

Roll Bender

Manually Powered

R-M10

Manual adjustment

Manually powered

Two hardened gear-driven rolls

2" flat / 1 1/4" tube capacity

Includes standard rolls



Storage cabinet



Roll Bender

Vertical and Horizontal

R-M30

Horizontal or vertical positioning

Foot pedal control

1½" square tubing / 2¼" round tubing

14 profile variations

Easy to operate

220V, single-phase



In horizontal position



Roll Bender

2 Driven Rolls



R-M50

Easy to operate

Scale and indicator depicts top roll position

2 powered rolls

Horizontal or vertical positioning

2 $\frac{3}{4}$ " round tube / 2" square capacity (14 ga.)

220V, single-phase



Roll Bender

Three Driven Rolls

R-H50-3

Three driven rolls

Hydraulic top roll positioning

Bends vertically or horizontally

Digital readout

2" square tubing max.

2³/₄" round tubing max.

220V, 3-phase



Shown with lateral angle guide rolls

Roll Bender

Three Driven Rolls

R-H60-3

Three driven rolls

Hydraulic top roll positioning

Bends vertically or horizontally

Digital readout

2 $\frac{3}{4}$ " square tubing max.

3 $\frac{3}{4}$ " round tubing max.

220V, 3-phase



Roll Bender Capacities

	R-M10		R-M30		R-M50		R-H50-3		R-H60-3	
	Max. Size OD / Wall	Min. Dia.	Max. Size OD / Wall	Min. Dia.	Max. Size OD / Wall	Min. Dia.	Max. Size OD / Wall	Min. Dia.	Max. Size OD / Wall	Min. Dia.
Mild Steel										
Flat Bar (Hard Way)	.75" (.188)	6.5"	.75" (.250)	12"	1.5" (.375)	20"	75" (.375)	12"	1.5" (.375)	15.75"
	1.2" (.375)	20"	2" (.375)	24"	2.3" (.375)	31.5"	2.3" (.375)	25.75"	3.25" (.50)	31.5"
Flat Bar (Easy Way)	.75" (.188)	6.5"	1.2" (.250)	15.75"	2.3" (.375)	24"	2" (.375)	12"	2" (.375)	15.75"
	2" (.375)	15.75"	3.25" (.50)	27.75"	3.9" (.50)	29.75"	3.9" (.50)	24"	4.75" (1.0)	24"
Solid Square Rod	.375"	6.5"	.375"	8"	.75"	15.75"	.5"	12"	.75"	15.75"
	.75"	20"	1.2"	35.5"	1.3"	47.25"	1.3"	24"	2"	31.5"
Solid Round Rod	.375"	6.5"	.375"	8"	1.2"	24"	.75"	12"	.75"	15.75"
	.875"	20"	1.2"	35.5"	1.3"	31.5"	1.3"	24"	2"	31.5"
Round Tube	1" (.065)	15.75"	1" (.065)	24"	1.2" (.078)	20"	1" (.065)"	15.75"	2.3" (.078)	20"
	1.2" (.078)	31.5"	2.3" (.065)	39.5"	2.75" (.078)	47.25"	2.75" (.078)	47.25"	3.9" (.078)	63"
Pipe	3/4" Sch 10	20"	3/8" Sch 10	12"	1" Sch 10	12.75"	1/2" Sch 10	12"	1" Sch 10	20"
	1" Sch 40	28"	1-1/2" Sch 10	24"	2" Sch 10	47.25"	2" Sch 40	39.5"	3" Sch 10	63"
