Optional accessories (only available from factory)

Optional accessories (only available from factory)	Art. no.
Workplace lighting	3640012
Micro-spraying system	3640010
Pressure regulator on vice	3640059
Hydr. bundle clamping unit	3640061
Chip conveyor incl. swarf container	3640006

Accessories

Accessories	Art. no.
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065

Roller conveyors 390 mm

Roller conveyors 390 mm	Art. no.
Connecting roller conveyor 390 mm discharge side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649172
1000 x 390 mm, roller conveyor 200 kg/m	3649173
2000 x 390 mm, roller conveyor 200 kg/m	3649174

Accessories, roller conveyors 390 mm

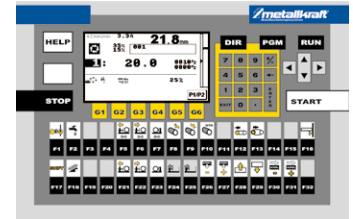
Accessories, roller conveyors 390 mm	Art. no.
lateral Guide roller 200 mm, moving (requires 3649080)	3649175
lateral Guide roller 200 mm, rigid	3649080
Horizontal bundle clamping roller 390 mm (requires: 3649080 + 3649175)	3649176
Additional leg for increasing the load bearing capacity	3649166
Roller support, height-adjustable, width 390 mm, load-bearing capacity 200 kg	3649177

* must be ordered with your order!

Fully-automatic CNC-controlled swivel frame metal-cutting band saw with frequency converter, ARP system and 1500 mm material feed

Automatic

- ▶ In addition to the CNC basic version, equipped with a 64-bit control system
- ▶ with 99 program memory slots with up to 24 setting options for cut lengths per program
- ▶ Includes frequency converter for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ Equipped with an ARP system to accelerate the work process and for a longer saw blade service life
- ▶ Feed vice with a stroke of 1500 mm; faster cutting process for longer workpieces without needing to re-clamp multiple times
- ▶ Saw arm tilted by 25° for a longer saw band service life



! For an exhaustive explanation of the controls, see pages 205 – 209

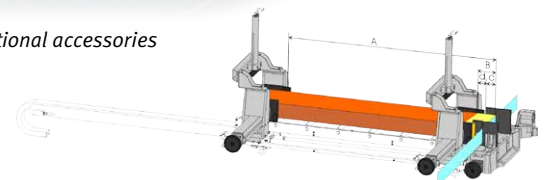


Scope of supply

- ▶ Workpiece chute
- ▶ Saw band
- ▶ Cut probe
- ▶ Operating tool
- ▶ Swarf brush
- ▶ Digital angle display
- ▶ Swivelling control panel
- ▶ With band tension monitoring
- ▶ With frequency converter as standard
- ▶ Coolant pump

! We are always happy to perform sample cutting for your material. Call us for details!

Fig. with optional accessories



Model	BMBS 300 x 320 CNC-DG X 1500
Art. no.	3690101

Technical specifications	
Motor output 3 x 400 V/50 Hz	2.4 kW
Speed stages	Continuously variable
Saw band speeds	20 – 100 m/min.
Saw band dimensions	3660 x 27 x 0.9 mm
Dimensions (L x W x H)	2280 x 4632 x 2177 mm
Table height material feed	941 mm
Weight	1200 kg
max. feed length for 1 x feed unit - A	490 mm
min. remaining workpiece length CNC operation - B	80 mm +20 mm**
Transport packaging flat rate*	TPFR 5 = € 100.00

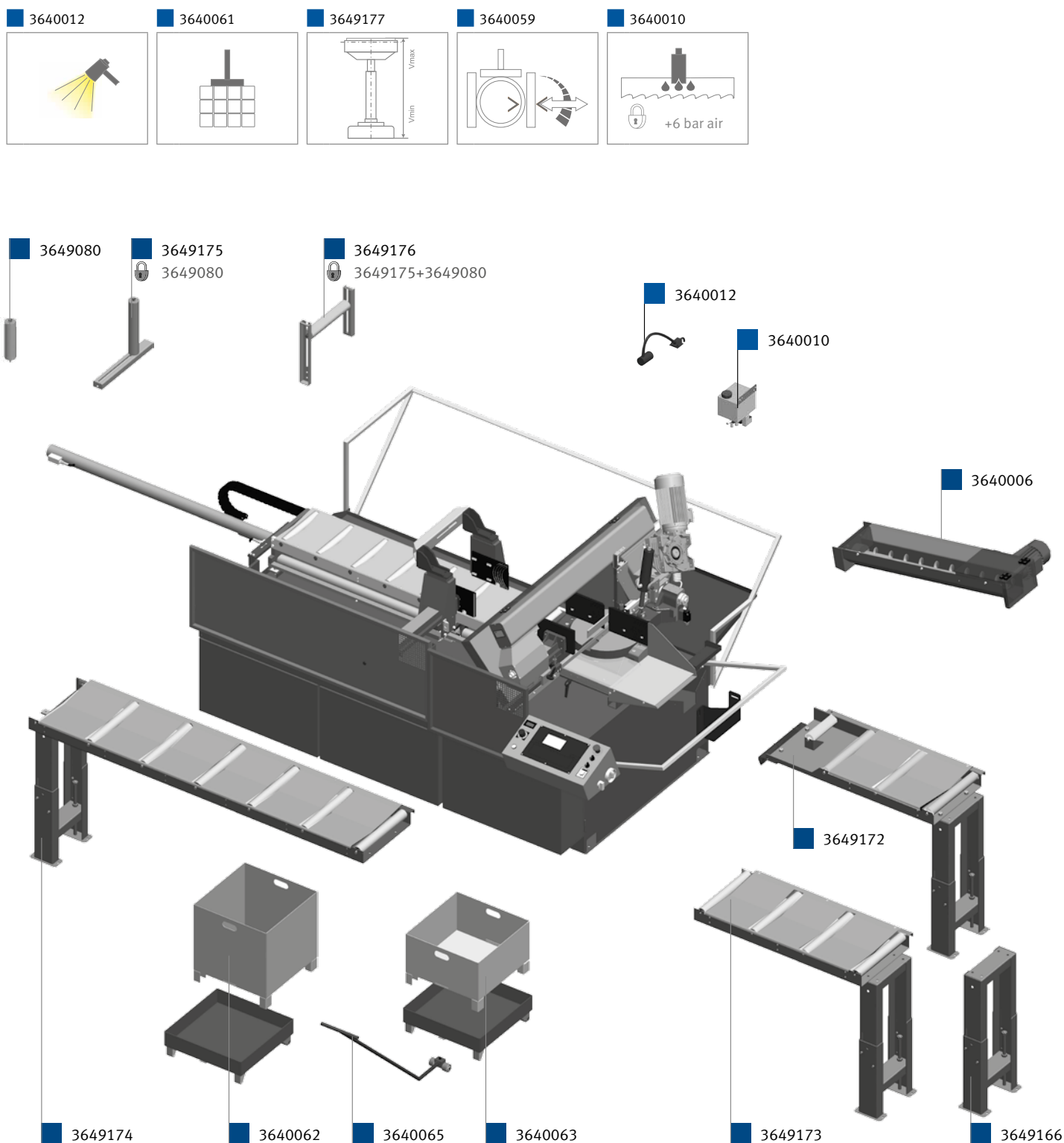
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.
 **recommended minimum value. This value can change depending on the weight of surface of the material to be cut.

Clamping range

mm	0°	45°	60°	45°	a x b
	300	300	200	240	X
	180 *	110 *	80 *	150 *	X
	320 x 300	300 x 250	200 x 200	260 x 200	260 x 200

* recommended values

a x b max. bundle cut



Optional accessories (only available from factory)	Art. no.
Pressure regulator on vice	3640059
Hydr. bundle clamping unit	3640061
Chip conveyor incl. swarf container	3640006
Workplace lighting	3640012
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065

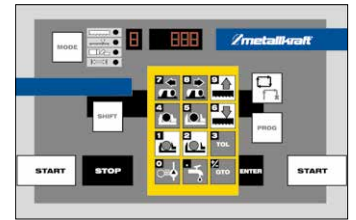
Roller conveyors 290 mm / 390 mm**	Art. no.
1000 x 390 mm, roller conveyor 200 kg/m	3649173
2000 x 390 mm, roller conveyor 200 kg/m	3649174
Connecting roller conveyor 390 mm discharge side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649172
Accessories, roller conveyors 290 mm/390 mm	
lateral Guide roller 200 mm, moving (requires 3649080)	3649175
lateral Guide roller 200 mm, rigid	3649080
Horizontal bundle clamping roller 390 mm (requires: 3649080 + 3649175)	3649176
Additional leg for increasing the load bearing capacity	3649166

* must be ordered with your order! ** (incl. legs and connecting adapter)

Fully-automatic hydraulic swivel frame metal-cutting band saw for mitre cuts from -45° to +45° with frequency converter

- ▶ designed for industrial use
- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Extremely stable and robust structure
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ with rugged 3-phase motor
- ▶ BRP - saw band monitoring
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ Motor includes overload protection
- ▶ Saw band guide with adjustable tungsten carbide plates

Automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

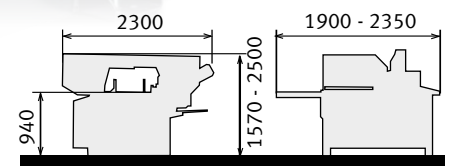
- ▶ Workpiece chute
- ▶ Saw band
- ▶ Operating tool
- ▶ Digital angle display
- ▶ Swarf clearing brush
- ▶ Frequency converter

! We are always happy to perform sample cutting for your material. Call us for details!





Model	BMBS 350 x 400 CNC-DG
Art. no.	3690004

Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min
Saw band dimensions	4520 x 34 x 1.1 mm
Dimensions (L x W x H)	2300 x 2350 x 2500 mm
Table height material feed	940 mm
Weight	1325 kg
max. feed length for 1 x feed unit	490 mm
min. remaining workpiece length CNC operation	260 mm / (HA) 20 mm**
Transport packaging flat rate*	TPFR 3 = € 59.00


* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.
 **recommended minimum value. This value can change depending on the weight of surface of the material to be cut.

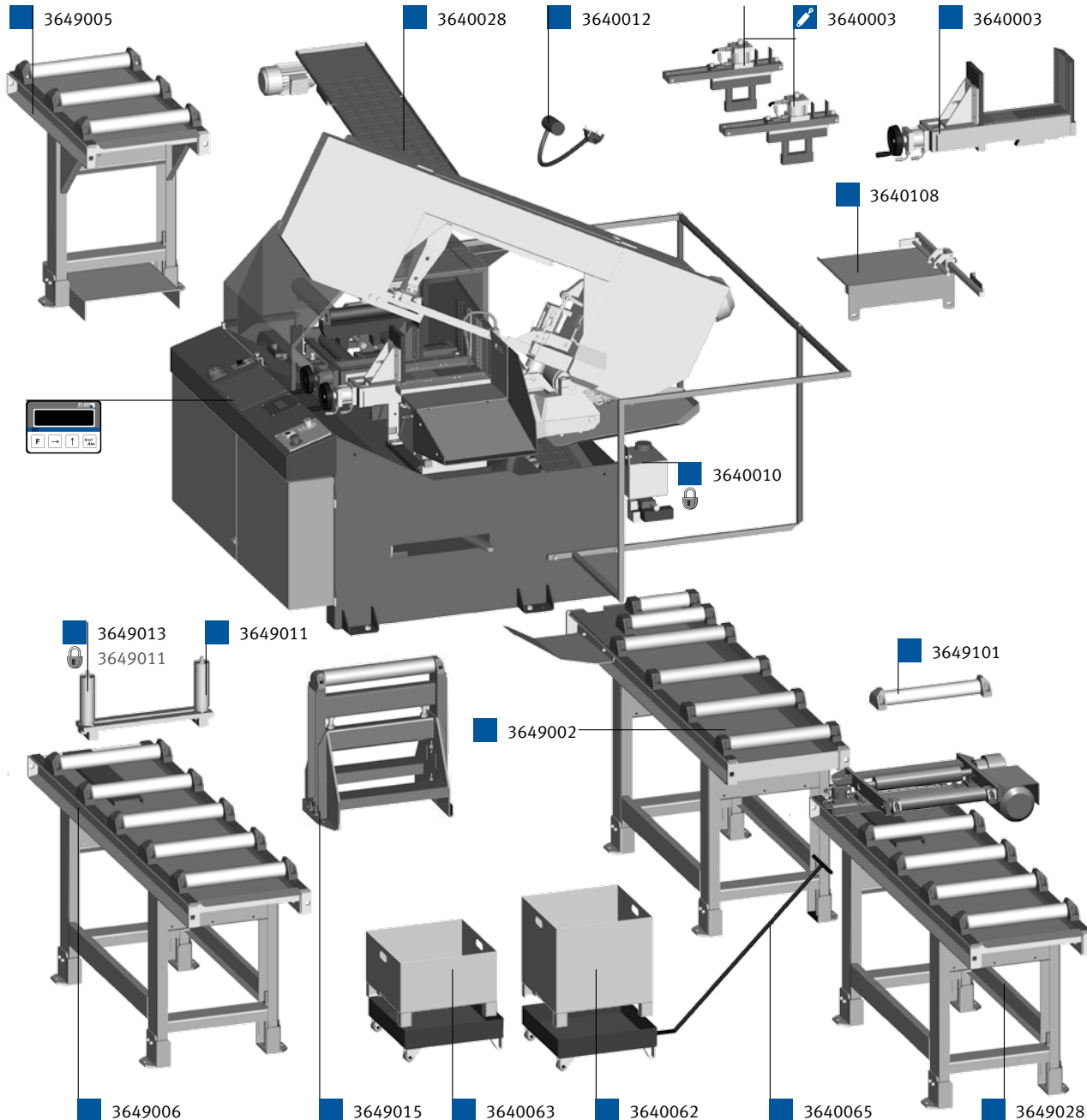
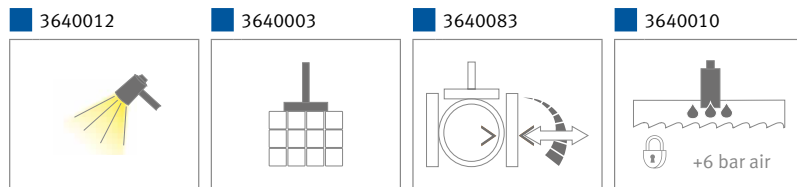


Clamping range

mm	0°	45°	45°	 $\frac{b}{a \times b}$
	350	320	320	X
	250 *	180 *	180 *	X
	400 x 350	330 x 120	330 x 120	400 x 210

* recommended values

 $\frac{b}{a \times b}$ max. bundle cut



Optional accessories (only available from factory)	Art. no.	Roller conveyors 450 mm	Art. no.
Hydr. bundle clamping unit	3640003	Discharge roller conveyor f. 60° cuts between saw and roller conveyor incl. connection plate	3649002
Pressure regulator on vice	3640005	2000 x 450 mm roller conveyor with one driven roller	3649028
Swarf conveyor	3640028	1000 x 450 mm roller conveyor	3649005
Micro-spraying system	3640010	2000 x 450 mm roller conveyor	3649006
Workplace lighting	3640012	Accessories, roller conveyors 450 mm	
Hydraulic vice downstream of cut for clamping the material behind the cut path	3640088	lateral Guide roller, rigid	3649011
Accessories		lateral guide roller, moving for roller conveyors (requires: 3649011*)	3649013
Workpiece container	3640062	height-adjustable roller 700 kg/m	3649015
Swarf container	3640063	Additional roller 450 mm for roller conveyor	3649101
Trolley for swarf container and workpiece container	3640065	Work table behind vice with measuring system	
		1 m length	3640116
		Measuring track extension	3640109

! When ordering a roller conveyor, always state whether you need a feed or discharge conveyor

* must be ordered with your order!

BMBS 360 x 500 H-DG / BMBS 360 x 500 HA-DG

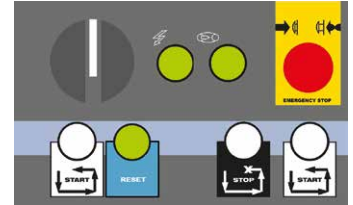
H-DG - hydraulic swivel frame metal-cutting band saw for mitre cuts from +60° to -60°; HA-DG - semi-automatic swivel frame metal-cutting band saw for mitre cuts from +60° to -60° with frequency converter

- ▶ designed for industrial use
- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor including overload protection
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ With mechanical saw band tensioning, and monitoring via micro-switch
- ▶ Cooling system on the saw band guides

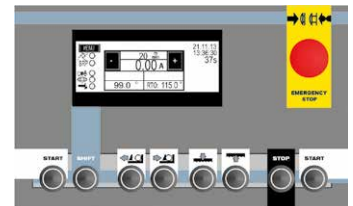
HA-DG only

- ▶ Includes frequency converter for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ With BRP saw band monitoring as standard

Manual



Semi-automatic



For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply










- ▶ Saw band
- ▶ Operating tool
- ▶ Swarf clearing brush
- ▶ Coolant pump
- ▶ Digital angle display (HA-DG only)

We are always happy to perform sample cutting for your material. Call us for details!

Model	BMBS 360 x 500 H-DG	BMBS 360 x 500 HA-DG
Art. no.	3680011	3690090

Technical specifications		
Motor output 3 x 400 V/50 Hz	2.0/2.6 kW	3.0 kW
Speed stages	2	Continuously variable
Saw band speeds	42/85 m/min.	20/100 m/min.
Saw band dimensions	4780 x 34 x 1.1 mm	4780 x 34 x 1.1 mm
Dimensions (L x W x H)	2750 x 950 x 2270 mm	2750 x 950 x 2270 mm
Table height material feed	820 mm	820 mm
Weight	650 kg	715 kg
min. remaining workpiece length	35 mm	35 mm
Transport packaging flat rate*	TPFR 5 = € 100.00	TPFR 5 = € 100.00

Clamping range BMBS 360 x 500 H-DG / BMBS 360 x 500 HA-DG

mm	 0°	 45°	 60°	 45°	 60°	 ^a _b
	360	350	270	360	310	X
	250 *	180 *	130 *	180 *	130 *	X
	500 x 360	400 x 180	270 x 320	400 x 190	310 x 170	500 x 220

* recommended values

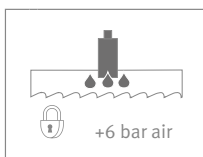
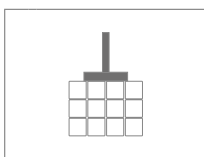
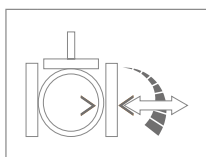
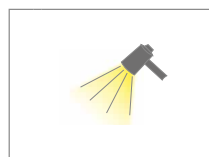
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

3640012

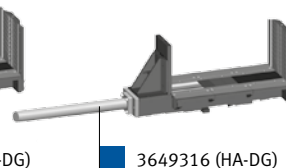
3640146 (HA-DG)

3649331 (H-DG)
3640001 (HA-DG)

3640010



3649317 (H-DG)



3649316 (HA-DG)

3649329
+RB

3649101

3649324

3649325

3649122

3649322

3649123

3649322



3649048

3649051

3649128

3649124

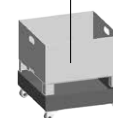


3640062



3640063

3640065



3649322

3649323

3649330

3649321

3649320

3649326
3649327

3649331

Optional accessories (only available from factory)	Art. no.
Micro-spraying system	3640010
Workplace lighting	3640012
Pressure regulator on vice (HA-DG only)	3640146
Vice downstream of cut (HA-DG only)	3649316
Hydr. bundle clamping unit (HA-DG only)	3640001
Vice downstream of cut (H-DG only)	3649317
Manual bundle clamping unit (H-DG only)	3649331
Optional accessories (only available from factory)	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Roller conveyors 520 mm	
Roller conveyor 1000 x 520 mm	3649320
Roller conveyor 2000 x 520 mm	3649321
Motorised roller conveyor 2000 x 520 mm	3649322
Extension to motorised roller conveyor 2000 x 520 mm	3649323
Feed roller conveyor for 60° cuts 2000 x 520 mm	3649324
Feed roller conveyor for 60° cuts, motorised 2000 x 520 mm	3649325
Discharge roller conveyor for 60° cuts 2000 x 520 mm	3649326
Discharge roller conveyor for 60° cuts, motorised 2000 x 520 mm	3649327

Accessories, roller conveyors 520 mm	Art. no.
lateral guide roller, moving for roller conveyors (requires: 3649328*)	3649329
Lateral guide roller, rigid	3649328
height-adjustable roller 700 kg/m	3649330
Additional roller 520 mm (requires: 3649320 + 3649321)	3649311
2 m stop fixed with measuring scale	3649129
2m stop with digital measuring display	3649125
Electro-mechanical stop for motor. Roller conveyor with scale (requires: 3649322)	3649122
Electro-mechanical stop for motor. Roller conveyor/digital display (requires: 3649322)	3649123
2m extension for stop with measuring device	3649048
2m extension for stop with digital display	3649051
M42 saw bands	
4780 x 34 x 1.1 mm 2-3 tpi Sprint Plus	3655400
4780 x 34 x 1.1 mm 3-4 tpi Sprint Plus	3655401
4780 x 34 x 1.1 mm 4-6 tpi Sprint-Medium-VS	3655402
4780 x 34 x 1.1 mm 5-8 tpi Sprint	3655403
4780 x 34 x 1.1 mm 10-14 tpi Sprint	3655404

* must be ordered with your order!

More saw bands and
info on page 283

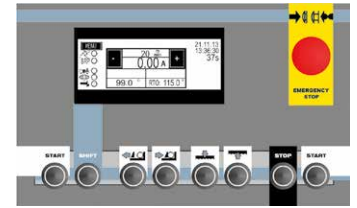
When ordering a roller
conveyor, always state whether
you need a feed or discharge
conveyor

BMBS 460 x 600 HA-DG

Semi-automatic swivel frame metal-cutting band saw for mitre cuts of +60° up to -60° with frequency converter

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ With completely hydraulically controlled sawing functions
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor including overload protection
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Cooling system on the saw band guides
- ▶ The vice is equipped with a long stroke hydraulic cylinder as standard; this removes the need to preset to the material cross-section to be cut
- ▶ The clamping jaws can move throughout the entire clamping area
- ▶ BRP - saw band monitoring
- ▶ With frequency converter for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ With STOP function - the sawing action can be interrupted at any time by pressing a switch. The band continues to run while the arm moves out of the cutting channel

Semi-automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



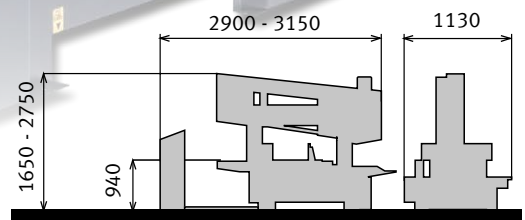
! We are always happy to perform sample cutting for your material. Call us for details!

Scope of supply

- ▶ Workpiece chute
- ▶ Saw band
- ▶ Operating tool
- ▶ Digital angle display
- ▶ Coolant pump

Model	BMBS 460 x 600 HA-DG
Art. no.	3690067
Technical specifications	
Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min.
Saw band dimensions	5380 x 41 x 1.3 mm
Dimensions (L x W x H)	3550 x 1130 x 2750 mm
Table height material feed	940 mm
Weight	1270 kg
Transport packaging flat rate*	TPFR 6 = € 200.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range BMBS 460 x 600 HA-DG

mm	0°	45°	60°	45°	60°	a ^b
	460	460	320	460	320	X
	400 *	280 *	200 *	280 *	190 *	X
	600 x 460	490 x 200	340 x 160	470 x 220	320 x 220	610 x 250

* recommended values



Accessories, roller conveyors 600 mm	Art. no.
lateral guide roller, moving for roller conveyors (requires: 3649053*)	3649053
Lateral guide roller, rigid	3649052
Roller support, height-adjustable, width 600 mm, load-bearing capacity 700 kg	3649260
Additional roller 600 mm	3649261
2 m stop fixed with measuring scale	3649129
2 m stop with digital measuring display	3649125
Electro-mechanical stop for roller conveyor motorised with scale (requires 3649256)	3649122
Electro-mechanical stop for roller conveyor motorised with digital measuring display (requires 3649256)	3649123
2m extension for stop with measuring device	3649048
2m extension for stop with digital measuring display	3649051
M42 saw bands	
5400 x 41 x 1.3 mm 3-4 tpi Sprint Plus	3655230
5400 x 41 x 1.3 mm 2-3 tpi Sprint Plus	3655231
5400 x 41 x 1.3 mm 4-6 tpi Sprint Plus	3655232

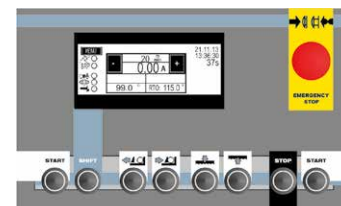
*** must be ordered with your order!**

**More *saw bands* and
*info on page 283***

Semi-automatic two column horizontal metal-cutting band saw for angle cuts of +60° to -60°, designed for industrial use

Semi-automatic

- ▶ For cutting sections and full materials
- ▶ Adjustable micro-switches control the upper and lower end positions of the saw arm
- ▶ The clamping jaws can move throughout the entire cutting area
- ▶ driven cleaning brush for cleaning and maintenance of the saw band
- ▶ Saw band tilted by 7° for improved cutting performance and a longer service life
- ▶ for straight cuts, clamping of the material upstream and downstream of the cut through two-part vice
- ▶ BRP - saw band monitoring
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ Cooling system on the saw band guides



For an exhaustive explanation of the controls, see pages 205 – 209



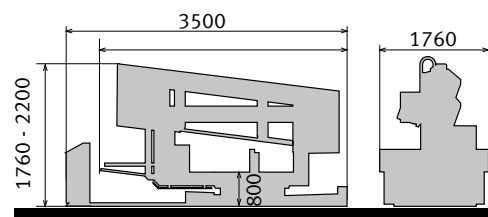
Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Frequency converter,
- ▶ Hydraulic angle adjustment
- ▶ Swarf purging gun
- ▶ Digital angle display
- ▶ Coolant pump

Model	HMBS 440 x 600 HA-DG
Art. no.	3690150

Technical specifications	
Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	6060 x 34 x 1.1 mm
Dimensions (L x W x H)	3500 x 1760 x 2200 mm
Table height material feed	800 mm
Weight	1685 kg
min. remaining workpiece length	50 mm
Transport packaging flat rate*	TPFR 6 = € 200.00

We are always happy to perform sample cutting for your material. Call us for details!

