



**SHEET METAL
WORKING
MACHINES**



MOTORIZED FOLDING MACHINES

AN INDIVIDUAL MACHINE FOR YOUR REQUEST



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Motorized and manual folding machines



Currently, the most popular machines for sheet metal folding are press brakes and folding machines. While folding with press brakes is mostly connected with serial manufacturing, folding machines are common for frequently changing production programmes (batch manufacturing) that do not require any change of tooling. The shape of the folding profile can be modified by simple reprogramming.

Other advantages of folding machines:

- the blank is placed on the back gauge table, which is an advantage, especially when folding large pieces easily handled by a single operator as for press brakes, there are two operators required;
- general folding tools no need to purchase special types of tooling for each kind of folding (reduced manufacturing time and need to invest);
- while folding, the contact with material possible only from the outer side of the piece being bent thus ensuring a precise bending angle required (material suspension).
- low set-up times for small batch
- fast folding cycles

The HMT product portfolio covers a wide range of manual, semimotorized and motorized folding machines processing sheet metal of 1,00 to 8,00 mm thickness and 1,0 m to 5,0 m length.

The modular concept allows for a wide range of different typical dimensions that may be customised as needed. Very successful are DUO models that allow one machine to work with blade and segments. There are different types of operating modes available, from manual, NC, CNC to graphical CNC. As for the backgauge selection, it is possible to choose from many different options covering the length of up to 3 m, using standard as well as special tooling etc.

Our modular system makes it possible to offer the machines that would fully meet the both, your technical needs and financial possibilities. Our customers that we have been supplying with machines since 1998 would surely confirm that.

It is a good reasons for a successful partnership.

Slavomila Lukčová

Slavomila Lukčová
Executive director

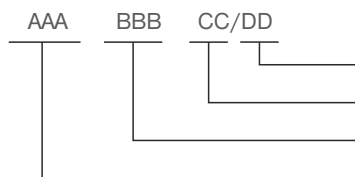
Table for selection of suitable folding machine:

Thickness sheet metal 400N/mm ²	Working length			
	1000mm	1250mm	1500mm	2000mm
1,00mm				STF
1,25mm				TF
1,5mm				SFM TFM
1,75mm			TFM	
2,00mm	STF	TFM STF	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 machines
 Semimotorized folding machines
 Motorized folding machines




Labeling of motorized folding machines :

Example: TVM 3SH 15/25



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

Standard colors:

-  RAL 7035
-  RAL 7016
-  RAL 3001

Customer colours for an extra charge.

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			
3220	25	30	35	40	45	50	75	100	150	200	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

Working length						Thickness sheet metal 400N/mm ²	
2500mm	3000mm		4000mm		4500mm		5000mm
		TFM		UNI SLF UNIM			1,00mm
	TFM	UNI					1,25mm
UNI SFM	SFM SLF UNIM			TSM			1,50mm
							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 machines  Semimotorized folding machines  Motorized folding machines



Semimotorized folding machines UNIM

UNIM, UNIMS, UNIMSH, UNIM2S, UNIM2SH, UNIM3S, UNIM3SH

A uniquely designed folding 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.

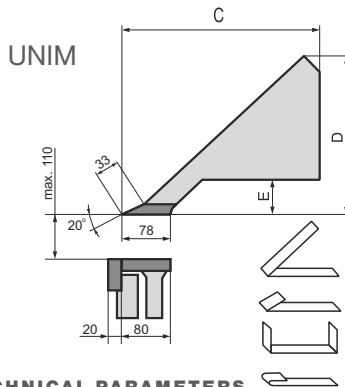
For easier alignment the sheet before folding, the machine may be equipped with a locking foot pedal for the clamping beam, which simplifies the work for the operator. For cutting thin sheet metal thickness up to 0,8mm, hand-operated rotary shears may be delivered. These machines are suitable for piece production, which in comparison with manual machines they achieve higher efficiency. They can be used in all industrial areas where one works with the material to 3,0mm thickness and 4m in length.

STANDARD EQUIPMENT:

- clamping beam is operated manually
- folding beam is motorized
- tools according type of machines (page 5)
- manual adjustment of one folding angle, type MA (page 21)
- manual crowning adjustment for folding beam
- foot switch
- locking lever of clamping beam
- 3x400V, 5 meter cable

SPECIAL EQUIPMENT:

- potentiometer for adjustment angle PT1 (page 21)
- touch control system NT1 (page 21)
- manual back gauge MOD, MPD (page 25)
- rotary shear up to material thickness 0,8mm
- blades and segments for stainless steel
- special shapes of blades and segments
- quick change segments
- marking segments with width in mm
- safety wire barrier
- extra foot switch (for 2. operator)
- tool cart
- power supply 3x230V
- customer colours



Work. length	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

For UNIM folding machines we recommend:
Motorized shears MLS

TECHNICAL PARAMETERS

Model	Working length mm	Max. sheet thickness steel 400N/mm ² mm	Max. sheet thickness stainless 600N/mm ² mm	Max. sheet thickness aluminium 275N/mm ² mm	Opening blade/segment mm	Motor of clamp./ folding beam kW	Length mm	Width mm	Height mm	Weight kg	
UNIM, UNIMS, UNIM2S UNIM SH, UNIM2SH UNIM3S, UNIM3SH	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	1,50*	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

* for stainless steel folding is needed to order hardened tools for stainless



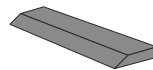
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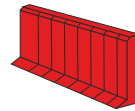


UNIM STANDARD TOOLS

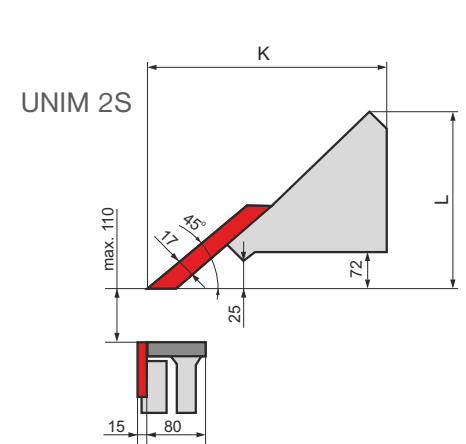
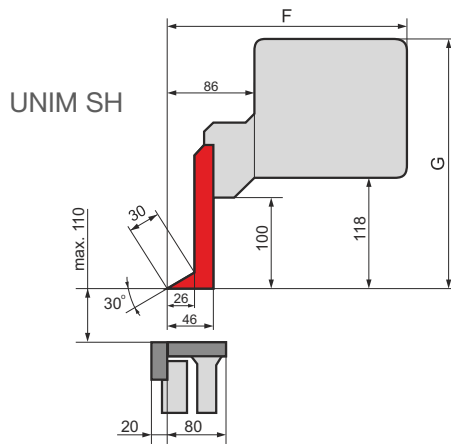
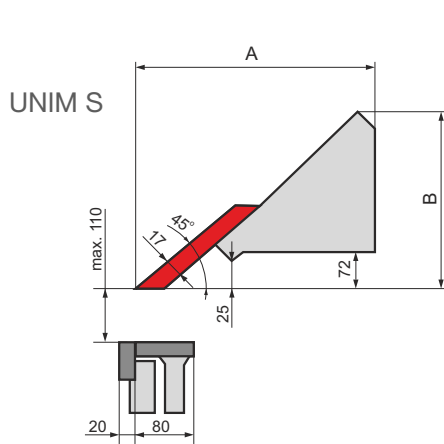
UNIM, UNIM S, UNIM SH, UNIM 2S, UNIM 2SH, UNIM 3S, UNIM 3SH



Gray tools - blades



Red tools - segments (divided blade)



Work. length	A	B
1000	360	335
1250	360	335
1500	360	335
2000	360	335
2500	370	340
3200	370	340
4000	370	340

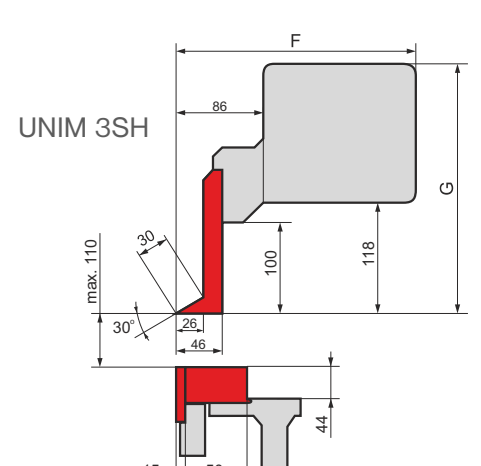
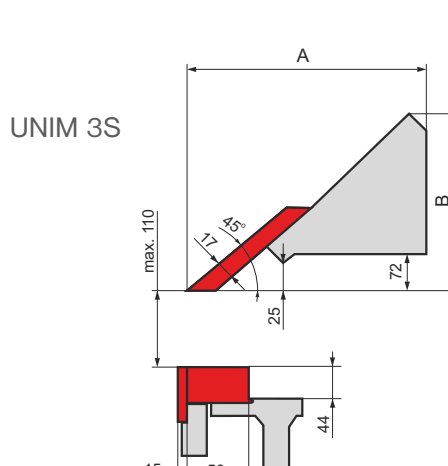
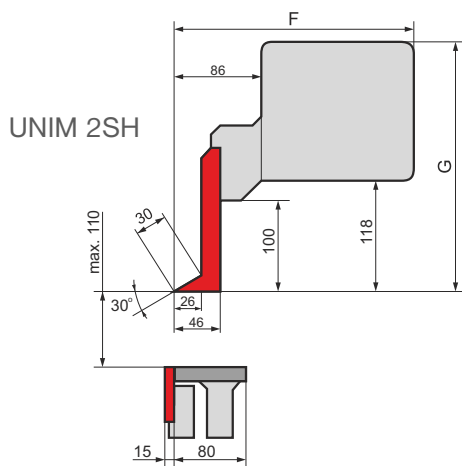
Dimensions of the beams are in mm

Work. length	F	G
1000	290	320
1250	290	320
1500	290	320
2000	290	320
2500	310	340
3200	310	340
4000	310	340

Dimensions of the beams are in mm

Work. length	K	L
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



Work. length	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

Work. length	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

Work. length	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



Motorized folding machines TFM

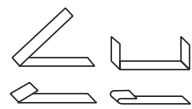
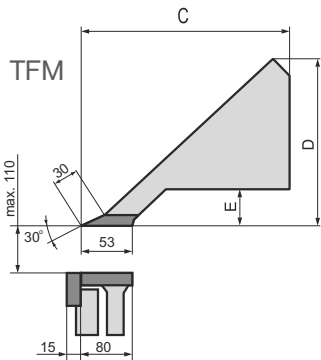
TFM, TFM S, TFM SH, TFM 3SH

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

Eccentric 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 folding 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.



