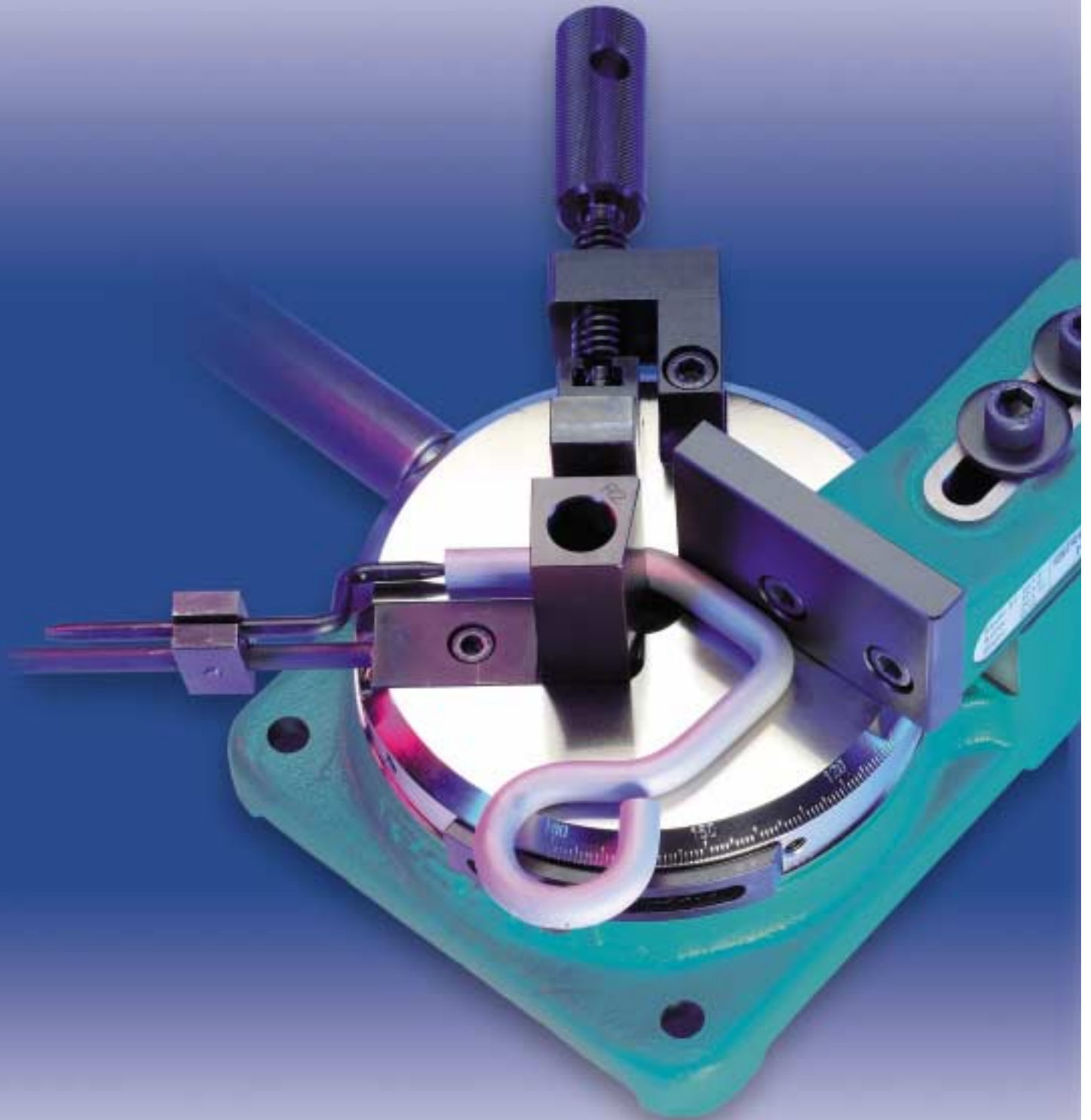


Profile bending machines HB

Precision bending up to 180°



Easy to operate

Highly suitable for the tight and precise bending of round and flat bar stock, high sections and other profiles. True to size bending of whole series possible, thanks to angular and linear stops.

Fields/areas of application

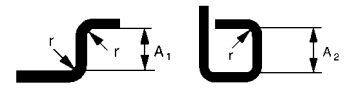
- Mechanical workshops
- Apparatus manufacture
- Prototype construction
- Fittings technology
- Instruments in medical engineering
- Small and medium sized series
- Repair work



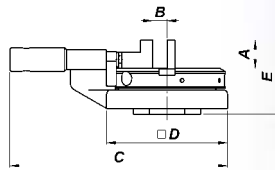
The following bends are possible with all types:



Minimum clearance A1 / A2



HB 10

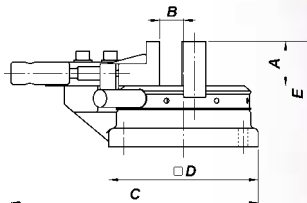


Profile bending machine HB 10
Portable machine for holding in vice. With nickel plated turn-table. Bending angle read-off up to 180°.

