



*PRECISE PROFILES*

***biegemaster***

LONG FOLDING MACHINES  
DOUBLE BENDING MACHINES

## ***LONG FOLDING MACHINE MODEL BM*** ***FLEXES TO YOUR REQUIREMENTS***

Can easily fold all common profiles with a bending length between 3 and 15 metres (10 - 50 ft.) and a **material thickness of up to 1.5 mm (14 gauge) of steel**. High level of precision and folding accuracy. Stands and tension arms made of high-tensile spheroidal cast iron.





## DETAILS



### Optimum clamping beam geometry

The special shape of the clamping beams enables a maximum bending angle of 145° while leaving a lot of free space inside the machine.



### Electronic back gauge

Motor-driven using a timing belt. Automatic positioning of the metal sheets. Variably adjustable back gauge fingers. Also available in conical design.



### Solid cutting equipment

Manual or electric design with a cutting capacity of up to 1.5 mm (14 gg). Fitting it on the clamping beam eliminates constraining contours or force effects on the bending beam. A maintenance-free timing belt drives the unit.



### Hydraulic bending units

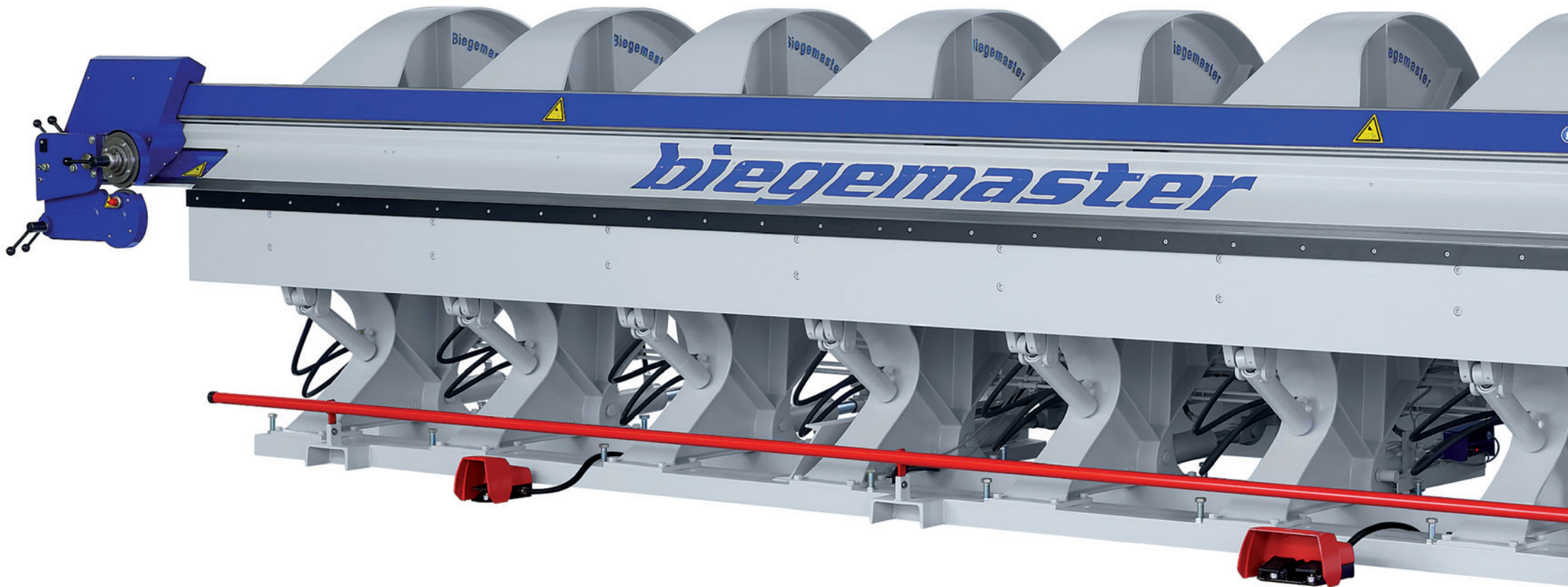
Each set of stand / tension arm is equipped with a hydraulically driven bending unit. Robust, sturdy construction for uniform bending forces along the full length.



## ***LONG FOLDING MACHINE MODEL BS***

### *SMART DESIGN FOR PRECISE RESULTS*

Can easily fold all common profiles with a bending length of 3 -15 m (10 - 50 ft.) and a **material thickness of up to 3 mm (9 gauge) of steel**. High level of precision and folding accuracy. Stands and tension arms made of high-tensile spheroidal cast iron.





## DETAILS



### Electronic back gauge

Motor-driven using a timing belt. Automatic positioning of the metal sheets. Variably adjustable back gauge fingers. Also available in conical design.



### Hydraulic bending units

Each set of stand / tension arm is equipped with a hydraulically driven bending unit. Robust, sturdy construction for uniform bending forces along the full length.



### Optimum clamping beam geometry

The special shape of the clamping beams enables a maximum bending angle of 145° while leaving a lot of free space inside the machine.



### Solid cutting equipment

Electric shear with a cutting capacity of up to 3 mm (9 gg). Fitting it on the clamping beam eliminates constraining contours or force effects on the bending beam. A maintenance-free timing belt drives the unit.



### Hydraulically adjusted clamping beams

The machine is equipped with a hydraulic device (air gap adjustment) for adjusting the clamping beams to balance different types of metal thickness.



**DOUBLE BENDING MACHINE XB**  
FOR TOP PERFORMANCE  
IN SERIES PRODUCTION





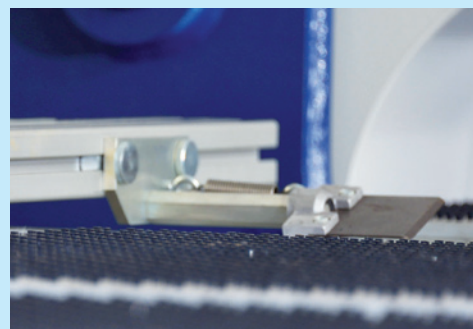
Double bending machine XB for profiles of 4+ metres of bending length with a **material thickness of up to 2.0 mm (12 gauge) of steel**. The machine is characterised by ease of operation and intuitive control. Jobs can be performed with high productivity and very easy handling. This is what profitable metal processing looks like.

## DETAILS



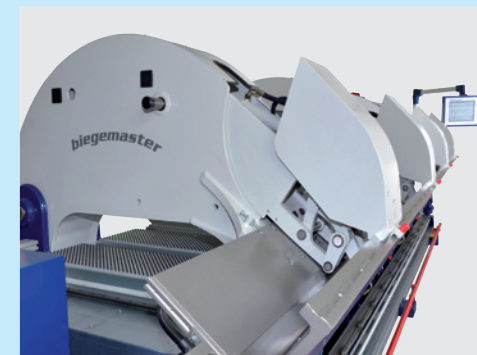
### Electric cutting equipment

A maintenance-free timing belt drives the cutting device with linear guides.



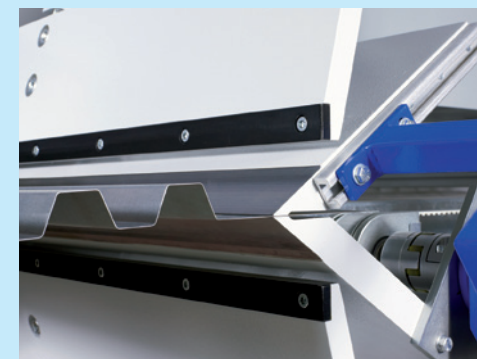
### Electronic back gauge

Motor-driven using a timing belt.  
Automatic positioning of the metal sheets.  
Variably adjustable back gauge fingers.  
Also available in conical design.



### Hydraulic bending units

Each set of stand / tension arm is equipped with 2 hydraulically driven bending units.  
Robust, sturdy construction for uniform bending forces along the full length.



### Inclined bending beams

For high flexibility and narrow bendings. Due to the removable bending rail strips of 10 millimetres (0.4") each, even smaller bendings are possible. Maximum bending angle: 145°.

## CONTROL UNITS

### MATURE SYSTEMS FOR EASY HANDLING

**biegemaster BM and BS long folding machines** can be equipped with a choice of three different control units. This enables you to make the right decision depending on your individual automation needs.

**biegemaster XB double bending machines** exclusively use intuitive BMS touch control.



#### BMS 9 control

Allows for the pre-setting of 9 different angles. These will be performed automatically in consecutive order. For fast and accurate production of repetitive profiles.



#### Standard control

Bending angle is set using a rotary dial. After bending the pre-set angle, the clamp opens automatically. Opening clearances can be adjusted variably.



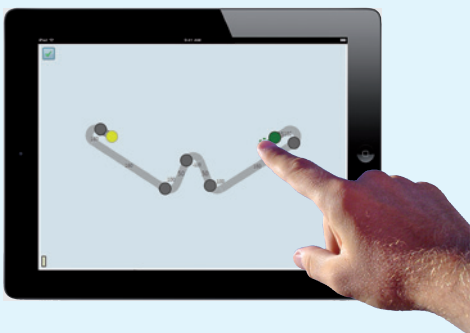
#### BMS touch control

Intuitive touch operation. Touch screen painting enables easy creation and editing of new profiles. The control can access saved profiles. Bending sequences can be calculated using graphical simulation and display. For individual profiles or foldings it is also possible to choose a semi-automatic process. You can also easily create profiles on the office PC and transfer them to the machine, making production planning highly efficient.



## OPTIONS

### A PLUS IN PERFECTION

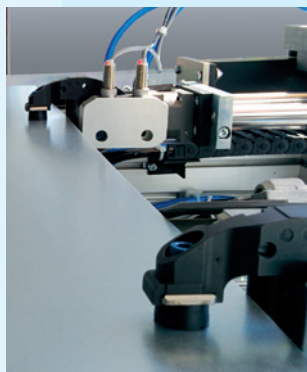
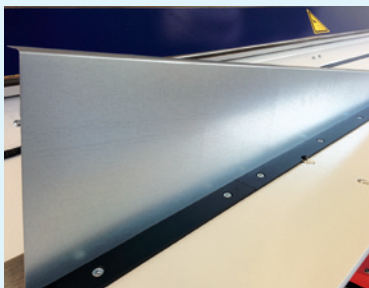


#### From your tablet directly to the machine

Quick and efficient: Using our special biegemaster software allows you to draw the required folding profile on your tablet while on the building site.

#### Conical back gauge

All biegemaster machines can be equipped with a conical back gauge.

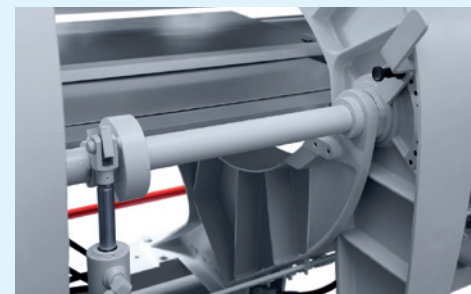
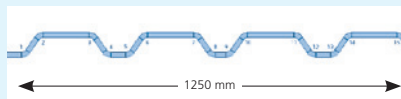


#### Automatic gripper system

The grippers hold the metal in position while the profile is created.

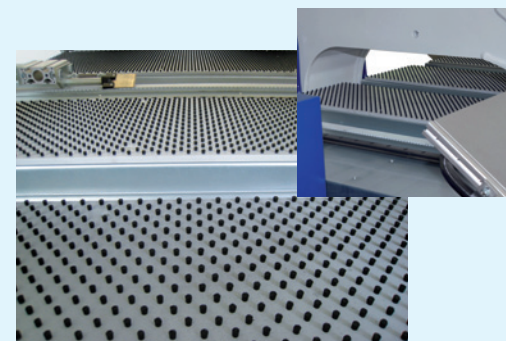
#### Insertion depth of 1250 mm (4.1 ft.)

All machines can be delivered with an insertion depth of 1250 mm (4.1 ft.).



#### Hydraulically adjusted clamping beams

All machines of the BM series can be equipped with hydraulically adjusted clamping beams (air gap adjustment) to balance different types of metal thickness. The BS series comes pre-configured with hydraulically adjusted clamping beams.



#### Non-abrasive placement area

Available in plastic or brush table design for XB models.

## SPECIFICATIONS FACTS AT A GLANCE

Always up to date

[www.biegemaster.de](http://www.biegemaster.de)

Please see our website for more information on biegemaster machines, such as attractively priced second-hand machines, innovative product developments, upcoming trade shows, and the option to place a direct customer service request.



### Videos:

Click here to watch the latest application videos of biegemaster machines.

## LONG FOLDING MACHINE MODEL BM Pages 2/3

Model BM	Working length mm	Bending capacity		Cutting capacity electric shear		Number of stand / tension arm units	Number of driven linkage assemblies	Total length incl. electric shears mm
		Steel 400 N/mm <sup>2</sup>	Alu 190 N/mm <sup>2</sup>	Steel 400 N/mm <sup>2</sup>	Alu 190 N/mm <sup>2</sup>			
3.1,00	3100	1,00	1,50	1,25	1,50	2	2	4300
3.1,25	3100	1,25	2,00	1,25	1,50	3	3	4300
3.1,50	3100	1,50	2,00	1,50	2,00	4	4	4300
4.1,00	4010	1,00	1,50	1,25	1,50	3	3	5200
4.1,25	4010	1,25	2,00	1,25	1,50	4	4	5200
4.1,50	4010	1,50	2,00	1,50	2,00	5	5	5200
6.1,00	6200	1,00	1,50	1,25	1,50	4	4	7380
6.1,25	6200	1,25	2,00	1,25	1,50	5	5	7380
6.1,50	6200	1,50	2,00	1,50	2,00	7	7	7380
8.1,00	8020	1,00	1,50	1,25	1,50	6	6	9200
8.1,25	8020	1,25	2,00	1,25	1,50	7	7	9200
8.1,50	8020	1,50	2,00	1,50	2,00	10	10	9200
10.1,00	10020	1,00	1,50	1,25	1,50	7	7	11200
10.1,25	10020	1,25	2,00	1,25	1,50	9	9	11200
10.1,50	10020	1,50	2,00	1,50	2,00	12	12	11200
12.1,00	12020	1,00	1,50	1,25	1,50	8	8	13200
12.1,25	12020	1,25	2,00	1,25	1,50	10	10	13200
12.1,50	12020	1,50	2,00	1,50	2,00	14	14	13200
15.1,50	15020	1,50	2,00	1,50	2,00	18	18	16200

