HMT PRODUCTION

Motorized folding machines

Type and custom made sheet metalworking machines.

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About us and about our products

The HM Company Transtech s.r.o. is a family company, founded in the year 1997, which has since its establishment been engaged in the development, manufacture, and sale of machines for sheet metal processing. A wide range of bending machines, guillotine shears, sheet cutting lines for the coils and other products is a guarantee that we can deliver affordable and technically optimal machines for small producers, but also for medium and large companies that produce larger series of products. In addition to the type of machinery, we manufacture and supply also special machines according to customer requirements. We sell our products in the national market, but mainly in international markets (the EU, Russian-speaking countries, Canada, and others).

Folding machines
These are used to produce different profiles of metal sheets of different materials. The proper selection of the bending machine depends on what the customer needs to produce: how complex profiles, in what quantities the production is planned, what thickness and length the customer needs to work with, and what material will be used. Of course, the economic return on investment is also very important.From our production range of bending machines we offer the following:

Manual folding machines
Suitable for single and small-batch production, these do not require any special training to operate and are not economically demanding. They are made up to a maximum length of 4m. Parameters and technical characteristics of these machines are listed in a separate catalogue.

Motorized folding machines
These are suitable for small-batch and mass production of simple open and closed profiles and boxed products. They are highly flexible in the transition to a different type of products. The capacity of the engine-powered bending machines ranges from 1mm - 8mm of thickness and the length is in the range of 1m - 5m. A wide range of accessories, such as motorized and manual rear bumpers, different levels of control from manual to CNC graphic control, allows the customer to choose an affordable and technically optimal machine. With the bending machines we also offer appropriate types of motorized guillotine shears whose parameters and technical characteristics are listed in a separate catalogue.

If you are working, or planning to operate in the field of roofing, production of metal parts, or in the provision of services by the service centre, please contact us, we will help you in choosing the appropriate device.

Anton Palko
The Owner

Tabel for selection of suitable folding machine:

Thickness sheet metal 400N/mm²	Working length				
	650mm	1000mm	1250mm	1500mm	2000mm
1,00mm		TBL KOMBI	TBSH KOMBI	TB TBSH	TBL TB
1,25mm		TBSH	TBL		TF
1,5mm		TBL			SFM TFM
1,75mm				TFM	
2,00mm	TBL		TF TFM TF3S	UNI	UNI
2,25mm		TFM	UNI		
2,50mm		UNI			SLF UNIM
3,00mm		UNIM	SLF UNIM	SLF UNIM	TSM
3,50mm		SLF		TSM	
4,00mm			TSM		TVM
5,00mm				TVM	
6,00mm					MAXI
7,00mm				MAXI	
8,00mm					MAXI PLUS

Manual folding machnies Motorized folding machine

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Labeling of motorized folding machines :

Example: **UNIM 3SH 15/25**
AAAA BBB CC/DD

1. folding capacity (25=2,5mm)
2. working length (15=1,5m)
3. tools (S, SH, ...)
4. type of machines (UNIM, TFM, ...)

1. capacity: 1mm; 1,25mm; 1,5mm; 1,75mm; 2mm; 2,25mm; 2,5mm; 3mm; 3,5mm; 4mm; 5mm; 6mm; 7mm; 8mm

2. working lenght: 0,65m; 1m; 1,25m; 1,5m; 2m; 2,5m; 3m; 4m; 4,5m; 5m

3. Standard tools used(no marking) - blades on all three beams
S - sloping segments on the clamping beam, blade on the folding beam and on the bed beam
SH - high segments on the clamping beam, blade on the folding beam and the bed beam
3S - segments on all three beams, on the clamping beam the segments are sloping
3SH - segments on all three beams, on the clamping beam the segments are high
DUO - on the same machine, there can be on the clamping beam a blade or SH segments

On requirement: 2S - sloping segments on the clamping beam, segments on the folding beam, the blade on the bed beam
2SH - high segments on the clamping beam, the segments on the folding beam, the blade on the bed beam

Tabel for selection of suitable folding machine:

Working length					Thickness sheet metal 400N/mm²
2500mm	3000mm	4000mm	4500mm	5000mm	
TBL	TBL TFM	UNI SLF UNIM			1,00mm
TFM	UNI				1,25mm
UNI SFM	SFM SLF UNIM	TSM			1,5mm
					1,75mm
SLF UNIM	TSM	TVM	MAXI	MAXI PLUS	2,00mm
					2,25mm
TSM					2,50mm
	TVM	MAXI	MAXI PLUS		3,00mm
TVM					3,50mm
	MAXI	MAXI PLUS			4,00mm
MAXI					5,00mm
	MAXI PLUS				6,00mm
MAXI PLUS					7,00mm
					8,00mm

Manual folding machnies Motorized folding machine

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Semimotorized folding machines HYBRID LINE

Types: UNIM, UNIM S, UNIM SH, UNIM 3SH

A uniquely designed bending machine, which combine the advantages of manual and motorized machines. The contact pressure is exerted by hand, through the eccentric piece, and the bending force is provided by an electric motor, thereby achieving a cost-optimal solution. The machines of this type may be equipped with manual or motorized back gauge, which streamlines the work on the machine.

For easier alignment the sheet before bending, the machine may be equipped with a locking foot pedal for the clamping beam, which simplifies the work for the operator. For cutting thin sheet metal thickness up to 0,8mm, hand-operated rotary shears may be delivered.
These machines are suitable for piece production, which in comparison with manual machines they achieve higher efficiency.

They can be used in all industrial areas where one works with

Standard equipment:	Special equipment:
- manual adjustment of one folding angle (type MA) - folding beam adjustment according material thickness - blade of the clamping beam 20° - blade of the folding beam 20mm - foot pedal (see page 18) - locking lever of clamping beam	- tools by type of machine (see page 13) - potenciometer for adjustment angle PT1 (see page 17) - rotary shear up to material thickeness 0,8mm - bed table - motorized back gauge MZDJ (see page 20) - manual back gauge MOD, MPD (see page 20) - manual front stop FSS, FSP (see page 20) - blades and segments on stainless steel - locking pedal of clamping beam - special blades and segments - marking segments with width in mm

We recommend:

Motorized shears
MLS

Technical parameters of semimotorized folding machines HYBRID LINE

Model		Working lenght	Max. sheet thickness steel 400N/mm²	Max. sheet thickness stainless 600N/mm²	Max. sheet thickness aluminium 275N/mm²	Opening height	Motor of folding beam	Length	Width	Height	Weight
		mm	mm	mm	mm	mm	kW	mm	mm	mm	kg
UNIM, UNIM S, UNIM 2S UNIM SH, UNIM 2SH UNIM 3S, UNIM 3SH	**10/30**	1020	3,00	2,00	5,00	140	1,1	1950	710	1280	860
	12/30	1270	3,00	2,00	5,00	140	1,1	2200	710	1280	970
	15/30	1520	3,00	2,00	5,00	140	1,1	2450	710	1280	1060
	20/25	2020	2,50	1,75	4,00	140	1,1	2950	710	1280	1380
	25/20	2520	2,00	1,25	3,00	140	1,1	3450	710	1280	1780
	30/15	3020	1,50	1,00	2,00	140	1,1	3950	710	1280	2200
	32/15	3220	1,50	1,00	2,00	140	1,1	4150	710	1280	2350
	40/10	4020	1,00	0,60	1,50	140	1,1	4950	710	1280	2600

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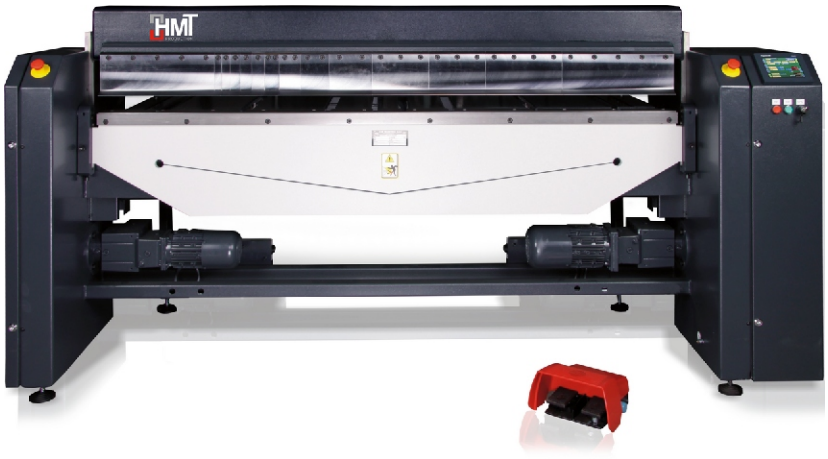
Motorized folding machines NORMAL LINE

Types: TFM, TFM S, TFM SH, TFM 3SH



Motorized bending machines "Normal Line" are representative of light machines, they are characterized by speed, cost-effectiveness in the production of components made of thin sheets of different materials.

