

# ***ROUND BENDING MACHINES***



# Manual ring bending machines

INHALTSVERZEICHNIS

## RBM 305 / RBM 610-08 - Manual, asymmetric 3-roll round bending machines

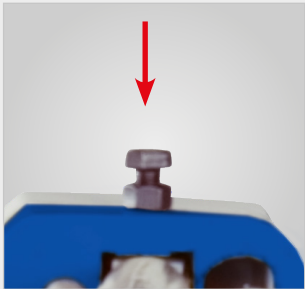
- ▶ Steel rollers
- ▶ Swivelling top roller for easier removal of the removal of the workpiece
- ▶ Asymmetrical roller arrangement for easy pre-bending
- ▶ Tilting side roller for conical bending
- ▶ Clamping and side roller with wire insertion groove
- ▶ Roller drive via hand crank and gearbox
- ▶ Particularly handy and therefore suitable for working in confined spaces
- ▶ Due to its low wave strength, it is ideally suited for delicate applications.
- ▶ 3-roller round bending machine for manufacturing all round-shaped parts such as pipes, cylinders, and much more.
- ▶ Simple and solid construction



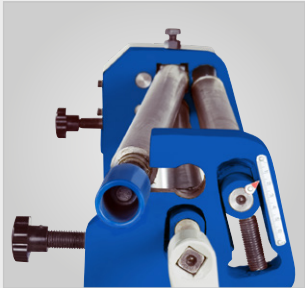
RBM 305 with optional Machine base(Art. no. 3780113)



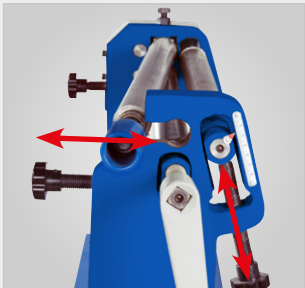
RBM 610-08



Lubrication via lubricating nipple possible (RBM 305)



The upper roller can be extended, making it easy to remove the finished workpiece



Rear roller can be adjusted individually, allowing conical work possible  
Adjustments using convenient, large roller adjusting screws

| Model                          | RBM 305            | RBM 610-08         |
|--------------------------------|--------------------|--------------------|
| Art. no.                       | 3780112            | 3780618            |
| <b>Technical data</b>          |                    |                    |
| Bending width max.             | 305 mm             | 610 mm             |
| Bending capacity (400 N/mm²)   | 0.80 mm            | 0.80 mm            |
| Roller Ø                       | 25 mm              | 38 mm              |
| Bending Ø min.                 | 40 mm              | 60 mm              |
| Wire insert groove Ø           | 4 / 6 / 8 mm       | 4.8 / 6.4 / 8 mm   |
| Dimensions (L x W x H) approx. | 580 x 210 x 255 mm | 885 x 220 x 340 mm |
| Weight approx.                 | 14 kg              | 37 kg              |

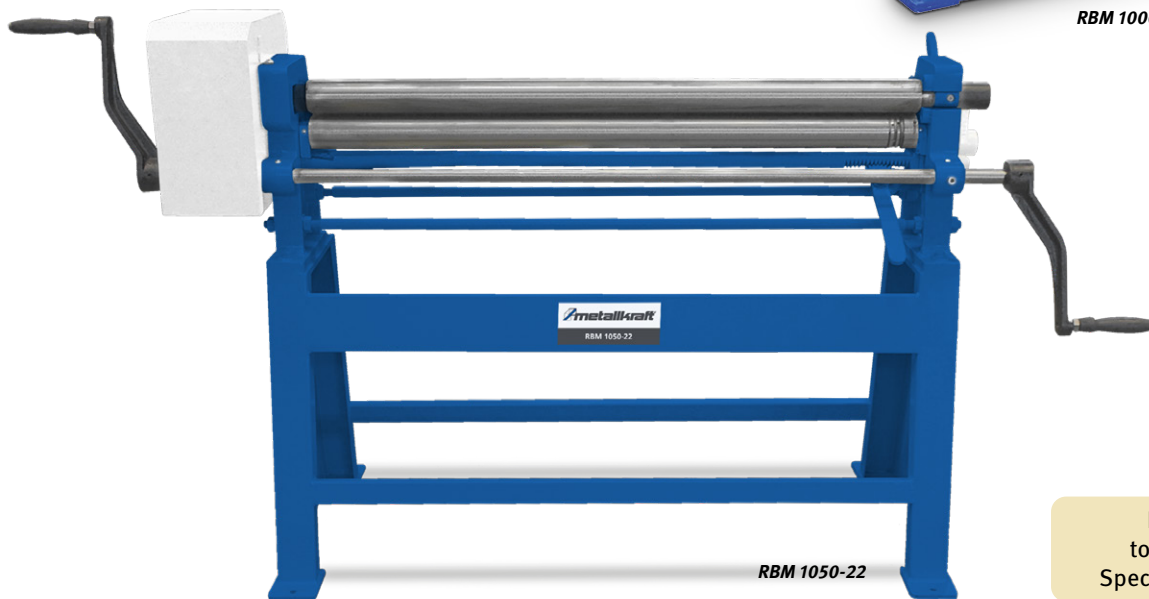
|                     |          |
|---------------------|----------|
| Accessories RBM 305 | Art. no. |
| Machine base        | 3780113  |

## RBM - Manual, asymmetrical 3-roll round bending machines

- ▶ Heavy and stable cast iron construction
- ▶ Asymmetrical 3-roller system for convenient pre-bending
- ▶ Swivelling top roller
- ▶ Roller drive via hand crank
- ▶ Suitable for bending wires with diameters of 3.5 and 8 mm
- ▶ Quick clamping of the sheet metal using a lever



RBM 1000-20 Eco



RBM 1050-22

Please order  
to be processed  
Specify material type!

| Model                                                    | RBM 1000-20 Eco   | RBM 1050-10       | RBM 1050-22       | RBM 1550-10       |
|----------------------------------------------------------|-------------------|-------------------|-------------------|-------------------|
| Art. no.                                                 | 3781301           | 3813101           | 3813103           | 3813104           |
| <b>Technical data</b>                                    |                   |                   |                   |                   |
| Bending width                                            | 1000 mm           | 1050 mm           | 1050 mm           | 1550 mm           |
| Bending capacity (400 N/mm <sup>2</sup> ) <sup>(1)</sup> | 2.0 mm            | 1.0 mm            | 2.0 mm            | 1.0 mm            |
| Roller Ø                                                 | 60 mm             | 56 mm             | 75 mm             | 68 mm             |
| Bending Ø min.                                           | 100 mm            | 84 mm             | 115 mm            | 102 mm            |
| Dimensions (L x W x H) approx.                           | 1542 x 550 x 1040 | 1400 x 700 x 1120 | 1400 x 700 x 1160 | 2430 x 700 x 1160 |
| Weight approx.                                           | 200 kg            | 185 kg            | 300 kg            | 350 kg            |

<sup>(1)</sup> Conical bending factor 0.5; bending capacity aluminium factor 1.2; bending capacity VA factor 0.75; optional hardened rollers are required for bending VA.

| Accessories (ex works only)  | Art. no. |
|------------------------------|----------|
| Hardened rollers RBM 1050-10 | 3880071  |
| Hardened rollers RBM 1050-22 | 3880073  |
| Hardened rollers RBM 1550-10 | 3880074  |

# Motorised round bending machines

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## RBM 1305-15 E – Motorised, asymmetrical 3-roll bending machines

- ▶ For manufacturing all round-shaped parts such as pipes, cylinders, etc.
- ▶ Motorised roller drive
- ▶ Heavy-duty and stable steel construction
- ▶ Asymmetrical 3-roller system for convenient pre-bending
- ▶ The upper roller can be extended, making it easy to remove the finished workpiece
- ▶ Bottom and side roller
- ▶ Easily adjustable upper and lower rollers
- ▶ Possibility of conical bending
- ▶ With safety devices
- ▶ wire insert groove on bottom and side roller
- ▶ The foot control leaves both hands free for material feeding



