

METALWORKING SOLUTIONS SUPPLIED

**RS**<sup>TM</sup>  
MACHINERY

METALWORKING MACHINERY CATALOGUE EDITION 6

PART OF  
**UKMG**  
UK MACHINERY GROUP





If you work with metal, you work with machinery. You know your productivity depends on the quality and reliability of that machinery, and you know your competitive advantage depends on first class back-up service, parts and consumables. You need RS Machinery.

Here at RS Machinery we specialize in providing total machinery solutions for companies like yours. With two showrooms in Scotland and as part of the nationwide UK Machinery Group, we are ideally located to service your requirements. With the widest range of metalworking products, a responsive efficient service team, and a vast wealth of technical knowledge accumulated over forty years in business, RS Machinery is the market leader. We bring this value to your business.

#### Our Locations



#### Our Mission

"To supply innovative machinery solutions with passion and commitment, which increase productivity, create total client satisfaction and benefit our marketplace and community."



Call us today on 0800 980 7709  
or send an email [sales@rsmachinery.co.uk](mailto:sales@rsmachinery.co.uk) or visit [www.rsmachinery.co.uk](http://www.rsmachinery.co.uk)



## Our Showrooms

See our machines powered up and working in our Aberdeen and Glasgow showrooms where our technical sales engineers are happy to demonstrate and share their knowledge on your application. Like you, we are practical people.



## Our Range of Machinery

With the largest and most varied range of machinery stock in Scotland, both new and used, and as part of the UK Machinery Group, we offer you viable cost-effective machinery solutions. We are large enough to give you competitive pricing yet small enough to respond quickly to your needs. We offer flexible payment terms and finance packages to suit every budget. RS Machinery has been in the metalworking industry for over forty years and will support your investment in the future. Like our machines, we are reliable.



## Our Range of Consumables and Tooling

We know your machinery and can quickly identify the right tooling and consumable solution. With large stocks and a wide range of products catering for multiple machinery needs, we are an effective single supplier saving you time and money. We offer same day or next day delivery and can support your production with a bespoke supply solution. Like you, we value quality.



## Our Service

Our friendly service department provides expert engineers to repair, service and refurbish your machinery on a contract or ad-hoc basis. We carry large stocks of spare parts and have a worldwide sourcing solution for non-stock items. Like you, we value good service.



RS Machinery is part of  
UK Machinery Group



# Welcome to the new RS Machinery Metalworking Machinery product catalogue Edition 6



We have introduced over fifty new models including the new Robocut KZ300 CNC Plasma Cutting System which enables low cost in-house profile cutting. The new Morgan Rushworth HSR4 Hydraulic Section Bending range represents the latest four-roll technology with the ability to double pinch sections and tubes. The ZMM range of Lathes features, with machine capacities ranging from 325mm - 1600mm swing with CNC and Oil Country solutions available. The Sterling bandsaw range has been increased with the addition of four new vice feed automatic models and the new STC820 GSA twin column mitring head bandsaw.

The renowned Morgan Rushworth range now features the completely revised HSW and HST steelworkers ranging from 40 tonnes up to 175 tonnes with new NC control options. The new PBS CNC pressbrakes complement the proven PB CNC range and benefit from new CNC Controllers with provision for office based programming to maximise efficiency.

Please browse through this comprehensive catalogue and call us with your requirements. Our showrooms are open for live demonstration where our knowledgeable staff can recommend a solution.

## What we offer?

FREE ADVICE FROM  
OUR EXPERT TEAM



1ST CLASS AFTER  
SALES SERVICE



COMPLETE RANGE  
OF CONSUMABLES  
AND TOOLING



A RELIABLE AND  
HONEST SERVICE



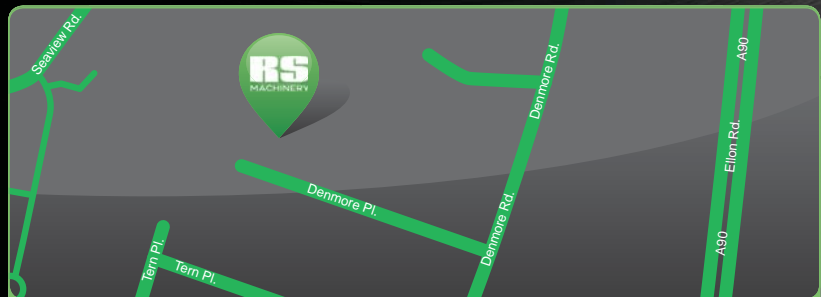
## Aberdeen Showroom

Denmore Place  
Denmore Industrial Estate  
Bridge of Don  
Aberdeen  
AB23 8JS

## Glasgow Showroom

265 Cambuslang Road  
Glasgow G72 7DB

## Where to find us?



Opening times 7:30am - 4:30pm Monday to Friday

Call us today on 0800 980 7709  
or send an email [sales@rsmachinery.co.uk](mailto:sales@rsmachinery.co.uk) or visit [www.rsmachinery.co.uk](http://www.rsmachinery.co.uk)

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## INTRODUCTION

The range of saws available from RS Machinery have been enhanced with many new products and improved features to our existing ranges. As main agents and stockists we are well able to provide superb after sales service through our own in house trained service engineers. Extended warranty, service contracts or routine service visits can be easily arranged through our service department. With our own bandsaw blade welding equipment and large stocks of coil from our manufacturer in Germany we can ensure continuous optimum performance for all our machines.

## Product overview

The Imaca circular saws are available in 315mm and 350mm blades and have the unique self centring double clamping vice. Maximum rigidity during the cut is achieved as the adjustable jaws can be positioned very close to both sides of the blade.



### Imaca



### Thomas

Thomas have been manufacturing circular saws in Italy for over sixty years. The range spans 250mm -350mm diameter blades and are available as pull down, semi automatic or fully automatic.

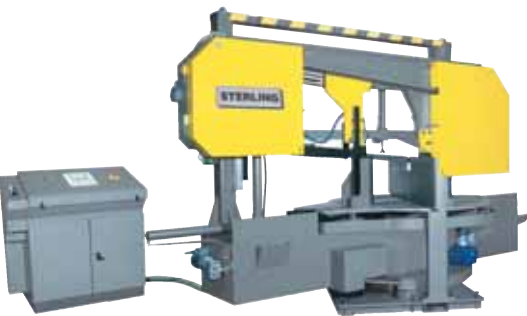
Bianco specialise in cast bow, high accuracy mitring head bandsawing machines. The range includes pull down, auto down feed, semi-automatic and fully automatic CNC machines with optional bundle clamping available.



### Bianco

### Sterling

The Sterling bandsaws range from the popular SRA230 DG double mitre up to large capacity 1100mm diameter machines. The traditional low bed height machines in auto down feed automatic are ideal for the engineering workshops, whilst the advanced SRA440 DGSA features large capacity double mitre , hydraulic cutting, hydraulic counter balancing, hydraulic clamping and hydraulic bow lock.



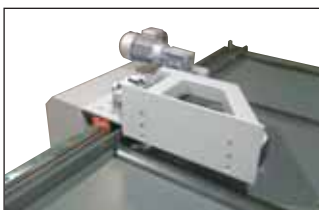
Bauer are one of the pioneers of bandsawing technology with over seventy years experience. The latest models, still completely manufactured in Germany specialise in double mitring bow capability in two capacities.



### Bauer

### Roller track and measuring systems

Our range consist of rollers complete with bearings for customers to construct their own frames, complete roller track in varying lengths, widths and weight capacities and the Pehu system of automatic track and measuring systems for increased productivity.



MODEL DFH 315H  
STOCK CODE 15320  
415V

MODEL DFH 315L  
STOCK CODE 15322  
415V



DOUBLE VICE WITH  
SELF CENTRING FEATURE.  
STANDARD ON  
DFH315 & DFH 350



MODEL DFH 350  
STOCK CODE 15321  
415V



## TECHNICAL SPECIFICATIONS

MODEL	DFH 315L   DFH 315H			DFH 350		
Capacity	90°	45°	60°	90°	45°	60°
○ mm	100	90	90	120	105	105
□ mm	100	90	90	100	100	100
▭ mm	140 x 90	100 x 90	100 x 90	140 x 100	100 x 100	100 x 100
Blade Size	mm 315ø x 40 bore			mm 350ø x 32 bore		
Blade Speed	rpm 18/36   36/72			rpm 41/82		
Cutting Speed	m/min 18/36   36/72			m/min 45/90		
Motor	Kw 0.75 - 1.3   1.1 - 1.5			Kw 1.1 - 2.2		
Length	mm 940			mm 970		
Width	mm 560			mm 560		
Height	mm 1530			mm 1550		
Weight	Kg 187			Kg 197		
Operation	Instant Pull Down			Instant Pull Down		
Vice	Manual			Manual		

## FEATURES

- Heavy Duty.
- Double vice-clamps both sides of the blade.
- Self centring vice-ensures optimum cutting position.
- Swivel head.
- Mitres 90° left and 90° right.
- Slitting facility.
- 2 speed motor.
- DFH 315H - standard speed range model for cutting mild steel.
- DFH 315L - low speed range model for cutting harder materials.
- Metal blade guard.
- Electric coolant pump.
- Base included.

# THOMAS Pull Down/Semi Automatic Circular Saws & ZIP Bandsaw

Sawing section



PULL  
DOWN

MODEL EXPORT 250  
STOCK CODE 15306  
240V

STOCK CODE 15302  
415V

BASE  
STOCK CODE 15304



PULL  
DOWN

MODEL 350 SUPER TECHNICS  
STOCK CODE 15308  
415V

BASE  
STOCK CODE 15305

MODEL SUPER CUT 315  
STOCK CODE 15307  
240V

STOCK CODE 15303  
415V

BASE  
STOCK CODE 15305



PULL  
DOWN

## TECHNICAL SPECIFICATIONS

MODEL	Export 250		Super Cut 315		350 Super Technics	
Capacity	90°	45° L + R	90°	45° L + R	90°	45° L + R
○ mm	70	60	95	90	120	100
□ mm	65	55	85	80	105	85
▭ mm	100 x 45	65 x 50	110 x 70	85 x 70	160 x 90	85 x 70
Blade Size	mm 250ø x 32 bore		mm 315ø x 32 bore		mm 350ø x 32 bore	
Blade Speed	rpm 40/80		rpm 41/82		rpm 22/44/88	
Cutting Speed	m/min 31/62		m/min 41/82		m/min 24/48/96	
Motor	Kw 0.75 - 0.95		Kw 1.3 - 1.9		Kw 1.3 - 1.7 - 2.4	
Length	mm 500		mm 700		mm 1100	
Width	mm 780		mm 780		mm 780	
Height	mm 1500		mm 1530		mm 1700	
Weight	Kg 115		Kg 148		Kg 186	
Operation	Instant Pull Down		Instant Pull Down		Instant Pull Down	
Vice	Manual		Manual		Manual	



### SEMI-AUTOMATIC

MODEL 350 SUPER TECHNICS SA  
STOCK CODE 15310  
415V



MODEL 350 SUPER TECHNICS  
FULLY AUTOMATIC  
STOCK CODE 15311  
415V

### AUTOMATIC



## TECHNICAL SPECIFICATIONS

MODEL	350 Super Technics SA		350 Super Technics Automatic	
Capacity	90°	45° R	90°	45° R
○ mm	120	100	120	100
□ mm	105	85	105	85
▭ mm	160 x 90	85 x 70	160 x 90	85 x 70
Blade Size	mm	350ø x 32 bore	350ø x 32 bore	
Blade Speed	rpm	22/44/88	22/44/88	
Cutting Speed	m/min	24/48/96	24/48/96	
Motor	Kw	1.3 - 1.7 - 2.4	1.3 - 1.7 - 2.4	
Length	mm	1100	2300	
Width	mm	900	1400	
Height	mm	1600	1600	
Weight	Kg	210	440	
Operation		Semi - Automatic	Automatic	
Vice		Pneumatic	Pneumatic	

The Thomas range of sawing machines has been manufactured in Italy since 1957. High quality components and attention to design has resulted in a truly heavy duty machine, well able to withstand years of intense use in today's busy workshops. The 350 Super Technics is equipped with a three speed motor and available in pull down or semi automatic operation with fast pneumatic power. The 350 Super Technics fully automatic machine can be programmed for multiple cuts, resulting in significant labour cost savings'.

