

SHEET METAL FORMING



Roof + Wall



METALLBAU

STEFANUTTI

- ➔ Wide range of services
- ➔ Competent advice
- ➔ Professional execution

B2C

B2B

⚙️ 5-Axis Waterjet System

4000x2000 mm Support Table

Cuttable materials: wood, stone, tiles, glass, plastics and almost all metals

⚙️ CMA 3RD 6006 Machining Center

3-Axis drilling and milling machine
with 16-slot tool changer

⚙️ Metal processing

⚙️ Stainless steel processing

We combine



CRAFTSHIP



INNOVATION



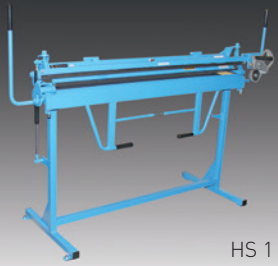
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Balconies

Stair Railings

Roofs

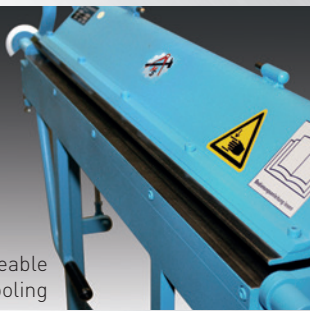
Special machine construction



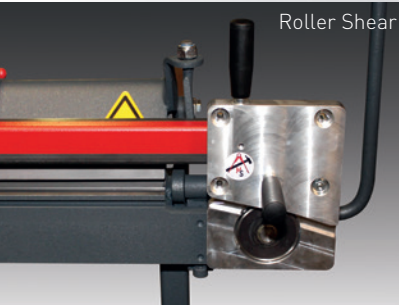
HS 1 Hand



BK 2 Foot



exchangeable tooling



Roller Shear

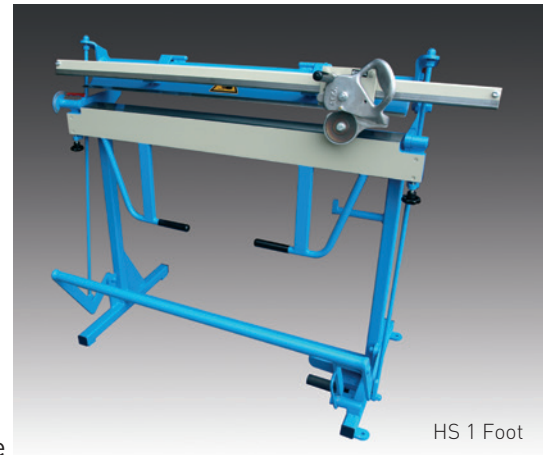


back gauge + Curl Forming Device

Model HS 1; HS 1-L; Building Site Bending Machine BK 2

Construction and Design

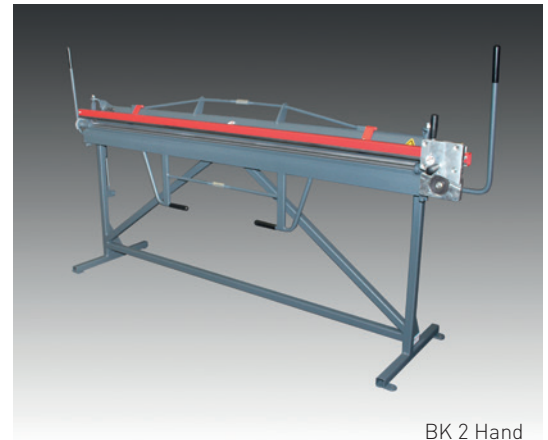
- » mechanical swivel bending machines
- » bearings and guideways maintenance free
- » angle scale for bending beam
0 – 155 degrees
- » adjustable bending beam
- » all machines in solid, welded all-steel design
- » light and portable manual bending machine
- » upper beam operated either by hand lever or foot pedal
- » tooling for upper and bending beam are not exchangeable
- » upper beam tooling 20 degrees
- » BK 2 has crowned bending beam and table



HS 1 Foot

Optional Accessory

- » tooling for upper and bending beam exchangeable
- » back gauge 600 mm
- » roller shear extension
- » curl forming attachment/curl forming rod/2 wrenches
- » swivel castors with wheel stops only for hand lever operated machines



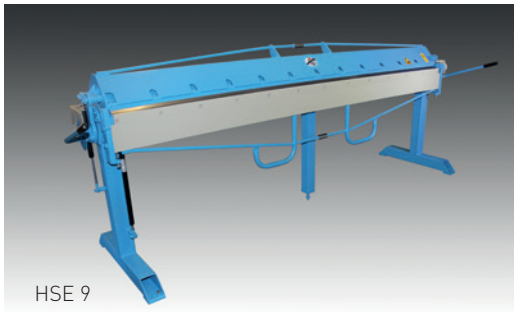
BK 2 Hand

Working length mm	Bending Capacity mm for steel 400 N/mm ²	Types
1030	1,00 mm	HS 1
1350	0,80 mm	HS 1-L
2030	0,70 mm	BK 2

Manual Bending Machines

Model Standard HSE 2 – HSE 9

- » manual swivel bending machine in sturdy design
- » fast closing of upper beam by hand levers on both sides
- » clamping system with eccentric tappet
- » tooling of upper and bending beam exchangeable
- » adjustable stop for equal bending angles 0 - 155 degrees
- » bending beam with pre-stressing mechanism (crown bow)
- » weight compensation of upper and bending beam



HSE 9

Standard Configuration

- » upper beam with sharp rail 20 degrees
- » bending beam with insert rail
- » equipment with boreholes for the assembly of back gauge/curl forming device
- » retrofitting possibility with curl forming device and roller shear extension

Optional Accessory for HSE 2 – HSE 9 + GE 2 – GE 9

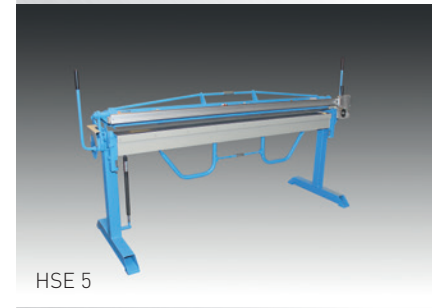


HSE 2

- » different tooling rail shapes for upper beam
- » back gauge 600 mm (manual adjustment on both sides)
- » back gauge 750 mm with gear rack adjustment
- » insert rail for bending beam
50 x 10, 50 x 15, 50 x 20, 50 x 25
- » roller shear extension up to 0,80 mm
- » roller shear extension up to 1,00 mm
- » curl forming attachement/2 wrenches/curl forming rod
either 1000 or 2000 mm long
- » additional middle-foot-actuation



HSE 2



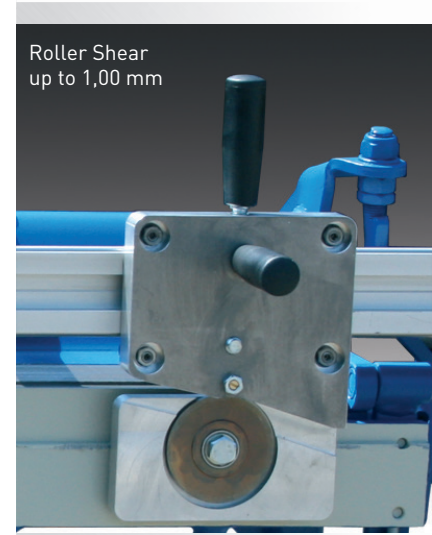
HSE 5



HSE 5 with middle-foot



HSE 6

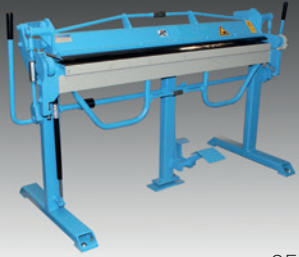


Roller Shear
up to 1,00 mm

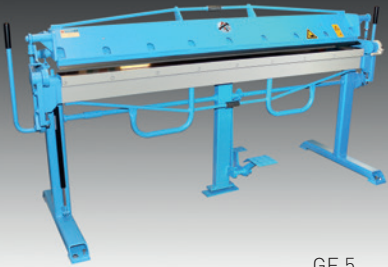
Working length mm	Bending capacity mm for steel 400 N/mm ²	Types
1030	2,00 mm	HSE 2
1280	1,75 mm	HSE 3
1530	1,50 mm	HSE 4
2030	1,00 mm	HSE 5
2030	1,50 mm	HSE 6
2530	1,00 mm	HSE 8
3030	1,00 mm	HSE 9

Model Exklusiv GE 2 – GE 9

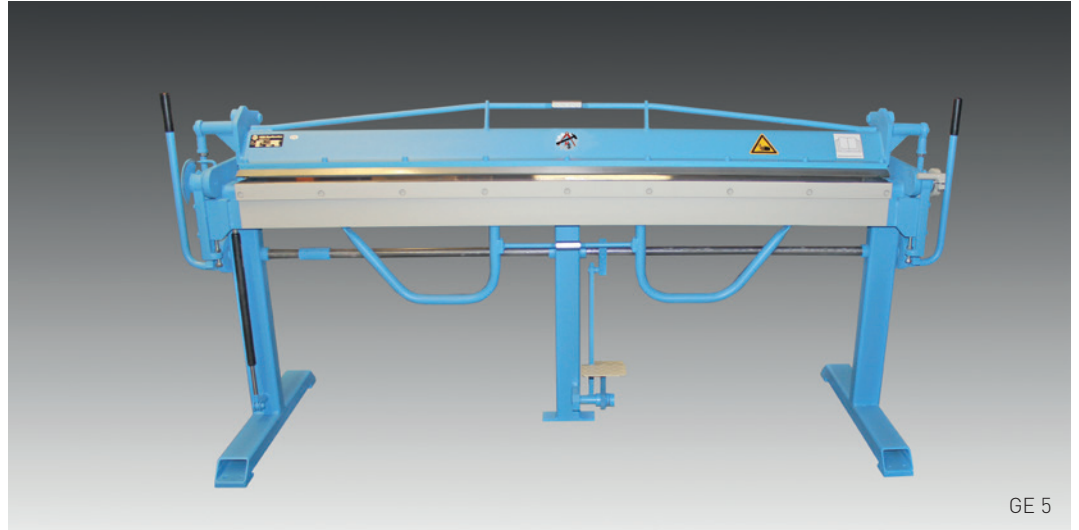
- » clamping system with hand lever and foot pedal
- » movement of upper beam parallel to the table
- » weight compensation of upper and bending beam through gas strut
- » pre-stressing of the beams (crown bow)