Please order  
to be processed  
Specify material type!

|                                            |                       |
|--------------------------------------------|-----------------------|
| Model                                      | RBM 1305-15 E         |
| Art. no.                                   | 3781305               |
| Technical data                             |                       |
| Bending width                              | 1270 mm               |
| Bending capacity (400N/mm²) <sup>(1)</sup> | 1.5 mm                |
| Roller Ø                                   | 75 mm                 |
| Bending Ø min.                             | 110 mm                |
| Motor power ~50 Hz                         | 0.75 kW/400 V         |
| Dimensions (L x W x H) approx.             | 1650 x 1020 x 1110 mm |
| Weight approx.                             | 318 kg                |

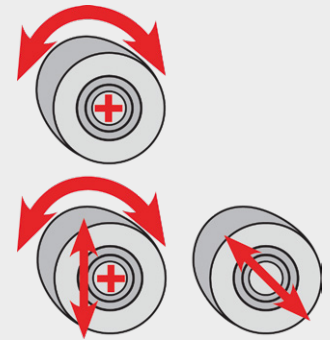
(1) Conical bending factor 0.5; bending capacity aluminium factor 1.2

## RBM E – Motorised, asymmetrical 3-roll bending machines

- ▶ Heavy and stable cast iron construction
- ▶ Asymmetrical 3-roller system for convenient pre-bending
- ▶ Swivelling top roller
- ▶ Possibility of conical bending
- ▶ Safety device emergency stop line
- ▶ With wire insert groove in clamping and side roller as standard
- ▶ The upper roller can be extended, making it easy to remove the finished workpiece
- ▶ Adjustment of the side roller by handwheel
- ▶ Convenient clamping via a lever
- ▶ User-friendly
- ▶ Optional hardened rollers



RBM 1270-25E



### Option



Control panel with digital display of the side roller

| Model                                    | RBM 1050-30E      | RBM 1270-25E      | RBM 1550-20E      | RBM 2050-15E      |
|------------------------------------------|-------------------|-------------------|-------------------|-------------------|
| Art. no.                                 | 3813201           | 3813202           | 3813203           | 3813204           |
| <b>Technical data</b>                    |                   |                   |                   |                   |
| Bending width                            | 1050 mm           | 1270 mm           | 1550 mm           | 2050 mm           |
| Bending capacity (400N/mm <sup>2</sup> ) | 3.0 mm            | 2.5 mm            | 2.0 mm            | 1.5 mm            |
| Roller Ø                                 | 90 mm             | 90 mm             | 90 mm             | 95 mm             |
| Bending Ø min.                           | 135 mm            | 135 mm            | 135 mm            | 145 mm            |
| Motor power ~50 Hz                       | 1.1 kW / 400 V    | 1.1 kW / 400 V    | 1.5 kW / 400 V    | 1.5 kW / 400 V    |
| Dimensions (L x W x H) approx.           | 1630 x 700 x 1200 | 1850 x 700 x 1200 | 2130 x 700 x 1200 | 2630 x 700 x 1200 |
| Weight approx.                           | 480 kg            | 520 kg            | 580 kg            | 665 kg            |

(1) Conical bending factor 0.5; bending capacity aluminium factor 1.2; bending capacity VA factor 0.75; optional hardened rollers are required for bending VA.