Rectangular Tube	1.2" x .6" (.059)	24"	1.5" x .75" (.078)	31.5"	2" x 1.5" (.120)	59"	1.2" x .5" (.078)	15.75"	1.5" x .75" (.078)	20"
	1.5" x .75" (.078)	39.5"	2" x 1.2" (.120)	47.25"	2.75" x 1.2" (.078)	59"	2.75" x 1.2" (.120)	59"	3" x 1.5" (.120)	55"
Square Tube	.75" (.078)	24"	1.2" (.078)	31.5"	1.5" (.120)	31.5"	.75" (.078)	15.75"	1.5" (.078)	20"
	1.2" (.078)	35.5"	1.5" (.120)	47.25"	2" (.078)	78.75"	2" (.120)	63"	2.75" (.120)	63"
Angle Iron (Leg Out)	1.2" x 1.2" (.157)	15.75"			2" x 2" (.197)	33.5"	1.2" x 1.2" (.120)	15.75"	1.5" x 1.5" (.197)	20"
	1.3" x 1.3" (.157)	31.5"	1.5" x 1.5" (.197)	24"	2.3" x 2.3" (.250)	47.25"	2" x 2" (.250)	24"	2.75" x 2.75" (.275)	39.5"
Angle Iron (Leg In)			1.2" x 1.2" (.157)	15.75"	1.2" x 1.2" (.120)	27.75"	1.2" x 1.2" (.120)	24"	1.5" x 1.5" (.197)	24"
			1.3" x 1.3" (.197)	24"	2" x 2" (.250)	47.25"	2" x 2" (.250)	35.5"	2.75" x 2.75" (.275)	47.25"
T-Bar (Leg Out)	1.2" x 1.2" (.157)	15.75"	.75" x .75" (.120)	15.75"	2" x 2" (.250)	25.75"	1.2" x 1.2" (.120)	20"	1.5" x 1.5" (.197)	15.75"
	1.3" x 1.3" (.177)	24"	2" x 2" (.314)	24"	2.3" x 2.3" (.275)	35.5"	2.3" x 2.3" (.275)	31.5"	3" x 3" (.354)	39.5"
T-Bar (Leg In)	1.2" x 1.2" (.157)	15.75"	.75" x .75" (.120)	15.75"	2" x 2" (.250)	25.75"	1.2" x 1.2" (.120)	20"	1.5" x 1.5" (.197)	20"
	1.3" x 1.3" (.177)	24"	2" x 2" (.314)	24"	2.3" x 2.3" (.275)	35.5"	2" x 2" (.250)	31.5"	3" x 3" (.354)	47.25"
Channel (Legs Out)	1" x .5" (.177)	20"	1.2" x .5" (.157)	15.75"	2.3" x 1.2" (.250)	21.75"	1.2" x .5" (.157)	15.75"	2.3" x 1.2" (.250)	20"
	1.5" x .75" (.197)	27.75"	2" x 1" (.197)	24"	3" x 1.75" (.250)	39.5"	3" x 1.75" (.250)	31.5"	4.9" x 2" (.275)	31.5"
Channel (Legs In)	1" x .5" (.177)	20"	1.2" x .5" (.157)	15.75"	2.3" x 1.2" (.250)	27.75"	1.2" x .5" (.157)	24"	2" x 1" (.197)	24"
	1.5" x .75" (.197)	27.75"	2" x 1" (.197)	24"	3" x 1.75" (.250)	47.25"	3" x 1.75" (.250)	47.25"	4.7" x 2" (.275)	47.25"
Shaft Diameter	1.2"		1.2"		2"		2"		2.36"	
Shaft Speed (RPMs)	—		6		9		9		6	
Upper Rolls Diameter	3.85"		5.82"		6.10"		6"		8"	
Lower Rolls Diameter	4.64"		4.64"		6.10"		6.37"		8.5"	
Power Requirements	—		220V, Single-Phase		220V, Single-Phase		220V, 3-Phase		220V, 3-Phase	
	—		30 Amp		30 Amp		30 Amp		30 Amp	
Weight (Lbs.)	363		484		770		1122		1892	
Length	17.7"		25.5"		26"		32"		32.5"	
Width	20"		20"		35.5"		37.5"		44.8"	
Height	59"		55"		53.3"		59"		65"	
Driven Rolls	2		2		2		3		3	



Roll Bender Tooling

Lateral Angle Guide Rolls

R-M30	ALGR-30
R-M50	ALGR-35
R-H50	ALGR-50
R-H60	ALGR-60

Scrolling Attachment

R-M30	SA-30
R-M50	SA-35

Twisting Attachment

R-M30	TA-30
R-M50	TA-35



	R-M10		R-M30		R-M50		R-H50-3		R-H60-3	
Nylon Round Tube Rolls	NT-10R		NT-30R				NT-50R		NT-60R	
	3/4"	NRTR-M10-19.05	3/4"	NRTR-M30-19.05	3/4"	NRTR-M50-19.05	3/4"	NRTR-H50-19.05	3/4"	NRTR-H60-19.05
	1"	NRTR-M10-25.4	1"	NRTR-M30-25.4	1"	NRTR-M50-25.4	1"	NRTR-H50-25.4	1"	NRTR-H60-25.4
	1 1/4"	NRTR-M10-31.75	1 1/4"	NRTR-M30-31.75	1 1/4"	NRTR-M50-31.75	1 1/4"	NRTR-H50-31.75	1 1/4"	NRTR-H60-31.75
	1 1/2"	NRTR-M10-38.1	1 1/2"	NRTR-M30-38.1	1 1/2"	NRTR-M50-38.1	1 1/2"	NRTR-H50-38.1	1 1/2"	NRTR-H60-38.1
			1 3/4"	NRTR-M30-44.45	1 3/4"	NRTR-M50-44.45	1 3/4"	NRTR-H50-44.45	1 3/4"	NRTR-H60-44.45
			2"	NRTR-M30-50.8	2"	NRTR-M50-50.8	2"	NRTR-H50-50.8	2"	NRTR-H60-50.8
					2 1/4"	NRTR-M50-57.15	2 1/4"	NRTR-H50-57.15	2 1/2"	NRTR-H60-63.50
									3"	NRTR-H60-76.2
Steel Round Tube Rolls	ST-10R		ST-30R				ST-50R		ST-60R	
	3/4"	SRTR-M10-19.05	1"	SRTR-M30-25.4	1"	SRTR-M50-25.4	1"	SRTR-H50-25.4	1"	SRTR-H60-25.4
	7/8"	SRTR-M10-22.225	1 1/4"	SRTR-M30-31.75	1 1/4"	SRTR-M50-31.75	1 1/4"	SRTR-H50-31.75	1 1/4"	SRTR-H60-31.75
	1"	SRTR-M10-25.4	1 1/2"	SRTR-M30-38.1	1 1/2"	SRTR-M50-38.1	1 1/2"	SRTR-H50-38.1	1 1/2"	SRTR-H60-38.1
					1 3/4"	SRTR-M50-44.45	1 3/4"	SRTR-H50-44.45	1 3/4"	SRTR-H60-44.45
					2"	SRTR-M50-50.8	2"	SRTR-H50-50.8	2"	SRTR-H60-50.8
							2 1/4"	SRTR-H50-57.15	2 1/2"	SRTR-H60-63.5
									3"	SRTR-H60-76.2
Steel Pipe Rolls			SP-30R				SP-50R		SP-60R	
			3/4"	SRPR-M30-26.67	3/4"	SRPR-M50-26.67	3/4"	SRPR-H50-26.67	1"	SRPR-H60-33.4
			1"	SRPR-M30-33.40	1"	SRPR-M50-33.4	1"	SRPR-H50-33.4	1 1/4"	SRPR-H60-42.16
			1 1/4"	SRPR-M30-42.16	1 1/4"	SRPR-M50-42.16	1 1/4"	SRPR-H50-42.16	1 1/2"	SRPR-H60-48.26
					1 1/2"	SRPR-M50-48.26	1 1/2"	SRPR-H50-48.26	2"	SRPR-H60-60.32
							2"	SRPR-H50-60.32	2 1/2"	SRPR-H60-73.025
									3"	SRPR-H60-88.9