

Gentlemen,

Many thanks for your above-mentioned purchase order which we confirm on the basis of our enclosed specified "Conditions for the Delivery of Machine Tools" as follows:

1 HYDRAULIC 4-ROLLER PLATE BENDING MACHINE TYPE VRM-hy 12' x 1 1/4"
for rounding plates upto 86,000 psi (60 kp/mm²) tensile strength
and 46,000 psi (32 Kp/mm²) yield point.

Technical Data

Max. width of plate	12'
Distance between the columns	12' 4"
Plate thickness for pre-bending	1 1/2"
Flat end at full width for 1 1/4" plate	X = 2 x th.
Flat end at full width for 1 1/2" plate	X = 2,4 x th.
Plate thickness for bending	1 3/4"
Roller diameter top and lower roll	595 mm
Roller diameter side rolls	480 mm

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18" Lower than std.

O.A. ht. of Top Support.

Diam Tolerance

= ± 0.1%

Min. bending diameter for 12' x 1 1/4"	28"
Min. bending diameter for 12' x 1 1/2"	36"
Number of rollers	4
Driven rollers	2 (top and bottom)
Drive for rollers over	2 hydro motors
Operating speed	158 IPM (4 m/min.)
Speed compensation between top and bottom roller	automatic
Reversing of the rotation direction	electro-hydraulic
Adjusting speed: bottom roller	0 - 8"/min. (0 - 200 mm/min.)
side rollers	0 - 28"/min. (0 - 700 mm/min.)
Motor power: main motor	150 HP
Operation of tipping bearing	hydraulic
Tilting of top roller	hydraulic
Control from swivelling steering panel	central
Adjustment of rollers	hydraulic
Indicating device for roller positions	4 x optical

Capacity chart VRM hy3,66/38_{ROLL} ϕ 595

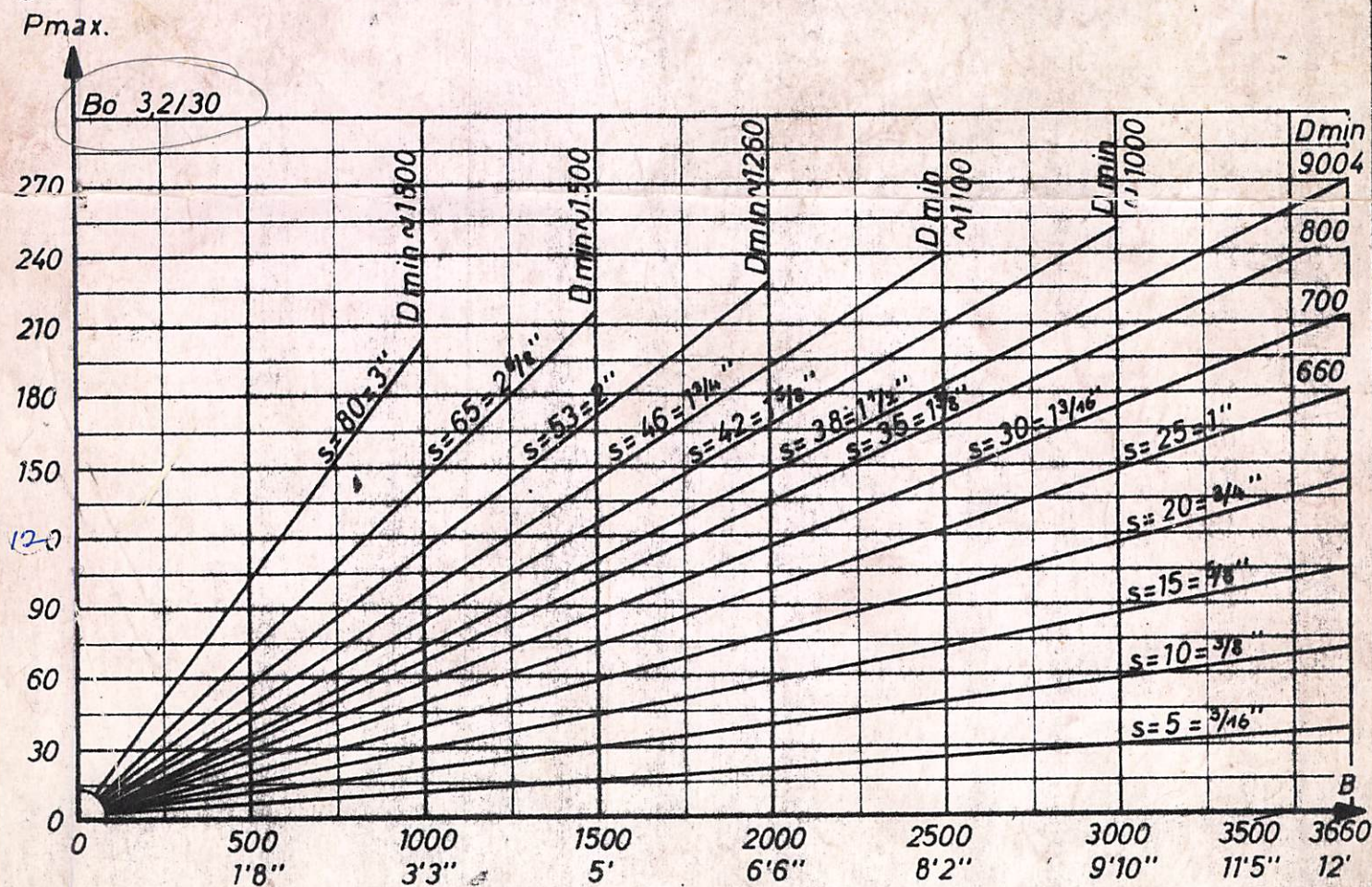
S = Plate thickness in mm

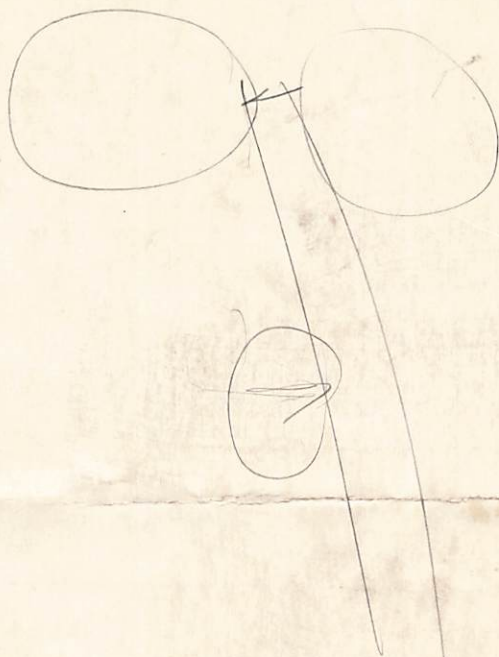
Mat. $\sigma_{S_{max}} = 32 \text{ kp/mm}^2$

B = Plate width in mm

X = Flat end $24 \times S$

P_{max} = max. permissible oil pressure for lower roll in atü (1atü = 14,2 psi)
for cone bending use only 35% of as indicated pressure as per cap. chart





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