Type	Dimensions (mm)					Weight (kg)
	A	B**	C	D	E	
HB 10	35	20	260	150 x 150	92	9.5

Type	Description/scope of delivery	Order No.	Bending perf. (mm)		Bending radius (r)	Section A height (mm)	Bending angle	Jaw opening (mm) B	Minimum clearance	
			St 37*	Copper					A1 (mm)	A2 (mm)
HB 10	Profile bending machine with bending lever 460 mm 1 bending tool R = 0 mm (90°) 1 bending tool R = 6 mm (180°) 1 material stop and 1 angle stop	HBM.010.000.01	35 x 4	35 x 5	0	35	90°	20	18	18
			25 x 5	25 x 6	2.5	35	90°	17.5	23	23
			18 x 6	16 x 8	4	35	90°	16	26	26
			10 x 8	10 x 10	6	35	180°	14	30	12
			9 x 9	Ø 10	10	35	180°	10	38	20
			Ø 10							

HB 14



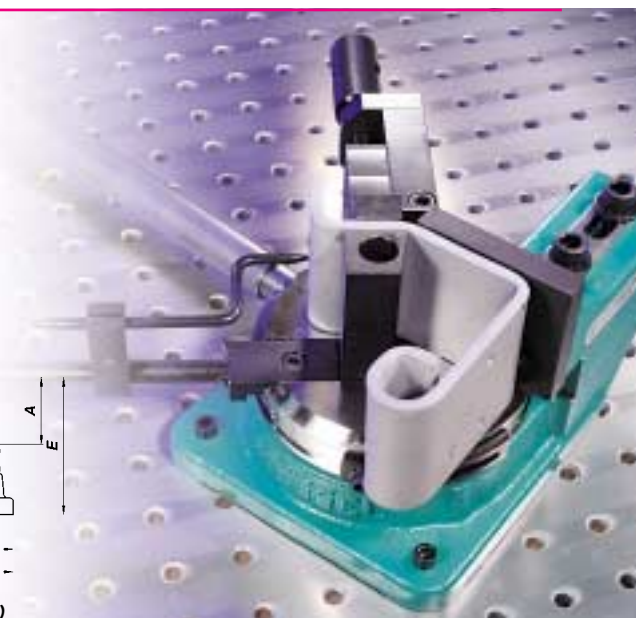
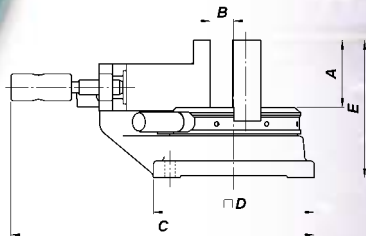
Profile bending machine HB 14
Portable machine for holding in vice and for bench fixture. With covered needle bearing and nickel plated turn-table. Angle read-off up to 180°.

Type	Dimensions (mm)					Weight (kg)
	A	B**	C	D	E	
HB 14	60	36	310	200 x 200	142	22.4

Type	Description/scope of delivery	Order No.	Bending perf. (mm)		Bending radius (r)	Section A height (mm)	Bending angle	Jaw opening (mm) B	Minimum clearance	
			St 37*	Copper					A1 (mm)	A2 (mm)
HB 14	Profile bending machine with bending lever 800 mm (2-part) 1 bending tool R = 2 mm (90°) 1 material stop and 1 angle stop 1 cover plug	HBM.014.000.01	60 x 6	60 x 7	0	60	90°	36	25	30
			40 x 8	50 x 8	2	60	90°	34	29	34
			25 x 10	35 x 10	5	60	90°	31	35	40
			20 x 12	25 x 12	8	60	180°	28	41	16
			13 x 13	15 x 15	10	60	180°	26	45	20
			Ø 15	Ø 16	15	60	180°	21	55	30
					20	60	180°	16	65	40

*Bending performance referred to mild steel St 37, hot rolled **Bending radius R=0

HB 20

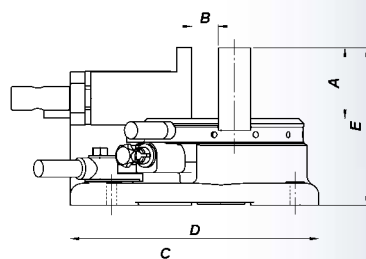


Profile bending machine HB 20
 With covered needle bearing and nickel plated turn-table. Bending angle read-off up to 180°. Bending tool 180° for small radii and reduced height.