Excentric drive of the clamping beam and fast adjustment of the folding beam to the desired thickness of the material in conjunction with optimal position and an appropriate stop allow for easy operation by a foot pedal.

Opening the clamping beam simultaneously with the return movement of the bending beam shortens the time-cycle of the machine.
The folding beam is equipped with a system for adjusting the crowning of the rail for precise bending of even long products.

These machines cover a wide range of different fields of use for manufacture of thin sheet metal such as construction, service centres, plumbing, etc.

Standard equipment:

- blade of the clamping beam 30°
- manual adjustment of one folding angle (type MA)
- blade of the folding beam 20mm
- manual crowning adjustment on the folding beam
- foot pedal (see page 18)

Special equipment:

- tools by type of machine (see page 14)
- rotary shear up to material thickeness 0,8mm
- blades on clamping beam 20°
- blade of the folding beam 10mm (for lenghts from 2m)
- control system PT1, PUD, NC 1A, CNC 2A, CNC 3A (see pages 17, 18)
- motorized back gauge MZDJ (see page 20)
- manual back gauge MOD, MPD (see page 20)
- manual front stop FSS, FSP (see page 20)
- blades and segments on stainless steel
- special blades and segments
- marking segments with width in mm

We recommend:

Motorized shears MLS

Technical parameters of motorized folding machines NORMAL LINE

Model			Working lenght	Max. sheet thickness steel 400N/mm²	Max. sheet thickness stainless 600N/mm²	Max. sheet thickness aluminium 275N/mm²	Opening height	Motor of clamp./ folding beam	Length	Width	Height	Weight
			mm	mm	mm	mm	mm	kW	mm	mm	mm	kg
TFM, TFM S TFM SH	TFM 3SH	**10/22**	1020	2,20	1,50	3,00	110	0,37/0,75	1650	700	1100	670
		12/20	1270	2,00	1,30	3,00	110	0,37/0,75	1900	700	1100	750
		15/17	1520	1,75	1,20	2,50	110	0,37/0,75	2150	700	1100	810
		20/15	2020	1,50	0,80	2,00	110	0,37/0,75	2650	700	1100	1050
		25/12	2520	1,25	0,60	1,50	110	0,37/0,75	3150	700	1100	1290
		30/10	3020	1,00	0,60	1,50	110	0,37/0,75	3650	700	1100	1610

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Motorized folding machines SUPER LINE

Types: SLF, SLF S, SLF SH, SLF 3SH

Motorized bending machines of the SLF type cover a wide range of applications in the production of both simple and complex products up to a length of 4m.

Excentric drive of the clamping beam provides the maximum speed and the desired contact force. When you open it, then it is up to 140mm.

Opening the clamping beam simultaneously with the return movement of the bending beam shortens the time-cycle of the machine.

The bending beam is equipped with a crowning system bar, which allows to achieve the required accuracy over the entire length of the bend.
The appropriate choice of the control system, back gauges, and other accessories creates the conditions for the optimal cost equipment and rapid return on investment.

The machines find application in construction, furniture industry, in the manufacture of doors, billboards, in air conditioners, in the manufacture of switchboards, and the like.

Standard equipment:

- blade of the clamping beam 20°
- manual adjustment of one folding angle (type MA)
- blade of the folding beam 20mm
- manual crowning adjustment on the folding beam
- foot pedal (see page 18)

Special equipment:

- tools by type of machine (see page 14)
- rotary shear up to material thickeness 0,8mm
- blade of the folding beam 10mm, 15mm
- control system Pt1, NC 1A, CNC 2A, CNC 3A, FF101 (see pages 17, 18, 19)
- motorized back gauge MZD (see page 21)
- manual back gauge MOD, MPD (see page 20)
- manual front stop FSS, FSP (see page 20)
- blades and segments on stainless steel
- special blades and segments
- marking segments with width in mm

We recommend:

Motorized shears MPS

Technical parameters of motorized folding machines SUPER LINE

Model		Working lenght	Max. sheet thickness steel 400N/mm²	Max. sheet thickness stainless 600N/mm²	Max. sheet thickness aluminium 275N/mm²	Opening height	Motor of clamp./ folding beam	Length	Width	Height	Weight
		mm	mm	mm	mm	mm	kW	mm	mm	mm	kg
SLF, SLF S SLF SH, SLF 3SH	**10/35**	1020	3,50	2,00	5,00	140	0,75/1,1	1950	800	1200	1360
	12/30	1270	3,00	2,00	5,00	140	0,75/1,1	2200	800	1200	1470
	15/30	1520	3,00	2,00	4,50	140	0,75/1,1	2450	800	1200	1580
	20/25	2020	2,50	1,50	4,00	140	0,75/1,1	2950	800	1200	1760
	25/20	2520	2,00	1,25	3,00	140	0,75/1,1	3450	800	1200	1920
	30/15	3020	1,50	1,00	2,00	140	0,75/1,1	3950	800	1200	2200
	40/10	4020	1,00	0,60	1,50	140	0,75/1,1	4450	800	1200	2850

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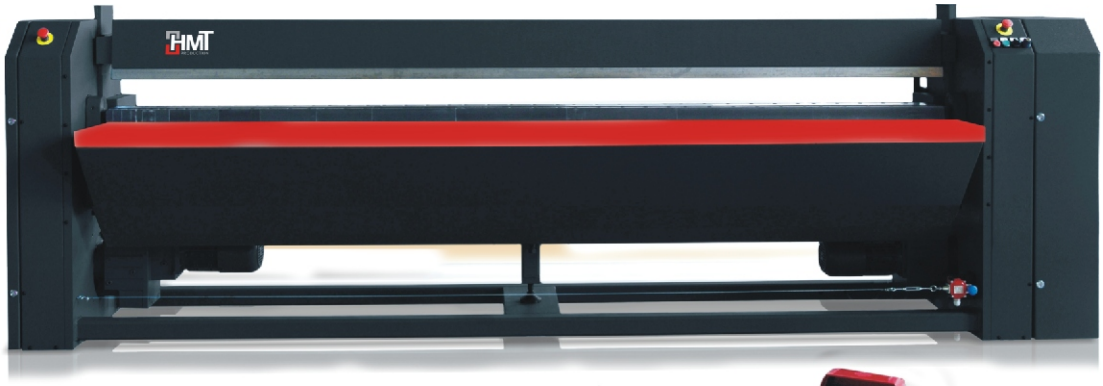
Motorized folding machines SUPER LINE

Types: SFM, SFM 3S

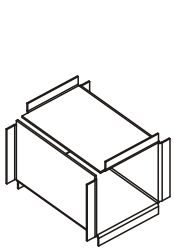


Motorized bending machines class SFM of solid welded construction are used to make square ventilation pipes and L-profiles with a TDC or TDF flange type. The maximum height of the flange is 35mm. The stop bar allows making the precise alignment of the position before bending the sheet metal of different lengths, which facilitates operation by one person.

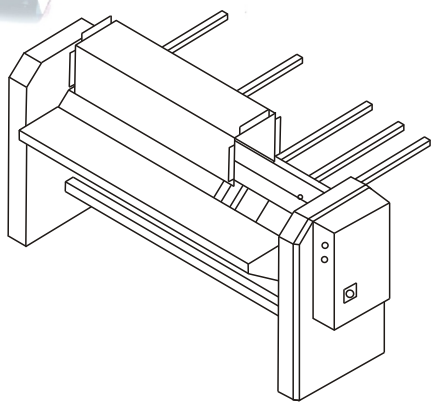
The SFM bending machines offer the following designs:

SFM - clamping blade is solid, bending and the bed blade are segmented

SFM 3S - clamping bending and bed blades are segmented



Duct for TDC connection



Standard equipment:	Special equipment:
- blade of the clamping beam 80° - bed and folding segments - front support table - manual adjustment of one folding angle (type MA) - foot pedal (see page 18)	- tools by type of machine (see page 14) - control system Pt1, NC 1A, CNC 2A, CNC 3A, FF101 (see pages 17, 18, 19) - motorized back gauge MZD (see page 21) - manual back gauge MOD, MPD (see page 20) - blades and segments on stainless steel - special blades and segments - marking segments with width in mm

We recommend:

Motorized shears MPS

Technical parameters of motorized folding machines SUPER LINE

Model		Working lenght	Max. sheet thickness steel 400N/mm²	Max. sheet thickness stainless 600N/mm²	Max. sheet thickness aluminium 275N/mm²	Min.dimension of profile	Motor of clamp./ folding beam	Length	Width	Height	Weight
		mm	mm	mm	mm	mm	kW	mm	mm	mm	kg
SFM SFM 3H	**20/15**	2020	1,50	1,10	2,50	180x180	0,37/0,75	2760	810	1160	1580
	25/15	2520	1,50	1,10	2,50	220x220	0,75/1,1	3240	825	1180	1820
	30/15	3020	1,50	1,10	2,50	250x250	0,75/1,1	3740	825	1180	2070

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Motorized folding machines VARIO LINE

Types: TSM, TSM S, TSM SH, TSM DUO, TSM 3SH

Motorized bending machines class TSM constitute a powerful mid-range device with a possibility of bending the products up to a length of 4m.
The contact force is led out by a pair of trapezoidal screws on both sides of the clamping beam. The bending beam is of solid welded construction and equipped with a crowning system of the bar, which allows to achieve the required accuracy over the entire length of the bend.
Adjustment of the bending of the beam to the desired thickness of the sheet is very easy and fast through quick fixators.

Wide set of tools, including the use of segments of all three beams (3SH-superflex), as well as the possibility of using the DUO system, which allows one to use on a single machine the clamping beam rail and SH segments, which makes the machine highly flexible. Machine control is by a foot pedal, with the four-metres length, two pedals are generally supplied. For the production of long parts, it is preferred to use a motorized back gauge, which simplifies the operation for the operator. The machine utilization is very wide in the manufacture of flat and boxed products for maintenance, the manufacture of switchboards, for kitchen furniture, and the like.

Standard equipment:

- blade of the clamping beam 30°
- blade of the folding beam 20mm
- manual crowning adjustment on the folding beam
- manual adjustment of one folding angle (type MA)
- foot pedal (see page 18)

Special equipment:

- tools by type of machine (see page 15)
- control system Pt1, NC 1A, CNC 2A, CNC 3A, FF101 (see pages 17, 18, 19)
- motorized back gauge MZD (see page 21)
- manual back gauge MOD, MPD (see page 20)
- manual front stop FSS, FSP (see page 20)
- blades and segments on stainless steel
- special blades and segments
- marking segments with width in mm

We recommend:

Motorized shears
MPS, MPSH

Technical parameters of motorized folding machines VARIO LINE

Model		Working lenght	Max. sheet thickness steel 400N/mm²	Max. sheet thickness stainless 600N/mm²	Max. sheet thickness aluminium 275N/mm²	Opening blade/segment	Motor of clamp./ folding beam	Length	Width	Height	Weight
		mm	mm	mm	mm	mm	kW	mm	mm	mm	kg
TSM, TSM S TSM SH, TSM DUO TSM 3SH	**12/40**	1270	4,00	2,50	5,00	200/90	0,75/3,0	2352	1070	1560	2300
	15/35	1520	3,50	2,25	5,00	200/90	0,75/3,0	2650	1100	1560	2700
	20/30	2020	3,00	2,00	4,50	200/90	0,75/3,0	3100	1100	1560	3050
	25/25	2520	2,50	1,50	3,50	200/90	0,75/3,0	3600	1100	1560	3600
	30/20	3020	2,00	1,20	3,00	200/90	0,75/3,0	4100	1100	1560	4300
	40/15	4020	1,50	1,00	2,00	200/90	0,75/3,0	5100	1100	1560	5600

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Motorized folding machines VARIO PLUS LINE

Types: TVM, TVM S, TVM SH, TVM DUO, TVM 3SH

Bending machines type TVM, as to the capacity belong among the high-end midrange products with bending lengths up to 4m for applications in various fields of industry, construction and services. Pairs of trapezoidal screws provide for the drive of the massive clamping beam.

The folding beam, which is of welded construction chamber design, is equipped with a bending bar or segments with adjustable convexity (crowning system). The drive is provided by one or two motors (in the 4m length).

Adjustment of the bending beam to the desired thickness of the sheet is very easy and fast, with quick fixators. Wide range of tools, including the use of segments of all three beams (3SH-superflex), as well as the possibility of using the DUO system, which allows the use on one machine for the clamping beam the rail and SH segments, makes the machine highly flexible. Machine control is by a foot pedal, for four meters in length, two pedals are generally supplied. For the production of long parts, the use of motorized back gauge is preferred to, which simplifies the operation for the operator.

Standard equipment:

- blade of the clamping beam 30°
- blade of the folding beam 25mm
- manual crowning adjustment on the folding beam
- manual adjustment of one folding angle (type MA)
- foot pedal (see page 18)

Special equipment:

- tools by type of machine (see page 15)
- control system Pt1, NC 1A, CNC 2A, CNC 3A, FF101 (see pages 17, 18, 19)
- motorized back gauge MZD (see page 21)
- manual back gauge MOD, MPD (see page 20)
- manual front stop FSS, FSP (see page 20)
- blades and segments on stainless steel
- special blades and segments
- marking segments with width in mm

We recommend:

Motorized shears
MPS, MPSH

Technical parameters of motorized folding machines VARIO LINE

Model		Working lenght	Max. sheet thickness steel 400N/mm²	Max. sheet thickness stainless 600N/mm²	Max. sheet thickness aluminium 275N/mm²	Opening blade/segment	Motor of clamp./ folding beam	Length	Width	Height	Weight
		mm	mm	mm	mm	mm	kW	mm	mm	mm	kg
TVM, TVM S TVM SH TVM DUO TVM 3SH	**15/50**	1520	5,00	3,00	6,00	200/90	1,10/4,0	2620	1150	1660	3350
	20/40	2020	4,00	2,50	6,00	200/90	1,10/4,0	3120	1150	1660	3900
	25/35	2520	3,50	2,20	5,00	200/90	1,10/4,0	3620	1150	1660	4500
	30/30	3020	3,00	2,00	4,50	200/90	1,10/4,0	4120	1150	1660	5200
	40/20	4020	2,00	1,20	3,00	200/90	1,10/4,0	5200	1150	1660	6600

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Motorized folding machines MAXI LINE

Types: MAXI, MAXI SH, MAXI DUO, MAXI 3SH

Bending machines type MAXI are among the best performing ones in terms of capacity resources when bending the material up to a length of 4,5m at a thickness of 7mm. Load-bearing parts of the machine are made as massive welded steel construction which, coupled with powerful motors, provides the required performance parameters. A pair of trapezoidal screws drives the clamping beam, which leads out the required pressure force for the massive machine table. The bending beam has also a dual drive, which eliminates the twisting, especially during longer working lengths.

When handling long and heavy panels, the motorized back gauge can be used suitably, which pushes the material into the bending space and allows you to operate the machine with only one operator. Machines are equipped with tools (segments and blades) of high strength steel (1100N/mm^2). The machine enables high opening (up to 300mm). The version DUO provides a wide range of possibilities, and the appropriate control system increases flexibility and productivity. It is suitable for bending various types of raw materials, especially stainless steel products.

Standard equipment:

- blade of the clamping beam 30°
- blade of the folding beam 40mm
- manual crowning adjustment on the folding beam
- manual adjustment angle (type MA)
- foot pedal (see page 18)

Special equipment:

- tools by type of machine (see page 16)
- control system CNC1A, CNC 2A, CNC 3A, FF101 (see pages 18, 19)
- motorized back gauge MZD (see page 21)
- manual back gauge MOD, MPD (see page 20)
- manual front stop FSS, FSP (see page 20)
- special blades and segments
- marking segments with width in mm

We recommend:

Motorized shears
MPSH, THS

Technical parameters of motorized folding machines MAXI LINE

Model			Working lenght	Max. sheet thickness steel 400N/mm^2	Max. sheet thickness stainless 600N/mm^2	Max. sheet thickness aluminium 275N/mm^2	Opening blade/segment	Motor of clamp./ folding beam	Length	Width	Height	Weight
			mm	mm	mm	mm	mm	kW	mm	mm	mm	kg
MAXI 3SH	MAXI, MAXI SH MAXI DUO	**15/70**	1520	7,00	4,20	8,00	300/190	2,2/5,5	2800	1160	1700	4025
		20/60	2020	6,00	3,50	7,00	300/190	2,2/5,5	3300	1160	1700	4650
		25/50	2520	5,00	3,00	6,00	300/190	2,2/5,5	3800	1160	1700	5270
		30/40	3020	4,00	2,50	5,00	300/190	2,2/5,5	4300	1160	1700	6090
		40/30	4020	3,00	1,50	4,00	300/190	2,2/5,5	4800	1160	1700	7460
		45/20	4520	2,00	1,20	3,00	300/190	2,2/5,5	5330	1160	1700	8390

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Motorized folding machines MAXI PLUS LINE

Types: MAXI plus, MAXI plus SH, MAXI plus DUO, MAXI plus 3SH

Motor bending standing MAXI plus are the most powerful devices of their category available on the market. Reinforced successful construction of the Maxi type allows to increase the capacity of bending the material thickness from 2mm to 8mm and a length of material being from 2m to 5m.

High clamping forces are provided by a pair of trapezoidal screws, the dual drive of the folding beam, quality tools (strength up to 1100N/mm^2) and the DUO system provide the machine with high flexibility. In the lengths from 4m, the machine is standard equipped with a pair of foot pedals.

When handling long and heavy panels, a motorized back gauge can be suitably used, which pushes the material into the bending and allows you to operate the machine with only one operator.

The machine enables high opening (up to 350mm). The machines are equipped with tools (segments and bars) of high strength steel (1100N/mm^2). The version DUO provides a wide range of possibilities and the appropriate control system increases flexibility and productivity. It is suitable for bending various types of raw materials, especially stainless steel products.

Standard equipment:

- blade of the clamping beam 30°
- blade of the folding beam 40mm
- manual crowning adjustment on the folding beam
- control system type NC1A (see page 18)
- blades and segments on stainless steel
- foot pedal (see page 18)

Special equipment:

- tools by type of machine (see page 16)
- control system CNC 2A, CNC 3A, FF101 (see pages 18, 19)
- motorized back gauge MZD (see page 21)
- manual back gauge MOD, MPD (see page 20)
- manual front stop FSS, FSP (see page 20)
- special blades and segments
- marking segments with width in mm

We recommend:

Motorized shears THS

Technical parameters of motorized folding machines MAXI plus LINE

Model		Working lenght	Max. sheet thickness steel 400N/mm^2	Max. sheet thickness stainless 600N/mm^2	Max. sheet thickness aluminium 275N/mm^2	Opening blade/segment	Motor of clamp./ folding beam	Length	Width	Height	Weight
		mm	mm	mm	mm	mm	kW	mm	mm	mm	kg
MAXI plus MAXI plus SH MAXI plus DUO MAXI plus 3SH	**20/80**	2020	8,00	5,00	10,00	350/240	4/2x4	3520	1300	1750	5350
	25/70	2520	7,00	4,20	8,00	350/240	4/2x4	4020	1300	1750	6080
	30/60	3020	6,00	3,50	7,00	350/240	4/2x4	4520	1300	1750	6950
	40/40	4020	4,00	2,50	5,00	350/240	4/2x4	5540	1300	1760	8150
	45/30	4520	3,00	1,50	4,00	350/240	4/2x4	6040	1300	1760	9100
	50/20	5020	2,00	1,20	3,00	350/240	4/2x4	6540	1300	1760	10230

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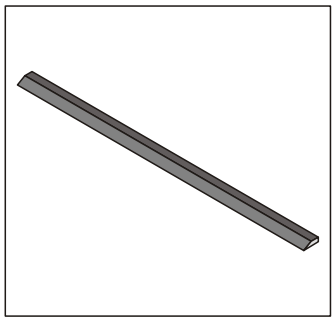
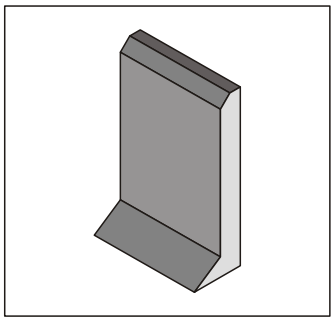
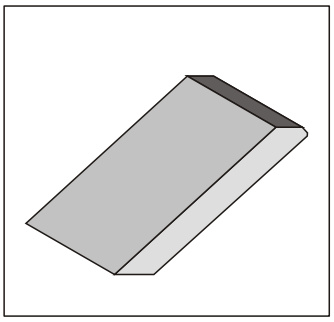
Tools



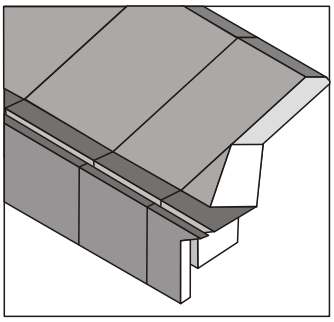
Standard blade



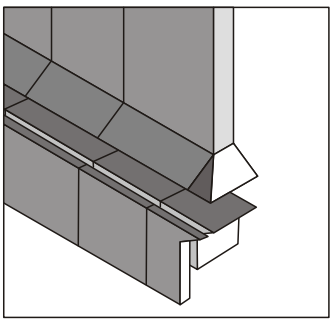
Segments type SH



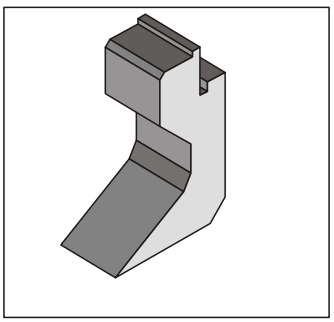
Segments type S



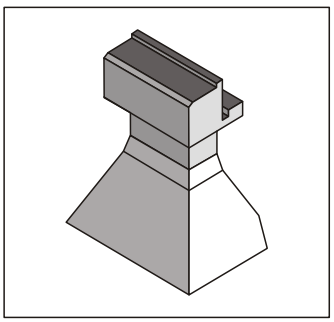
Segmenty typu 3S



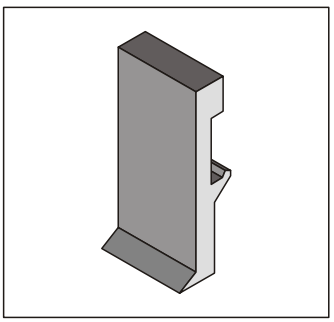
Segments type 3SH



Special tools



Corners segments



Quick change segments

Length	Standard separation of segments																	
	mm																	
1020	25	30	35	40	45	50	75	100	150	200	270							
1270	25	30	35	40	45	50	75	100	150	200	250	270						
1520	25	30	35	40	45	50	75	100	150	200	270	500						
2020	25	30	35	40	45	50	75	100	150	200	200	270	400	400				
2520	25	30	35	40	45	50	75	100	150	200	200	270	400	400	500			
3020	25	30	35	40	45	50	75	100	150	200	200	270	400	400	500	500		
4020	25	30	35	40	45	50	75	100	150	220	250	500	500	500	500	500	500	
4520	25	30	35	40	45	50	75	100	150	220	250	500	500	500	500	500	500	500
5020	25	30	35	40	45	50	75	100	150	220	250	500	500	500	500	500	500	500	500

- other dimensions of segments for requirement
- marking segments with width in mm (optional)

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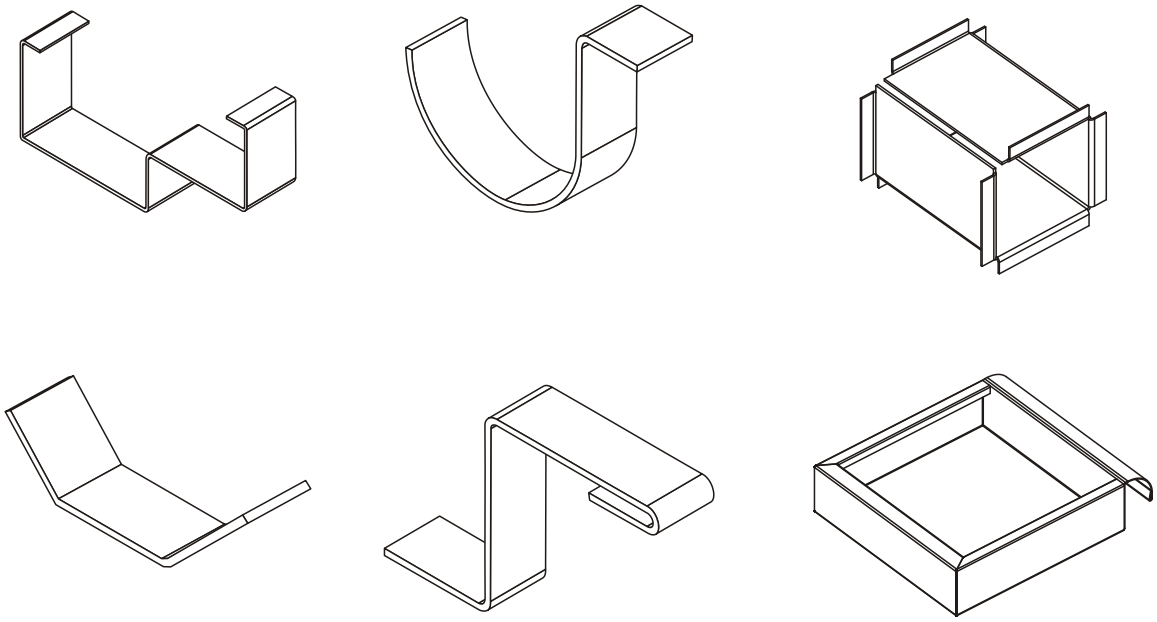
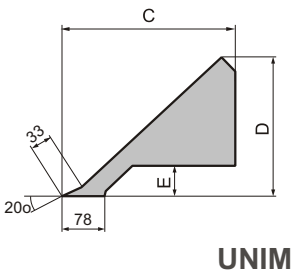
Example of products



HYBRID LINE - standard tools

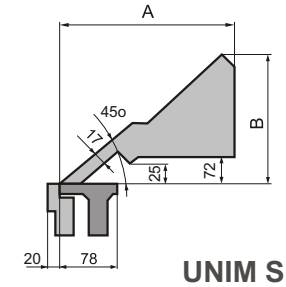
UNIM, UNIM S, UNIM SH, UNIM 3SH



UNIM

	C	D	E
1000	340	305	49
1250	340	305	49
1500	340	305	49
2000	340	305	49
2500	345	310	49
3000	345	310	49
3200	345	310	49
4000	345	310	49

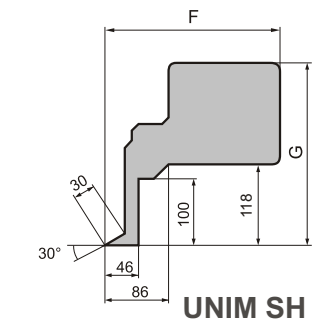
Dimensions of the beams are in mm



UNIM S

	A	B
1000	360	335
1250	360	335
1500	360	335
2000	360	335
2500	370	340
3000	370	340
3200	370	340
4000	370	340

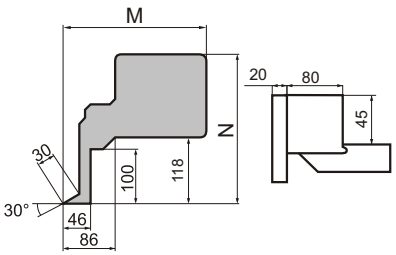
Dimensions of the beams are in mm



UNIM SH

	F	G
1000	290	320
1250	290	320
1500	290	320
2000	290	320
2500	310	340
3000	310	340
3200	310	340
4000	310	340

Dimensions of the beams are in mm



UNIM 3SH

	M	N
1000	290	320
1250	290	320
1500	290	320
2000	290	320
2500	310	340
3000	310	340
3200	310	340
4000	310	340

Dimensions of the beams are in mm

Other shapes and dimensions of tools consult the manufacturer

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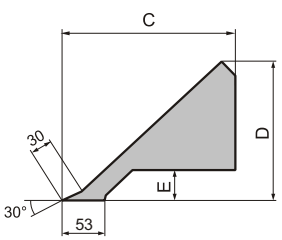
NORMAL LINE - standard tools

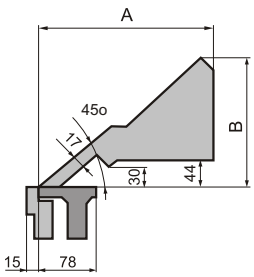
TFM, TFM S, TFM SH, TFM 3SH



TFM

	C	D	E
1000	220	194	44
1250	220	194	44
1500	225	200	44
2000	258	232	44
2500	258	232	44
3000	262	232	44

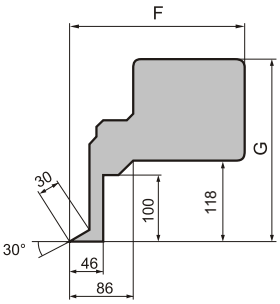
Dimensions of the beams are in mm



TFM S

	A	B
1000	234	198
1250	234	198
1500	258	215
2000	258	215
2500	310	265
3000	343	303

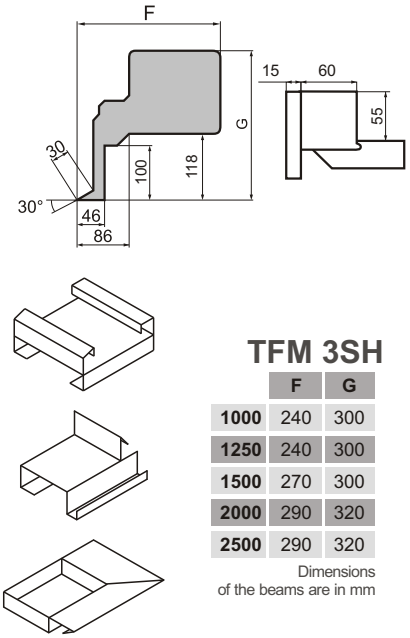
Dimensions of the beams are in mm



TFM SH

	F	G
1000	240	300
1250	240	300
1500	270	300
2000	290	320
2500	290	320
3000	290	320

Dimensions of the beams are in mm



TFM 3SH

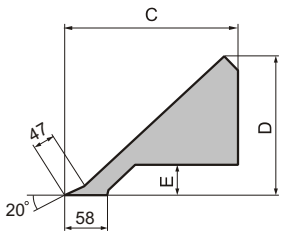
	F	G
1000	240	300
1250	240	300
1500	270	300
2000	290	320
2500	290	320

Dimensions of the beams are in mm

Other shapes and dimensions of tools consult the manufacturer

SUPER LINE - standard tools

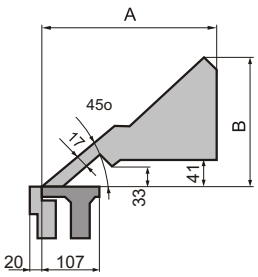
SLF, SLF S, SLF SH, SLF 3SH



SLF

	C	D	E
1000	380	338	52
1250	380	338	52
1500	380	338	52
2000	360	338	52
2500	360	338	52
3000	360	338	52
4000	*360**	*338**	*52**

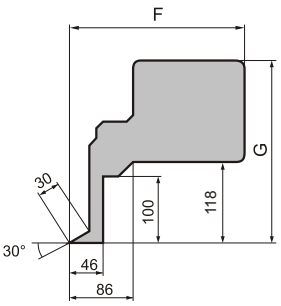
Dimensions of the beams are in mm



SLF S

	A	B
1000	350	310
1250	350	310
1500	350	310
2000	350	310
2500	355	315
3000	355	315
4000	*355**	*315**

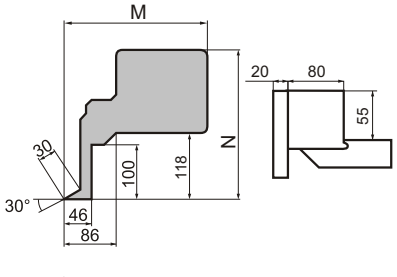
Dimensions of the beams are in mm



SLF SH

	F	G
1000	270	300
1250	270	300
1500	290	320
2000	290	320
2500	310	340
3000	310	340
4000	*310**	*306**

Dimensions of the beams are in mm



SLF 3SH

	M	N
1000	270	300
1250	270	300
1500	290	320
2000	290	326
2500	310	340
3000	310	340
4000	*310**	*340**

Dimensions of the beams are in mm

Other shapes and dimensions of tools consult the manufacturer
*Dimensions are informative

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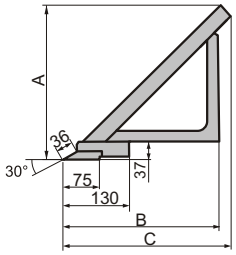
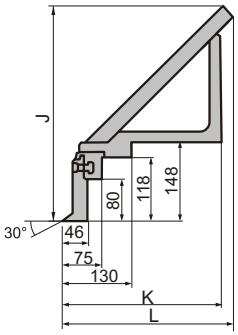
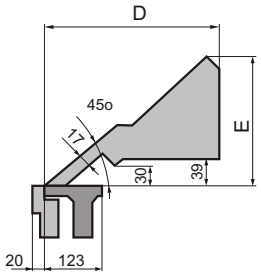
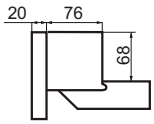
VARIO LINE - standard tools

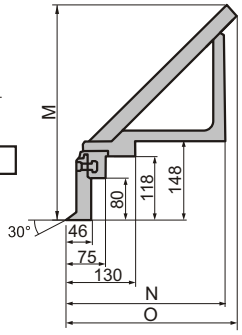
TSM, TSM S, TSM SH, TSM DUO, TSM 3SH



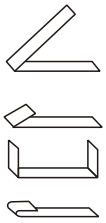








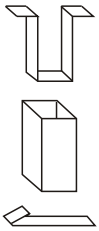
TSM



	A	B	C
1000	300*	300*	325*
1250	300	300	325
1500	300	300	325
2000	365	370	400
2500	400	370	435
3000	435	415	470
4000	435*	415*	470*

Dimensions of the beams are in mm

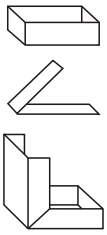
TSM SH



	J	K	L
1000	410*	300*	325*
1250	410	300	325
1500	410	300	325
2000	475	370	400
2500	510	370	400
3000	545	415	470
4000	545*	415*	470*

