

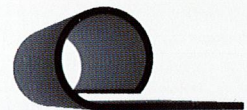
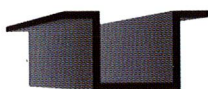
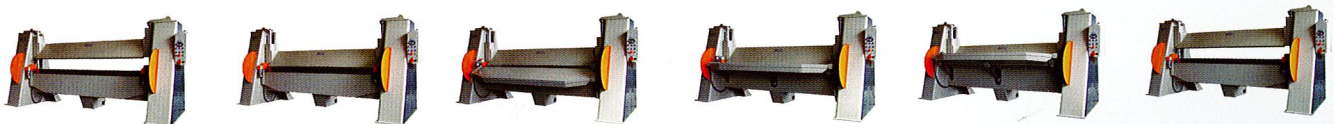
HYDRAULIC BENDING MACHINES

SBM 1000-5000

06



Machine to size your sheet metal profiles with worldwide unique
- patented - hydraulic dynamic crowning



Hydraulic Bending Machines Series SBM 1000 - 5000

Highest precision by new development of Hochstrate Mechanical Engineering

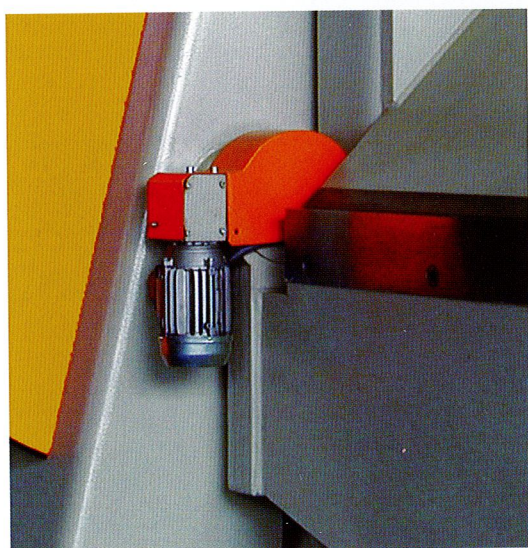
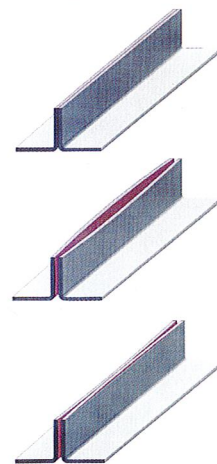
Highest dimensional accuracy by hydraulic dynamic crowning:*

With the patented hydraulic dynamic crowning of the bending beam there is no longer the effect of "bulging" when bending sheets with different materials and different sheet thickness.

Traditional bending machines have almost a static crowning of the bending beam, which is useful just for a special sheet thickness and a special bending angle.

Contrary to that the new hydraulic dynamic crowning of the bending beam makes it possible to bend a sheet with an arbitrary angle exactly, independent of sheet thickness and material.

The controlled operating of the beams with electronic control, regarding sheet thickness and restraightening component, directs the corresponding crowning of the bending beam, so an optimal bending result over the whole length is guaranteed.



Simple operation by automatic sheet metal thickness control:*

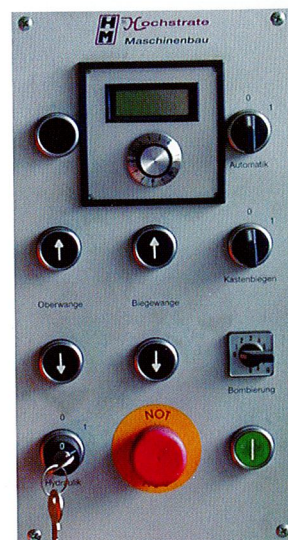
Long setup times for necessary adjustments do no longer aggravate the working process because of the automatic sheet thickness control. The thickness of the sheet will be scanned automatically and the bending beam will be positioned to its required space to the lower beam. This, combined with a clearly visible control panel, makes expensive training of personnel unnecessary. So a flexible exchange of users is practicable and operating errors are avoided.

Light and robust construction

The bending machine is at least a very robust and tough welded steel construction. In contrary to other conventional constructions the weight could be reduced.

An essential component of this new construction is the optimization of the bending force when folding. The special constellation of the hydraulic cylinders underneath the bending beam (incl. different bending radius checkback) guarantees no dead angle over the range, so the hydraulic drive is most effective.

