

HM MACHINERY

Industrivej 3-9
DK-9460 Brovst
Denmark
Tel.: +45 98 23 60 88
Fax: +45 98 23 61 44

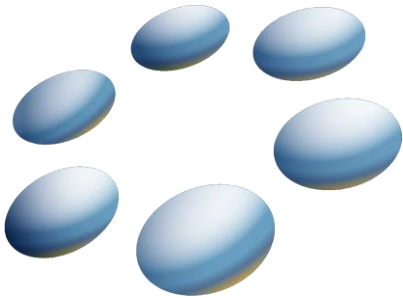
MANUAL
HM MB 700-1000-1300
Bending Machines



CE



EC Declaration of conformity

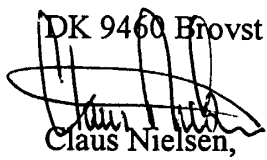


HM MACHINERY A/S

Industrivej 3-9
9460 Brovst
Denmark
www.scantool-group.com
Tel: +45 98 23 60 88
Fax.: +45 98 23 61 44

hereby declares that

HM MB 700-1000-1300 Bending Machines are manufactured in accordance with the provisions of the European Parliament and Council Directive 2006/42 / EC of 17 May 2006

DK 9460 Brovst

Claus Nielsen,
Producent



Preface

This manual is covering MB 700-1000-1300 sheet bending machines. Therefore there will be description of some parts which are not a part of all machines. But as the operation of the various models are alike we have decided to make one manual covering all the models. Below you can see the various models illustrated with the type description.

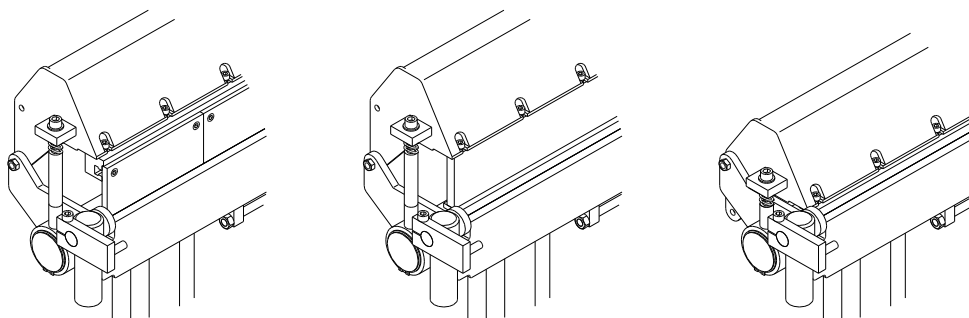


Table Of Contents

1.1 TRANSPORT	4
1.2 HANDLING	4
1.3 PLACING	4
<u>2.0 USER'S GUIDE</u>	<u>5</u>
2.1 OPERATION	5
2.2 SAFETY PRECAUTIONS	6
2.3 MAINTENANCE	6
<u>3.0 SPARE PARTS LIST</u>	<u>7</u>
3.1 EXPLODED DRAWING OF MODEL L AND H	7
3.2 SPARE PARTS LIST FOR SHEET BENDING MACHINE MODEL L & H	8
3.3 EXPLODED DRAWING OF MODEL S	9
3.4 SPARE PARTS LIST FOR BENDING MACHINE MODEL S	10
<u>4.0 TECHNICAL DATA</u>	<u>11</u>
4.1 TECHNICAL SPECIFICATIONS	11
4.2 GUARANTEE	12

1.0 Transport & handling

1.1 Transport

MB sheet bending machine is delivered on a pallet or on transportation feet. The bending machine is wrapped in protective wrapping.

1.2 Handling

MB bending machine can easily be moved on the pallet or the transportation feet it is delivered/equipped on or with.

1.3 Placing

Placing of the bending machine must take place on a firm and level ground. If a model has fittings on the legs you can use these to fasten the bending machine to the floor.

Important that this machine is bolted to the floor.

Before the machine is bolted to the floor the machine it is necessary to level out the machine. It can be necessary to make adjustment with distance pieces underneath the machine if the floor is not in level. The adjustment is necessary to avoid the machine for twisting and then pull uneven.

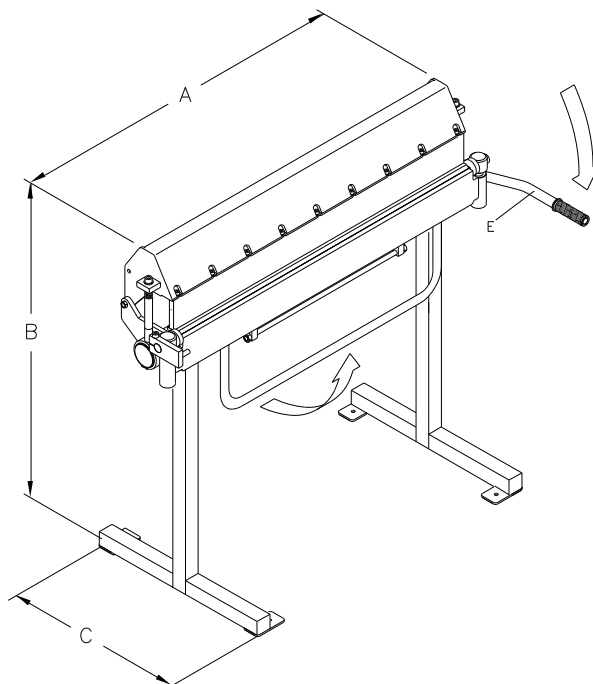


Fig.: 2.1

2.0 User's guide

2.1 Operation

As mentioned earlier the operation of the bending machines is alike no matter which model and type you have got. Please note that the machines have various max limits of how much they can bend due to their construction. This does not change the fact that the operation and the settings are alike for all the models.

Before start operating the bending machine loosen the adjustable bending stop (A) by loosening the bolt (B). Now tilt the bending member (C) to the wanted angle. Before inserting the plate into the machine lift the sheet holder (D) by lifting the handle (E) in top position. When the sheet is placed correctly in the machine the handle (E) is lowered to hold on to the sheet. Do the bending operation by tilting the bending member (C) to the wanted angle. The bending stop can be preset in the wanted angle and this way you are sure go get the same bending angle on all the sheets.

It may be necessary to adjust to the various sheet thickness' by loosening or tightening the adjustment bolts (F) equal in both sides of the bending machine.

To be able to take advantage of the many possibilities the HM sheet bending machine offers (see *fig.: 2.2*), it may be necessary to dismount one or some of the segments in the top member (of the machines which are equipped with these).

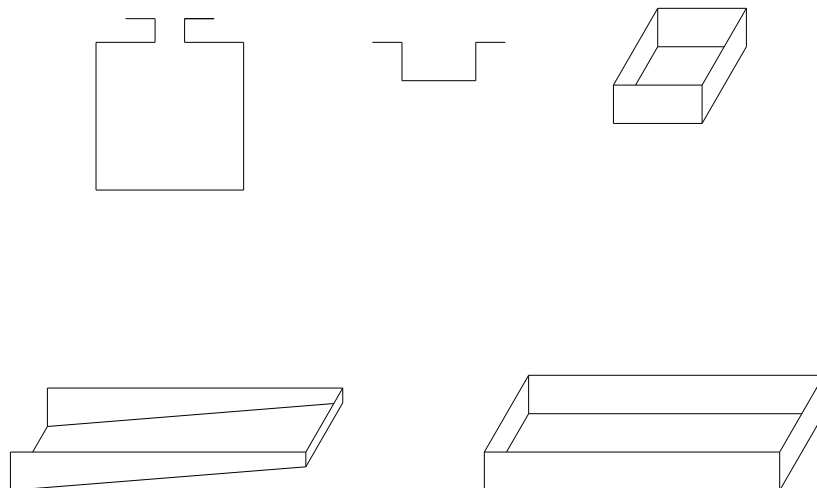


Fig.: 2.2

2.2 Safety precautions

When using and maintaining the machine the following safety precautions must be kept in order to prevent personal and material damage:

The machine should only be operated by personnel who are familiar with the safety rules and precautions connected to the machine.

Operator must wear gloves and safety footwear suitable for working with steel plates.

When operating the sheet bending machine it is important that the operator makes absolutely sure that no-one has their fingers cut off when lowering the top member and activating the bending member.

The HM sheet bending machine is constructed for operation with the equipment it is delivered with. Therefore we do not recommend to make any technical changes on the machine as well as not using any technical equipment which is not approved for the HM sheet bending machine.

Watch your back when operating the machine.

Do keep the work area clean and tidy as mess invites accidents.

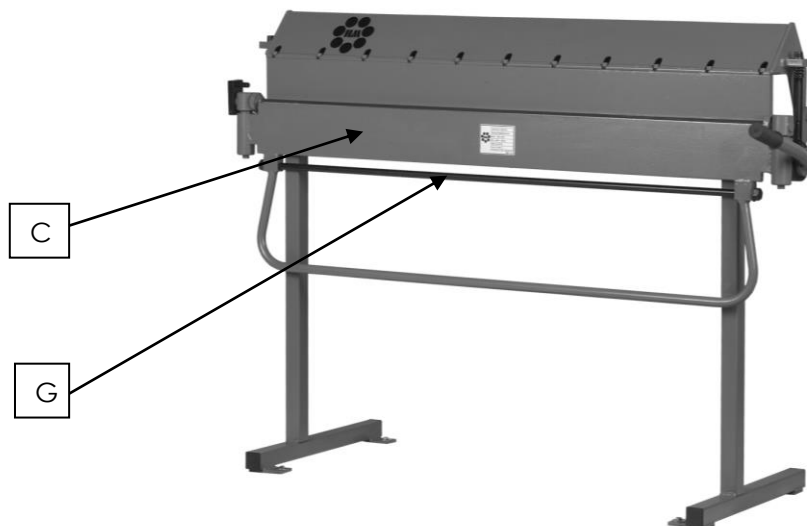
2.3 Maintenance

The sheet bending machine does not need any particular maintenance.

Those models which are equipped with lubrication nipples, must be lubricated whenever necessary.

It may be necessary to readjust the bending member (C) (see *fig.: 2.3*) by tightening/loosening the adjustment screws at both sides of the machine and by tightening the presettings (G) on the member.

Fig.: 2.3



3.0 Spare parts list

3.1 Exploded drawing of model L and H

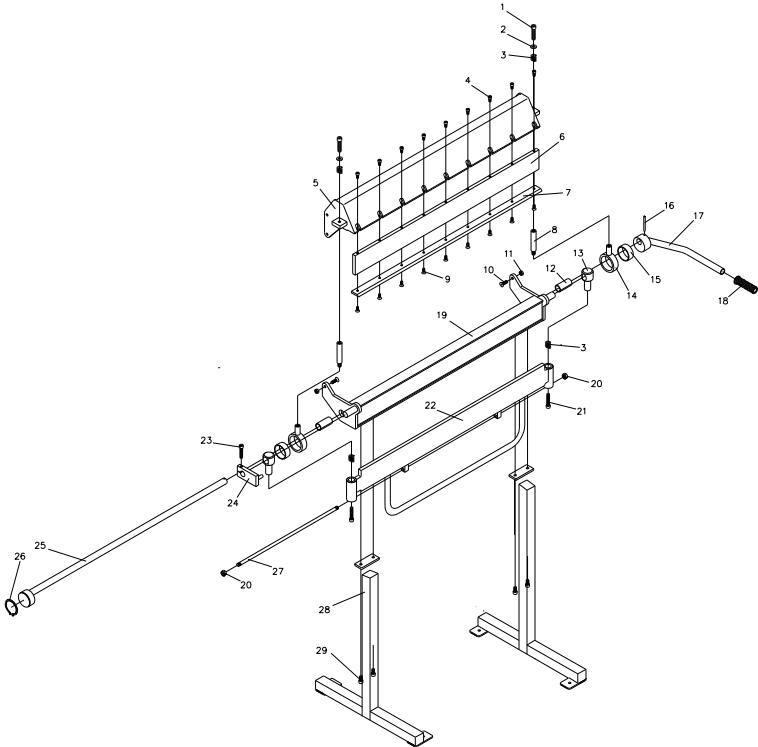


Fig.: 3.1

3.2 Spare parts list for sheet bending machine model L & H

No.	Description	Ordering number					
		Model L			Model H		
		660	1050	1300	660	1050	1300
1	Bolt M12x60	0203001	0203001	0203001	0203001	0203001	0203001
2	Disc ø20x2,75	0203002	0203002	0203002	0203002	0203002	0203002
3	Conical spring	0203003	0203003	0203003	0203003	0203003	0203003
4	Screw M8x16 CH	0203004	0203004	0203004	0203004	0203004	0203004
5	Top member	0203125	0203126	0203127	0203125	0203126	0203127
6	Distance piece f/nose member	-	-	-	0203104	0203105	0203106
7	Nose member	0203108	0203109	0203110	0203112	0203113	0203114
8	Extension shaft	-	-	-	0203008	0203008	0203008
9	Screw M8x16 UH	-	-	-	0203009	0203009	0203009
10	Screw M10x30 UH	0203010	0203010	0203010	0203010	0203010	0203010
11	Nut M10	0516637	0516637	0516637	0516637	0516637	0516637
12	Nylon bearings ø25x35	0203012	0203012	0203012	0203012	0203012	0203012
13	Holder f/bending member	0203013	0203013	0203013	0203013	0203013	0203013
14	Rotational ball f/top member	0203014	0203014	0203014	0203014	0203014	0203014
15	Nylon bearings ø64x25	0203015	0203015	0203015	0203015	0203015	0203015
16	Pipe split ø6x70	0203016	0203016	0203016	0203016	0203016	0203016
17	Arm for plate hold	0203017	0203017	0203017	0203017	0203017	0203017
18	Handle	0110029	0110029	0110029	0110029	0110029	0110029
19	Lower member	0203119	0203120	0203121	0203119	0203120	0203121
20	Nut M12	0411612	0411612	0411612	0411612	0411612	0411612
21	Screw M10x55 CH	0203021	0203021	0203021	0203021	0203021	0203021
22	Bending member	0203130	0203131	0203132	0203130	0203131	0203132
23	Bolt M10x40 CH	0042447	0042447	0042447	0042447	0042447	0042447
24	Stop for bending member	0203024	0203024	0203024	0203024	0203024	0203024
25	Bending shaft	0203134	0203135	0203135	0203134	0203135	0203135
26	Lock ring ø64	0203026	0203026	0203026	0203026	0203026	0203026
27	Clamping bolt	0203137	0203138	0203139	0203137	0203138	0203139
28	Legs for machine	-	-	-	-	-	-
29	Screw M10x16 CH	0203029	0203029	0203029	0203029	0203029	0203029

3.3 Exploded drawing of model S

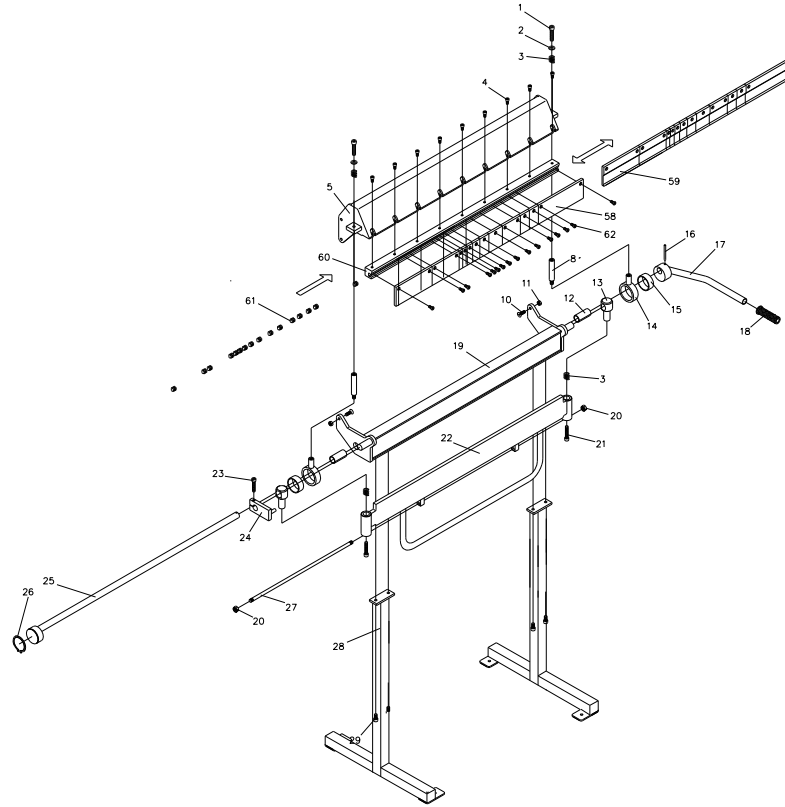


Fig.: 3.2

3.4 Spare parts list for bending machine model S

No.	Description	Ordering number		
		Model S		
		660	1050	1300
1	Bolt M12x60	0203001	0203001	0203001
2	Disc ø20x2,75	0203002	0203002	0203002
3	Conical spring	0203003	0203003	0203003
4	Screw M8x16 CH	0203004	0203004	0203004
5	Top member	0203125	0203126	0203127
8	Extension shaft	-	-	-
10	Screw M10x30 UH	0203010	0203010	0203010
11	Nut M10	0516637	0516637	0516637
12	Nylon bearing ø25x35	0203012	0203012	0203012
13	Holder f/bending member	0203013	0203013	0203013
14	Rotational ball f/top member	0203014	0203014	0203014
15	Nylon bearings ø64x25	0203015	0203015	0203015
16	Pipe split ø6x70	0203016	0203016	0203016
17	Arm for plate holder	0203017	0203017	0203017
18	Handle	0110029	0110029	0110029
19	Lower member	0203119	0203120	0203121
20	Nut M12	0411612	0411612	0411612
21	Screw M10x55 CH	0203021	0203021	0203021
22	Bending member	0203130	0203131	0203132
23	Bolt M10x40 CH	0042447	0042447	0042447
24	Stop for bending member	0203024	0203024	0203024
25	Bending shaft	0203134	0203135	0203135
26	Lock ring ø64	0203026	0203026	0203026
27	Clamping bolt	0203137	0203138	0203139
28	Legs for bending machine	-	-	-
29	Screw M10x16 CH	0203029	0203029	0203029
58	Segment set	0203589	0203588	0203587
59	Segment set w/nose member	-	-	-
60	Mounting member	0203581	0203580	0203579
61	T- grooved nut M8	0203577	0203577	0203577
62	Screw M8x16 DIN 7984	0203576	0203576	0203576

4.0 Technical data

4.1 Technical specifications

All measures are in mm or kg

Item no.	Model	Work length	Max. sheet dim.	A	B	C	Weight
00307150	MB 700H	650	650x1,80	850	1070	510	50
00308150	MB 1000H	1040	1040x1,25	1240	1070	510	80
00309150	MB 1300H	1290	1290x1,20	1470	1070	510	91
00307050	MB 700L	650	650x2,00	850	1050	510	47
00308050	MB 1000L	1040	1040x1,25	1240	1050	510	77
00309050	MB 1300L	1290	1290x1,20	1470	1050	510	88
00307250	MB 700S	650	650x1,50	840	1060	510	64
00308250	MB 1000S	1040	1040x1,25	1240	1060	510	94
00309250	MB 1300S	1290	1290x1,20	1470	1060	510	105

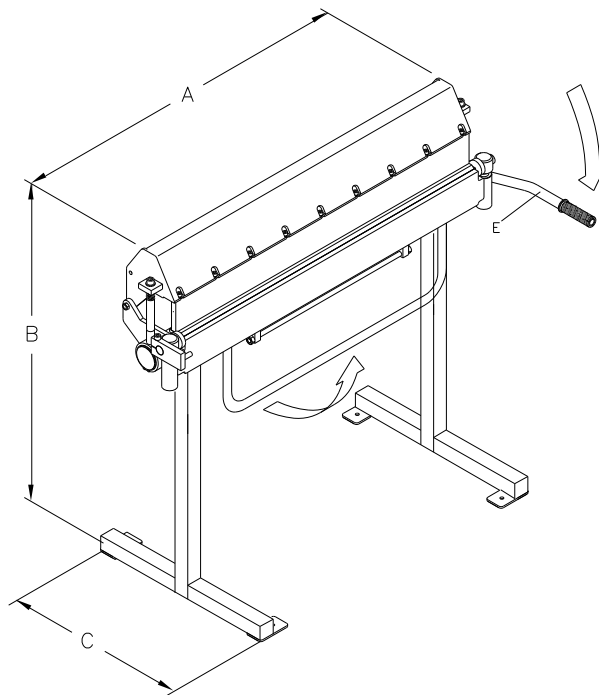


Fig.: 4.2

4.2 Guarantee

If within 2 year of purchase this machine supplied by HM Machinery A/S becomes defective due to faulty materials or workmanship we guarantee to repair or replace the machine or defective part or parts free of charge provided that:

1. The product is returned complete to one of our Service Branches or Official Service Agents.
2. The product has not been misused or carelessly handled and in particular has not been used in a manner contrary to the operating instructions.
3. Repairs have not been made or attempted by other than our own Service Staff or the staff of our Official Service Agents.
4. Documentary proof of purchase date is produced when the goods are handed in or sent for repair.
5. Wear parts are not covered by the warranty