



## Schröder Group

The Schröder Group consists of Hans Schröder Maschinenbau GmbH, which is located in Wessobrunn, Germany, and SCHRÖDER-FASTI Technologie GmbH, which is located in Wermelskirchen, Germany.

Founded in 1949, Hans Schröder Maschinenbau GmbH unifies traditional and modern approaches in machine building: Successfully managed as a quality and customer-oriented, family-owned company, Hans Schröder Maschinenbau is specialized in the development of modern machine concepts for bending and cutting sheet metal.

The successful integration of the Fasti Company in 2006 and its worldwide presence make the Schröder Group one of today's leading providers of machines for bending, cutting, beading, flanging, and circular bending all types of sheet metal. The company's precision machines range from proven solutions for craftsmen to innovative, high-performance machines for automatic industrial production processes. Overall, the Schröder Group currently employs more than 240 people at various locations at home and abroad.



All information provided as a guide only  
and subject to change at all times.  
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# The manual folding machine 204

The manual folding machine type 204 is the frontrunner in the handicraft business: It is a must in workshops, in sample construction and in repair shops.



The small folder with the characteristics of a big one.

204	10/2
Working length (mm)	1020
Sheet thicken. (400 N/mm <sup>2</sup> ) (mm)	2,0
Machine length (mm)	1760
Machine width (mm)	360
Machine height (mm)	1320
Clamping beam stroke (mm)	220
Folding beam adjustment (mm)	60
Bottom beam adjustment (mm)	
Weight (kg)	460

Combined gauge with scale, pinion and rack Pneumatic bending support

The favourite in handicraft: essential in workshops, sample construction and repair shops.

### Clamping beam

- Sufficient stroke height for different tool geometries
- Drive with handwheel and bevelled gears
- Short change-over time by quick clamp system for tools
- Space for flanged parts

### Folding beam

- Adjustable for exact radius bending
- Adjustable angle gauge for identical bending angles
- Folding beam supported by gas spring

### Bottom beam

- Adjustable via radius tools

### Tools

- Blades ca. 700 N/mm<sup>2</sup> tensile strength
- Clamping beam: sharp nose blade 45°
- Folding beam: flat- and carrier blade

### Optional equipment

- Pneumatic bending support
- Special blades
- Segmentation of clamping beam: h = 60 mm or 120 mm
- Segmentation of bottom- and folding beam possible (only available as initial equipment)
- Combination gauge with scales, pinion, rack, range of adjustment 0 - 600 mm

# Tools for the folding machine

**Tool system WZS 1000**

**Standard blades**

- Sharp nose blade SA45 (45°)
- Carrier blade 17 mm
- Flat blade 10 mm

**Special blades**

- Clamping beam**
  - Sharp nose blade SB20 (20°)
  - Sharp nose blade SA80 (80°)
  - Radius blade RA
  - Angled rail WA
  - Radius blade cranked RB (up to radius r = 20 mm)
  - Goat's foot blade WB
  - Radius blade composed RC (up to r = 30 mm)
- Bottom beam**
  - Radius blade composed RD
  - Cranked goat foot radius blade RH
  - Special blade
- Folding beam**
  - Flat blade set down
  - Radius blade

**Segmented tool systems**

- Clamping beam**
  - a = 11 mm
  - b = 41 mm
  - h = 60 mm or 120 mm
  - Tensile strength 700 N/mm<sup>2</sup>
  - Segmentation of tools for 1020 mm: 3x25/2x30/2x35/3x40/45/50/2x100/2x200
- Bottom beam**
- Folding beam**
  - Form A and B