Work. length	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

TECHNICAL PARAMETERS

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

STANDARD EQUIPMENT:

- tools according type of machines (page 7)
- manual adjustment of one folding angle, type MA (page 21)
- manual crowning adjustment for folding beam
- foot switch
- 3x400V, 5 meter cable

SPECIAL EQUIPMENT:

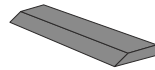
- potentiometer for adjustment angle PT1 (page 21)
- touch control system NT1 (page 21)
- touch control system NT3 (page 22) with motorized back gauge 1000mm (page 25)
- balls for back gauge
- squaring arm on right or left side for back gauge
- extension of back gauge (1500mm)
- manual back gauge MOD, MPD (page 25)
- blades and segments for stainless steel
- special shapes of blades and segments
- quick change segments
- marking segments with width in mm
- safety wire barrier
- extra foot switch (for 2. operator)
- tool cart
- power supply 3x230V
- customer colours
- welded frame for transport

For TFM folding machines we recommend:
Motorized shears MLS

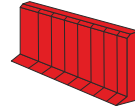
* for stainless steel folding is needed to order hardened tools for stainless

TFM STANDARD TOOLS

TFM, TFM S, TFM SH, TFM 3SH

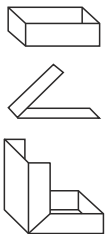
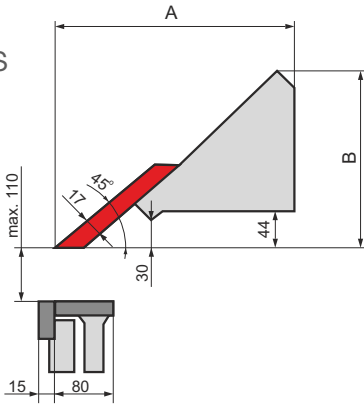


Gray tools - blades



Red tools - segments (divided blade)

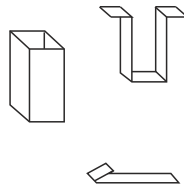
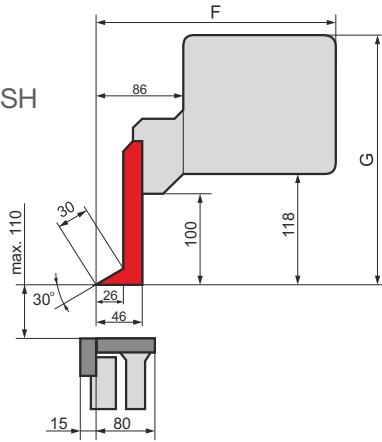
TFM S



Work. length	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

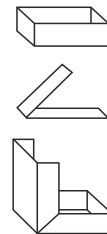
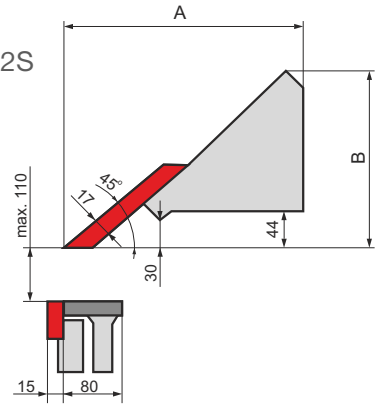
TFM SH



Work. length	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

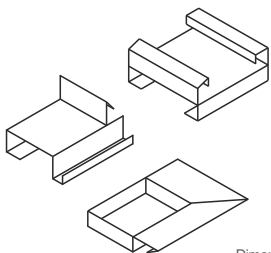
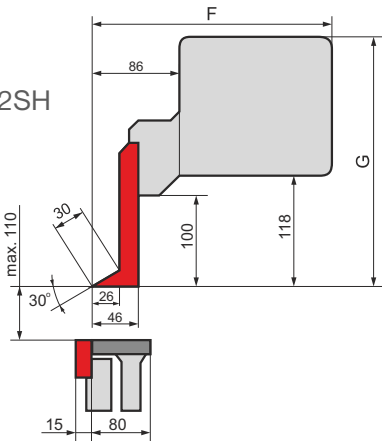
TFM 2S



Work. length	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

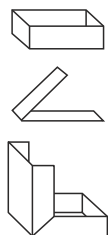
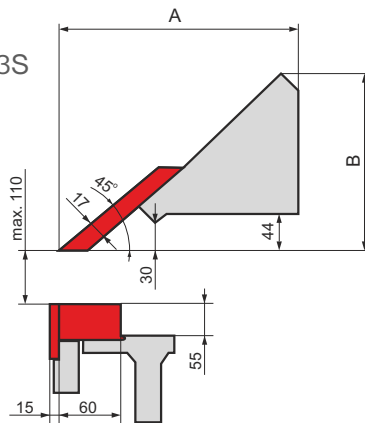
TFM 2SH



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

Dimensions of the beams are in mm

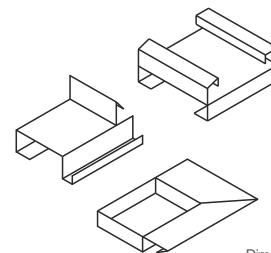
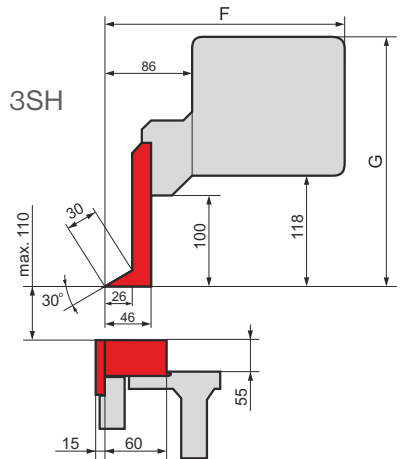
TFM 3S



Work. length	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 3SH



Work. length	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. *Dimensions are informative



Motorized folding machines SLF

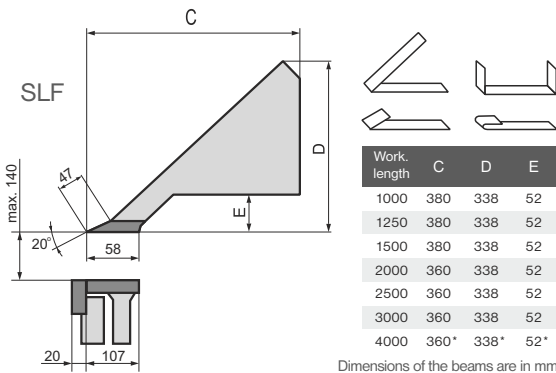
SLF, SLF S, SLF SH, SLF 2SH, SLF 3SH

Motorized folding 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.

Eccentric 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 folding beam shortens the time-cycle of the machine.

The folding beam is equipped with a crowning system bar, which allows to achieve the required accuracy over the entire length of the fold.

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.



STANDARD EQUIPMENT:

- tools according type of machines (page 9)
- manual adjustment of one folding angle, type MA (page 21)
- manual crowning adjustment for folding beam
- foot switch
- 3x400V, 5 meter cable

SPECIAL EQUIPMENT:

- potentiometer for adjustment angle PT1 (page 21)
- touch control system NT1 (page 21)
- touch control system NT3 (page 22) or FF-101 (page 23) with motorized back gauge 1000mm (page 25)
- touch control system FF-101 (page 23) with motorized back gauge for shape U, J, L and T (page 26)
- balls for back gauge
- squaring arm on right or left side for back gauge
- extension of back gauge (1500, 2000, 2500, 3000mm)
- manual back gauge MOD, MPD (page 25)
- blades and segments for stainless steel
- special shapes of blades and segments
- quick change segments
- marking segments with width in mm
- safety wire barrier
- extra foot switch (for 2. operator)
- tool cart
- power supply 3x230V
- customer colours
- welded frame for transport

For SLF folding machines we recommend:
Motorized shears MPS

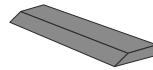
TECHNICAL PARAMETERS

Model	Working length mm	Max. sheet thickness steel 400N/mm ² mm	Max. sheet thickness stainless 600N/mm ² mm	Max. sheet thickness aluminium 275N/mm ² mm	Opening blade/segment mm	Motor of clamp./ folding beam kW	Length mm	Width mm	Height mm	Weight 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	1,75*	4,50	140	0,75/1,1	2200	800	1200	1470
	15/30	1520	3,00	1,75*	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

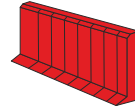
* for stainless steel folding is needed to order hardened tools for stainless

SLF STANDARD TOOLS

SLF, SLF S, SLF SH, SLF 3SH

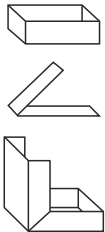
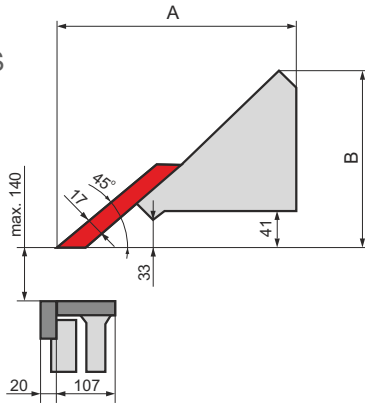


