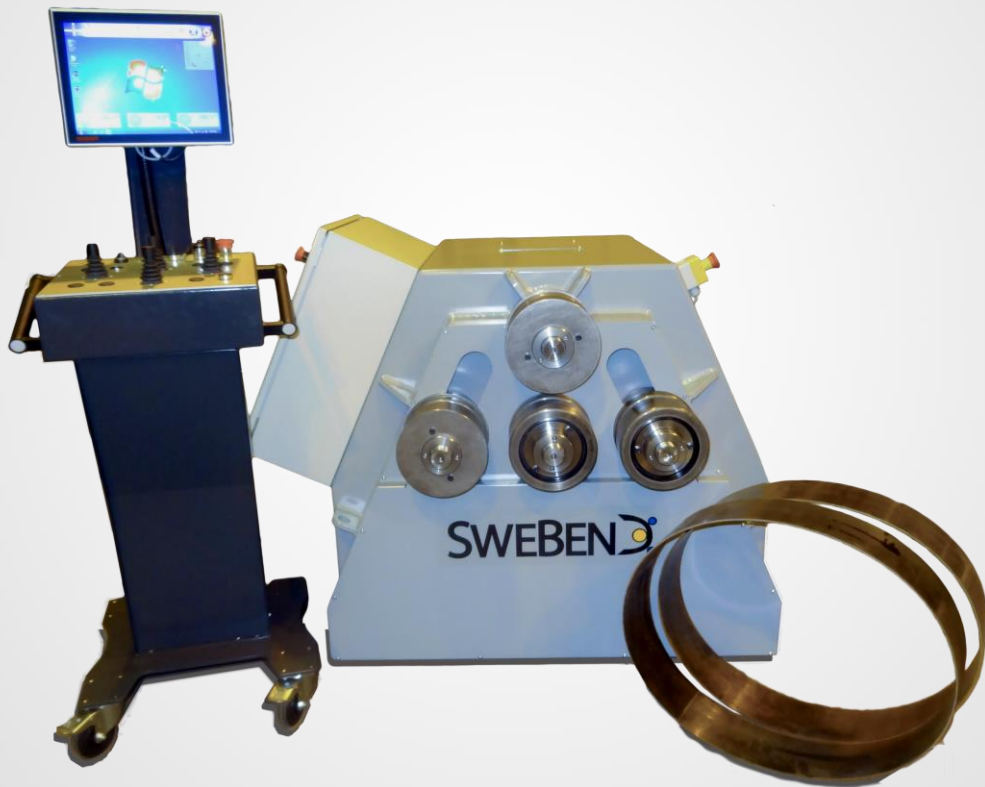


# SWEBEND

*Genuine Swedish Craftmanship,  
Proven results*



## **FOUR-ROLL SECTION BENDING MACHINES** *SB4*

[www.SWEBEND.com](http://www.SWEBEND.com)



Above: Model **SB4B-65 CNC** with tooling to allow rolling plates into desired shape, in this case ellipses. Normally this particular product would have been produced in a four roll plate bending machine, but due to cycle time requirement the SB4 model was the better choice.

### SweBend SB4-series

SweBend has developed a series of four roll section bending machines, starting with the SB4B-55 and ranging up to the SB4-240S.

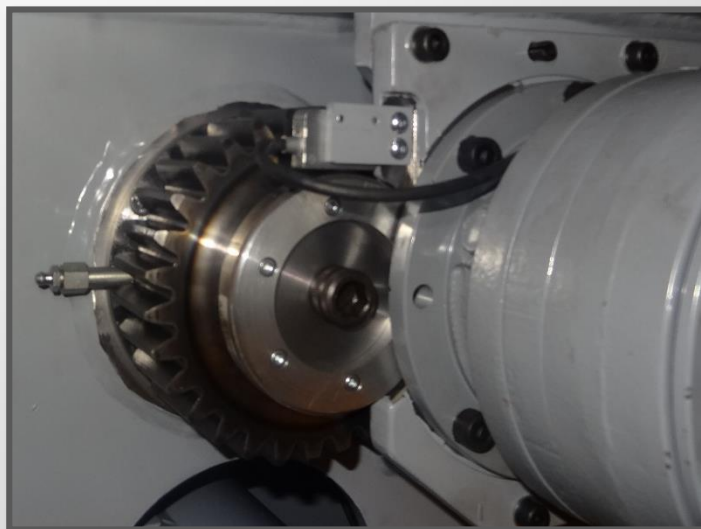
- Type "B" is our basic model without guide rolls
  - Type "S" is with fully hydraulic guide rolls, allowing you to bend and compensate/correct all types of sections
- Both types have the same geometry and capacities.



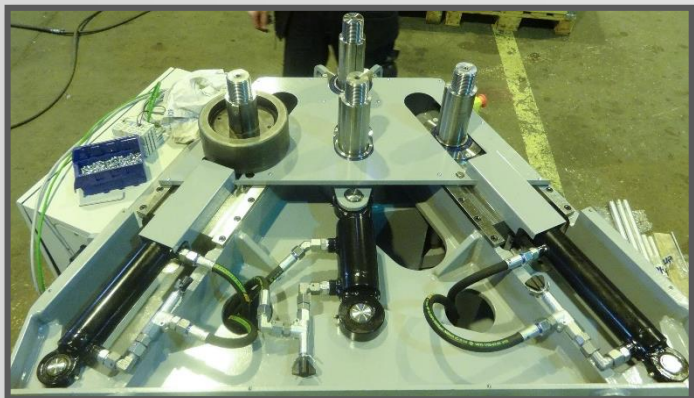
At the back and well protected inside the frame we have placed the hydraulic components, including the oil cooler as an integrated part of the frame. Drive is by separate hydraulic motors and planetary gear boxes for the top and lower shafts.



Machine design is made with attention to aspects like how to keep the geometry and machine size compact and yet be able to use the more sophisticated components like linear encoders of absolute type, as shown on the picture above. These encoders are placed inside the frame where they are well protected yet still easily serviced. This is just one detail to explain the way we think and design machines at **SweBend**.



For length measuring (detecting rotation) we use a system without moving parts that can be damaged or malfunction. Instead we have mounted a magnetic wheel directly on the top shaft and a measuring head on a bracket next to the ring. With this system there is no part that can be worn out.





## CNC System

SweBend SB4B and SB4-S machines can easily be equipped with our own **SEVEN™** CNC system in Bronze, Silver or Gold versions, depending on requirements and optional equipment.



## Optional equipment

We offer many different options like combined execution with separate hydraulic power pack, lifting roll, twisting unit, special rolls, higher speeds, extended shafts etc.

Model Name / Size		SB4B-55 / SB4-55S	SB4B-65 / SB4-65S	SB4B-75 / SB4-75S	SB4B-105 / SB4-105S
Rated Capacity	cm3	7	11	16	50
Installed Power	kW	3,0	4	5,5	11
Shaft diameter (top / lower)	mm	55 / 55	65 / 65	75 / 75	105 / 105
Shaft diameter (side rolls)	mm	55	65	65	75
Roll diameters Top/Lower (OD / drive)	mm	175 / 140	195 / 150	225 / 175	310 / 250
Roll diameters Side rolls (OD / drive)	mm	175 / 140	195 / 150	195 / 150	225 / 175
Free shaft length	mm	125	135	160	230
Max daylight drive rolls	mm	90	100	125	160
Drive on top and lower rolls		Standard	Standard	Standard	Standard
Variable rotation speed		Standard	Standard	Standard	Standard
Type of drive		Electro-mechanic	Hydraulic	Hydraulic	Hydraulic
Number of motors		1	2	2	2
Speed compensation top/lower rolls		Slip Clutch	Hydraulic	Hydraulic	Hydraulic
Digital display for bending rolls		Standard	Standard	Standard	Standard
<b>"S" Version (with guide rolls)</b>					
Guide Roll height adjustment		Hydraulic	Hydraulic	Hydraulic	Hydraulic
Guide Roll turn adjustment		Hydraulic	Hydraulic	Hydraulic	Hydraulic
Guide Roll length adjustment		Hydraulic	Hydraulic	Hydraulic	Hydraulic
Digital display for Guide Rolls height		Optional	Optional	Optional	Option
Combined execution Hor/Vert		Optional	Optional	Optional	Standard
Angle leg out		50 x 50 x 5	60 x 60 x 6	75 x 75 x 8	100 x 100 x 14 (Wb=35)
Angle leg in		50 x 50 x 5	60 x 60 x 6	75 x 75 x 8	100 x 100 x 10 (Wb=25)
Flat bar X-X		50x15 to ID300 (wb=6,3)	60x15 to ID400 (wb=9)	80x15 to ID500 (wb=16)	100x30 to ID800 (wb=50) 80x40 to ID750 (wb=29)
Flat bar Y-Y		100x20 to ID400 (wb=7)	100x25 to ID500 (wb=11)	150x25 to ID500 (wb=16)	200x35 to ID500 (wb=41)
Square bar		35x35 to ID400 (wb=7)	40x40 to ID500 (wb=11)	45x45 to ID750 (wb=15)	65x65 to ID800 (wb=46)
H Beam Y-Y		(Max wb=5 cm3)	(Max wb=10 cm3)	(Max wb=15 cm3)	HEA140 to ID700 (wb=56) HEB120 to ID700 (wb=53)
I Beam Y-Y		IPE100 to ID750 (wb=5,8)	IPE120 to ID750 (wb=8,7)	IPE140 to ID750 (wb=12,3)	IPE180 to ID750 (wb=22)
Channel Y-Y		UNP65x42 to ID500 (wb=5)	U100x50 to ID750 (wb=8,5)	U140x60 to ID750 (wb=14,7)	UNP180 to ID750 (wb=22) UPE180 to ID750 (wb=29)
Rectangular tubing		50x20x3 (wb=4,4)	50x30x3 (wb=5,7)	60x40x4 (wb=11,5)	120x50x6 to ID3500 (wb=53)
Square tubing		35x35x4 (wb=4,3)	40x40x4 (wb=6,3)	50x50x5 (wb=12,3)	90x90x6 to ID3500 (wb=53)
Pipe ODxT		1-1/2" sch.40 / 48 t5 to ID500 (wb=7)	2" sch.40 / 60 t4 to ID600 (wb=9)	2-1/2" sch.40 / 73 t5 to ID750 (wb=18)	4" sch.40 / 115 t7 to ID1500 (wb=60)

Capacities are valid for normal steel with yield point 260 N/mm<sup>2</sup>

Min. dia. depends on grade of deformation accepted

Standard Rolls

Standard Rolls and/or Spec. Rolls

Pipe Rolls Required

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**SweBend** is a Swedish company located in Hässleholm in the very south of Sweden. Our team of dedicated and experienced engineers and mechanics offers you the best possible assistance in the field of bending and forming. Together we have a solid foundation of experience and know-how of what it takes to design, manufacture and install machines that will be a cornerstone in your production.



At **SweBend** we pay attention to the smallest details, since these are often important for the overall functionality as well as performance and endurance.



**SweBend** offers many different sizes of section and plate bending machines, from our smallest model, SB3B-55, designed for narrow and small jobs, throughout a range of standard machines up to our giant Eliminator-400. **SweBend** also offers customer specific machines and special capacities when required.



Design benefits of **SweBend** machines include operator friendly controls such as our own developed wireless **BlueTooth** unit and focus on short lead times to set up the machine for the next job.

Machine frames and mechanical parts are heavily proportioned and all purchased components are only of the highest quality from the best suppliers. We only use bearings from **SKF** – the World famous Swedish Bearing Company.

#### Co-operation partner

SweBend has a close co-operation with the World famous German producer of Tube Bending Machines; **Schwarze-Robitec GmbH**.

This 110 year old company is a strong partner of **SweBend**, and together we can offer a complete range of machines for all types of bending and forming.

**SweBend** is the Swedish and Danish representative for Schwarze-Robitec.



# SWEBEND

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