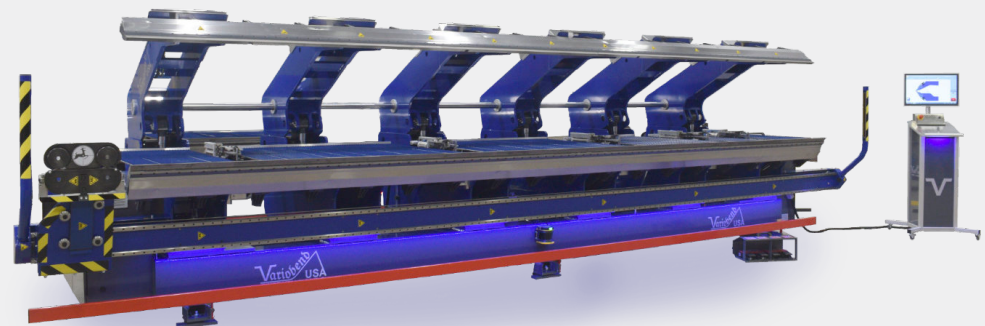




SHEET METAL FOLDING MACHINES



Speed. Accuracy. Service.



***A Unique Hybrid of European Design
and American Manufacturing***

Who We Are

Hershey's the Metal Meister, LLC is owned and operated by the Hershberger family in central Illinois. The company is founded upon two basic values:

1. Nothing we have is ours; it all belongs to the Lord and we are only stewards striving to use these earthly possessions to bring honor and glory to our Creator.
2. We endeavor to treat each person the way we would like to be treated.

Our family has a background in both roll-forming and machinery manufacturing, so we understand the frustration of having a breakdown in the bottleneck of your operation. We also know what it is to have a superior European machine, yet not be able to get parts promptly or receive knowledgeable technical support.

Therefore when the opportunity developed to purchase the North American patent rights to the most productive folder we have ever seen, we felt the Lord leading us into this opportunity to provide the best of both worlds to the American market.

Now your company can have the advantage of the latest European engineering coupled with enhancements by Americans for Americans. And since the en-



Mattoon, IL Manufacturing Facility

tire Variobend USA folding machines are assembled right here in Illinois, if you ever need a replacement part, be assured that it is in stock and ready to be rushed to your facility. Contact our team today! We are ready to assist you!

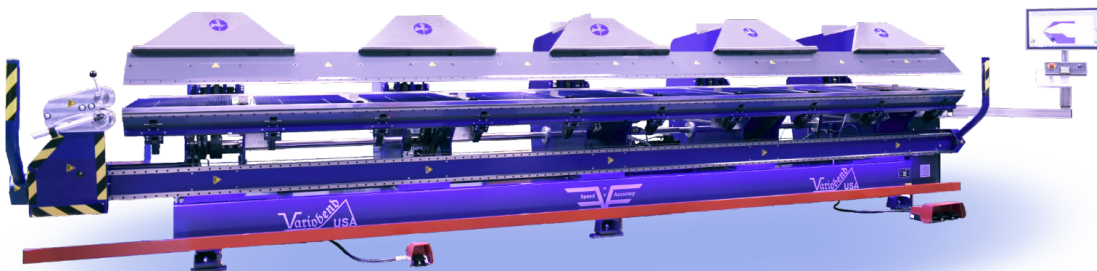
Single and Double Folders

Variobend machines offer greater efficiency for metal roofing companies and general sheet metal manufacturers. The engineers at Variobend- Austria were driven by a passion to innovate and desired to bring double-bending capacities to small and medium manufacturers. This resulted in a unique system that offers flexibility and reduced material handling that is also capable of bending profiles not possible before.

Every function on the machine is variable speed, which greatly enhances productivity as well as the longevity of the machine. The back gauge is designed with ball screws to eliminate the potential problem of inaccurate measurements. Both the clamping and bending beam are equipped with replaceable, hardened segments. The machine is built on a heavy duty 8" x 12" tubing frame, which greatly simplifies the machine setup.