GE 4



GE 5



GE 5



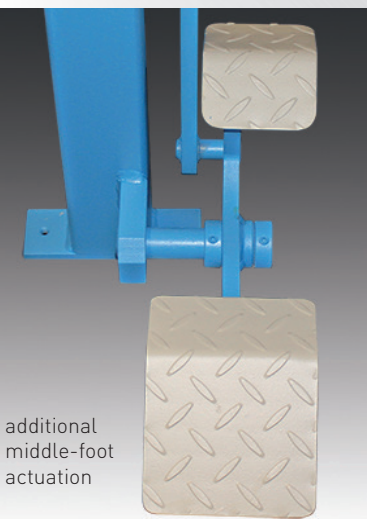
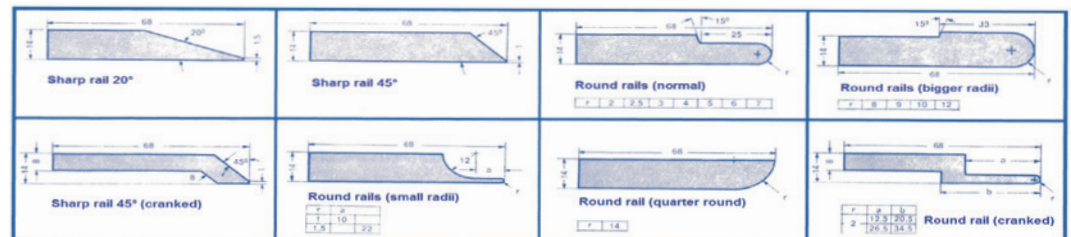
GE 9

Standard Configuration

- » stop for equal angles 0 – 155 degrees
- » sharp rail 20 degrees of upper beam, bending beam with exchangeable inser rail

Optional Accessory like Model HSE

Bending tool shapes for bending machines

additional
middle-foot
actuation

Working length mm	Bending capacity mm for steel 400 N/mm ²	Types
1030	2,00 mm	GE 2
1280	1,75 mm	GE 3
1530	1,50 mm	GE 4
2030	1,00 mm	GE 5
2030	1,50 mm	GE 6
2530	1,00 mm	GE 7
3030	1,00 mm	GE 9

Bending Machines with variable width

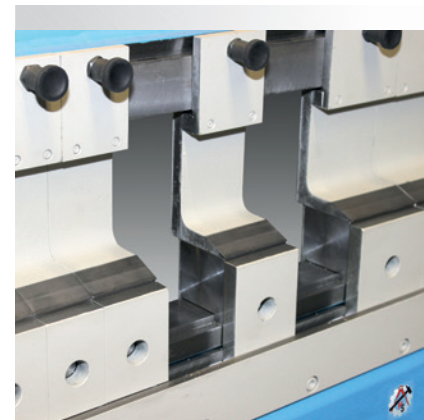
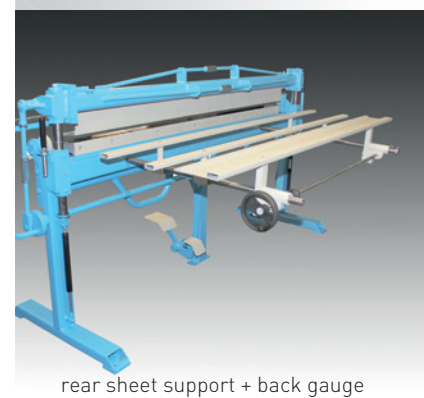
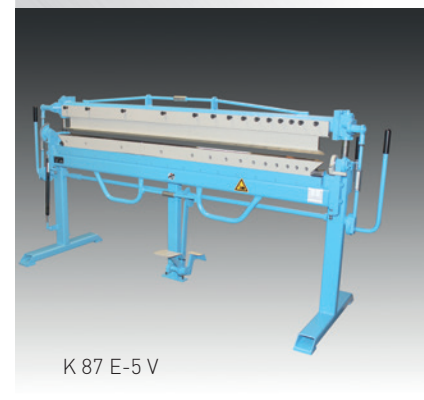
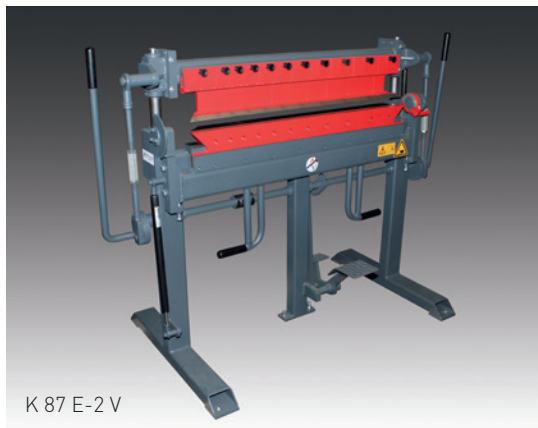
Model K 87 E-1 – completely segmented