### Note

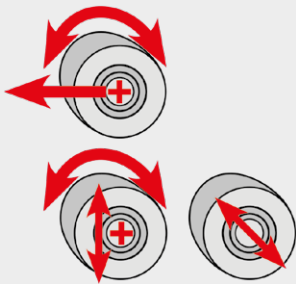
Options cannot be retrofitted, only available when ordering a new machine

|                                         |                 |                                         |                 |
|-----------------------------------------|-----------------|-----------------------------------------|-----------------|
| <b>Option RBM 1050-30E</b>              | <b>Art. no.</b> | <b>Option RBM 1550-20E</b>              | <b>Art. no.</b> |
| Hardened rollers                        | 3880059         | Hardened rollers                        | 3880065         |
| Motorised adjustment of the side roller | 3880060         | Motorised adjustment of the side roller | 3880066         |
| Digital display for side roller         | 3880061         | Digital display for side roller         | 3880067         |
| <b>Option RBM 1270-25E</b>              | <b>Art. no.</b> | <b>Option RBM 2050-15E</b>              | <b>Art. no.</b> |
| Hardened rollers                        | 3880062         | Hardened rollers                        | 3880068         |
| Motorised adjustment of the side roller | 3880063         | Motorised adjustment of the side roller | 3880069         |
| Digital display for side roller         | 3880064         | Digital display for side roller         | 3880070         |

# Motorised round bending machines

## RBM E PRO – Heavy-duty motorised round bending machines for sheet thicknesses up to 4 mm

- ▶ Heavy welded steel construction
  - ▶ Driven top and pinch rollers
  - ▶ Swivelling top roller
  - ▶ Manual delivery of the clamping and side rollers
- ▶ Roller drive via powerful electric motor and gearbox
  - ▶ Wire grooves on the clamping roller
  - ▶ Safety device emergency stop line
  - ▶ Mobile control panel and foot pedal



Swivelling top roller



RBM 2050-30 E Pro  
with options Digital display for side roller  
and Motorised adjustment of the side roller



Control panel with digital display for side roller, motorised adjustment of side roller and button for material feed instead of foot pedal (optional)

Other models on request

Please order to be processed  
Specify material type!

| Model                          | RBM 1270-40 E Pro    | RBM 1550-40 E Pro    | RBM 2050-30 E Pro    |
|--------------------------------|----------------------|----------------------|----------------------|
| Art. no.                       | 3813301              | 3813302              | 3813303              |
| <b>Technical data</b>          |                      |                      |                      |
| Bending width                  | 1270 mm              | 1550 mm              | 2050 mm              |
| Bending capacity (400N/mm²)    | 4 mm                 | 4 mm                 | 3 mm                 |
| Roller Ø                       | 120 mm               | 140 mm               | 130 mm               |
| Bending Ø min.                 | 180 mm               | 210 mm               | 195 mm               |
| Roller speed                   | 3 m/min.             | 3.5 m/min.           | 3.5 m/min.           |
| Motor power ~50 Hz             | 2.2 kW               | 2.2 kW               | 2.2 kW               |
| Electrical connection ~ 50 Hz  | 400 V / 50 Hz        | 400 V / 50 Hz        | 400 V / 50 Hz        |
| Weight approx.                 | 1115 kg              | 1350 kg              | 1500 kg              |
| Dimensions (L x W x H) approx. | 2470 x 750 x 1000 mm | 2470 x 750 x 1000 mm | 3200 x 750 x 1000 mm |

(1) Conical bending factor 0.5; bending capacity aluminium factor 1.2; bending capacity VA factor 0.75; optional hardened rollers are required for bending VA.