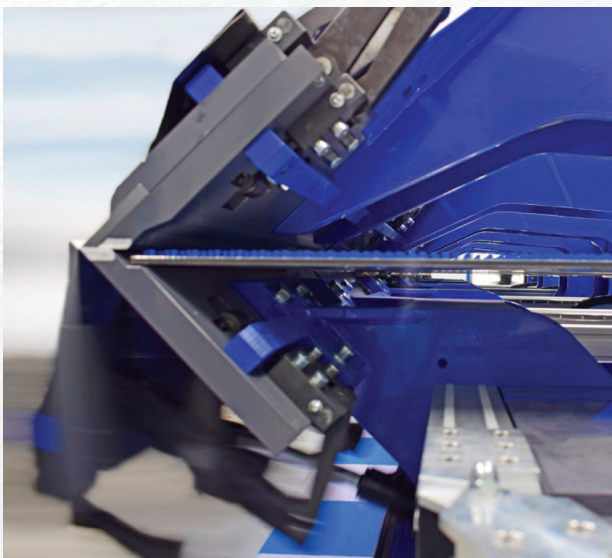
The control software is the most user-friendly we have seen. A 24" wide touch screen assures excessive screen real estate for drawing profiles, and the easy-to-understand software is run on Windows 7 Pro for convenient networking and compatibility. Office personnel can also draw profiles on any Windows desktop or tablet PC and upload them to the machine for higher productivity. Technicians are able to remotely connect to your machine to diagnose and repair software issues (whether or not you have internet access).

Variobend machines are beautifully designed with precision, and attention to detail. We continue to improve them based on suggestions of present and future users. Once you see the quality, versatility, and outstanding technical design, you will understand why no other machine matches Variobend on a performance to price ratio.



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WHY VARIOBEND USA?



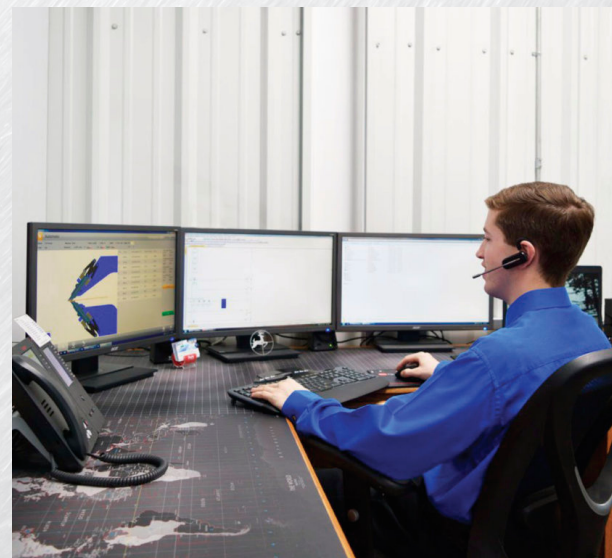
■ Speed

for maximum returns on your investment. Utilizing advanced programming plus the latest in servo-drive technology equals a whisper-quiet, lightning-fast machine that can produce more trim in less man hours than ever! In addition, unless the machine is moving, no motors are running, thereby maximizing its energy efficiency and providing a more pleasant working environment for your operators.



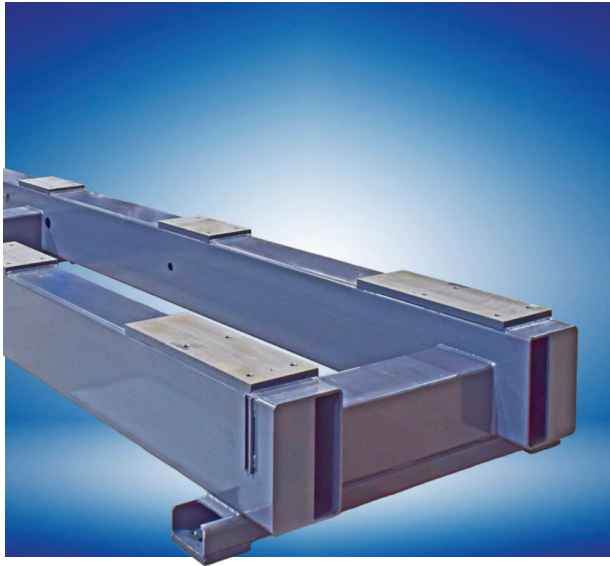
■ Accuracy

for your customers' satisfaction. What better way to impress your customers than by producing products that are precise and accurate every single time? With servo-driven, ball screw back gauges in your Variobend, peace of mind is a way of life!



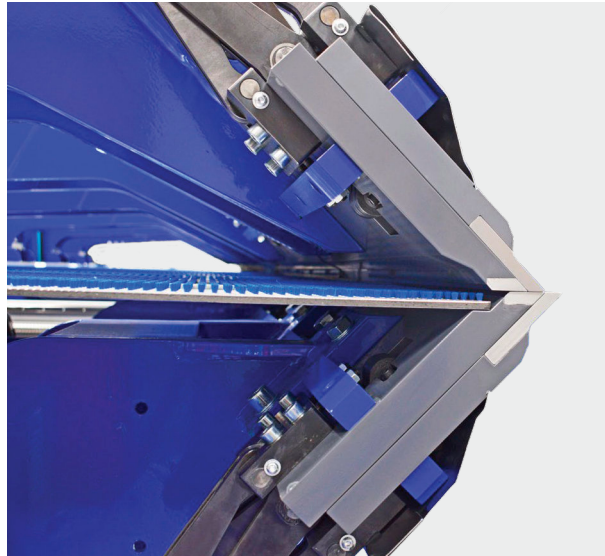
■ Service

to keep it that way! How about calling the 800 number on your folding machine and promptly talking with someone who can transfer you directly to the technicians who built your machine? Sound too good to be true? It gets better yet. At Hershey's Metal Meister, you not only get that, but we are also able to immediately access your machine remotely and step you through any difficulty you have as well as make any software adjustments or customizations that you need! Need a technician onsite? No problem! Our service technicians can often be onsite within hours rather than days or weeks.



■ Robust Frame

A folding machine is no better than its foundation, and this is another area where Variobend is superior. An 8" x 12" tubing for the main frame assures ease of setup and consistent accuracy in spite of possible variation in the plant floor.



■ Angular Bending Beam

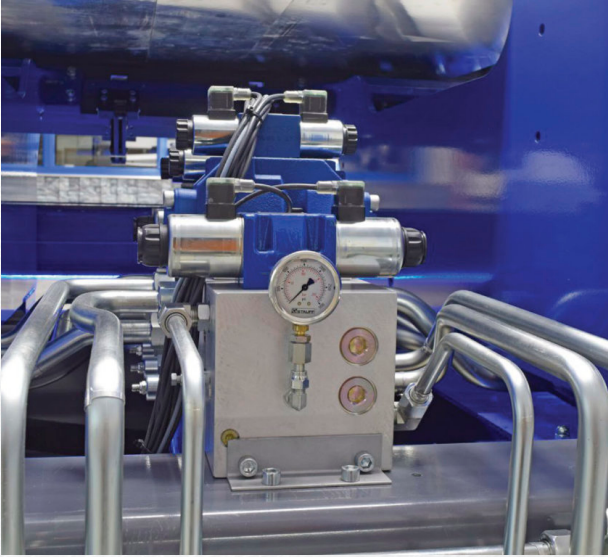
The patented Variobend bending beams are angled back, allowing you to bend profiles that used to be impossible with vertical bending beams.



■ Replaceable Hardened Segments

Removable, hardened segments for both the clamping and bending beam guarantee precision for life. Damaged segments can easily be replaced.

STANDARD FEATURES



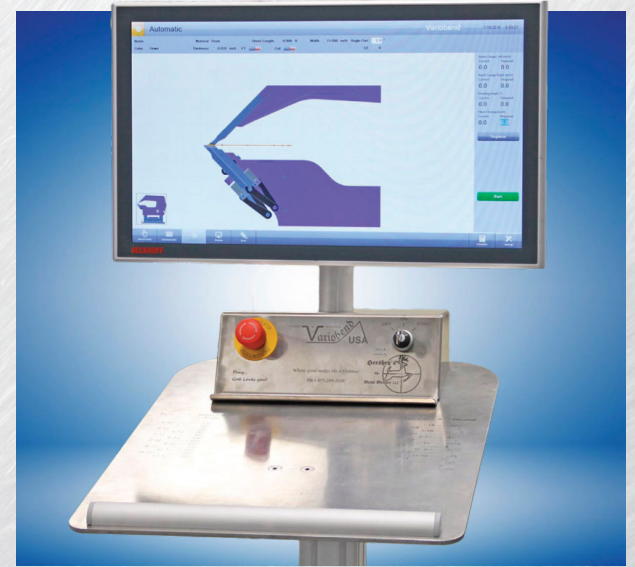
■ Hydraulic Components

Featuring American flat face fittings, Gates® hoses, and double filters, the entire hydraulic system is engineered in the USA for maximum performance, efficiency and long-term reliability.



■ Slitter

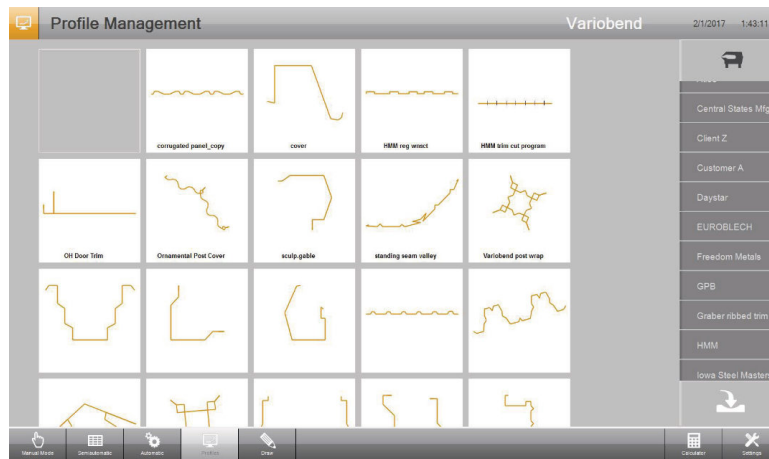
The slitting assembly slides on dual linear bearing rails mounted directly on the machine chassis, therefore providing a rigid structure. This innovative solution ensures the bending beams are free from any interference as is typically found on rails mounted on the clamping or bending beam. The Variobend cuts up to 3X faster than its competitors.



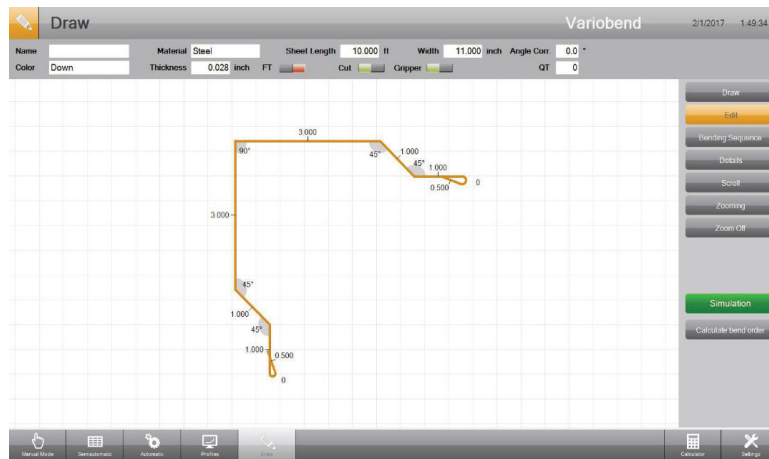
■ User-Friendly Touch Screen Controls

The Variobend touch screen control allows fast and easy input of new profiles as well as a library of standard profiles. A new standard has been set for operator convenience and software possibilities.

From Imagination to Fabrication!



The Variobend touch screen control allows the input of any number of profiles and folders. All profiles and folders can be randomly named, saved, or deleted as desired. Both profiles and also complete folders can be shifted to a USB stick or a network location and saved simply by touching and dragging. Sophisticated industrial monitors precisely implement any finger command.

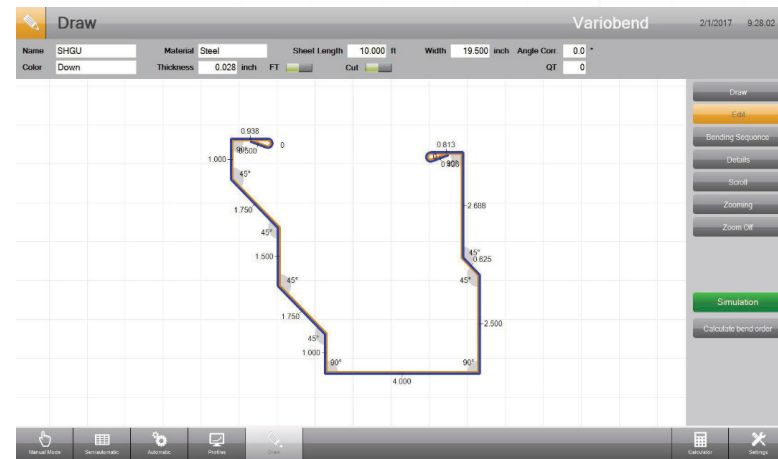


New profiles can be drawn and dimensioned with the fingers in a user-friendly way. The following actions are easily activated with their respective buttons;

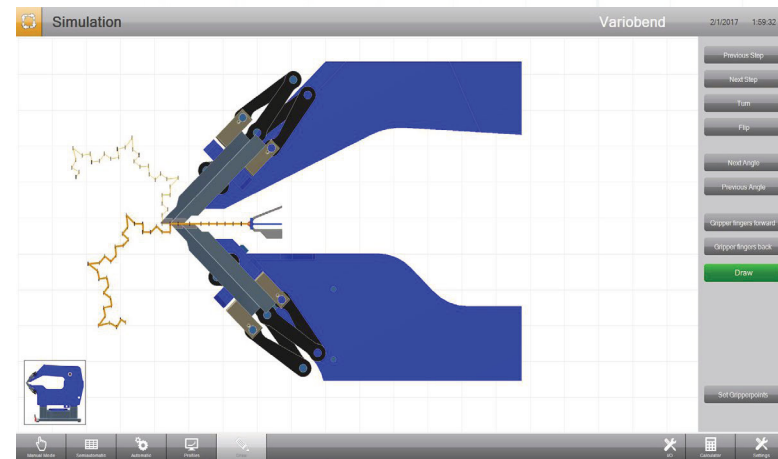
Fit Together: Automatic wide/narrow chamfering of the profiles to allow for plugging them together.

Cutting: Prior to bending, the sheet is cut to the calculated dimensions.

Gripper: If the machine is equipped with a depth stop with grippers, the profiles can be manufactured automatically.



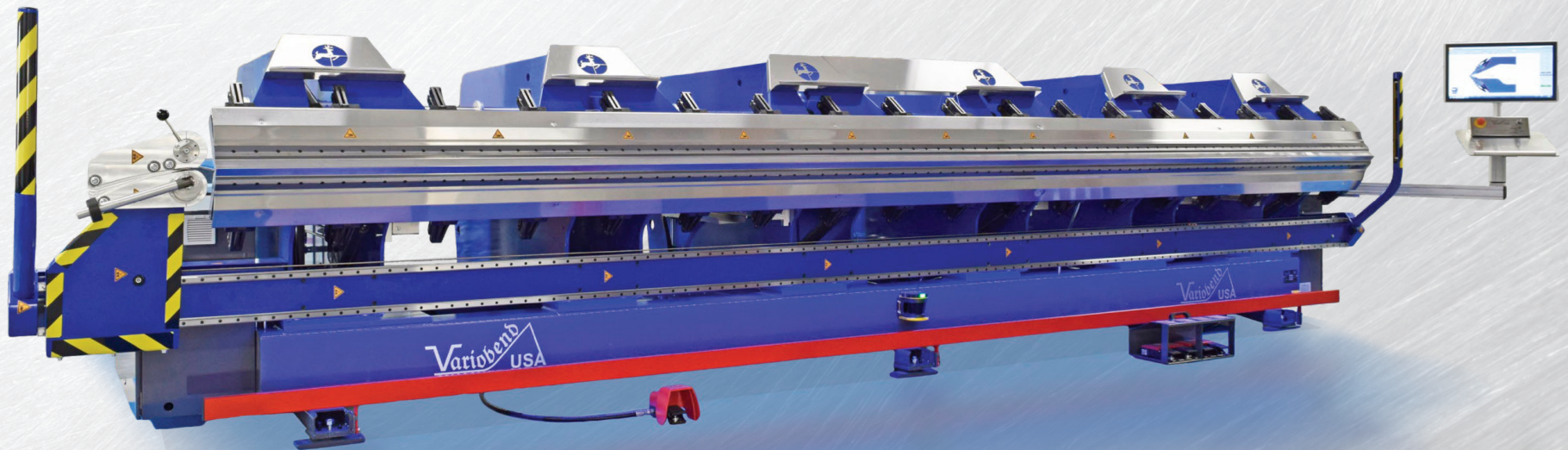
An additional blue profile contour is displayed if the plugging together of profiles is activated by the fit together button. In this case, all sides of the profile are conically chamfered by one material thickness. The correct bending sequence is immediately determined on the basis of the automatic bending sequence calculation. As an option, the bending sequence can be overwritten or manually entered.



In simulation mode, the complete bending cycle can be checked for collision-free operation. Variobend double bending machines with automatic gripper system can also define the position of the grippers and stop fingers. During the following automatic mode, the operator is guided through the complete bending program, and all sheet handling activities such as turning and rotating are displayed optically and with text messages.

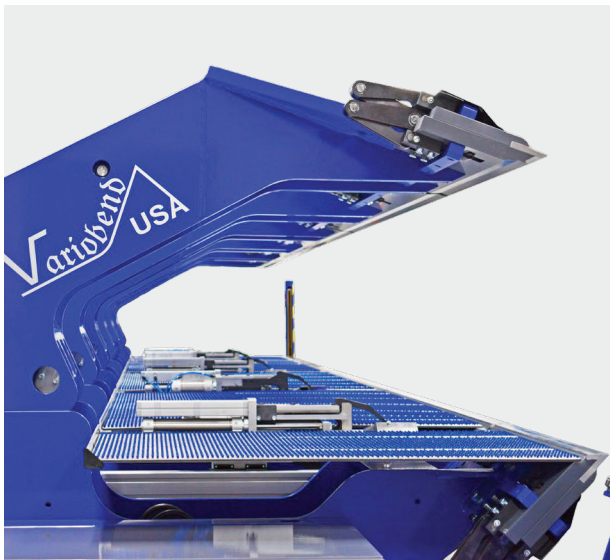
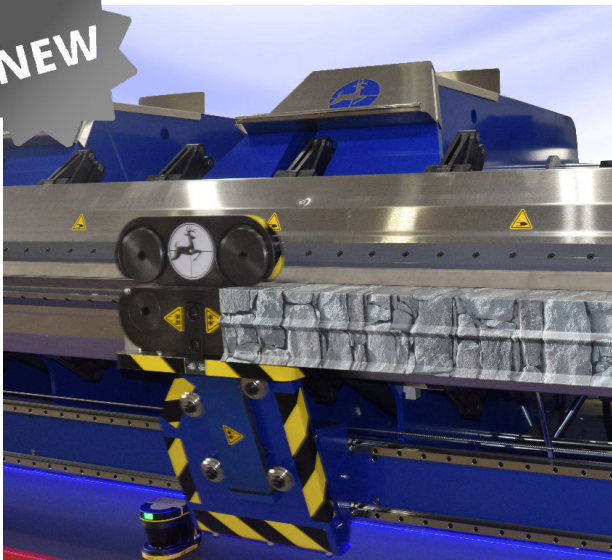
DOUBLE BENDER

In most operations a great deal of time is wasted turning and flipping long, awkward parts. In fact, far more time is spent handling than bending. Users of the Vario-bend Double Bender are multiplying the output on common profiles compared to their conventional bending machines.



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NEW



DOUBLE BENDER FEATURES

Bring efficiency to your operation with the new SLIT-FREI 2-way, post cut slit! Save time, material and money by reducing handling and scratching. Process full width flat sheets into finished product without pre-slitting!

Revolutionize your trim handling process!

The Variobend Double Bender features a massive clamping beam opening to allow for comfortable flipping of sheets and profiles or the ability to unroll small coils within the frames of the machine. Many times this feature eliminates the need for a second operator.

