

# SWEBEND

*Genuine Swedish Craftmanship,  
Proven results*



## **THREE ROLL SECTION BENDING MACHINES** *SB3*

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

# SB3B series

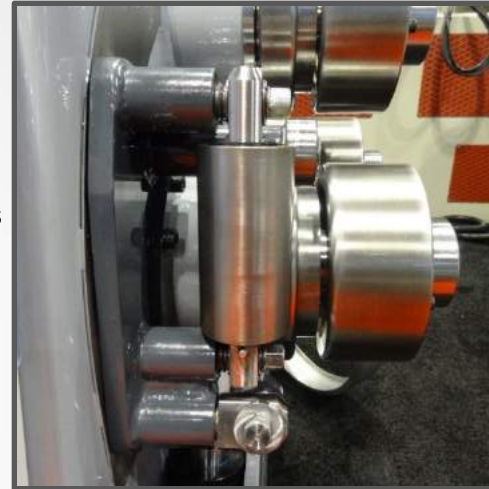


**SB3B** (Section **B**ending **3** roll **B**asic) series offers seven different models ranging from 0.4 to 37 in<sup>3</sup>. The machines are extremely sturdy in design and have more power compared to any other section bending machine on the market.

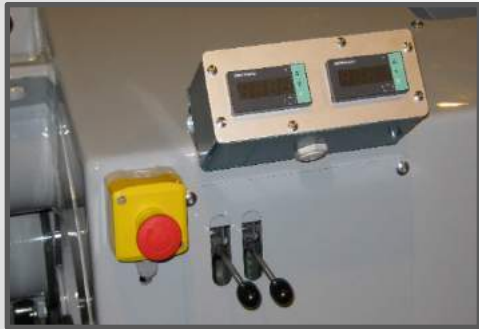
Main standard features:

- Highest available side roll power (=bending power)
- Planetary gearbox on all machine sizes ensures maximum drive torque. Other manufacturers may use worm gear boxes which produce less drive torque.
- Tilttable guide rolls enable better result when rolling asymmetrical sections like angle bars "L-iron" with leg out (see below).

**SB3B-65** in standard execution with hand valves, digital readouts & electrical motor drive.



Guide roll units also have a small guide roll "Dolly Roll" which is often used to untwist angle rolled with leg in



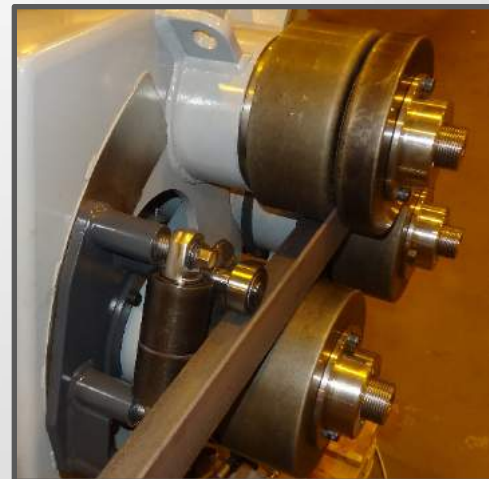
Hand valves & digital readouts



SB3B-55 with special equipment



Control with joystick for rotation & switch for pushing roll



Our broad and unique variety of options like variable speed by means of inverter (frequency changer), hydraulic motor with proportional valve, joysticks, additional digital readouts, lifting roll, spiraling device, pushing roll, CNC, special tooling, etc. ensures you that we can provide the best possible solution for each and every customer.

Control with joystick for side rolls & rotation





# SB3S series

**SB3S** (Section Bending 3 roll Special) series offers thirteen different models ranging from 0.4 to 1100 in<sup>3</sup>. These machines are extremely sturdy in design and have more power compared to any other section bending machine on the market.

## Main standard features:

- Highest available side roll power (=bending power)
- Hydraulic drive for rotation and on most models this is done by two or even three motors.
- Proportional valve for all functions
- Extremely sturdy hydraulically powered guide rolls enable "L-irons" with leg out (see below).
- Wireless control unit (BlueTooth)



We offer two different machine versions with hydraulic guide rolls: **SB3S-XXX** and **SB3-XXX-S** where "XXX" is the size of the top shaft in millimeters.

