

# Maximum section sizes and minimum inside bending diameters. (Data based upon steel 450 N/mm² tensile strength)

The right is reserved to change design, construction and specifications without notice. All dimensions are in mm, unless otherwise indicated. Minimum diameters shown in the table are given for indicative purpose only and are not binding. Smallest diameters could possibly be accomplished in more than one pass. In any case, the final result will depend on operator's ability.

Note - For square and rectangular tubes: smallest achievable diameters will depend on tolerance of distortion that the user is willing to accept. Values shown in the table could be reduced by adopting special rolls and suitable systems, such as filling the hollow sections with uncompressible materials.

### LEGEND:

- a - With standard rolls.
- b - One set of rolls required for each tube diameter.
- c - Special modular rolls for thin wall tubes in case the filling is necessary.
- d - In order to facilitate the operator and achieve a perfect result, one special roll is recommended for each angle size.
- e - With standard rolls up to Mod.305. For other models, two extra rolls are recommended.
- f - Special rolls.
- g - Special tooling.

MODELLO	301	302	303	304	305	306	307	308	309	310	311	312	313	314	
	PM PH HV	PH HV CN	PH HV CN	HV HV3 HV4 CN	PH HV HV3 HV4 CN	HV HV3 HV4 CN	HV HV3 HV4 CN	HV4 HV8V CN	HV4 HV8V CN	HV4 HV8V CN	HV4 HV8V CN	HV4 HV8V CN	HV4 HV8V CN	HV4 HV8V CN	
1		35 x 8 20 x 5	50 x 8 20 x 5	60 x 10 25 x 5	70 x 12 25 x 5	80 x 15 25 x 5	90 x 18 40 x 8	100 x 25 40 x 8	125 x 25 40 x 8	140 x 30 50 x 10	150 x 40 50 x 10	170 x 40 50 x 10	180 x 45 80 x 10	200 x 50 80 x 10	250 x 60 80 x 10
2		50 x 12	60 x 18	80 x 20	100 x 25	120 x 25	150 x 30	180 x 35	200 x 50	220 x 50	250 x 60	300 x 60	350 x 60	400 x 70	500 x 80
3		20	28	32	38	45	50	60	75	85	95	105	115	125	150
4		Ø 22	Ø 30	Ø 38	Ø 45	Ø 52	Ø 62	Ø 75	Ø 85	Ø 100	Ø 110	Ø 125	Ø 135	Ø 150	Ø 180
5		40 x 1,5 10 x 1	50 x 1,5 12 x 1	60 x 2 15 x 1	80 x 2 25 x 1,5	100 x 2 25 x 1,5	120 x 3 50 x 2	140 x 3 50 x 2	160 x 4 60 x 2	180 x 4 60 x 2	220 x 4 60 x 2	240 x 5 60 x 2	275 x 5 60 x 2	320 x 5 100 x 3	375 x 6 100 x 3
6		33,7 x 2,3 26,9 x 5	42,4 x 3,5 33,7 x 10	48,3 x 4 42,4 x 7	60,3 x 4 48,3 x 10	76,1 x 4,5 60,3 x 8	88,9 x 5 76,1 x 8	114,3 x 5 88,9 x 10	139,7 x 5 101,6 x 12	168,3 x 5,4 114,3 x 16	193,7 x 6,3 127 x 20	193,7 x 8 139,7 x 20	219,1 x 8 152,4 x 22	273 x 7,1 152,4 x 35	323,9 x 10 219,1 x 22
7		30 x 20 x 2	40 x 25 x 2	60 x 25 x 3	75 x 25 x 3	80 x 40 x 4	100 x 40 x 4	120 x 50 x 4	140 x 50 x 5	160 x 60 x 6	180 x 70 x 8	200 x 75 x 8	220 x 80 x 8	230 x 100 x 10	250 x 125 x 12
8		25 x 2	35 x 3	45 x 3	50 x 4	60 x 4	70 x 5	80 x 6	90 x 8	100 x 10	125 x 10	150 x 10	165 x 10	180 x 12	225 x 12
9		35 x 5 20 x 3	50 x 6 20 x 3	60 x 6 30 x 4	70 x 7 30 x 4	80 x 8 30 x 4	90 x 10 40 x 5	100 x 12 40 x 5	120 x 15 50 x 5	140 x 15 50 x 5	150 x 16 50 x 5	180 x 18 60 x 6	200 x 20 60 x 6	200 x 25 80 x 8	250 x 25 80 x 8
10		30 x 4 20 x 3	40 x 5 20 x 3	50 x 5 30 x 4	60 x 6 30 x 4	70 x 7 30 x 4	80 x 8 40 x 5	90 x 10 40 x 5	100 x 12 50 x 5	120 x 12 50 x 5	130 x 14 50 x 5	150 X 15 60 x 6	180 x 18 60 x 6	200 x 20 80 x 8	200 x 25 80 x 8
11		35	50	60	70	80	90	100	120	135	150	160	200	225	250
12		30	40	50	60	80	90	100	120	140	150	180	200	225	250
13		40	50	70	80	90	100	120	130	140	160	170	220	230	280
14		40 x 20	50 x 38	80 x 45	100 x 50	120 x 55	160 x 65	180 x 70	220 x 80	260 x 90	300 x 100	360 x 150	425 x 150	475 x 150	550 x 150
15		35 x 17	50 x 25	70 x 40	80 x 45	100 x 50	140 x 60	180 x 70	220 x 80	260 x 90	300 x 100	360 x 150	425 x 150	475 x 150	550 x 150
16				80 x 42	100 x 50	120 x 58	160 x 74	180 x 82	220 x 98	260 x 113	300 x 125	360 x 143	425 x 163	450 x 170	600 x 215
17							A 100	A 120 B 100	A 140 B 120	A 180 B 160 M 120	A 200 B 180 M 140	A 220 B 200 M 160	A 240 B 220 M 180	A 280 B 240 M 200	A 350 B 320 M 240
18								120 x 55 80 x 45	140 x 60 80 x 45	160 x 65 80 x 45	180 x 70 80 x 45	200 x 75 100 x 50	220 x 80 100 x 50	260 x 90 120 x 55	300 x 100 160 x 65
19								140 x 66 80 x 42	160 x 74 80 x 42	180 x 82 120 x 66	200 x 90 120 x 66	220 x 98 140 x 66	260 x 113 140 x 66	300 x 125 140 x 66	360 x 143 140 x 66
20								A 100	A 120 B 100	A 140 B 120	A 180 B 140 M 100	A 200 B 160 M 120	A 220 B 180 M 140	A 240 B 200 M 160	A 280 B 240 M 200
W cm³	1,5	3,5	6	10	16	25/37	45/80	70/120	100/170	150/250	200/350	250/400	350/600	600/1000	
INSTALLED POWER KW	1,5	2,8	3	3,5	4,9	7,5	11	15	18	20	22,5	30	37,5	56	
PROFILE FEEDING SPEED (m/min)	5,8	5,5	5,5	5,2	6,1	VARIABLE 0 - 7	VARIABLE 0 - 7	VARIABLE 0 - 7	VARIABLE 0 - 7	VARIABLE 0 - 7	VARIABLE 0 - 7	VARIABLE 0 - 7	VARIABLE 0 - 7	VARIABLE 0 - 7	VARIABLE 0 - 7
ROLLS DIAMETER	125	145	180	215	245	280	315	390	430	475	555	630	680	840	
SHAFTS DIAMETER	35	40	50	60	70	85	100	120	135	150	175	200	250	300	
WEIGHT (kg)	350	495	780	1090	1520	2600	3600	4450	6900	9000	11500	18000	24000	45000	