Type	Dimensions (mm)					Weight (kg)
	A	B**	C	D	E	
HB 20	100	40	420	240 x 240	205	43.9

Type	Description/scope of delivery	Order No.	Bending perf. (mm)		Bending radius (r)	Section A height (mm)	Bending angle	Jaw opening (mm) B	Minimum clearance	
			St 37*	Copper					A1 (mm)	A2 (mm)
HB 20	Profile bending machine with bending lever 1000 mm (2-part) 1 bending tool R = 2 mm (90°) 1 material stop and 1 angle stop	HBM.020.000.01	100 x 7	100 x 8	0	100	90°	40	30	40
			80 x 8	80 x 10	2	100	90°	38	34	44
			50 x 10	50 x 12	5	100	90°	35	40	50
			35 x 12	30 x 15	8	100	90°	32	46	56
			18 x 18	20 x 20	10	100	180°	30	50	20
			∅ 18	∅ 20	15	100	180°	25	60	30
					20	100	180°	20	70	40
					25	100	180°	15	80	50
					4	25	180°	36	38	8
					6	25	180°	34	42	12
		8	25	180°	32	46	16			

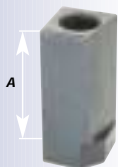
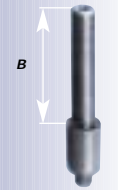
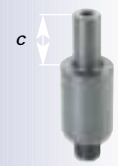

HB 25



Profile bending machine HB 25
 With covered ball bearing and built-in force amplification for heavy sections. Bending angle read-off up to 180°. Bending tool 180° for small radii and reduced section height.

Type	Dimensions (mm)					Weight (kg)
	A	B**	C	D	E	
HB 25	120	60	520	420 x 310	270	106

Type	Description/scope of delivery	Order No.	Bending perf. (mm)		Bending radius (r)	Section A height (mm)	Bending angle	Jaw opening (mm) B	Minimum clearance	
			St 37*	Copper					A1 (mm)	A2 (mm)
HB 25	Profile bending machine with bending lever 1250 mm (2-part) 1 bending tool R = 5 mm (90°) 1 bending tool R = 20 mm (180°) 1 material stop and 1 angle stop 1 cover plug	HBM.025.000.01	120 x 6	120 x 7	0	120	90°	60	40	50
			100 x 7	100 x 8	2	120	90°	58	44	54
			60 x 8	60 x 10	5	120	90°	55	50	60
			40 x 10	40 x 12	10	120	90°	50	60	70
			30 x 12	30 x 15	15	120	180°	45	70	30
			18 x 18	20 x 20	20	120	180°	40	80	40
			∅ 18	∅ 20	30	120	180°	30	100	60
					6	40	180°	54	52	12
					10	40	180°	50	60	20
			HB 25 S	Profile bending machine Model with rapid clamping mechanism	HBM.025.000.02					

Accessories	Type	HB 10	HB 14	HB 20	HB 25 und HBH 25						
	Bending tool 90°	Section height A = 35 mm	Section height A = 60 mm	Section height A = 100 mm	Section height A = 120 mm						
		Radius	Order No.	Radius	Order No.	Radius	Order No.				
		0 mm	HBM.010.030.11	0 mm	HBA.014.030.11	0 mm	HBA.020.030.11	0 mm	HBA.025.032.11		
		2.5 mm	HBA.010.050.11	2 mm	HBM.014.020.11	2 mm	HBM.020.020.11	2 mm	HBA.025.033.11		
		4 mm	HBA.010.051.11	5 mm	HBA.014.031.11	5 mm	HBA.020.031.11	5 mm	HBM.025.030.11	10 mm	HBA.025.034.11
	Bending tool 180°	Section height B = 35 mm	Section height B = 60 mm	Section height B = 100 mm	Section height B = 120 mm						
		Radius	Order No.	Radius	Order No.	Radius	Order No.				
		6 mm	HBM.010.052.11	8 mm	HBA.014.032.11	10 mm	HBA.020.033.11	15 mm	HBA.025.035.11		
		10 mm	HBA.010.053.11	10 mm	HBA.014.033.11	15 mm	HBA.020.034.11	20 mm	HBM.025.031.11		
				15 mm	HBA.014.034.11	20 mm	HBA.020.035.11	30 mm	HBA.025.036.11		
			20 mm	HBA.014.035.11	25 mm	HBA.020.036.11					
	Bending tool 180° for small radii	Section height C = 25 mm			Section height C = 40 mm						
		Radius	Perform.	Order No.	Radius	Perform.	Order No.				
		mm	□	∅	mm	□	∅				
		4	25/1,5	4	HBA.020.037.11	6	40/2	6	HBA.025.038.11		
		6	25/2	6	HBA.020.038.11	10	40/4	10	HBA.025.037.11		
		8	25/3	8	HBA.020.039.11						
						Performance referred to mild steel St 37 hot rolled					
	Extra clamp	For extreme bends, this clamp provides extra connection between the 90° bending tool and the clamp jaw. Usable with the types HB 20 and HB 25.									
		Order No. HBA.020.060.01									



Rapid action clamp for HB 25

A rapid action clamping mechanism can be supplied for the bending machines HB 25. Series work can thereby be performed still more economically, as the workpieces can be clamped and unclamped quickly and safely by a simple lever action.

Order No. HBA.025.040.01

Features of this sturdy construction:

- Rough setting via spindle
- Clamping by cam-lock. Stroke 2.4 mm; self-locking over whole range
- Jaw opening same size as standard model
- Wear resistant and no maintenance

Easy exchange of clamp mechanisms by unscrewing the cyl. hd. screws in the support plate.



Distributor: