

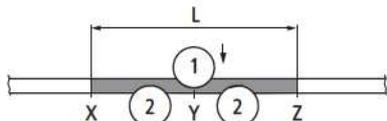
• Bending procedure

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

$$L = R \cdot K \quad \begin{array}{l} R = \text{bend radius.} \\ K = \text{bend coefficient.} \end{array}$$

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.

Fig. A

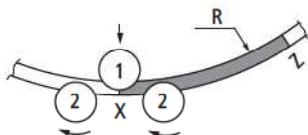
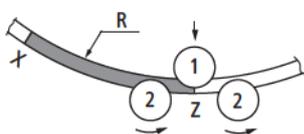
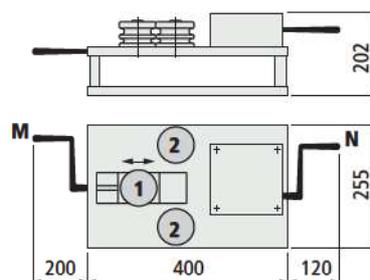


Fig. B



■ Guide rail bending machine (manual)

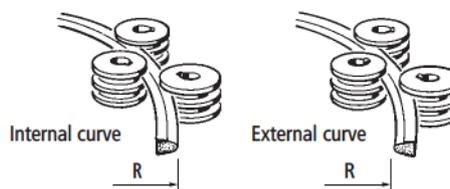
Part. 218



Part.	Code	Weight kg
218	60151*	23

- Functioning : manual.
- Packaging : 1 bending machine.
- Accessories : rollers for bending Part. 233.
- 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 profile bending at one time.

- Both internal and external bends can be made.



* = items highlighted are made to order and not in stock, minimum quantity may apply, consult our customer service for availability.

Part. 233



Rollers for bending

Part.	Types of guides to be bent	Inside bent rollers position	Inside bent rollers position	Code	No. of rollers
233	Part. 219 Part. 393 Part. 317 Part. 308 Part. 223			62791	4
	Part. 247			62811*	4
	Part. 346			64374*	4
	Part. 273			69232*	3
	Part. 596			621462*	3
	Part. 422			68179*	4
	Steel rods dia. 8 to 14* mm			62821*	3
	Part. 191 Part. 296			62801*	3

*= items highlighted are made to order and not in stock, minimum quantity may apply, consult our customer service for availability.

Part.	Types of guides to be bent	Inside bent rollers position	Inside bent rollers position	Code	No. of rollers
233	Part. 537 	 R R min = 500	 R R min = 500	689371*	4
	Part. 128 S 	 R R min = 500	 R R min = 800	64566*	4

- Material : steel (the rollers for Part. 346 - 273 - 596 - 356, are supplied in polyamide PA black).
- Packaging : 1 series of rollers.
- Double race rollers allow two guides to be bent at the same time.
- * = Steel rods dia.14 mm, can be bent only one at a time (use the lower groove to give less stress to the machine).

* = items highlighted are made to order and not in stock, minimum quantity may apply, consult our customer service for availability.