## FEATURES

### CIRCULAR SAWS

- Heavy duty.
- Anti burr jaw.
- Mechanical coolant pump.
- Mitres 45° left and right.
- Quick lock vice.
- 240V machines available with one speed motor.
- Three speed motors standard with Super technics .

### ADDITIONAL FEATURES-350 Super Technics SA

- Pneumatic head descent with variable control and automatic return.
- Pneumatic vice.

### ADDITIONAL FEATURES-350 Super Technics Automatic

- Fully automatic cutting cycle.
- Pneumatic vice feed system.
- Shuttle vice facility for long cutting lengths.

MODEL TA400  
STOCK CODE  
15011  
415V



PICTURED WITH  
OPTIONAL BASE

MODEL TA400P  
STOCK CODE  
15000  
415V



PICTURED WITH  
OPTIONAL BASE

FAST  
PNEUMATIC  
CLAMPING

## FEATURES

- Heavy Duty.
- Fast aluminium cutting.
- Large capacity.
- Two quick action vices with teflon jaws.
- Either vice can be removed to cut awkward shapes.
- Mitring head 45° left and right.
- Inclinable head 45° left for compound cuts.
- Flat solid bed.
- Material length stop.
- Bar support roller.
- TA400P - fast pneumatic clamping automatically activated when head is pulled down.

## OPTIONS

- Base - stock code 15012.



## TECHNICAL SPECIFICATIONS

MODEL	TA400		TA400P	
Capacity	90°	45° L + R	90°	45° L + R
○ mm	140	130	140	130
□ mm	110	100	110	100
▭ mm	215 x 100	150 x 100	215 x 100	150 x 100
Blade Size	400ø x 32 bore		400ø x 32 bore	
Blade Speed	3000		3000	
Motor	3 Kw		3	
Length	915		915	
Width	810		810	
Height	1520		1520	
Weight	180 Kg		180	
Operation	Instant Pull Down		Instant Pull Down	
Vice	Manual		Pneumatic	

The Bianco and Thomas pull down mitre bandsaws are fast cutting, quiet running and ideal for sawing mild steel and stainless steel.

MODEL ZIP22  
Stock Code  
15312  
240V



MITRE AUTO  
DOWN FEED

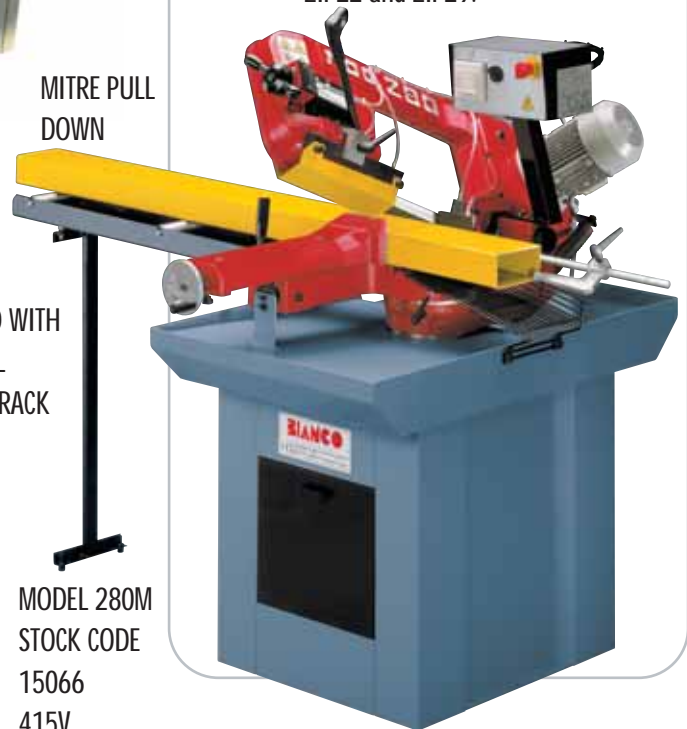
MITRE AUTO  
DOWN FEED



MODEL ZIP29  
Stock Code  
15311  
415V

MITRE PULL  
DOWN

PICTURED WITH  
OPTIONAL  
ROLLER TRACK



MODEL 280M  
STOCK CODE  
15066  
415V

## FEATURES

- Quick mitring swivel head up to 60°.
- Fast cutting.
- Cast bow construction.
- Carbide blade guides for high accuracy.
- 2 speed motor.
- Heavy Duty.
- Coolant System.
- Blade tension indicator.
- Safety interlock switch fitted to bandwheel cover.
- Material length stop.
- Pull down or auto down feed controller – ZIP22 and ZIP29.

## TECHNICAL SPECIFICATIONS

MODEL	ZIP22			ZIP29			280M		
Capacity	90°	45°	60°	90°	45°	60°	90°	45°	60°
○ mm	180	115	70	225	160	90	220	160	95
□ mm	180	110	70	200	140	90	220	155	95
▭ mm	200 x 150	125 x 110	70 x 70	240 x 160	155 x 115	90 x 100	260 x 140	160 x 140	95 x 95
Blade Size	mm 2085 x 20 x 0.9			2450 x 27 x 0.9			2450 x 27 x 0.9		
Cutting Speed	m/min 40/80			32/64			35/70		
Motor	Kw 0.37 - 0.75			0.55 - 1.1			0.5 - 1.1		
Length	mm 1300			1400			1200		
Width	mm 720			750			800		
Height	mm 1450			1600			1700		
Weight	Kg 180			225			300		
Operation	Pull Down/Auto Down Feed			Pull Down/Auto Down Feed			Instant Pull Down		
Vice	Manual			Manual			Manual		

## MITRING HEAD



# BIANCO Auto Down feed & Semi Automatic Mitring Bandsaws

Sawing section

MODEL 280MS  
STOCK CODE  
15069  
415V



MITRE AUTO  
DOWN FEED

MODEL 330MS  
STOCK CODE 15073  
415V



MITRE AUTO  
DOWN FEED

The Bianco bandsaws are manufactured totally in Italy with reliability and accuracy as the first consideration. All machines have modern cast bows in special alloys to ensure one of the highest precision bandsaw ranges available. The production models start at the popular 280M pull down detailed on the previous page and extend to automatic feeding machines with automatic mitring. Quality electrical components are fitted to all models and quiet hydraulic pumps and fittings ensure a long working life.

MITRE AUTO  
DOWN FEED



MODEL 420MS  
STOCK CODE  
15083  
415V

## TECHNICAL SPECIFICATIONS

MODEL	280MS			330MS			420MS		
Capacity	90°	45°	60°	90°	45°	60°	90°	45°	60°
○ mm	220	160	95	260	200	120	300	240	170
□ mm	220	155	95	220	190	115	260	230	170
▭ mm	260 x 140	160 x 140	95 x 95	330 x 140	200 x 130	120 x 100	420 x 180	250 x 180	170 x 170
Blade Size	mm 2450 x 27 x 0.9			3010 x 27 x 0.9			3270 x 27 x 0.9		
Cutting Speed	m/min 35/70			35/70			35/70		
Motor	Kw 0.5 - 1.1			0.7 - 1.4			0.7 - 1.4		
Length	mm 1200			1400			1600		
Width	mm 800			900			1000		
Height	mm 1700			1900			1900		
Weight	Kg 320			390			480		
Operation	Pull Down/Auto Down Feed			Pull Down/Auto Down Feed			Pull Down/Auto Down Feed		
Vice	Manual			Manual			Manual		



PICTURED WITH OPTIONAL ROLLER TRACK

MODEL 330SAE  
STOCK CODE 15062  
415V

MITRE SEMI AUTOMATIC



MODEL 420SAE  
STOCK CODE 15084  
415V

MITRE SEMI AUTOMATIC

## FEATURES

- Quick mitring swivel head up to 60°.
- Fast cutting.
- Cast bow construction.
- Swarf brush.
- Carbide blade guides for high accuracy.
- 2 speed motor.
- Heavy Duty.
- Coolant System.
- Blade tension indicator.
- Safety interlock switch fitted to bandwheel cover.
- Material length stop.
- 280MS/330MS/420MS - Special feature, choose between instant pull down or switch to automatic gravity down feed with variable control.

## ADDITIONAL FEATURES 330SAE/420SAE

- Hydraulic cutting with variable pressure and variable speed.
- Hydraulic vice.
- Fast approach with auto bow height return setting.

## OPTIONS

- Blade speed variation.
- Spray mist cooling system.
- Powered swarf brush.
- Roller track and measuring systems – pages 25 - 27.

## TECHNICAL SPECIFICATIONS

MODEL	330SAE			420SAE		
Capacity	90°	45°	60°	90°	45°	60°
○ mm	260	200	120	300	240	170
□ mm	220	190	115	240	230	170
▭ mm	330 x 140	200 x 130	120 x 100	420 x 160	250 x 180	170 x 170
Blade Size	mm 3010 x 27 x 0.9			mm 3270 x 27 x 0.9		
Cutting Speed	m/min 35/70			m/min 35/70		
Motor	Kw 0.7 - 1.4			Kw 0.7 - 1.4		
Length	mm 1400			mm 1700		
Width	mm 950			mm 1400		
Height	mm 1800			mm 1900		
Weight	Kg 425			Kg 450		
Operation	Semi-automatic			Semi-automatic		
Vice	Hydraulic			Hydraulic		

## SEMI AUTOMATIC CONTROL PANEL



# BIANCO Auto Downfeed Double Mitre Bandsaws

Sawing section



MODEL 370 DS MS  
STOCK CODE 15091  
415V



MODEL 420 DS MS  
STOCK CODE 15092  
415V

## FEATURES

- Special Feature: choose between instant pull down or switch to automatic gravity downfeed with variable control.
- Quick double mitre swing head up to 60° right/45° left.
- Digital Mitre Angle Display.
- Unique sliding vice.
- Fast cutting.
- Cast bow construction.
- Swarf brush.
- Carbide blade guides for high accuracy.
- 2 speed motor.
- Coolant System.
- Blade tension indicator.
- Safety interlock switch fitted to bandwheel cover.
- Material length stop.

## OPTIONS

- Blade speed variation.
- Spray mist cooling system.
- Roller track and measuring systems – pages 29 - 31.

## TECHNICAL SPECIFICATIONS

MODEL	370 DS MS				420 DS MS			
Capacity	90	45L	45R	60R	90	45L	45R	60R
○ mm	280	200	230	150	280	200	260	170
□ mm	250	170	220	150	250	180	250	160
▭ mm	370 x 180	220 x 120	230 x 120	150 x 140	420 x 180	250 x 100	260 x 200	160 x 160
Blade Size	mm	3120 x 27 x 0.9			3270 x 27 x 0.9			
Cutting Speed	m/min	35/70			35/70			
Motor	Kw	0.9/1.5			0.9/1.5			
Length	mm	1700			1750			
Width	mm	1450			1450			
Height	mm	1870			1900			
Weight	Kg	460			480			
Operation		Manual/Auto Down Feed			Manual/Auto Down Feed			
Vice		Manual			Manual			



MODEL 370SA DS MS  
STOCK CODE 15093  
415V



MODEL 420SA DS MS  
STOCK CODE 15094  
415V

## FEATURES

- Fully semi automatic operation including:
- Hydraulic vice.
- Hydraulic cutting with variable pressure and variable speed.
- Quick double mitre swing head up to 60° right/45° left.
- Digital Mitre Angle Display.
- Unique sliding vice.
- Fast cutting.
- Cast bow construction.
- Swarf brush.
- Carbide blade guides for high accuracy.
- 2 speed motor.
- Coolant System.
- Blade tension indicator.
- Safety interlock switch fitted to bandwheel cover.
- Material length stop.
- Fast approach with auto bow height return setting.

## OPTIONS

- Blade speed variation.
- Spray mist cooling system.
- Roller track and measuring systems – pages 29 - 31.

## TECHNICAL SPECIFICATIONS

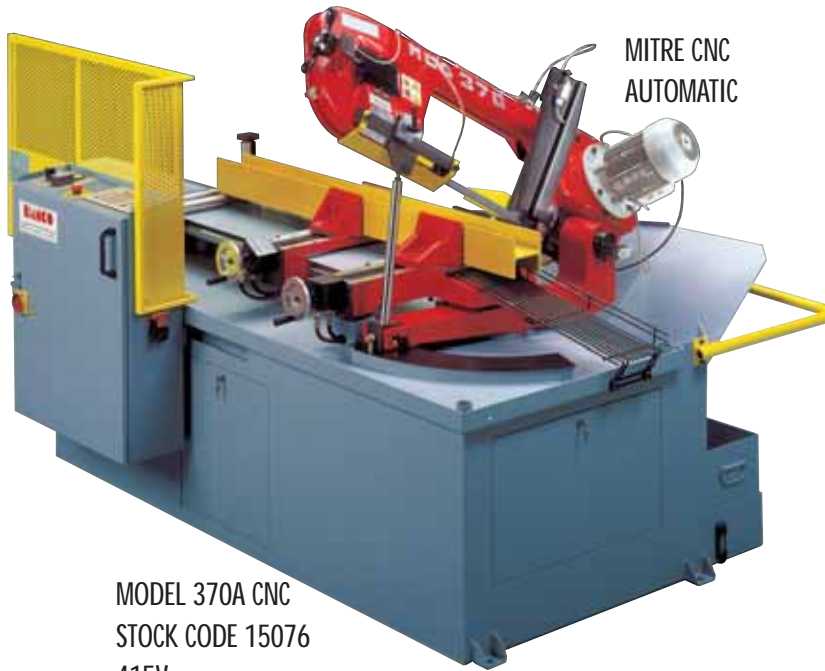
MODEL	370SA DS MS				420SA DS MS			
Capacity	90	45L	45R	50R	90	45L	45R	60R
○ mm	280	200	230	140	280	200	260	170
□ mm	250	170	230	140	250	180	250	160
▭ mm	220 x 200	220x120	230x120	150x140	420 x 180	250x100	260x200	160x160
Blade Size	mm	3120 x 27 x 0.9			3270 x 27 x 0.9			
Cutting Speed	m/min	35/70			35/70			
Motor	Kw	0.5 - 1.5			0.9/1.5			
Length	mm	1530			1630			
Width	mm	1400			1400			
Height	mm	1800			1800			
Weight	Kg	480			495			
Operation		Semi Automatic			Semi Automatic			
Vice		Hydraulic			Hydraulic			

# BIANCO Automatic Single & Double Mitring Bandsaws

Sawing section



MODEL 330AE  
STOCK CODE 15063  
415V  
MODEL 370AE  
STOCK CODE 15100  
415V



MODEL 370A CNC  
STOCK CODE 15076  
415V



OPTIONAL  
HYDRAULIC TOP  
CLAMPS -  
330AE  
370AE  
370A CNC  
370A DS CNC 1R

CONTROL PANEL 370A CNC/  
370A DS CNC 1R



CONTROL PANEL 330AE/370AE



CUTTING LENGTH ADJUSTING WHEEL-  
330AE/370AE



## TECHNICAL SPECIFICATIONS

MODEL	330AE			370AE			370A CNC		
Capacity	90°	45°	60°	90°	45°	60°	90°	45°	60°
○ mm	260	200	120	280	225	140	280	225	140
□ mm	220	190	115	240	215	140	240	215	140
▭ mm	330 x 140	200 x 130	120 x 100	330 x 240	230 x 140	140 x 130	330 x 240	230 x 140	140 x 130
Blade Size	mm 3010 x 27 x 0.9			mm 3120 x 27 x 0.9			mm 3120 x 27 x 0.9		
Cutting Speed	m/min 35/70			m/min 10 - 100			m/min 10 - 100		
Motor	Kw 0.9 - 1.4			Kw 0.9 - 1.4			Kw 1.5		
Length	mm 2330			mm 2800			mm 2800		
Width	mm 1520			mm 1950			mm 1950		
Height	mm 1800			mm 1850			mm 1850		
Weight	Kg 655			Kg 945			Kg 945		
Operation	Automatic			Automatic			CNC Automatic		
Vice	Hydraulic			Hydraulic			Hydraulic		





## FEATURES

- Hydraulic cutting with variable pressure and variable speed.
- Hydraulic vice.
- Fast approach with auto bow height return setting.
- Cast bow construction.
- Carbide blade guides for high accuracy.
- Quick mitring swivel head up to 60°.
- Fully automatic cutting cycle with hydraulic vice feed system.
- Shuttle vice facility for long cutting lengths.

### AUTOMATIC LEFT SWING



MODEL 370A DS CNC 1R  
STOCK CODE 15081  
415V

### DOUBLE MITRE CNC AUTOMATIC

### AUTOMATIC RIGHT SWING



### VIEW WITH FULL GUARDING IN POSITION



### ADDITIONAL FEATURES 370A CNC

- CNC control programmer for varying cutting length and quantities.
- Chip conveyor.
- Powered swarf brush.
- Blade speed variator.

### ADDITIONAL FEATURES 370A DS CNC 1R

- Hydraulic left and right bow swing.
- CNC automatic programmer controlling cutting lengths, cutting quantities and angle of cut left and right.
- Chip conveyor.
- Powered swarf brush.

## TECHNICAL SPECIFICATIONS

MODEL	370A DS CNC 1R		
Capacity	90°	45° L + R	60° R
○ mm	280	200	150
□ mm	240	170	150
▭ mm	320 x 190	220 x 120	150 x 140
Blade Size	mm	3120 x 27 x 0.9	
Cutting Speed	m/min	10 - 100	
Motor	Kw	1.5	
Length	mm	3000	
Width	mm	1900	
Height	mm	1850	
Weight	Kg	1100	
Operation		CNC Automatic	
Vice		Hydraulic	

FAST APPROACH & BOW HEIGHT RETURN SETTING. STANDARD ON ALL BIANCO AUTOMATIC BANDSAWS

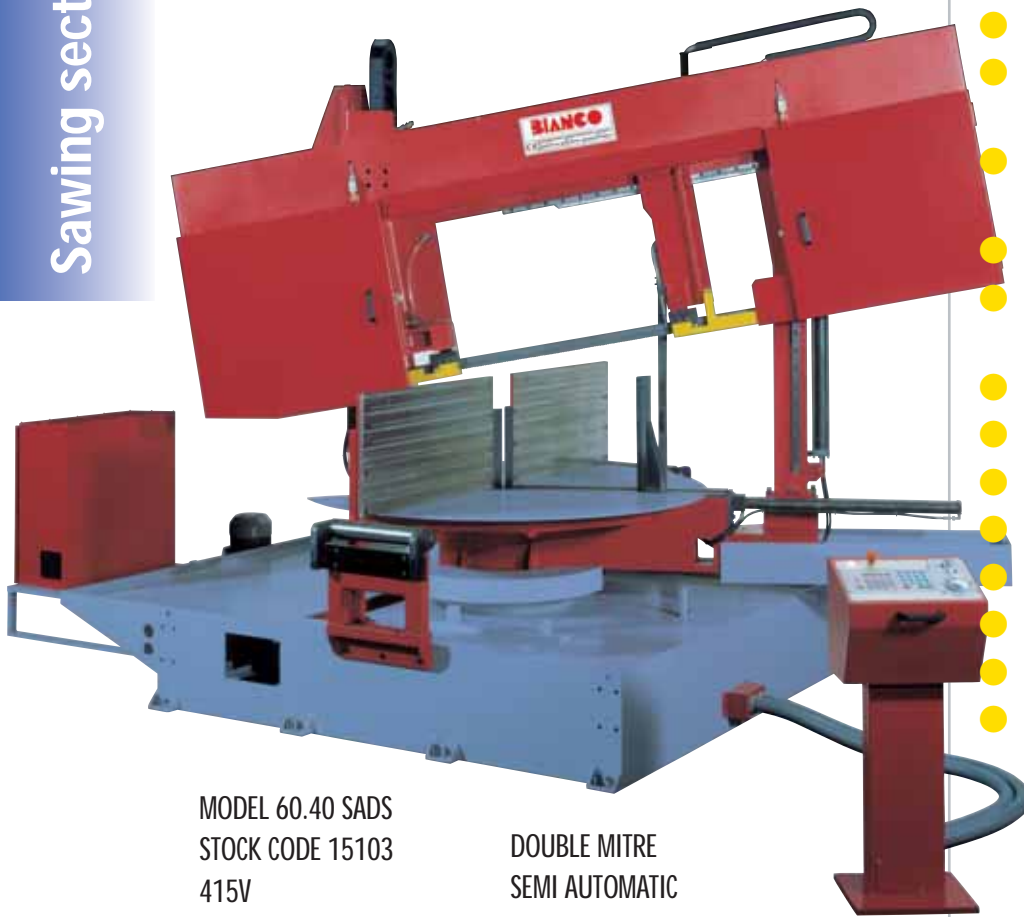


## OPTIONS

- Blade speed variation - 330AE/370AE.
- Spray mist cooling system.
- Chip conveyor - 330AE.
- Hydraulic bundle cutting.
- Variable clamping pressure.
- Roller track and measuring systems – pages 29 - 31.

# BIANCO Twin Column Double Mitring Semi Automatic Bandsaws

Sawing section



MODEL 60.40 SADS  
STOCK CODE 15103  
415V

DOUBLE MITRE  
SEMI AUTOMATIC

MODEL 70.50 SADS  
STOCK CODE 15104  
415V

MODEL 100.60 SADS  
STOCK CODE 15108  
415V

## FEATURES

- Double mitre semi automatic.
- Heavy duty twin column with linear guidance.
- 10° inclined blade for superior section cutting.
- Chip conveyor.
- Hydraulic cutting with variable pressure and speed.
- Hydraulic vice.
- Hydraulic blade tension.
- Hydraulic swarf brush.
- Hydraulic bow lock.
- DRO for cutting angle.
- Moveable control panel.
- Coolant system.
- Carbide blade guides for cutting accuracy.

## OPTIONS

- Automatic powered bow rotation 60° left and right.
- Hydraulic bundle clamping.
- Laser cutting line.

## TECHNICAL SPECIFICATIONS

MODEL	60.40 SADS			70.50 SADS			100.60 SADS			
	90°	45° L&R	60° L&R	90°	45° L&R	60° L&R	90°	45° L&R	60° L&R	
Capacity										
○ mm	400	400	300	500	500	360	600	600	420	
□ mm	400	400	300	500	500	360	600	600	420	
▭ mm	600 x 400	400 x 400	300 x 300	700 x 500	500 x 500	340 x 450	1000 x 600	600 x 600	420 x 420	
Blade Size	mm	6340 X 41 X 1.3			7925 X 54 X 1.6			8275 X 54 X 1.6		
Cutting Speed	m/min	15/80			15-80			18-80		
Motor	Kw	4			5.5			5.5		
Length	mm	3000			4250			3220		
Width	mm	3200			4250			1850		
Height	mm	2500			2800			2450		
Weight	Kg	2800			5000			4200		
Operation		Semi-Automatic			Semi-Automatic			Semi-Automatic		
Vice		Hydraulic			Hydraulic			Hydraulic		



MODEL 61.41 AF CNC  
STOCK CODE 15105  
415V

CNC AUTOMATIC

MODEL 71.51 AF CNC  
STOCK CODE 15106  
415V

MODEL 81.61 AF CNC  
STOCK CODE 15107  
415V

## FEATURES

- CNC fully automatic.
- Heavy duty twin column with linear guidance.
- Hydraulic cutting with variable pressure and speed.
- Chip conveyor.
- Hydraulic vice.
- Variable clamping pressure.
- Hydraulic feed carriage 800mm.
- Hydraulic swarf brush.
- Infinitely variable blade speed inverter.
- Coolant system.
- Carbide blade guides for accurate cutting.

## OPTIONS

- Hydraulic bundle cutting.
- Spray mist lubrication system.
- Laser cutting line.

## TECHNICAL SPECIFICATIONS

MODEL		61.41 AF CNC	71.51 AF CNC	81.61 AF CNC
Capacity		90°	90°	90°
	○ mm	410	510	610
	□ mm	410	510	610
	▭ mm	610 x 410	710 x 510	810 x 610
Blade Size	mm	5200 X 34 X 1.1	5800 X 41 X 1.3	6300 X 41 X 1.3
Cutting Speed	m/min	20/100	20-100	20-100
Motor	Kw	2.2	3	3
Length	mm	3100	3300	3500
Width	mm	2400	2400	2700
Height	mm	2000	2250	2450
Weight	Kg	2800	3400	3800
Operation		Automatic	Automatic	Automatic
Vice		Hydraulic	Hydraulic	Hydraulic

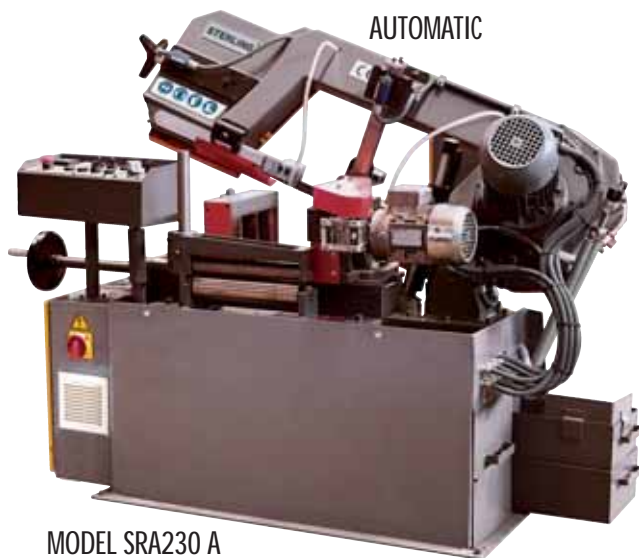
# STERLING Auto Down Feed, Semi Automatic & Fully Automatic Bandsaws

## Sawing section



MODEL SRA230 DG  
STOCK CODE 15140  
415V

DOUBLE MITRE  
AUTO DOWN FEED



AUTOMATIC

MODEL SRA230 A  
STOCK CODE 15141  
415V

STERLING heavy duty pivot action bandsaws follow the traditional pattern of manual, semi-automatic and fully automatic models. The new style SRA230 DG model is ideal for angle cutting up to 320mm beam capacity with its quick set double mitre swing head feature.

Twin column bandsaws with capacities from 320mm round up to a huge 1100mm round are available in semi-automatic and fully automatic configuration and are detailed in the following pages.

MODEL SRA270DG  
STOCK CODE 15136  
415V



AUTO DOWN FEED

SEMI-AUTOMATIC  
MODEL SRA270DGSA  
STOCK CODE 15137

## TECHNICAL SPECIFICATIONS

MODEL	SRA230 DG				SRA230 A	SRA270DG/SRA270DGSA			
Capacity	90°	45° L	45° R	60° R	90°	90°	45° L	45° R	60° R
○ mm	230	220	180	120	230	270	240	210	160
□ mm	230	190	150	105	230	260	220	180	150
▭ mm	320 x 130	230 x 140	220 x 60	120 x 105	240 x 230	350 x 220	240 x 160	180 x 180	150 x 150
Blade Size	mm	2730 x 27 x 0.9			2730 x 27 x 0.9	3160 X 27 X 0.9			
Cutting Speed	m/min	35/70			35/70	34 - 68			
Motor	Kw	1.0/1.5			1.0/1.5	0.75/1.5			
Length	mm	1350			1700	1730			
Width	mm	900			1100	770			
Height	mm	1300			1300	1550			
Weight	Kg	345			370	456/475			
Operation		Auto down feed			Automatic	Auto down feed/Semi-Automatic			
Vice		Manual			Manual	Manual/Hydraulic			



MODEL SRA320SA  
STOCK CODE 15033  
415V

FOR STERLING  
ROLLER TRACK SEE  
PAGE 29



MODEL SRA320HA  
STOCK CODE 15037  
415V

VICE FEED AUTOMATIC

## FEATURES

- Heavy duty cast bow construction.
- SRA230DG/SRA270DG – double mitre, with automatic downfeed.
- SRA270DGSA – double mitre, semi-automatic with automatic bow lift and auto height settings.
- SRA280- single mitre with swivel vice clamp and automatic downfeed.
- SRA320SA – single mitre with swivel vice, semi-automatic with automatic bow lift and auto height settings.
- SRA230A/SRA320A – fully automatic roller feed with piece counter and hydraulic vice.
- S320HA – fully automatic with vice feed and hydraulic vice.
- Safety interlock switches fitted to band cover.
- Blade speed inverter and hydraulic vice.
- Safety interlock switches fitted to band cover.
- Variable Blade speed inverter 20-100m/min (not SRA230DG/ SRA230A/ SRA270DG/ SRA270DGSA)
- Hydraulic Blade Tension indicator
- Carbide blade guides for high accuracy

## OPTIONS

- Hydraulic Vice
- Laser Cutting Line
- Roller track & measuring systems – page 29-31

## TECHNICAL SPECIFICATIONS

MODEL	SRA280		SRA320 SA		SRA320 A	SRA320 HA
Capacity	90°	45°	90°	45°	90°	90°
○ mm	280	240	320	280	320	320
□ mm	280	210	320	260	300	320
▭ mm	350 x 200	240 x 180	400 x 220	280 x 200	320 x 300	350 x 320
Blade Size	mm 3400 x 27 x 0.9		mm 3660 x 27 x 0.9		mm 3660 x 27 x 0.9	mm 3660 x 27 x 0.9
Cutting Speed	m/min 20 - 100		m/min 20 - 100		m/min 20 - 100	m/min 20-100
Motor	Kw 1.5		Kw 1.5		Kw 1.5	Kw 1.5
Length	mm 1800		mm 1850		mm 1850	mm 1850
Width	mm 850		mm 850		mm 850	mm 1850
Height	mm 1200		mm 1250		mm 1250	mm 1250
Weight	Kg 530		Kg 600		Kg 660	Kg 1490
Operation	Auto down feed		Semi-automatic		Automatic	Vice Feed Automatic
Vice	Manual		Manual		Manual	Hydraulic

### AUTOMATIC ROLLER FEED SYSTEM SRA320A



# STERLING Pivot / Twin Column Double Mitre Semi Automatic Bandsaw

Sawing section



MODEL STC440 DGSA  
STOCK CODE 15148  
415V

DOUBLE MITRE  
SEMI AUTOMATIC



MODEL SRA440 DGSA  
STOCK CODE 15146  
415V

DOUBLE MITRE  
SEMI AUTOMATIC

## FEATURES

- Double mitring swivel head 60 left and right.
- Strong twin column frame with linear guidance bearing (STC440DGSA).
- Sliding vice from left to right.
- Hydraulic cutting with variable pressure and variable speed.
- Hydraulic vice.
- Hydraulic bow lock at any angle with digital readout on control panel.
- Hydraulically controlled counter balance to prevent bow descent speed increasing during the cutting cycle (SRA440DGSA).
- Carbide blade guides for high accuracy.
- Ergonomic mobile control panel.
- Blade Tension indicator.

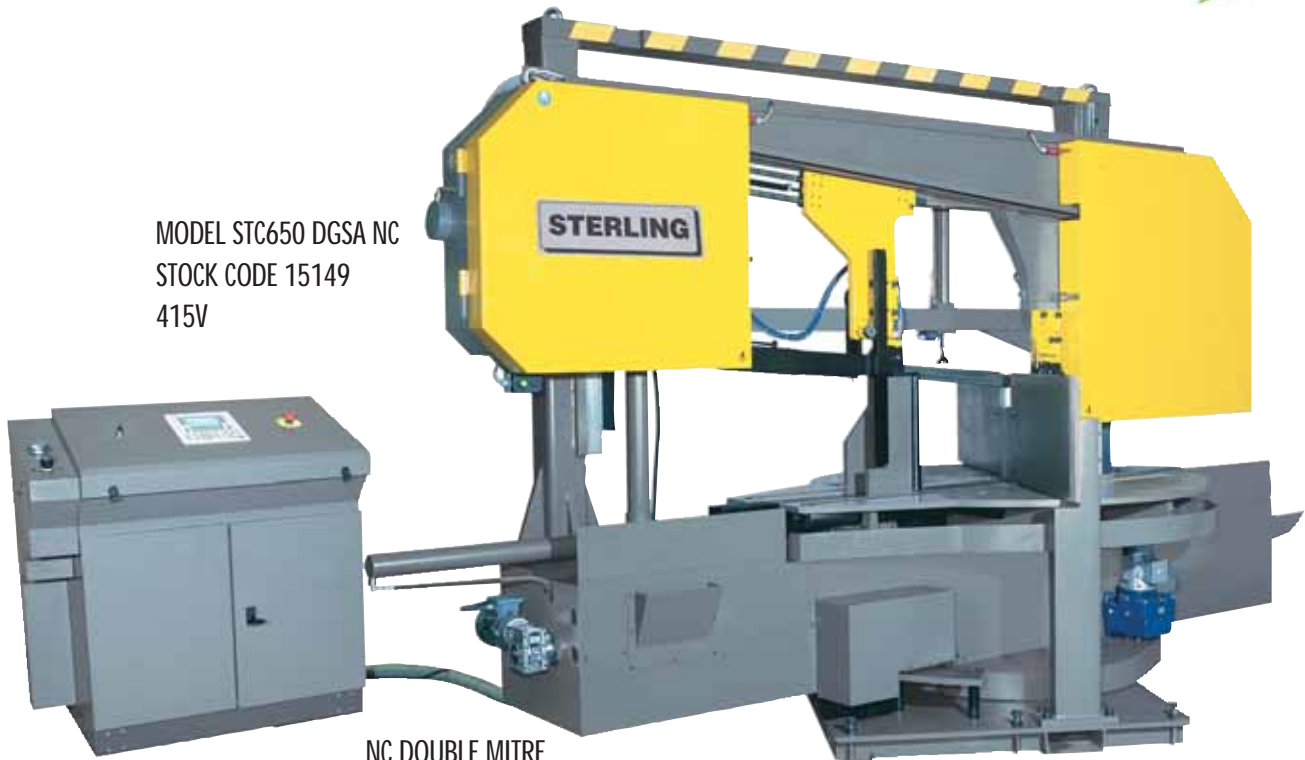
## OPTIONS

- Laser cutting line.
- Spraymist lubrication.
- Hydraulic blade tension.
- Hydraulic top clamping for bundle cutting.
- Automatic swivelling head by DC motor.
- Hydraulic sliding vice.
- Variable vice pressure.
- Chip conveyor.
- Roller track and measuring systems – page 29-31.

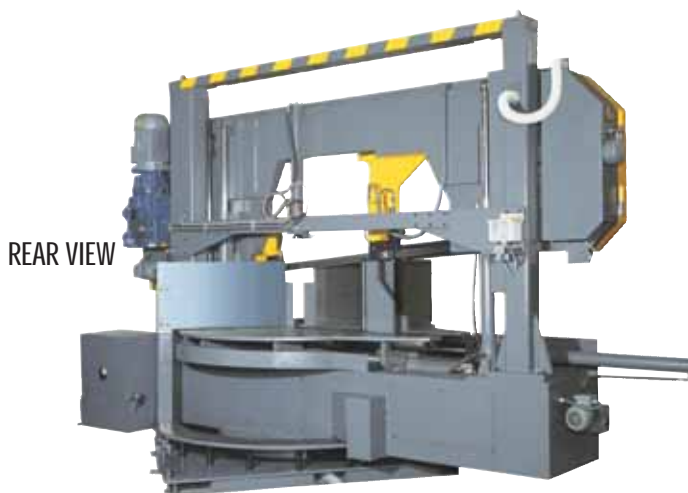
## TECHNICAL SPECIFICATIONS

MODEL	SRA440 DGSA			STC440 DGSA			
		90°	45° L & R	60° L & R	90°	45° L & R	60° L & R
Capacity		90°	45° L & R	60° L & R	90°	45° L & R	60° L & R
○ mm		440	410	330	440	440	350
□ mm		440	410	310	440	440	290
▭ mm		610 x 440	460 x 270	330 x 170	640 x 440	400 x 440	250 x 440
Blade Size	mm	5200 x 34 x 1.1			5200 x 41 x 1.3		
Cutting Speed	m/min	20 - 100			20 - 100		
Motor	Kw	3			4		
Length	mm	2720			3100		
Width	mm	2830			1350		
Height	mm	2530			2125		
Weight	Kg	1400			1740		
Operation		Semi-automatic			Semi-automatic		
Vice		Hydraulic			Hydraulic		

MODEL STC650 DGSA NC  
STOCK CODE 15149  
415V



NC DOUBLE MITRE  
SEMI AUTOMATIC



REAR VIEW

## TECHNICAL SPECIFICATIONS

MODEL	STC650 DGSA NC		
Capacity	90°	45° L & R	60° R
○ mm	650	650	440
□ mm	600	600	440
▭ mm	1000 x 600	650 x 600	440 x 600
Blade Size	mm	8400 x 54 x 1.6	
Cutting Speed	m/min	20 - 100	
Motor	Kw	7.5	
Length	mm	4660	
Width	mm	1730	
Height	mm	2630	
Weight	Kg	6000	
Operation		Semi-automatic	
Vice		Hydraulic	

## FEATURES

- Semi automatic double mitre 60° left and 45° right.
- Heavy duty twin column with linear guidance bearing.
- Powered bow rotation with NC control.
- Fast approach speed with automatic bow height return.
- DRO for cutting angle.
- 5° inclined blade.
- Chip conveyor.
- Hydraulic cutting with variable pressure and speed.
- Hydraulic vice.
- Hydraulic bow lock.
- Hydraulic blade tension
- Motorised swarf brush.

## OPTIONS

- Spray mist lubrication system.
- Hydraulic top clamp.
- Laser cutting line.
- Roller track and measuring systems – pages 29 - 31.

# STERLING Twin Column Semi Automatic Bandsaws

Sawing section

SEMI AUTOMATIC



MODEL STC380 SA  
STOCK CODE 15156  
415V

MODEL STC460 SA  
STOCK CODE 15157  
415V

MODEL STC560 SA  
STOCK CODE 15158  
415V



MODEL STC820 SA  
STOCK CODE 15163  
415V

MODEL STC1110 SA  
STOCK CODE 15164  
415V

## FEATURES

- Twin column rigidity.
- Linear guidance bearing.
- Inverter drive providing infinitely variable blade speed.
- Automatic bow return.
- Hydraulic vice.
- Blade tension indicator.
- Carbide blade guides.
- Coolant system.

## OPTIONS

- Hydraulic blade tension.
- Hydraulic top clamps.
- Chip conveyer.
- Spray mist lubrication.
- Laser cutting line.
- Digital bow return height .
- Roller track and measuring systems – pages 29 - 31.

## TECHNICAL SPECIFICATIONS

MODEL	STC380 SA		STC460 SA		STC560 SA		STC820 SA		STC1110 SA
Capacity	90°	45°	90°	45°	90°	45°	90°	45°	90°
○ mm	380	380	460	460	560	560	820	480	1110
□ mm	380	270	460	380	560	430	820	480	1110
▭ mm	520 x 380	270 x 380	650 x 450	380 x 460	750 x 560	430 x 560	820 x 850	480 x 850	1100 x 1110
Blade Size	mm 4800 x 34 x 1.1		5200 x 41 x 1.3		6000 x 41 x 1.3		8200 x 54 x 1.6		10500 x 67 x 1.6
Cutting Speed	m/min 20 - 100		20 - 100		20 - 100		20 - 100		20 - 100
Motor	Kw 3		4		4		7.5		11
Length	mm 3060		3100		3400		3900		4800
Width	mm 1000		1000		1100		1200		1500
Height	mm 1650		1800		1950		2350		2975
Weight	Kg 1200		1450		1800		2500		8020
Operation	Semi-automatic		Semi-automatic		Semi-automatic		Semi-automatic		Semi-automatic
Vice	Hydraulic		Hydraulic		Hydraulic		Hydraulic		Hydraulic



# STERLING Twin Column Mitring Semi Automatic Bandsaws



MODEL STC325G SA  
STOCK CODE 15165  
415V

MODEL STC360G SA  
STOCK CODE 15166  
415V

MODEL STC440G SA  
STOCK CODE 15167  
415V

MODEL STC540G SA  
STOCK CODE 15168  
415V

MODEL STC810G SA  
STOCK CODE 15169  
415V



## FEATURES

- Strong twin pillar frame with linear guidance bearing.
- Mitring swivel head to 60°.
- Hydraulic cutting with variable pressure and variable speed.
- Hydraulic vice.
- Hydraulic bow lock at any angle.
- Digital readout for mitre angle.
- Variable blade speed 20-100 m/min.
- Carbide blade guides.
- Blade tension indicator.

## OPTIONS

- Hydraulic blade tension.
- Hydraulic top clamps.
- Chip conveyor.
- Spray mist lubrication.
- Laser cutting line.

## TECHNICAL SPECIFICATIONS

MODEL	STC325 GSA			STC360 GSA			STC440 GSA			STC540 GSA			STC810 GSA		
Capacity	90°	45° R	60° R	90	45	60	90°	45° R	60° R	90°	45° R	60° R	90°	45° R	60° R
○ mm	325	305	190	360	360	305	440	440	305	540	510	270	810	530	320
□ mm	320	270	180	360	360	305	440	440	305	540	455	240	770	520	320
▭ mm	450x320	270x320	180x240	700x360	460x360	305x360	700x440	460x440	305x440	750x540	455x540	240x540	810x770	500x750	310x750
Blade Size	mm 4160 x 34 x 1.1			5000x34x1.1			5200 x 41 x 1.3			6000 x 41 x 1.3			8200 x 41 x 1.3		
Cutting Speed	m/min 20 - 100			20-100			20 - 100			20 - 100			20 - 100		
Motor	Kw 2.2			3			4			4			4		
Length	mm 2100			2850			2850			2900			3940		
Width	mm 800			2100			780			1100			1300		
Height	mm 1600			1910			2125			2130			2470		
Weight	Kg 1150			1550			1630			2100			3100		
Operation	Semi-Automatic			Semi-Automatic			Semi-Automatic			Semi-Automatic			Semi-Automatic		
Vice	Hydraulic			Hydraulic			Hydraulic			Hydraulic			Hydraulic		

# STERLING Twin Column NC Automatic Mitre Bandsaws

Sawing section

NC MITRE  
AUTOMATIC



MODEL STC360 GA NC  
STOCK CODE 15159  
415V

MODEL STC440 GA NC  
STOCK CODE 15160  
415V



## FEATURES

- Twin column rigidity.
- Fully automatic cutting cycle.
- Swing frame mitre cutting in semi automatic mode.
- Linear guidance bearing.
- Inverter drive providing infinitely variable blade speed.
- Hydraulic vice.
- Blade tension indicator.
- Carbide blade guides.
- Coolant system.

## OPTIONS

- Hydraulic blade tension.
- Hydraulic top clamps.
- Chip conveyor.
- Spray mist lubrication.
- Laser cutting line.
- Digital bow return height.
- Roller track and measuring systems – pages 29 - 31.

## TECHNICAL SPECIFICATIONS

MODEL	STC360 GA NC			STC440 GA NC			STC540 GA NC		
Capacity	90°	45° R	60° R	90°	45° R	60° R	90°	45°	60°
○ mm	360	360	305	440	440	305	540	510	270
□ mm	360	360	305	440	400	305	540	455	240
▭ mm	610 x 360	460 x 360	305 x 360	640 x 440	460 x 440	305 x 440	720 x 540	455 x 540	240 x 540
Blade Size	mm 5000 x 34 x 1.1			5200 x 41 x 1.3			6000 x 41 x 1.3		
Cutting Speed	m/min 20 - 100			20 - 100			20 - 100		
Motor	Kw 3			4			4		
Length	mm 2250			2250			2900		
Width	mm 2100			2100			2200		
Height	mm 1740			1740			2150		
Weight	Kg 2500			2500			3200		
Operation	Automatic			Automatic			Vice Feed Automatic		
Vice	Hydraulic			Hydraulic			Hydraulic		



## FEATURES

- Heavy duty twin column rigidity with linear guidance bearing.
- Fully automatic cutting cycle with multi pass hydraulic vice.
- Hydraulic cutting with variable pressure.
- Variable blade speed 20-100m/min.
- User friendly control panel with NC Control.
- Blade Tension indicator.

## OPTIONS

- Laser cutting line.
- Spraymist lubrication.
- Hydraulic blade tension.
- Hydraulic top clamping for bundle cutting.
- Variable vice pressure.
- Chip conveyor.
- Roller track and measuring systems – page 29-31.

MODEL STC325 HA NC  
STOCK CODE 15171  
415V

MODEL STC360 HA NC  
STOCK CODE 15172  
415V

MODEL STC460 HA NC  
STOCK CODE 15173  
415V

MODEL STC560 HA NC  
STOCK CODE 15174  
415V

## TECHNICAL SPECIFICATIONS

MODEL		STC325 HA NC	STC360 HA NC	STC460 HA NC	STC 560 HA NC
Capacity		90	90	90	90
	○ mm	325	360	460	560
	□ mm	325	360	460	560
	▭ mm	350 x 325	485 x 360	610 x 460	600 x 560
Blade Size	mm	4130 x 34 x 1.1	4800 x 34 x 1.1	5200 x 41 x 1.3	6000 x 41 x 1.3
Cutting Speed	m/min	20 - 100	20-100	20 - 100	20 - 100
Motor	Kw	2.2	3	4	4
Length	mm	2300	2850	3100	3500
Width	mm	2200	2200	2200	2200
Height	mm	1550	1740	1950	2050
Weight	Kg	1500	1950	2200	2500
Operation		Vice Feed Automatic	Vice Feed Automatic	Vice Feed Automatic	Vice Feed Automatic
Vice		Hydraulic	Hydraulic	Hydraulic	Hydraulic

# BAUER Manual and Semi-Automatic Mitre Bandsaws

Bauer have been designing and manufacturing bandsaws in Germany since 1937, with thousands of machines installed worldwide. Bauer products have firmly established a reputation for long life and reliability with many machines still in use today in the UK after many years of service.

The entry level S280G is surprisingly competitive, yet still has the benefit of a mitring head for angle cutting. The S280DG offers double mitring and increased beam capacity. The S320DG machines are large capacity double mitre bandsaws available in manual and semi automatic operation.



MODEL S280G  
STOCK CODE 15119  
415V

MITRE AUTO  
DOWN FEED



MODEL S280DG  
STOCK CODE 15115  
415V

DOUBLE MITRE  
AUTO DOWN  
FEED

## TECHNICAL SPECIFICATIONS

MODEL	S280G			S280DG		
Capacity	90°	45°	60°	90°	45° L&R	60° R
○ mm	280	240	150	280	240	150
□ mm	240	220	130	240	220	130
▭ mm	330 x 180	220 x 240	130 x 160	400 x 180	265 x 240	130 x 160
Blade Size	mm 3000 x 27 x 0.9			mm 3200 x 27 x 0.9		
Cutting Speed	m/min 35/70			m/min 35/70		
Motor	Kw 1.1 - 1.4			Kw 1.1 - 1.4		
Length	mm 1700			mm 1800		
Width	mm 700			mm 700		
Height	mm 1400			mm 1400		
Weight	Kg 470			Kg 520		
Operation	Auto Down Feed			Auto Down Feed		
Vice	Manual			Manual		



DOUBLE MITRE  
AUTO DOWN  
FEED

MODEL S320DG  
STOCK CODE 15116  
415V

## FEATURES

- Made in Germany.
- Heavy duty.
- Carbide blade guides for high accuracy.
- Double mitring head - except verticals and S280G.
- Coolant system.
- Large easy to read mitre scales - except verticals.
- S280G/S280DG/S320DG - automatic down feed with variable control.
- S320 DGSA - semi automatic with hydraulic vice and automatic bow lift.

MODEL S320DGSA  
STOCK CODE 15117  
415V

DOUBLE MITRE  
SEMI AUTOMATIC



MOTOR WITH  
HEAVY DUTY  
GEAR BOX



LARGE EASY TO READ DEGREE MITRE SCALE



## TECHNICAL SPECIFICATIONS

MODEL	S320DG			S320DGSA		
Capacity	90°	45° L&R	60° R	90°	45° L&R	60° R
○ mm	320	320	180	320	320	180
□ mm	305	305	210	305	305	210
▭ mm	520 x 160	325 x 240	210 x 240	520 x 160	325 x 240	210 x 240
Blade Size	mm 4150 x 34 x 1.1			mm 4150 x 34 x 1.1		
Cutting Speed	m/min 35/70			m/min 35/70		
Motor	Kw 1.1 - 1.4			Kw 1.1 - 1.4		
Length	mm 2040			mm 2040		
Width	mm 1000			mm 1000		
Height	mm 1300			mm 1300		
Weight	Kg 790			Kg 870		
Operation	Auto Down Feed			Semi-Automatic		
Vice	Manual			Hydraulic		



As with the horizontal bandsaws from Bauer, the range of vertical bandsaws are manufactured in Germany to high quality standards. Bauer products have established a deserved reputation for long working life and reliability, with machines in use the world over. The vertical saw range today consists of four models and can be specified with an integral blade welder.

MODEL 400V  
STOCK CODE 15200  
415V

MODEL 500V  
STOCK CODE 15201  
415V

MODEL 650V  
STOCK CODE 15202  
415V

MODEL 1000V  
STOCK CODE 15203  
415V

## TECHNICAL SPECIFICATIONS

MODEL		400V	500V	650V	1000V
Cutting Height	mm	210	350	400	400
Cutting Depth	mm	390	490	620	1000
Table Size	mm	520 x 160	630 x 530	630 x 530	600 x 860
Blade Size	mm	3000 x 6 x 2.0	3900 x 6 x 2.5	5000 x 6 x 2.5	5200 x 6 x 2.5
Cutting Speed	m/min	OPTIONS AVAILABLE	OPTIONS AVAILABLE	OPTIONS AVAILABLE	OPTIONS AVAILABLE
Motor	Kw	0.75	1.1	2.2	2.2
Length	mm	780	830	830	1400
Width	mm	600	600	600	600
Height	mm	1800	2000	2200	2200
Weight	Kg	280	400	500	600
Operation		Manual	Manual	Manual	Manual



The Sterling stand alone gravity roller track systems are adjustable for height and available in 1000mm, 2000mm and 3000mm lengths. A selection of load ratings and roller widths provide a material handling solution for virtually all bandsaws. For track sizes not included below, vertical rollers and motorised systems please contact our sales department.

The Sterling range of rollers are available in varying diameters, lengths and load ratings. Each roller is supplied with heavy duty machined bearings and spring loaded telescopic axial pins and are ideal for



companies who desire to manufacture their own roller track.

FRAME DESIGN  
MAY VARY



## TECHNICAL SPECIFICATIONS - STERLING ROLLERS

STOCK CODE	ROLLER DIA mm	WIDTH mm	CAPACITY Kg UDL	PIN SIZE mm
15633	50 x 3	200	160	11
15634	50 x 3	250	160	11
15635	50 x 3	300	160	11
15636	50 x 3	400	160	11
15637	63 x 3	400	300	16
15638	63 x 3	500	300	16
15639	63 x 3	600	300	16
15640	76 x 4	500	400	19
15641	76 x 4	600	400	19
15642	76 x 4	750	400	19

## TECHNICAL SPECIFICATIONS - STERLING ROLLER TRACK

STOCK CODE	WIDTH mm	LENGTH mm	ROLLER DIA mm	HEIGHT mm	ROLLER PITCH mm	CAPACITY/ROLLER Kg UDL	NO OF ROLLERS	MAX. CAPACITY Kg UDL	FRAME SIZE RSA mm
15600	250	1000	50 x 2	610 - 960	200	110	4	375	50 x 50 x 5
15601	250	2000	50 x 2	610 - 960	300	110	6	560	50 x 50 x 5
15602	250	3000	50 x 2	610 - 960	300	110	10	935	50 x 50 x 5
15603	350	1000	50 x 2	610 - 960	200	110	4	375	50 x 50 x 5
15604	350	2000	50 x 2	610 - 960	300	110	6	560	50 x 50 x 5
15605	350	3000	50 x 2	610 - 960	300	110	10	935	50 x 50 x 5
15609	350	1000	60 x 2	610 - 960	200	160	4	545	75 x 50 x 6
15610	350	2000	60 x 2	610 - 960	300	160	6	815	75 x 50 x 6
15611	350	3000	60 x 2	610 - 960	300	160	10	1360	75 x 50 x 6
15612	450	1000	60 x 2	610 - 960	200	160	4	545	75 x 50 x 6
15613	450	2000	60 x 2	610 - 960	300	160	6	815	75 x 50 x 6
15614	450	3000	60 x 2	610 - 960	300	160	10	1360	75 x 50 x 6
15618	450	1000	63.5 x 3	610 - 960	200	270	4	920	75 x 50 x 6
15619	450	2000	63.5 x 3	610 - 960	300	270	6	1380	75 x 50 x 6
15620	450	3000	63.5 x 3	610 - 960	300	270	10	2295	75 x 50 x 6
15621	550	1000	63.5 x 3	610 - 960	200	270	4	920	75 x 50 x 6
15622	550	2000	63.5 x 3	610 - 960	300	270	6	1380	75 x 50 x 6
15623	550	3000	63.5 x 3	610 - 960	300	270	10	2295	75 x 50 x 6
15627	650	1000	76.4 x 3	610 - 960	200	450	4	1530	100 x 50 x 6
15628	650	2000	76.4 x 3	610 - 960	300	450	6	2295	100 x 50 x 6
15629	650	3000	76.4 x 3	610 - 960	300	450	10	3825	100 x 50 x 6
15630	750	1000	76.4 x 4	610 - 960	200	650	4	2210	100 x 50 x 6
15631	750	2000	76.4 x 4	610 - 960	300	650	6	3315	100 x 50 x 6
15632	750	3000	76.4 x 4	610 - 960	300	650	10	5525	100 x 50 x 6

Sawing section



LMS15 WITH DRO



STANDARD PEHU 109 NC CONTROLLER FITTED TO LMS30 -LMS80 MODELS

OPTIONAL PEHU 107 CNC CONTROLLER



The Pehu DRO and NC roller track and measuring systems greatly increase cutting accuracy and reduce measuring time. The LMS15 is a manually operated positioning system with a digital read out indicating the cutting length. The LMS30 – LMS80 range have a motorised positioner operated from the Pehu 109 NC controller. The operator enters the required cutting length and the stop will automatically move to the required position and lock. The range includes cutting widths up to 1100mm and lengths up to 20000mm. All systems include heavy duty roller track and can be fitted to any bandsawing machine.

## FEATURES

- Supplied with standard Pehu 109 controller – except LMS15
- Fast and accurate
- Eliminates measuring errors
- Choice of manual system with DRO or powered NC
- Includes heavy duty roller track
- Vastly improved productivity
- Hydraulic swing away stop – LMS60 and LMS80

## OPTIONS

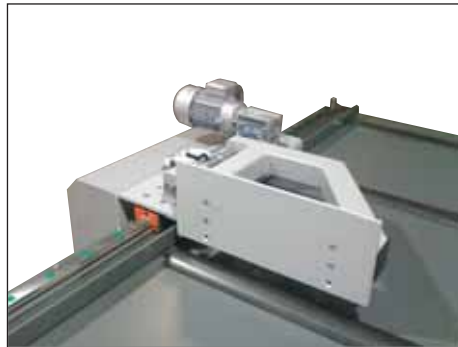
- Pehu 107 controller with material clamp. This connects to a semi automatic machine and results in a fully CNC measuring, cutting and feeding system without the need of a shuttle vice.
- Manual swing away stop – LMS30
- Powered swing away stop – LMS45
- Powered roller track – recommended for LMS60 and LMS80



LMS30 WITH OPTIONAL PEHU 109 CNC CONTROLLER



LMS45



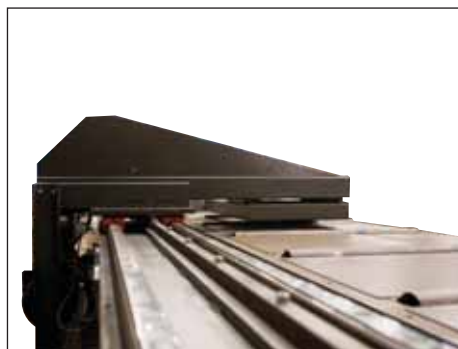
LMS60



LMS60 – END VIEW



LMS80



LMS80 IN 'SWING AWAY' POSITION



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	WIDTH mm	LENGTH mm	ROLLER DIA mm	HEIGHT mm	ROLLER PITCH mm	CAPACITY/ROLLER Kg UDL	NO OF ROLLERS	MAX. CAPACITY Kg UDL	FRAME SIZE
LMS15-03	15660	350	3000	50 x 5	As required	3 x 210, rest x 400	500	9	4500	UNP100
LMS15-04	15661	350	4000	50 x 5	As required	3 x 210, rest x 400	500	12	6000	UNP100
LMS15-05	15662	350	5000	50 x 5	As required	3 x 210, rest x 400	500	17	8500	UNP100
LMS15-06	15663	350	6000	50 x 5	As required	3 x 210, rest x 400	500	22	11000	UNP100
LMS30-04	15664	350	4000	50 x 5	As required	3 x 210, rest x 400	500	12	6000	UNP 100
LMS30-06	15665	350	6000	50 x 5	As required	3 x 210, rest x 400	500	17	8500	UNP 100
LMS30-08	15666	350	8000	50 x 5	As required	3 x 210, rest x 400	500	22	11000	UNP 100
LMS30-10	15667	350	10000	50 x 5	As required	3 x 210, rest x 400	500	27	13500	UNP 100
LMS30-12	15668	350	12000	50 x 5	As required	3 x 210, rest x 400	500	32	16000	UNP 100
LMS45-04	15669	630	4000	89 x 6	As required	3 x 210, rest x 630	750	9	6750	UNP 100
LMS45-06	15670	630	6000	89 x 6	As required	3 x 210, rest x 630	750	12	9000	UNP 100
LMS45-08	15671	630	8000	89 x 6	As required	3 x 210, rest x 630	750	15	11250	UNP 100
LMS45-10	15672	630	10000	89 x 6	As required	3 x 210, rest x 630	750	18	13500	UNP 100
LMS45-12	15673	630	12000	89 x 6	As required	3 x 210, rest x 630	750	21	15750	UNP 100
LMS60-08	15674	830	4000	114 x 8	As required	500	850	9	7650	UNP 140
LMS60-10	15675	830	6000	114 x 8	As required	500	850	13	11050	UNP 140
LMS60-12	15676	830	8000	114 x 8	As required	500	850	17	14450	UNP 140
LMS60-16	15677	830	10000	114 x 8	As required	500	850	21	17850	UNP 140
LMS60-20	15678	830	12000	114 x 8	As required	500	850	25	21250	UNP 140
LMS80-08	15679	1100	4000	130 x 10	As required	500	850	9	7650	UNP 140
LMS80-10	15680	1100	6000	130 x 10	As required	500	850	13	11050	UNP 140
LMS80-12	15681	1100	8000	130 x 10	As required	500	850	17	14450	UNP 140
LMS80-16	15682	1100	10000	130 x 10	As required	500	850	21	17850	UNP 140
LMS80-20	15683	1100	12000	130 x 10	As required	500	850	25	21250	UNP 140

### INTRODUCTION

The range of lathes has been greatly enhanced with the inclusion of the top quality Pinacho machines. These machines compliment our long standing Meyer SB and SG models and are ideal for our customers that are looking for top quality European built lathes. The Meyer range has also been expanded with a new top of the range SG3056 and a new ST range of large capacity machines with power traverse as standard. Our trained in house engineers are available on call for rapid response or planned maintenance and servicing. Extended warranty and service contracts can also be arranged through our customer service desk.

### Product overview

#### Bema

The Bema pillar drills are genuinely heavy duty machines with large columns providing rigidity even when drilling to maximum capacity. The Bema range includes the top selling 32mm capacity machines through to the radial arm models available in four sizes. All radial models are fitted with DC injection brakes guaranteeing operator safety.



#### Meyer

The popular Meyer SR series of gear head drilling machines are available in traditional pull down, automatic feed with mechanical clutch and automatic feed electro-magnetic clutch. New for this catalogue is the option of infinitely variable speed on all models adding to their versatility. The compact Meyer SB centre lathes are ideal for tool room applications and training establishments, whilst the heavy duty SG range are well suited to the most demanding environments and equipped with generous levels of standard equipment.



#### Pinacho

The Pinacho European manufactured centre lathes are one of the best quality ranges available in the world. The high standard of workmanship, high grade materials and engineering excellence ensure operator satisfaction and long working life. The wide product range ensures a machine for virtually all applications, including the CNC smart turn machines.



#### Brenner

The established Brenner universal milling machines consist of four models with varying table sizes, motor power and features. Generous levels of standard equipment are a hallmark of the Brenner range including 3 axis digital readout display.





MODEL MG32  
STOCK CODE 18051  
415V



MODEL MG32C  
STOCK CODE 18053  
415V

MODEL MG32  
STOCK CODE 18050  
240V

MODEL MG32C  
STOCK CODE 18052  
240V

## TECHNICAL SPECIFICATIONS

MODEL		MG32	MG32C
Drilling Capacity	mm	32	32
Tapping Capacity	mm	20	20
Spindle Taper	MT no	3	3
Motor	Kw	1.5/2	1.5/2
Speeds	rpm	100 - 2150	100 - 2150
Spindle Stroke	mm	130	130
Work Table	mm	570 x 470	570 x 470
Base Plate	mm	635 x 460	635 x 460
Throat	mm	202	202
Length	mm	820	820
Width	mm	490	490
Height	mm	1760	1760
Weight	Kg	305	305

The Bema range of belt driven drilling machines are manufactured to exacting standards.

The MG32 and MG32C models feature large columns, large working tables and a large base plate for greater rigidity. Both models are available in 240V and 415V.

The components are of robust design and are superbly engineered resulting in a truly heavy duty machine, fulfilling a requirement between light weight low capacity machines and costly geared head machines.

The MG32C has the added benefit of a coolant system.

## FEATURES

- Heavy duty construction.
- 2 speed motor.
- Forward and reverse motor - 415V model only.
- Table and head can be wound up and down the column.
- Eye shield.
- Milling capability.

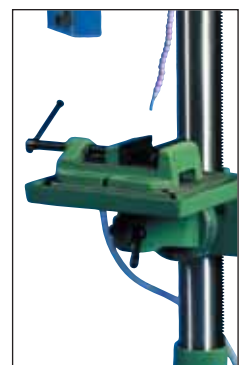
## OPTIONS

- Drill press vice STOCK CODE 18009.
- Universal crosstable - see page 31.

### HEAD DETAIL



### OPTIONAL VICE



# MEYER Geared Head Manual & Automatic Drilling Machines

Engineering  
Machinery

MODEL SR25  
STOCK CODE 18046  
415V



MODEL SR32  
STOCK CODE 18041  
415V



MODEL SR32AE  
STOCK CODE 18042  
415V



## TECHNICAL SPECIFICATIONS

MODEL		SR25	SR32	SR32AE	SR35A	SR50AE
Capacity	mm	25	32	32	35	50
Column dia	mm	95	120	120	140	180
Spindle Taper	MT no	3	4	4	4	4
Motor	Kw	0.75	1/1.2	1/1.2	1.5	3
Speeds	rpm	125 - 2825	125 - 3030	125 - 3030	76 - 2065	52 - 1400
Spindle Stroke	mm	110	160	160	190	240
Work Table	mm	350 x 400	500 x 420	500 x 420	520 x 440	580 x 460
Base Plate	mm	340 x 340	330 x 330	320 x 320	405 x 420	440 x 450
Throat	mm	240	320	320	340	360
Length	mm	700	830	830	900	980
Width	mm	450	510	510	610	650
Height	mm	1900	2180	2180	2280	2370
Weight	Kg	400	470	510	565	655

MODEL SR35A  
STOCK CODE 18043  
415V



AUTOMATIC  
FEED  
MECHANICAL  
CLUTCH

POWERED RISE &  
FALL TABLE

WIND UP AND TILTING HEAD  
STANDARD SR32/SR32A



POWERED RISE AND FALL TABLE  
STANDARD SR35A/SR50AE



POWERED RISE &  
FALL TABLE



MODEL SR50AE  
STOCK CODE 18044  
415V

AUTOMATIC  
FEED  
ELECTRO  
MAGNETIC  
CLUTCH

PICTURED WITH  
OPTIONAL  
CROSTABLE

## FEATURES

- Geared head.
- Exceptional heavy construction.
- DRO for down feed stroke - SR35A/SR50AE.
- DRO for spindle speed - SR32AE/SR35A/SR50AE.
- Large work tables.
- Auto tool release.
- Eye shield with interlock switch.
- Coolant system - except SR25.
- Low voltage lamp.
- Tilting work table  $\pm 45^\circ$ .

## OPTIONS

- NEW Infinitely variable blade speed
- Drill press vice - STOCK CODE 18009.
- Universal crosstable - STOCK CODE 18047.
- SR35A/SR50AE - Milling collett chuck set STOCK CODE 18048.

# BEMA Radial Arm Drilling Machines

Engineering Machinery



MODEL MG850  
STOCK CODE 18029  
MODEL MG1050  
STOCK CODE 18030

## FEATURES

- Heavy duty.
- DC Injection brake providing instant stop in emergency.
- Manual clamping to column and arm - MG850/MG1050.
- Automatic hydraulic clamping and unclamping when arm is raised or lowered. Independent clamping of drilling head to arm. Hydraulic gear change - MG1675/MG2090.
- Wide speed range.
- Manual, automatic and fine feed can be selected.
- Box table with T slots included.
- Adjustable working lamp.

## OPTIONS

- MEGA machine vice  
Jaw width 250mm  
Jaw opening 280mm  
STOCK CODE 18033
- MEGA machine vice  
Jaw width 320mm  
Jaw opening 360mm  
STOCK CODE 18034

## TECHNICAL SPECIFICATIONS

MODEL	MG850	MG1050	MG1675	MG2090
Capacity C.I.	mm 50	50	75	90
Spindle Taper	MT no 4	4	5	6
Motor	Kw 1.5	2.2	4	7.5
Speeds	rpm 75 - 1220	32 - 2500	25 - 2000	16 - 1250
Spindle Stroke	mm 240	280	315	400
Box Table	mm 400 x 400 x 350	600 x 450 x 450	630 x 500 x 500	800 x 550 x 550
Base Plate Size	mm 1370 x 700	1700 x 800	2400 x 1000	3000 x 1200
Throat	mm 820	1000	1600	2000
Length	mm 1400	1760	2500	3100
Width	mm 720	800	1060	1250
Height	mm 1885	2050	2650	3440
Weight	Kg 1200	1600	3750	8000

## CONTROL PANEL



HYDRAULIC CLAMPING  
ARM TO COLUMN



MODEL MG1675  
STOCK CODE 18031  
415V

MODEL MG2090  
STOCK CODE 18032  
415V

HYDRAULIC CLAMPING  
DRILLING HEAD TO ARM

CONTROL PANEL



DC INJECTION BRAKE



OPTIONAL MEGA MACHINE VICE



# BRENNER Turret Milling Machines

## Engineering Machinery

The Brenner Range of Milling Machines are high precision, very accurate and extremely versatile. The turret head can be inclined upwards and downwards, rotated in both vertical and horizontal planes, clockwise and anticlockwise. Each angle can be finely set due to the degree scales for all three variations. X, Y and Z axis are easily and accurately controlled by both the hand wheels, with micrometer scales which can be zeroed, and the DRO system. The 220R and 220RX models accept R8 tooling whilst the 375S and 515ST models driven by powerful motors accept ISO40 tooling. Infinitely variable power feed with fast override button is fitted as standard to the X axis on the 220R and 220RX models and to X, Y and Z axis on the 375S and 515ST machines.

MODEL 220R  
STOCK CODE 24213  
415V

MODEL 220RX  
STOCK CODE 24200  
415V



CENTRALISED LUBRICATION



DRO CONTROL PANEL



POWER FEED CONTROLLER



OPTIONAL SLOTTING HEAD





MODEL 375S  
STOCK CODE 24201  
415V

MODEL 515ST  
STOCK CODE 24219  
415V



## FEATURES

- High accuracy.
- Heavy duty.
- Hardened slideways.
- Centralised lubrication.
- DRO for X, Y and Z axis.
- Large table with T slots.
- Tapping facility.
- Motor brake lever.
- Coolant system.
- 220R/220RX - R8 tooling with power X axis.
- 375S/515ST - ISO40 tooling with power X, Y and Z axis.
- Halogen lamp.
- Safety guard with interlock.
- Swarf Tray.

## TECHNICAL SPECIFICATIONS

MODEL		220R	220RX	375S	515ST
Spindle Taper		R8	R8	ISO40	ISO40
Spindle Travel	mm	127	127	127	150
Number of Spindle Speeds		Variable	Variable	Variable	Variable
Spindle Speed	rpm	60 - 4200	60 - 4200	60 - 4200	60 - 3900
Quill Power Feed	mm/rev	0.04/0.08/0.13	0.04/0.08/0.16	0.04/0.08/0.16	0.04/0.08/0.16
Motor	KW	2.2	2.2	3.75	5.63
Longitudinal Travel - Long	mm	840	920	920	1200
Saddle Travel - Cross	mm	335	405	405	495
Knee Travel - Vertical	mm	350	405	405	500
Max Distance Spindle To Table	mm	435	435	435	560
Table Size	mm	230 x 1245	254 x 1370	254 x 1370	330 x 1500
Head Movement Left/Right		90°/90°	90°/90°	90°/90°	90°/90°
Head Movement Up/Down		45°/45°	45°/45°	45°/45°	45°/45°
Length	mm	1500	1670	1670	2180
Width	mm	1575	1700	1700	2050
Height	mm	2030	2235	2235	2300
Weight	Kg	1060	1280	1320	2300

MODEL S90VS-260  
WITH VARIABLE SPEED



### FEATURES

- High quality Spanish built machines
- Quality materials and highly rigid build ensure high chip removal rate during the 'rough' turning operation
- Cast bed with hardened and ground bed ways
- High resistant steel used for all gear and spindle parts with high loading capacity
- Chuck guard with interlock switch
- Centralised lubrication
- Constant surface speed – Models VS

### OPTIONS

- VS - Variable speed models
- 3 and 4 jaw chucks
- Digital readout
- Fixed and travelling steadies
- Quick change tool post

MODEL CNC SMART TURN 8  
FULL SPECIFICATIONS AVAILABLE ON REQUEST



The Pinacho range of machines have been designed and manufactured in Spain since 1968. Pinacho with their modern manufacturing facility use highest quality materials with stringent quality control and verification procedures. The range now consists of the S-90 with long life gearbox or the S-90 VS infinitely variable speed models all with high resistance hardened and ground gears. The Pinacho range includes the CNC smart turn 8, which can be used as a manual lathe for operators without programming knowledge, or in automatic copy mode or CNC with graphic simulation.