**SB3S-XXX** has the guide rolls journaled as an integrated part of the swing arms, which means that the guide roll will always automatically follow a side roll adjustment.

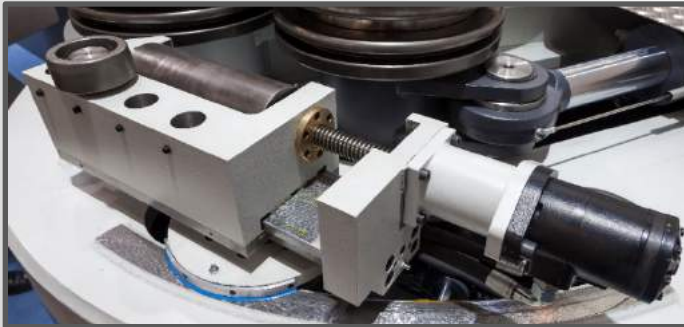
**SB3-XXX-S** has the guide rolls journaled separately in the machine frame. Hence they are always individually adjustable and offers the operator total control of the bending process at all times.



Rolling a W33 x 169# beam in a section bending machine where guide rolls are journaled separately in the frame.



Model **SB3-360S** frame in machining center



On models SB3S-XXX it is possible to have the guide rolls adjustable in the plane (length adjustment)



Rolling a C15 x 50# using standard pulling head & universal rolls

# Capacity table for SweBend SB3 machines

Model Name / Size		SB3B-55	SB3B-65	SB3B-75	SB3-85	SB3-105
Rated Section Modulus Capacity	in <sup>3</sup>	0.45	0.67	1.1	2.2	3.7
Maximum capacity - solid sections	in <sup>3</sup>	0.45	0.67	1.0	1.8	3.1
Maximum capacity - hollow sections	in <sup>3</sup>	0.45	0.67	1.1	2.2	3.7
Maximum capacity - Beams X-X (hard way)	in <sup>3</sup>	N/A	N/A	N/A	N/A	N/A
Installed Power	HP	3	4	8	10	15
Shaft diameter (top/lower)	in	2.17 / 2.17	2.56 / 2.56	2.95 / 2.95	3.35 / 3.35	4.13 / 4.13
Roll diameter (OD / inside drive)	in	6.9 / 5.5	7.7 / 5.9	8.9 / 6.9	9.8 / 7.9	12.2 / 9.8
Free shaft length	in	4.9	5.3	6.7	7.9	9.1
Max daylight - drive rolls	in	3.5	3.9	4.9	5.5	6.3
Drive on all three rolls		Standard	Standard	Standard	Standard	Standard
Variable rotation speed		Standard	Standard	Standard	Standard	Standard
Type of drive		Mechanical	Mechanical	Mechanical	Hydraulic	Hydraulic
Number of motors on standard machine		1	1	1	1	1
Speed compensation top/lower rolls		Slip Clutch	Slip Clutch	Slip Clutch	Slip Clutch	Slip Clutch
Digital display for bending rolls		Standard	Standard	Standard	Standard	Standard
Guide Roll Auto Radius Positioning		No	Standard	Standard	Standard	Standard
Guide Roll height adjustment		Mechanical	Mechanical	Mechanical	Hydraulic	Hydraulic
Guide Roll turn adjustment		Mechanical	Mechanical	Mechanical	Hydraulic	Hydraulic
Guide Roll length adjustment		N/A	N/A	N/A	Option	Hydraulic
Digital display for Guide Rolls height		N/A	N/A	N/A	Option	Option
Combined horizontal/vertical execution		Standard	Standard	Standard	Standard	Standard
Angle leg out		2 x 2 x 3/16 to Ø20	2 x 2 x 5/16 to Ø20	3 x 3 x 5/16 to Ø30	3 x 3 x 3/8 to Ø33	4 x 4 x 1/2 to Ø48
Angle leg in		2 x 2 x 3/16 to Ø27	2 x 2 x 1/4 to Ø24	3 x 3 x 1/4 to Ø40	3 x 3 x 3/8 to Ø40	4 x 4 x 3/8 to Ø48
Flat bar X-X		2 x 9/16 to Ø12	2-1/4 x 1/2 to Ø16	3 x 5/8 to Ø24	3-1/2 x 1/4 to Ø32 3 x 1-3/8 to Ø30	4 x 1-1/4 to Ø36 3 x 1-1/2 to Ø30
Flat bar Y-Y		4 x 1/4 to Ø16	4 x 1 to Ø20	6 x 1 to Ø24	7 x 1 to Ø20	8 x 1-1/2 to Ø24
Square bar		1-3/8 to Ø16	1-1/2 to Ø20	1-3/4 to Ø32	2 to Ø24	2-1/2 to Ø30
H Beam Y-Y		S3 x 5.7# to Ø32	S4 x 9.5# to Ø32	S5 x 10# to Ø32	W4 x 13# to Ø24	W6 x 16# to Ø30
I Beam Y-Y		S3 x 5.7# to Ø32	S4 x 9.5# to Ø32	S5 x 10# to Ø32	S6 x 17.25# to Ø32	S6 x 17.25# to Ø26
Channel Y-Y		C3 x 6# to Ø24	C4 x 7.25# to Ø32	C5 x 9# to Ø32	C6 x 13# to Ø30	C7 x 14.75# to Ø30
Rectangular tubing		2 x 1 x 1/8 *	2 x 1-1/2 x 1/8 *	2-1/2 x 1-1/2 x 3/16 *	3 x 2 x 5/16 *	5 x 2 x 3/16 *
Square tubing		1-1/2 x 1/8 *	1-5/8 x 3/16 *	2 x 3/16 *	3 x 1/4 *	3-1/2 x 1/4 *
Pipe ODxT		1-1/2" Sch. 40 to Ø24	2" Sch. 40 to Ø24	2-1/2" Sch. 40 to Ø32	3" Sch. 80 to Ø40	4" Sch. 40 to Ø48
H Beam X-X		-	-	-	S3 x 7.5# to Ø40	S5 x 9# to Ø60
I Beam X-X		-	-	-	S3 x 7.5# to Ø40	S5 x 9# to Ø60
Channel X-X		-	-	C3 x 3.5# *	C3 x 6# *	C5 x 6.7# *

