Part. S0218

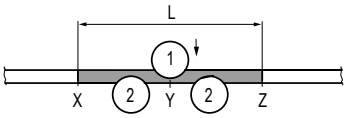
• Bending procedure

1 - Calculate the length of the section to be bent L.

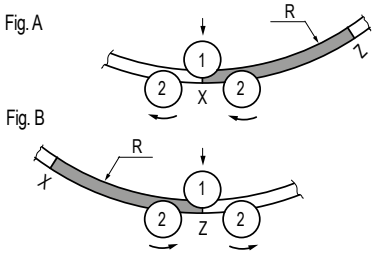
L = R • K R = bend radius.
K = bend coefficient.

bend angle (degrees)	30°	60°	90°	120°	150°	180°
bend coefficient K	0,5	1	1,5	2	2,5	3

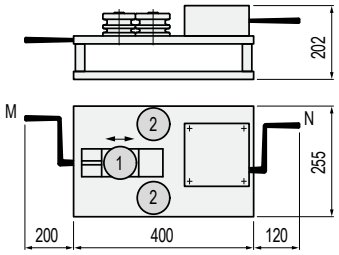
2 - Sign the length L on the profile to be bent, with (X) starting point, (Z) end point and (Y) middle point. Acting on handle (M), displace roller (1) to contact the profile



3 - Acting on handle (M), adjust the displacement to obtain the right radius (more displacement, smaller radius). Acting on handle (N), rollers (2) rotate and move the profile to position X (picture A) or Z (picture B). To obtain the desired radius it is necessary a minimum of two shifts.
To get a seamless transition from straight section to curve section and vice-versa it is necessary to exceed points X and Z by 20 mm.



Guide rail bending machine (manual)



Code	Weight kg
60151	23

- Functioning: manual.
- Packaging: 1 bending machine.

- The bending machine is made with 3 shafts for rollers, hand driven.
  Handle (M), displaces roller (1), to determine the bending radius.
  Handle (N), actions the rotation of rollers (2).

- The rollers are supplied as separate accessories.
  Each type of guide needs specific rollers, according to the table below. Double groove rollers allow two profiles bending at one time.

- Both internal and external bends can be made.