Gray tools - blades



Red tools - segments (divided blade)

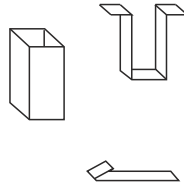
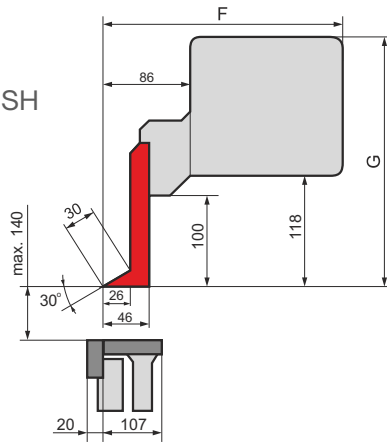
SLF S



Work. length	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

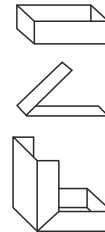
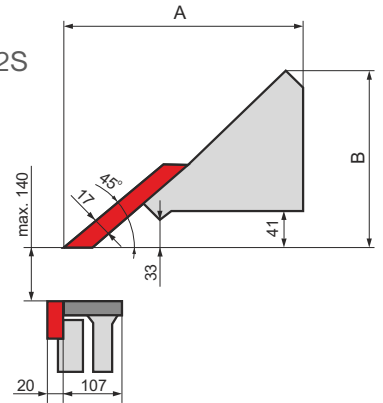
SLF SH



Work. length	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

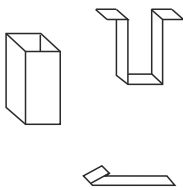
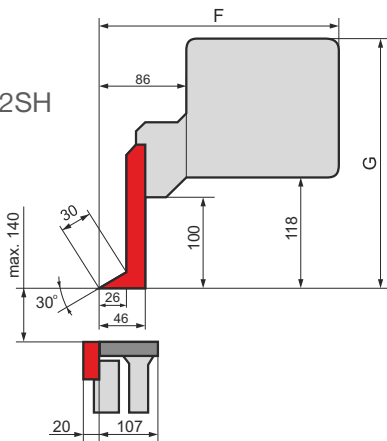
SLF 2S



Work. length	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

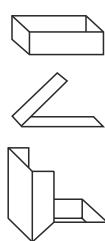
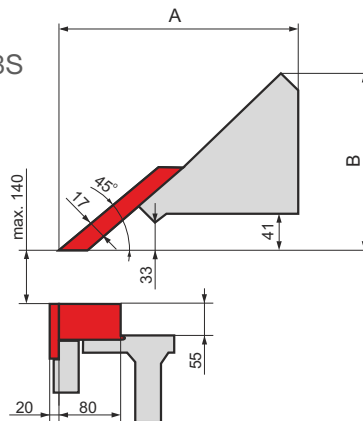
SLF 2SH



Work. length	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

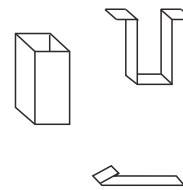
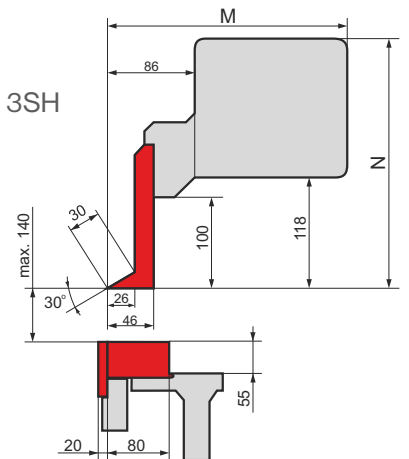
SLF 3S



Work. length	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 3SH



Work. length	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



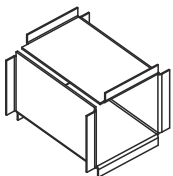
Motorized folding machines SFM

SFM, SFM S

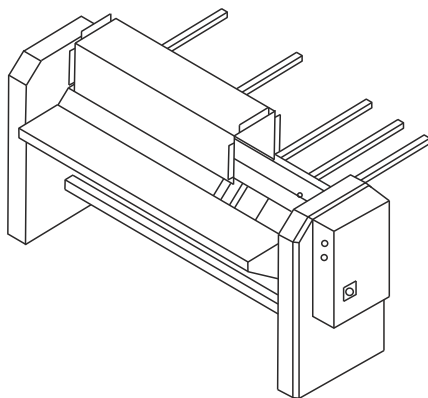
Motorized folding machines class SFM of solid welded construction are used to make square ventilation pipes and L-profiles with a TDC or TDF flange type. The maximum height of the flange is 35mm. The stop bar allows making the precise alignment of the position before folding the sheet metal of different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

The SFM folding machines offer the following designs:

- SFM • clamping blade is solid, folding and the bed blade are segmented
- SFM 3S • clamping bending and bed blades are segmented



Duct for TDC connection



STANDARD EQUIPMENT:

- blade of the clamping beam 80° or segments
- bed and folding segments
- front support table
- manual adjustment of one folding angle, type MA (page 21)
- foot switch
- 3x400V, 5 meter cable

SPECIAL EQUIPMENT:

- potentiometer for adjustment angle PT1 (page 21)
- touch control system NT1 (page 21)
- touch control system NT3 (page 22) with motorized back gauge 1000mm (page 25)
- balls for back gauge
- squaring arm on right or left side for back gauge
- extension of back gauge (1500, 2000, 2500, 3000mm)
- manual back gauge MOD, MPD (page 25)
- blades and segments for stainless steel
- special shapes of blades and segments
- quick change segments
- marking segments with width in mm
- safety wire barrier
- extra foot switch (for 2. operator)
- tool cart
- power supply 3x230V
- customer colours
- welded frame for transport

For SFM folding machines we recommend:
Motorized shears **MPS**

TECHNICAL PARAMETERS

Model	Working length mm	Max. sheet thickness steel 400N/mm ² mm	Max. sheet thickness stainless 600N/mm ² mm	Max. sheet thickness aluminium 275N/mm ² mm	Opening blade/segment mm	Motor of clamp./ folding beam kW	Length mm	Width mm	Height mm	Weight kg	
SFM SFM 3S	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

* for stainless steel folding is needed to order hardened tools for stainless



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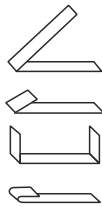
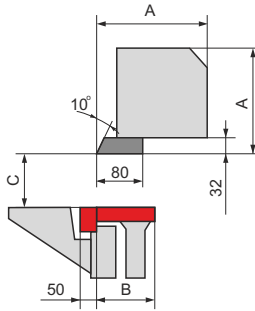
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SFM STANDARD TOOLS

SFM, SFM 3S

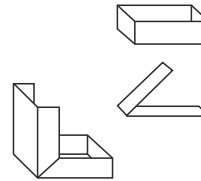
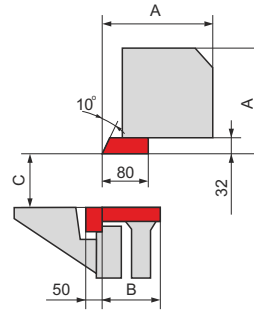
SFM



Work. length	A	B	C
2000	170	70	100
2500	220	80	140
3000	220	80	140

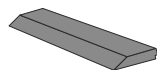
Dimensions of the beams are in mm

SFM 3S

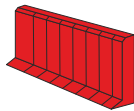


Work. length	A	B	C
2000	170	70	100
2500	220	80	140
3000	220	80	140

Dimensions of the beams are in mm



Gray tools - blades



Red tools - segments (divided blade)

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



Motorized folding machines TSM

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

Motorized folding 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 folding 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 folding 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.

STANDARD EQUIPMENT:

- tools according type of machines (page 13)
- manual adjustment of one folding angle, type MA (page 21)
- manual crowning adjustment for folding beam
- foot switch
- storage for blade (only for TSM DUO)
- 3x400V, 5 meter cable

SPECIAL EQUIPMENT:

- potentiometer for adjustment angle PT1 (page 21)
- touch control system NT1 (page 21)
- touch control system NT3, NT5 (page 22) or FF101 (page 23) with motorized back gauge 1000mm (page 25)
- touch control system FF-101 (page 23) with motorized back gauge for shape U, J, L and T (page 26)
- balls for back gauge
- squaring arm on right or left side for back gauge
- extension of back gauge (1500, 2000, 2500, 3000mm)
- manual back gauge MOD, MPD (page 25)
- blades and segments for stainless steel
- special shapes of blades and segments
- quick change segments
- marking segments with width in mm
- safety wire barrier
- extra foot switch (for 2. operator)
- tool cart
- power supply 3x230V
- customer colours
- welded frame for transport

For TSM folding machines we recommend:
Motorized shears **MPS** or **MPSH**

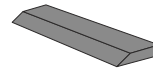
TECHNICAL PARAMETERS

Model	Working length mm	Max. sheet thickness steel 400N/mm ² mm	Max. sheet thickness stainless 600N/mm ² mm	Max. sheet thickness aluminium 275N/mm ² mm	Opening blade/segment mm	Motor of clamp./ folding beam kW	Length mm	Width mm	Height mm	Weight 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	1100	1560	2300
	15/35	1520	3,50	2,25*	4,75	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

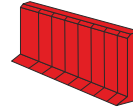
* for stainless steel folding is needed to order hardened tools for stainless