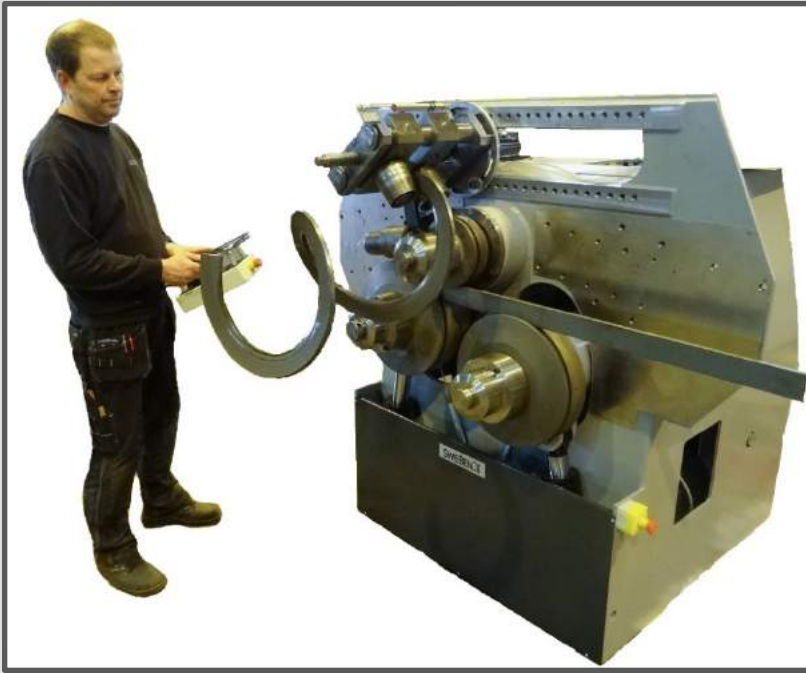
Capacities are valid for normal steel with yield point 38,000 psi

