

HSBM - Manual swivel bending machines

- ▶ Inexpensive entry-level models for craftsmen
- ▶ Simple design and solid construction ensure precise work
- ▶ Secure fixing of the workpiece via clamping device

HSBM 305 HS / HSBM 610 HS

- ▶ Upper cheek segmented
- ▶ Ideal for manufacturing all profiles, including fully folded boxes
- ▶ User-friendly adjustment of the upper beam via eccentric mechanism
- ▶ Top rail for high-edged U-profiles
- ▶ Swivel bend over bow handle
- ▶ Easy to transport

HSBM 1020-10

- ▶ User-friendly adjustment of the upper beam
- ▶ Swivel bend via double handle



HSBM 610 HS

Segment height here 25 mm



HSBM 1020-10

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

Model	HSBM 305 HS	HSBM 610 HS	HSBM 1020-10
Art. no.	3772305	3772610	3771020

Technical data			
Working width max.	305 mm	610 mm	1020 mm
Bending capacity(400N/mm ²) ¹⁾	1.0 mm	1.0 mm	1.0 mm
Bending angle max.	135°	135°	135°
Dimensions (L x W x H) approx.	500 x 350 x 410 mm	850 x 360 x 420 mm	1276 x 550 x 975 mm
Weight approx.	30 kg	42 kg	105 kg

1) Bending capacity aluminium factor 1.2; bending capacity VA factor 0.75; optional tools are required for bending VA.

Accessories for HSBM 1020-10	Art. no.
Hardened upper tool	3772700

Manual swing bending machines

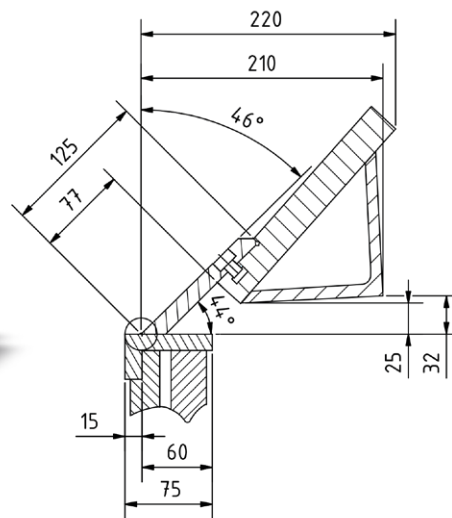
FSBM - Manual swivelling bending machines with workpiece clamping by means of foot pedal

- ▶ The workpiece is clamped using a foot pedal, leaving both hands free for feeding the material.
- ▶ Different tool variants available: E, S2, HS2 and HSG
- ▶ The powerful auxiliary cylinder facilitates bending
- ▶ Clearance between upper and lower rail of up to approx. 50 mm
- ▶ Self-lubricating plain bearings
- ▶ Clamping pressure of the upper beam easily adjustable via non-slip knurled screws
- ▶ Adjustment of material thickness using knurled screws
- ▶ Adjustable stop for bending angle



FSBM 1020-25 E

- ▶ With segmented sharp bending tools,
- ▶ continuous bending strip and
- ▶ continuous bed pad



Dimensions E-Series:

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

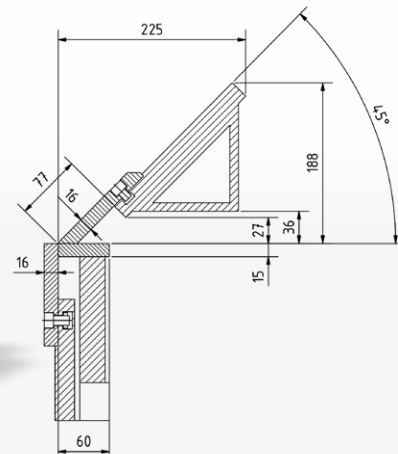
Model		FSBM 1020-25 E	FSBM 1020-20 S2	FSBM 1020-20 HSG	FSBM 1270-20 E	FSBM 1270-20 HS2	FSBM 1520-15 E	FSBM 2020-12 E
Art. no.		3772125	3772102	3770103	3772127	3772128	3772129	3772130
Technical data								
Working width	mm	1020	1020	1020	1270	1270	1520	2020
Bending capacity (400 N/mm ²)	mm	2.5	2.0	2.0	2.0	2.0	1.5	1.2
Bending capacity (600 N/mm ²)	mm	1.5	1.2	1.2	1.2	1.2	0.9	0.7
Bending angle	mm	135°	135°	135°	135°	135°	135°	135°
Dimensions (L) approx.	mm	1350	1350	1280	1600	1600	1850	2290
Dimensions (W) approx.		800	800	620	800	800	770	820
Dimensions (H) approx.		1130	1130	1200	1130	1130	1130	1180
Weight approx.	kg	290	325	360	340	370	415	540

Optional tools are required for bending VA.



FSBM 1020-20 S2

- ▶ With segmented sharp bending tools,
- ▶ segmented bending bar
- ▶ and continuous bed cover



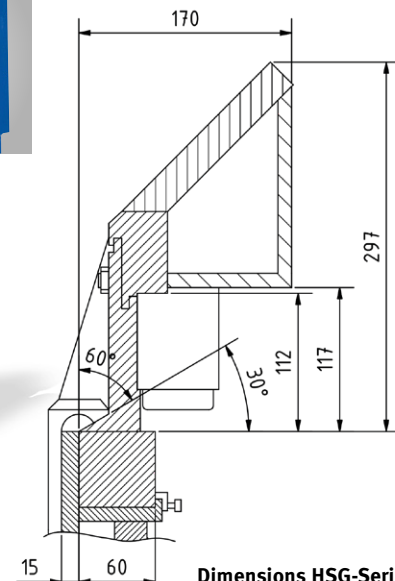
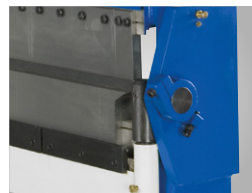
Dimensions S2 / HS2 series:

Max. Clearance between upper mould and bed support 25 mm



FSBM 1020-20 HSG

- ▶ Standard with high, segmented upper beam,
- ▶ segmented overlay
- ▶ segmented bending bar



Dimensions HSG-Series:

Option - hardened upper tools

Option - hardened upper tools	Art. no.
for FSBM 1020-20 S2	3772701
for FSBM 1020-25 E	3772702
for FSBM 1270-20 E	3772703
for FSBM 1270-20 HS2	3772703
for FSBM 1520-15 E	3772704

Accessories

Accessories	Art. no.
Backgauge up to 300 mm (suitable for FSBM 1020-20 S2 / FSBM 1020-25 E / FSBM 1270-20 E / FSBM 1270-20 HS2)	3772720
Neu Hardened segments for FSBM2020-12 E	3772998

Manual swing bending machines

HSBM HSG - Manual swivel bending machines, crowbar tools, segmented bed support and bending bar

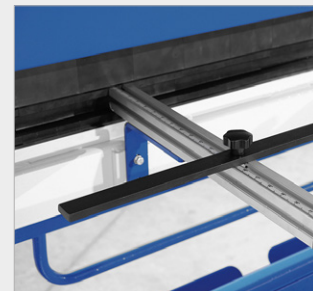
- ▶ Segmented crowbar tool 100 mm with quick-change system in the upper beam
- ▶ Segmented bending bar and segmented bed support, both with quick-change system
- ▶ Clear opening 100 mm
- ▶ Backgauge up to 500 mm
- ▶ Stop for bending angle adjustment
- ▶ Tools made of 42CrMo4 with 60 HRC, laser-hardened and ground. Suitable for bending stainless steel
- ▶ Easy clamping and releasing of the upper beam thanks to spring support
- ▶ Bending beam supported by spring system
- ▶ Quick foot clamping for fixing the workpiece
- ▶ Transport rollers with parking brake
- ▶ With tool storage box



HSBM 1050-15 HSG



All three tools segmented and with quick-change system



Backgauge 500 mm



Quick foot clamping (short stroke approx. 20 mm)



Bending angle stop



Clamping lever with spring support

Type	Segmentation
HSBM 1050-15 HSG	100-100-100-100-100-100-100-100-70-60-50-40-30-100mm
HSBM 1250-12 HSG	100-100-100-100-100-100-100-100-70-60-50-40-30-100-100-100mm

Model	HSBM 1050-15 HSG	HSBM 1250-12 HSG
Art. no.	4120010	4120012

Technical data			
Working width max.	mm	1050	1250
Steel bending capacity (400 N/mm ²)	mm	1.5	1.25
Stainless steel bending capacity (600N/mm ²)		1	0.8
Aluminium bending capacity (235N/mm ²)		2.2	2
Clear opening with/without upper tool	mm	100/200	100/200
Bending angle max.		135°	135°
Dimensions (L x W x H) approx.	mm	750 x 1300 x 1515	750 x 1500 x 1715
Weight approx.	kg	280	315

1) Performance data based on material with tensile strength 400 N/mm²; bending capacity stainless steel: Factor 0.75; bending capacity aluminium: Factor 1.2; the optional tool is required for bending VA

HSBM 2020-20 SB - Manual swivelling bending machine in heavy-duty design with segmented upper tools

- ▶ Simple operation
- ▶ Segmented upper tool - Circumferential bends up to 25 mm high possible
- ▶ Swivelling bending function with secure clamping of the workpiece thanks to adjustable clamping pressure
- ▶ Heavy, compact welded construction
- ▶ Simple bending with precise adjustment of the bending angle using a stop with scale
- ▶ Particularly low maintenance



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

Model	HSBM 2020-20 SB
Art. no.	3772920

Technical data	
Working width max.	2020 mm
Bending capacity (400N/mm ²)	2.0 mm
Bending angle max.	135°
Passage between upper + lower cheek max.	120 mm
Dimensions (L x W x H) approx.	2800 x 710 x 1500 mm
Weight approx.	1020 kg

(1) Bending capacity aluminium factor 1.2; bending capacity VA factor 0.75; the optional tools are required for bending VA 2) Explanation of the transport surcharge see overleaf, price TPZ plus VAT

Accessories HSBM 2020- 20 SB	Art. no.
Manual rear stop 0 - 500 mm	3772921
Hardened upper tool	3772922

Manual swing bending machines

HSBM N - Manual swivelling bending machines for universal use, expandable via various attachment kits

- ▶ The workpiece is clamped by hand
- ▶ Simple fixing of the set bending angle, which guarantees a high repeat accuracy is guaranteed
- ▶ Self-lubricating plain bearings
- ▶ The basic version can be converted to a high

upper beam, high segmented upper beam or high segmented upper beam with goat foot at any time using optional attachment kits

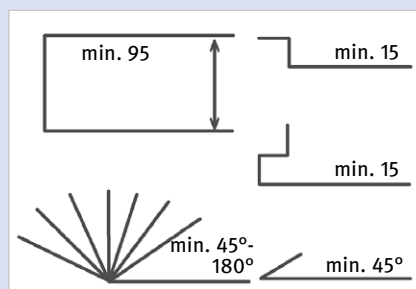


HSBM 660 N version
with low upper beam

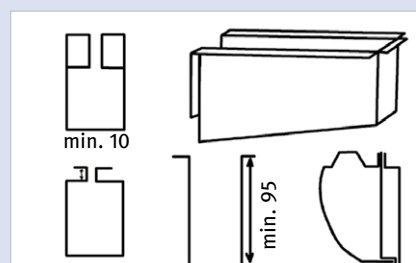
Model		HSBM 660 N	Mounting kit 660 H		HSBM 1050 N	Mounting kit 1050 H	Mounting kit 1050 HSG		HSBM 1300 N	Mounting kit 1300 H	Mounting kit 1300 HSG
Art. no.		3770066	3770067		3771050	3771051	3771053		3771300	3771301	3771303
Technical data											
Working width	mm	660	1020		1050	1050	1270		1300	1300	1300
Bending performance ⁽¹⁾	mm	2	1.80		1.25	1.25	1.20		1.20	1.20	1.20
Bending angle	mm	135°	93°		135°	93°	93°		135°	93°	93°
Dimensions (L) approx.	mm	880	880		1250	1250	1250		1480	1480	1480
Dimensions (W) approx.		570/500	570/500		570/500	570/500	570/500		570/500	570/500	570/500
Dimensions (H) approx.		970	1060		970	1060	1070		970	1060	1070
Weight approx.	kg	56	+ 8		78	+ 13	+ 15		88	+ 16	+ 18

(1) max. values with regard to bending soft metals, e.g. aluminium

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



Bending examples
HSBM with low
and high
Upper cheek



Bending examples
HSBM with high
Upper cheek, segment
splint or goat foot



Quality
Made in
Europe



Basic machine
HSBM N version

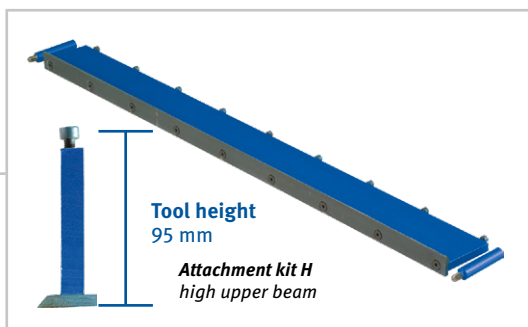
Tool height
25 mm



Optional sharpening rail



Optional round bending rail



Tool height
95 mm

Attachment kit H
high upper beam



Attachment kit HS
With segmented upper beam



Attachment kit HSG
high segment. Upper cheek with goat's foot



HSBM with mounting kit
H-Version



HSBM with mounting kit
HS version



HSBM with mounting kit
HSG version

HSBM - Manual swivel bending machines in heavy-duty design

- ▶ Simple operation
- ▶ Heavy, compact welded construction
- ▶ Particularly low maintenance
- ▶ With continuous sharpening rail

- ▶ For easy bending with precise adjustment of the bending angle using a stop with scale
- ▶ Sheet thickness adjustable via bending beam

S models

- ▶ With segmented upper tools

SH models

- ▶ With tall, segmented goat's foot tools



HSBM 3020-12

ASK FOR YOUR PERSONALISED OFFER!

Convince yourself of our capabilities and ask for individual advice!

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beratung@metallkraft.de



Further swing bending machines available on request!

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

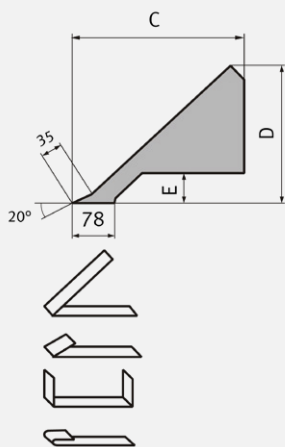
Model		HSBM 1520-20	HSBM 2020-20	HSBM 2520-16	HSBM 3020-12
Art. no.		3779001	3779002	3779003	3779004

Model		HSBM 1520-20 S	HSBM 2020-20 S	HSBM 2520-16 S	HSBM 3020-12 S
Art. no.		3779010	3779011	3779012	3779013

Model		HSBM 1520-20 SH	HSBM 2020-20 SH	HSBM 2520-16 SH	HSBM 3020-12 SH
Art. no.		3779020	3779021	3779022	3779023

Technical data					
Working width	mm	1520	2020	2520	3020
Bending capacity (400 N/mm ²)	mm	2.0	2.0	1.6	1.2
Clearance between upper and lower rail max	mm	140	140	140	140
Bending angle	mm	135°	135°	135°	93°
Dimensions (L x W x H) approx.	mm	2680 x 560 x 1255	2695 x 560 x 1255	3195 x 560 x 1255	3695 x 560 x 1255
Weight approx.	kg	850	1130	1320	1900

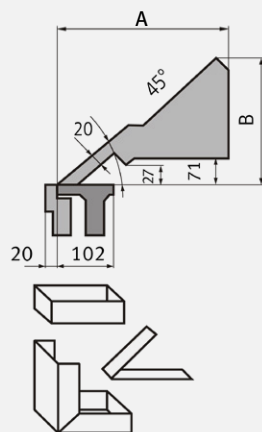
Bending capacity aluminium factor 1.2; bending capacity VA factor 0.75; optional tools are required for bending VA



**Dimensions
Bending beam HSBM**

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

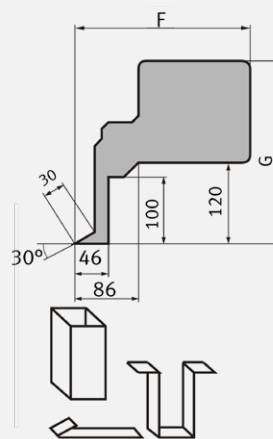
Width of the bending bar 20 mm



**Dimensions
Bending beam HSBM S**

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

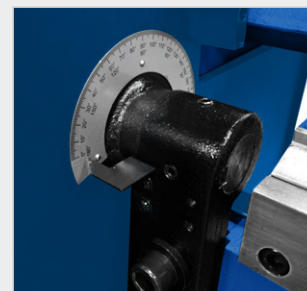
Width of the bending bar 20 mm



**Dimensions
Bending beam HSBM SH**

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

Width of the bending bar 20 mm



Simple, manual adjustment of the bending angle using a stop with scale



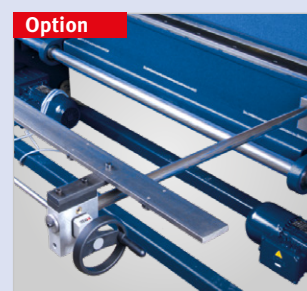
HSBM 1520-20 S

Option



Roller shears for sheet thicknesses up to 0.8 mm

Option



Rear stop with hand wheel and measuring device

Tools for VA on request!

Sharpening rail and bending bar made of Toolox 33 / Segmented tools and bending bar made of Toolox 33 / Segmented goat's foot tools made of Toolox 33

Accessories HSBM 1520- 20 / S/ SH	Art. no.
Rear stop 75 - 760 mm, with handwheel, measuring device and stop fingers	3797010
Option HSBM 1520-20 / S / SH (only ex works!)	Art. no.
Roller shears for sheet thicknesses up to 0.8 mm	3797030
Rear stop 6 - 760 mm, with handwheel, measuring device and stop fingers	3797020

Accessories HSBM 2020- 20 / S/ SH	Art. no.
Rear stop 75 - 760 mm, with handwheel, measuring device and stop fingers	3797011
Option HSBM 2020-20 / S / SH (only ex works!)	Art. no.
Roller shears for sheet thicknesses up to 0.8 mm	3797031
Rear stop 6 - 760 mm, with handwheel, measuring device and stop fingers	3797021

Accessories HSBM 2520- 16 / S/ SH	Art. no.
Rear stop 75 - 760 mm, with handwheel, measuring device and stop fingers	3797012
Option HSBM 2520-16 / S / SH (only ex works!)	Art. no.
Roller shears for sheet thicknesses up to 0.8 mm	3797032
Rear stop 6 - 760 mm, with handwheel, measuring device and stop fingers	3797022

Accessories HSBM 3020- 12 / S/ SH	Art. no.
Rear stop 75 - 760 mm, with handwheel, measuring device and stop fingers	3797013
Option HSBM 3020-12 / S / SH (only ex works!)	Art. no.
Roller shears for sheet thicknesses up to 0.8 mm	3797033
Rear stop 6 - 760 mm, with handwheel, measuring device and stop fingers	3797023

Manual swing bending machines

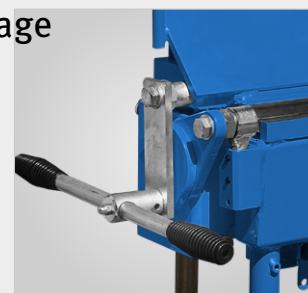
Quality
Made in
Europe



HSBM – Lightweight manual swivel bending machines with undercarriage

- ▶ Robust, versatile and mobile
- ▶ Ideal for roofers and plumbers during installation work, e.g. for making bay window and valley flashings or chimney cladding.
- ▶ Simple and solid design
- ▶ Equipped with transport rollers with parking

- ▶ brake
- ▶ Safe, material-friendly operation
- ▶ Secure fixing of the workpiece via lever
- ▶ Swivel bending process via bow handle



Bending angle stop with scale



HSBM 2160-1.0

Illustration shows optional accessories:

Wooden step support (Art. no.: 3792061)

Foot pedal for upper beam (Art. no. no: 3792059)

Rear stop (Art. no.: 3792052)

Roll shear (Art. no.: 3792050)

Handles (Art. no.: 3792056)

Degree scale (Art. no.: 3792053)

Height adjustment of the upper beam (Art. no. no: 3792057)

Turret stop 4x 0° - 160° Art. no. no.: 3792054



HSBM 3160-0.7

Model		HSBM 1160-1.5	HSBM 2160-1.0	HSBM 2660-0.8	HSBM 3160-0.7
Art. no.		3775011	3775021	3775026	3775031
Technical data					
Working width max.	mm	1150	2000	2500	3000
Bending capacity (400 N/mm ²)	mm	1.5	1.0	0.8	0.8
Dimensions (L x W x H) approx.	mm	1550 x 660 x 1060	2500 x 660 x 1000	2950 x 660 x 1000	3550 x 660 x 1000
Weight approx.	kg	155	244	304	415

Accessories	Art. no.
Roller shears	3792050
Spare blade set	3792051
Degree scale	3792053
Turret stop	3792054
Handles	3792056
Height adjustment	3792057
Seam closer	3792063
Gas spring for lower beam	3792058

Backgauge 1000 mm	
for HSBM 1160.15	3792090
for HSBM 2160-1.0/ HSBM 2660-0.8	3792052
for HSBM 3160-0.7	3792086

Front stop	
for HSBM 1160.15	3792091
for HSBM 2160-1.0	3792055
for HSBM 2660-0.8	3792070

for HSBM 3160-0.7 3792080

Drop moulding for sheet metal sections Art. no.

for HSBM 2160-1.0 3792060

for HSBM 2660-0.8 3792072

for HSBM 3160-0.7 3792082

Foot pedal for upper beam

for HSBM 1160.15 3792092

for HSBM 2160-1.0 3792059

for HSBM 2660-0.8 3792071

for HSBM 3160-0.7 3792081

Beading device Ø 16 mm

for HSBM 2160-1.0 3792062

for HSBM 2660-0.8 3792074

for HSBM 3160-0.7 3792085

Wooden step support

for HSBM 1160.15 3792093

for HSBM 2160-1.0 3792061

for HSBM 2660-0.8 3792073

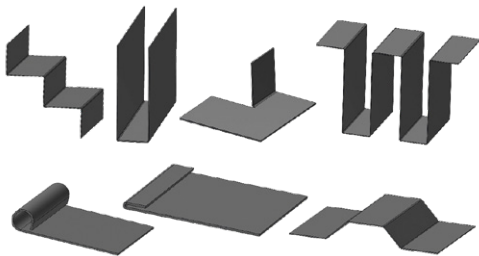
for HSBM 3160-0.7 3792084

MBM 1250- Manual swivelling bending machines with workpiece clamping by means of foot pedal

- ▶ Revolutionary, simple, very fast and convenient operation
- ▶ Compact & space-saving
- ▶ Ideal for bending aluminium, copper, steel, stainless steel, etc.
- ▶ Precise bending angle adjustment up to 170 °
- ▶ Powerful electromagnetic clamping system for optimum bending results
- ▶ Clamping across the entire width guarantees a clean bend
- ▶ Segment division in mm: 25 | 40 | 50 | 70 | 140 | 280 | 700 | 1250
- ▶ The main pressure is on the upper cheek, not on the machine
- ▶ The unique centreless hinges ensure precise force transmission at the bending point.
- ▶ Rear stop, segmented upper beam and foot pedal are included in the standard scope of delivery



7 of numerous other bending options



Model	MBM 1250
Art. no.	3770125

Technical data	
Bending width max.	1250 mm
Fixing pressure	6 t
Power	10 A
Term protection	70 °C
Workpiece thickness ⁽¹⁾	
Bending capacity (400 N/mm ²)	1.6 mm ²⁾ / 1.2 mm ³⁾
Aluminium sheet	1.6 mm ²⁾ / 1.2 mm ³⁾
Copper, zinc, brass sheet	1.6 mm ²⁾ / 1.2 mm ³⁾
Stainless steel sheet	1.0 mm ²⁾ / 0.9 mm ³⁾
Dimensions (L x W x H) approx.	1500 x 410 x 390 mm
Weight approx.	150 kg

Scope of delivery:

- › Bending angle stop
- › Widening of bending beam
- › Backgauge
- › Sharp bending rails
- › Narrow sharpening rail
- › Segmented upper beam
- › Slotted bending rail
- › 7 bending segments
- › Foot pedal

Note: Do not use the machine with a pacemaker

- 1) for workpiece lengths of 1250 mm - higher material thickness possible for shorter workpieces
- 2) Bending beam extension removed
- 3) Bending beam extension fitted

Extremely quick and easy operation - you can bend your sheets into the desired shape in just a few steps with little effort

Step 1:

- ▶ Place the workpiece on the magnetic guide and adjust using the bending edge.



Step 2:

- ▶ Select the appropriate bending segment, place it on the workpiece and activate the magnet.



Step 3:

- ▶ The exact bending angle can be set on the bending stop. Carry out the bending process.



- ▶ Conversion for further bending processes is done in just a few simple steps.

Info & Video