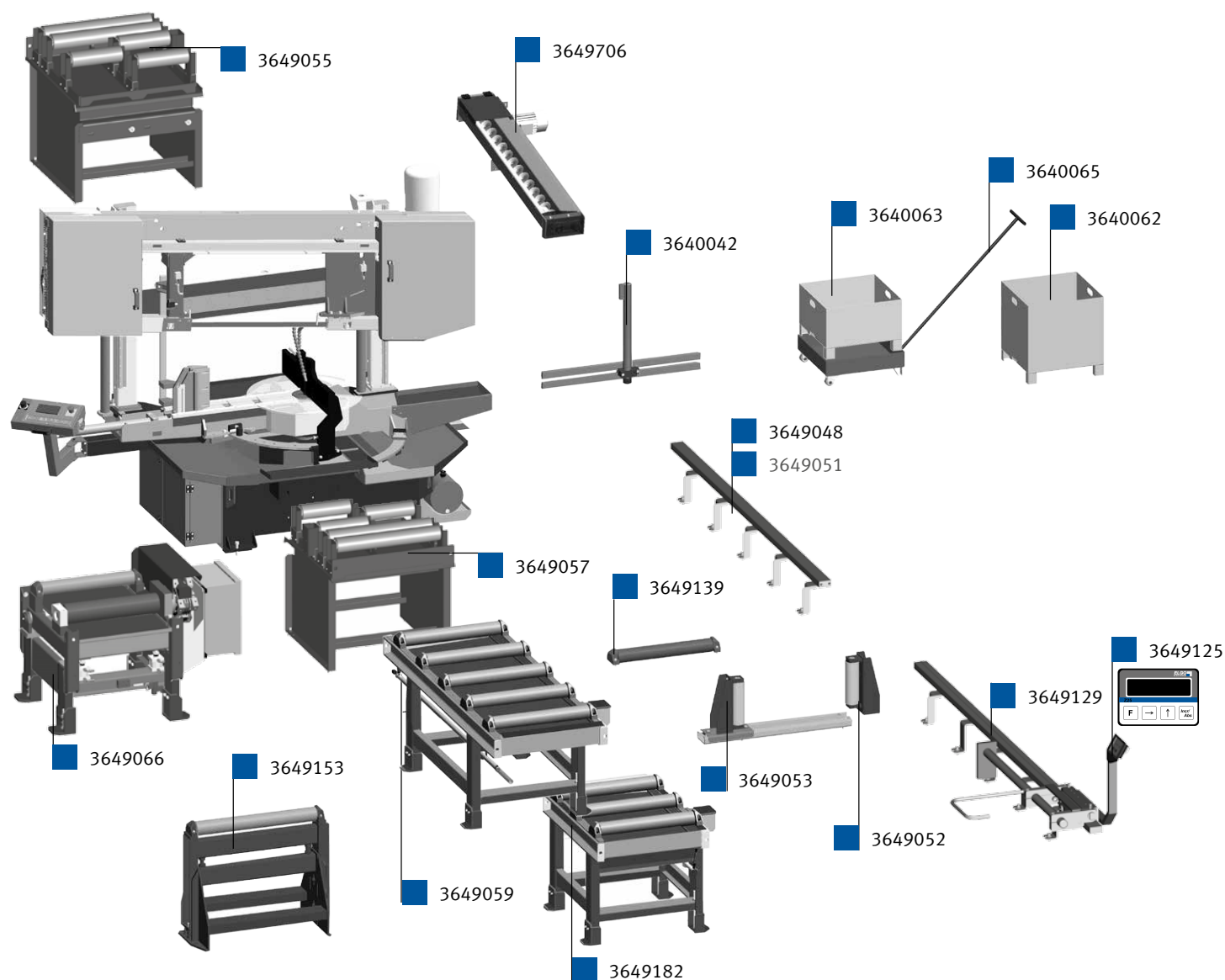
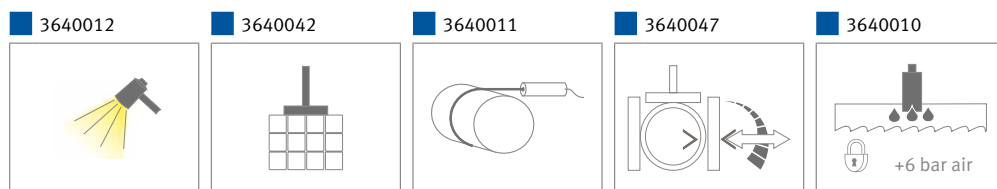


Clamping range

mm	0°	45°	60°	45°	60°	a	b
	470	475	330	475	305	x	
	250*	180*	130*	180*	130*	x	
	610 x 410	490 x 415	320 x 410	495 x 415	305 x 425	610 x 255	

* recommended values

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Optional accessories (only available from factory)	Art. no.
Hydraul. band tensioning unit	3640039
Pressure regulator on vice	3640047
Cutting line laser	3640011
Chip conveyor for stainless steel chips incl. swarf container	3649706
Hydraul. Bundle clamping unit	3640042
Micro-spraying system	3640010
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Roller conveyors (incl. legs and connecting adapter)	
800 x 620 mm feed roller conveyor	3649055
800 x 620 mm discharge roller conveyor	3649057
1000 x 620 mm roller conveyor	3649182
2000 x 620 mm roller conveyor	3649059
Motorised roller conveyor with hydr. driven lifting roller	3649066

Accessories, roller conveyors	Art. no.
lateral guide roller, moving for roller conveyors (requires: 3649080*)	3649053
lateral Guide roller 380 mm, rigid	3649052
Roller support, height-adjustable, width 600 mm, load-bearing capacity 700 kg	3649153
Additional roller 600 mm	3649139
2 m stop fixed with measuring scale	3649129
2 m stop with digital measuring display	3649125
2m extension for stop with measuring device	3649048
2m extension for stop with digital display	3649051

* must be ordered with your order!

More saw bands and
info on page 283

When ordering a roller
conveyor, always state whether
you need a feed or discharge
conveyor

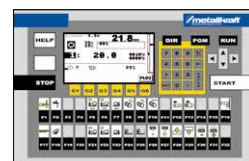
HMBS 440 x 600 NC-DG X 2000

New

Fully-automatic two-column horizontal metal-cutting band saw for angle cuts with a feed length of 2000 mm and ARP system for industrial use

Automatic

- ▶ For cutting sections and full materials
- ▶ For straight cuts, clamping of the material upstream and downstream of the cut through two-part vice
- ▶ The vice can move throughout the entire cutting area
- ▶ Driven cleaning brush for cleaning and maintenance of the saw band
- ▶ Saw band tilted by 7° for improved cutting performance and a longer service life
- ▶ Includes frequency converter for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ Cooling system on the saw band guides
- ▶ Front band guide automatically moves in parallel with the moving vice jaw



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

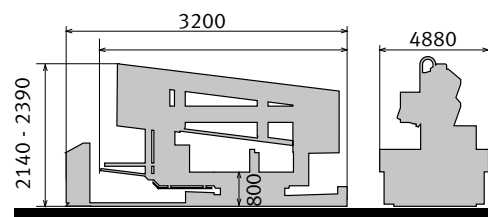
- ▶ Saw band
- ▶ Operating tool
- ▶ With frequency-converter
- ▶ With automatic transporter 2000 mm as standard
- ▶ Pressure regulator on vice
- ▶ continuously variable adjustment of the saw band speed
- ▶ driven swarf clearing brush
- ▶ 64-bit control system
- ▶ Hydraulic angle adjustment
- ▶ Digital angle display
- ▶ Workplace lighting
- ▶ Coolant pump

We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 440 x 600 NC-DG X 2000
Art. no.	3690151

Technical specifications	
Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	6060 x 34 x 1.1 mm
Dimensions (L x W x H)	3200 x 4880 x 2390 mm
Table height material feed	800 mm
Weight	3835 kg
Transport packaging flat rate*	TPFR 6 = € 200.00

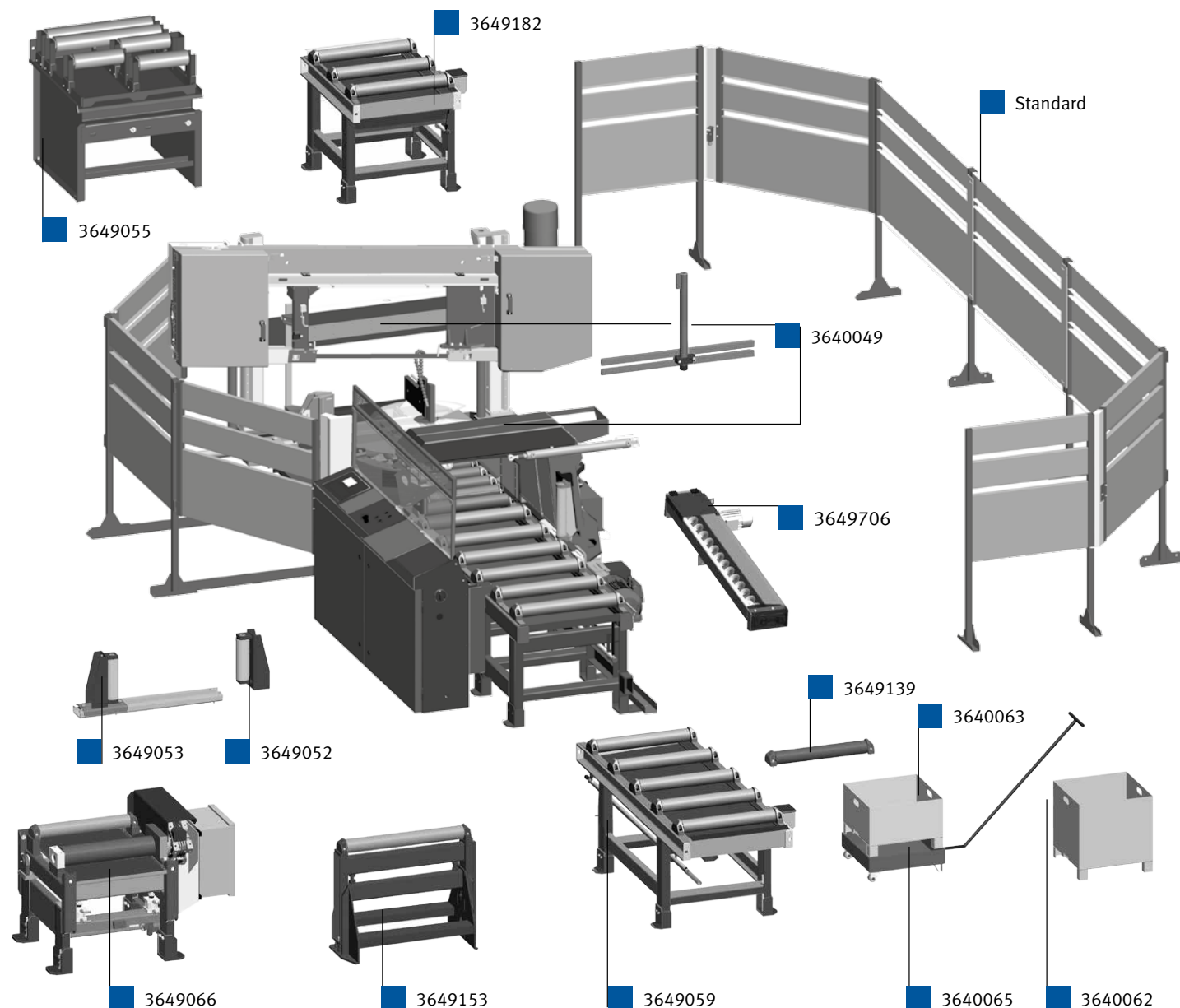
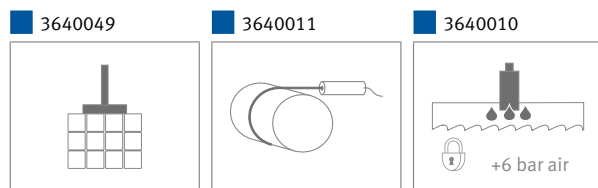
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°	45°	60°	45°	60°	a ^b
	470	475	330	475	305	x
	250*	180*	130*	180*	130*	x
	610 x 410	490 x 415	320 x 410	495 x 415	305 x 425	610 x 255

* recommended values



Optional accessories (only available from factory)		Roller conveyors (incl. legs and connecting adapter)	
Cutting line laser	3640011	800 x 620 mm discharge roller conveyor	3649055
Chip conveyor for stainless steel chips incl. swarf container	3649706	1000 x 620 mm roller conveyor	3649182
Micro-spraying system	3640010	2000 x 620 mm roller conveyor	3649059
Hydraul. Bundle clamping unit	3640049	Motorised roller conveyor with hydr. driven lifting roller	3649066
Accessories		Accessories, roller conveyors	
Workpiece container	3640062	lateral guide roller, moving 380 mm	3649053
Swarf container	3640063	lateral guide roller, rigid, 380 mm	3649052
Trolley for swarf container and workpiece container	3640065	Roller support, height-adjustable, width 600 mm, load-bearing capacity 700 kg	3649153
		Additional roller 600 mm	3649139

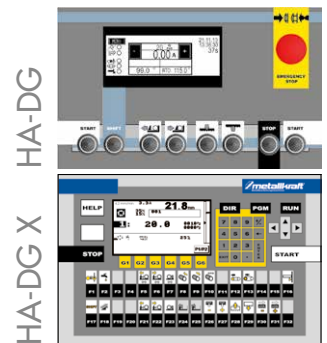
When ordering a roller conveyor,
always state whether you need a feed
or discharge conveyor

HMBS 500 x 750 HA-DG/ HMBS 500 x 750 HA-DG X

Semi-automatic two column horizontal metal-cutting band saw for mitre cuts of +60° to -60°, designed for industrial use

- ▶ Semi-automatic, hydraulically controlled two-column guided steel design
- ▶ For cutting sections and full materials
- ▶ Bearings for adjusting the saw frame for angle cuts with smoothed guide surfaces on the machine body
- ▶ A hydraulically controlled system controls the machines work sequences
- ▶ Linear guides on both columns ensure perfect cutting results
- ▶ BRP - saw band monitoring (HA-DG)
- ▶ Front band guide automatically moves in parallel with the moving vice jaw
- ▶ HA-DG X with ARP system
- ▶ Saw band tilted by 7° for improved cutting performance and a longer service life
- ▶ With horizontally swivelling saw arm from +60° to -60°
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ Safety display for saw band tension and protective hood open
- ▶ Emulsion cooling with liquid distribution across the saw band guides in the cutting channel
- ▶ For straight cuts, clamping of the material upstream and downstream of the cut through two-part vice

Semi-automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



driven cleaning brush for cleaning and maintenance of the saw band



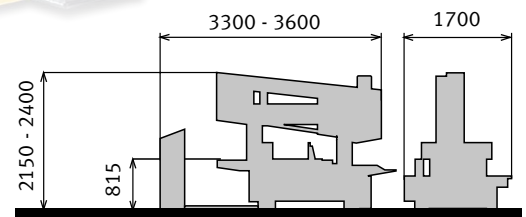
Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Two rugged support rollers
- ▶ Frequency converter,
- ▶ Hydraulic angle adjustment
- ▶ Swarf purging gun
- ▶ Digital angle display
- ▶ Coolant pump

Scope of supply HA-DG X:

- ▶ Pressure regulator on vice
- ▶ Workplace lighting

! We are always happy to perform sample cutting for your material. Call us for details!



Model	HMBS 500 x 750 HA-DG	HMBS 500 x 750 HA-DG X
Art. no.	3690075	3690076

Technical specifications	HMBS 500 x 750 HA-DG	HMBS 500 x 750 HA-DG X
Motor output 3 x 400 V/50 Hz	4.0 kW	4.0 kW
Speed stages	Continuously variable	Continuously variable
Saw band speeds	20/100 m/min.	20/100 m/min.
Saw band dimensions	6500 x 41 x 1.3 mm	6500 x 41 x 1.3 mm
Dimensions (L x W x H)	3600 x 1700 x 2400 mm	3600 x 1700 x 2400 mm
Table height material feed	815 mm	815 mm
Weight	2000 kg	2000 kg
Transport packaging flat rate*	TPFR 6 = € 200.00	TPFR 6 = € 200.00

Clamping range HMBS 500 x 750

mm	0°	45°	60°	45°	60°	a	b
500	500	330	500	300	X		
400 *	280 *	200 *	280 *	190 *	X		
750x480	500x480	330x480	500x480	300x480	750x260		

* recommended values

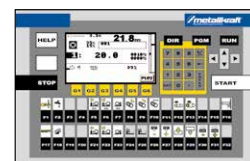
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

HMBS 500 x 750 NC-DG X 2000

Fully-automatic two-column horizontal metal-cutting band saw ARP system for for mitre cuts from +60° to -60° and 2000 mm transporter

- ▶ Designed for industrial use
- ▶ For cutting sections and full materials
- ▶ For straight cuts, clamping of the material upstream and downstream of the cut through two-part vice
- ▶ Saw band tilted by 7° for improved cutting performance and a longer service life
- ▶ A completely hydraulically-controlled system controls the machines work sequences
- ▶ The clamping jaw moves throughout the entire cutting area
- ▶ Hydraulically controlled angle adjustment of the saw arm
- ▶ Front band guide automatically moves in parallel with the moving vice jaw
- ▶ With horizontally swivelling saw arm from +60° to -60°
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.

Automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply:

- ▶ Saw band
- ▶ Operating tool
- ▶ With automatic transporter 2000 mm as standard
- ▶ Workplace lighting
- ▶ Pressure regulator on vice
- ▶ Continuously variable adjustment of the saw band speed
- ▶ Driven swarf clearing brush
- ▶ 64-bit control system
- ▶ Workplace lighting
- ▶ Coolant pump
- ▶ Safety perimeter

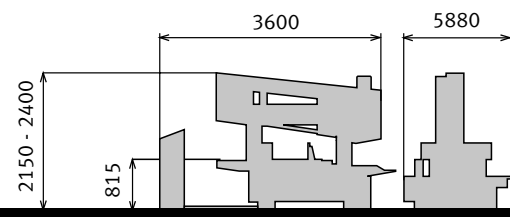
! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 500 x 750 NC-DG X 2000
Art. no.	3690077










Technical specifications

Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min.
Saw band dimensions	6500 x 41 x 1.3 mm
Dimensions (L x W x H)	3600 x 5880 x 2400 mm
Table height material feed	815 mm
Weight	4150 kg
Transport packaging flat rate*	TPFR 6 = € 200.00

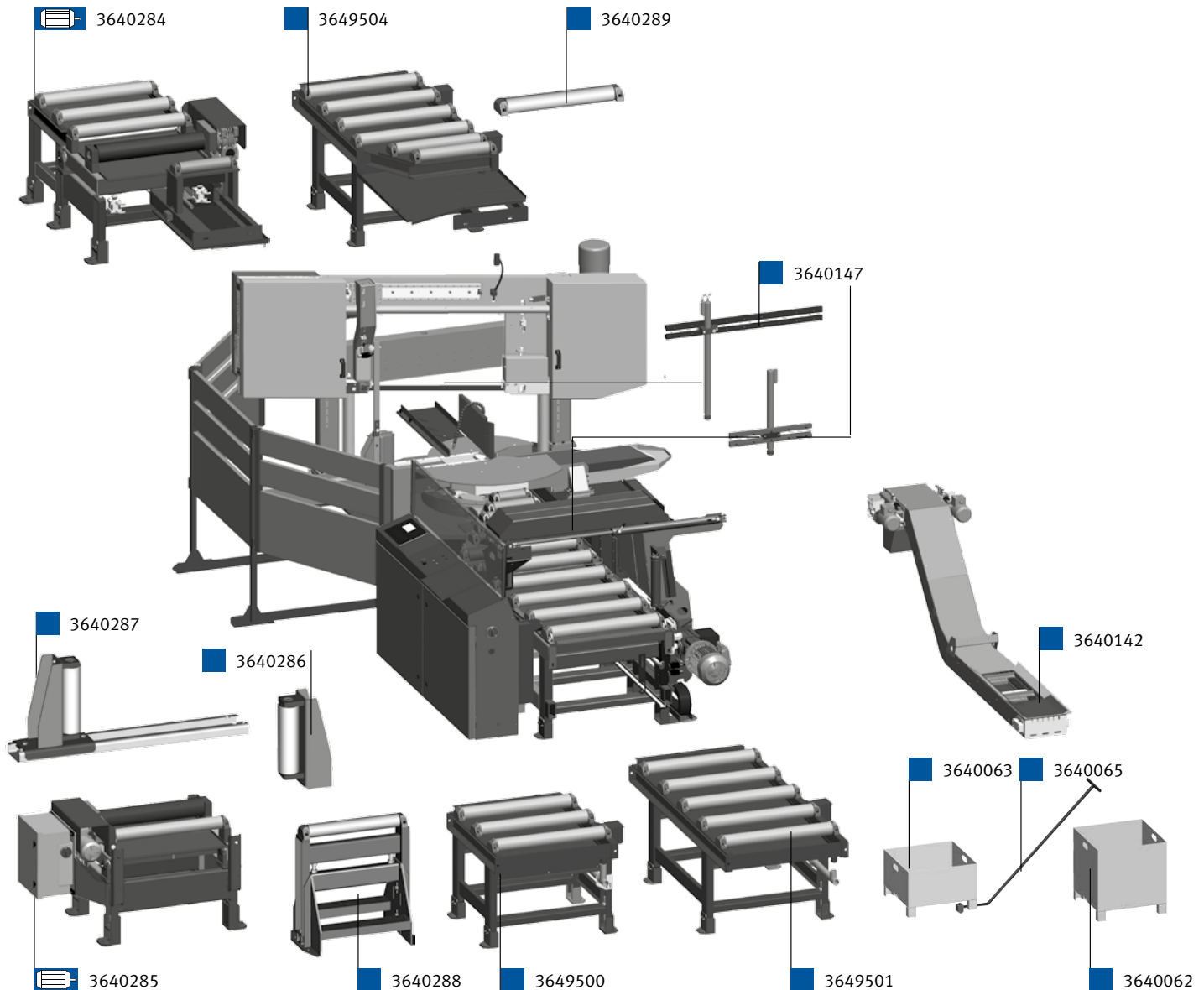
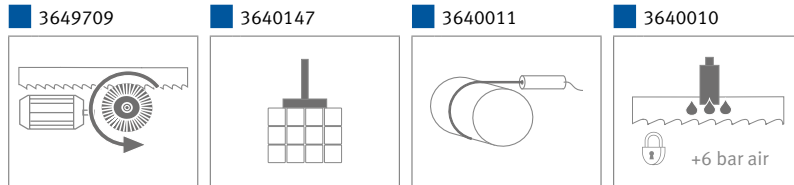
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range HMBS 500 x 750 NC-DG X 2000

clamping range HMB 500 x 750 NC DS x 2000						
mm	 0°	 45°	 60°	 45°	 60°	 ^a _b
	500	500	330	500	300	X
	400 *	280 *	200 *	280 *	190 *	X
	750 x 480	500 x 480	330 x 480	500 x 480	300 x 480	750 x 260

* recommended values



Optional accessories	Art. no.	Accessories, roller conveyors	Art. no.
Swarf conveyor	3640142	lateral guide roller, moving for roller conveyors	3640287
Hydraul. Bundle clamping unit	3640147	Lateral guide roller, rigid	3640286
Micro-spraying system	3640010	Roller support, height-adjustable, width 620 mm, load-bearing capacity 700 kg	3640288
Cutting line laser	3640011	Additional roller 620 mm	3640289
Motorised swarf brush	3649709	2 m extension for transporter	3640290
Accessories		3 m extension for transporter	3640291
Workpiece container	3640062	M42 saw bands	
Swarf container	3640063	6500 x 41 x 1.3 mm 2-3 tpi Sprint Plus	3655240
Trolley for swarf container and workpiece container	3640065	6500 x 41 x 1.3 mm 3-4 tpi Sprint Plus	3655241
Roller conveyors		6500 x 41 x 1.3 mm 5-8 tpi Sprint	3655242
Motorised feed roller conveyor with hydr. driven lifting roller	3640284	* must be ordered with your order!	
Motorised discharge roller conveyor with hydr. driven lifting roller	3640285		
1000 x 800 mm roller conveyor	3649500		
2000 x 800 mm roller conveyor	3649501		
2000 x 800 mm discharge roller conveyor	3649504		
2000 x 800 mm motorised discharge roller conveyor	3649505		

More saw bands and info on page 283

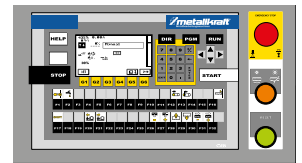
When ordering a roller conveyor, always state whether you need a feed or discharge conveyor

HMBS 600 x 1100 HA-DG X

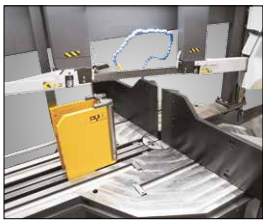
Semi-automatic hydraulically controlled two column horizontal metal-cutting band saw with ARP system for heavy-duty industrial use

Semi-automatic

- ▶ Semi-automatic, hydraulically controlled two-column guided steel design
- ▶ For cutting sections and full materials
- ▶ Saw band angled by 10°
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ With horizontally swivelling saw arm from +60° to +60°
- ▶ Front band guide automatically moves in parallel with the moving vice jaw
- ▶ Motorised cleaning brush for cleaning and maintenance of the saw band
- ▶ Safety display for saw band tension and cover



! For an exhaustive explanation of the controls, see pages 205 – 209



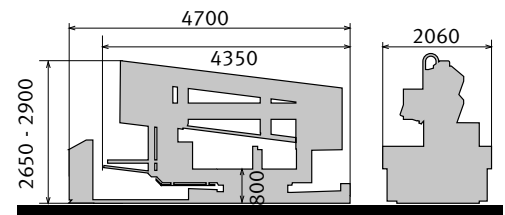
! We are always happy to perform sample cutting for your material. Call us for details!

Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Illumination
- ▶ Hydraulic angle adjustment of the saw arm
- ▶ Pressure regulator on vice
- ▶ Digital angle display
- ▶ Micro-spraying system
- ▶ Hydraulic band tensioner
- ▶ Coolant pump
- ▶ Workplace lighting
- ▶ Motorised swarf clearing brush



Fig. with optional accessories



Model	HMBS 600 x 1100 HA-DG X
Art. no.	3690084

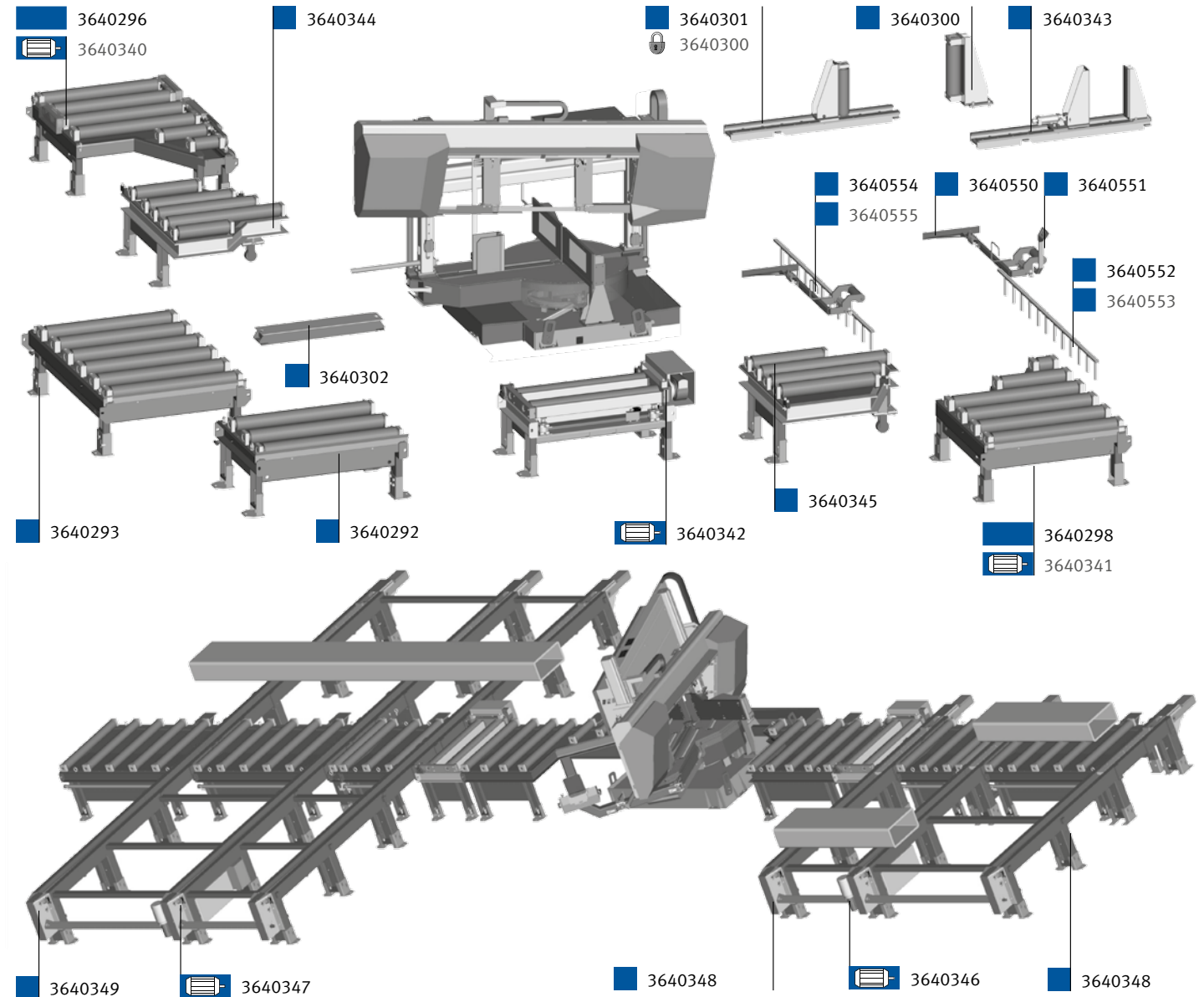
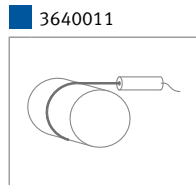
Technical specifications	
Motor output 3 x 400 V/50 Hz	5.5 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	9000 x 54 x 1.6
Dimensions (L x W x H)	4700 x 2060 x 2900 mm
Table height material feed	800 mm
Weight	5200 kg
Transport packaging flat rate*	TPFR 7 = € 300.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

Clamping range

mm	0°	45°	60°	45°	60°	a b
	620	620	500	650	490	X
	550 *	400 *	300 *	400 *	300 *	X
	1100 x 600	750 x 600	500 x 600	740 x 600	470 x 600	1100 x 400 700 x 400*

* recommended values



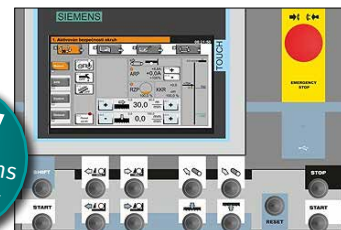
Optional accessories	Art. no.	Accessories, roller conveyors	Art. no.
Cutting line laser	3640011	lateral guide roller, moving for roller conveyors (requires: 3640301*)	3640301
Roller conveyors		Lateral guide roller, rigid	3640300
Additional feed roller conveyor for 90° cuts (must be removed for angle cuts)	3640344	Additional roller 1150 mm	3640302
Additional feed roller conveyor for 90° cuts (must be removed for angle cuts)	3640345	hydraulic lifting roller	3640342
1000 x 1150 mm roller conveyor	3640292	Hydraulic vice on the roller conveyor	3640343
2000 x 1150 mm roller conveyor	3640293	2m stop	
2000 x 1150 mm feed roller conveyor	3640296	with measuring scale - heavy duty version	3640550
2000 x 1150 mm discharge roller conveyor	3640298	2 m stop	
Motorised feed roller conveyor		with digital measuring display - heavy duty version	3640551
2000 x 1150	3640340	2m extension for stop	
Motorised discharge roller conveyor		with measuring scale - heavy duty version	3640552
2000 x 1150	3640341	2m extension for stop	
Cross-conveyor 4 metre length	3640346	with digital display - heavy duty version	3640553
Cross-conveyor 8 metre length	3640347	Electro-mechanical stop for motor. Roller conveyor	
Extension for 4 metre cross-conveyor	3640348	with scale, - heavy duty version	3640554
Extension for 8 metre cross-conveyor	3640349	Electro-mechanical stop for motor. Roller conveyor	
		with digital display - heavy duty version	3640555

Fully-automatic two-column horizontal metal-cutting band saw with ARP system for heavy duty industrial use

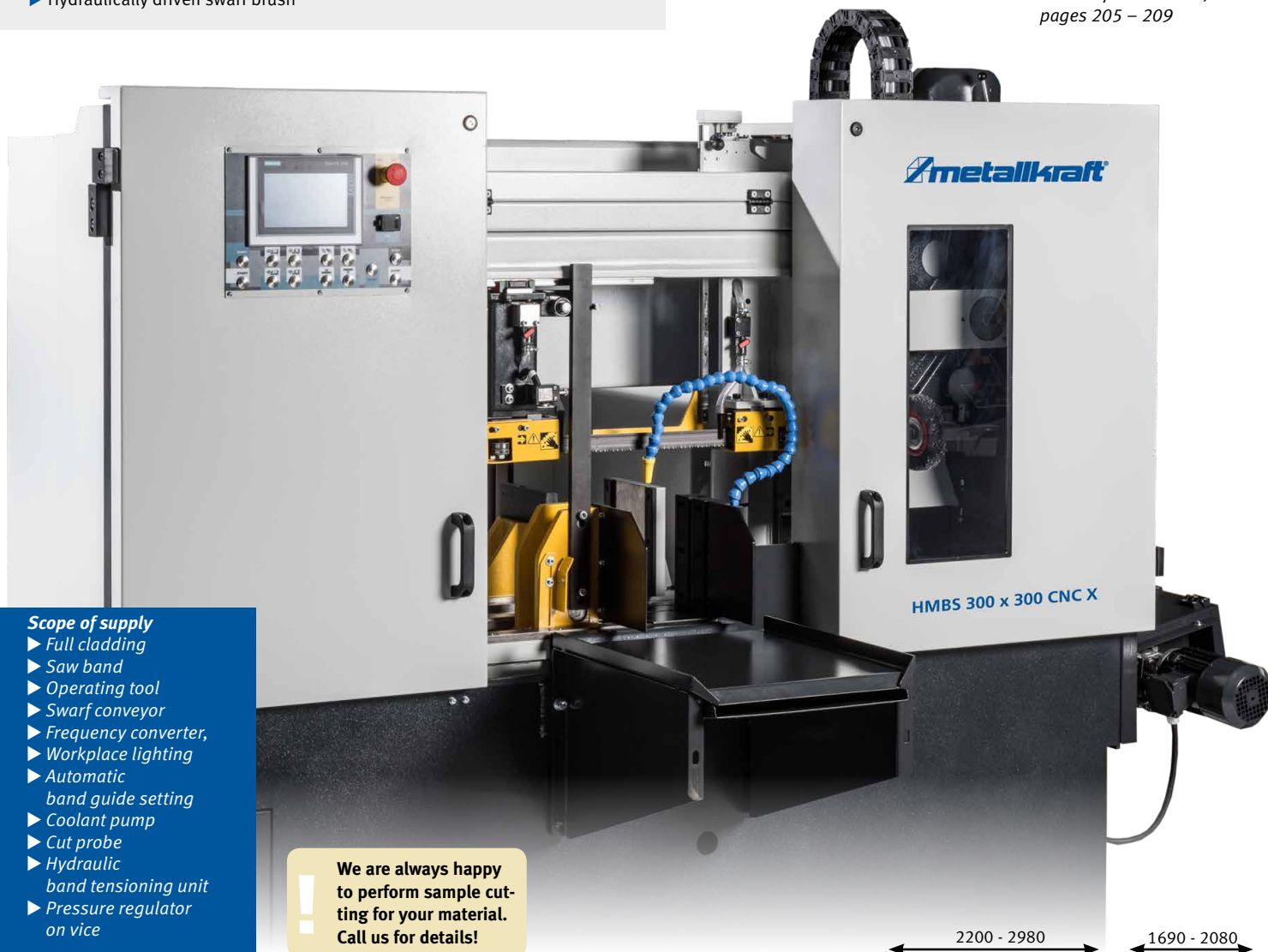
Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Compact design with short distance between saw arm guide and vice for low-vibration operation
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece and an additional bottom end position sensor
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Rugged saw band guide borne on linear guides
- ▶ Front band guide automatically moves in parallel with the moving vice for more stable saw band guiding
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ Hydraulically driven swarf brush

NEW
With Siemens
control unit



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

- ▶ Full cladding
- ▶ Saw band
- ▶ Operating tool
- ▶ Swarf conveyor
- ▶ Frequency converter,
- ▶ Workplace lighting
- ▶ Automatic band guide setting
- ▶ Coolant pump
- ▶ Cut probe
- ▶ Hydraulic band tensioning unit
- ▶ Pressure regulator on vice

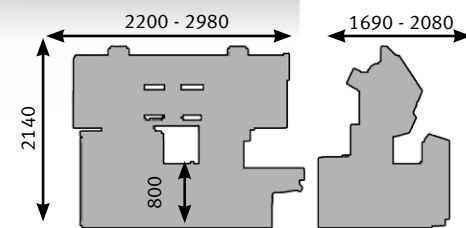
! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 300 x 300 CNC X
Art. no.	3690098

Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	4520 x 34 x 1.1 mm
Dimensions (L x W x H)	2980 x 2080 x 2140 mm
Table height material feed	800 mm
Weight	1420 kg
max. feed length for 1 x feed unit	505 mm
min. remaining workpiece length CNC operation	120 mm**
Transport packaging flat rate*	TPFR 5 = € 100.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

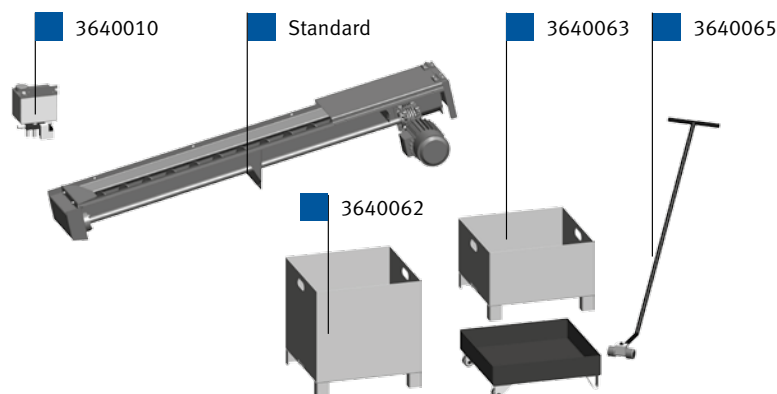
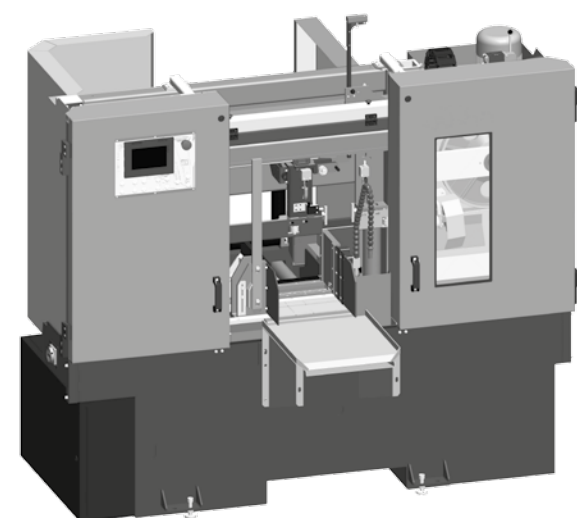
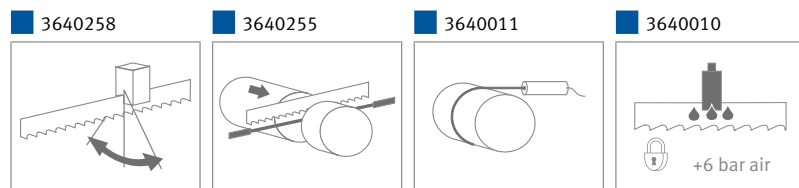
** Recommended minimum value. This value can change depending on the weight of surface of the material to be cut.



Clamping range HMBS 300 x 300

mm	0°	b a x b
	300	X
	250 *	X
	300 x 300	300 x 220

* recommended values

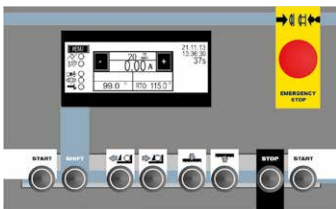


Optional accessories (only available from factory)	Art. no.	Roller conveyors	Art. no.
Cutting line laser	3640011	Roller conveyor 1000 x 350 mm	3649700
Micro-spraying system	3640010	Roller conveyor 2000 x 350 mm	3649701
Material start sensor	3640255	Connecting roller conveyor discharge side	3649702
Cut path monitoring	3640258	1000 x 350 mm with cover plates between rollers	
Accessories		Roller conveyor 2000 x 350 mm with one electrically driven roller This roller is hydraulically height adjustable via a separate control	3649703
Workpiece container	3640062	Accessories, roller conveyors	
Swarf container	3640063	lateral guide roller, moving for roller conveyors	3649705
Trolley for swarf container	3640065	Lateral guide roller, rigid	3640261
and workpiece container		Additional roller 350 mm	3649704
* must be ordered with your order! **(incl. legs and connecting adapter)			

Semi-automatic two column horizontal metal-cutting band saw

Semi-automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ Rugged top saw band guide due to linear guides
- ▶ Saw band angled by 7°
- ▶ Automatic band guide setting
- ▶ Doors open at sides to facilitate saw band replacement
- ▶ Material is tensioned before and after cutting
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ With cut probe as standard
- ▶ Additional cut pressure control



For an exhaustive explanation of the controls, see pages 205 – 209



- Scope of supply**
- ▶ Saw band
 - ▶ Operating tool
 - ▶ Workplace lighting
 - ▶ Cut probe
 - ▶ Frequency converter,
 - ▶ Automatic band guide setting
 - ▶ Hydraulic cut pressure control
 - ▶ Coolant pump
 - ▶ Hydraulic band tensioning unit
 - ▶ Chip conveyor with swarf container

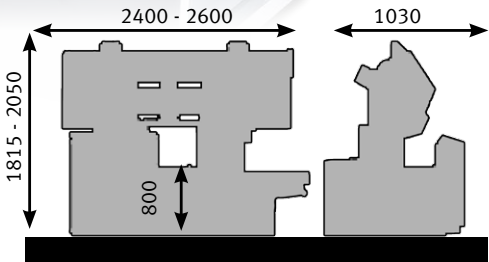
We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 400 HA
Art. no.	3690160

Fig. shows machine with optional chip conveyor

Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min
Saw band dimensions	4520 x 34 x 1.1
Dimensions (L x W x H)	2600 x 1030 x 2050 mm
Table height material feed	800 mm
Weight	940 kg
Transport packaging flat rate*	TPFR 6 = € 200.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

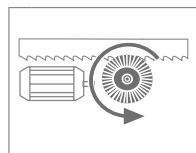
mm	0°	a b
410	X	
250 *	X	
400 x 400		400 x 340

* recommended values

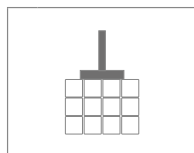


Quality
made in
Europe

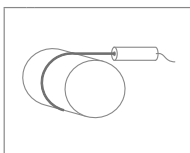
3649709



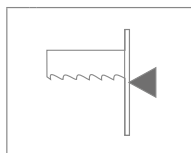
3649708



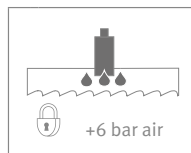
3640011



3649707



3640010



3649007

3649009

3649710

3649705
3640261

3640261

3649015

3649006

3649005

3640065

3640062

3640063

3649706

3649048

3649051

3649122

3649007

3649123

3649007

3649129

3649125

Optional accessories (only available from factory)

Micro-spraying system	3640010
Cutting line laser	3640011
Chip conveyor for stainless steel chips	
incl. swarf container	3649706
Cutting speed display	
on control panel (mm/min)	3649707
Hydraul. Bundle clamping unit	3649708
motorised swarf brush	3649709

Accessories

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container	
and workpiece container	3640065

Roller conveyors

1000 x 450 mm roller conveyor	3649005
2000 x 450 mm roller conveyor	3649006
Motorised roller conveyor 2000 x 450 mm	3649007
2000 x 450 mm motorised extension	3649009

Roller conveyors**

1000 x 450 mm discharge roller conveyor for short cuts (7 rollers/m) 1000kg/m	3649710
Roller conveyor 2000 x 450 mm with one electrically driven roller This roller is hydraulically height adjustable via a separate control	3649711

Accessories, roller conveyors

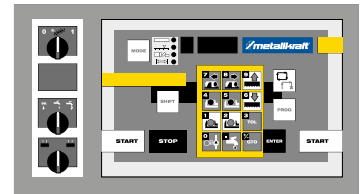
lateral guide roller, moving for roller conveyors	3649705
Lateral guide roller, rigid	3640261
Roller support, height-adjustable, width 450 mm, load-bearing capacity 700 kg/m	3649015
Electro-mechanical stop for motor. Roller conveyor with measuring unit	3649122
Electro-mechanical stop for motor. Roller conveyor/ digital display	3649123
2 m stop fixed with measuring scale	3649129
2 m stop with digital measuring display	3649125
2m extension for stop with measuring device	3649048
2m extension for stop with digital display	3649051

* must be ordered with your order! ** (incl. legs and connecting adapter)

Fully-automatic two-column horizontal metal-cutting band saw for industrial use

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ Rugged top saw band guide due to linear guides
- ▶ Saw band angled by 7°
- ▶ Automatic band guide setting
- ▶ Doors open at sides to facilitate saw band replacement
- ▶ Material is tensioned before and after cutting
- ▶ Additional hydraulic cut pressure control
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ With cut probe as standard

Automatic



For an exhaustive explanation of the controls, see pages 205 – 209



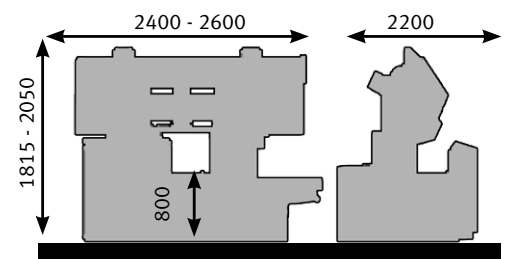
Scope of supply

- ▶ Workplace lighting
- ▶ Saw band
- ▶ Operating tool
- ▶ Frequency converter,
- ▶ Material feed 550 mm
- ▶ With cut probe as standard
- ▶ Automatic band guide setting
- ▶ Mechanically driven swarf brush
- ▶ Hydraulic cut pressure control
- ▶ Coolant pump
- ▶ Hydraulic band tensioning unit
- ▶ Chip conveyor with swarf container

Model	HMBS 400 CNC
Art. no.	3690161

Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min
Saw band dimensions	4520 x 34 x 1.1
Dimensions (L x W x H)	2600 x 2200 x 2050 mm
Table height material feed	800 mm
Weight	1300 kg
Minimal cross cut length	10 mm
Minimum size of material	30 mm
Remaining piece length in HA operation	50 mm
Remaining piece length in CNC operation	110 mm
Minimum material feed	3 mm
Feed length	550 mm
Maximum feed length	9999 mm
Transport packaging flat rate*	TPFR 6 = € 200.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

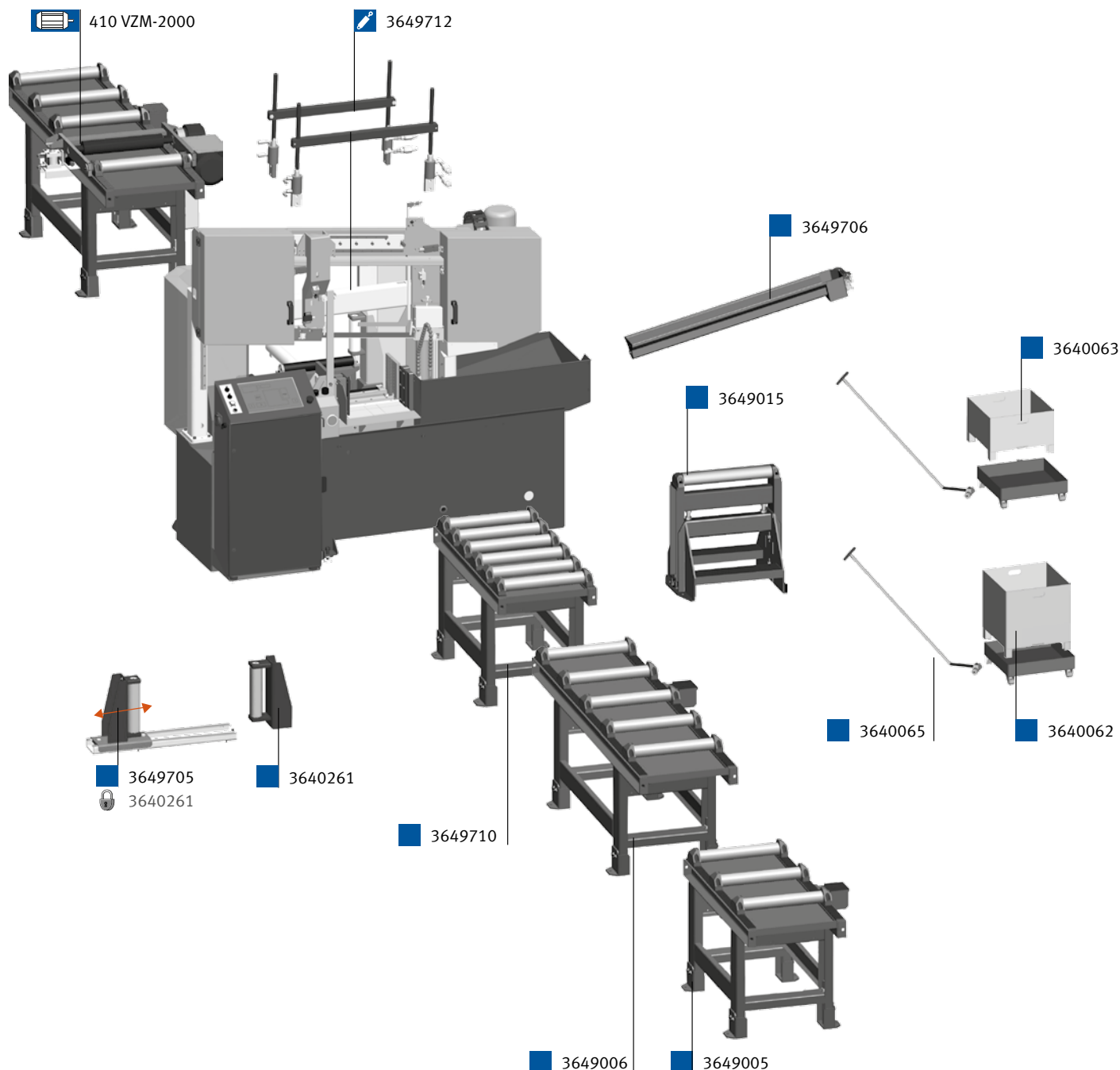
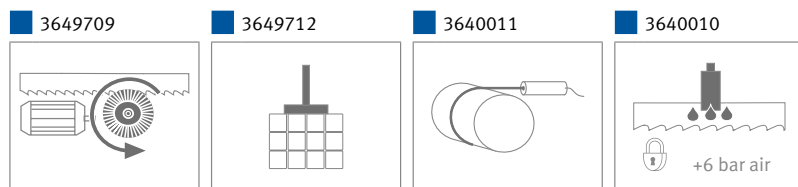
mm	0°	a
	410	X
	250 *	X
	400 x 400	400 x 340

* recommended values

We are always happy to perform sample cutting for your material. Call us for details!