## LONG FOLDING MACHINE MODEL BS Page 4/5

Model BS	Working length mm	Bending capacity		Cutting capacity electric shear		Number of stand / tension arm units	Number of driven linkage assemblies	Total length incl. electric shears mm
		Steel 400 N/mm <sup>2</sup>	Alu 190 N/mm <sup>2</sup>	Steel 400 N/mm <sup>2</sup>	Alu 190 N/mm <sup>2</sup>			
3.2,00	3100	2,00	3,00	2,00	2,50	3	3	4500
4.2,00	4010	2,00	3,00	2,00	2,50	4	4	5500
6.2,00	6200	2,00	3,00	2,00	2,50	6	6	7700
8.2,00	8020	2,00	3,00	2,00	2,50	8	8	9500
10.2,00	10020	2,00	3,00	2,00	2,50	10	10	11500
12.2,00	12020	2,00	3,00	2,00	2,50	12	12	13500
3.3,00	3100	3,00	4,00	3,00	4,00	4	4	4500
4.3,00	4010	3,00	4,00	3,00	4,00	6	6	5500
6.3,00	6200	3,00	4,00	3,00	4,00	8	8	7700
8.3,00	8020	3,00	4,00	3,00	4,00	11	11	9500
10.3,00	10020	3,00	4,00	3,00	4,00	14	14	11500
12.3,00	12020	3,00	4,00	3,00	4,00	16	16	13500
15.3,00	15020	3,00	4,00	3,00	4,00	20	20	16500

## LONG FOLDING MACHINE XB DOUBLE BENDING MACHINE

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Model XB	Working length mm	Bending capacity		Cutting capacity electric shear		Number of stand / tension arm units	Number of driven linkage assemblies	Total length incl. electric shears mm
		Steel 400 N/mm <sup>2</sup>	Alu 190 N/mm <sup>2</sup>	Steel 400 N/mm <sup>2</sup>	Alu 190 N/mm <sup>2</sup>			
4.1,50	4010	1,50	2,00	1,50	2,00	3	6	5420
4.2,00	4010	2,00	2,00	1,50	2,00	5	10	5420
5.1,50	5010	1,50	2,00	1,50	2,00	4	8	6420
6.1,25	6400	1,25	2,00	1,50	2,00	4	8	7800
6.1,50	6400	1,50	2,00	1,50	2,00	5	10	7800
6.1,75	6400	1,75	2,00	1,50	2,00	6	12	7800
6.2,00	6400	2,00	2,00	1,50	2,00	7	14	7800
8.1,25	8020	1,25	2,00	1,50	2,00	5	10	9420
8.1,50	8020	1,50	2,00	1,50	2,00	6	12	9420
8.2,00	8020	2,00	2,00	1,50	2,00	8	16	9420

**biegemaster**  
EXCELLING IN SERVICE

To us, competent manufacturing service already includes goal-oriented and customised advice on application options prior to your purchasing decision. Naturally, you will be extensively trained and instructed on the machine during commissioning. Our proficient after-sales team will continue to support you whenever you need help following your purchase. You need spare parts? We will ship them instantly – by post, extra tour, or collection. We will do everything to safeguard the conservation of your long folding or double bending machine's value – you can count on that.



### Competence and safety directly from the manufacturer

Ever since 1955, Sperr & Lechner Maschinenbau have been focusing on producing and selling high-quality machines. As early as in 1978, we introduced the first long folding machine for metal profiles onto the market. Branded "biegemaster", these machines swiftly made a name for themselves in terms of precision, reliability, and easy handling as well as attractive quality for money.

Sharing information on an equal footing with our customers enables us to continuously optimise our constructions and to align them precisely to real-life challenges.



COMPETENCE AND SERVICE  
DIRECTLY FROM THE MANUFACTURER

***biegemaster***

***biegemaster***

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MASCHINENBAU