

Guide bending machine (manual) - Part. C50
Curvatrice guide (manuale) - Part. C50

Bending procedure / Procedimento di curvatura

1. Determinate development of L bend.

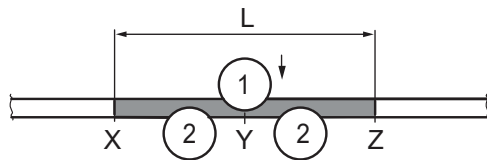
Determinare lo sviluppo della curva L.

$L = R \cdot K$ $R =$ Bending radius / *Raggio di curvatura*
 $K =$ Bending coefficient / *Coefficiente di curvatura*

Bending angle (degree) <i>Angolo di curvatura (gradi)</i>	30°	60°	90°	120°	150°	180°
K Bending coefficient <i>Coefficiente di curvatura K</i>	0,5	1	1,5	2	2,5	3

2. Report L length on guide to be bended and mark on it the beginning of the bend (X), the end (Z) and middle point (Y).
 Place the guide between pulleys.
 Through the lever (M), place the pulley (1) in touch with the guide.

Riportare la lunghezza L sulla guida da curvare e segnare su di essa l'inizio curva (X), la fine (Z) e la mezzeria (Y).
Posizionare la guida tra i rulli.
Mediante la manovella (M), portare il rullo scorrevole (1) a contatto con la guida.



3. Through the lever (M), regulate the movement of pulley (1) defining the increase of radius
 Through the lever (N), turn pulleys (2) clockwise and counterclockwise, placing the guide in position Fig. A and Fig. B. in order to get the desired bending radius it is necessary a minimum number of steps (minimum two increases of radius). Exceeding by minimum 20mm the ends of the bend (points X and Z) you get a better link between the bend and the rectilinear section.

Mediante la manovella (M), regolare lo spostamento del rullo (1) determinando l'incremento del raggio.
Mediante la manovella (N), ruotare i rulli (2) in senso orario / antiorario, portando la guida nella posizione di Fig. A e Fig. B.
Per ottenere la curva di raggio desiderato è necessario un numero minimo di passaggi (minimo due incrementi di raggio).
Superando di almeno 20 mm gli estremi della curva (punti X e Z) si ottiene un miglior raccordo tra la curva ed il tratto rettilineo.

Fig.A

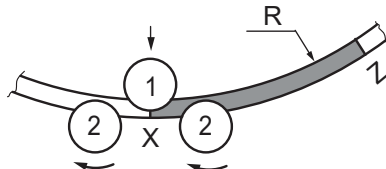
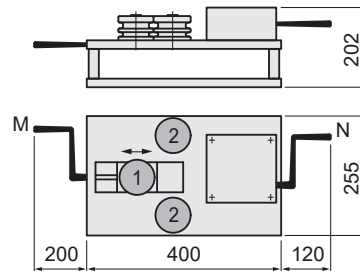
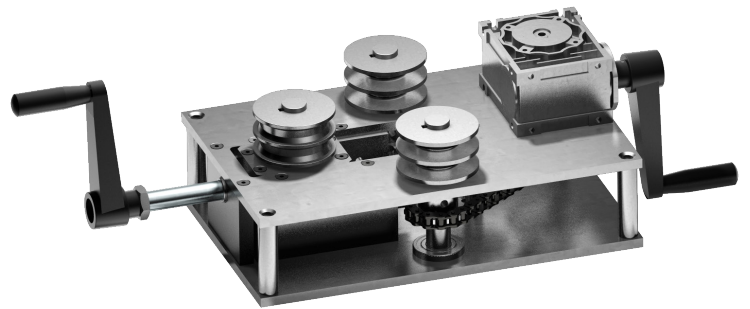
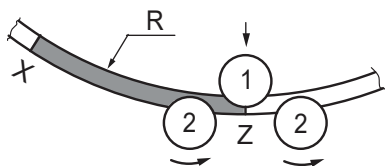


Fig.B



Type	Code	Weight
<i>Tipo</i>	<i>Codice</i>	<i>Peso (kg)</i>
C50	CPA00055	23

UK MATERIALS: Steel and alluminium

FEATURE: Manual working

WORKING: The bending machine is made by 3 shafts with pulleys moved manually by levers.

The lever (M) controls the movement of pulley (1), defining the increase of bending angle.

The lever (N) starts the rotation of pulleys (2).

Simultaneous rotation of levers (M)+(N), let get the desired bend.

Bending pulleys are supplied as accessories.

Each type of guide needs his own pulleys, pulleys with double grooves, let bend simultaneously two guides of the same type.

Bending machine let bend both internally and externally

IT MATERIAL: Acciaio e alluminio.

CARATTERISTICHE: Funzionamento manuale.

FUNZIONAMENTO: La curvatrice è costituita da 3 alberi portarulli, azionati manualmente da manovelle.

La manovella (M), regola lo spostamento del rullo (1), determinando l'incremento del raggio di curvatura.

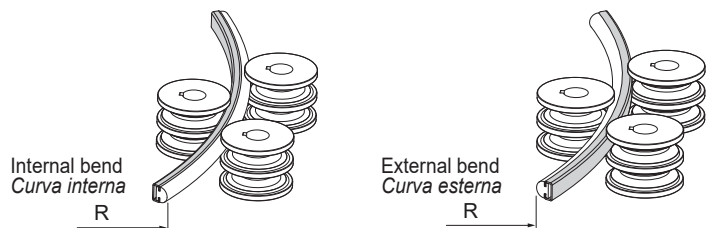
La manovella (N), aziona la rotazione dei rulli (2).

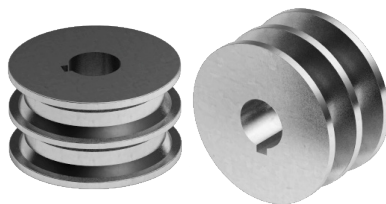
La rotazione contemporanea delle manovelle (M) + (N), consente di ottenere la curva desiderata.




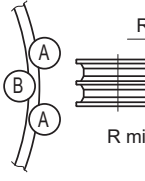
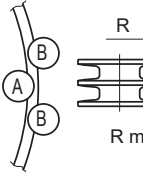

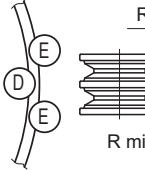
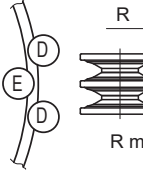


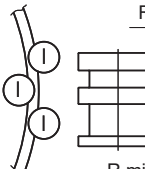
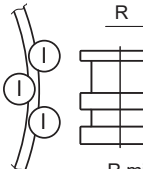

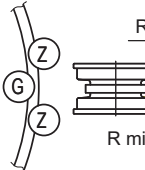
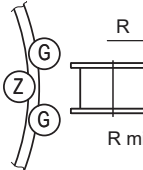

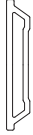
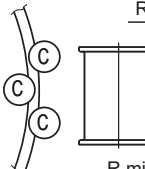
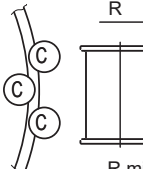

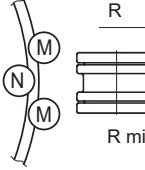
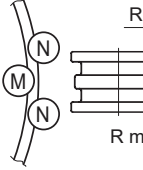

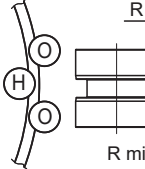
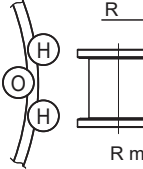

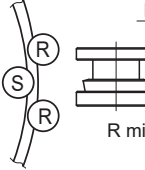
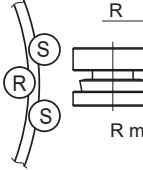
I rulli di curvatura sono forniti come accessori.

Ogni tipo di guida richiede l'utilizzo dei propri rulli di curvatura. I rulli a doppia gola, consentono di curvare simultaneamente due guide dello stesso tipo.

La curvatrice consente di realizzare curve interne ed esterne.


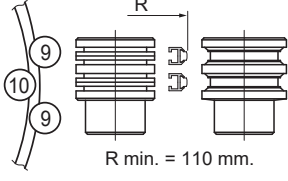
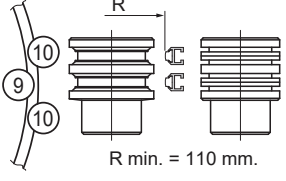

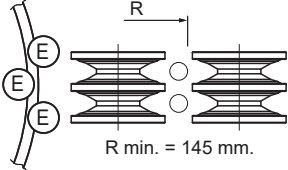
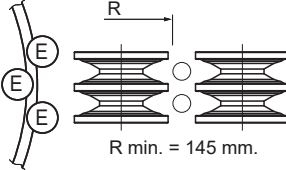