Quality
made in
Europe



Optional accessories (only available from factory)	Art. no.
Micro-spraying system	3640010
Cutting line laser	3640011
Chip conveyor for stainless steel chips incl. swarf container	3649706
Hydraul. Bundle clamping unit	3649712
motorised swarf brush	3649709
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065

Roller conveyors	Art. no.
1000 x 450 mm roller conveyor	3649005
2000 x 450 mm roller conveyor	3649006
1000 x 450 mm discharge roller conveyor for short cuts (7 rollers/m) 1000kg/m	3649710
Roller conveyor 2000 x 450 mm with one electrically driven roller This roller is hydraulically height adjustable via a separate control	3649711
Accessories, roller conveyors	
lateral guide roller, moving for roller conveyors	3649705
Lateral guide roller, rigid	3640261
Roller support, height-adjustable, width 450 mm, load-bearing capacity 700 kg	3649015
* must be ordered with your order! **incl. legs and connecting adapter	

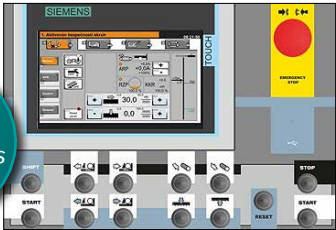
HMBS 400 x 400 HA X

Semi-automatic hydraulically controlled two column horizontal metal-cutting band saw with ARP system for cutting full materials, for industrial use

Semi-automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Compact design with short distance between saw arm guide and vice for low-vibration operation
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ Rugged top saw band guide due to linear guides
- ▶ Automatic band guide setting
- ▶ Doors open at sides to facilitate saw band replacement
- ▶ Material is tensioned before and after cutting
- ▶ Hydraulic band tensioning unit
- ▶ Motorised swarf clearing brush

NEW
With Siemens
control unit



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

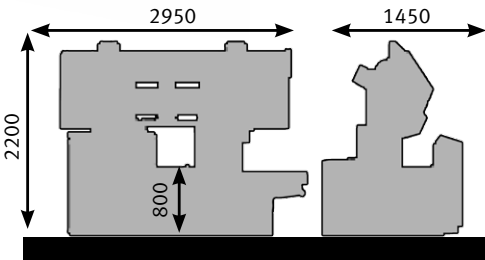
- ▶ Saw band
- ▶ Operating tool
- ▶ Workplace lighting
- ▶ Cut probe
- ▶ Frequency converter,
- ▶ Automatic band guide setting
- ▶ Hydraulic cut pressure control
- ▶ ARP system
- ▶ Coolant pump
- ▶ Chip conveyor with swarf container

! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 400 x 400 HA X
Art. no.	3690078

Technical specifications	
Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min
Saw band dimensions	5580 x 41 x 1.3
Dimensions (L x W x H)	2950 x 1450 x 2200 mm
Table height material feed	800 mm
Weight	1950 kg
Transport packaging flat rate*	TPFR 6 = € 200.00

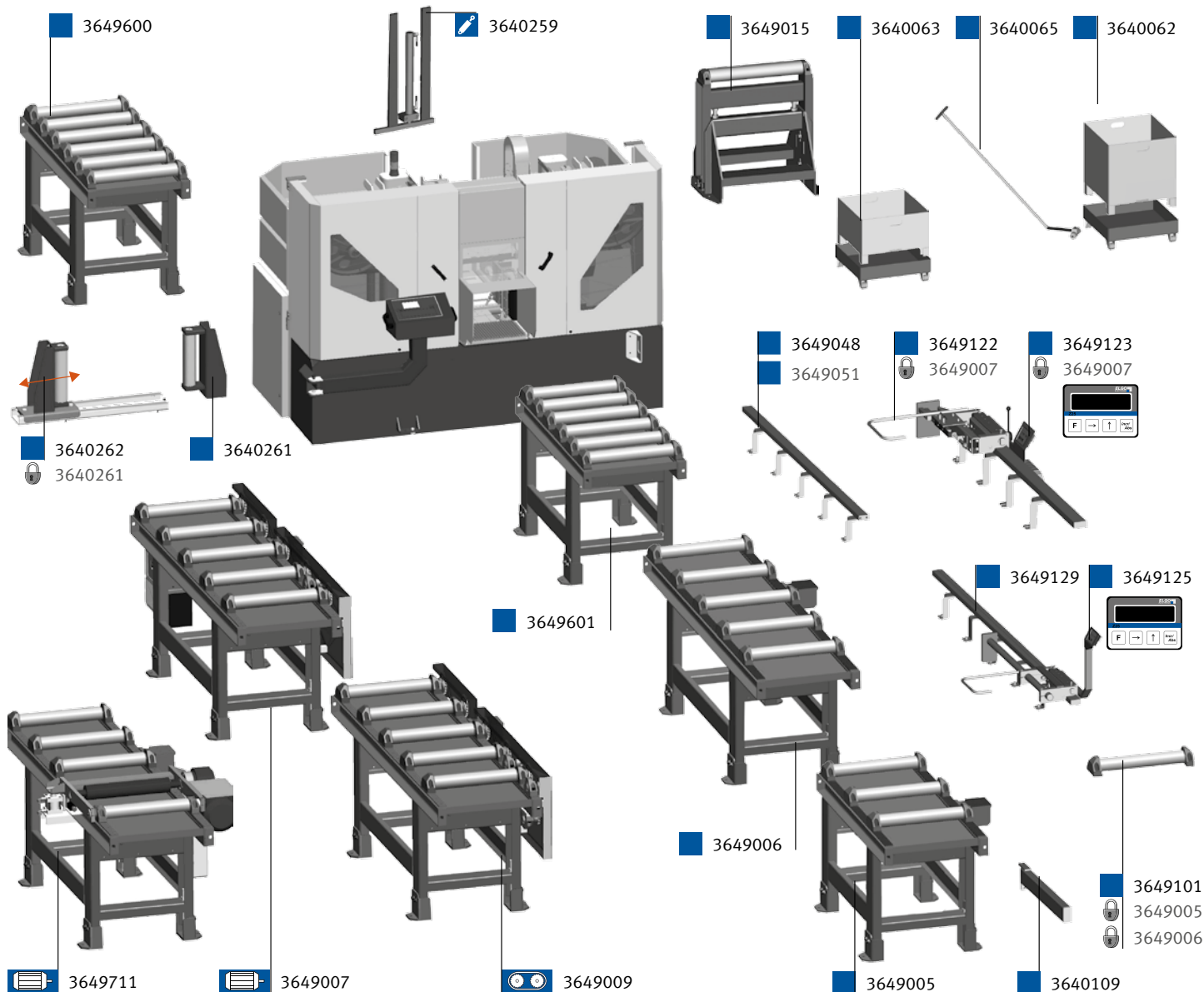
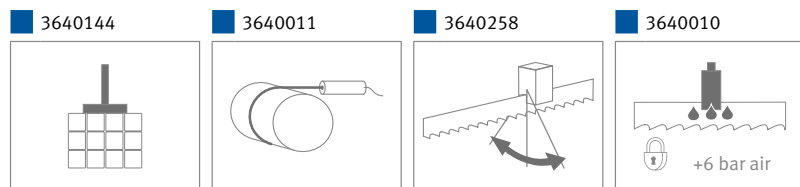
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range HMBS 400 x 400

mm	0°	
	400	X
	400 *	X
	400 x 400	400 x 250

* recommended values



Optional accessories (only available from factory)		Accessories, roller conveyors	
	Art. no.		Art. no.
Hydraul. Bundle clamping unit	3640259	lateral guide roller, moving for roller conveyors (requires: 3640261*)	3640262
Cutting line laser	3640011	Lateral guide roller, rigid	3640261
Micro-spraying system	3640010	Roller support, height-adjustable, width 450 mm, load-bearing capacity 700 kg/m	3649260
Cut path monitoring	3640258	Additional roller 450 mm	3649101
Accessories		2 m stop fixed with measuring scale	3649129
Workpiece container	3640062	2 m stop with digital measuring display	3649125
Swarf container	3640063	Electro-mechanical stop for motor. Roller conveyor with scale (requires: 3649007)	3649122
Trolley for swarf container and workpiece container	3640065	Electro-mechanical stop for motor. Roller conveyor with digital measuring display (requires 3649007)	3649123
Roller conveyors		2m extension for stop with measuring device	3649048
1000 x 450 mm feed roller conveyor with coolant drain	3649600	2m extension for stop with digital display	3649051
1000 x 450 mm feed roller conveyor with coolant drain and a guide roller at the side	3649601	Measuring track extension	3640109
1000 x 450 mm roller conveyor	3649005	* must be ordered with your order! *incl. legs and connecting adapter	
2000 x 450 mm roller conveyor	3649006		
Motorised roller conveyor 2000 x 450 mm	3649007		
2000 x 450 mm motorised extension	3649009		
Roller conveyor 2000 x 450 mm with one electrically driven roller This roller is hydraulically height adjustable via a separate control	3649711		

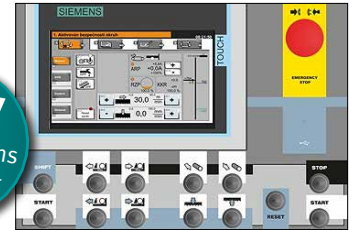
HMBS 400 x 400 CNC X

Fully-automatic two-column horizontal metal-cutting band saw with ARP system for heavy duty industrial use

Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Compact design with short distance between saw arm guide and vice for low-vibration operation
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed
- ▶ With motorised swarf brush
- ▶ Material feed 700 mm
- ▶ Hydraulic band tensioning unit
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece support and an additional bottom end position sensor
- ▶ Rugged saw band guiding with linear guides, with adjustable tungsten carbide plates
- ▶ Offcut clamping

NEW
With Siemens
control unit



! For an exhaustive explanation of the controls, see pages 205 – 209



• Swarf brush motor



Scope of supply

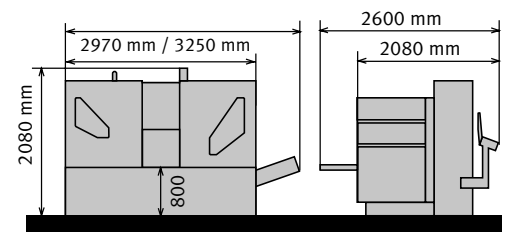
- ▶ Full cladding
- ▶ Saw band
- ▶ Operating tool
- ▶ Chip conveyor with swarf container
- ▶ Workplace lighting
- ▶ Automatic band guide setting
- ▶ Coolant pump
- ▶ Cut probe

! We are always happy to perform sample cutting for your material. Call us for details!





Model	HMBS 400 x 400 CNC X
Art. no.	3690079

Technical specifications	
Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	5580 x 41 x 1.3 mm
Dimensions (L x W x H)	2970 x 2600 x 2200 mm
Table height material feed	800 mm
Weight	2740 kg
Minimal cross cut length	10 mm
Minimum size of material	85 mm
Remaining piece length in HA operation	50 mm
Remaining piece length in CNC operation	110 mm
Minimum material feed	3 mm
Feed length	550 mm
Maximum feed length	9999 mm
Transport packaging flat rate*	TPFR 6 = € 200.00


* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

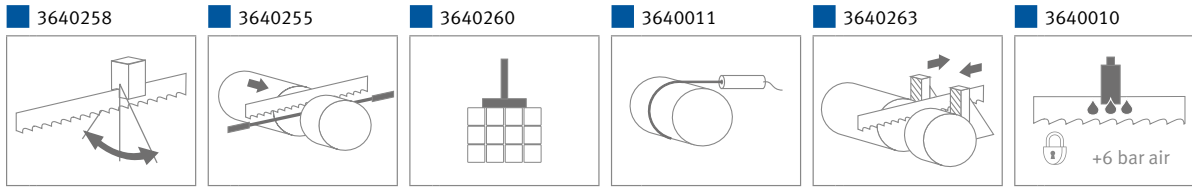


Clamping range HMBS 400 x 400

mm	0°	
	400	X
	400 *	X
	400 x 400	400 x 250

* recommended values

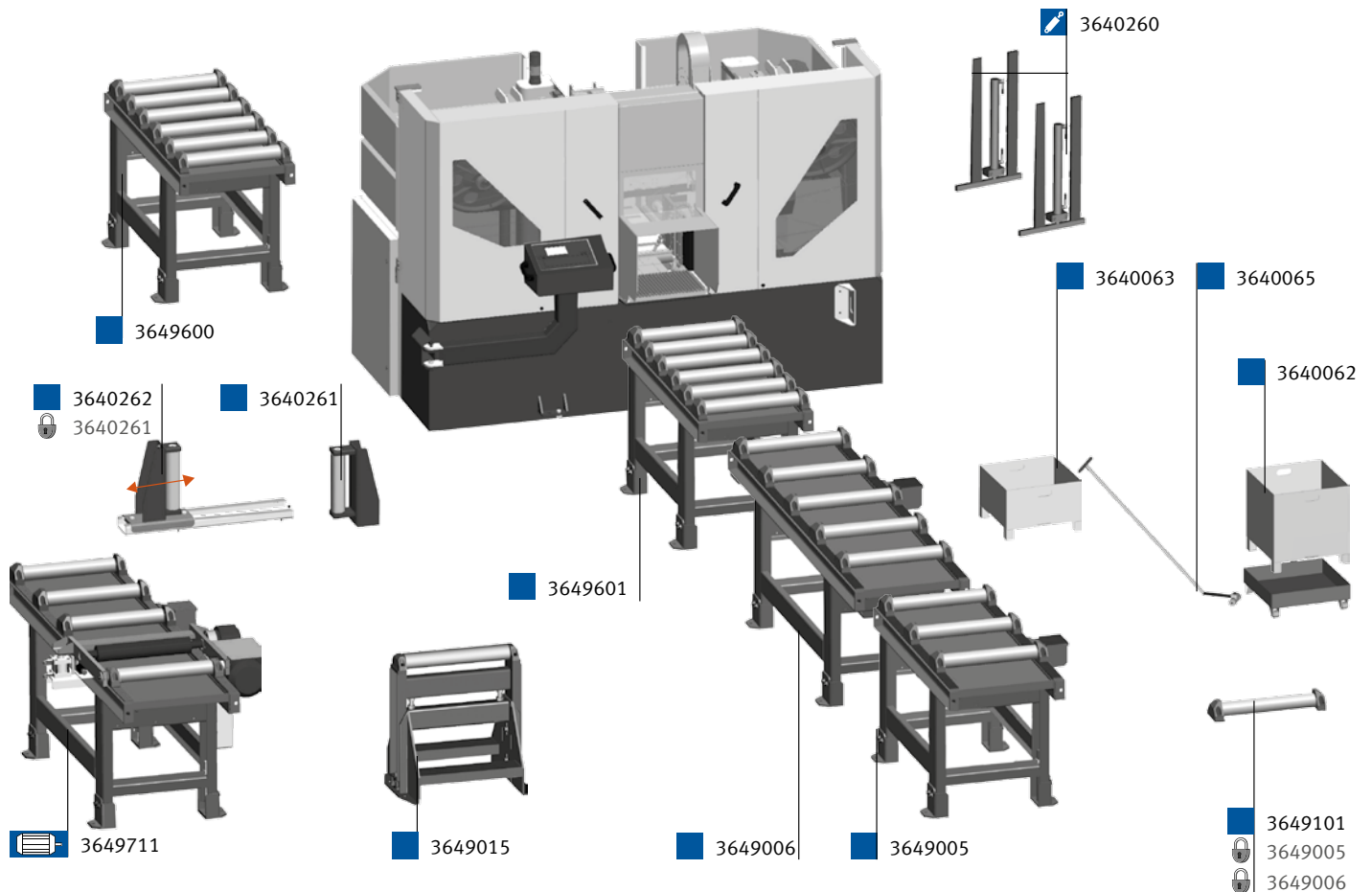
 b max. bundle cut
a x b



• 2-column linear guide with hydr. cylinder



• Offcut clamping



Optional accessories (only available from factory)	Art. no.	Roller conveyors**	Art. no.
Set 2 x hydr. bundle clamping unit	3640260	1000 x 450 mm feed roller conveyor with coolant drain	3649600
Cutting line laser	3640011	1000 x 450 mm discharge roller conveyor with coolant drain and a guide roller at the side	3649601
Micro-spraying system	3640010	1000 x 450 mm roller conveyor	3649005
Material start sensor	3640255	2000 x 450 mm roller conveyor	3649006
Cut path monitoring	3640258	Roller conveyor 2000 x 450 mm with one electrically driven roller This roller is hydraulically height adjustable via a separate control	3649711
Spring-loaded clamping jaws on vice	3640263		
Accessories		Accessories, roller conveyors	
Workpiece container	3640062	lateral guide roller, moving for roller conveyors (requires: 3640261*)	3640262
Swarf container	3640063	Lateral guide roller, rigid	3640261
Trolley for swarf container and workpiece container	3640065	Roller support, height-adjustable, width 450 mm, load-bearing capacity 700 kg/m	3649015
		Additional roller 450 mm	3649101

HMBS 510 x 510 HA X / HMBS 510 x 510 CNC X

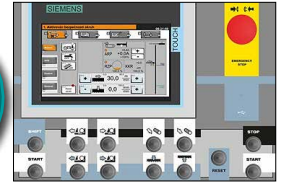
HMBS 510 x 510 HA X - semi-automatic two-column horizontal metal-cutting band saw with SIEMENS control unit, CNC X fully-automatic

Semi-automatic

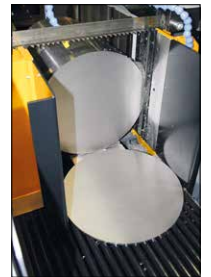
Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Material feed 670 mm
- ▶ Saw arm with stroke measuring sensor for determining the cut start position
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Saw band wheels tilted through 25° for a longer saw band service life
- ▶ Clamping of the material upstream and downstream of the cut through two-part vice
- ▶ Line guides on both columns
- ▶ Rugged top saw band guide
- ▶ Hydraulic band tensioning unit
- ▶ With motorised swarf clearing brush
- ▶ CNC X: Controller with 99 program memory slots with up to 99 setting options

NEW
With Siemens
control unit

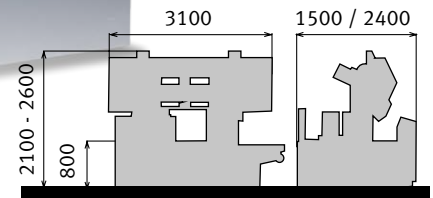


! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

- ▶ Workpiece chute
- ▶ Saw band
- ▶ Operating tool
- ▶ Cut probe
- ▶ Workplace lighting
- ▶ Chip conveyor with swarf container
- ▶ Automatic band guide setting
- ▶ Frequency converter,
- ▶ Coolant pump

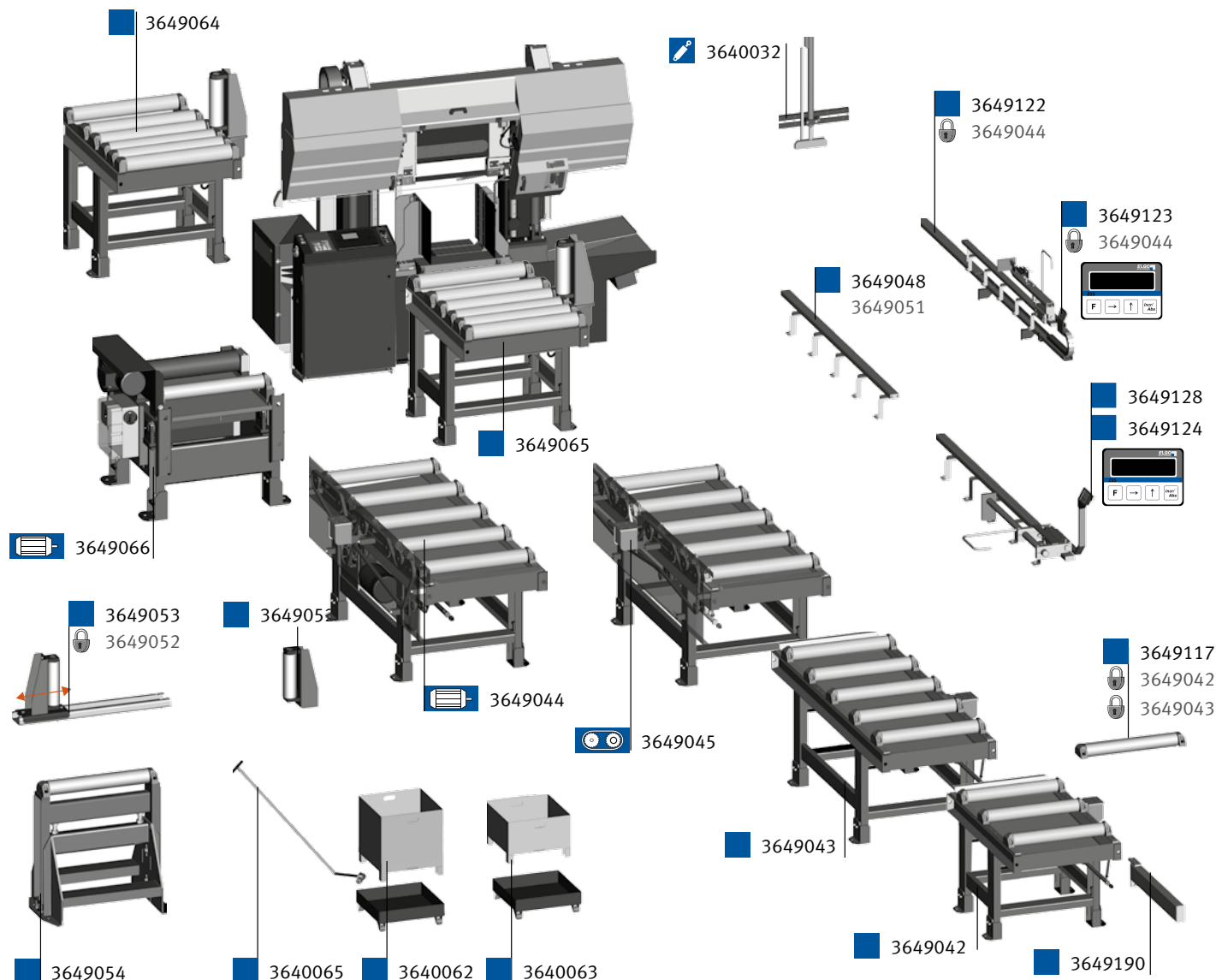
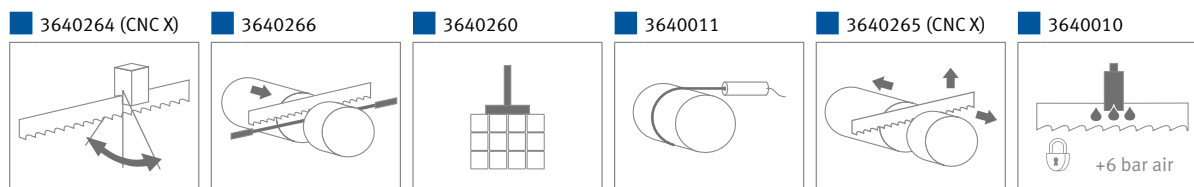


Model	HMBS 510 x 510 HA X	HMBS 510 x 510 CNC X	HMBS 510 x 510 CNC X	
Art. no.	3690016	3690019	Minimal cross cut length	10 mm
			Minimum size of material	75 mm
			Remaining piece length during a cut	50 mm
			Remaining piece length in CNC operation	120 mm
			Minimum material feed	3 mm
			Feed length	670 mm
			Maximum feed length	9999 mm
Technical specifications			Clamping range HMBS 510 x 510	
Motor output 3 x 400 V/50 Hz	7.5 kW	7.5 kW	mm	0°
Speed stages	Continuously variable	Continuously variable		
Saw band speeds	15/80 m/min	15/80 m/min		
Saw band dimensions	6060 x 54 x 1.6 mm	6060 x 54 x 1.6 mm		
Dimensions (L x W x H)	3100 x 1500 x 2600 mm	3100 x 2400 x 2600 mm		
Table height material feed	800 mm	800 mm		
Weight	3750 kg	6220 kg		
max. feed length for 1 x feed unit	50 mm	50 mm		
min. remaining workpiece length CNC operation	-	120 mm		
Transport packaging flat rate*	TPFR 7 = € 300.00	TPFR 7 = € 300.00		

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

mm	0°	
	510	X
	510 *	X
	510 x 530	500 x 450

* recommended values



Optional accessories	Art. no.
Cutting line laser	3640011
Micro-spraying system	3640010
Cut path monitoring	3640264
Hydraul. Bundle clamping unit (for HA-X only) max. width 200 mm	3640032
Set 2 x hydr. bundle clamping unit (for CNC-X only)	3640033
Cutting channel opens as soon as the saw band moves to the top position (for CNC-X only)	3640265
Material start sensor (for CNC-X only)	3640266
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Roller and measuring tracks**	
1000 x 620 mm roller conveyor	3649042
2000 x 620 mm roller conveyor	3649043
2000 x 620 mm motorised roller conveyor (for HA-X only)	3649044
2000 x 620 mm motorised extension (for HA-X only)	3649045
1000 x 620 mm feed roller conveyor with one guide roller at the side	3649064
1000 x 620 mm discharger roller conveyor with one guide roller at the side (for HA-X only)	3649065
Motorised roller conveyor with hydr. driven lifting roller	3649066

Accessories, roller and measuring tracks	Art. no.
lateral guide roller, moving for roller conveyors (requires: 3649052*)	3649053
Lateral guide roller, rigid	3649052
Roller support, height-adjustable, width 620 mm, load-bearing capacity 1,000 kg	3649054
Additional roller 620 mm (requires 3649042*/3649043*)	3649117
Accessories, roller and measuring tracks (for CNC-X only)	
2 m stop fixed with measuring scale	3649129
2 m stop with digital measuring display	3649125
Electro-mechanical stop for motor. Roller conveyor with scale (requires 3649044*)	3649122
Electro-mechanical stop for motor. Roller conveyor with digital measuring display (requires 3649044*)	3649123
2m extension for stop with measuring device	3649048
2m extension for stop with digital display	3649051
Measuring track extension	3649190
M42 saw bands for HMBS 510 x 510 HA X / CNC X	
6060 x 54 x 1.6 mm 3-4 tpi Sprint Plus	3655007
6060 x 54 x 1.6 mm 2-3 tpi Sprint Plus	3655107

* must be ordered with your order! *incl. legs and connecting adapter

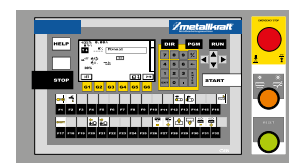
More saw bands and
info on page 283

When ordering a roller con-
veyor, always state whether
you need a feed or discharge
conveyor

Semi-automatic two-column horizontal metal-cutting band saw with ARP system

Semi-automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Line guides on both columns
- ▶ Clamping of the material upstream and downstream of the cut through two-part vice
- ▶ Rugged top saw band guide
- ▶ Hydraulic band tensioner
- ▶ Motorised swarf clearing brush



Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Workplace lighting
- ▶ Hydraulic cut pressure control
- ▶ Automatic band guide setting
- ▶ Frequency converter,
- ▶ Motorised swarf clearing brush
- ▶ Coolant pump

We are always happy to perform sample cutting for your material. Call us for details!

