

ROLL BENDING

Roll Bending Machines

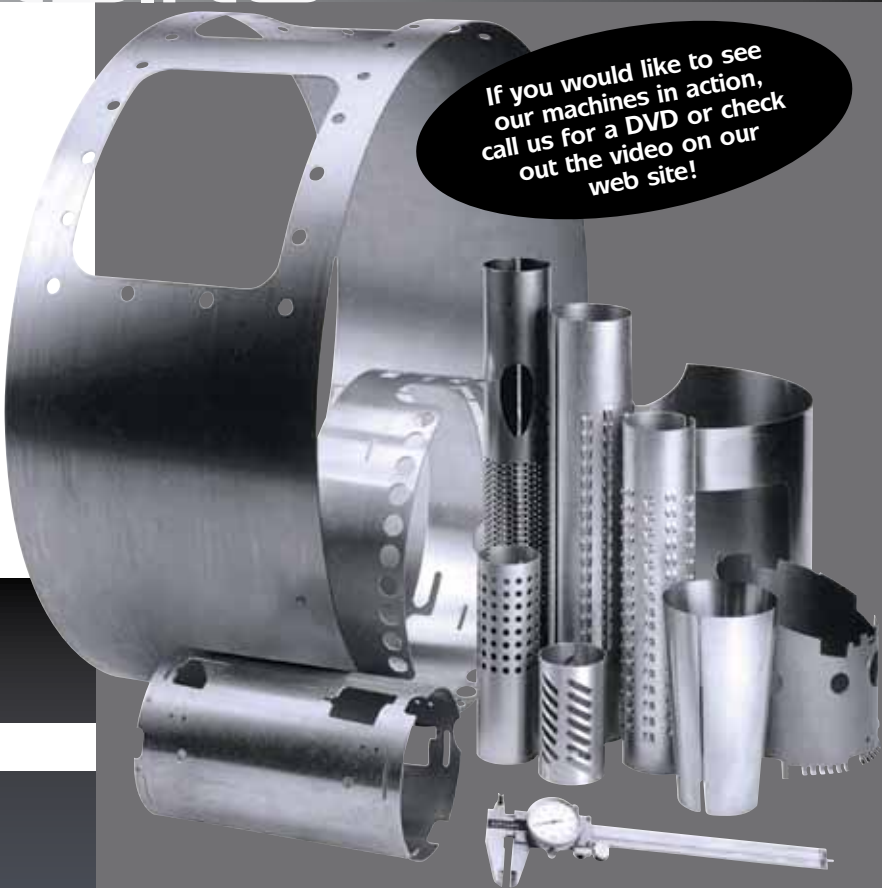
Acrotech/Di-Acro also manufactures a line of One Pass Roll Bending Machines. If you have large-volume needs for complete or partial cylinders with little or no flats on the ends, our machines will produce your parts quickly and cleanly. This includes polished materials containing large cutouts or perforations!

If you rolled parts sporadically or in small quantities, Acrotech/Di-Acro will custom roll them for you!

For a quote, contact one of our machine engineers or inquire at:

www.acrotechinc.com • www.diacro.com

If you would like to see our machines in action, call us for a DVD or check out the video on our web site!



The Benefits of "One Pass" Two Roll Bending Machines

Cylinders in one pass!

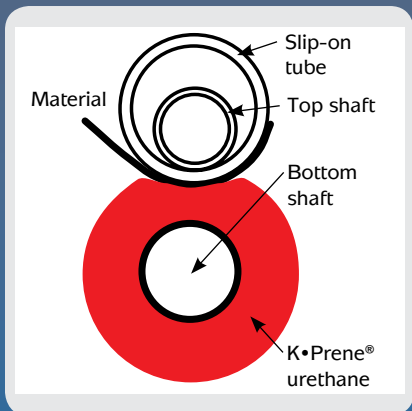
- > Roll parts with a minimum of flat on the leading and trailing ends for easier welding and better looking parts.
- > Increase production and lower costs because there is no preforming required.
- > Roll perforated and other difficult materials without fluting or kinking. Roll prefinished materials (stainless, aluminum, prepaint, etc.) without damaging parts.
- > Easy set up and operations with excellent repeatability and quick tooling changes.
- > Auto loading.
- > Additional operator protection (light curtains).
- > Special Hi alloy snaps for larger diameter to length ratios.