- » Segment height standard 120 mm
- » operating of upper beam by means of hand levers on both sides
- » segmentation: 50, 60, 2x70, 80, 90, 100, 120, 140 und 250 mm
- » operational lateral clearance height with closed upper beam approx. 110 mm
- » fast clamping system
- » with bending angle scale from 0 – 155 degrees
- » weight compensation of upper and bending beam through gas strut
- » additional middle-foot-actuation
- » corner segments 45 degrees complete right + left

Working length mm	Bending capacity mm for steel 400 N/mm ²	Types
1030	1,50 mm	K 87 E-1
1380	1,00 mm	K 87 E-1 L
1030	2,00 mm	K 87 E-2 V
1280	1,75 mm	K 87 E-3 V
1530	1,50 mm	K 87 E-4 V
2030	1,00 mm	K 87 E-5 V

Optional Accessory

- » back gauge 600 mm resp. 750 mm
- » rear sheet support
- » roller shear up to 1,00 mm
- » set of segments for window sills
- » swivel castors with wheel stops
- » higher segments for the upper beam



Model K 87 E-1 N – Only upper beam segmented

Working length mm	Bending capacity mm for steel 400 N/mm ²	Types
1030	1,50 mm	K 87 E-1 N
1380	1,00 mm	K 87 E-1 NL
1030	2,00 mm	K 87 E-2 VN
1280	1,75 mm	K 87 E-3 VN
1530	1,50 mm	K 87 E-4 VN
2030	1,00 mm	K 87 E-5 VN

Model R1 – R9

Construction and design

- » three rollers, supported asymmetrically, made of high-tensile steel
- » two driven rollers
- » upper roller can be swivelled out for easy workpiece removal
- » sturdy frame in welded steel construction
- » rear roller can be inclined for the fabrication of conical forms
- » upper roller with rabbet groove
- » two rollers are provided with ring grooves for rolling plates with wire insert
- » quick adjustment for rear roller
- » crowned rollers for compensation of deflection
- » cylindrical rollers available on request

Optional accessory

- » Electric motor drive, with gear motor 0,55 KW, speed infinitely variable, right and left-hand rotation