Dimensions of the beams are in mm

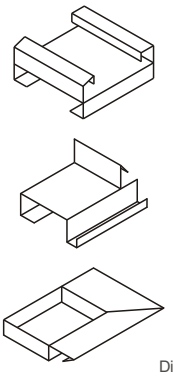
TSM S



	D	E
1000	345*	295*
1250	345	295
1500	345	295
2000	420	365
2500	455	400
3000	490	435
4000	490*	435*

Dimensions of the beams are in mm

TSM 3SH



	M	N	O
1000	410*	300*	325*
1250	410	300	325
1500	410	300	325
2000	475	370	400
2500	510	370	400
3000	545	415	470
4000	545*	415*	470*

Dimensions of the beams are in mm

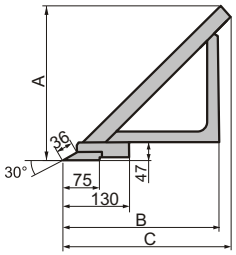
TSM DUO

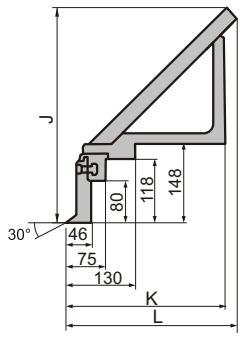
Other shapes and dimensions of tools consult the manufacturer

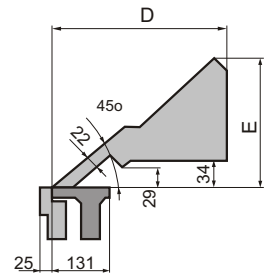
*Dimensions are informative

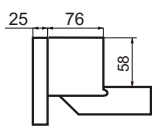
VARIO PLUS LINE - standard tools

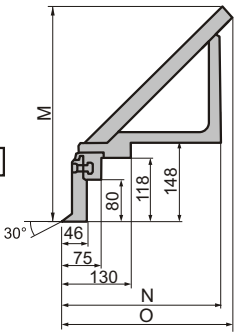
TVM, TVM S, TVM SH, TVM DUO, TVM 3SH



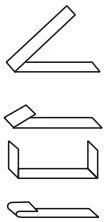








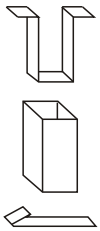
TVM



	A	B	C
1500	390*	395*	415*
2000	390	395	415
2500	460	445	485
3000	460	445	485
4000	485	470	510

Dimensions of the beams are in mm

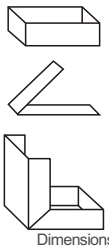
TVM SH



	J	K	L
1500	500*	395*	415*
2000	500	395	415
2500	570	445	485
3000	570	445	485
4000	595	470	510

Dimensions of the beams are in mm

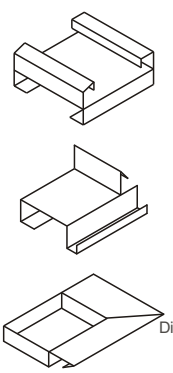
TVM S



	D	E
1500	440*	375*
2000	440	375
2500	510	445
3000	510	445
4000	535	470

Dimensions of the beams are in mm

TVM 3SH



	M	N	O
1500	500*	395*	415*
2000	500	395	415
2500	570	445	485
3000	570	445	485
4000	595	470	510

Dimensions of the beams are in mm

TVM DUO

Other shapes and dimensions of tools consult the manufacturer

*Dimensions are informative

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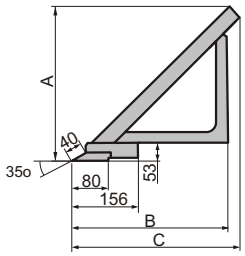
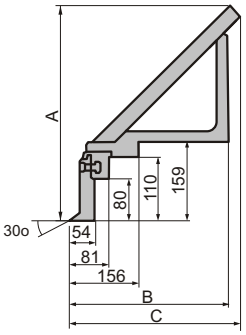
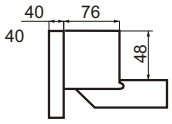
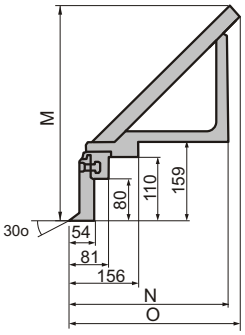
MAXI LINE - standard tools

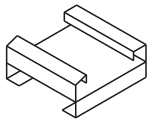
MAXI, MAXI SH, MAXI DUO, MAXI 3SH

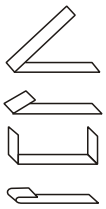








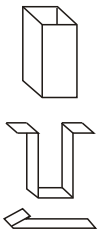




MAXI

	A	B	C
1500	525	530	555
2000	525	530	555
2500	525	530	555
3000	530	530	560
4000	535	530	565
4500	535	530	565

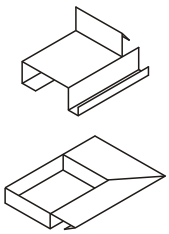
Dimensions of the beams are in mm



MAXI SH

	A	B	C
1500	630	530	555
2000	630	530	555
2500	630	530	555
3000	635	530	560
4000	640	530	565
4500	640	530	565

Dimensions of the beams are in mm



MAXI 3SH

	M	N	O
1500	630	530	555
2000	630	530	555
2500	630	530	555
3000	635	530	565
4000	640	530	565
4500	640	530	565

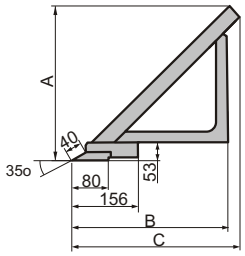
Dimensions of the beams are in mm

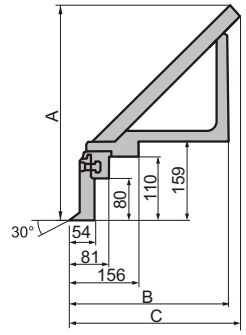
MAXI DUO

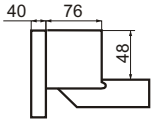
Other shapes and dimensions of tools consult the manufacturer

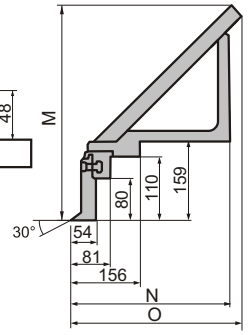
MAXI PLUS LINE - standard tools

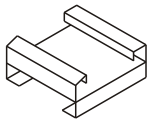
MAXI plus, MAXI plus SH, MAXI plus DUO, MAXI plus 3SH

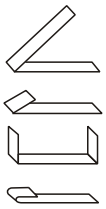








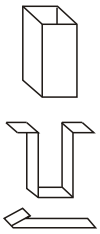




MAXI plus

	A	B	C
2000	525	530	555
2500	525	530	555
3000	525	530	555
4000	560	530	590
4500	560	530	590
5000	585	545	615

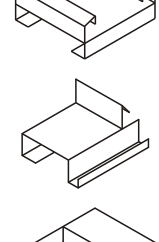
Dimensions of the beams are in mm



MAXI plus SH

	A	B	C
2000	630	530	555
2500	630	530	555
3000	630	530	555
4000	665	530	590
4500	665	530	590
5000	690	545	615

Dimensions of the beams are in mm



MAXI plus 3SH

	M	B	C
2000	630	530	555
2500	630	530	555
3000	630	530	555
4000	665	530	590
4500	665	530	590
5000	690	545	615

Dimensions of the beams are in mm

MAXI PLUS DUO

Other shapes and dimensions of tools consult the manufacturer

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Control systems

Our wide range of control systems is to allow the customers to choose the cost-optimal machine configuration, considering what the customer will produce. Standard machines are supplied with manual bending angle under the name MA, except for the MAXI PLUS machine in which the standard is control system NC1A. Other types are like the options that the customer can choose when ordering the machine.

MA

- manually adjust the angle
- normally on the left side of the machine

PT-1

- manual angle adjustment via potentiometer
- located on the right side of the machine (convenient for longer machines)

PUD

- one angle adjustment by a potentiometer
- positioning of the back gauge "+", "-" buttons (start-stop)
- set the speed of back gauge by potentiometer

NC1A

- 5,7´´colour touch screen (for MAXI and MAXI plus 7,5´´)
- setting the angle, including the correction for different thickness and quality of the material
- the ability to store the angles in memory
- the names of profiles (in words and figures)

CNC2A

- 5,7´´colour touch screen (for MAXI and MAXI plus 7,5´´)
- entering the back gauge position and bending angles
- profiles can be programmed with memory for 100 sections, each with 10 bends
- function of radius
- the names of profiles (in words and figures)
- copy function profile
- the "clean table" - for easy material handling, particularly during rotation

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Control systems

CNC3A

- 5,7"colour touch screen (for MAXI and MAXI plus 7,5")
- entering the back gauge position, including bending angle correction, crushing beam stroke
- profiles can be programmed with the memory for 100 sections, each with 10 bends
- control of the crushing beam, i.e. the opportunity to stop at a defined opening position
- function of radius
- function "hem" closed or open
- the names of profiles (in words and figures)
- copy function profile
- the "clean table" - for easy material handling, particularly during rotation

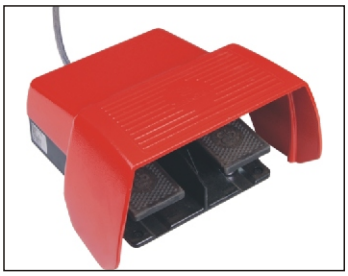
Control systems NC1A, CNC2A and CNC3A ensure control of induction motors drives by frequency changers.