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 the **1212**, **1618**, and **1824** are built to meet the demands of production involving small, light gauge parts. Pneumatic lock-up is standard on all models for increased productivity. 120V 1PH standard wiring simplifies installation. 220 or 440V 3PH wiring is also available.

ROLL BENDING

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.	2.7mm	12"	305mm	3-1/2"	88.9mm	9"	229mm	22	670.6CMPM	1.0
1618	16 ga.	1.5mm	18"	457mm	3-1/2"	88.9mm	6"	152mm	15	457.2CMPM	1.0
1824	18 ga.	1.2mm	24"	610mm	3-1/2"	88.9mm	6"	152mm	15	457.2CMPM	1.0
LD-1418	14 ga.	1.9mm	18"	457mm	3-1/2"	88.9mm	9"	229mm	23.2	707.1CMPM	1.5
LD-1118	11 ga.	3.1mm	18"	457mm	4"	102mm	9"	229mm	23.2	707.1CMPM	1.5
LD-1224	12 ga.	2.7mm	24"	610mm	4"	102mm	9"	229mm	23.2	707.1CMPM	1.5
LD-31618	3/16"	4.8mm	18"	457mm	5"	127mm	9"	229mm	19.8	603.5CMPM	3.0
LD-1024	10 ga.	3.4mm	24"	610mm	5"	127mm	9"	229mm	19.8	603.5CMPM	3.0
LD-1230	12 ga.	2.7mm	30"	762mm	5"	127mm	9"	229mm	23.2	707.1CMPM	1.5
HD-31624	3/16"	4.8mm	24"	610mm	6"	152mm	12"	305mm	16.0	487.7CMPM	5.0
HD-1030	10 ga.	3.4mm	30"	762mm	6"	152mm	12"	305mm	19.5	594.4CMPM	3.0
HD-1236	12 ga.	2.7mm	36"	914mm	6"	152mm	12"	305mm	19.5	594.4CMPM	3.0
HD-31630	3/16"	4.8mm	30"	762mm	7"	178mm	12"	305mm	16.0	487.7CMPM	5.0
HD-1036	10 ga.	3.4mm	36"	914mm	7"	178mm	12"	305mm	16.0	487.7CMPM	5.0
HD-1248	12 ga.	2.7mm	48"	1220mm	7"	178mm	12"	305mm	19.5	594.4CMPM	3.0
HD-31636	3/16"	4.8mm	36"	914mm	8"	203mm	12"	305mm	16.0	487.7CMPM	5.0
HD-1048	10 ga.	3.4mm	48"	1220mm	8"	203mm	12"	305mm	16.0	487.7CMPM	5.0
HD-1160	11 ga.	3.1mm	60"	1520mm	8"	203mm	12"	305mm	16.0	487.7CMPM	5.0
HD-1672	16 ga.	1.5mm	72"	1830mm	8"	203mm	12"	305mm	22.9	698.0CMPM	1.5
V-1006	10 ga.	3.4mm	6"	152mm	4"	102mm	8"	203mm	22.0	6.68CMPM	0.75

800-345-0583

www.diacro.com

Fax: 651-345-3759

Every model in Acrotech/Di-Acro'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!



LD and HD Models

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 and safety of these machines include:

- 1) A digital readout that indicates roll position and allows for quick repeat set up.
- 2) A safety kneebar which can be easily activated to quickly shut down all mechanical operations.



Model V-1006

The model V-1006 has cantilevered rolls mounted in a vertical position. This unique design allows the parts to simply drop from the machine at the end of the rolling cycle, greatly increasing productivity. Its short, sturdy rolls are ideally suited for narrow parts such as clamps, brake bands, hole saws, light fixtures, etc.