



























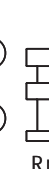


















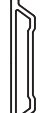







Part. S0233




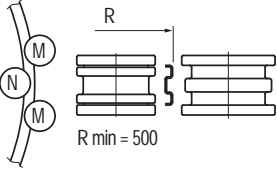
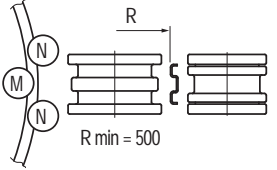

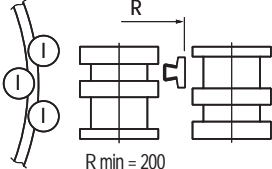
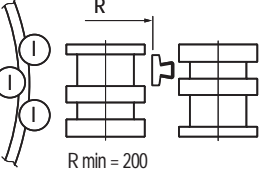

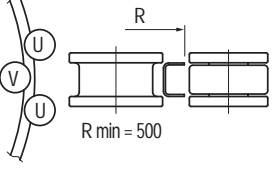
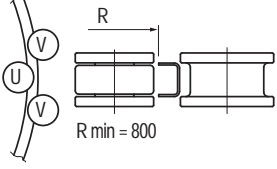
			Code		
S0233	S0219 S0393   S0317 S0308   S0223 S0715  	  <p>R R min = 145</p>	  <p>R R min = 145</p>	62791	4
	S0247 	  <p>R R min = 145</p>	  <p>R R min = 145</p>	62811	4
	S0346 	  <p>R R min = 110</p>	  <p>R R min = 110</p>	64374	4
	S0273 	  <p>R R min = 160</p>	  <p>R R min = 160</p>	69232	3
	S0768 S0767  	  <p>R R min = 160</p>	  <p>R R min = 160</p>	621993	3
	S0596 	  <p>R R min = 160</p>	  <p>R R min = 160</p>	621462	3
	S0422 	  <p>R R min = 280</p>	  <p>R R min = 280</p>	68179	4
	4 	  <p>R R min = 145</p>	  <p>R R min = 145</p>	62821	3
	S0191 S0296  	  <p>R R min = 200</p>	  <p>R R min = 200</p>	62801	3

 Best Seller

 Standard

 On request: minimum quantity may apply. Consult our Customer Service for availability.

Item code for order = Part. + Code

Part.	Types of guides to be bent	Internal curve position of rollers	External curve positions of rollers	Code	No. of rollers
S0233	S0537 	 R min = 500	 R min = 500	689371	4
	S0765 	 R min = 200	 R min = 200	621983	3
	S0128 S 	 R min = 500	 R min = 800	64566	4

- Material: steel (the rollers for Part. S0346 - S0273 - S0596 - S0356, 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).

• Bending procedure

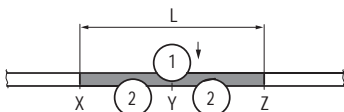
1 - Calculate the length of the section to be bent L.

$$L = R \cdot K$$

R = bend radius.
K = bend coefficient.

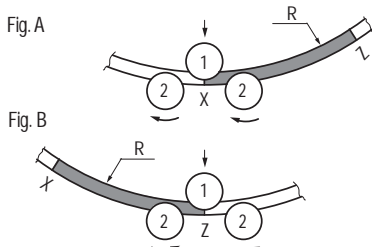
bend angle (degrees)	30°	60°	90°	120°	150°	180°
bend coefficient K	0,5	1	1,5	2	2,5	3

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

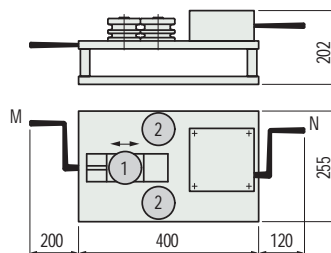


3 - Acting on handle (M), adjust the displacement to obtain the right radius (more displacement, smaller radius).
Acting on handle (N), rollers (2) rotate and move the profile to position X (picture A) or Z (picture B).
To obtain the desired radius it is necessary a minimum of two shifts.

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.



■ Guide rail bending machine (manual)

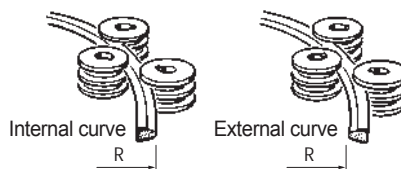


Code	Weight kg
60151	23

- Functioning: manual.
- Packaging: 1 bending machine.
- Accessories: rollers for bending Part. S0233.

- 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 profiles bending at one time.

- Both internal and external bends can be made.



Part. S0218



- Best Seller
- Standard
- On request: minimum quantity may apply. Consult our Customer Service for availability.

Item code for order = Part. + Code