R1



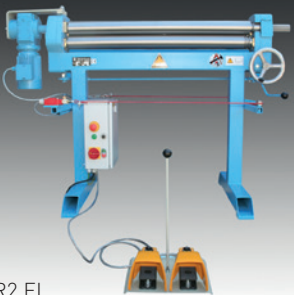
R1 EL



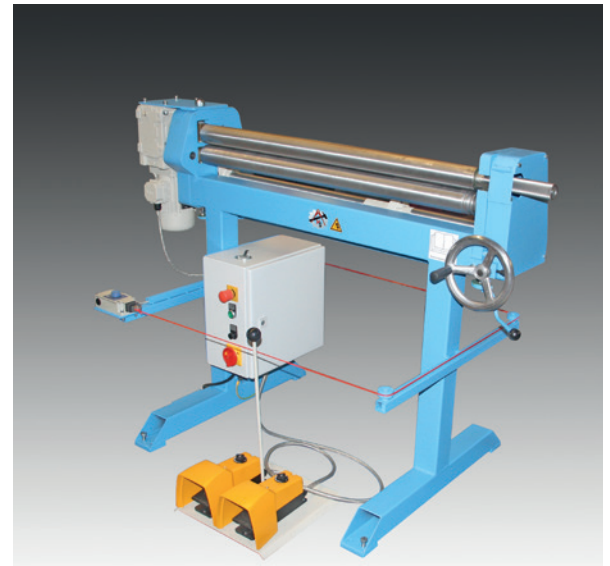
R2



R2 EL



R6



R2

Working area

Types

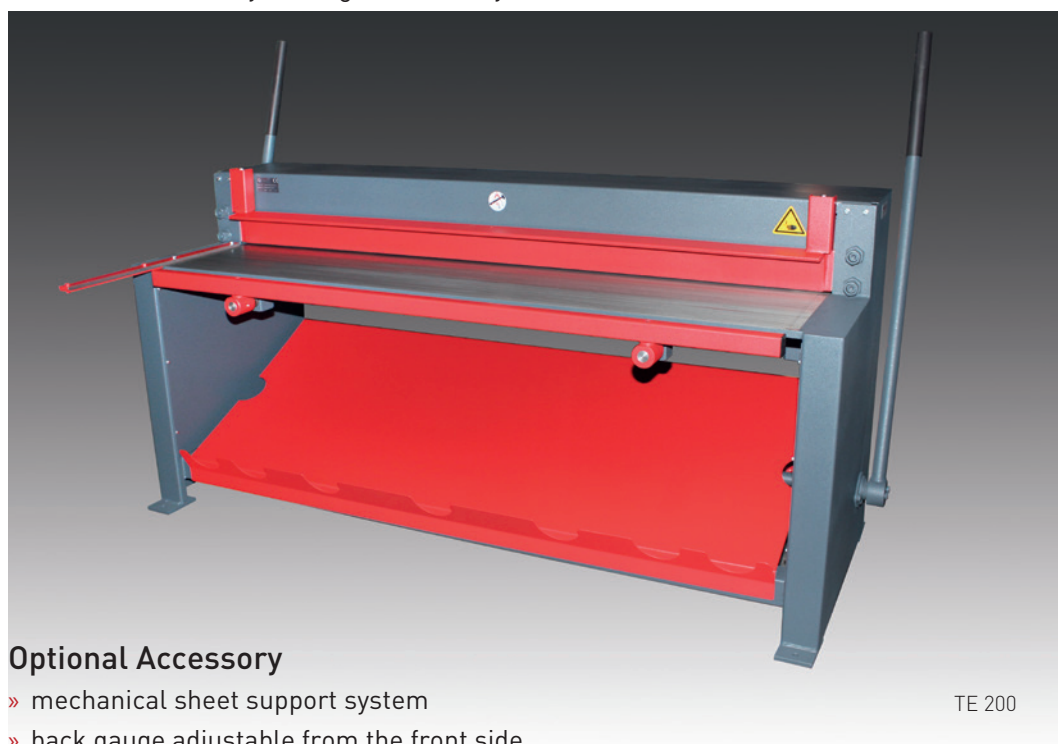
Working area	Types	
1030 x 0,80 mm	Roller-Ø 50 mm	R1
1030 x 1,50 mm	Roller-Ø 65 mm	R2
1030 x 2,00 mm	Roller-Ø 80 mm	R3
1280 x 1,00 mm	Roller-Ø 65 mm	R4
1280 x 1,75 mm	Roller-Ø 80 mm	R5
1530 x 1,00 mm	Roller-Ø 65 mm	R6
1530 x 1,50 mm	Roller-Ø 80 mm	R7
2030 x 1,00 mm	Roller-Ø 80 mm	R8
2030 x 1,50 mm	Roller-Ø 90 mm	R9

Manual Guillotine Plate Shears

Model TE 100 – TE 300

Construction and design

- » a strong mechanically acting blankholder ensures the secure clamping of the sheet metals
- » cutting table 400 mm with engraved measuring marks every 10 mm
- » lateral right-angled stop 800 mm
- » all bearings are maintenance free
- » as standard four edged blades made of high alloyed special steel guarantee a long service life and excellent cuttings, generally suitable for cutting stainless steel
- » weight compensation fo cutting bar - for easy cutting
- » back gauge till 750 mm as standard
- » variable work sheet throw off - the sheet can be gathered from the front side or from the back by turning the slideway



TE 200

Optional Accessory

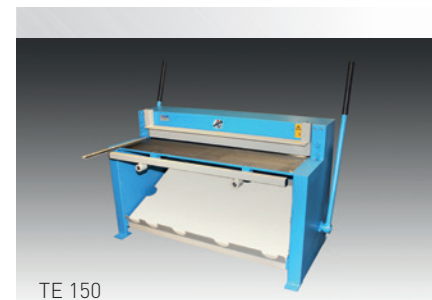
- » mechanical sheet support system
- » back gauge adjustable from the front side
- » sheet wagon

Working length x max. sheet thickness for steel 400 N/mm²

	Types
1030 x 1,75 mm	TE 100
1530 x 1,50 mm	TE 150
2030 x 1,25 mm	TE 200
2530 x 1,00 mm	TE 250
3030 x 1,00 mm	TE 300



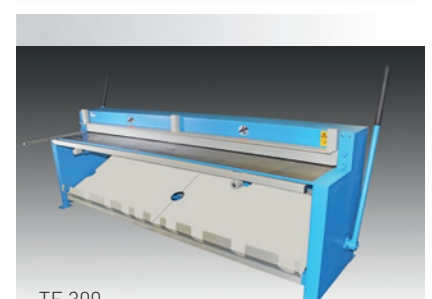
TE 100



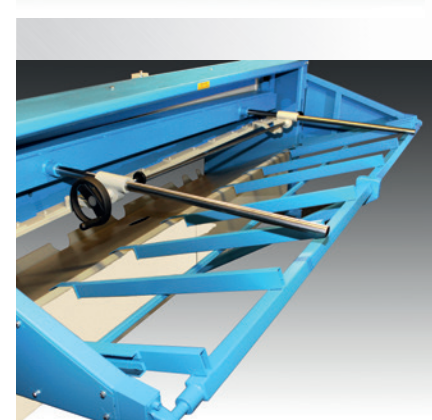
TE 150



TE 250



TE 300



mechanical sheet support system

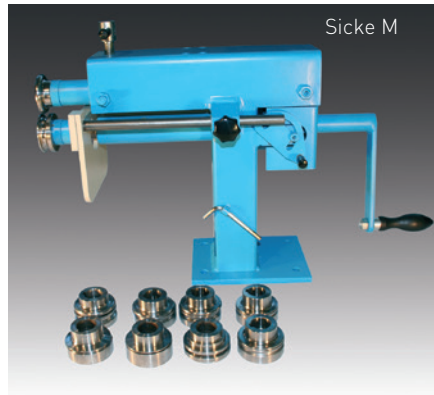
Model M and EL Construction and design

- » designed for beading, flanging and wire inserting works
- » advance of the top roller by means of threaded spindle
- » axially adjustable bottom roller
- » guidance of the workpieces through an adjustable stop

Sicke M



Sicke M



Accessory

Set of beading dies standard

- 2 pairs wiring rollers BA + BC
- 1 pair of necking rollers F
- 1 pair of folding rollers ZA
- 1 pair of beading rollers S = 6 mm
- 1 pair of crimping rollers E = 30 mm
- 1 pair of swaging rollers V, 2,5 mm
- 1 pair of swaging rollers V, 4,0 mm
- 1 pair of swaging rollers V, 5,0 mm

Special dies

- Beading rollers S, SK
- Wiring rollers BA, BE, BM, BD, BF
- Elbow rollers KA, KB
- Seaming rollers ZB
- Cutting rollers M

Special dies on request

Centre to centre distance between depth rollers	Throat depth	max. sheet thickness	working height above table	Types
63	200	1,00	250	M
63	200	1,00	250	EL



Sicke EL

Optional Accessory

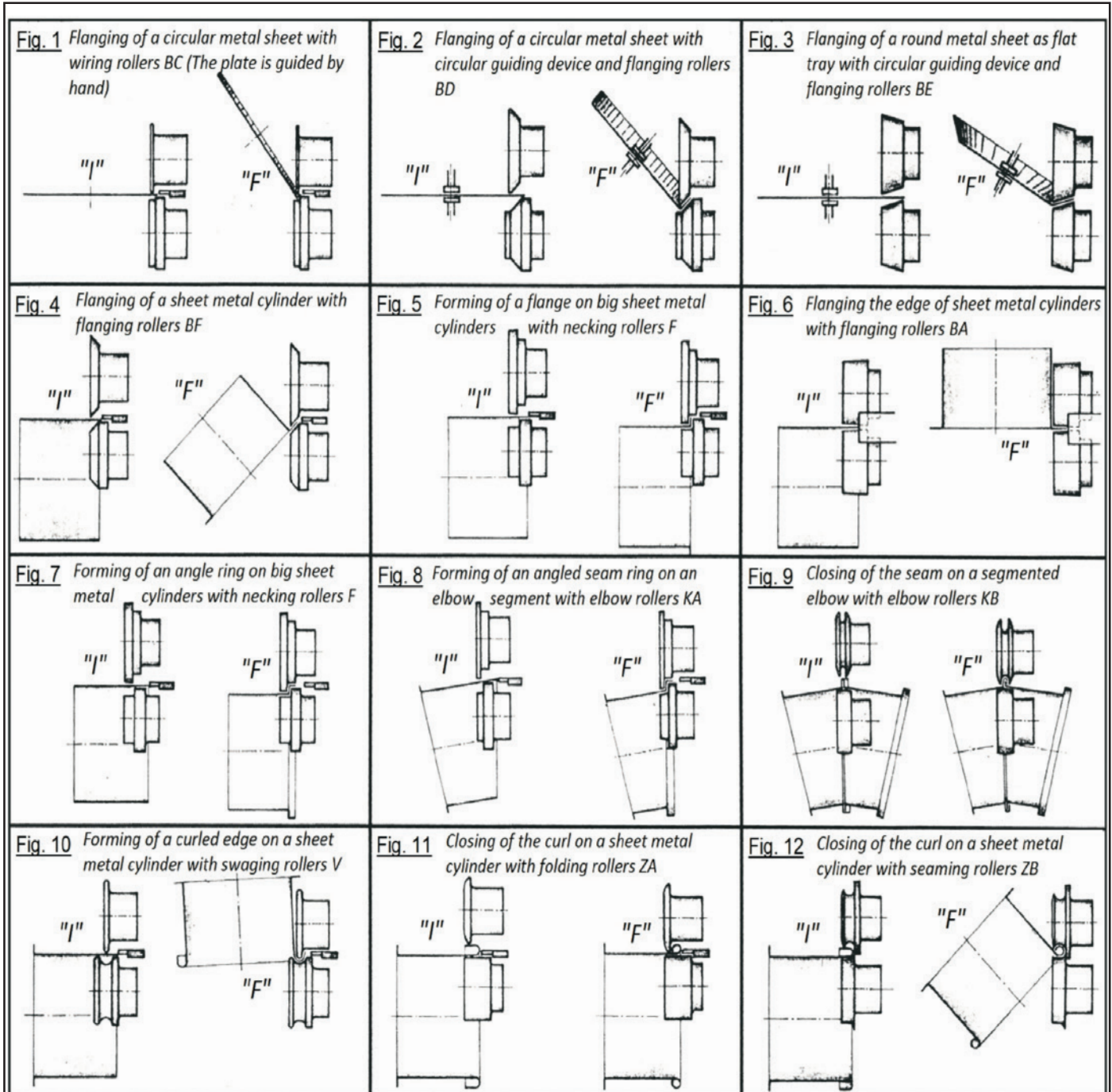
- » Electric motor drive, with geared motor 0,37 KW, speed infinitely variable, right and left-hand rotation

Examples of forming steps on beading machines

I = Initial Position

F = Final Position

Depending on the complexity of the forming process, one or more intermediate positions are necessary!



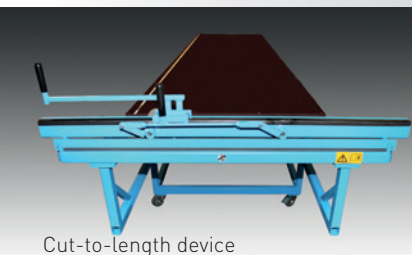
Milling Machine for Gutter Brackets

- » Milling depth 6 or 8 mm,
milling width ap. 32 mm,
weight ca. 2,5 kg
- » including 2 batteries
- » fast battery charger
- » including case

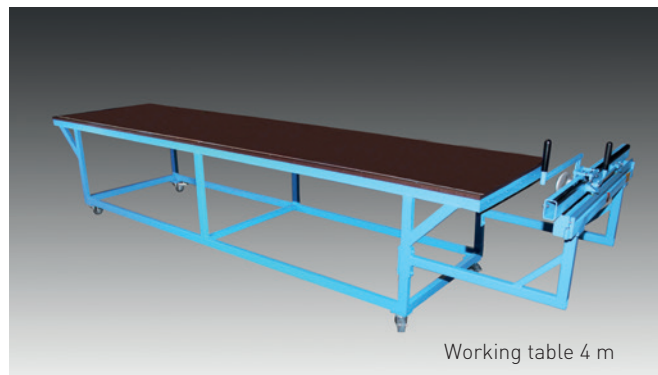


Working table

- » available in the lengths 2 m - 6 m and in the working widths 1 m or 1,25 m
- » also available with cut-to-length device
- » height from floor 900 mm
- » worktop made of resistant silk-screen printed table
- » swivel castors with wheel stops



Cut-to-length device



Working table 4 m

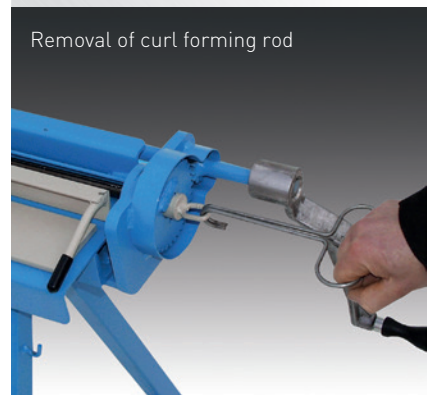
Curl Forming Machine / Reel Decoiler / Universal Decoiler

Curl Forming Machine Construction and Design

- » curl forming machine with base frame
- » working length 1020 resp. 2020 mm
- » max. sheet thickness: 0,8 mm
- » double sided drive through gear pairs and hand crank
- » adjustable bead guide
- » removal flap

Accessories

- » curl forming rod
Ø 16, 18, 20 mm
- » special curl forming rod
on request

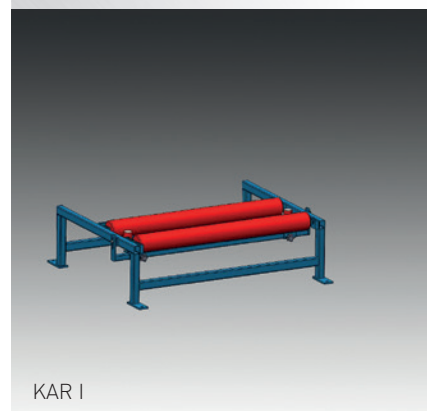
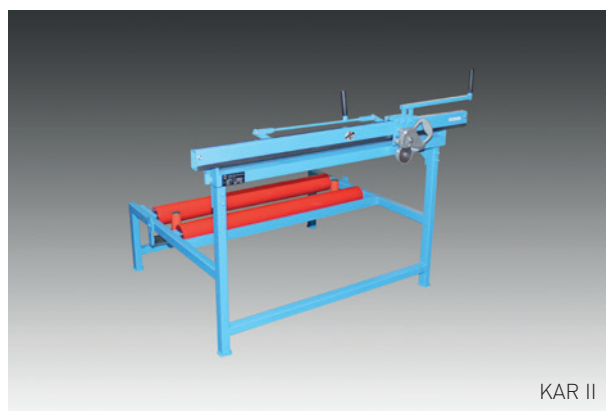


Reel decoiler

- » **1000 kg load capacity**
- » four tined reel decoiler with diameter range from 380 – 530 mm, continuously adjustable
- » complete with base frame, brake mechanism strong bearings
- » available in 670, 1000 or 1250 mm

Universal decoiler for all purposes

- » Type KAR I – decoiling in floor height with strip treading path
- » Type KAR II – decoiling in table height for coil width up to 1000 mm or 1250 mm with strip treading path, angle stop and roller shear 90 degrees



Length measuring device:

- » Option: mechanical dial gauge in cm spacing for length up to 99 m

Model ETS 200 – ETS 300

Construction and design

- » welded steel construction
- » four edged blades, generally suitable for stainless steel
- » overload protection
- » hold-down bar right at the cutting edge
- » hold-down bar adjusted automatically to the thickness of material
- » mechanically controlled synchronization
- » electric control



ETS 200

Standard Accessory

- » manual back gauge 0 – 750 mm
- » lateral angle stop
- » sheet slideway

Sonderzubehör

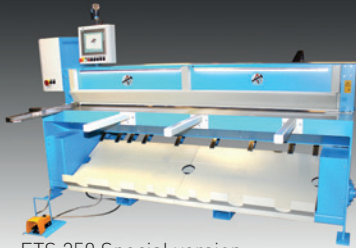
- » motorized back gauge 750 mm or 1000 mm with 4 inch touch panel KTP 400
- » stroke counter
- » forward table extension
- » lighting of the cutting edge with LED
- » automatically sheet support system
- » security cage with barrier

Working length mm	Cutting capacity for steel 400 N/mm ²			Types
	1,50 mm	2,50 mm	3,00 mm	
2030	1,50 mm	2,50 mm	3,00 mm	ETS 200
2530	1,25 mm	2,00 mm		ETS 250
3030	1,50 mm	2,00 mm		ETS 300

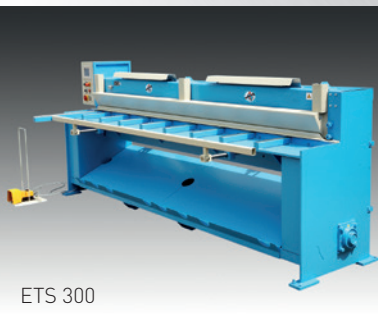
ETS 100
Special
version



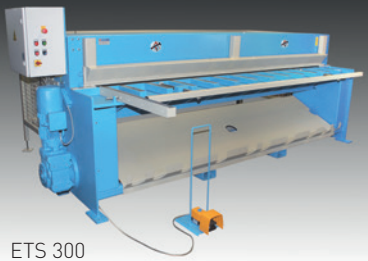
ETS 250 Special version



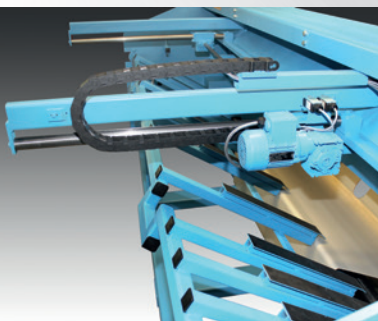
ETS 300



ETS 300



automatically sheet
support system



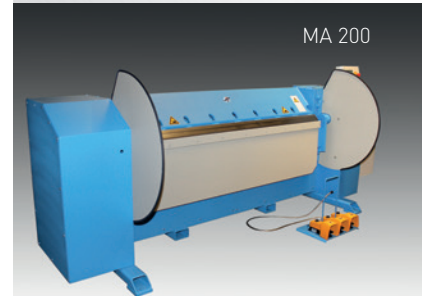
Motorized Bending Machines MA

Model MA 200 – MA 300

- » motorized swivel bending machine
- » robust welded construction
- » maintenance free guideways and bearings
- » upper beam with clearance of 180 mm
- » Siemens control S7-1200
- » standard with 4 inch touch panel with adjustment for 1 bending angle 0 – 130 Grad depending on bending tool shape
- » quick change system
- » sharp rail 45 degrees as standard
- » other insert rails on request



MA 200



MA 200



MA 300



Touch Control

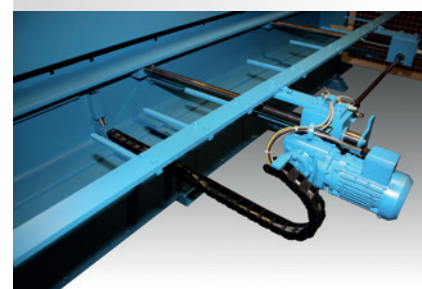
Optional Accessory

- » combined manual back gauge with gauge fingers 750 mm oder 1000 mm
- » motorized back gauge 750 mm or 1000 mm with 6 inch touch panel KTP 600
- » electronic adjustment for 10 or 99 bending angles
- » Grafiksteuerung über 17 Zoll Industrie PC
- » touch panel available in different sizes
- » safety cage with light barrier



Foot pedals

Working length mm	Bending capacity for steel 400 N/mm ²			Types
	1,5	2,0	3,0	
2030	1,5	2,0	3,0	MA 200
2530	1,0	1,5	2,5	MA 250
3030	1,5	2,0	3,0 (Alu)	MA 300



motorized back gauge



METALLBAU

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