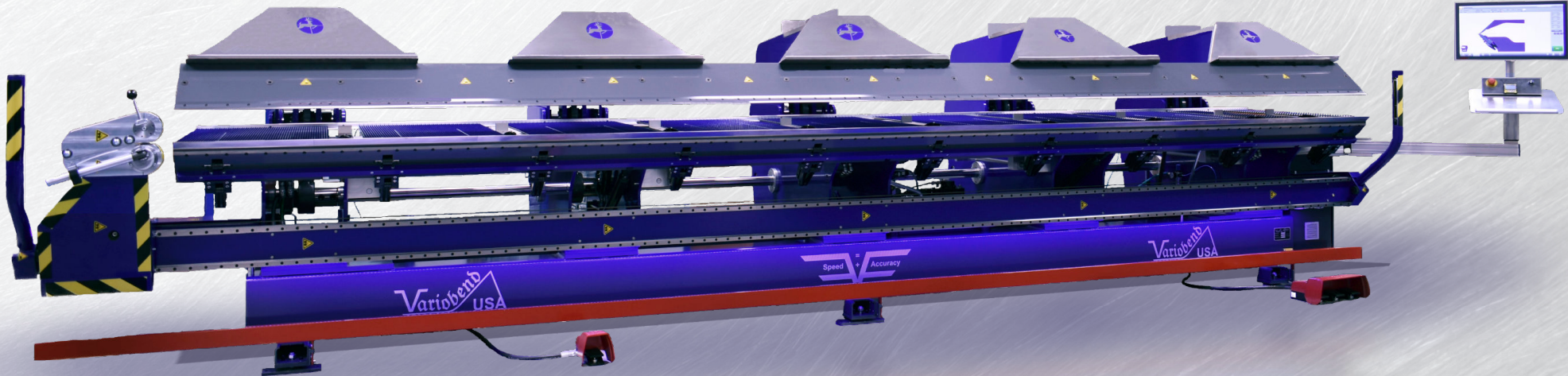
Large grippers with pneumatic clamping fingers for fully automatic bending (optional). Wide fingers prevent part marking. Gripper pressure is adjustable.

Model	Working Length	Bending / Cutting Capacity CQ Steel / AL. / SS	Max Bending Angle	Clamp Beam Opening	Insertion Depth*	Speed of Bending Beam	Back Gauge Range	Number of Back Gauge Fingers	Motor Size	Total Dimensions L x W x H	Weight
DB 2160	21'	0.059" - 16 ga./ 0.078"/0.031"	135°	28.5"	39.3"	0°-140°-0° Approx. 2.25 sec.	1/4" - 39 1/4"	9	30 HP	24' 3" x 6' 1" x 6' 7"	19,100 lbs.
DB 2860	28' 4"	0.059" - 16 ga./ 0.078"/0.031"	135°	28.5"	39.3"	0°-140°-0° Approx. 4 sec.	1/4" - 39 1/4"	12	30 HP	31' 8" x 6' 1" x 6' 7"	23,000 lbs.