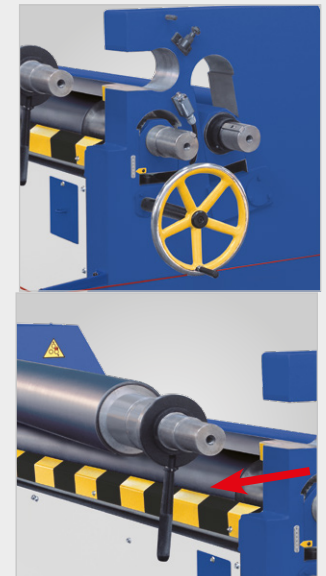
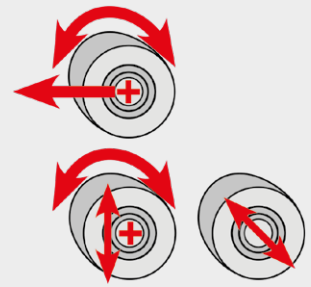
|                                                                                          |                                         |                  |                                         |                  |
|------------------------------------------------------------------------------------------|-----------------------------------------|------------------|-----------------------------------------|------------------|
| <b>Note</b><br>Options cannot be retrofitted, only available when ordering a new machine | <b>Accessories RBM 1270-40E PRO</b>     |                  | <b>Accessories RBM 2050-30E PRO</b>     |                  |
|                                                                                          | Hardened rollers for stainless steel    | Art. no. 3880050 | Hardened rollers for stainless steel    | Art. no. 3880056 |
|                                                                                          | Motorised adjustment of the side roller | 3880051          | Motorised adjustment of the side roller | 3880057          |
|                                                                                          | Digital display for side roller         | 3880052          | Digital display for side roller         | 3880058          |
|                                                                                          | <b>Accessories RBM 1550-40E PRO</b>     |                  |                                         |                  |
|                                                                                          | Hardened rollers for stainless steel    | Art. no. 3880053 |                                         |                  |
|                                                                                          | Motorised adjustment of the side roller | 3880054          |                                         |                  |
|                                                                                          | Digital display for side roller         | 3880055          |                                         |                  |

## RBM E PRO –Heavy-duty motorised round bending machines with motorised feed for sheet thicknesses up to 6 mm

- ▶ Heavy welded steel construction
- ▶ Driven top and pinch rollers
- ▶ Motorised adjustment of the side roller
- ▶ Swivelling top roller
- ▶ Roller drive via powerful electric motor and gearbox
- ▶ Safety device emergency stop line
- ▶ Mobile control panel



**RBM 2050-50E PRO**  
with digital display for side roller  
(optional)



Swivelling top roller

**Other models on request**

Please order  
to be processed  
Specify material type!

| Model                                     | RBM 1550-60E PRO  | RBM 2050-50E PRO  | RBM 2050-60E PRO  | RBM 2550-40E PRO  | RBM 2550-60E PRO  | RBM 3050-60E PRO   |
|-------------------------------------------|-------------------|-------------------|-------------------|-------------------|-------------------|--------------------|
| Art. no.                                  | 3813314           | 3813315           | 3813316           | 3813317           | 3813318           | 3813319            |
| <b>Technical data</b>                     |                   |                   |                   |                   |                   |                    |
| Bending width                             | 1550 mm           | 2050 mm           | 2050 mm           | 2550 mm           | 2550 mm           | 3050 mm            |
| Pre-bending performance                   | 5 mm              | 4 mm              | 5 mm              | 3 mm              | 5 mm              | 5 mm               |
| Bending capacity (400 N/mm <sup>2</sup> ) | 6 mm              | 5 mm              | 6 mm              | 4 mm              | 6 mm              | 6 mm               |
| Roller Ø                                  | 130 mm            | 150 mm            | 170 mm            | 150 mm            | 190 mm            | 220 mm             |
| Bending Ø min.                            | 195 mm            | 225 mm            | 255 mm            | 225 mm            | 285 mm            | 330 mm             |
| Roller speed                              | 3.2 m/min.        | 3.4 m/min.        | 3.8 m/min.        | 3.4 m/min.        | 4.3 m/min.        | 5.0 m/min.         |
| Motor power ~50 Hz                        | 2.2 kW / 400 V    | 3.0 kW / 400 V    | 4.0 kW / 400 V    | 3.0 kW / 400V     | 4.0 kW / 400V     | 5.5 kW / 400V      |
| Weight approx.                            | 1400 kg           | 1885 kg           | 2100 kg           | 2150 kg           | 3400 kg           | 6000 kg            |
| Dimensions (L x W x H) approx.            | 3250 x 650 x 1020 | 3750 x 680 x 1040 | 3850 x 720 x 1050 | 4250 x 650 x 1020 | 4700 x 950 x 1300 | 5200 x 1150 x 1400 |