TSM STANDARD TOOLS

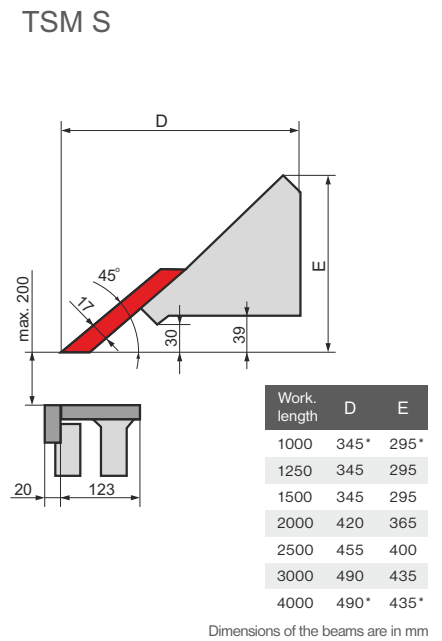
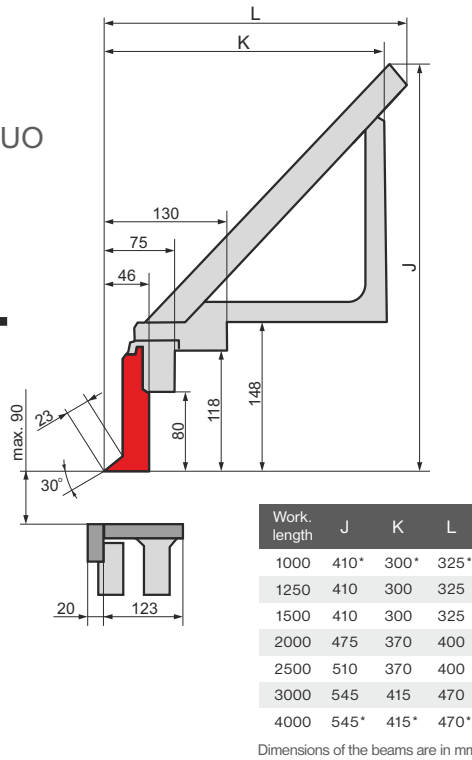
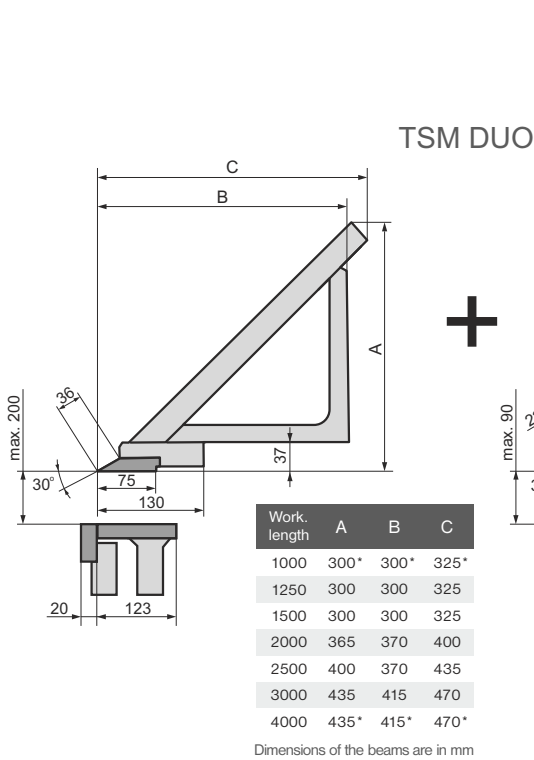
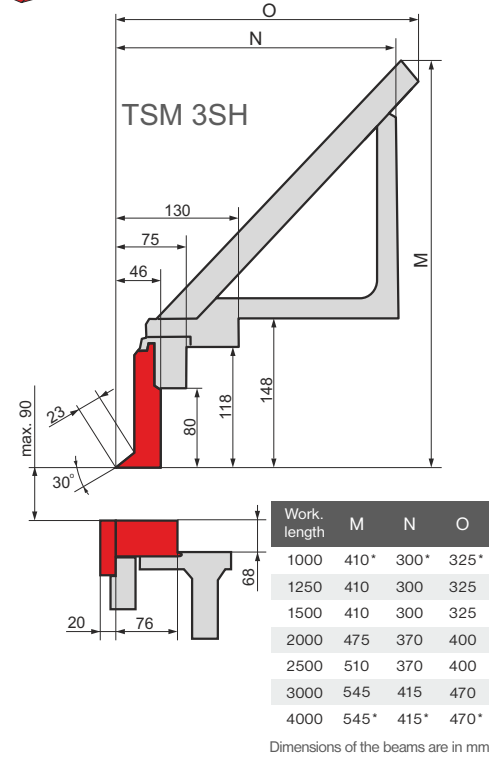
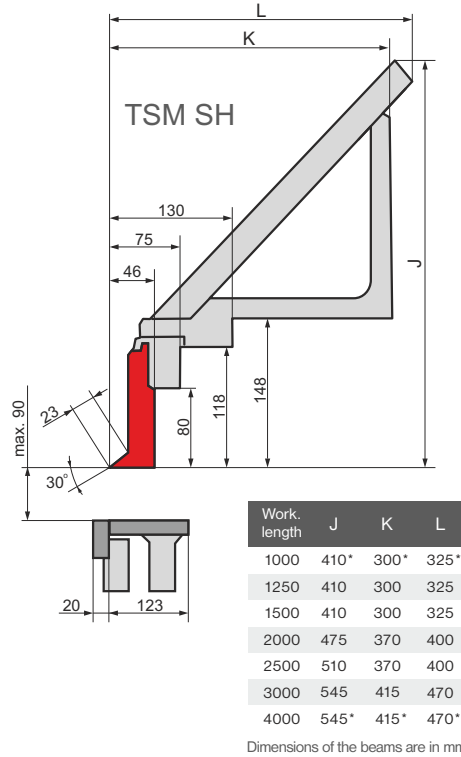
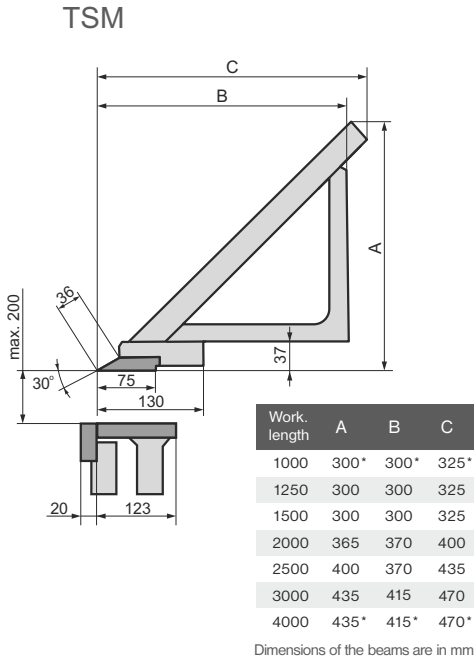
TSM, TSM SH, TSM 3SH, TSM DUO, TSM S



Gray tools - blades



Red tools - segments (divided blade)



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



Motorized folding machines TVM

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

Folding machines type TVM, as to the capacity belong among the high-end midrange products with folding 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 folding blade or segments with adjustable convexity (crowning system). The drive is provided by one or two motors (in the 4m length).

Adjustment of the folding 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:

- tools according type of machines (page 15)
- manual adjustment of one folding angle, type MA (page 21)
- manual crowning adjustment for folding beam
- foot switch
- storage for blade (only for TVM DUO)
- 3x400V, 5 meter cable

SPECIAL EQUIPMENT:

- potentiometer for adjustment angle PT1 (page 21)
- touch control system NT1 (page 21)
- touch control system NT3, NT5 (page 22) or FF101 (page 23) with motorized back gauge 1000mm (page 25)
- touch control system FF-101 (page 23) with motorized back gauge for shape U, J, L and T (page 26)
- balls for back gauge
- squaring arm on right or left side for back gauge
- extension of back gauge (1500, 2000, 2500, 3000mm)
- manual back gauge MOD, MPD (page 25)
- motorized adjustment of folding beam
- blades and segments for stainless steel
- special shapes of blades and segments
- quick change segments
- marking segments with width in mm
- safety wire barrier
- extra foot switch (for 2. operator)
- tool cart
- power supply 3x230V
- customer colours
- welded frame for transport

For TVM folding machines we recommend:
Motorized shears **MPS** or **MPSH**

TECHNICAL PARAMETERS

Model	Working length mm	Max. sheet thickness steel 400N/mm ² mm	Max. sheet thickness stainless 600N/mm ² mm	Max. sheet thickness aluminium 275N/mm ² mm	Opening blade/segment mm	Motor of clamp./ folding beam kW	Length mm	Width mm	Height mm	Weight 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*	5,00	200/90	1,10/4,0	3120	1150	1660	3900
	25/35	2520	3,50	2,20*	4,75	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

* for stainless steel folding is needed to order hardened tools for stainless



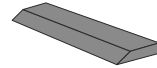
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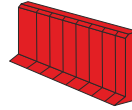


TVM STANDARD TOOLS

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

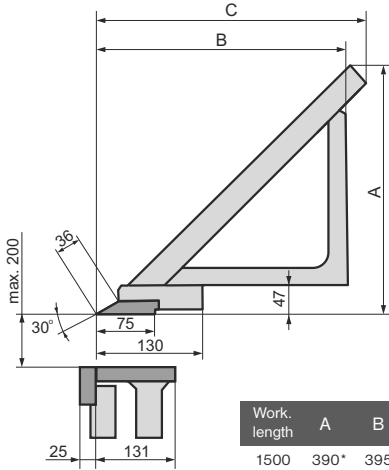


Gray tools - blades



Red tools - segments (divided blade)