Fig. with optional accessories

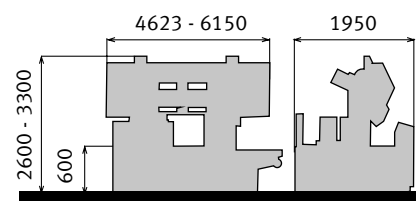
Model	HMBS 550 x 1300 X
Art. no.	3690170

Technical specifications	
Motor output 3 x 400 V/50 Hz	7.5 kW
Speed stages	Continuously variable
Saw band speeds	20/100 m/min.
Saw band dimensions	9000 x 54 x 1.6 mm
Dimensions (L x W x H)	6150 x 1950 x 3300 mm
Table height material feed	600 mm
Weight	5750 kg
Transport packaging flat rate*	TPFR 7 = € 300.00

Clamping range

mm	0°	a x b
650	X	
510 *	X	
1300 x 550		1300 x 450

* recommended values



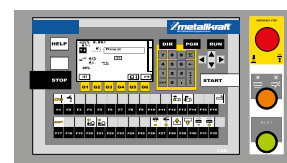
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

Accessories for HMBS 550 x 1300 X on request!

Semi-automatic two column horizontal metal-cutting band saw with ARP system for heavy-duty industrial use

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Line guides on both columns
- ▶ Clamping of the material upstream and downstream of the cut through two-part vice
- ▶ Rugged top saw band guide
- ▶ Hydraulic band tensioner
- ▶ Motorised swarf clearing brush

Semi-automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Two rugged rollers to support material infeed and discharge
- ▶ Frequency converter,
- ▶ Swarf purging gun
- ▶ Coolant pump

! We are always happy to perform sample cutting for your material. Call us for details!

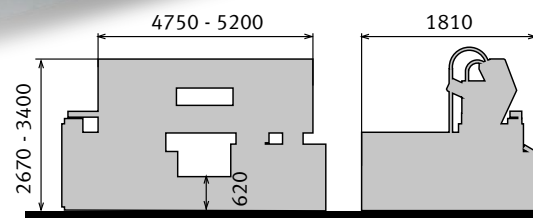
Model	HMBS 700 x 1400 X
Art. no.	3690171

Technical specifications




Motor output 3 x 400 V/50 Hz	7.5 kW
Speed stages	Continuously variable
Saw band speeds	15/85 m/min
Saw band dimensions	9360 x 54 x 1.6
Dimensions (L x W x H)	5200 x 1810 x 3400
Table height material feed	620 mm
Weight	5810 kg

Transport packaging flat rate* **TPFR 7 = € 300.00**

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°	b a x b
	700	X
	510*	X
	1400 x 700	1400 x 600

* recommended values for full material

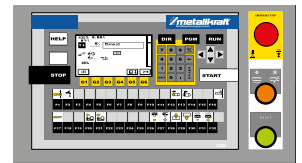
! Accessories for HMBS 700 x 1400 X on request!

HMBS 600 HA X

Semi-automatic two column horizontal metal-cutting band saw with extra high passage for cutting pipes

- ▶ Specially developed for cutting pipes
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed
- ▶ Rugged 3-phase motor including overload protection
- ▶ The vice is equipped with a long stroke cylinder to compensate for larger differences in cross-sections
- ▶ Suitable for high-performance cutting of H and L sections, square and round tubes
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ Hydraulic vice pressure control
- ▶ Features 64-bit control system
- ▶ Saw band angled by 12°
- ▶ Linear guides on both columns ensure perfect cutting results

Semi-automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



Fig. with optional bundle clamping unit (Art. no. 3640130) and optional vice downstream of cut (Art. no. 3640132)

Scope of supply

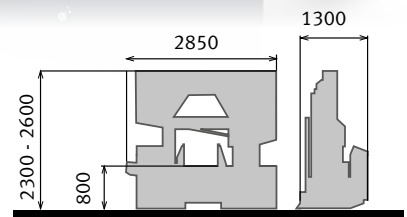
- ▶ Saw band
- ▶ Operating tool
- ▶ Frequency converter,
- ▶ Workplace lighting
- ▶ Motorised swarf clearing brush
- ▶ Coolant pump







Model	HMBS 600 HA X
Art. no.	3690060
Technical specifications	
Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	6230 x 41 x 1.3 mm
Dimensions (L x W x H)	2850 x 1300 x 2600 mm
Table height material feed	800 mm
Weight	2580 kg
Transport packaging flat rate*	TPFR 5 = € 100.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

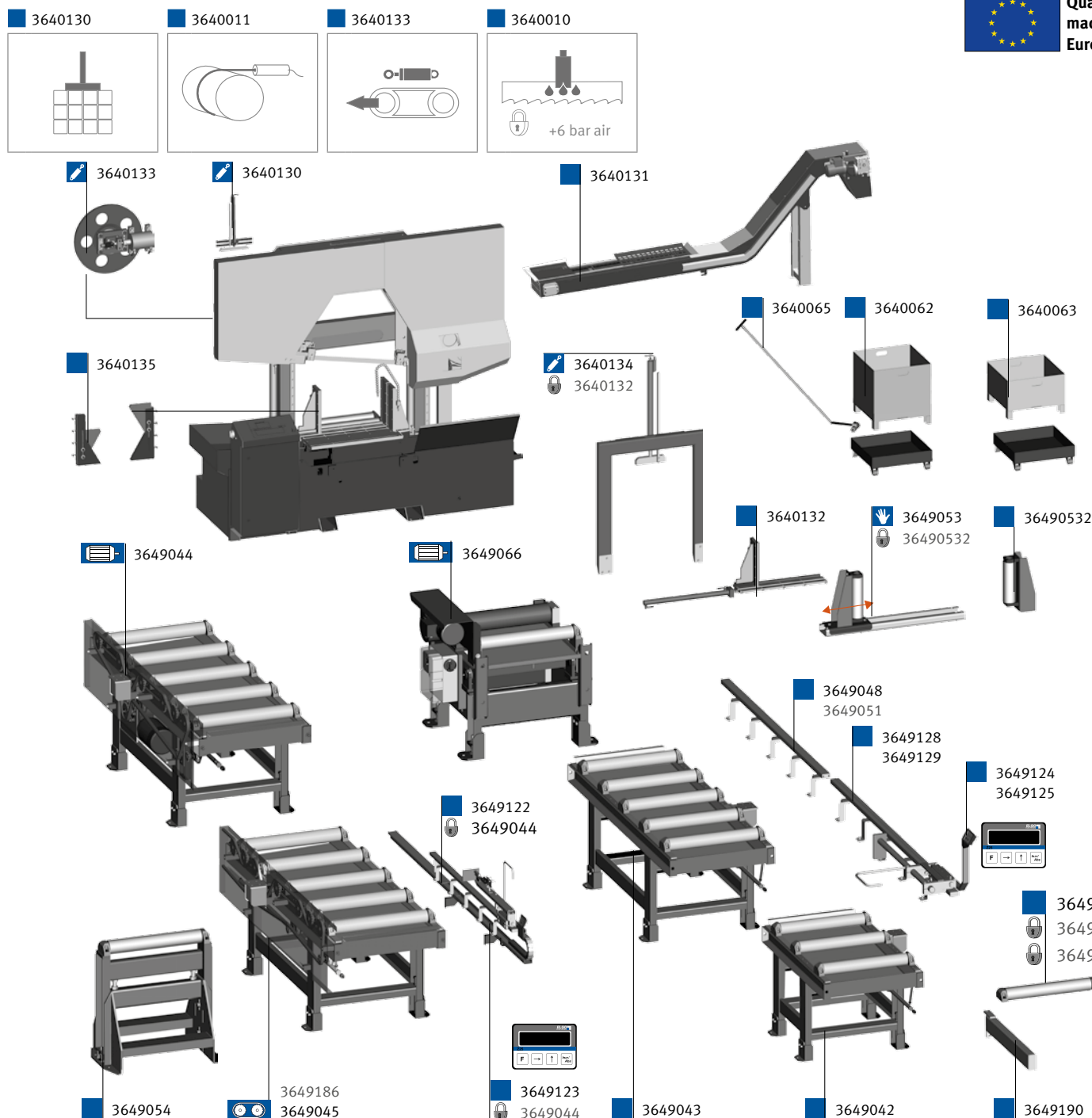
! We are always happy to perform sample cutting for your material. Call us for details!



Clamping range

mm	0°	
	600	X
	400 *	X
	600 x 510	600 x 415

* recommended values



Optional accessories (only available from factory)	Art. no.
Swarf conveyor	3640131
Hydraulic vice downstream of cut	3640132
Hydraul. band tensioning unit	3640133
Cutting line laser	3640011
Micro-spraying system	3640010
Hydraul. Bundle clamping unit	3640130
Hydraul. Bundle clamping unit mounted on hydr. vice downstream of cut	3640134
Prism-type clamping jaws	3640135
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Roller conveyors 620 mm	
1000 x 620 mm roller conveyor 1700 kg/m	3649042
2000 x 620 mm roller conveyor 1700 kg/m	3649043
2000 x 620 mm motorised roller conveyor, 1700 kg/m	3649044
2000 x 620 mm roller conveyor extension motorised, 1700 kg/m (requires 3649044)	3649045
Hydraulic lifting roller	3649066

Accessories, roller conveyors 620 mm	Art. no.
lateral guide roller, moving for roller conveyors (requires: 3649052*)	3649053
Lateral guide roller, rigid	3649052
Roller support, height-adjustable, width 620 mm, load-bearing capacity 1,000 kg	3649054
Additional roller 620 mm (requires 3649042*/3649043*)	3649117
2 m stop fixed with measuring scale	3649129
2 m stop with digital measuring display	3649125
Electro-mechanical stop for motor. Roller conveyor with scale (requires 3649044*)	3649122
Electro-mechanical stop for motor. Roller conveyor with digital measuring display (requires 3649044*)	3649123
2m extension for stop with measuring device	3649048
2m extension for stop with digital measuring display	3649051
Bracket for extending the measuring unit	3649190
M42 saw bands	
6230 x 41 x 1.3 mm 3-4 tpi Sprint Plus	3655215
6230 x 41 x 1.3 mm 2-3 tpi Sprint Plus	3655216

* must be ordered with your order! *incl. legs and connecting adapter

When ordering a roller conveyor, always state whether you need a feed or discharge conveyor

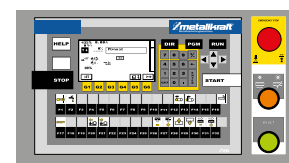
HMBS 600 CNC X 2000 / HMBS 600 CNC X 6000

New

Automatic

Fully-automatic two-column horizontal metal-cutting band saw with extra high passage, ARP system and 2000/6000 mm material feed

- ▶ Specially developed for cutting pipes
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed
- ▶ Rugged 3-phase motor including overload protection
- ▶ The vice is equipped with a long stroke cylinder to compensate for larger differences in cross-sections
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ Hydraulic vice pressure control
- ▶ Features 64-bit control system
- ▶ Saw band angled by 12°
- ▶ extra high passage - thus ideal for cutting pipes
- ▶ Linear guides on both columns ensure perfect cutting results



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

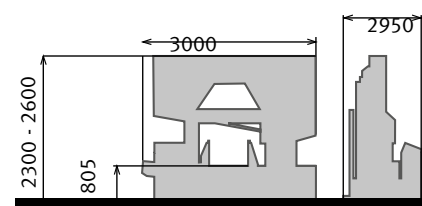
- ▶ Saw band
- ▶ Operating tool
- ▶ Workplace lighting
- ▶ ARP system
- ▶ 2000 mm / 6000 mm material feed
- ▶ driven swarf clearing brush
- ▶ Coolant pump
- ▶ Hydraulic band tensioning unit

! We are always happy to perform sample cutting for your material. Call us for details!

· Fig. with optional bundle clamping unit (Art. no. 3640130)

Model	HMBS 600 CNC X 2000	HMBS 600 CNC X 6000
Art. no.	3690096	3690099
Technical specifications		
Motor output 3 x 400 V/50 Hz	4.0 kW	4.0 kW
Speed stages	Continuously variable	Continuously variable
Saw band speeds	20 - 100 m/min	20 - 100 m/min
Saw band dimensions	6230 x 41 x 1.3 mm	6230 x 41 x 1.3 mm
Dimensions (L x W x H)	3020 x 3600 x 2850 mm	2950 x 3000 x 2600 mm
Table height material feed	800 mm	805 mm
Weight	3630 kg	5200 kg
Transport packaging flat rate*	TVP 6 = 200.00	TVP 6 = 200.00

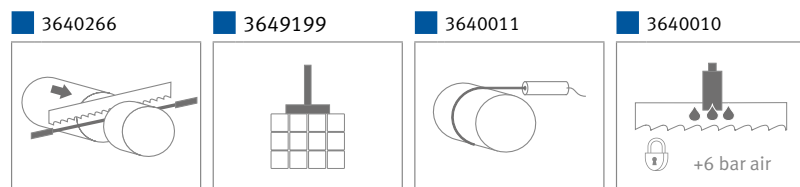
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



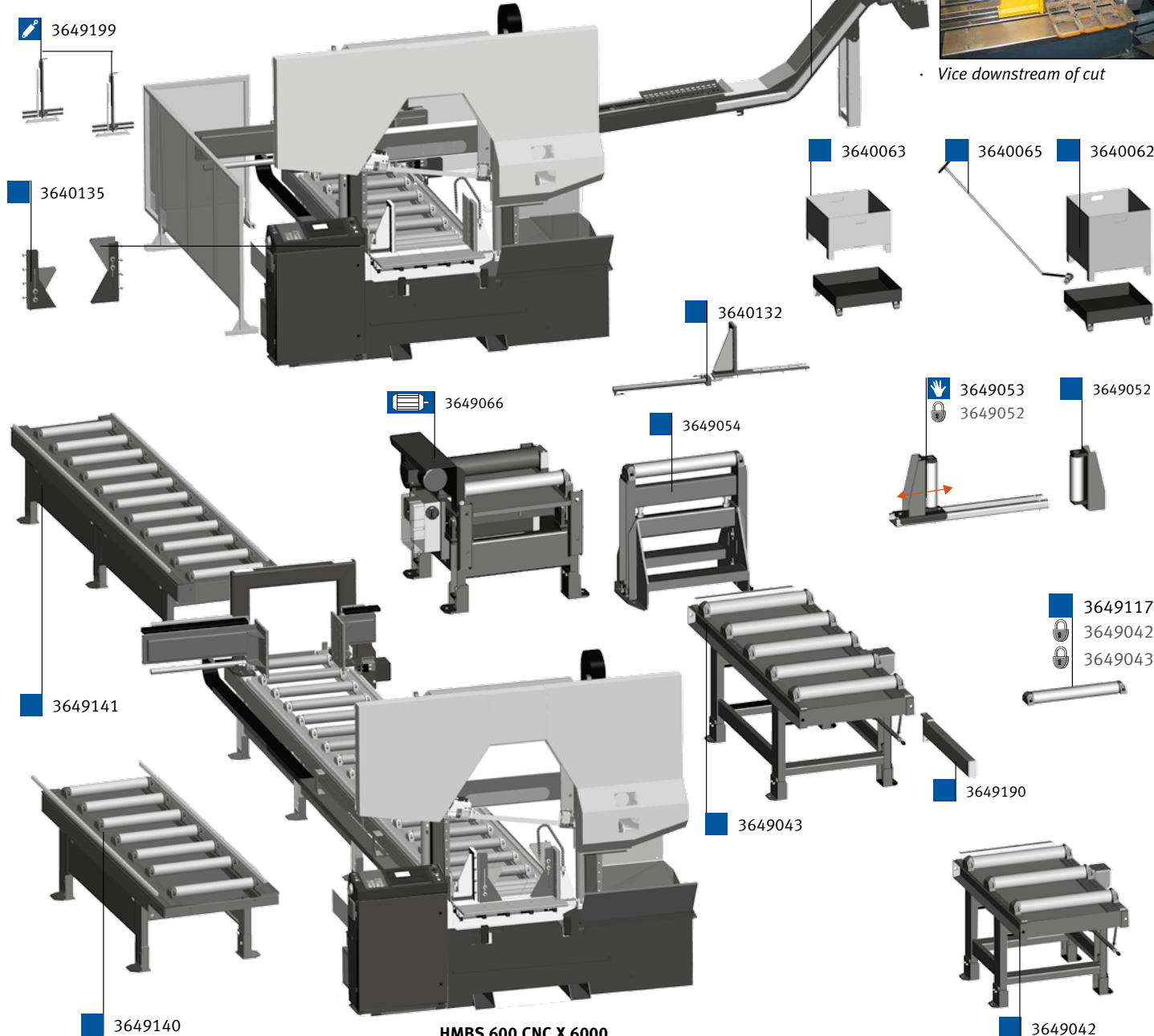
Clamping range

mm	0°	$\frac{b}{a \times b}$
	600	X
	400 *	X
	600 x 510	600 x 415

* recommended values for full material



Vice downstream of cut



HMBS 600 CNC X 6000

Optional accessories (only available from factory)

Art. no.	
3640131	Swarf conveyor
3640132	Hydraulic vice downstream of cut
3640011	Cutting line laser
3640010	Micro-spraying system
3649199	2xHydraul. Bundle clamping unit
3640266	Material start sensor
3649140	Extension of feed unit by 2000 mm
3649141	Extension of feed unit by 3000 mm
3640135	Prism-type clamping jaws

Accessories

3640062	Workpiece container
3640063	Swarf container
3640065	Trolley for swarf and workpiece container

Roller conveyors

Art. no.	
3649042	1000 x 620 mm roller conveyor 1700 kg/m
3649043	2000 x 620 mm roller conveyor 1700 kg/m
3649066	Motorised roller conveyor with hydr. driven lifting roller

Accessories, roller conveyors

3649053	lateral guide roller, moving for roller conveyors (requires: 3649052*)
3649052	Lateral guide roller, rigid
3649054	Roller support, height-adjustable, width 620 mm, load-bearing capacity 1,000 kg
3649117	Additional roller 620 mm (requires 3649042*/3649043*)
3649190	Measuring track extension

M42 saw bands

3655215	6230 x 41 x 1.3 mm 3-4 tpi Sprint Plus
3655216	6230 x 41 x 1.3 mm 2-3 tpi Sprint Plus

* must be ordered with your order! *incl. legs and connecting adapter

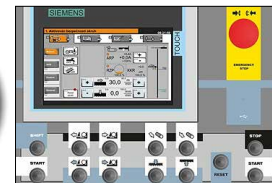
HMBS 700 x 750 HA X

Semi-automatic two-column horizontal metal-cutting band saw with SIEMENS control unit for heavy-duty industrial use

Semi-automatic

- ▶ Linear guides on both columns ensure perfect cutting results
- ▶ Rugged 3-phase motor including overload protection
- ▶ The vice is equipped with a long stroke cylinder to compensate for larger differences in cross-sections
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ Hydraulic vice pressure control

NEW
With Siemens
control unit



! For an exhaustive explanation of the controls, see pages 205 – 209



• Front band guide automatically moves in parallel with the moving vice for more stable saw band guiding



Scope of supply

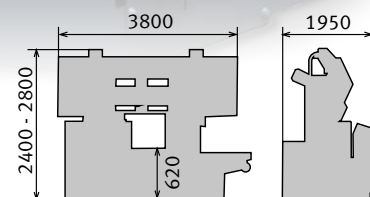
- ▶ Saw band
- ▶ Operating tool
- ▶ Workplace lighting
- ▶ Motorised swarf brush
- ▶ Frequency converter,
- ▶ Coolant pump
- ▶ Hydraulic band tensioning unit

! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 700 x 750 HA X
Art. no.	3690082

Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15/80 m/min
Saw band dimensions (mm)	7680 x 67 x 1.6
Dimensions (L x W x H)	4100 x 1950 x 2700
Table height material feed	620 mm
Weight	5950 kg
Transport packaging flat rate*	TPFR 6 = € 200.00

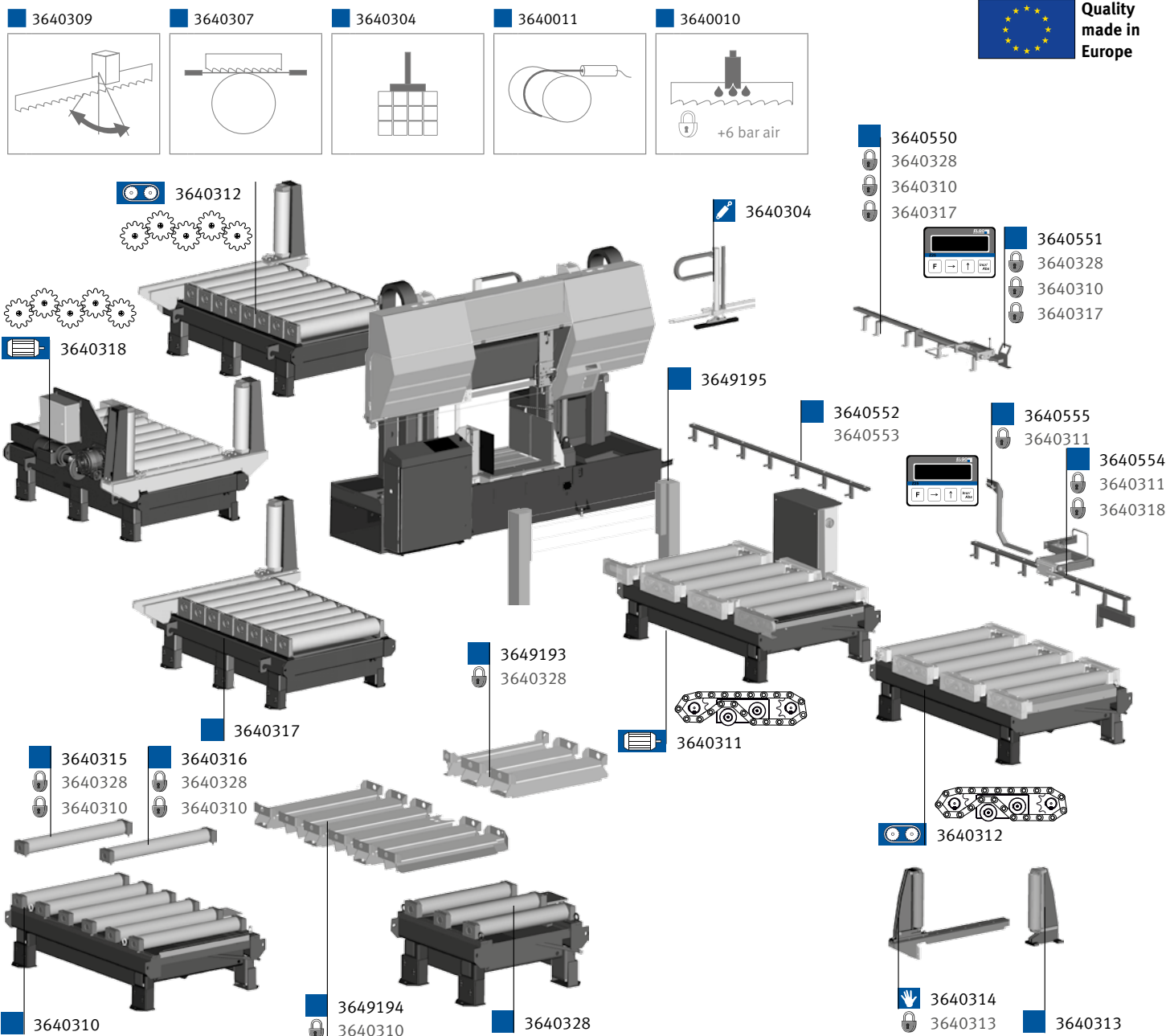
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°	b a x b
	700	X
	700 *	X
	750 x 700	750 x 450

* recommended values for full material



Optional accessories (only available from factory)	Art. no.	Accessories, roller and measuring tracks	Art. no.
Hydraul. Bundle clamping unit	3640304	lateral guide roller, moving for roller conveyors (requires: 3640313*)	3640314
Cutting line laser	3640011	Lateral guide roller, rigid	3640313
Micro-spraying system	3640010	Additional roller 800 mm (requires 3640328*/3640310*)	3640315
Material start sensor	3640307	Idler rollers tempered to 55 HRc (requires 3640328/ 3640310)	3640316
Cut path monitoring	3640309	1m casing for roller conveyor (requires 3640328)	3649193
Safety light barrier	3649195	2m casing for roller conveyor (requires 3640310)	3649194
Roller conveyors		2m stop with measuring scale - heavy-duty version (requires 3640328* /3640310* /3640317*)	3640550
1000 x 800 mm roller conveyor	3640328	2m stop with dig. measuring display - heavy duty version, (requires 3640328* /3640310* /3640317*)	3640551
2000 x 800 mm roller conveyor	3640310	2m extension for stop with scale and measuring scale - heavy duty version	3640552
Motorised roller conveyor 2000 x 800 mm	3640311	2m extension for stop with digital display - heavy duty version	3640553
2000 x 800 mm motorised extension requires: 3640311*	3640312	Electro-mechanical stop for motor. Roller conveyor with scale - heavy duty version (requires 3640311* /3640318*)	3640554
2000 x 800 mm feed/discharge roller conveyor heavy-duty version	3640317	Electro-mechanical stop for motor. Roller conveyor with digital display - heavy duty version (requires: 3640311*)	3640555
2000 x 800 mm feed/discharge roller conveyor, motorised / heavy-duty version	3640318	M42 saw bands	
2000 x 800 mm extension motorised / heavy duty version	3640319	7680 x 67 x 1.6 2-3 tpi Sprint Plus	3655410
		7680 x 67 x 1.6 3-4 tpi Sprint-Medium-VS	3655411
		* must be ordered with your order! *incl. legs and connecting adapter	

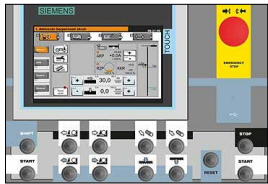
HMBS 700 x 750 CNC X

Automatic two column horizontal metal-cutting band saw with ARP system for heavy-duty industrial use

Automatic

- ▶ The vices are equipped a long stroke cylinder
- ▶ Clamping pressure control
- ▶ the fixed, hydraulically-controlled jaw on the vice moves back by 5 mm, thus improving the workpiece feed
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Clamping of the material upstream and downstream of the cut through two-part vice
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ Compact design with short distance between saw arm guide and vice for low-vibration operation
- ▶ electronic setting of the saw arm's top and bottom positions
- ▶ permanent monitoring of the saw band and feed speeds
- ▶ USB interface