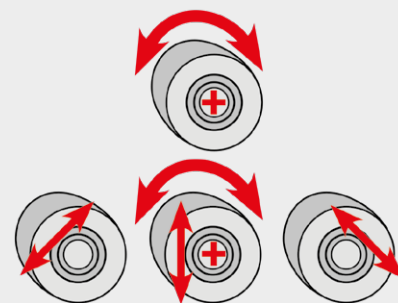
(1) Conical bending factor 0.5; bending capacity aluminium factor 1.2; bending capacity VA factor 0.75; optional hardened rollers are required for bending VA.

|                                                                                          |                                             |                 |                                             |                 |
|------------------------------------------------------------------------------------------|---------------------------------------------|-----------------|---------------------------------------------|-----------------|
| <b>Note</b><br>Options cannot be retrofitted, only available when ordering a new machine | <b>Accessories RBM 1550-60E PRO</b>         | <b>Art. no.</b> | <b>Accessories RBM 2550-40E PRO</b>         | <b>Art. no.</b> |
|                                                                                          | Digital display for side roller             | 3880220         | Digital display for side roller             | 3880220         |
|                                                                                          | Motorised adjustment of the clamping roller | 3880221         | Motorised adjustment of the clamping roller | 3880221         |
|                                                                                          | Hardened rollers for stainless steel        | 3880225         | Hardened rollers for stainless steel        | 3880234         |
|                                                                                          | <b>Accessories RBM 2050-50E PRO</b>         | <b>Art. no.</b> | <b>Accessories RBM 2550-60E PRO</b>         | <b>Art. no.</b> |
|                                                                                          | Digital display for side roller             | 3880220         | Digital display for side roller             | 3880220         |
|                                                                                          | Motorised adjustment of the clamping roller | 3880221         | Motorised adjustment of the clamping roller | 3880221         |
|                                                                                          | Hardened rollers for stainless steel        | 3880228         | Hardened rollers for stainless steel        | 3880237         |
|                                                                                          | <b>Accessories RBM 2050-60E PRO</b>         | <b>Art. no.</b> | <b>Accessories RBM 3050-60E PRO</b>         | <b>Art. no.</b> |
|                                                                                          | Digital display for side roller             | 3880220         | Digital display for side roller             | 3880220         |
|                                                                                          | Motorised adjustment of the clamping roller | 3880221         | Motorised adjustment of the clamping roller | 3880221         |
|                                                                                          | Hardened rollers for stainless steel        | 3880231         | Hardened rollers for stainless steel        | 3880240         |

# Hydraulic round bending machines

## RBM 4 HMS PRO - Hydraulic 4-roll round bending machines

- ▶ Heavy and robust welded construction
- ▶ Linear feed of the clamping and side rollers by means of hydraulic cylinders
- ▶ Induction-hardened rollers, suitable for bending stainless steel
- ▶ Upper roller driven by hydraulic motor and planetary gearbox, movement is transmitted to the clamping roller via cardan shafts
- ▶ Machine secured against overload
- ▶ Three digital displays (2 x side rollers, 1 x clamping roller)
- ▶ Hydraulic hinged bearing for easy removal of the finished workpieces
- ▶ Mobile control panel
- ▶ Conical bending device
- ▶ Hydraulic equalisation system to ensure parallelism
- ▶ Safety emergency lifeline



Please order  
to be processed  
Specify material type!

Further models and accessories available on request

RBM 1550-110 4 HMS PRO

**ASK FOR YOUR PERSONALISED OFFER!**

| RBM 4 HMS PRO                             |        | 1550-65   | 1550-110  | 1550-150  | 2050-60   | 2050-80   | 2050-100  | 2050-120  | 2550-60   | 2550-80   | 2550-100  |
|-------------------------------------------|--------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| Art. no.                                  |        | 3813346   | 3813347   | 3813348   | 3813349   | 3813350   | 3813351   | 3813352   | 3813354   | 3813355   | 3813356   |
| Technical data                            |        |           |           |           |           |           |           |           |           |           |           |
| Bending width                             | mm     | 1550      | 1550      | 1550      | 2050      | 2050      | 2050      | 2050      | 2550      | 2550      | 2550      |
| Pre-bending performance                   | mm     | 3.5/4.5   | 7/9       | 10/12     | 3/4       | 4/6       | 6/8       | 8/10      | 3/4       | 4/6       | 6/8       |
| Bending capacity (400 N/mm <sup>2</sup> ) | mm     | 4.5/6.5   | 9/11      | 12/15     | 4/6       | 6/8       | 8/10      | 10/12     | 4/6       | 6/8       | 8/10      |
| Roller Ø                                  | mm     | 150       | 200       | 250       | 150       | 180       | 200       | 250       | 180       | 200       | 250       |
| Bending Ø min.                            | mm     | 225/750   | 300/1000  | 375/1250  | 225/750   | 270/900   | 300/1000  | 375/1250  | 270/900   | 300/1000  | 375/1250  |
| Roller speed                              | m/min. | 6         | 6         | 5         | 6         | 5         | 6         | 5         | 5         | 6         | 5         |
| Motor power                               | kW     | 2.2 & 1.5 | 4.0 & 1.5 | 7.5 & 1.5 | 2.2 & 1.5 | 3.0 & 1.5 | 4.0 & 1.5 | 7.5 & 1.5 | 3.0 & 1.5 | 4.0 & 1.5 | 7.5 & 1.5 |
| Dimensions (L) approx.                    | mm     | 3300      | 3350      | 3500      | 3800      | 3850      | 3850      | 4000      | 4350      | 4350      | 4500      |
| Dimensions (W) approx.                    |        | 1150      | 1350      | 1500      | 1150      | 1350      | 1350      | 1500      | 1350      | 1350      | 1500      |
| Dimensions (H) approx.                    |        | 1110      | 1290      | 1370      | 1110      | 1290      | 1290      | 1370      | 1290      | 1290      | 1370      |
| Weight approx.                            | kg     | 2370      | 3250      | 4650      | 2800      | 3300      | 3750      | 5350      | 3700      | 4250      | 6100      |

(1) Conical bending factor 0.5; bending capacity aluminium factor 1.2; bending capacity VA factor 0.75; optional hardened rollers are required for bending VA.

### Would you like advice?

Your local specialist dealer will be happy to advise you on all matters. We would be happy to advise you on this topic and refer you to a specialist retailer in your area.  
Contact (09 51) 96 555-504  
beratung@metallkraft.de

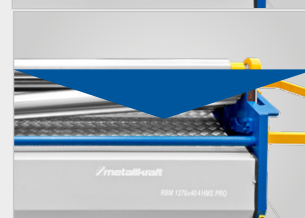
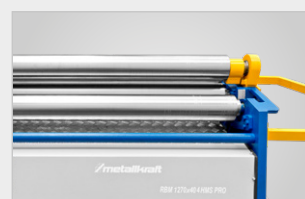


**Convince yourself of our capabilities and ask for individual advice!**

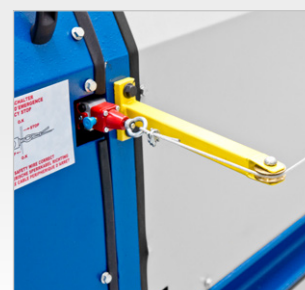
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beratung@metallkraft.de



Hydraulic hinged bearing for easy removal of the material



Conical bending device



Safety emergency lifeline

### Note

Options cannot be retrofitted, only available when ordering a new machine

| Equipment options             | Art. no. |
|-------------------------------|----------|
| Teach-in NC control Easy-View | 3883100  |
| Two bending speeds            | 3883101  |
| Stepless bending speed        | 3883102  |
| Hydraulic auxiliary crane     | 3883103  |
| Hydraulic side support        | 3883104  |



**Optional accessories:**  
Teach-in NC control