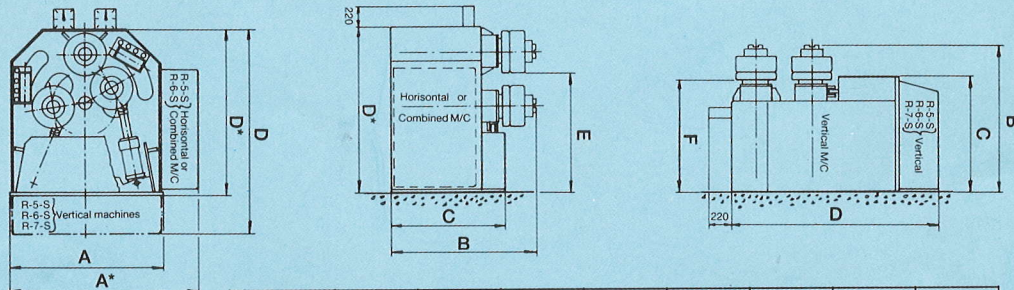


Capacities and Specifications

Section	R-5-S				R-6-S				R-7-S				
	With standard rolls		With special rolls		With standard rolls		With special rolls		With standard rolls		With special rolls		
	Max 120 x 12 Min 35 x 3	To Ø 1250 To Ø 430	Small profiles to min Ø:	310 mm	Max 150 x 16 Min 40 x 4	To Ø 2000 To Ø 600	Min 20 x 3	To Ø 360 mm	Max 160 x 20 Min 50 x 5	To Ø 1600 To Ø 600	Min 25 x 3	To Ø 400 mm	
	Max 100 x 12 Min 35 x 3	To Ø 1250 To Ø 600	"	400 mm	Max 120 x 15 Min 40 x 4	To Ø 1200 To Ø 800	Min 20 x 3	To Ø 500 mm	Max 150 x 20 Min 50 x 5	To Ø 1600 To Ø 900	Min 25 x 3	To Ø 500 mm	
	Max 120 x 13 Min 20 x 3	To Ø 1250 To Ø 400	"	310 mm	Max 140 x 15 Min 25 x 3	To Ø 1200 To Ø 480	Min	To Ø 360 mm	Max 160 x 20 Min 30 x 4	To Ø 1400 To Ø 600	Min 20 x 3	To Ø 400 mm	
	Max 100 x 11 Min 20 x 3	To Ø 1250 To Ø 400	"	350 mm	Max 120 x 13 Min 25 x 3	To Ø 1200 To Ø 480	Min	To Ø 400 mm	Max 150 x 15 Min 30 x 4	To Ø 1400 To Ø 600	Min 20 x 3	To Ø 400 mm	
	Max 140 x 15 Min 20 x 3	To Ø 1000 To Ø 400	"	310 mm	Max section modulus 100 cm ³				Max section modulus 185 cm ³				
	Max 100 x 30 Min 30 x 5	To Ø 1000 To Ø 400	"	310 mm	Max 120 x 40 Min 30 x 5	To Ø 1000 To Ø 470	Min	To Ø 360 mm	Max 150 x 45 Min 40 x 5	To Ø 1200 To Ø 570	Min	To Ø 400 mm	
	Max 250 x 30 Min	To Ø 1000 To Ø 400	"	310 mm	Max 250 x 40 Min	To Ø 1000 To Ø 480	Min	To Ø 360 mm	Max 350 x 50 Min	To Ø 900 To Ø 580	Min	To Ø 400 mm	
	Max 50 x 50 Min	To Ø 650 To Ø 400	Max 65 x 65 Min	To Ø 650 mm To Ø 310 mm	Max 60 x 60 Min	To Ø 600 To Ø 460	Max 85 x 85 Min	To Ø 1000 mm To Ø 360 mm	Max 75 x 75 Min	To Ø 750 To Ø 580	Max 100 x 100 Min	To Ø 1000 mm To Ø 400 mm	
	Small profiles		Max Ø 70 Min	To Ø 700 mm To Ø 310 mm	Small profiles		Max Ø 100 Min	To Ø 1000 mm To Ø 360 mm	Small profiles		Max Ø 110 Min	To Ø 400 mm To Ø 400 mm	
	Small profiles		Max OD 100 Min	To Ø 1000 mm To Ø 310 mm	Small profiles		Max OD 120 Min	To Ø 1200 mm To Ø 360 mm	Small profiles		Max OD 160 Min	To Ø 1500 mm To Ø 400 mm	
	Max 100 x 50 x 5,6 Min	To Ø 3000 To Ø 500	Max 90 x 90 x 5 Min	To Ø 2800 mm To Ø 510 mm	Max 100 x 60 x 6,3 Min	To Ø 3000 To Ø 700	Max 100x100x10 Min	To Ø 3000 mm To Ø 700 mm	Max 140 x 70 x 8 Min	To Ø 3500 To Ø 1000	Max 140x140x8 Min	To Ø 3500 mm To Ø 1000 mm	
	Small profiles		Max INP 200 Min	To Ø 900 mm To Ø 500 mm	Small profiles		Max INP 300 Min	To Ø 1100 mm To Ø 600 mm	Small profiles		Max IPE 330 Min IPE/INP 80	To Ø 1500 mm To Ø 700 mm	
	Small profiles		Max HEB 120 Min	To Ø 1500 mm To Ø 500 mm	Small profiles		Max HEB 160 Min	To Ø 2000 mm To Ø 600 mm	Small profiles		Max HEB 200 Min	To Ø 2400 mm To Ø 700 mm	
	Small profiles		Max UNP 200 Min	To Ø 900 mm To Ø 500 mm	Small profiles		Max UNP 300 Min UNP 60	To Ø 1100 mm To Ø 480 mm	Small profiles		Max UNP 320 Min UNP 80	To Ø 1200 mm To Ø 600 mm	
	Small profiles		Max UNP 200 Min	To Ø 1200 mm	Small profiles		Max UNP 300 Min UNP 60	To Ø 1600 mm To Ø 480 mm	Small profiles		Max UNP 320 Min UNP 80	To Ø 1800 mm To Ø 600 mm	
	Special rolls only		Max UNP 100 Min	To Ø 8000 mm	Special rolls only		Max UNP 140 Min UNP 60	To Ø 9000 mm To Ø 2000 mm	Special rolls only		Max UNP 180 Min UNP 80	To Ø 11000 mm To Ø 2500 mm	
	Max INP 100 Min	To Ø 2000 To Ø 1000	Max INP 120 Min	To Ø 1200 mm To Ø 800 mm	Max INP 120 Min	To Ø 2200 To Ø 800	Max INP 140 Min	To Ø 1500 mm To Ø 800 mm	Max INP 160 Min	To Ø 2600 To Ø 800	Max INP 180 Min	To Ø 1800 mm To Ø 800 mm	
	Special rolls only				Special rolls only		Max HEB 100 Min	To Ø 2000 mm	Special rolls only		Max HEB 140 Min	To Ø 2500 mm	
Max section modulus in material with tensile strength 60-70,000 PSI/42-50 kp/mm ² : Diameter of the rolls: Motor output:				48 cm ³ 385 mm 15 hp					100 cm ³ 460 mm 20 hp	185 cm ³ 550 mm 40 hp			