NEW
With Siemens
control unit



! For an exhaustive explanation of the controls, see pages 205 – 209



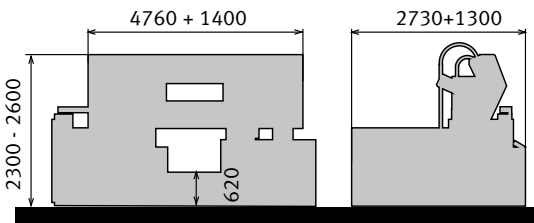
- Scope of supply**
- ▶ Saw band
 - ▶ Operating tool
 - ▶ Workplace lighting
 - ▶ Autom. band guide setting
 - ▶ Motorised swarf clearing brush
 - ▶ Frequency converter,
 - ▶ Swivelling control panel
 - ▶ Coolant pump
 - ▶ Hydraulic band tensioning unit

! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 700 x 750 CNC X
Art. no.	3690083

Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15/80 m/min
Saw band dimensions (mm)	7680 x 67 x 1.6
Dimensions (L x W x H)	7000 x 2750 x 2700 mm
Table height material feed	620 mm
Weight	12500 kg
Transport packaging flat rate*	TPFR 7 = € 300.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

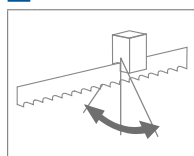


Clamping range

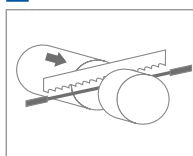
mm	0°	$\begin{matrix} b \\ a \times b \end{matrix}$
	700	x
	700 *	x
	750 x 700	750 x 450

* recommended values

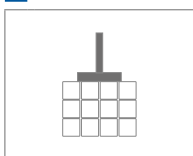
3640309



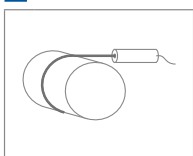
3640306



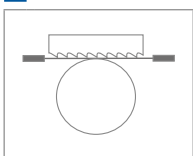
3640327



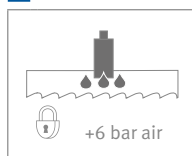
3640011



3640307



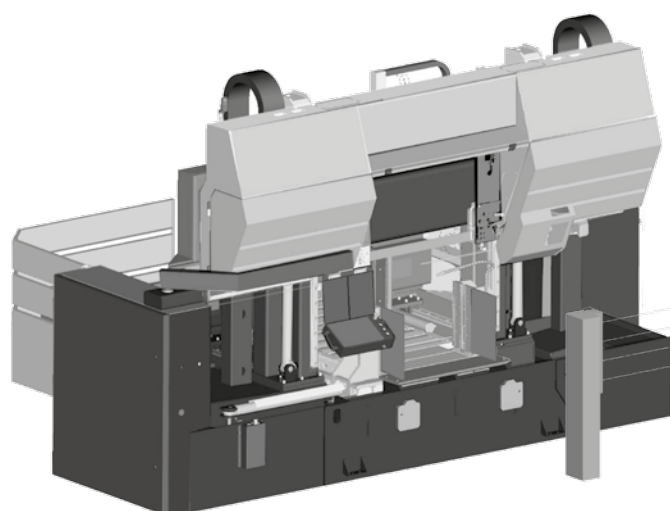
3640010



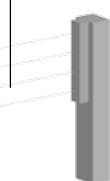
Quality
made in
Europe



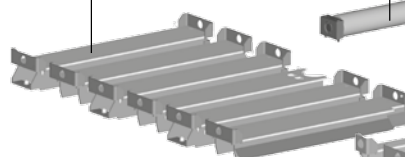
Clamping of the material upstream and downstream of the cut through two-part vice



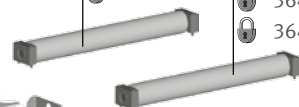
3649195



3649194
3640310



3640315
3640328
3640310

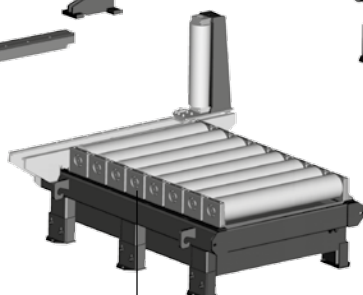


3640316
3640328
3640310

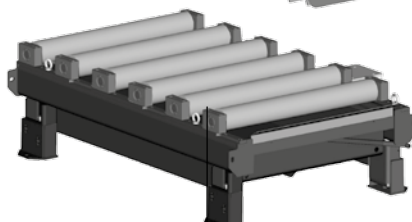
3640314
3640313



3640313

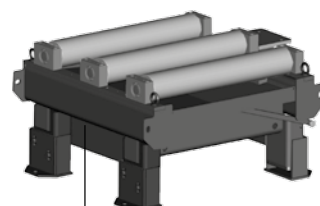


3640317



3640310

3649193
3640328



3640328

Optional accessories (only available from factory)

Art. no.	
3640327	Hydraul. Bundle clamping unit
3640011	Cutting line laser
3640010	Micro-spraying system
3640306	Automatic material start sensor **
3640307	Automatic detection of the top material end point **
3640309	Cut path monitoring **
3649195	Safety light barrier

Roller conveyors

3640328	1000 x 800 mm roller conveyor
3640310	2000 x 800 mm roller conveyor
3640317	2000 x 800 mm feed/discharge roller conveyor heavy-duty version

Accessories, roller and measuring tracks

Art. no.	
3640314	lateral guide roller, moving for roller conveyors (requires: 3640313*)
3640313	Lateral guide roller, rigid
3640315	Additional roller 800 mm (requires 3640328*/3640310*)
3640316	Idler rollers tempered to 55 HRC (requires 3640328/ 3640310)
3649193	1m casing for roller conveyor (requires 3640328)
3649194	2m casing for roller conveyor (requires 3640310)
3655410	M42 saw bands 7680 x 67 x 1.6 2-3 tpi Sprint Plus
3655411	7680 x 67 x 1.6 3-4 tpi Sprint-Medium-VS

* must be ordered with your order! ** Explanations, see page 241

HMBS 850 x 1000 HA X / HMBS 850 x 1000 CNC X

Semi-automatic/fully-automatic two column horizontal metal-cutting band saw with ARP system for heavy-duty industrial use with ARP-System

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Material feed 700 mm
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Robust, automatically adjustable saw band guide with cooling system
- ▶ With hydraulic band tensioning
- ▶ Line guides on both columns
- ▶ With motorised swarf clearing brush

Semi-automatic

Automatic

NEW
With Siemens
control unit



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply:

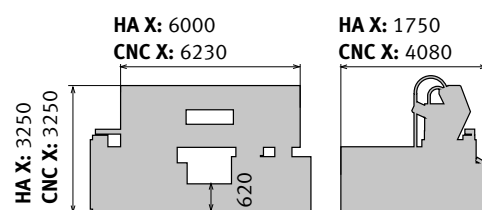
- ▶ Saw band
- ▶ Operating tool
- ▶ Workplace lighting
- ▶ Swarf conveyor
- ▶ Frequency converter
- ▶ Material feed 700 mm
- ▶ Coolant pump

We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 850x1000 HA X	HMBS 850 x 1000 CNC X
Art. no.	3690013	3690094

Technical specifications		
Motor output 3 x 400 V/50 Hz	11 kW	11 kW
Speed stages	Continuously variable	Continuously variable
Saw band speeds	15 – 80 m/min.	15 – 80 m/min.
Saw band dimensions	9490 x 67 x 1.6 mm	9490 x 67 x 1.6 mm
Dimensions (L x W x H)	6000 x 1750 x 3250 mm	6230 x 4080 x 3250 mm
Table height material feed	620 mm	620 mm
Weight	7800 kg	13700 kg
		50 mm
Transport packaging flat rate*	TPFR 8 = € 400.00	TPFR 8 = € 400.00

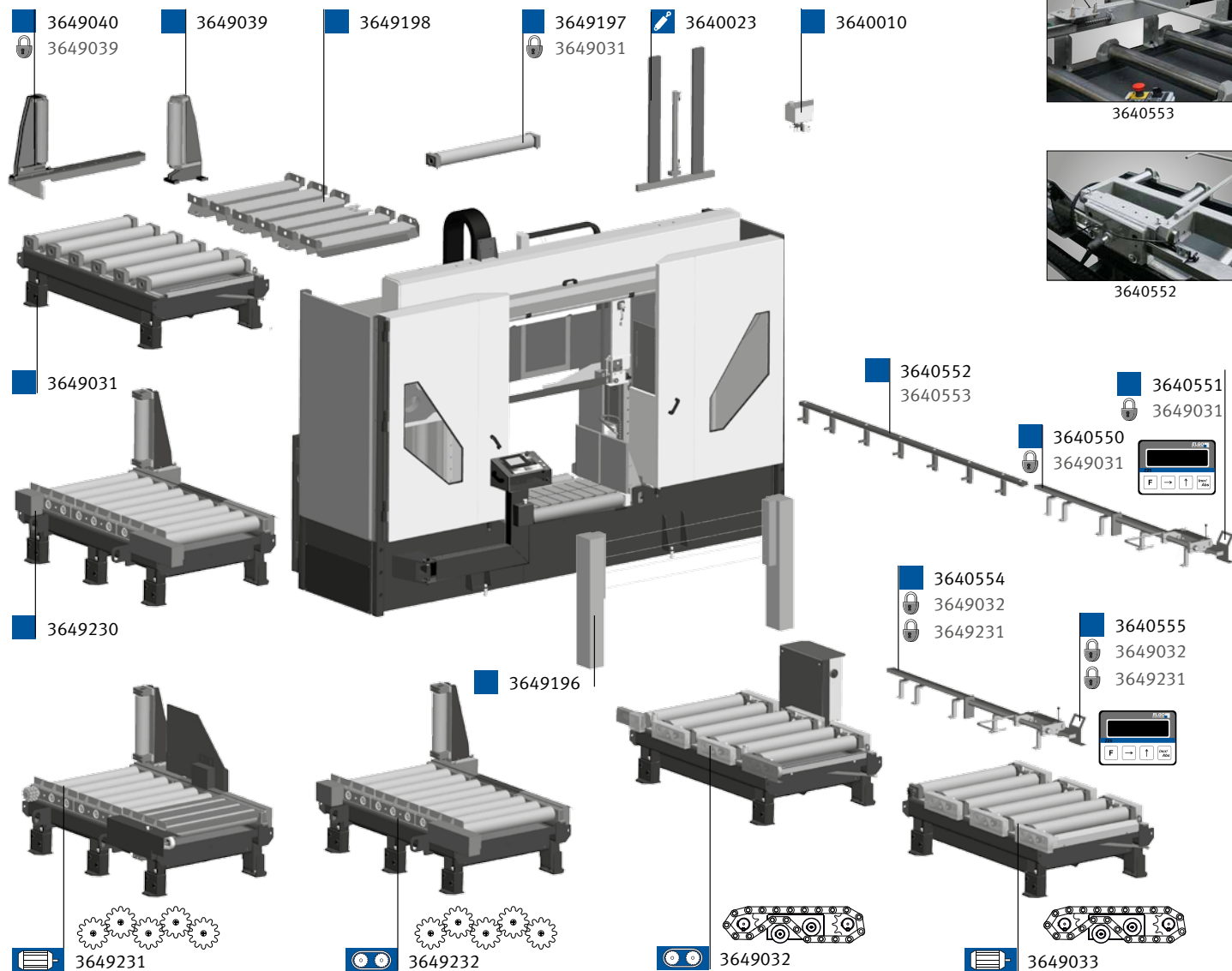
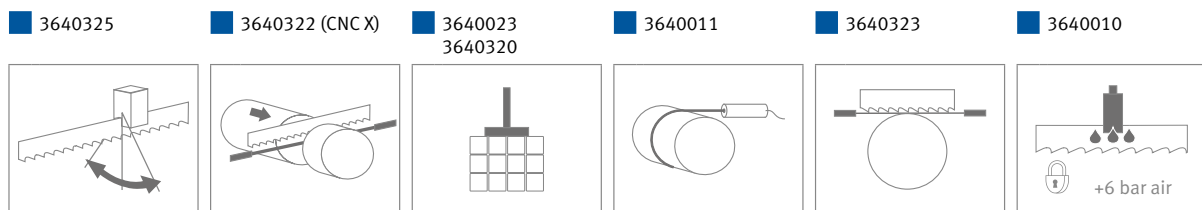
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°	a x b
850	x	x
850 *	x	x
1000 x 850		1000 x 610

* recommended values



Optional accessories (only available from factory)	Art. no.
Light barrier	3649196
Cutting line laser	3640011
Micro-spraying system	3640010
Automatic detection of the top material end point **	3640323
Cut path monitoring **	3640325
Hydraul. Bundle clamping unit (for HA-X only)	3640023
Hydraul. Bundle clamping unit (for CNC-X only)	3640320
Material start sensor (for CNC-X only)	3640322
Roller conveyors	
2000 x 1000 mm roller conveyor 5000 kg/m	3649031
2000 x 1000 mm heavy-duty roller conveyor, 7000 kg/m	3649230
Roller conveyors for HA X only	
2000 x 1000 mm motorised roller conveyor, 5000 kg/m	3649032
2000 x 1000 mm extension to motorised roller conveyor, 5000 kg/m	3649033
2000 x 1000 mm feed/discharge roller conveyor heavy-duty version, load-bearing capacity 7000 kg/m	3649231
2000 x 1000 mm motorised feed/discharge roller conveyor heavy-duty version, load-bearing capacity 7000 kg/m	3649232

Accessories, roller conveyors 1000 mm	Art. no.
lateral guide roller, moving for roller conveyors (requires: 3649039*)	3649040
Lateral guide roller, rigid	3649039
Additional roller 1000 mm (requires: 3649031*)	3649197
2m casing for roller conveyor (requires 3649031*)	3649198
2m stop with measuring scale (requires 3649031*)	3640550
2m stop with digital measuring display (requires 3649031*)	3640551
2m extension with measuring scale (requires 3640553*)	3640552
2m extension for stop with digital display	3640553
Electro-mechanical stop for motor. Roller conveyor with measuring scale (requires 3649032* / 3649231*)	3640554
Electro-mechanical stop for motor. Roller conveyor with digital display (requires 3649032* / 3649231*)	3640555
M42 saw bands	
9490 x 67 x 1.6 2-3 tpi Sprint-Medium-VS	3655011
9490 x 67 x 1.6 3-4 tpi Sprint Plus	3655111

* must be ordered with your order! ** Explanations, see page 241

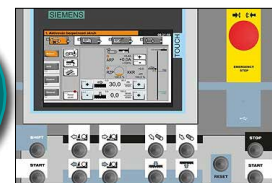
HMBS 850 x 1000 HA X-VS New

Semi-automatic two column horizontal metal-cutting band saw with ARP system for heavy-duty industrial use

Semi-automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Custom model with symmetrical moving clamping system
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Robust, automatically adjustable saw band guide with cooling system
- ▶ With hydraulic band tensioning
- ▶ Line guides on both columns

NEW
With Siemens
control unit



! For an exhaustive explanation of the controls, see pages 205 – 209



Scope of supply

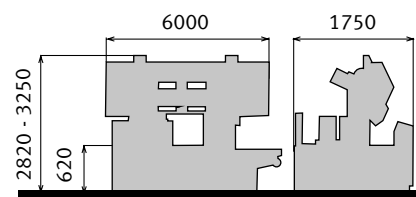
- ▶ Saw band
- ▶ Operating tool
- ▶ Workplace lighting
- ▶ Swarf conveyor
- ▶ Frequency converter
- ▶ Coolant pump

! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 850 x 1000 HA X-VS
Art. no.	3690175

Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15/80 m/min.
Saw band dimensions	9490 x 67 x 1.6 mm
Dimensions (L x W x H)	6000 x 1750 x 3250 mm
Table height material feed	620 mm
Weight	8100 kg
Transport packaging flat rate*	TPFR 7 = € 300.00

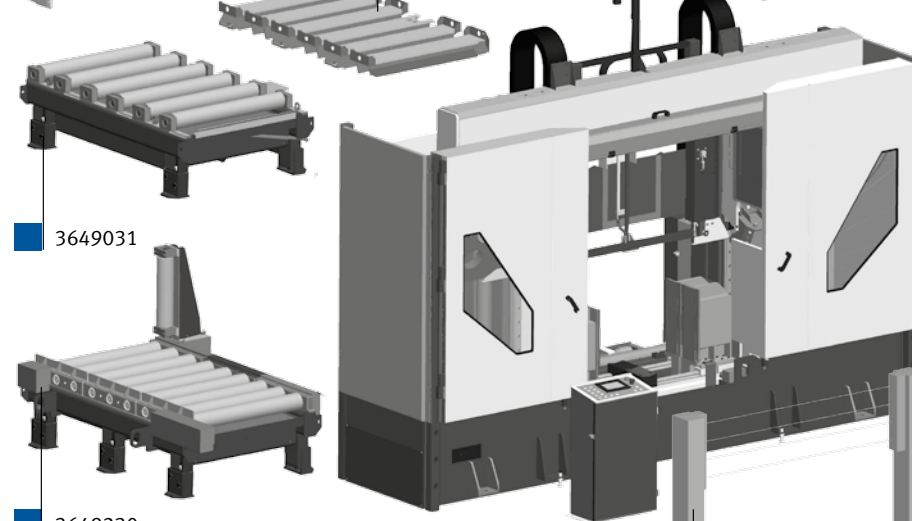
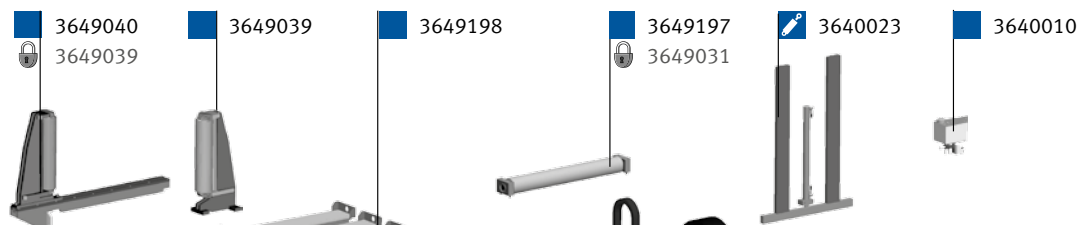
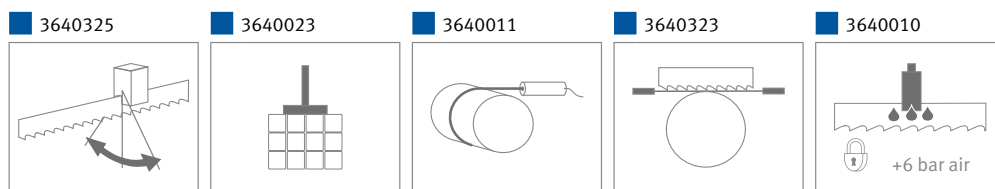
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



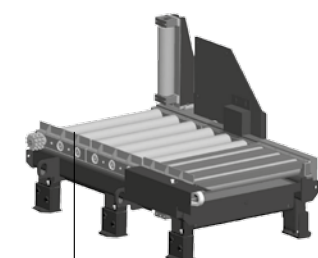
Clamping range

mm	0°	
	850	x
	850	x
	850 x 850	850 x 610

* recommended values



3649230

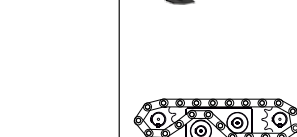


3649231



3649232

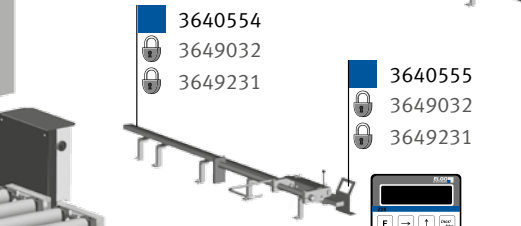
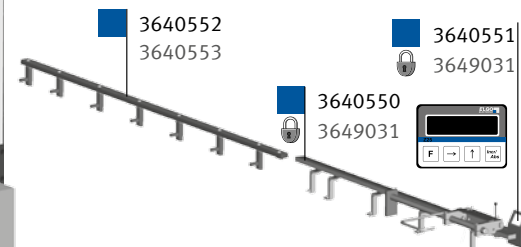
3649196



3649032



3649033



3640554
3649032
3649231



3640553



3640552

Optional accessories (only available from factory)

Optional accessories (only available from factory)	Art. no.
Light barrier	3649196
Cutting line laser	3640011
Micro-spraying system	3640010
Automatic detection of the top material end point **	3640323
Cut path monitoring **	3640325
Hydraul. Bundle clamping unit	3640023
Roller conveyors	
2000 x 1000 mm roller conveyor 5000 kg/m	3649031
2000 x 1000 mm motorised roller conveyor, 5000 kg/m	3649032
2000 x 1000 mm roller conveyor extension motorised, 5000 kg/m	3649033
2000 x 1000 mm heavy-duty roller conveyor, 7000 kg/m	3649230
2000 x 1000 mm feed/discharge roller conveyor heavy-duty version, load-bearing capacity 7000 kg/m	3649231
2000 x 1000 mm motorised feed/discharge roller conveyor heavy-duty version, load-bearing capacity 7000 kg/m	3649232

Accessories, roller conveyors 1000 mm

Accessories, roller conveyors 1000 mm	Art. no.
lateral guide roller, moving for roller conveyors (requires: 3649039*)	3649040
Lateral guide roller, rigid	3649039
Additional roller 1000 mm (requires: 3649031*)	3649197
2m casing for roller conveyor (requires 3649031*)	3649198
2m stop with measuring scale (requires 3649031*)	3640550
2m stop with digital measuring display (requires 3649031*)	3640551
2m extension with measuring scale (requires 3640553*)	3640552
2m extension for stop with digital display	3640553
Electro-mechanical stop for motor. Roller conveyor with measuring scale (requires 3649032* /3649231*)	3640554
Electro-mechanical stop for motor. Roller conveyor with digital display (requires 3649032* /3649231*)	3640555
M42 saw bands	
9490 x 67 x 1.6 2-3 tpi Sprint-Medium-VS	3655011
9490 x 67 x 1.6 3-4 tpi Sprint Plus	3655111

* must be ordered with your order! ** Explanations, see page 241

More saw bands and info on page 283

! When ordering a roller conveyor, always state whether you need a feed or discharge conveyor

HMBS 1000 HA X / HMBS 1000 CNC X 4000

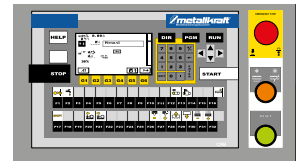
HMBS 1000 HA X - Semi-automatic two-column horizontal metal-cutting band saw with extra high passage ARP system

HMBS 1000 CNC X 4000 - Vollautomatisch mit 4000 mm Materialvorschub

- ▶ Specially developed for cutting pipes
- ▶ Saw band tilted by 12°
- ▶ The machine frame consists of a solid 2-column steel construction with linear guides
- ▶ Motor includes overload protection
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ Hydraulic clamping pressure control
- ▶ Features 64-bit control system

Semi-automatic

Automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



HMBS 1000 HA X with optional bundle clamping unit (Art. no. 3640130)

New

Machines with 8m, 12m material feed on request!

Scope of supply

- ▶ Saw band
 - ▶ Operating tool
 - ▶ Two workplace lights
 - ▶ ARP system
 - ▶ Swarf conveyor
 - ▶ Frequency converter, driven swarf clearing brush
- HMBS 1000 CNC X 4000**
- ▶ 4000 mm material feed

We are always happy to perform sample cutting for your material. Call us for details!



