

STANDARD ROLLS

One set of combined bending rolls for flat bar on the flat and on edge, angle leg out and leg in, are supplied as standard with the machines.

The rolls are hardened and located on the shafts by means of a single key, thus making it easy to adjust and change over the various special rolls that can be supplied as optional equipment.

Guide rolls, partly self-adjusting and necessary for bending of asymmetrical sections as well as scales indicating the positions of the lower rolls, are standard equipment.

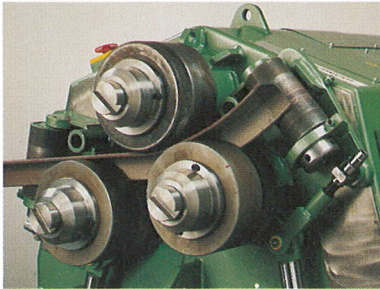
The machines can as an option be supplied in a combined horizontal/vertical design and can easily be turned 90° to function in the vertical or the horizontal position.



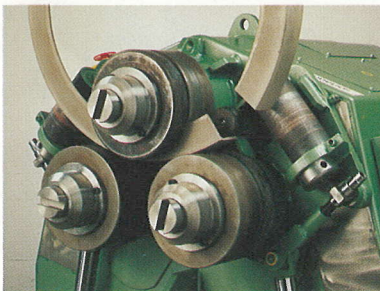
Model R-5 horizontal



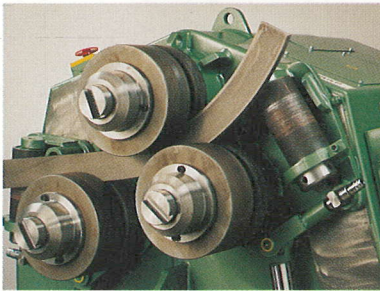
Model R-6 vertical.



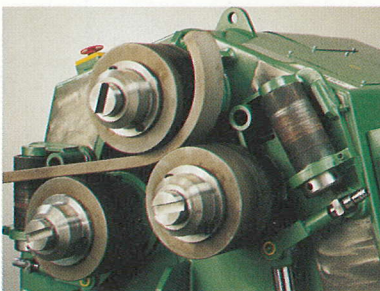
Angle leg-out. The guide rolls support the angle, avoiding twist.



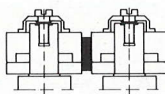
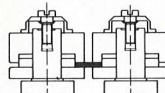
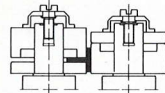
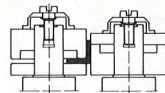
Angle leg-in. The guide rolls are used to avoid twist and deformation.



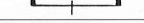
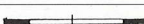
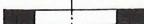

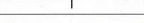
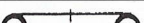


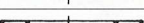
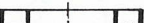
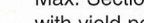




Flat bar on-edge



Flat bar on-flat



Capacities and specifications	R-4		R-5
	With standard rolls	With special rolls	With standard rolls
	Max 90x9 To Ø 900 ¹⁾ Min 20x3 To Ø 400	Small profiles to min. bending dia. 250 mm	Max 120x12 Min 35x3
	Max 70x7 To Ø 900 Min 20x3 To Ø 600	Small profiles to min. bending dia. 350 mm	Max 100x10 Min 35x3
	Max 90x10 To Ø 900 Min 15x3 To Ø 285	Small profiles to min. bending dia. 250 mm	Max 120x13 Min 20x3
	Max 70x8 To Ø 900 Min 15x3 To Ø 320	Small profiles to min. bending dia. 300 mm	Max 100x11 Min 20x3
	Max 90x10 To Ø 900 Min 15x3 To Ø 285	Small profiles to min. bending dia. 270 mm	Max 120x13 Min 20x3
	Max 100x18 To Ø 800 Min 20x5 To Ø 285	Small profiles to min. bending dia. 230 mm	Max 100x30 Min 30x5
	Max 200x30 To Ø 800 Min no limit. To Ø 285	Small profiles to min. bending dia. 250 mm	Max 250x30 Min no limit.
	Max 55x55 To Ø 550 Min no limit. To Ø 285	Small profiles to min. bending dia. 250 mm	Max 65x65 Min no limit.
	Small profiles	Max Ø 60 To Ø 600 Min no limit.	Small profiles
	Small profiles	Max od 100 To Ø 1500 Min no limit. To Ø 250	Small profiles
	Small profiles	Max INP 160 To Ø 800 Min no limit. To Ø 300	Small profiles
	Small profiles	Max UNP 160 To Ø 800 Min no limit. To Ø 300	Small profiles
	Small profiles	Max UNP 160 To Ø 900 Min no limit. To Ø 320	Small profiles
	Special rolls only	On request To Ø 1000 Up to INP 80	Special rolls only
	Special rolls only	On request To Ø 6000 Up to UNP 80	Special rolls only
Max. Section module in material with yield point 270 N/mm ² :		30 cm ³	
Diameter of the rolls:		275 mm	
Shaft diameters, Top/Lower:		105/105 mm	
Motor:		5,5 kW	
Rolling speed:		7 alt. 0-7 m/min	
Dimensions:		1400x1240x1210 mm	
Net weight:		2400 kg	
1) Indicated diameters are min. bending diameters in one or a few passes and are valid for max. sections.			

STANDARD EQUIPMENT

Horizontal bending shafts (R-4).

Vertical bending shafts (R-5 and R-6).

Three roll drive.

Hydraulic infinitely variable drive on all three rolls via low speed hydraulic motor (R-5 and R-6).

Compensating and adjustable slip clutch for the central roll.

One set of standard rolls for flat bar, angle and T-sections and square bar.

Guide rolls for bending of asymmetrical sections.

Portable push button control for roll rotation (R-4).

Portable push button control for all functions (R-5, R-6 and R-4 equipped with hydraulic drive).

Steel scales showing the positions of the lower rolls (R-4).

Dial indicators showing the positions of the lower rolls (R-5 and R-6).

Emergency stop palm buttons.

Complete set of adjusting tools.

Operators manual and service instructions.