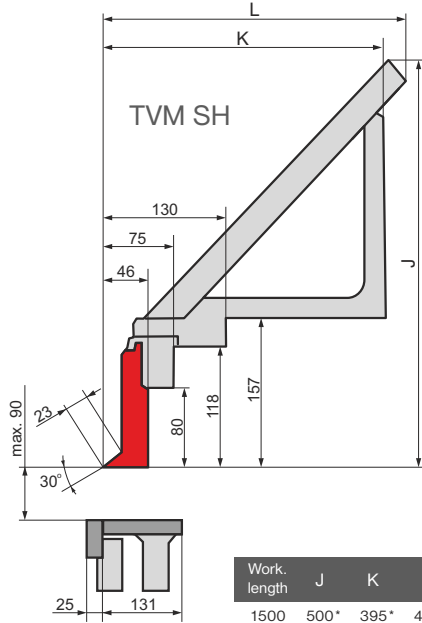
TVM



Work. length	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

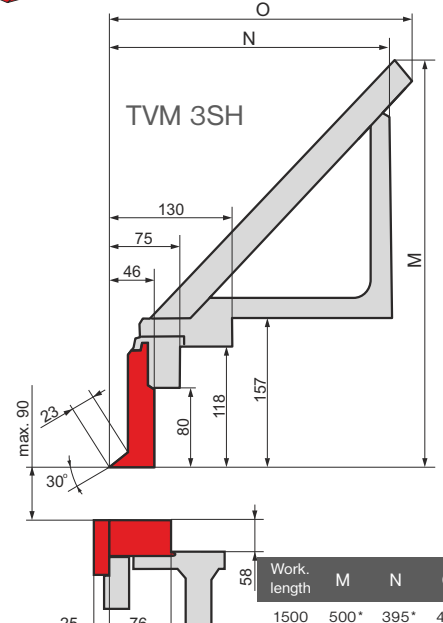
TVM SH



Work. length	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

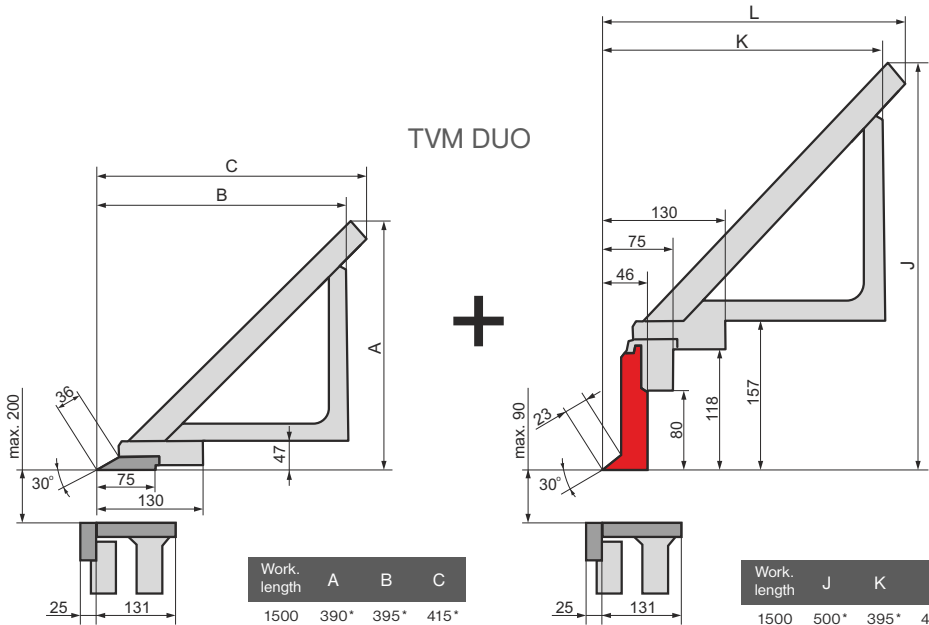
TVM 3SH



Work. length	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



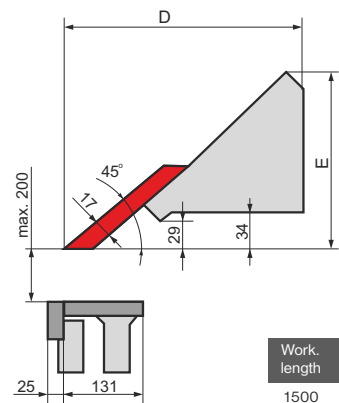
Work. length	A	B	C
1500	390*	395*	415*
2000	390	395	415
2500	460	445	485
3000	460	445	485
4000	485	470	510

Dimensions of the beams are in mm

Work. length	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



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

Dimensions of the beams are in mm

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



Motorized folding machines MAXI

MAXI, MAXI SH, MAXI 3SH, MAXI DUO

Folding machines type MAXI are among the best performing ones in terms of capacity resources when folding 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 folding 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 folding 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/mm²). 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 folding various types of raw materials, especially stainless steel products.

STANDARD EQUIPMENT:

- tools according type of machines (page 17)
- hardened tools material for stainless
- manual adjustment of one folding angle, type MA (page 21)
- manual crowning adjustment for folding beam
- foot switch
- storage for blade (only for MAXI DUO)
- 3x400V, 5 meter cable

SPECIAL EQUIPMENT:

- potentiometer for adjustment angle PT1 (page 21)
- touch control system NT1 (page 21)
- touch control system NT3, NT5 (page 22) or FF101 (page 23) with motorized back gauge 1000mm (page 25)
- touch control system FF-101 (page 23) with motorized back gauge for shape U, J, L and T (page 26)
- balls for back gauge
- squaring arm on right or left side for back gauge
- extension of back gauge (1500, 2000, 2500, 3000mm)
- manual back gauge MOD, MPD (page 25)
- motorized adjustment of folding beam
- special shapes of blades and segments
- quick change segments
- marking segments with width in mm
- safety wire barrier or light barrier
- extra foot switch (for 2. operator)
- tool cart
- power supply 3x230V
- customer colours
- welded frame for transport

For MAXI folding machines we recommend:
Motorized shears **TKS** or **THS**

TECHNICAL PARAMETERS

Model		Working length mm	Max. sheet thickness steel 400N/mm ² mm	Max. sheet thickness stainless 600N/mm ² mm	Max. sheet thickness aluminium 275N/mm ² mm	Opening blade/segment mm	Motor of clamp./ folding beam kW	Length mm	Width mm	Height mm	Weight 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



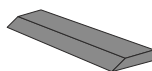
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Volgogradská 13/B, 080 01 Prešov, Slovakia
tel.: +421 51 7718 516
e-mail: sales@hmtranstech.com



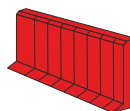
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MAXI STANDARD TOOLS

MAXI, MAXI SH, MAXI 3SH, MAXI DUO

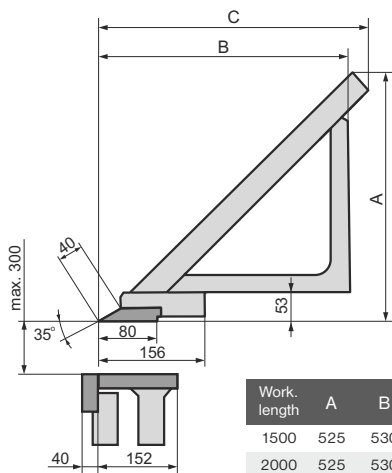


Gray tools - blades



Red tools - segments (divided blade)

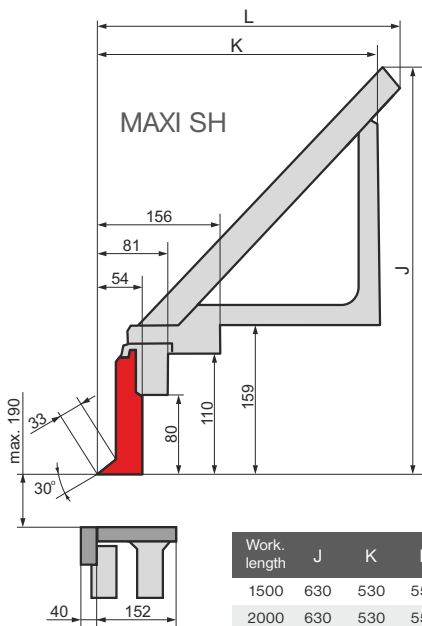
MAXI



Work. length	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

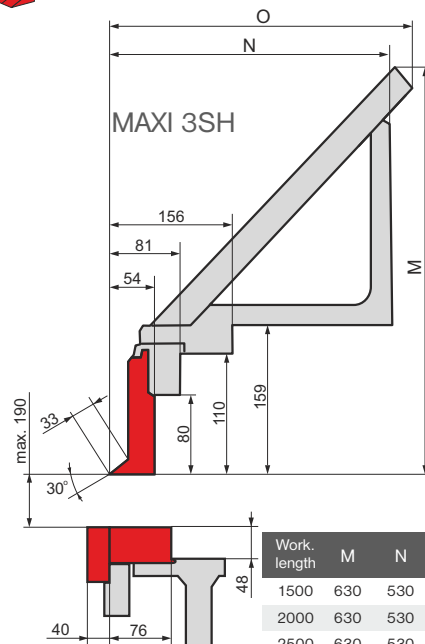
MAXI SH



Work. length	J	K	L
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

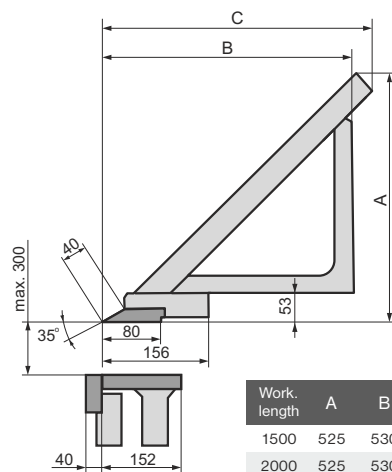
MAXI 3SH



Work. length	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

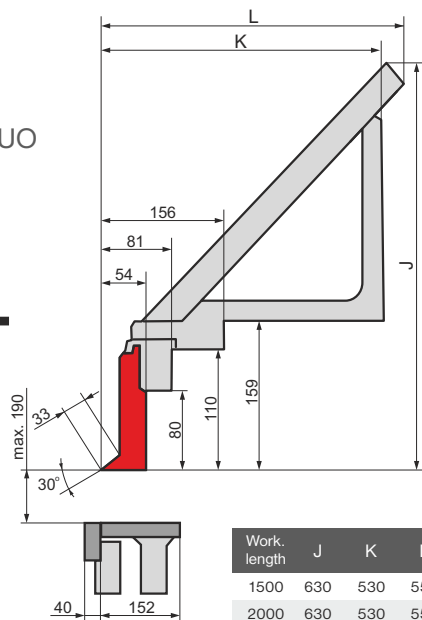
Dimensions of the beams are in mm

MAXI DUO



Work. length	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



Work. length	J	K	L
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

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



Motorized folding machines MAXI PLUS

MAXI PLUS, MAXI PLUS SH, MAXI PLUS 3SH, MAXI PLUS DUO

Motorized folding machines 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 folding 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/mm²) 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 folding 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 blades) of high strength steel (1100N/mm²). The version DUO provides a wide range of possibilities and the appropriate control system increases flexibility and productivity. It is suitable for folding various types of thick materials, especially stainless steel products.