The standard position of the control panel

- on the right side of machine
- ergonomically placed control touch panel
- fixed position of control system

Position of the control panel on the console

- suitable for lengths over 2 m (optional)
- positioning of control system according to the needs of machine operator
- optional for control systems CNC2 and CNC3 and standard for FF-101



Control foot pedal

- two control pedals
- STOP production function
- bar for keeping the pedal (optional)

Marking of segments

- marking segments with width in mm
- faster and more transparent work with tools

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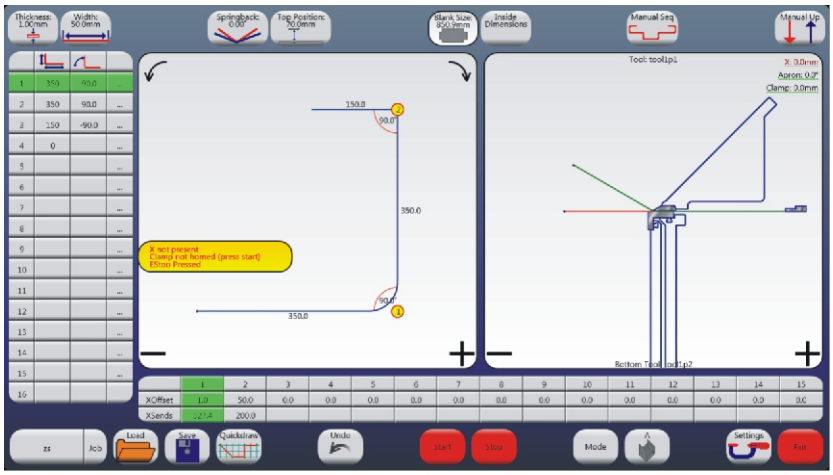
Control systems

Control system FF101

This universal control system can be used for all kinds of motorized bending machines made by company.
It uses the latest technology in the field of control, resulting in an easily programmable system controlled via the touch screen.
The advantage is its ease of use, ease of preparation of the programme, while the less qualified person may handle the programming and control of the machine after two hours of instruction learning.

Touch and go



Properties of the FF101 System

- 19"LCD touch screen colour monitor with the best graphics
- WINDOWS 8.1
- Graphics Mode
- graphical representation of bending sequences for the selected programme
- graphical display of the position of the material before bending
- verbal and graphical display steps
- correction of the profile by direct contact on the desired part of the profile
- each operator can have their own password to enter their library
- powerful diagnostics
- inserting a different angle corrections for various materials
- correction of the bending angle (suspension) for the entire programme or for each bending angle
- control of the size of the opening of the crushing beam for the entire programme or just some steps
- bending radius
- edging
- linked profiles
- extended length of the profile directly on the main screen
- a list of the bending sequence
- a possibility to draw the profile, measure angles and lengths, select the points in the line of bending and visual inspection before bending the profile thanks to the split screen
- USB connection to the conservation and loading programmes
- off-line programming from the office
- Search profiles by name, sketches profiles
- the ability to save more than 5,000 programmes in Memory
- optional programme names (names of profiles)
- languages??: English as a basis (other languages ??on request)

The FF101 control system provides for the control of d.c.motors.

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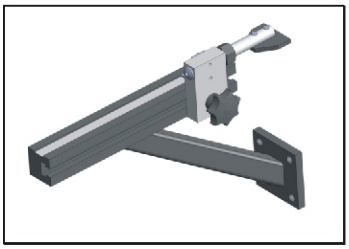
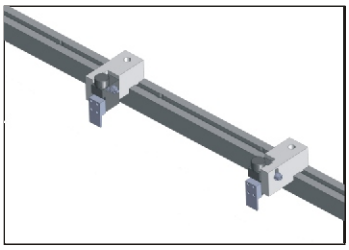
Front stop



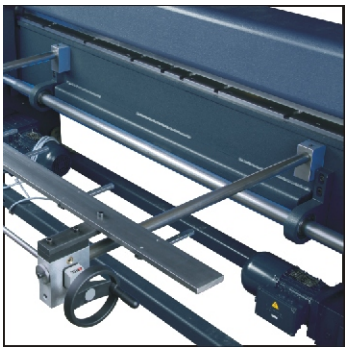
FSS
- hand-operated forward stop with metering, the length between 70mm and 300mm



FSP
- adjustable front stop with metering, length - 5mm to 300mm

Manual back gauge

A cost-effective solution for simple applications that do not require frequent readjustment. Hand stops are equipped with the rack - pinion system and the position indicator, which the operator can adjust



MPD
- manual back gauge with the transfer rack - pinion system and counter, complete with thumbs and grooves in the table
- range of motion of 10 mm - 760 mm, or 10mm - 1,000 mm or 10 mm - 1200 mm

MOD
- manual back gauge with the transfer rack pinion system, counter and stop rail
- range of motion of 80mm - 760mm, or 80mm - 1000mm or 80mm - 1200mm

Motorized back gauge

MZDJ
A simple motor back gauge that uses the rack - pinion transfer in conjunction with an electric motor. The stop is suitable for simple applications. It is supplied with thumbs for a range of motion 6 mm - 1000 mm.

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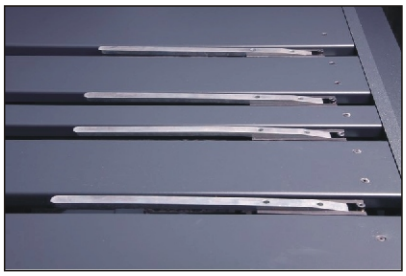
Motorized back gauge

MZD Motorized back gauge is used for positioning the material in the correct position without being held by the operator. The back gauge drive is provided by one or two ball screws and accurate control. The front abutment surface (fingers) are optional depending on the thickness of bent and customer requirements They can be supplied as folding fingers or swivel fingers made of spring steel.
The storage area of the back gauge can be equipped as needed by ball nests, side guides left or right. For engine with the MZD control the use of one of controls is required, CNC2A , CNC3A or FF101.



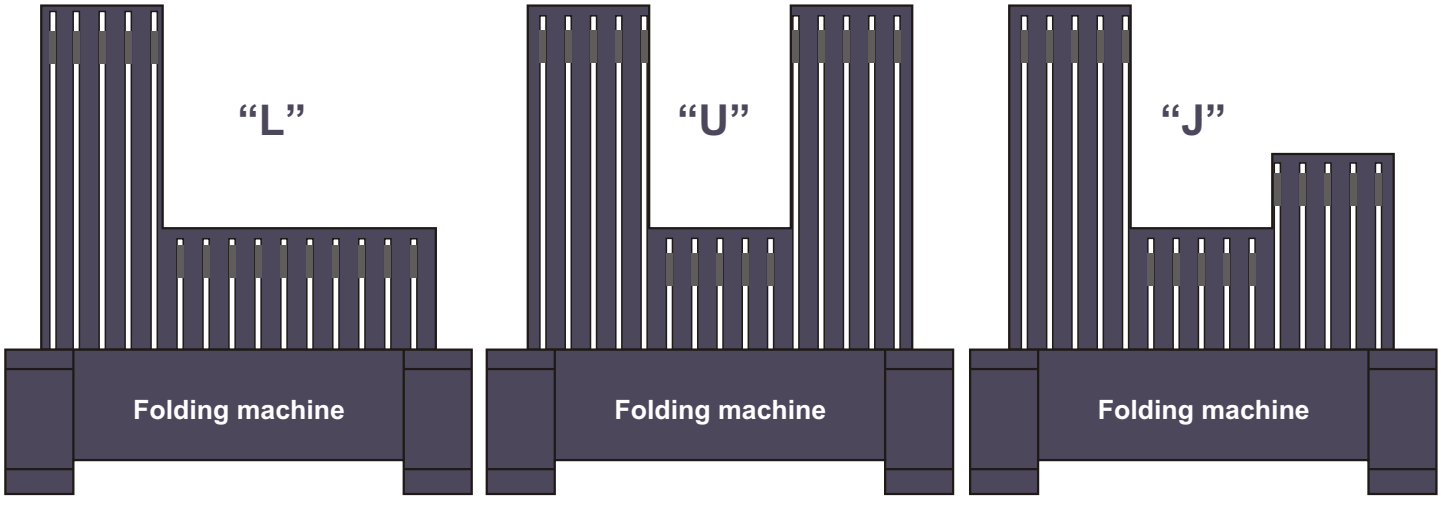
MZD SP

Motorized back gauge with standard folding fingers. Range of motion 6 to 1000mm (1500mm, 2000mm, 2500mm, 3000mm)

MZD OP

Motorized back gauge with turn fingers in steel plate. Range of motion 2 to 1000mm, 1500mm, 2000mm, 2500mm, 3000mm.

