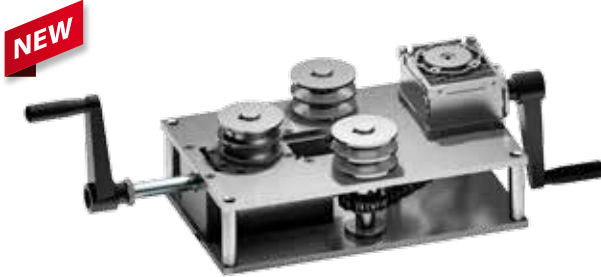


Product / chain guides and accessories

Part. 550 Guide rail bending machine (manual)



Code	Weight (Kg)
550 / 90466	23

MATERIALS: Steel and aluminium.

FEATURES: Manual functioning.

BOX QUANTITY: 1 machine.

ACCESSORIES: Bending rollers Part.547.

FUNCTIONING: The bending machine is made up of 3 roller shafts, operated manually by cranks.

The crank (M) displaces roller (1), to determine the bending radius.

The crank (N) activates the rotation of rollers (2).

The simultaneous rotation of handles (M) + (N) allows you to obtain the desired curve.

Bending rollers are supplied as accessories.

Each type of guide requires the use of its own bending rollers. The double groove rollers allow two guides of the same type to be bent simultaneously.

The bending machine allows you to create internal and external curves.

Bending procedure

1. Determine the length of the section to be bent L.

$$L = R \cdot K$$

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 guide to be bent and mark the beginning of the curve (X), the end (Z) and the center line (Y).
 - Place the guide between the rollers.
 - Acting on crank (M), displace the roller (1) in contact with the guide.

3.
 - Acting on crank (M), adjust the displacement of the roller (1) in order to obtain the right radius.
 - Acting on crank (N), rotate the rollers (2) clockwise / anti clockwise, moving the guide to position X (Fig. A) or Z (Fig. B). To obtain the desired radius curve, it is necessary a minimum number of shifts (minimum two radius increments). In order to obtain a seamless transition between the curve and the straight section, it is recommended to exceed the ends of the curve (points X and Z) by at least 20 mm.