STANDARD EQUIPMENT:

- tools according type of machines (see page 19)
- hardened tools material for stainless
- touch control system NT1 (see page 21)
- manual crowning adjustment for folding beam
- foot switch
- storage for blade (only for MAXI PLUS DUO)
- 3x400V, 5 meter cable

SPECIAL EQUIPMENT:

- touch control system NT3, NT5 (page 22) or FF101 (page 23) with motorized back gauge 1000mm (page 25)
- touch control system FF-101 (page 23) with motorized back gauge for shape U, J, L and T (page 26)
- balls for back gauge
- squaring arm on right or left side for back gauge
- extension of back gauge (1500, 2000, 2500, 3000mm)
- manual back gauge MOD, MPD (see page 25)
- motorized adjustment of folding beam
- special shapes of blades and segments
- quick change segments
- marking segments with width in mm
- safety wire barrier or light barrier
- extra foot switch (for 2. operator)
- tool cart
- power supply 3x230V
- customer colours
- welded frame for transport

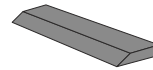
For **MAXI PLUS** folding machines we recommend:
Motorized shears **TKS** or **THS**

TECHNICAL PARAMETERS

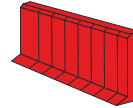
Model	Working length mm	Max. sheet thickness steel 400N/mm ² mm	Max. sheet thickness stainless 600N/mm ² mm	Max. sheet thickness aluminium 275N/mm ² mm	Opening blade/segment mm	Motor of clamp./ folding beam kW	Length mm	Width mm	Height mm	Weight kg	
MAXI PLUS MAXI PLUS SH MAXI PLUS DUO	20/80	2020	8,00	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

MAXI PLUS STANDARD TOOLS

MAXI PLUS, MAXI PLUS SH, MAXI PLUS 3SH, MAXI PLUS DUO

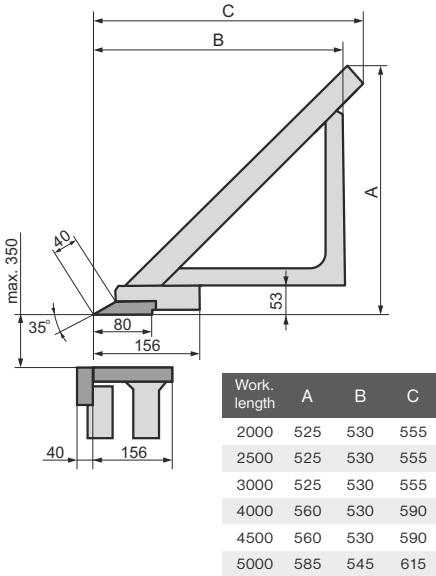


Gray tools - blades



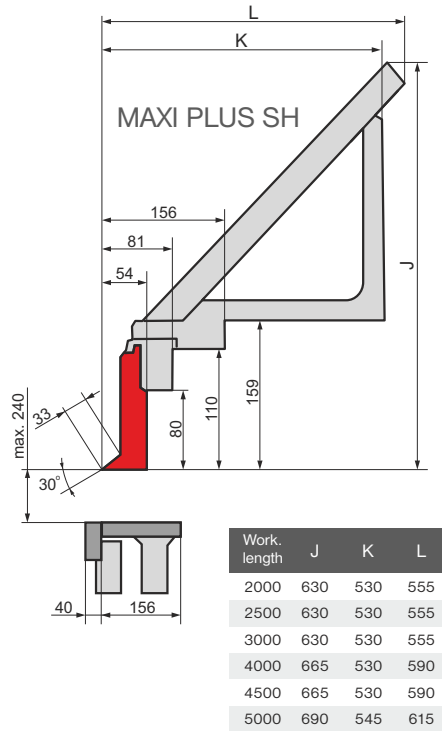
Red tools - segments (divided blade)

MAXI PLUS



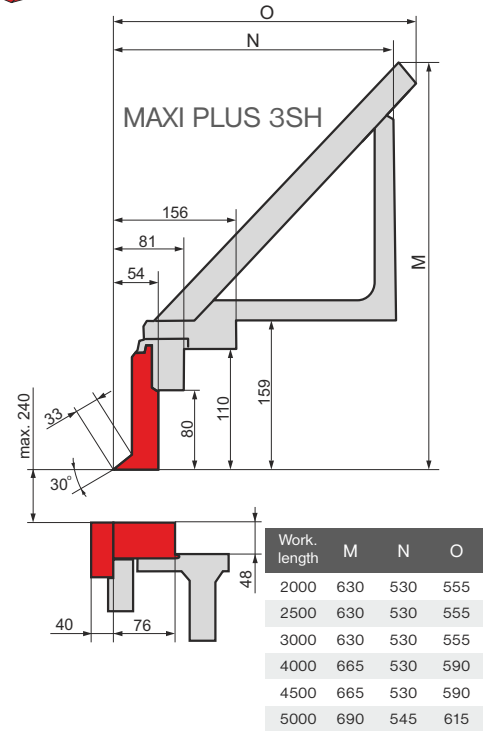
Dimensions of the beams are in mm

MAXI PLUS SH



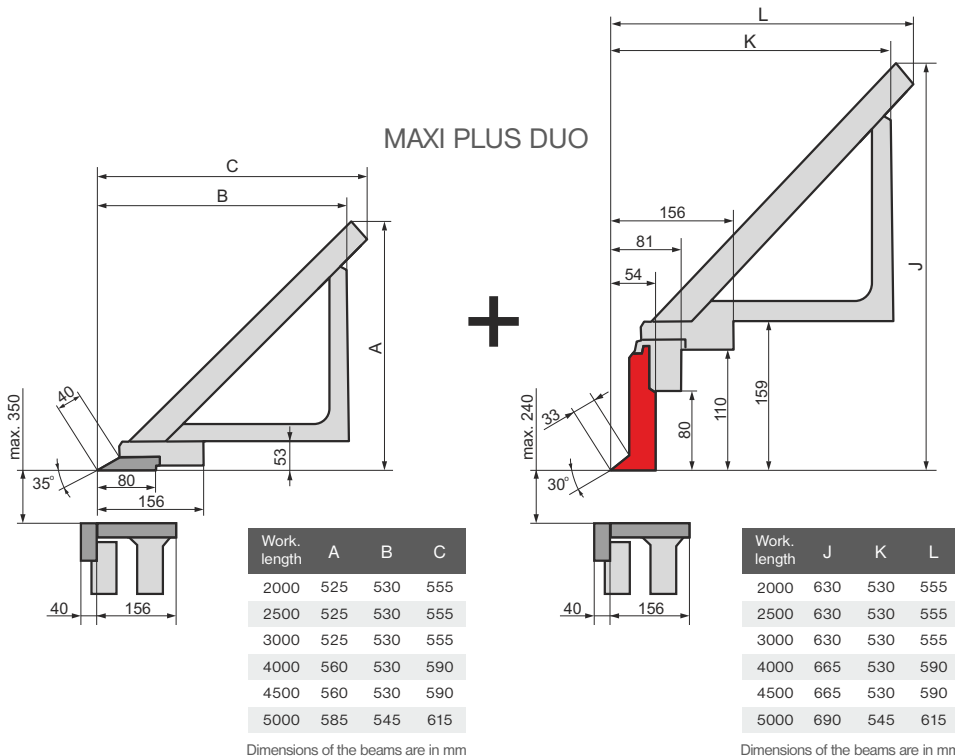
Dimensions of the beams are in mm

MAXI PLUS 3SH



Dimensions of the beams are in mm

MAXI PLUS DUO

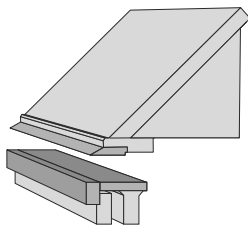


Dimensions of the beams are in mm

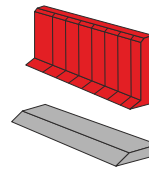
Dimensions of the beams are in mm

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

Standard tools



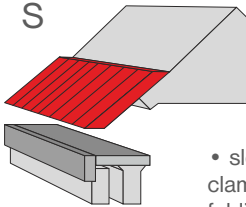
no letter • blades on all three beams



Red tools • segments

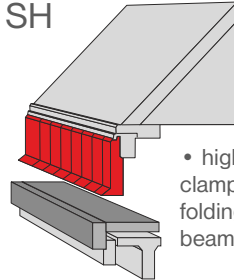
Gray tools • blades

S



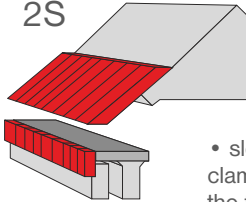
• sloping segments 45° on the clamping beam, blade on the folding beam and on the bed beam

SH



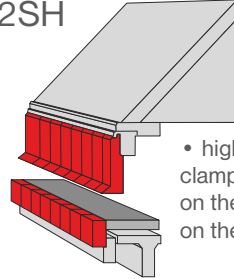
• high segments on the clamping beam, blade on the folding beam and the bed beam

2S



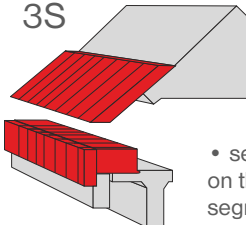
• sloping segments 45° on the clamping beam, segments on the folding beam, the blade on the bed beam

2SH



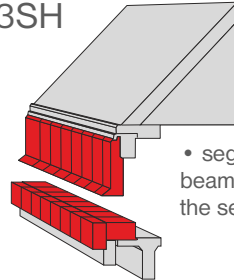
• high segments on the clamping beam, the segments on the folding beam, the blade on the bed beam

3S



• segments on all three beams, on the clamping beam the segments are sloping

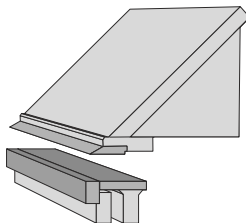
3SH



• segments on all three beams, on the clamping beam the segments are high

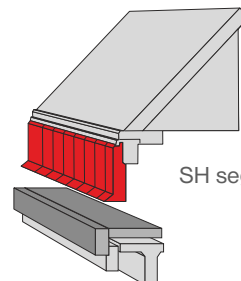
DUO

Blade



clamping beam with blade

or



SH segments

the same clamping beam with SH segments

Contains one clamping beam with a rail or SH segments. The machine operator changes only the tool on the same beam. Duo system is available only for machines TSM, TVM, MAXI and MAXI plus.

Control systems

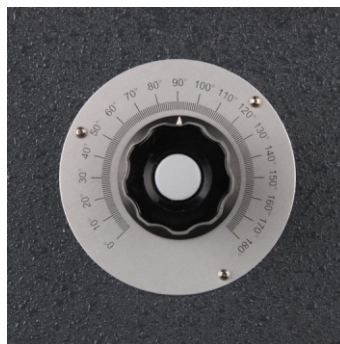
MA, PT-1

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 folding angle under the name MA, except for the MAXI PLUS machine in which the standard is control system NT1. 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

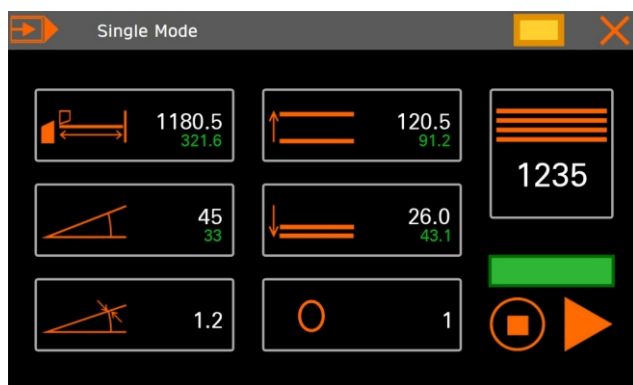


PT-1

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

Control systems

NT1, NT3, NT5

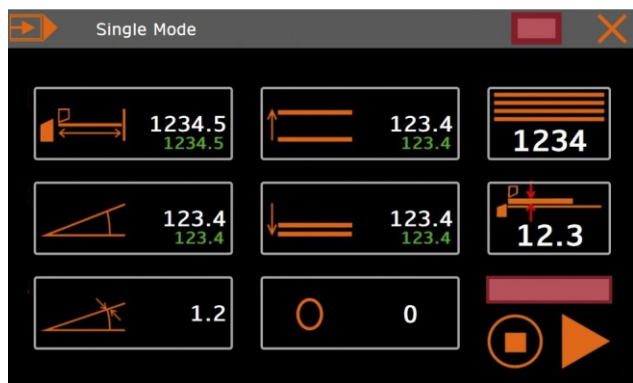


NT1 (Schneider) – one axis control

- 7" colour touch screen
- user-friendly and intuitive operation mainly via icon menu
- entering of the folding angle and correction
- only control system without back gauge
- profile programming with memory for 49 profiles, each with 20 folds
- possibility to extend control with simple steps to 3-axis NT3 control without the need for control system change
- cooperation also with servodrives
- jog mode, manual control of one axis
- profile names (both verbally and numerically)
- work with profiles as well as individual steps in the profile (deleting, inserting steps)
- backup profiles to USB stick

Control systems

NT1, NT3, NT5

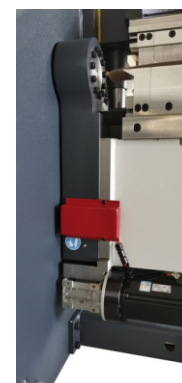
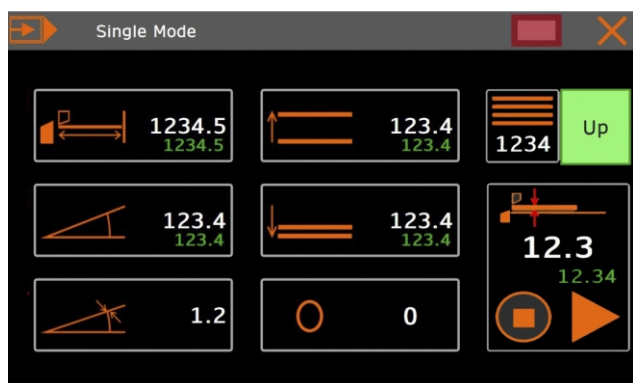


NT3 (Schneider) – three axis control

- 7" colour touch screen
- user-friendly and intuitive operation mainly via icon menu
- entering position of the back gauge, folding angle and correction, position of the clamping beam
- profile programming with memory for 49 profiles, each with 20 folds
- radius function
- hemming function (closed, open or teardrop)
- cooperation also with servodrives in three axes
- jog mode, manual control of three axis
- profile names (both verbally and numerically)
- work with profiles as well as individual steps in the profile (deleting, inserting steps)
- backup profiles to USB stick



Video of control system NT3



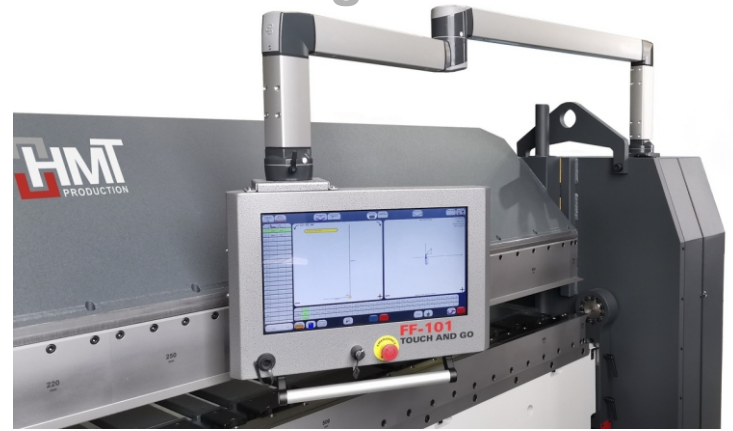
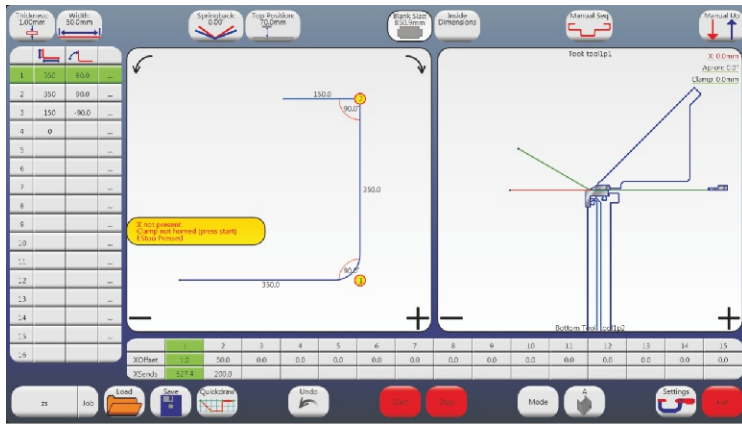
NT5 (Schneider) – five axis control

- 7" colour touch screen
- user-friendly and intuitive operation mainly via icon menu
- entering position of the back gauge, folding angle and correction, position of the clamping beam
- control motorized movement of position folding beam depending on thickness of material
- profile programming with memory for 49 profiles, each with 20 folds
- radius function
- hemming function (closed, open or teardrop)
- cooperation also with servodrives in five axes
- jog mode, manual control of all axis
- profile names (both verbally and numerically)
- work with profiles as well as individual steps in the profile (deleting, inserting steps)
- backup profiles to USB stick

Control systems

FF101

Touch and go



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.

PROPERTIES OF THE FF101 SYSTEM:

- 21,5"LCD touch screen colour monitor
- newest Microsoft Windows
- 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 clamping 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 and change angles and lengths, select the points in the line of folding and visual inspection before folding 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.