For handling large-size products such as panels, cabinets, etc. It is appropriate to use rear stops that allow for easy handling and attendance by the machine operator. There are stops of L, U and J types with multiple sections of pneumatically operated fingers.
These special stops are supplied according to the customer requirements in the length of max. 3000mm.



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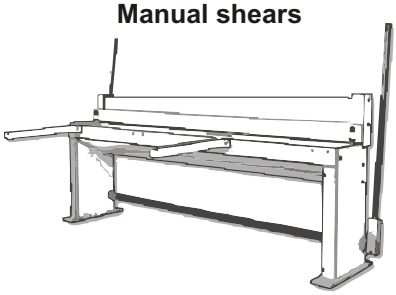
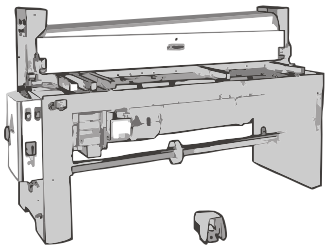
Production program

Manual shears



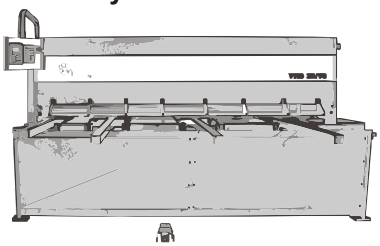
Maximum length: 3000 mm
Maximum sheet thickeness: 2,25 mm

Motorized shears



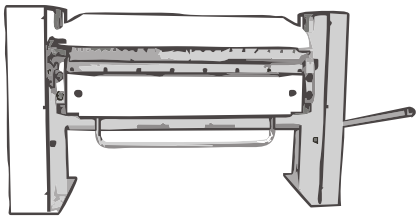
Maximum length: 4000 mm
Maximum sheet thickeness: 5,00 mm

Hydraulic shears



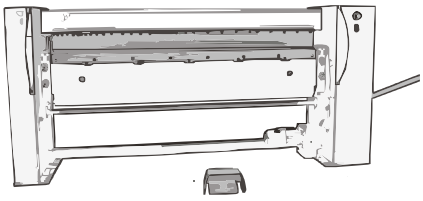
Maximum length: 4000 mm
Maximum sheet thickeness: 20,00 mm

Manual folding machines



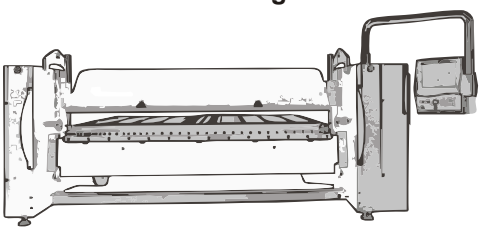
Maximum length: 4000 mm
Maximum sheet thickeness: 2,50 mm

Semimotorized folding machines



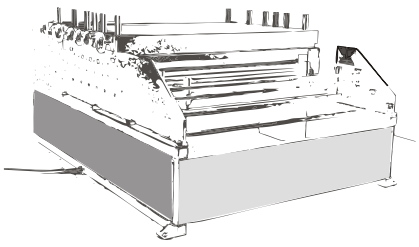
Maximum length: 4000 mm
Maximum sheet thickeness: 3,00 mm

Motorized folding machines



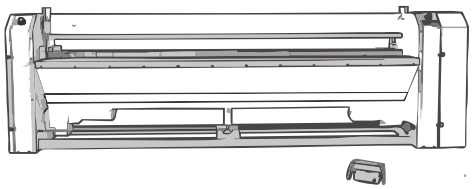
Maximum length: 5000 mm
Maximum sheet thickeness: 8,00 mm

Cut to length lines



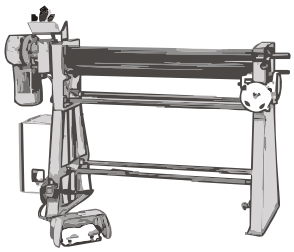
Maximum length: 1500 mm
Maximum sheet thickeness: 2,25 mm

Wrap Brake-tdc



Maximum length: 3000 mm
Maximum sheet thickeness: 1,50 mm

Bending machines



Maximum length: 1200 mm
Maximum sheet thickeness: 2,00 mm

H.M.Transtech spol. s.r.o
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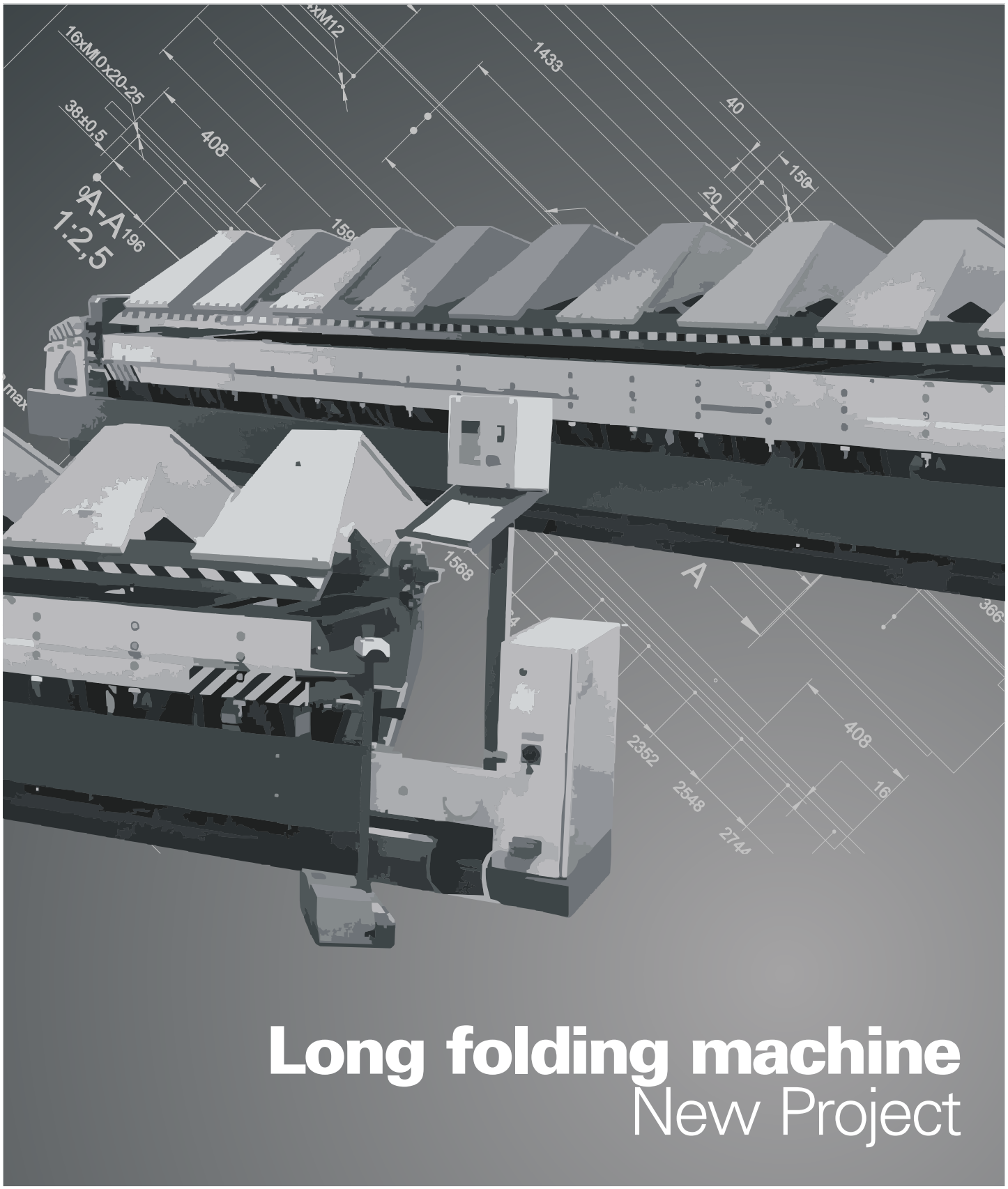
e-mail: sales@hmtranstech.com, www.hmtranstech.com
tel.: +421 51 7718 516, fax: +421 51 7716 056



Long folding machine
New Project

Producer reserves the right to change all specifications subject without notice.
For current information about our products visit www.hmtranstech.com

HMT PRODUCTION

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