HMBS 1000 CNC X 4000 with optional bundle clamping unit (Art. no. 3640130)

Model	HMBS 1000 HA X	HMBS 1000 CNC X 4000
Art. no.	3690100	3690102

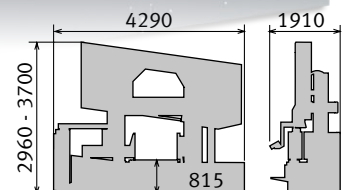
Technical specifications	HMBS 1000 HA X	HMBS 1000 CNC X 4000
Motor output 3 x 400 V/50 Hz	7.5 kW	7.5 kW
Speed stages	Continuously variable	Continuously variable
Saw band speeds	20 - 100 m/min	20 - 100 m/min
Saw band dimensions	8920 x 54 x 1.6 mm	8920 x 54 x 1.6 mm
Dimensions (L x W x H)	4290 x 1910 x 3700 mm	4680 x 10080 x 3700 mm
Table height material feed	815 mm	815 mm
Weight	6040 kg	10800 kg
Transport packaging flat rate*	TPFR 8 = € 400.00	TPFR 8 = € 400.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

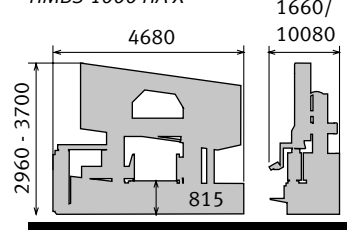
Clamping range

mm	0°
1000	
550 *	
1000 x 960	
1000 x 650	

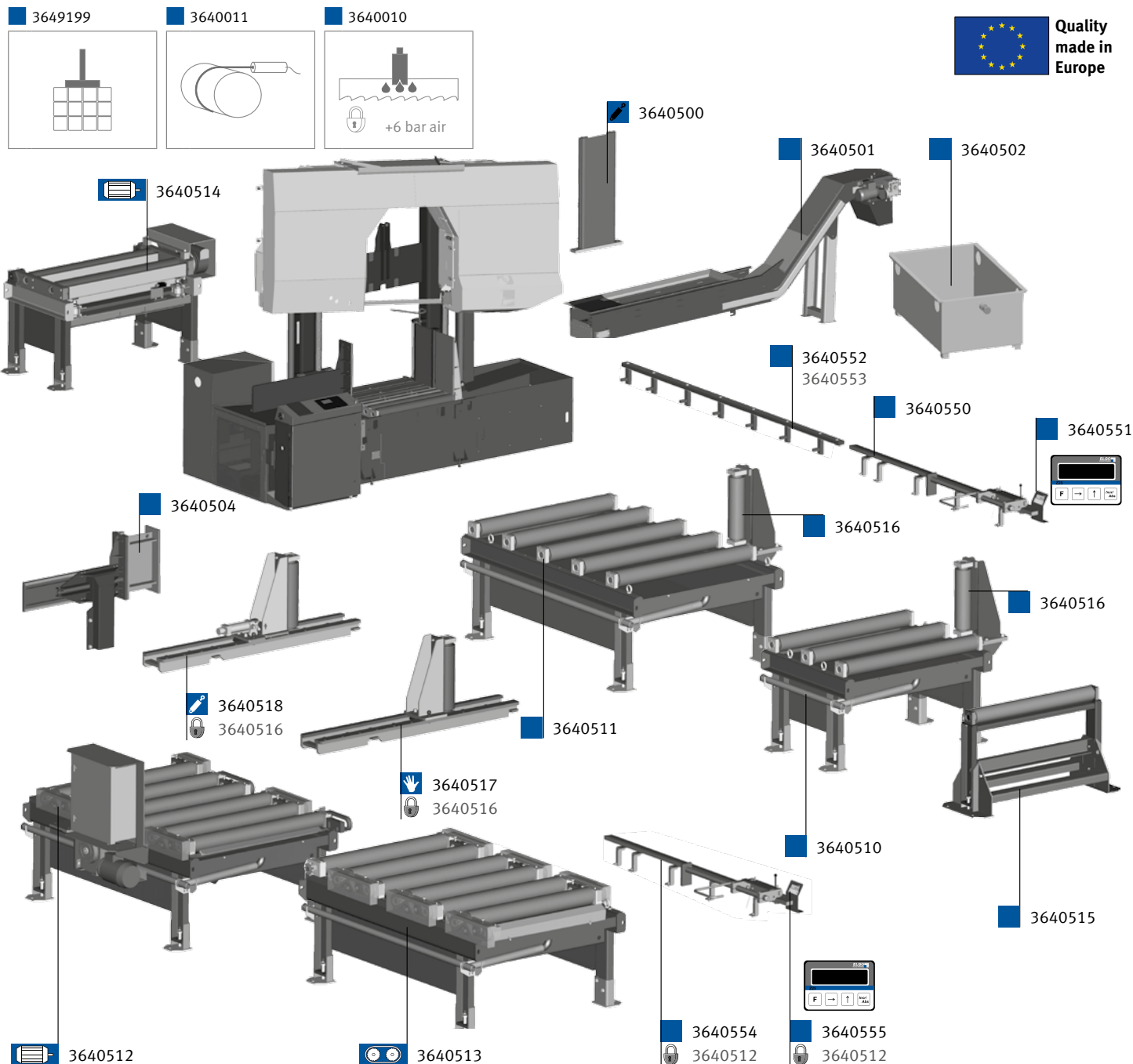
* recommended values



HMBS 1000 HA X



HMBS 1000 CNC X 4000



Optional accessories (only available from factory)	Art. no.
Cutting line laser	3640011
Micro-spraying system	3640010
Swarf conveyor	3640501
Vice downstream of cut	3640503
Additional clamping jaw for round material with less than Ø 600 mm	3640504
Hydraulic bundle clamping unit for HA X	3640500
Hydraulic bundle clamping unit for CNC X	3640556
Accessories	
Swarf container large version	3640502
Roller conveyors (incl. legs and connecting adapter)	
1000 x 1150 mm roller conveyor	3640510
2000 x 1150 mm roller conveyor	3640511
Hydraulic lifting roller	3640514
Roller conveyors for HA X**	
2000 x 1150 mm motorised roller conveyor	3640512
2000 x 1150 mm motorised roller conveyor extension	3640513

Accessories, roller conveyors	Art. no.
Lateral guide roller, rigid	3640516
lateral guide roller, moving for roller conveyors (requires: 3640516*)	3640517
Roller support, height-adjustable, width 1150 mm, load-bearing capacity 1,000 kg	3640515
Accessories roller conveyor HA X	
Lateral guide roller, mobile and hydraulic for roller conveyor (requires 3640516*)	3640518
2 m fixed stop with measuring scale	3640550
2m stop with digital measuring display	3640551
2m extension for stop with measuring scale	3640552
2m extension for stop with digital display	3640553
Electro-mechanical stop for motor. Roller conveyor (requires 3640312*)	3640554
Electro-mechanical stop for motor. Roller conveyor with digital display (requires 3640312*)	3640555
Accessories, roller conveyors CNC	
lateral Guide roller, mobile on transporter	3640557

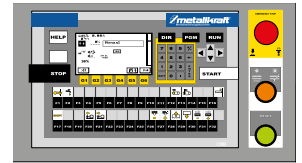
* must be ordered with your order! *incl. legs and connecting adapter

HMBS 1200 x 1400 HA X / HMBS 1200 x 1400 CNC X

Semi-automatic/fully-automatic two column horizontal metal-cutting band saw with ARP system for heavy-duty industrial use

Semi-automatic

- ▶ Developed for cutting full materials
- ▶ A hydraulic system controls the machines automated work sequences
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Linear guides on both columns ensure perfect cutting results
- ▶ Wheels tilted for a longer saw band service life



! For an exhaustive explanation of the controls, see pages 205 – 209



- ▶ with solid, precision 2-column guide
- ▶ Linear guides on both columns ensure perfect cutting results

▶ Chip conveyor as standard

Scope of supply

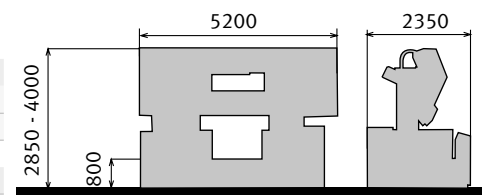
- ▶ Saw band
- ▶ Operating tool
- ▶ Two workplace lights
- ▶ ARP system
- ▶ Swarf conveyor
- ▶ Frequency converter,
- ▶ Cooling system on the saw band guides
- ▶ Motorised swarf clearing brush
- ▶ Automatic band guide setting

We are always happy to perform sample cutting for your material. Call us for details!

HMBS 1200 x 1400 HA X
Fig. with optional 2nd vice

Model	HMBS 1200 x 1400 HA X	New HMBS 1200 x 1400 CNC X
Art. no.	3690052	3690097
Technical specifications		
Motor output 3 x 400 V/50 Hz	11 kW	11 kW
Speed stages	Continuously variable	Continuously variable
Saw band speeds	15 – 80 m/min.	15 – 80 m/min.
Saw band dimensions	11650 x 80 x 1.6 mm	11650 x 80 x 1.6 mm
Dimensions (L x W x H)	5200 x 2350 x 4000 mm	5200 x 2350 x 4000 mm
Table height material feed	800 mm	800 mm
Weight	25000 kg	25000 kg
Transport packaging flat rate*	TPFR 8 = € 400.00	TPFR 8 = € 400.00

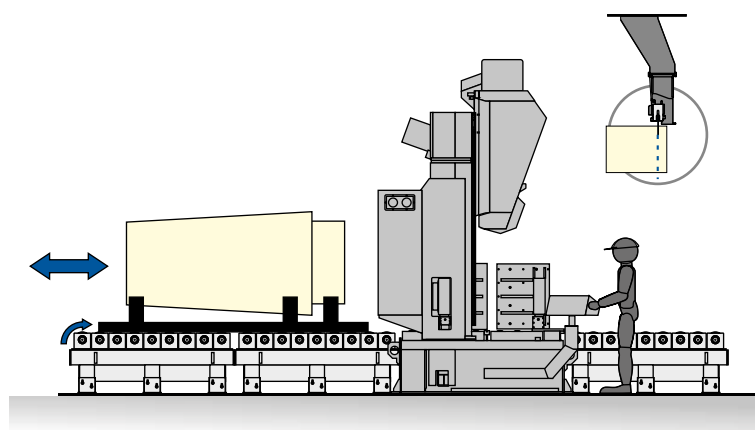
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°
	1200
	1200 *
	1200 x 1400

* recommended values

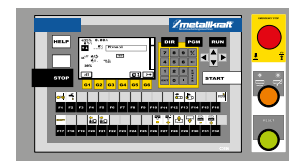


HVMBS 850 x 1000 Xtreme

Semi-automatic two column horizontal metal-cutting horizontal/vertical band saw with moving material support table for heavy-duty industrial use

Semi-automatic

- ▶ Developed for cutting full materials
- ▶ Material movements are handled by a moving clamping table borne on a linear guide and actuated by an independent control
- ▶ Saw band swivels through 90° - ideal for notching in blocks of solid material
- ▶ Automatic band guide with adjustable tungsten carbide plates and cooling system
- ▶ A hydraulic system controls the machines automated work sequences
- ▶ With an electrically driven swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ The wheels are tilted for a longer saw band service life
- ▶ With continuously variable saw band speed setting
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece support plus an additional bottom end position sensor



! For an exhaustive explanation of the controls, see pages 205 – 209

Scope of supply

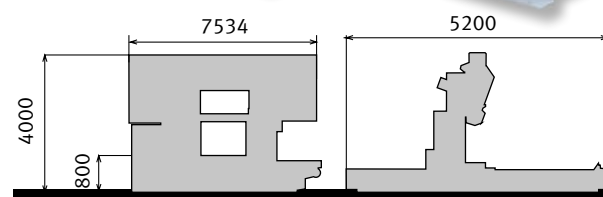
- ▶ Saw band
- ▶ Operating tool
- ▶ Two workplace lights
- ▶ ARP system
- ▶ Swarf conveyor
- ▶ Moving clamping table with 2500 mm stroke
- ▶ Automatic band guide setting
- ▶ Frequency converter



Model	HVMBS 850 x 1000 Xtreme
Art. no.	3690020

Technical specifications	
Motor output 3 x 400 V/50 Hz	11.0 kW
Speed stages	Continuously variable
Saw band speeds	15 – 80 m/min.
Saw band dimensions	9080 x 67 x 1.6 mm
Dimensions (L x W x H)	5200 x 7534 x 4000 mm
Table height material feed	800 mm
Weight	12500 kg
Transport packaging flat rate*	TPFR 8 = € 400.00

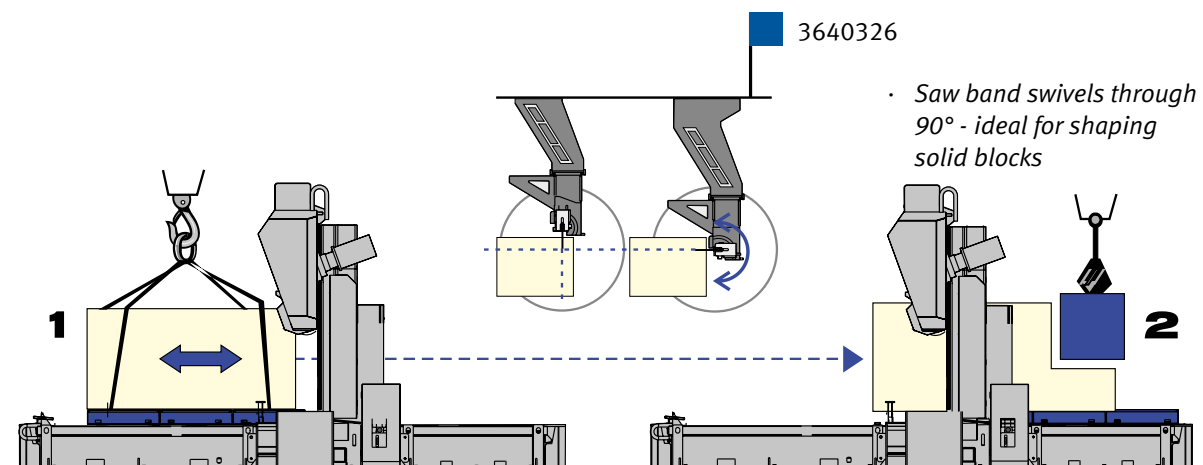
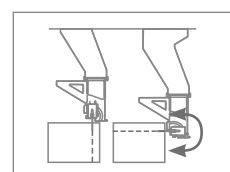
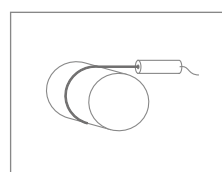
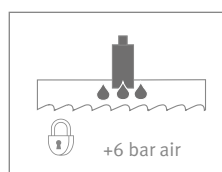
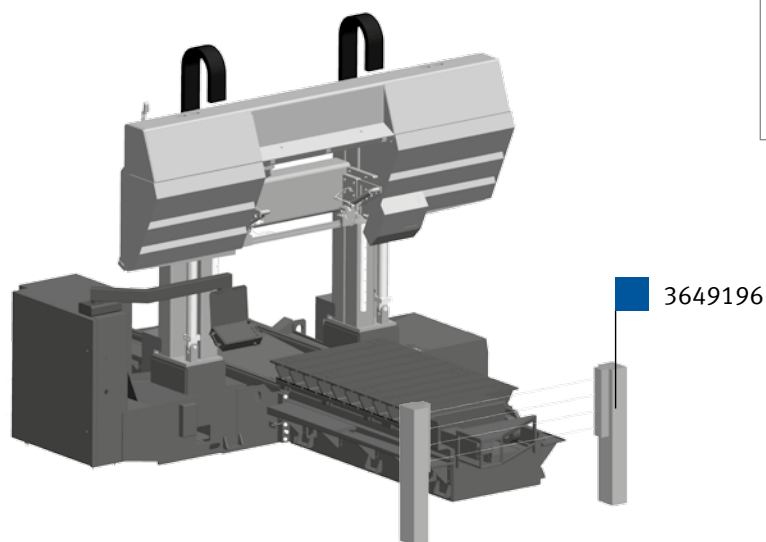
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°
	850
	1000 x 850
	2000 x 850

! We are always happy to perform sample cutting for your material. Call us for details!



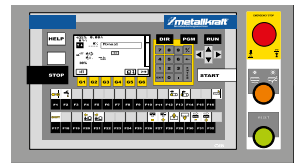
Optional accessories	Art. no.
Cutting line laser	3640011
Micro-spraying system	3640010
Hydraulically swivelling saw band guide	3640326

HVMBBS 1200 x 1600 Xtreme

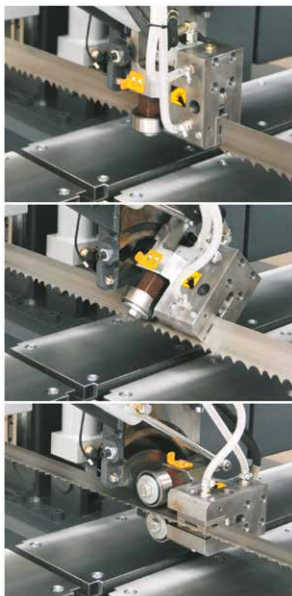
Semi-automatic two column horizontal/vertical metal-cutting band saw with moving feed table for heavy-duty industrial use

- ▶ Developed for cutting full materials
- ▶ Material movements are handled by a moving clamping table borne on a linear guide and actuated by an independent control
- ▶ Saw band swivels through 90° - ideal for notching in blocks of solid material
- ▶ Automatic band guide with adjustable tungsten carbide plates and cooling system
- ▶ A hydraulic system controls the machines automated work sequences
- ▶ With an electrically driven swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ The wheels are tilted for a longer saw band service life
- ▶ With continuously variable saw band speed setting
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece support plus an additional bottom end position sensor

Semi-automatic



! For an exhaustive explanation of the controls, see pages 205 – 209



- Saw band swivels through 90°
- ideal for notching in blocks of solid material

Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Automatic band guide setting
- ▶ Swarf conveyor
- ▶ Electrically driven swarf clearing brush
- ▶ Workplace lighting
- ▶ Frequency converter

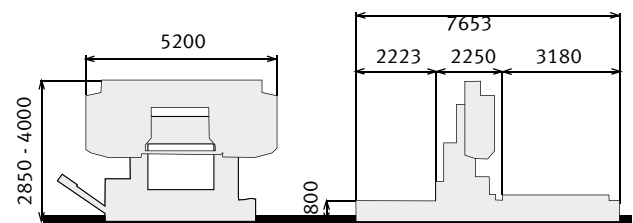


! We are always happy to perform sample cutting for your material. Call us for details!

Model	HVMBBS 1200 x 1600 Xtreme
Art. no.	3690032

Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15 – 80 m/min.
Saw band dimensions	11650 x 80 x 1.6 mm
Dimensions (L x W x H)	5200 x 7653 x 4000 mm
Table height material feed	800 mm
Weight	30350 kg
Transport packaging flat rate*	TPFR 8 = € 400.00

* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.



Clamping range

mm	0°
	1200
	1600 x 1200
	1600 x 3000



Quality
made in
Europe

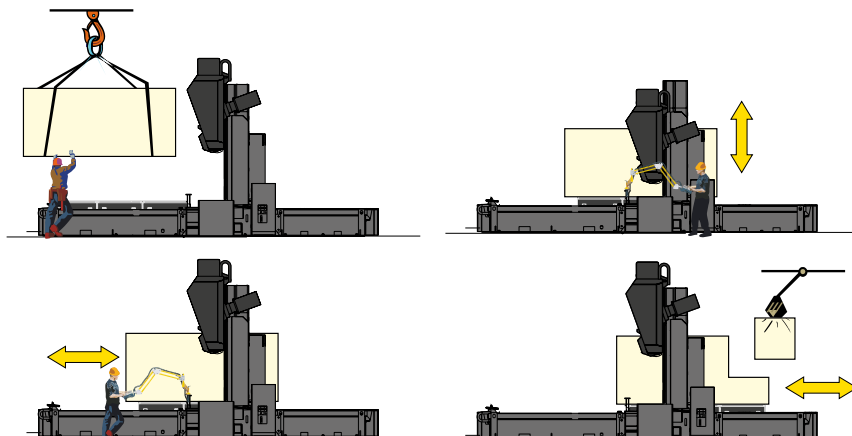


· Band rollers tilted for a longer saw band service life



· Moving clamping table with 2500 mm stroke and T grooves

! For an exhaustive explanation of the controls, see pages 205 – 209



Material feed on HVMB 1200 x 1600 Xtreme

- Material feed by clamping table
- The table is borne on linear guides and is actuated by a separate control
- The feed speed is continuously variable
- Solid work table with T grooves

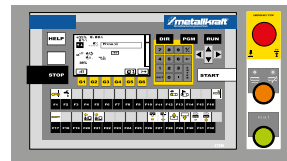
! Accessories for HVMB 1200 x 1600 Xtreme on request!

HVMBS 1250 x 1600 Portal

Semi-automatic two column horizontal/vertical metal-cutting band saw specially designed for cutting full material with extremely high deadweight

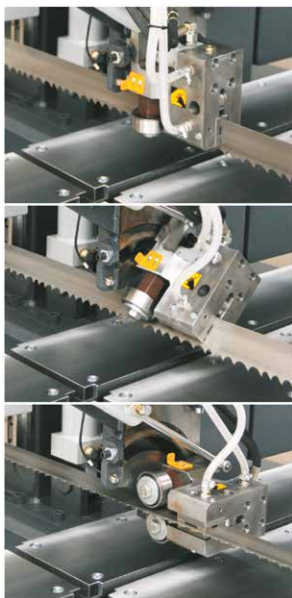
Semi-automatic

- ▶ designed for industrial use
- ▶ Developed for cutting full materials
- ▶ With an electrically driven swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ Rugged top saw band guide
- ▶ A hydraulic system controls the machines automated work sequences
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece support and an additional bottom end position sensor



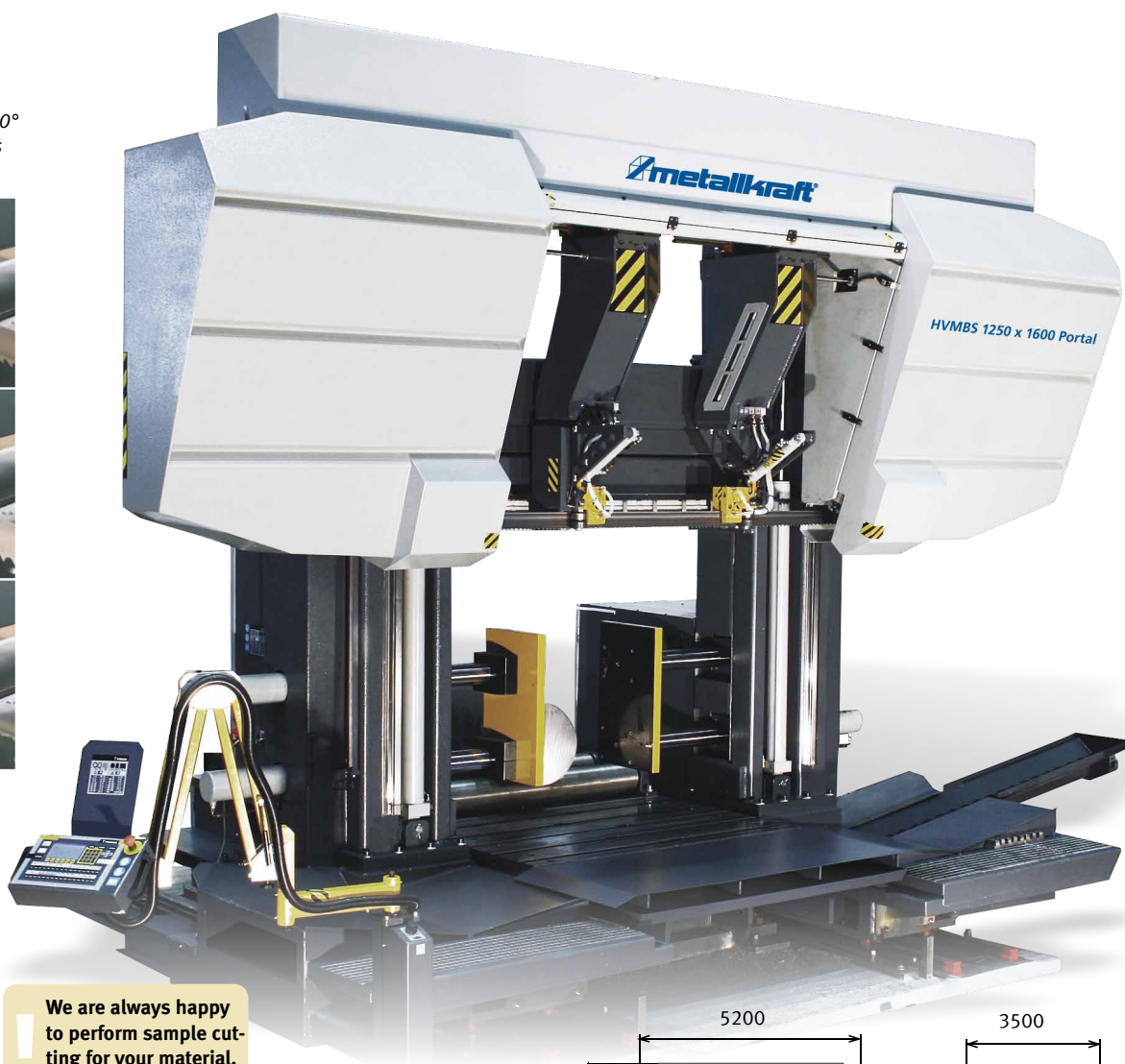
! For an exhaustive explanation of the controls, see pages 205 – 209

- Saw band swivels through 90°
- ideal for notching in blocks of solid material

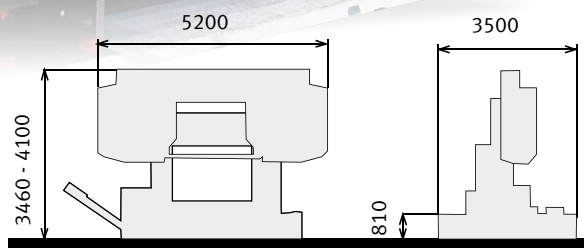


Scope of supply

- ▶ Saw band
- ▶ Operating tool
- ▶ Swarf conveyor
- ▶ Workplace lighting
- ▶ Automatic band guide setting
- ▶ Cooling system on the saw band guides
- ▶ Frequency converter



! We are always happy to perform sample cutting for your material. Call us for details!



Model	HVMBS 1250 x 1600 Portal
Art. no.	3690035

Technical specifications	
Motor output 3 x 400 V/50 Hz	12.5 kW
Speed stages	Continuously variable
Saw band speeds	15 – 80 m/min.
Saw band dimensions	11650 x 80 x 1.6 mm
Dimensions (L x W x H)	5200 x 3500 x 4100 mm
Table height material feed	810 mm
Weight	20000 kg
Transport packaging flat rate*	TPFR 8 = € 400.00

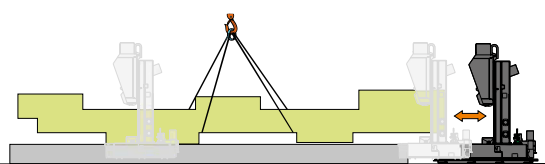
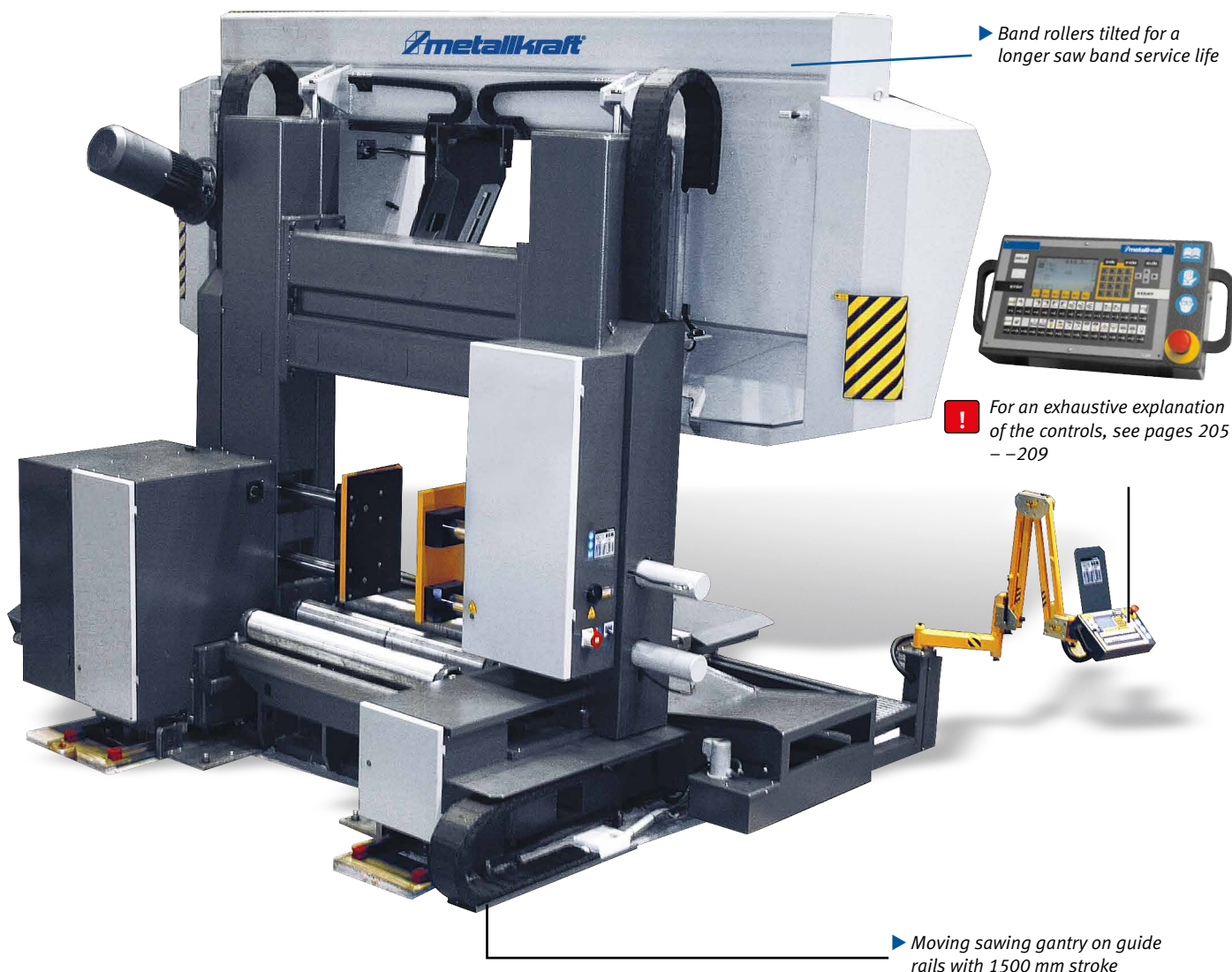
* Please turn over for descriptions of the packaging surcharges, data on TPFR excluding VAT.

