Krieger Basic Machine: KBM 4

All Basic Machines

are set up for basic bar twisting. They are additionally used to drive the various optional attachments.

All versions of the basic machine include these features:

Extra solid construction

Moveable control panel to either working position, possible to connect at three different machine positions: front, rear, left side. Fully independent from machine body and ist motor heat.

Machine bed with mm increments for precise measurement of twisting length

Two built in **storage cabinets** for dies and attachments with shelves and holders for allan keys, grease gun, two length stop, plastic hammer, 300 mm measuring scale.

Low, comfortable working height

Twisting length: infinitely up to 1800 mm (70 in)

Electronic control with **cooling fan and double filter system**

Technical Information KBM 4:

Driving speed in r.p.m.:	**14/28**
Motor drive in kW:	**3.7/4.5**
with KBMH 26/30/34	
bending machine	**6.7/7,8**
Twisting capacity:	
with ST37-2 in mm	**30x30mm**
Twisting length:	**up to 1.800 mm (70 i)**

Electric operated brake motor ensures exact termination upon completion of a production run.

Standard Equipment for all Basic Machines:

Central computer with customizable, storable programs, production status monitor (displays quantity completed and target quantity), automatic shut down at the end of a production run, ability to interface with a hydraulic bending machine KBMH 26/30/34 for fully automated production of baskets, automatic computer controlled functions such as "soft start".

Standard equipment:

3 twisting dies (KTC), if not other specified:
12 x 12 mm,
20 x 20 mm,
25 x 25 mm
(alternatively up to 35 x 35 mm or in inch dimensions)

1 additional foot pedal	1 grease gun
1 set of alan keys	1 open/ring wrench 24 mm
3 meter measuring tape	3,5 m of power supply cable
2 tool cabinets	2 length stops
1 extensive operators manual	

Details of the computer production steps:

For bar twisting, two production steps are necessary: First is required number of twists with the precise amount of overbending to allow for spring back. Second is reverse to release the tension in the twisting dies to allow the material to be removed and allow the ends to be paralell.

For scroll bending, up to four production steps are necessary. To form an "S" scroll, step 1 forms the first scroll and step 2 releases the material from the pressure roll by reversing the main drive. Step 3 forms a larger scroll on the opposite end of the material and step 4 releases the material once again from the pressure roll.

You can easily regulate the various programs. You can determine in which program the machine should start automatically or if the programs should be started manually, i.e. twisting a bar first with a right twist and then a left twist, or if the machine should first start with a reverse twist as in the production of baskets, and continue automatically with the remaining functions.

The production of various shapes of baskets requires a minimum of 3 production steps. For other shapes, 5 or more production steps may be necessary. The computer allows you to do them automatically.