YouTube

Video of control system FF-101



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e-mail: sales@hmtranstech.com



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Control system

Standard position



The standard position of the control panel

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



Control panel on the console

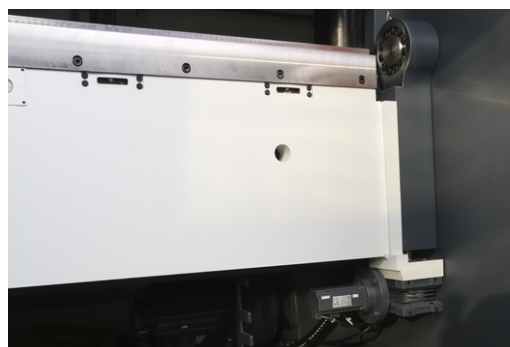
- suitable for lengths over 2 m (optional)
- positioning of control system according to the needs of machine operator
- optional for control systems NT1, NT3, NT5 and standard for FF-101

Adjustment of folding beam



Manual adjustment of folding beam

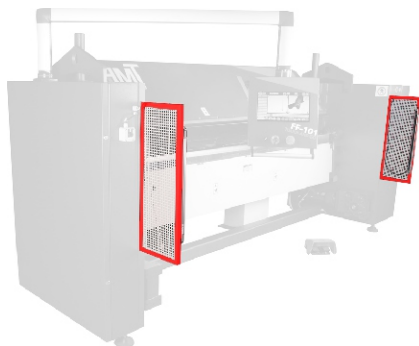
- change position of folding beam by the adjustment screw
- cost-effective solution, suitable for operations when it is not often change the position of folding beam



Motorized adjustment of folding beam

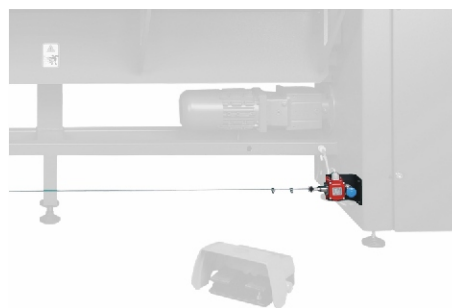
- change position of folding beam by the motors
- speeds up work with different thicknesses of material
- available for TVM, MAXI a MAXI PLUS model with control system NT5

Extra safety systems



Safety light barrier

- machine automatically stops if person moves into the safety area of the machine
- with control system FF101 as special equipment for everyone machine

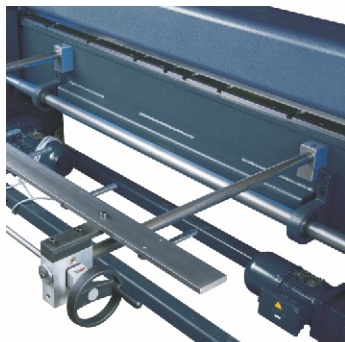


Safety wire barrier

- security wire attached under folding beams
- folding beam will be stop immediatly after operator touch the wire

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

Standard full table



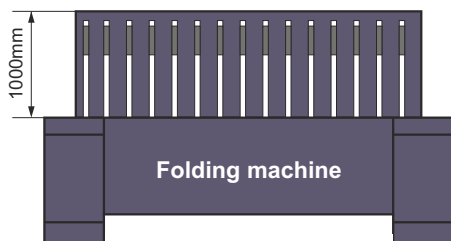
MZD

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 fold and customer requirements They can be supplied as folding fingers or twisted 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 machines with the MZD is use of one of controls is required NT3, NT5 or FF 101.

Standard back gauge with 1m range, machine operated only from front side.

Range 1,5m, 2m, 2,5m and 3m as special accesories.



MZD SP

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



MZD OP

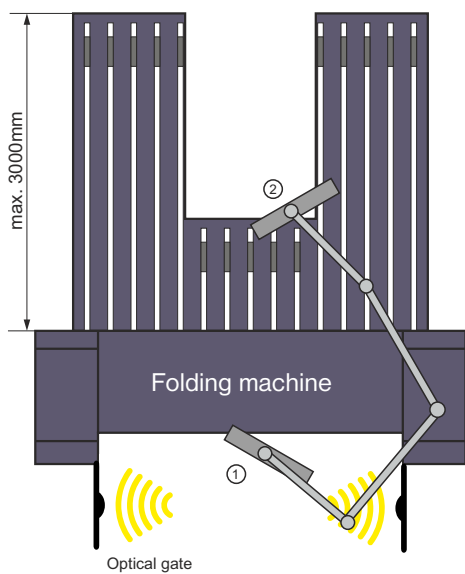
Motorized back gauge with twisted steel plate fingers. Range of motion 2 to 1000mm, 1500mm, 2000mm, 2500mm, 3000mm.

Motorized back gauge

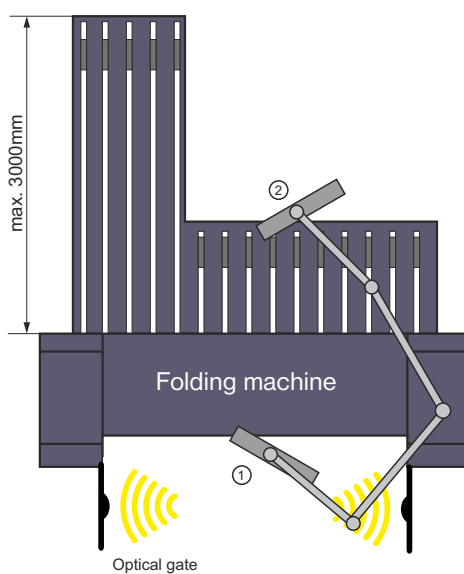
U, L, J, T shape

For handling large-size products such as panels, cabinets, etc. It is appropriate to use back gauges 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. Motorized back gauge U, L, J, T shape are delivered only with FF101 control system, with front optical safety system and two possible operation position (front and rear).

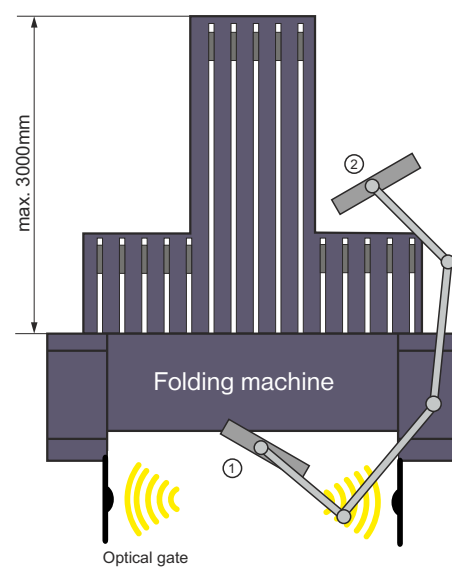
U shape



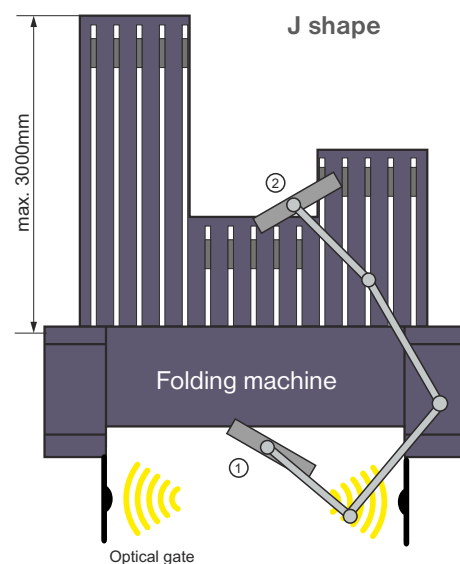
L shape



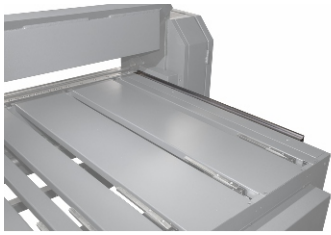
T shape



J shape

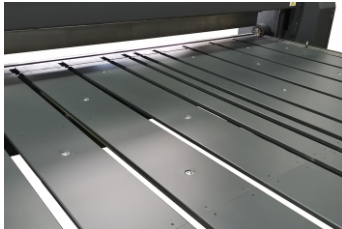


Back gauge J shape, with two sections and motorized folding machine Maxi 30/40 DUO FF-101



Squaring arm (for motorized back gauge)

- mounted on the right, left or both side of the back gauge
- as special accessories



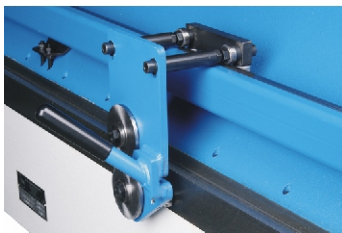
Balls or brush for back gauges

- integrated ball or brush for easy transfer folding material



Foot pedal

- two control pedals with function " STOP production"
- as standard equipment for all machines
- for machines 4m and longer second pedals as standard equipment



Rotary shear K0,8

- rotary shear up to material 400Mpa and thickness 0,8mm
- after lock clamping beam easy manually cut material
- as special equipment only for UNI and UNIM machine with blade on all three beams



Marking of segments

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



Tool cart

- allows organized storage segments in the case of frequent replacement
- the cart is portable on wheel



Welded frame for transport

- we recommend for transport folding machine with motorized back gauge as one unit on metal pallet with additional price
- simplifies manipulation the machine during transport and installation

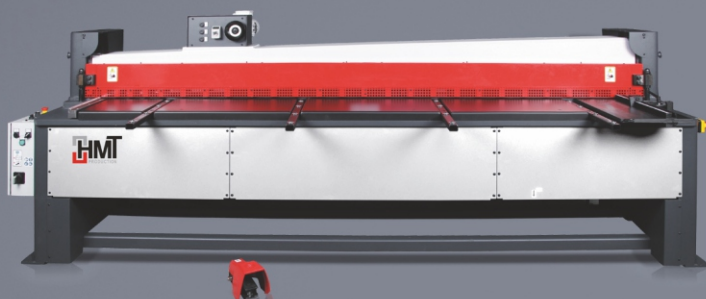
PRODUCTION PROGRAM:



MOTORIZED FOLDING MACHINES



MANUAL MACHINES



MOTORIZED SHEARS



HYDRAULIC SHEARS



CUT TO LENGTH LINES



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