\* - Minimum diameter depends on grade of deformation accepted

SB3-140	SB3-180	SB3-240	SB3-300	SB3-330	SB3-360	SB3-420	SB3-520
7	14	37	98	214	400	672	1100
5	8.5	25	49	92	160	336	550
5.5	9.2	31	67	147	183	400	615
7	14	37	98	214	400	672	1100
20	30	50	90	90	100	150	215
5.5 / 5.5	7.1 / 6.3	9.5 / 8.7	11.8 / 11.0	14.2 / 14.2	14.2 / 14.2	16.5 / 16.5	20.5 / 16.5
15.5 / 12.2	18.1 / 15.0	21.7 / 18.1	29.1 / 24.4	31.5 / 28.4	31.5 / 28.4	33.1 / 29.9	34/30 - 31.5/28.4
10.25	14.6	21.25	29.5	41.3	41.3	43.3	43.3
7.1	7.9	10.6	14.2	16	24	32	45.3
Standard	Standard	Standard	Standard	Standard	Standard	Standard	Standard
Standard	Standard	Standard	Standard	Standard	Standard	Standard	Standard
Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic
2	2	3	3	3	3	3	4 (2 + 1 + 1)
Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic
Standard	Standard	Standard	Standard	Standard	Standard	Standard	Standard
Standard	Standard	Standard	N/A	N/A	N/A	N/A	N/A
Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic
Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic
Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic
Standard	Standard	Standard	Standard	Standard	Standard	Standard	Standard
Option	Option	Option	Option	N/A	N/A	N/A	N/A
5 x 5 x ½ to Ø50	6 x 6 x 5/8 to Ø85	6 x 6 x 1 to Ø100	8 x 8 x 1-1/8 to Ø80	8 x 8 x 1-1/4 to Ø60	8 x 8 x 1-1/4 to Ø60	10 x 10 x 1-1/8 to Ø120	10 x 10 x 1-1/8 to Ø120
4 x 4 x ½ to Ø50	5 x 5 x ¾ to Ø85	6 x 6 x 1 to Ø130	8 x 8 x 1-1/8 to Ø100	8 x 8 x 1-1/4 to Ø70	8 x 8 x 1-1/4 to Ø70	10 x 10 x 1-1/8 to Ø130	10 x 10 x 1-1/8 to Ø130
5 x 1-1/8 to Ø60	6 x 1-3/8 to Ø40	8 x 2 to Ø48	10 x 2-3/8 to Ø80	12 x 3-3/4 6to Ø96	16 x 3 to Ø120	20 x 5 to Ø120	24 x 4-1/2 to Ø144
10 x 1-1/2 to Ø40	10 x 2 to Ø45	16 x 2-3/8 to Ø48	18 x 3 to Ø60	20 x 4 to Ø80	24 x 4-1/2 to Ø80	32 x 7 to Ø96	32 x 8 to Ø80
3 to Ø60	3-1/2 to Ø40	5 to Ø60	6 to Ø80	8 to Ø80	10 to Ø80	12 to Ø96	15 to Ø120
W8 x 21# to Ø32	W12 x 35# to Ø45	W12 x 58# to Ø60	W24 x 117# to Ø80	W40 x 211# to Ø160	HEA1000 to ID4000 (wb=934) HEB1000 to ID5000 (wb=1090)	HEA1000 to ID2500 (wb=934) HEB1000 to ID2500 (wb=1090)	HEA1000 to ID2000 (wb=934) HEB1000 to ID2000 (wb=1090)
S8 x 23# to Ø26	S12 x 50# to Ø40	S18 x 70# to Ø48	S24 x 121# to Ø80	IPE600 to ID2000 (wb=308)	IPE600 to ID2000 (wb=308)	IPE600 to ID2000 (wb=308)	IPE600 to ID2000 (wb=308)
C8 x 22.8# to Ø30	MC12 x 45# to Ø40	MC 18 x 58# to Ø80	MC 18 x 58# to Ø50	MC 18 x 58# to Ø40	MC 18 x 58# to Ø60	MC 18 x 58# to Ø80	MC 18 x 58# to Ø80
5 x 2-1/2 x ¼*	160x80x8 to ID5000 (wb=142)	250x150x10 to R5000 (wb=466)	300x200x12 to R8000 (wb=952)	400x200x10 to R20000 (wb=1218)	500x300x12,5 to R15000 (wb=2632)	500x300x20 to R20000 (wb=3951)	500x300x20 to R20000 (wb=3951)
4 x 5/16*	120x120x10 to ID5000 (wb=149)	180x180x12 to R5000 (wb=423)	200x200x16 to R5000 (wb=639)	300x300x13 to R15000 (wb=1369)	400x400x16 to R15000 (wb=2967)	400x400x20 to R20000 (wb=3577)	400x400x20 to R20000 (wb=3577)
5" Sch. 40 to Ø60	6" Sch. 40 to Ø80	8" Sch. 100 to Ø200	12" Sch. 60 to Ø400	18" Sch. 40 to Ø600	20" Sch. 40 to Ø600	24" Sch. 60 to Ø600	28x ¾ wall to Ø600
HEA120 to ID4000 (wb=106) HEB100 to ID3000 (wb=90)	HEA160 to ID5000 (wb=220) HEB140 to ID5000 (wb=216)	HEA220 to R4000 (wb=515) HEB200 to R4000 (wb=570)	HEA300 to R10000 (wb=1260) HEB280 to R7500 (wb=1380)	HEA400 to R15000 (wb=2310) HEB400 to R15000 (wb=2880)	HEA600 to R25000 (wb=4790) HEB600 to R20000 (wb=5700)	HEA800 to R25000 (wb=7680) HEB800 to R20000 (wb=8980)	HEA1000 to R35000 (wb=11200) HEB1000 to R30000 (wb=12900)
S5 x 10# to Ø100	S6 x 17.25# to Ø160	S10 x 25.4# to Ø350	IPE360 to ID20000 (wb=904)	IPE400 to R15000 (wb=1160)	IPE600 to R15000 (wb=3070)	IPE600 to ID25000 (wb=3070)	IPE600 to ID25000 (wb=3070)
C5 x 9# to Ø200	C7 x 14.75# to Ø200	C9 x 20 to Ø240	C12 x 30# to Ø300	C15 x 50# to Ø500	MC18 x 58# to Ø400	MC18 x 58# to Ø400	MC 18 x 58# to Ø400