Clamping range HVMBS 1250 x 1600 Portal

mm	0°
	1250
	1600 x 1250
	1600 x ...

► The HVMB 1250 x 1600 Portal band saw was developed on the basis of the HVMB 1200 x 1600 Xtreme. The main difference is the standing material table. The machine frame is implemented as a rugged gantry above the work table. The gantry is moved on gear racks by a servo drive

► This saw is specially designed for cutting long material with a greater weight than the machine itself. In this case it makes more sense to move the machine than the material.



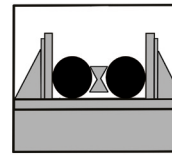
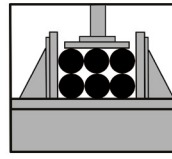
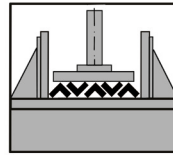
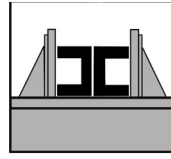
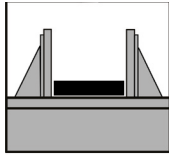
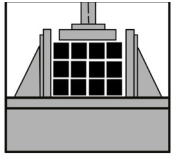
HVMB 1250 x 1600 Portal
• Saw is moved on gear racks by a servo drive

! **Accessories for HVMB 1250 x 1600 Portal on request!**

Information on metal-cutting band saws and saw bands

Clamping the material

- Clamp the material to allow for vibration-free operation of the saw band to the extent possible
- In case of bundle cutting, weld the ends if needed (this improves the cut performance and service life)



Coolant

The coolant helps to prevent overheating of the saw tooth and the workpiece, and it transports the swarf away from the cut location. It is normal to saw all steels while using a cooling emulsion. Cast iron is normally dry sawn. Cutting oil helps you achieve good cutting results when sawing case-hardened steels, higher-alloyed tool steels, heat-treated steels, stainless steels (VA) and titanium.

Running in correctly: a guarantee for long service lives.

Like all tools, saw bands need to be correctly run in. This guarantees the longest service lives and it saves tool and tooling costs.

The very sharp tooth tips must not be fully exposed to load when you start cutting. Premature overload can cause the tooth tips to break out. Correct running in helps to round the blades perfectly.

Bi-metal saw bands

For the first 300 - 500 cm² of cut surface, the saw band runs at half the feed speed and the recommended cutting speed

After the running in time, the feed is gradually increased to the intended level

Value increased. If vibration noises occur at the start of cutting, you need to make minor adjustments to the cutting speed

Carbide saw bands

We recommend the following application values for at least the first 30 minutes:

Material diameters up to 600 mm cutting speed = 30 m/min. (feed speed = 5 mm/min)

Material diameters above 600 mm cutting speed = 25 m/min. (feed speed = 3 mm/min)

After the saw band is operating in a fully vibration-free way, the cutting and feed speeds can be gradually increased simultaneously to the desired maximum values.

Cutting speed and feed

The cutting speed (band speed) depends on the strength, grade and cross-section of the material to be sawed.

The higher the strength, the lower the speed you need to select. Smaller diameters can be sawed at higher speeds than larger diameters. Thin-walled pipes and sections, and sharp edges, are sawed at a low speed, and at a constant feed rate (pressure) where possible.

Materials

- Construction steel/Machining steel
- Case-hardened steels/Heat-treated steels
- Unalloyed tool steels/Rolled steels
- Alloyed tool steels/High-speed steels
- Stainless steels
- Heat resistant steels/Highly heat-resistant alloys

- In case of vibration, minimally adjust the cutting speed (m/min) up or down.
- As blunting increases, increase the feed rate slightly

Teeth arrangement recommendations

for solid materials:

Variable toothing		
Material cross-section	Teeth per inch	Tooth shape
mm	tpi	
as of 550	0.75/1.25	K
380 - 750	1/1.5	K
250 - 550	1.4/2	K
120 - 350	2/3	K
80 - 140	3/4	K
60 - 110	4/6	K
40 - 70	5/7 5/8	K
30 - 60	6/10	K
20 - 40	8/11 8/12	K
up to 25	10/14	K

K = combined tooth

Cutting speed
in m/min. (M42)
80-90
45-75
40-60
30-40
20-35
15-25

The chip shape itself tells you if the speed and feed are correct:



thin or powdery chips - increase the feed speed

loosely rolled chips - cutting values correct

thick, heavy of blue chips - cutting values too high

Teeth arrangement recommendations for pipes:

Thin-walled sections (0° rake angle)								
Wall thickness	Section external diameter (D) in mm							
(S) in mm	20	40	60	80	100	120	150	
2	14	14	14	14	14	14	10/14	
3	14	14	14	14	10/14	10/14	8/11 8/12	
4	14	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10	6/10
5	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10	6/10	5/7 5/8
6	14	10/14	8/11 8/12	8/11 8/12	6/10	6/10	5/7 5/8	5/7 5/8
8	14	8/11 8/12	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8	-
10	-	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8	-	

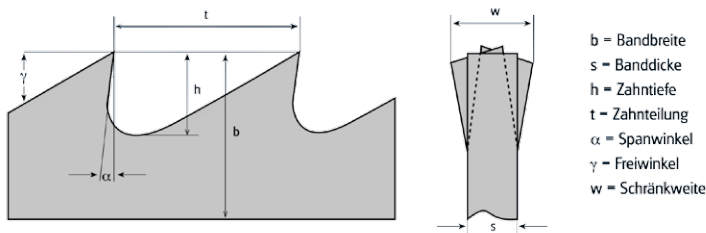
N = Standard tooth

H = Hook tooth

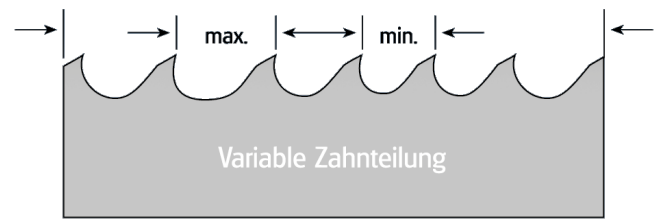
Combined teeth layouts 1,4/2, 2/3, 3/4, 4/5, 4/6 with 10° rake angle: these tooth shapes are particularly well suited to cutting solid, high-alloyed, long-chipping steel grade materials;

The use of 3/4 tooth layout allows for a good, clean cut surface in the upper Ø range up to 140 mm material cross-section.

Saw band geometry

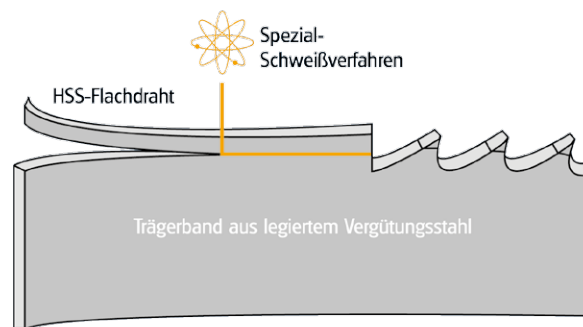


Teeth per inch



The distances between teeth change in a tooth group. Combined toothing of the saw band is designated by reference to the largest or smallest tooth in the tooth group.

Bi-metal



So flexible:

The carrier band on the bi-metal saw band consists of a specially alloyed heat-treated steel. Highly flexible with a strength of approx. 50 HRC. Long fatigue life and excellent in terms of the band run, this is an optimal basis.

Tough and resilient:

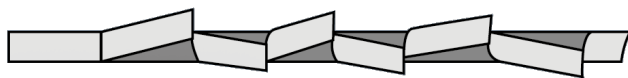
Tooth tips made of heat-treated HSS steel, M42 and M51 grades, guarantee maximum wear resistance thanks to mature heat treatment techniques and a defined structural state.

Optimally joined:

The carrier band and the HSS flat wire are optimally and immutably joined by electron or laser beam welding.

All the benefits:

The premium bi-metal saw band combines the flexibility of the carrier with the enormous wear resistance of HSS high speed steel. Each tooth tip of the finished saw band consists of heat-treated HSS steel, tough, resilient to load and with great performance.

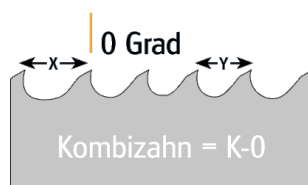


Gruppenschränkung

In addition to the tooth shape and tpi, the exact set of the saw band is definitive for its performance. An application-specific set guarantees correct cutting by the saw band. It prevents the band jamming - which is important for difficult steels. The set type and width is precisely matched to the cutting task:

Tooth shapes

Only the right choice of tooth shape optimally cuts your material with low vibration. There are various basic types here:

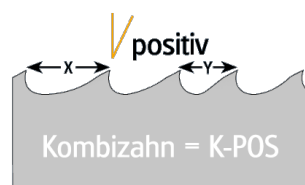


Specialist for:

- long-chipping, tough materials
- large cross-sections

Data

- positive rake angle
- 2 to 6 tpi



Specialist for:

- low-vibration cutting
- Sections

Data

- Rake angle of 0°
- variable tpi from 3/4 to 10/14 tpi

! We are always happy to perform sample cutting for your special material.
■ Call us for details!

M42 Sprint saw bands

The section expert for small to medium wall thicknesses

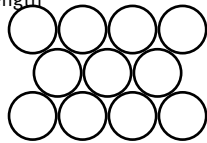
Dimensions	Variable tooth groups					
mm	3/4	4/6	5/8	6/10	8/12	10/14
13 x 0.65			K	K	K	K
13 x 0.90				K	K	K
20 x 0.90		K	K	K	K	K
27 x 0.90	K	K	K	K	K	K
34 x 1.10	K	K	K	K	K	K
41 x 1.30	K	K	K	K		
54 x 1.60	K	K	K			

K = combined tooth

The combined with a 0° rake angle in combination with the group set will cut thin-walled sections with little vibration. Short-chipping material is processed with ease. The M42-SPRINT bi-metal saw band improves the service life and achieves good cutting quality.

The specialist for:

popular steel grades up to approx. 1400 N/mm² tensile strength
NE sections
Individual and bundle cuts
Sections with low or medium wall thickness
Steel sheets on vertical plate sawing systems



M42 Sprint Plus saw bands

Powerful for materials with medium to large dimensions

Dimensions	Variable tooth groups				
mm	0.75/1.25	1.4/2	2/3	3/4	4/6
20 x 0.90					K
27 x 0.90			K	K	K
34 x 1.10		K	K	K	K
41 x 1.30		K	K	K	K
54 x 1.30		K	K	K	K
54 x 1.60		K	K	K	K
67 x 1.60	K	K	K		
80 x 1.60	K	K			

K = combined tooth

The combined tooth with a positive rake angle in combination with the group set will cut solid material and thick-walled sections with little vibration, while improving the cutting performance and achieving a smooth surface.

The specialist for:

popular steel grades up to approx. 1400 N/mm² tensile strength
NE sections
Individual and bundle cuts
Medium to large sized workpieces
Thick-walled sections



M42 Sprint-Medium-VS saw bands

The multifunctional talent for many cutting tasks

Dimensions	Variable tooth groups				
mm	2/3	3/4	4/6	5/7	8/11
27 x 0.90		K	K	K	K
34 x 1.10	K	K	K	K	
41 x 1.30	K	K	K		
54 x 1.30		K			
54 x 1.60	K	K	K		
67 x 1.60	K	K			

K = reinforce combined tooth

The new reinforced HL combined tooth with a positive rake angle in combination with the group set will cut solid material and thick-walled sections with very little vibration, while improving the cutting performance, achieving a smooth surface and an impressive service life.

The specialist for:

small to medium-sized swivel frame machines
popular steel grades up to approx. 1400 N/mm² tensile strength
Individual and bundle cuts
Sections and beams
Solid material



M51 Sprint-Plus saw bands

Extra wear resistant teeth for steels and alloys of medium dimensions

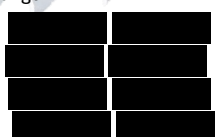
Dimensions	Variable tooth groups			
mm	1.4/2	2/3	3/4	4/6
27 x 0.90		K	K	K
34 x 1.10		K	K	K
41 x 1.30		K	K	
54 x 1.60	K	K		
67 x 1.60	K	K		

K = combined tooth

The combined with an extremely positive rake angle in combination with the group set will cut thin-walled sections with little vibration. Tooth tips made of HSS M 51 additionally improve the band service life, in particular for problematic materials.

The specialist for:

popular steel grades up to approx. 1700 N/mm² tensile strength
Corrosion and acid-resistant steels
Nickel based alloys
Titanium and special bronzes
Solid material medium dimensions
Thick-walled sections



Saw bands for all Metallkraft metal band saws

M42 Sprint saw bands	M42 Sprint-Medium-VS saw bands
M42 Sprint Plus saw bands	M51 Sprint-Plus saw bands

See left-hand side for explanations

Saw bands for band saws	Art. no.	€ plus VAT	Saw bands for band saws	Art. no.	€ plus VAT	Saw bands for band saws	Art. no.	€ plus VAT
VMBS 1408 (bi-metal M 42)			BMBS 220 x 250			BMBS 360 x 500		
2880 x 10 x 0.9 mm 10-14 Vario	3651110		2450 x 27 x 0.9 mm 5-8 TPI	3655122		4780 x 34 x 1.1 mm 5-8 TPI	3655403	
2880x13x0.65 mm 6-10 Vario	3651210		2450 x 27 x 0.9 mm 6-10 TPI	3655127		4780 x 34 x 1.1 mm 10-14 TPI	3655404	
2880x13x0.65 mm 8-12 Vario	3651212		2450 x 27 x 0.9 mm 10-14 TPI	3655123		4780 x 34 x 1.1 mm 6-10 TPI	3655405	
2880x13x0.65 mm 10-14 Vario	3651214		2450 x 27 x 0.9 mm 3-4 TPI	3655120		4780 x 34 x 1.1 mm 2-3 TPI	3655400	
VMBS 1610 / VMBS 1610 E (bi-metal M 42)			2450 x 27 x 0.9 mm 2-3 TPI	3655121		4780 x 34 x 1.1 mm 3-4 TPI	3655401	
3140 x 13 x 0.65 mm 6-10 Vario	3651310		2450 x 27 x 0.9 mm 4-6 TPI	3655119		4780 x 34 x 1.1 mm 4-6 TPI	3655402	
3140 x 13 x 0.65 mm 8-12 Vario	3651312		2450 x 27 x 0.9 mm 3-4 TPI	3655125		BMBS 460 x 600		
3140 x 13 x 0.65 mm 10-14 Vario	3651314		2450 x 27 x 0.9 mm 2-3 TPI	3655126		5380 x 41 x 1.3 mm 3-4 TPI	3655230	
VMBS 2012/ VMBS 2012E (bi-metal M 42)			BMBS 230 x 280			5380 x 41 x 1.3 mm 2-3 TPI	3655231	
4030 x 13 x 0.65 mm 6-10 Vario	3651710		2720 x 27 x 0.9 5-8 TPI	3655508		5380 x 41 x 1.3 mm 4-6 TPI	3655232	
4030 x 13 x 0.65 mm 8-12 Vario	3651712		2720 x 27 x 0.9 6-10 TPI	3655510		HMBS 350 x 400		
4030 x 13x 0.65 mm 10-14 Vario	3651714		2720 x 27 x 0.9 10-14 TPI	3655514		4520 x 34 x 1.1 mm 5-8 TPI	3655201	
			2720 x 27 x 0.9 2-3 TPI	3655603		4520 x 34 x 1.1 mm 6-10 TPI	3655218	
4030 x 20 x 0.9 mm 6-10 Vario	3651720		2720 x 27 x 0.9 3-4 TPI	3655604		4520 x 34 x 1.1 mm 3-4 TPI	3655001	
4030 x 20 x 0.9 mm 8-12 Vario	3651722		2720 x 27 x 0.9 4-6 TPI	3655606		4520 x 34 x 1.1 mm 2-3 TPI	3655101	
4030 x 20 x 0.9 mm 10-14 Vario	3651724		2720 x 27 x 0.9 2-3 TPI	3655703		HMBS 440 x 600		
			2720 x 27 x 0.9 3-4 TPI	3655704		6060 x 34 x 1.1 mm 5-8 TPI	3656350	
4030 x 27 x 0.9 mm 6-10 Vario	3651730		2720 x 27 x 0.9 4-6 TPI	3655706		6060 x 34 x 1.1 mm 6-10 TPI	3656351	
4030 x 27 x 0.9 mm 8-12 Vario	3651732		BMBS 250 x 315			6060 x 34 x 1.1 mm 3-4 TPI	3656352	
4030 x 27 x 0.9 mm 10-14 Vario	3651734		2825 x 27 x 0.9 mm 5-8 TPI	3655222		6060 x 34 x 1.1 mm 2-3 TPI	3656353	
VMBS 2613 / VMBS 2613 E (bi-metal M 42)			2825 x 27 x 0.9 mm 10-14 TPI	3655226		HMBS 400 x 400		
4680 x 13 x 0.65 mm 6-10 Vario	3651810		2825 x 27 x 0.9 mm 6-10 TPI	3655223		5580 x 41 x 1.3 mm 3-4 TPI	3655600	
4680 x 13 x 0.65 mm 8-12 Vario	3651812		2825 x 27 x 0.9 mm 3-4 TPI	3655220		5580 x 41 x 1.3 mm 2-3 TPI	3655601	
4680 x 13 x 0.65 mm 10-14 Vario	3651814		2825 x 27 x 0.9 mm 2-3 TPI	3655221		HMBS 300 x 300 & HMBS 400		
			2825 x 27 x 0.9 mm 4-6 TPI	3655219		4520 x 34 x 1.1 mm 2-3 TPI	3655520	
4680 x 20 x 0.9 mm 6-10 Vario	3651820		2825 x 27 x 0.9 mm 3-4 TPI	3655224		4520 x 34 x 1.1 mm 3-4 TPI	3655521	
4680 x 20 x 0.9 mm 8-12 Vario	3651822		2825 x 27 x 0.9 mm 4-6 TPI	3655225		4520 x 34 x 1.1 mm 4-6 TPI	3655522	
4680 x 20 x 0.9 mm 10-14 Vario	3651824		BMBS 240 x 280			HMBS 500 x 750		
			2980 x 27 x 0.9 mm 5-8 TPI	3655206		6500 x 41 x 1.3 mm 5-8 TPI	3655242	
4680 x 27 x 0.9 mm 6-10 Vario	3651830		2980 x 27 x 0.9 mm 10-14 TPI	3655208		6500 x 41 x 1.3 mm 2-3 TPI	3655240	
4680 x 27 x 0.9 mm 8-12 Vario	3651832		2980 x 27 x 0.9 mm 6-10 TPI	3655207		6500 x 41 x 1.3 mm 3-4 TPI	3655241	
4680 x 27 x 0.9 mm 10-14 Vario	3651834		2980 x 27 x 0.9 mm 3-4 TPI	3655013		HMBS 510 x 510		
VMBS 3612 / VMBS 3612 E (bi-metal M 42)			2980 x 27 x 0.9 mm 2-3 TPI	3655115		6060 x 54 x 1.6 mm 3-4 TPI	3655007	
5020 x 13 x 0.65 mm 6-10 Vario	3651910		2980 x 27 x 0.9 mm 4-6 TPI	3655116		6060 x 54 x 1.6 mm 2-3 TPI	3655107	
5020 x 13 x 0.65 mm 8-12 Vario	3651912		2980 x 27 x 0.9 mm 2-3 TPI	3655212		HMBS 600		
5020 x 13 x 0.65 mm 10-14 Vario	3651914		2980 x 27 x 0.9 mm 3-4 TPI	3655213		6.0 x 0.6 x 3455 mm /6 TPI*	3655215	
			2980 x 27 x 0.9 mm 4-6 TPI	3655214		6230 x 41 x 1.3 mm 2-3 TPI	3655216	
5020 x 20 x 0.9 mm 6-10 Vario	3651920		BMBS 290 x 290 & BMBS 290 x 320			HMBS 600 x 1100		
5020 x 20 x 0.9 mm 8-12 Vario	3651922		3100 x 27 x 0.9 mm 5-8 TPI	3655200		9000 x 54 x 1.6 mm 3-4 TPI	3655511	
5020 x 20 x 0.9 mm 10-14 Vario	3651924		3100 x 27 x 0.9 mm 10-14 TPI	3655209		9000 x 54 x 1.6 mm 2-3 TPI	3655512	
			3100 x 27 x 0.9 mm 6-10 TPI	3655204		HMBS 700 x 750		
5020 x 27 x 0.9 mm 6-10 Vario	3651930		3100 x 27 x 0.9 mm 3-4 TPI	3655000		7680 x 67 x 1.6 mm 3-4 TPI	3655410	
5020 x 27 x 0.9 mm 8-12 Vario	3651932		3100 x 27 x 0.9 mm 2-3 TPI	3655100		7680 x 67 x 1.6 mm 2-3 TPI	3655411	
5020 x 27 x 0.9 mm 10-14 Vario	3651934		3100 x 27 x 0.9 mm 4-6 TPI	3655146		HMBS 850 x 1000 & HVMB 850 x 1000		
			3100 x 27 x 0.9 mm 2-3 TPI	3655227		9080 x 67 x 1.6 mm 3-4 TPI	3655011	
Saw bands for band saws			3100 x 27 x 0.9 mm 3-4 TPI	3655228		9080 x 67 x 1.6 mm 2-3 TPI	3655111	
MBS 85			3100 x 27 x 0.9 mm 4-6 TPI	3655229		HMBS 1000		
1335 x 13 x 0.65 mm K 6-10	3650011		BMBS 300 x 320			8920 x 54 x 1.6 mm 2-3 TPI	3656355	
1335 x 13 x 0.65 mm K 10-14	3650012		3660 x 27 x 0.9 mm 5-8 TPI	3656301		8920 x 54 x 1.6 mm 3-4 TPI	3656366	
MBS 125			3660 x 27 x 0.9 mm 6-10 TPI	3656302		HMBS 1200 x 1400, HVMB 1200 x 1600 Xtreme, HVMB 1250 x 1600 Portal		
1440 x 13 x 0.65 mm 6-10	3650014		3660 x 27 x 0.9 mm 10-14 TPI	3656303		11650 x 80 x 1.6 mm 3-4 TPI	3655113	
1440 x 13 x 0.65 mm 10-14	3650015		3660 x 27 x 0.9 mm 3-4 TPI	3656304		11650 x 80 x 1.6 mm 2-3 TPI	3655114	
MBS 150			3660 x 27 x 0.9 mm 2-3 TPI	3656305				
1735 x 13 x 0.65 mm 6-10	3650017		3660 x 27 x 0.9 mm 4-6 TPI	3656306				
1735 x 13 x 0.65 mm 10-14	3650018		3660 x 27 x 0.9 mm 2-3 TPI	3656307				
MBS 155			3660 x 27 x 0.9 mm 3-4 TPI	3656308				
1735 x 13 x 0.65 mm 6-10	3650017		3660 x 27 x 0.9 mm 4-6 TPI	3656309				
1735 x 13 x 0.65 mm 10-14	3650018							

Interested in more products?



CNC Catalogue
www.optimum-maschinen.de



Main Catalogue
www.optimum-maschinen.de



www.schweisskraft.de



www.aircraft-kompressoren.com



www.finicompactors.de



www.unicraft.de



www.holzkraft.de

- The publication of this catalogue renders all previous price lists invalid.
- Prices are recommended retail prices, subject to change, in €, plus statutory VAT, plus packaging, shipping, transportation, unloading, installation and training costs as applicable.
- We accept no liability for printing errors, mistakes or incorrect representation.
- Technical and visual changes reserved.
- Some illustrations show optional accessories.
- Delivery is effected solely on the basis of our terms of delivery and payment.
- All items are sold through specialist retailers.
- The goods shall remain our property until payment has been received in full.
- Our retention of title shall remain valid in case of sale to a third-party.

- Legal warranty conditions apply for businesses.
- Copying and reproduction in full or in part is subject to written approval by us.
- Please note that transport packaging surcharges apply for some machines in this catalogue to cover transport units, packaging and packaging overheads. These machines are appropriately marked in the catalogue.
- The transport packaging lump sums are as defined in the following table:

TVP 1 = € 19.00 plus VAT
TVP 2 = € 39.00 plus VAT
TVP 3 = € 59.00 plus VAT
TVP 4 = € 79.00 plus VAT
TVP 5 = € 100.00 plus VAT
TVP 6 = € 200.00 plus VAT
TVP 7 = € 300.00 plus VAT
TVP 8 = € 400.00 plus VAT

Sales Germany:
Metallkraft – Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt/Bamberg
Phone: +49 (0) 951 96 555 - 0
Fax: +49 (0) 951 96 555 - 55
email: info@metallkraft-maschinen.de

Sales Austria:
AIRCRAFT Kompressorenbau GmbH
Gewerbestrasse Ost 6 · A- 4921 Hohenzell
Phone: +43 (0) 7752 - 70 929-0
Fax : +43 (0) 77 52 - 70 929-99
email: info@aircraft.at
www.aircraft.at

Your specialist retailer:

