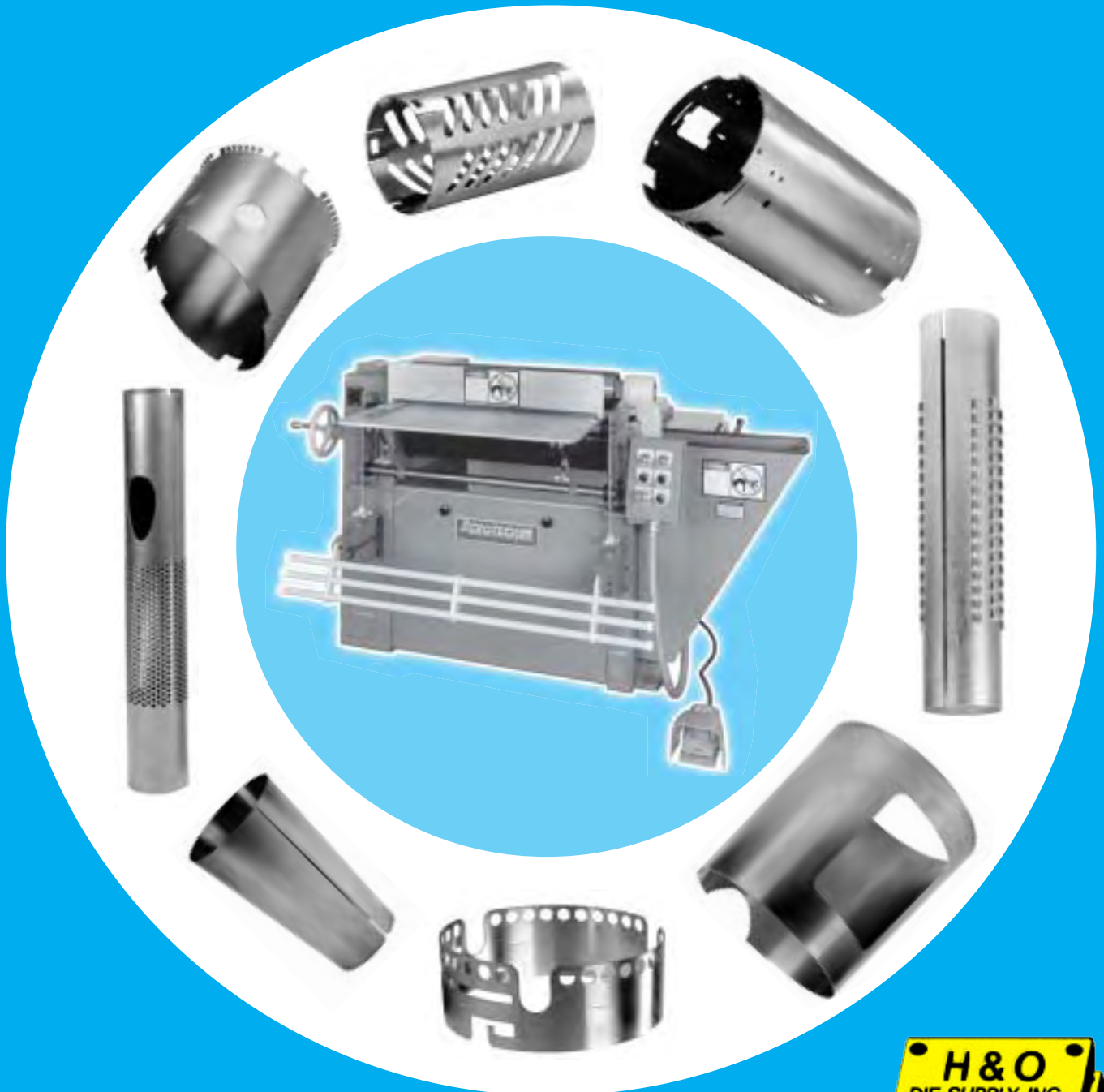


*Cylinders in one pass with...*



# Roll Bending Machines



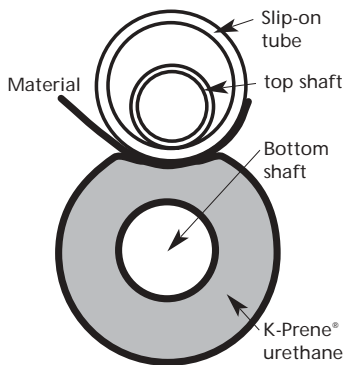
For Precision and Production



## The Benefits of "One Pass" Two Roll Bending Machines

- Roll parts with a minimum of flat on the leading and trailing ends for easier welding and better looking parts.
- Increased production and lower costs because no preforming required.
- Roll perforated and other difficult materials without fluting or kinking. Roll prefinished materials (stainless, aluminum, prepaint, etc.) without damaging parts.
- With easy set up and operation, most operators can be manufacturing production volumes following a brief introduction to the equipment.

## The Two Roll Principle



Under pressure, the top steel roll acts as a rotary punch penetrating the bottom roll. The bottom roll, a steel shaft coated with K-Prene® urethane acts as a female die, wrapping the material around the top roll. Rotation of both rolls produces accurate curving and rolling of complete or partial cylinders in one pass!



Our smaller models (1212, 1618, and 1824) are built to meet the demands of production involving small, light gauge parts. A manual lock-up is standard on these models. Pneumatic lock-up is available as an option for increased productivity. 120V 1PH standard wiring simplifies installation. 220 or 440V 3PH wiring is also available.

Model 1618

## LD and HD Models



Model HD-1248

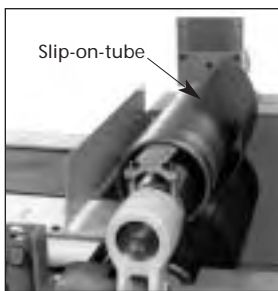
Our LD and HD models are designed for the production of larger, heavier gauge parts. The drop arm and the lower roll are positioned pneumatically on all LD machines and hydraulically on the HD models. Standard features adding to the productivity of and safety of these machines include 1) a digital readout that indicates roll position and allows for quick repeat set up, and 2) a safety kneebar which can be easily activated to quickly shut down all mechanical operations.