# A variety of optional equipment & specials



Hydraulic spiraling equipment is used to produce flat bar spirals (“augers”, “flights”) in various dimensions.



Special rolls & equipment to roll aluminum sections on SB3B-55

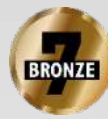


Spiraling pipe in a SB3H-75 (“H” = hydraulic drive)



Nylon pipe rolls

# CNC & controls



The most advanced & user friendly CNC system



Possibility to use a standard TFT screen to display axis positions in large format that may be seen from a distance if machine is operated through our wireless control unit.

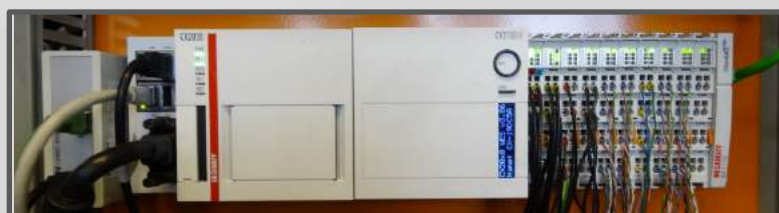


As an option we offer to have the control panel (here with 15" TFT) on a swing arm.

Also here it is possible to adjust the tilt angle of the display.



Our own designed control panel (here with 19" TFT) on wheels is light & easy to move around. Note that screen can be tilted to match the operators height.



Hardware from Beckhoff offers highest quality



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



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



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



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

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

#### Co-operation partner

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

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

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



# SWEBEND

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