



The specialists for Plate Rolls, Angle Rolls, Dished Ends



Certified Quality System
UNI EN ISO 9001

Visano, 17/07/2012

STABAR Sp. z o.o.
ul. Jaktorowska 21
ZYRARDOW
POLAND

OFFER N. 638

FACCIN HYDRAULIC ANGLE BENDING ROLL SERIES RCMI 130

The FACCIN sections rolling machines series **RCMI** are equipped, as standard, with two hydraulically adjustable bending rolls (**double pinch design**). The guiding rolls are, as standard, **independantly adjustable in 6 directions**. Also, as standard, the machines are supplied with **universal rolls** for rolling all different profiles except hallow sections. The rolls are independantly driven via 3 hydraulic motors coupled to 3 planetary gearboxes.

MAIN TECHNICAL FEATURES

- Section modulus (Material with yield point 260 N/mm ²)	cm ³	100
- Shafts diameter	mm	130
- Rolls diameter	mm	410
- Infinitely variable speed	m/min	0-6
- Installed power	Hp	25
- Power Supply	380 V – 50 hz – 3 ph.	

The shafts are made of forged high tensile **NiCrMo alloyed steel**. They are **quenched, tempered and surface hardened**. The machine structure is made of high quality welded plates and it is **stress relieved after the welding**. All the main components of FACCIN section rolling machines are designed with **finite elements methods on C.A.D. workstations**. The dimensions of these components are the guarantee of the machine precision and reliability.

OVERALL DIMENSIONS

- Lenght	mm	1.900
- Width	mm	2.200
- Height	mm	1.900
- Approx. machine weight	Kg.	6.500

SERIES RCMI STANDARD EQUIPMENT

- **Hydraulic** adjustment of lower rolls;
- 3 independantly driven rolls (**3 hydraulic motors + 3 planetary gearboxes**);
- **Lateral guide rolls** independantly adjustable in 6 directions;
- **Automatic compensation** of peripheral rolls speed;
- **Set of wrench** for machine tooling;
- **Low voltage controls** centralized on mobile console on wheels;
- **Safety device with immediate stop of every movement**
- Instructions and maintenance manual according to CE standards.

TOTAL PRICE FOR THIS FACCIN EQUIPMENT EX-WORKS: EURO	48.500
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ACCESSORIES upon request :

- Complete set of universal modular rolls for standard sections	INCLUDED
- 2 digital readouts for rolls position	EURO 1.050
- 1 digital readout for rolls rotation	EURO 2.100
- Hydraulic pulling for H, I and U sections rolled over x-x axis	EURO 5.500
- Set of arm guide rolls for beams type HEA 100 rolled in the hard way	EURO 1.600
- Set of arm guide rolls for beams type IPE 100-120 rolled in the hard way	EURO 1.600
- Set of arm guide rolls for beams type UPN 100-120 rolled in the hard way	EURO 1.600
- Retaining roll for beams	EURO 1.900
- Set of distance rings	EURO 3.150
- Hydraulic vertical setting of guide rolls	INCLUDED 1.400
- Hydraulic angular setting of guide rolls	1.900
- Hydraulic in-out setting of guide rolls	
- Set of rolls to bend tubes	Different Sizes Available
- Numerical control PGS CLASSIC	EURO 14.000
- Numerical control ULTIMA PGS LASER	EURO 28.000
- transport DDU Zyrardow-Poland	EURO 1.800,-
- installation, training and put into operation of the machine at the client premises	EURO 5.000,-

SALE TERMS:
DELIVERY TIME: 60-90 days – unless sold

OFFER VALIDITY: 30 days

PAYMENT: 30% down payment at the moment of the order - 70% after acceptance tests in Italy prior to shipment or irrevocable and confirmed L/C payable at sight against shipping documents.

GUARANTEE: 12 months

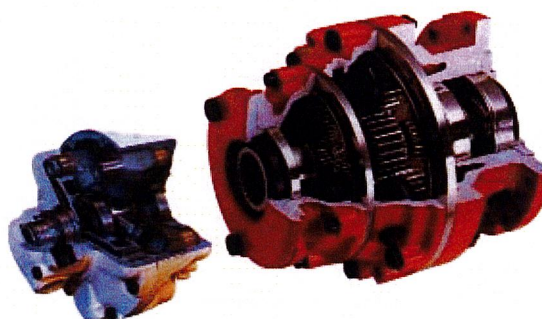
FACCIN SRL

FACCIN HYDRAULIC ANGLE BENDING ROLL SERIES RCMI

The Motors:

The FACCIN sections rolling machines are equipped, as standard, with 3 independent **hydraulically driven rolls** (3hydraulic motors coupled to 3 planetary gearboxes). This solution has four major advantages.

- 1) Minimum loss of energy for dissipation (efficiency near to 90%);
- 2) 100% Torque availability at maximum speed;
- 3) Automatic adjustment of peripheral speed between center and side rolls;
- 4) No overload on mechanical components due to differences in peripheral speeds.



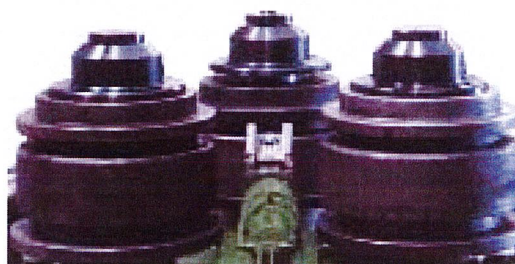
The guide rolls:

As standard, the side guiding rolls can be adjusted in **6 different directions independantly**. This means that it is possible to control in the best way the rolling process to avoid the usual deformations specially when asymmetrical sections are processed. The guiding system is provided as standard with **two rolls**: one is used to control the planarity of the rolling and the other is used to guide the profile flanges outside the forming area.

The universal rolls:

The sections rolling machines series RCMI are supplied as standard with universal rolls. These complete tooling consists of 4 rolls for each shaft (**total 12 standard rolls**). The shape of these rolls are specially designed to guarantee the possibility of rolling all the standard profiles in any principal bending direction (flat on flat, flat on edge, square bars, tees, angles, columns, channels, beams).

The rolls are made of high tensile NiCrMo alloyed steel. They are forged quenched, tempered, surface hardened and stress relieved. They are designed to bear the high compression loads located where the profile is in contact with the rolls. The rolls are guaranteed to resist for several years of heavy duty use without any damage on their surface.



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The Components:

The internal quality control checks 100% every part before the final assembly. The **certificates of chemical analysis and heat treatments** are available together with the maintenance manual. Also the results of **non-destructive tests** are at customer disposal for the final acceptance control before the delivery.

The manufacturing process:

Every machine is completely manufactured **in our facilities**. In this way we achieve the necessary tolerances to optimize the final machine's **ruggedness** and **bending precision**. **FACCIN's** machines are **all designed** by our engineers with new **CAD technologies**; every drawing is available in few minutes from the main computer **data base** even for machines which was delivered several years in the past. The computerized data base system allows us to give the best **after sales assistance** to our customers.

The **fabrication department** takes a special care of **welding** the high quality steel plates used for the main frame. The **machining** of the heaviest and most important components (base, uprights, shafts, rolls) is made with **our CNC machines**.

After a primarily quality control, the components go to the **assembly bay** where skillfull personel takes care of the construction of each machine.

When the assembling is completed the machine is **tested** by the quality control staff and then **painted** according to the customer's request.

A SHORT DESCRIPTION OF THE ACCESSORIES AVAILABLE:

The digital readouts:

The machines equipped with **digital readouts** are provided with LCD displays on the main control console. With this device, the operator, can easily control the actual bending radius performed by the machine. The accuracy of this reading system guarantees positioning tolerances lower than 0.1 mm.

The digital readout for rotation

With this system, the operator can control the developed length of the section he is rolling. The LCD display is located in the main consol together with the other controls.

Interchangeable rings for tubes

They are quoted upon request according to the size of the pipes to be rolled. It is possible to supply rolls with more than one groove to have the possibility to roll more pipe sizes with the same tooling.

Hydraulic arm for H, I and U sections

When rolling beams, columns and channels the hard way, it is necessary to minimize the web deformation. The pulling arm has the function to avoid any deformation of the web during the bending operations. It is adjustable by means of an hydraulic cylinder and the control of the correction load is visualized with oil pressure gauges. In order to obtain the best results, the hydraulic pulling arm has to be equipped with the proper tooling for each kind of section.

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A SHORT DESCRIPTION OF THE ACCESSORIES AVAILABLE:

Containing ring for H,I and U sections

This ring is designed to minimize the spiral deformation by guiding the profile flanges. It has to be mounted over the rolls in combination with the hydraulic pulling arm to obtain perfect results when H,I and U beams are rolled the hard way.

Spacers for beams rolled in the easy way

Even if it is possible to roll I,U and H beams the easy way with the standard equipment, better results can be obtained if spacers are used to guide the profiles web. The spacers have different height and can be combined to be used with all the standard sections up to maximum capacity of the machine.

Hydraulic vertical (in-out) setting of guide rolls

The side guiding rolls are adjustable in 6 different directions independently from the bending rolls. The adjustment in each direction can either be manual or hydraulic. Obviously the hydraulic setting is faster and easier than the manual one.

As the most used movement is the vertical one, FACCIN angle rolls series RCMI are supplied as standard with an hydraulic cylinder controlled with a joy stick from the main console.

Hydraulic angular setting of guide rolls

The angular setting of the guide rolls is often needed to adjust the direction of the supporting roller according to the bending radius. The standard setting is manual but, upon request, it can be hydraulically adjustable with a cylinder controlled with a joy stick located on the main console.

Hydraulic transverse setting of guide rolls

This option is suggested when many angles have to be rolled with leg-in. In fact, in order to avoid the twisting of the angle it is necessary to adjust continuously the guiding roller according to the actual bending radius. The hydraulic transverse setting of the guide rolls guarantees optimum quality of the final product in very short time.

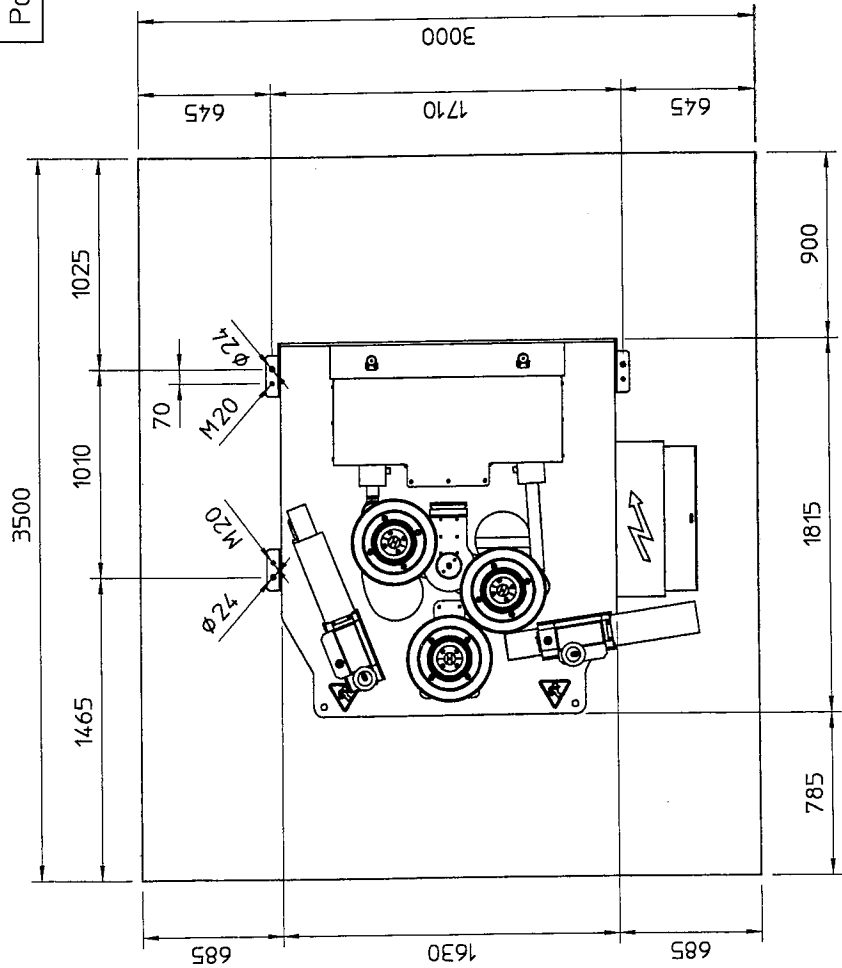
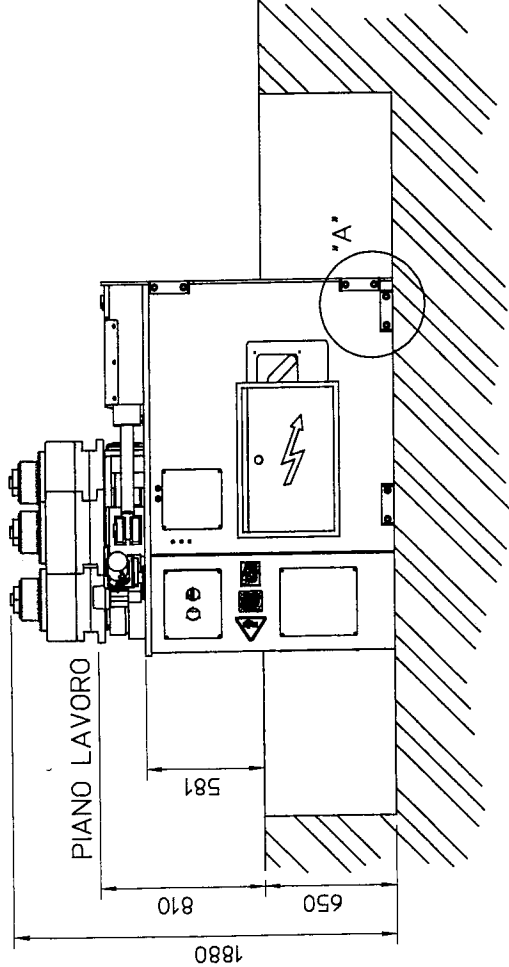


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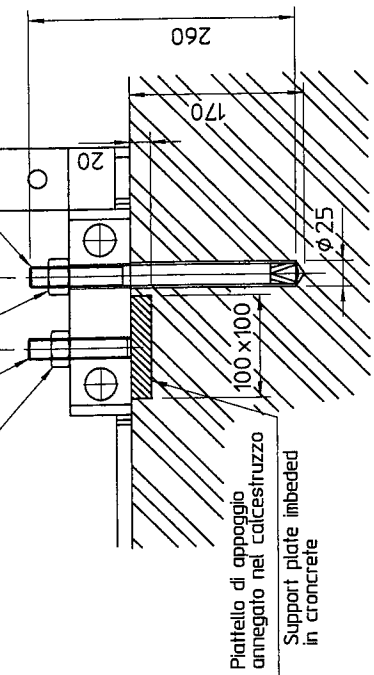


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N°4 Viti STEI M20x100
 N°4 Grub screws M20x100
 N°8 Dadi M20
 N°8 M20 Nuts

N°4 Tiranti Fischer RGM 20x260 + RM 20
 N°4 M20 bolts Fischer RGM 20x260 + RM 20



Piattello di appoggio
 annegato nel calcestruzzo
 Support plate imbedded
 in concrete

Particolare A Scala 1:5

- Grigliati o sistemi di copertura e loro fissaggio,
 non compresi nella fornitura
 - Wire-nettings or any other covering system and
 their fixings, are not included in the supply

La macchina dev'essere solidamente ancorata su fondazione in calcestruzzo
 adeguata al peso. Per ulteriori informazioni sul sistema di fissaggio si
 rimanda al catalogo 'Fischer'.
 The machine has to be layed and anchored on concrete foundations adaguated
 to the machine weight. To have more information about the pinching system,
 please see the catalogue 'Fischer'.

NB: Max carico specifico sul pavimento : ~2.5 kg/cm2
 Max specific load on the floor: ~2.5 kg/cm2

Piano di Fondazione - Piegaprofilati
 (Foundation Drawing - Angle Bending)

RCMI 130

CLIENTE



Data
 27.07.09

Firma
 SF

Scala

DISEGNO

Tav.

018.130.000.031

MODIFICHE