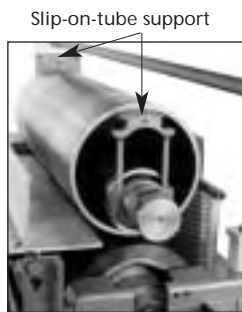
## Specifications

Model	Capacity mild steel		Working length of rolls		Diameter of top roll		Diameter of bottom roll		Rolling speed F.P.M.		Motor HP
	Std	Metric	Std	Metric	Std	Metric	Std	Metric	Std	Metric	
1212	12 ga.	2.7 mm	12 in.	305 mm	3 ½ in.	88.9 mm	9 in.	229 mm	22	670.6 CPM	1
1618	16 ga.	1.5 mm	18 in.	457 mm	3 ½ in.	88.9 mm	6 in.	152 mm	15	457.2 CPM	1
1824	18 ga.	1.2 mm	24 in.	610 mm	3 ½ in.	88.9 mm	6 in.	152 mm	15	457.2 CPM	1
LD-1418	14 ga.	1.9 mm	18 in.	457 mm	3 ½ in.	88.9 mm	9 in.	229 mm	23.2	707.1 CPM	1 ½
LD-1118	11 ga.	3.1 mm	18 in.	457 mm	4 in.	102 mm	9 in.	229 mm	23.2	707.1 CPM	1 ½
LD-1224	12 ga.	2.7 mm	24 in.	610 mm	4 in.	102 mm	9 in.	229 mm	23.2	707.1 CPM	1 ½
LD-31618	¾ in.	4.8 mm	18 in.	457 mm	5 in.	127 mm	9 in.	229 mm	19.8	603.5 CPM	3
LD-1024	10 ga.	3.4 mm	24 in.	610 mm	5 in.	127 mm	9 in.	229 mm	19.8	603.5 CPM	3
LD-1230	12 ga.	2.7 mm	30 in.	762 mm	5 in.	127 mm	9 in.	229 mm	23.2	707.1 CPM	1 ½
HD-31624	¾ in.	4.8 mm	24 in.	610 mm	6 in.	152 mm	12 in.	305 mm	16.0	487.7 CPM	5
HD-1030	10 ga.	3.4 mm	30 in.	762 mm	6 in.	152 mm	12 in.	305 mm	19.5	594.4 CPM	3
HD-1236	12 ga.	2.7 mm	36 in.	914 mm	6 in.	152 mm	12 in.	305 mm	19.5	594.4 CPM	3
HD-31630	¾ in.	4.8 mm	30 in.	762 mm	7 in.	178 mm	12 in.	305 mm	16.0	487.7 CPM	5
HD-1036	10 ga.	3.4 mm	36 in.	914 mm	7 in.	178 mm	12 in.	305 mm	16.0	487.7 CPM	5
HD-1248	12 ga.	2.7 mm	48 in.	1220 mm	7 in.	178 mm	12 in.	305 mm	19.5	594.4 CPM	3
HD31636	¾ in.	4.8 mm	36 in.	914 mm	8 in.	203 mm	12 in.	305 mm	16.0	487.7 CPM	5
HD-1048	10 ga.	3.4 mm	48 in.	1220 mm	8 in.	203 mm	12 in.	305 mm	16.0	487.7 CPM	5
HD-1160	11 ga.	3.1 mm	60 in.	1520 mm	8 in.	203 mm	12 in.	305 mm	16.0	487.7 CPM	5
HD-1672	16 ga.	1.5 mm	72 in.	1830 mm	8 in.	203 mm	12 in.	305 mm	22.9	698.0 CPM	1 ½
V-1006	10 ga.	3.4 mm	6 in.	152 mm	4 in.	102 mm	8 in.	203 mm	22	6.68 CPM	¾

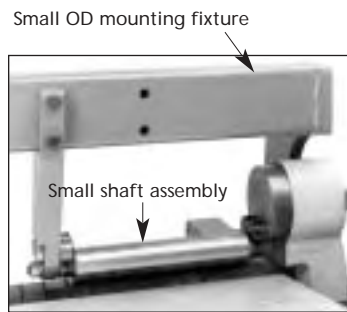
## Accessories



Slip-on-tube

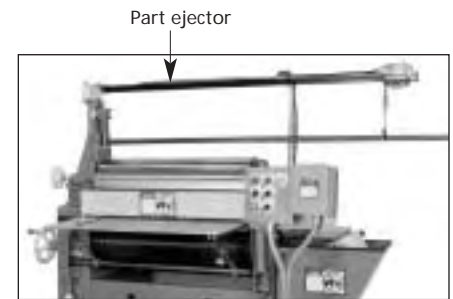


Slip-on-tube support



Small OD mounting fixture

Small shaft assembly



Part ejector

### Slip-on-tubes

When the diameter required is larger than what the top shaft will produce, a slip-on-tube is used. The tubes are developed per part size and increase the forming diameter capability of the top shaft. Changing the tubes is done quickly by simply slipping them on and off the top shaft as needed.

### Slip-on-tube support

This support mechanism prevents slip-on-tubes from pinching your rolled parts against the lower roll at the end of the cycle. It is adjustable to accommodate different tube sizes.

### Small shaft assemblies

These are for the production of small diameter parts. There are several standard sizes and custom sizes are possible, depending on requirements. *Note: These shafts require the small OD mounting fixture.*

### Part Ejectors

For increased production, part ejectors and part feeders can be developed for most models.



# Rock Solid and Ready to Roll!



Every model in Acrotech's unique line of Two Roll Bending Machines is designed and built for production and precision. These machines will roll a variety of materials and configurations into cylinders with virtually no flats on the ends!

For further information, please contact your area Acrotech distributor...



800-222-5441 • 214-630-6660 • FAX: 214-630-6660



*Specifications subject to change without notice.*