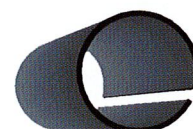
*optional



Program Overview:

Technical data:

Bending angle max.	135°
Inner bend radius min.	2 x sheet thickness
Restraint length min.	10 x sheet thickness
Operating Voltage	400 V
Power consumption	9.5 to 20 hp



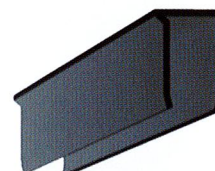
Standard scope of supply:

- Hydraulic operation of clamping- and bending beam
- Clamping beam 45°
- Tools changeable in clamping-, bending and lower beam
- Electronical positioning of bending beam
- Control Panel
 - Digital display bending angle
 - continuously variable setting of bending angle
 - Switches for operating clamping- and bending beam
 - Switch for automatic operation
- Control SPS-Siemens
- Foot-actuated switch for manual and automatic operation
- CE-Certification

Special accessories:

Feed inlet gauge

- Manual
- Electrical with digital positioning display
- Range 10 - 1000 mm (0.394"-39.37"); optional to 5000 mm (196.85")



Tools

- Tools (changeable division) height 50 - 200 mm (1.95"-7.9")
- Pipe forming tools for various diameters
- Special tools for boxing etc.



Special equipment:

- Round bending without tool-changing -cylindrical -
- Round bending without tool-changing -conical -
- Round bending of U-profiles
- Hydraulic tool clamp
- Hydraulic dynamic crowning
- Manual or hydraulic swing out clamping beam
- Fast move
- CNC-memory for bending processes
- Electrical radial positioning for bending beam
- Automatic sheet thickness detection
- Extension of bending angle to 150°
- Extension of clamping beam movement to 500 mm
- Sheet width up to 6000 x 12 mm
- Further special equipment available



STANDARD MANUFACTURING LINE : *

Hochstrate SBM		2004	2005	2006	2008	2010	2012
bending length	in	80,7	80,7	80,7	80,7	80,7	80,7
max. sheet thickness 400N/mm ²	in	0,16	0,20	0,24	0,31	0,39	0,47
upper beam rail	degrees	45	45	45	45	45	45
power cosumption	hp	6,7	6,7	8,0	9,4	9,4	9,4
max raise of upper beam	in	11,8	11,8	11,8	11,8	11,8	11,8
weight ca.	kg	3300	3600	3850	4350	5250	6650
length	in	140	140	140	140	140	140
width	in	68	68	68	68	68	68
height	in	87	87	87	87	87	87
Hochstrate SBM		3004	3005	3006	3008	3010	3012
bending length	in	120	120	120	120	120	120
max. sheet thickness 400N/mm ²	in	0,16	0,20	0,24	0,31	0,39	0,47
upper beam rail	degrees	45	45	45	45	45	45
power cosumption	hp	6,7	6,7	8,0	9,4	9,4	9,4
max raise of upper beam	in	11,8	11,8	11,8	11,8	11,8	11,8
weight ca.	kg	4300	4600	4850	5050	5550	7820
length	in	180	180	180	180	180	180
width	in	68	68	68	68	68	68
height	in	87	87	87	87	87	87
Hochstrate SBM		4004	4005	4006	4008	4010	4012
bending length	in	160	160	160	160	160	160
max. sheet thickness 400N/mm ²	in	0,16	0,20	0,24	0,31	0,39	0,47
upper beam rail	degrees	45	45	45	45	45	45
power cosumption	hp	9,4	9,4	9,4	14,8	20,0	20,0
max raise of upper beam	in	11,8	11,8	11,8	11,8	11,8	11,8
weight ca.	kg	5200	5600	6100	8050	9550	9850
length	in	219	219	219	219	219	219
width	in	68	68	68	68	68	68
height	in	87	87	87	87	87	87
Hochstrate SBM		5004	5005	5006	5008	5010	5012
bending length	in	200	200	200	200	200	200
max. sheet thickness 400N/mm ²	in	0,16	0,20	0,24	0,31	0,39	0,47
upper beam rail	degrees	45	45	45	45	45	45
power cosumption	hp	9,4	9,4	14,8	20,0	20,0	20,0
max raise of upper beam	in	11,8	11,8	11,8	11,8	11,8	11,8
weight ca.	kg	7250	7650	8100	10050	11550	11900
length	in	258	258	258	258	258	258
width	in	68	68	68	68	68	68
height	in	87	87	87	87	87	87

subject to change without prior notice

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*the scope of supply includes
the standard size:

bending length	thickness
40	x 0.04-0.59
60	x 0.04-0.59
79	x 0.04-0.59
99	x 0.04-0.59
118	x 0.04-0.47
138	x 0.04-0.47
158	x 0.04-0.47
177	x 0.04-0.47
197	x 0.04-0.47