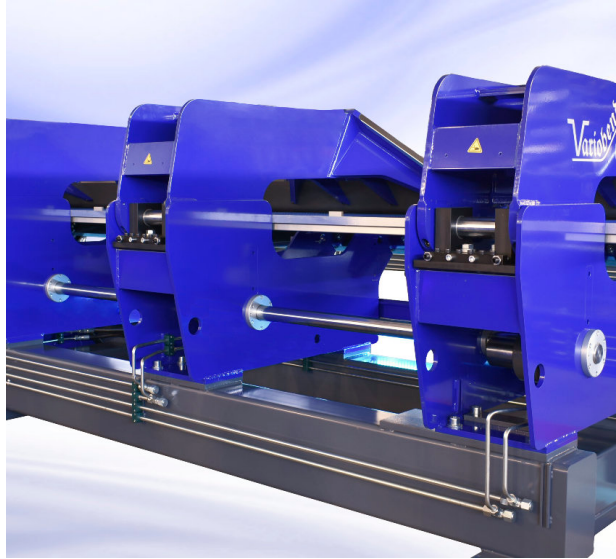
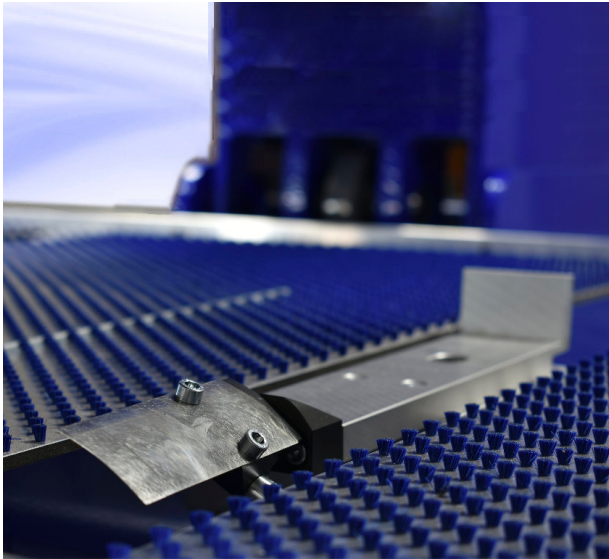
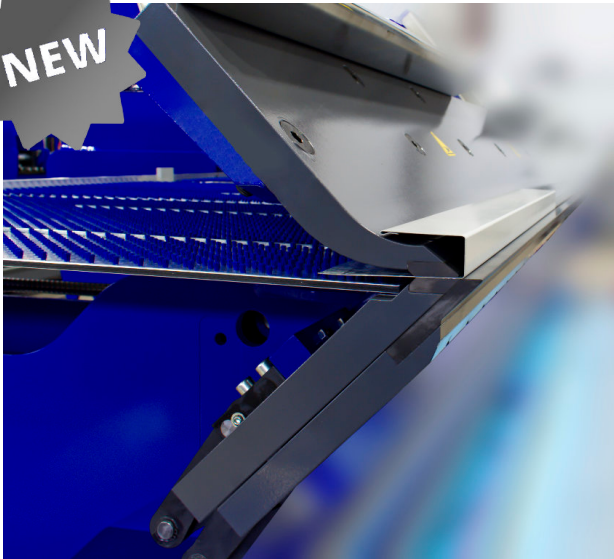
*49" depth is also optional

SINGLE BENDER

The SB Series is technically unique compared to other long folders on the market. One such difference is the geometry of the clamping beam. The Variobend Single Bender has a work envelope of 280 degrees which is far more than other benders on the market. It allows the operator to make profiles otherwise impossible and eliminates turning steps. Another improvement is the torsion bar clamping system that gives accurate level closing of the clamping beam even under the load of hemming operations. This feature includes an opening height that is infinitely variable by the touch screen control and allows hemming to maintain an even gap if required.



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SINGLE BENDER FEATURES

The Variobend offers two clamping beam geometry options. V-Standard offers a work envelope of 280°. The new V-Curved offers even more, allowing for deeper J profiles.

High-speed back gauge with curved-spring steel fingers is driven by ball screws with a range of 1/4" - 39 1/4". The back gauge can manage parts with a maximum taper of 4".

The torsion bar clamping system assures perfectly level clamping and CNC controlled hemming.

Model	Working Length	Bending / Cutting Capacity CQ Steel / AL. / SS	Working Height	Insertion Depth*	Total Dimensions L x W x H	Motor HP	Weight Lbs.
SB 1360	13' 5"	0.059" - 16 ga./0.078"/0.031"	39.4"	39.3"	18' x 5' 3" x 6' 7"	10	9,300
SB 2160	21'	0.059" - 16 ga./0.078"/0.031"	39.4"	39.3"	24' 7" x 5' 3" x 6' 7"	10	12,100
SB 2860	28' 4"	0.059" - 16 ga./0.078"/0.031"	39.4"	39.3"	31' 10" x 5' 3" x 6' 7"	30	16,500
SB 1340	13' 5"	0.078" - 14 ga./0.118"/0.040"	39.4"	39.3"	18' x 5' 3" x 6' 7"	18	9,900
SB 2140	21'	0.078" - 14 ga./0.118"/0.040"	39.4"	39.3"	24' 7" x 5' 3" x 6' 7"	30	13,900
SB 2840	28' 4"	0.078" - 14 ga./0.118"/0.040"	39.4"	39.3"	31' 10" x 5' 3" x 6' 7"	30	17,900

*49" depth is also optional



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