¹⁾ Indicated diameters are approximative. Smaller diameters can be bent with the standard rolls if the bending is made in more than one operation.

Dimensions



TYPE	A	A*	B	C	D	D*	E	F
R-5-S	1600	2100	1215	940	1930	1430	1030	895
R-6-S	1930	2430	1575	1200	2150	1650	1170	1170
R-7-S	2020	—	1845	1410	2800	—	1500	1345

A* and D* for horizontal or combined machines!

Standard equipment.

- Vertical bending shafts.
- Hydraulic infinitely variable adjustment of the two main bending rolls as well as the guide rolls.
- Hydraulic infinitely variable drive on all three rolls via low speed hydraulic motor.
- One set of standard rolls for flat bar, angle and T-sections and square bar.
- Hydraulically adjusted guide rolls.
- Portable or pendant push button control for all functions.
- Compensating and adjustable slip clutch for the central roll.
- Dial indicators showing the position of the lower rolls.
- Complete set of adjusting tools.
- Operators manual and service instructions.

Optional equipment.

- Combined horizontal/vertical design.
- Bending rolls for pipes.
- Bending rolls, combined for I and U beams the easy way.
- Bending rolls for I, U and H-beams the hard way.
- Bending rolls for round bar.
- Spiral bending rolls for production of rings from flat bars or pipes.
- Spiralling device for production of coils and spirals from flat bars and pipes.
- Bending rolls for other special profiles.
- Electronic speed control from the pendant control unit. (Standard equipment on R-7-S, optional equipment on R-5-S and R-6-S).
- Digital readouts showing the position of the lower roll.
- Micro-hydraulic adjustment of lower rolls.
- CNC-controlled machines.