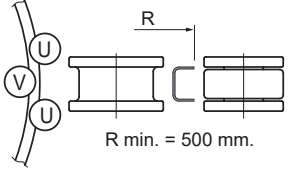
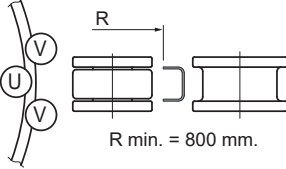
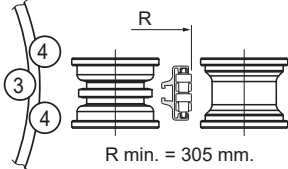
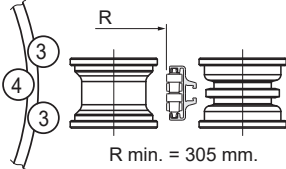
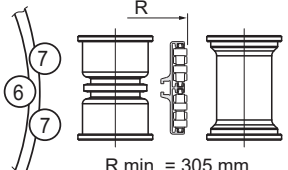
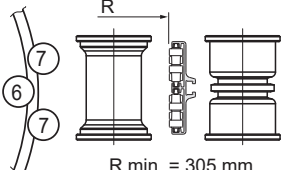
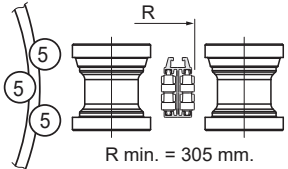
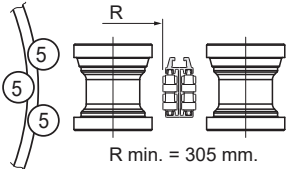
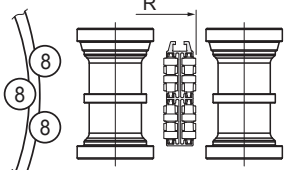
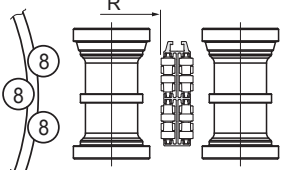


Bending pulleys (for guide bending machine) - Part. C47
Rulli di curvatura (per macchina curvatrice) - Part. C47


Type of guide Tipo di guida	Internal bend pulley position Curva interna posizione dei rulli	External bend pulley position Curva esterna posizione dei rulli	Tip Tipo	Code Codice	Quantity rulli	Material Materiale
Part.T54  Part.Q19  Part.Q18 	 <p>R</p> <p>R min. = 145 mm.</p>	 <p>R</p> <p>R min. = 145 mm.</p>	C47A	CPA00232	4	Steel Acciaio
Part.T73 	 <p>R</p> <p>R min. = 145 mm.</p>	 <p>R</p> <p>R min. = 145 mm.</p>	C47B	CPA00233	4	Steel Acciaio
Part.Q69  Part.Q20 	 <p>R</p> <p>R min. = 160 mm.</p>	 <p>R</p> <p>R min. = 160 mm.</p>	C47C	CPA00234	3	Polyamide Poliammide
Part.T81 	 <p>R</p> <p>R min. = 280 mm.</p>	 <p>R</p> <p>R min. = 280 mm.</p>	C47D	CPA00235	4	Steel Acciaio
Part.Q63 Part.C28  	 <p>R</p> <p>R min. = 200 mm.</p>	 <p>R</p> <p>R min. = 200 mm.</p>	C47E	CPA00236	3	Steel Acciaio
Part.T30 	 <p>R</p> <p>R min. = 500 mm.</p>	 <p>R</p> <p>R min. = 500 mm.</p>	C47F	CPA00237	4	Steel Acciaio
Part.Q85 	 <p>R</p> <p>R min. = 200 mm.</p>	 <p>R</p> <p>R min. = 200 mm.</p>	C47G	CPA00238	4	Polyamide Poliammide
Part.Q46 	 <p>R</p> <p>R min. = 450 mm.</p>	 <p>R</p> <p>R min. = 450 mm.</p>	C47H	CPA00239	4	Steel Acciaio

Bending pulleys - Part. C47
Rulli di curvatura - Part. C47



Type of guide <i>Tipo di guida</i>	Internal bend pulley position <i>Curva interna posizione dei rulli</i>	External bend pulley position <i>Curva esterna posizione dei rulli</i>	Type <i>Tipo</i>	Code <i>Codice</i>	Quantity <i>rulli</i>	Material <i>Materiale</i>
Part.Q38 	 <p>R min. = 110 mm.</p>	 <p>R min. = 110 mm.</p>	C47I	CPA00240	4	Steel <i>Acciaio</i>
 for Ø8 to Ø14 mm	 <p>R min. = 145 mm.</p>	 <p>R min. = 145 mm.</p>	C47L	CPA00241	3	Steel <i>Acciaio</i>
Part.C02 	 <p>R min. = 500 mm.</p>	 <p>R min. = 800 mm.</p>	C47M	CPA00242	4	Steel <i>Acciaio</i>
Part.T55 Part.Q67 Part.T06 Part.Q68 Part.T25	 <p>R min. = 305 mm.</p>	 <p>R min. = 305 mm.</p>	C47N	CPA00243	4	Polyamide <i>Poliammide</i>
Part.T56 Part.Q74 Part.T07 Part.T26 Part.Q77	 <p>R min. = 305 mm.</p>	 <p>R min. = 305 mm.</p>	C47O	CPA00244	4	Polyamide <i>Poliammide</i>
Part.T08 Part.Q75 Part.T27 Part.Q79 Part.T57	 <p>R min. = 305 mm.</p>	 <p>R min. = 305 mm.</p>	C47P	CPA00245	3	Polyamide <i>Poliammide</i>
Part.T58 Part.T19 Part.Q76 Part.T28 Part.Q79	 <p>R min. = 305 mm.</p>	 <p>R min. = 305 mm.</p>	C47Q	CPA00246	3	Polyamide <i>Poliammide</i>