## TECHNICAL SPECIFICATIONS

MODEL	1	S-90/180/750	S-90/200/1150	S-90/225/1150	S-90/250/1150	S-90/260/2225	S-90/310/1150	S-90/310/1150 LB
	2	S-90/180/1000	S-90/200/1650	S-90/225/1650	S-90/250/1650	S-90/260/3150	S-90/310/1625	S-90/310/1625 LB
	3						S-90/310/2225	S-90/310/2225 LB
	4						S-90/310/3150	S-90/310/3150 LB

CAPACITIES								
Swing over Bed	mm	360	400	450	500	520	620	620
Swing over Cross Slide	mm	205	210	260	310	325	425	425
Swing over Gap	mm	520	600	650	700	780	880	880
Length of Gap	mm	130	160	160	125	215	200	200
Distance between Centres (1)	mm	750	750	1150	1150	2225	1150	1150
Distance between Centres (2)	mm	1000	1000	1650	1650	3150	1625	1625
Distance between Centres (3)	mm	-	-	-	-	-	2225	2225
Distance between Centres (4)	mm	-	-	-	-	-	3150	3150
Width of Bed	mm	250	300	300	300	350	350	350

FEED RATES								
Longitudinal - no. of steps	-	44	44	44	44	55	55	55
Longitudinal - range	mm/rev	0.05 - 0.75	0.05 - 0.75	0.05 - 0.75	0.05 - 1.5	0.05 - 1.5	0.05 - 1.5	0.05 - 1.5
Cross - no. of steps	-	44	44	44	44	55	55	55
Cross - range	mm/rev	0.025 - 0.375	0.025 - 0.375	0.025 - 0.375	0.025 - 0.375	0.025 - 0.75	0.025 - 0.75	0.025 - 0.75
Max. Travel of Cross Slide	mm	245	300	300	300	355	365	365
Max. Travel of Compound Rest	mm	120	130	130	130	165	165	165

THREAD CUTTING								
Metric - no. of steps	-	44	44	44	44	55	55	55
Metric - range	mm	0.5 - 7.5	0.5 - 7.5	0.5 - 7.5	0.5 - 7.5	0.5 - 15	0.5 - 15	0.5 - 15
Whitworth - no. of steps	-	44	44	44	44	55	55	55
Whitworth - range	TPI	60-4	60-4	60-4	60-4	60-2	60-2	60-2
Diametric - no. of steps	-	44	44	44	44	55	55	55
Diametric - range	DP	120-8	120-8	120-8	120-8	120-4	120-4	120-4
Module - no. of steps	-	44	44	44	44	55	55	55
Module - range	MP	0.25 - 3.75	0.25 - 3.75	0.25 - 3.75	0.25 - 3.75	0.25 - 7.5	0.25 - 7.5	0.25 - 7.5
Lead Screw Pitch	mm	6	6	6	6	6	6	6

HEADSTOCK								
Spindle Nose		D1-4	D1-4	D1-4	D1-4	D1-5	D1-5	D1-5
Spindle Bore	mm	42	52	52	105	68	80	155
Spindle Bore Taper	MT	4	4	4	4	5	5	5
Spindle Speeds - no. of steps	-	18	12	12	12	12	12	12
Spindle Speeds - range	rpm	30 - 2000	40 - 2200	40 - 2200	25 - 1200	30 - 1500	30 - 1500	16 - 750

TAILSTOCK								
Quill Diameter	mm	48	58	58	58	72	72	72
Quill Travel	mm	140	155	155	155	180	180	180
Quill Taper	MT	3	4	4	4	5	5	5

POWER								
Motor	kW	2.2/3.4	4	4	4	5.5	5.5	7.5

# MEYER Centre Lathes

## Engineering Machinery

The Meyer Precision Lathes range from 330mm to 660mm swing capacities and from 1000mm to 3000mm distance between centres. The sturdy SB models are ideal for the tool room and for jobbing operations. The heavy duty SG machines are available in eight different sizes and have the added benefit of 2 axis DRO and the super quick tool change system fitted as standard equipment. The ST range are large capacity machines with 660mm swing dimension and distance between centres available up to 3000mm. Power traverse is fitted as standard equipment to all ST model which is particularly operator friendly for the longer length machines. All Meyer lathes are of the Gap Bed design with precision ground bed and saddle. Meyer machines are equipped with generous levels of standard equipment including 3 and 4 jaw chucks and face plate.

MODEL SB1033  
STOCK CODE 24025  
415V

MODEL SB1036  
STOCK CODE 24034  
415V



SUPER QUICK TOOL CHANGE SYSTEM. STANDARD ON SG/ST MODELS.



- MODEL SG1041
- MODEL SG1541
- MODEL SG1046
- MODEL SG1546
- MODEL SG1056
- MODEL SG1556
- MODEL SG2056
- MODEL SG3056
- MODEL ST2066
- MODEL ST3066



SG RANGE

VIEW THROUGH BED AND SADDLE. SG.



OPTIONAL TAPER TURNING ATTACHMENT.



## FEATURES

- Heavy duty.
- Chuck guard with interlock switch.
- Halogen lamp.
- Steady rest.
- Follow rest.
- 4 jaw chuck.
- 3 jaw chuck.
- Face plate.
- Coolant system.
- SG/ST - 2 axis DRO.
- SG/ST - super quick tool change system with 4 holders.
- ST – Power traverse

### DRO system



## OPTIONS

- Taper turning attachment.

# MEYER TECHNICAL SPECIFICATIONS

	SB1033	SB1036	SG1041 (1) SG1541 (2)	SG1046 (1) SG1546 (2)	SG1056 (1) SG1556 (2) SG2056 (3) SG3056 (4)	ST2066 (1) ST3066 (2)
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## CAPACITIES

Swing over Bed	mm	330	360	410	460	560	660
Swing over Cross Slide	mm	200	212	224	274	350	440
Swing over Gap	mm	476	491	640	690	788	900
Length of Gap	mm	210	210	155	155	200	250
Distance between Centres (1)	mm	1000	1000	1000	1000	1000	2000
Distance between Centres (2)	mm	-	-	1500	1500	1500	3000
Distance between Centres (3)	mm	-	-	-	-	2000	-
Distance between Centres (4)	mm	-	-	-	-	3000	-
Width of Bed	mm	187	187	300	300	350	400

## FEED RATES

Longitudinal - no.of steps	-	36	36	42	42	35	25
Longitudinal - range	mm/rev	0.050-0.696	0.050-0.696	0.031-1.7	0.031-1.7	0.059-1.646	0.022 - 0.74
Cross - no.of steps	-	36	36	42	42	35	25
Cross - range	mm/rev	0.013-0.188	0.013-0.188	0.014-0.784	0.014-0.784	0.02-0.573	0.044 - 1.48
Max. Travel of Cross Slide	mm	160	118	290	290	326	368
Max. Travel of Compound Rest	mm	68	68	120	120	130	230

## THREAD CUTTING

Metric - no. of steps	-	28	28	41	41	47	54
Metric - range	mm	0.2-5.0	0.2-5.0	0.1-14	0.1-14	0.2-14	.45 - 120
Imperial - no. of steps	-	36	36	60	60	60	54
Imperial - range	TPI	8-112	8-112	2-112	2-112	2-112	7/16 - 80
Diametric - no of steps	-	36	36	50	50	50	42
Diametric - range	DP	8-112	8-112	4-112	4-112	4-112	7/8 - 160
Module - no. of steps	-	22	22	34	34	39	42
Module - range	MP	0.2-3	0.2-3	0.1-7	0.1-7	0.1-7	0.25- 60
Lead Screw Pitch	mm	3	3	6	6	6	2 or 12

## HEADSTOCK

Spindle Nose		D1-4	D1-4	D1-6	D1-6	D1-8	D1-8
Spindle Bore	mm	38	38	58	58	80	105
Spindle Bore Taper	MT	5	5	6	6	7	5
Spindle Speeds - no. of steps	-	8	8	12	12	12	16
Spindle Speeds - range	rpm	70-2000	70-2000	25-2000	25-2000	25-1600	26-1700

## TAILSTOCK

Quill Diameter	mm	32	32	60	60	75	90
Quill Travel	mm	100	100	120	120	180	235
Quill Taper	MT	3	3	4	4	5	5

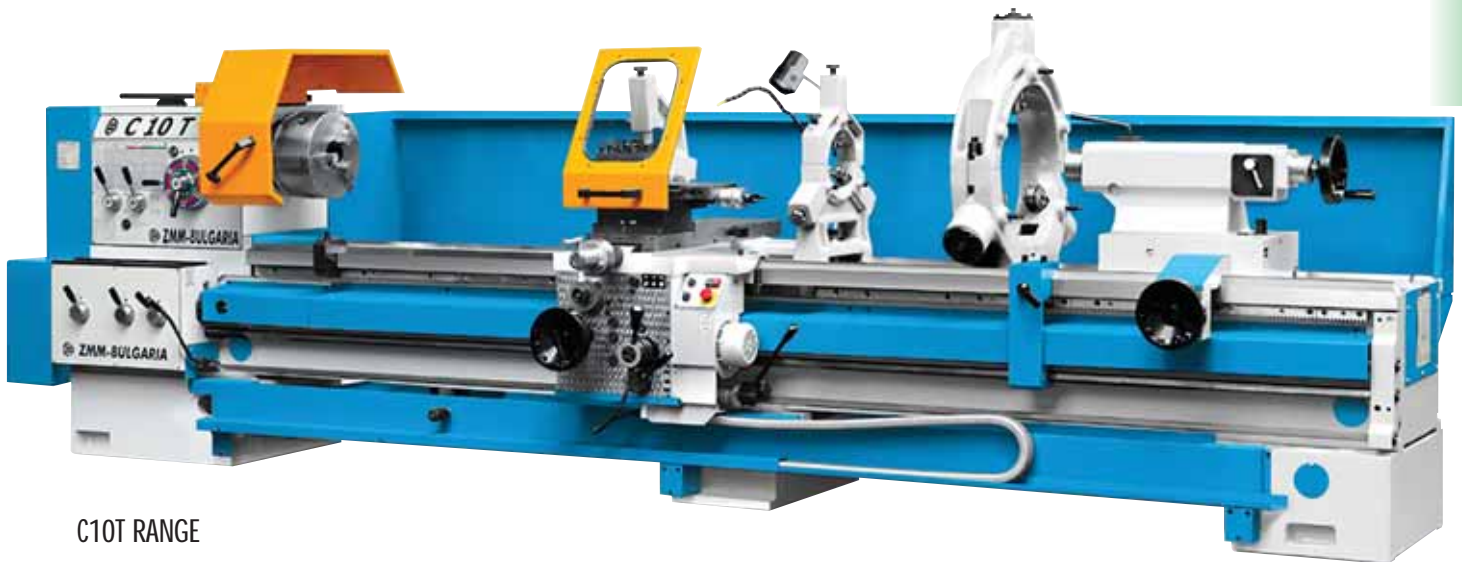
## POWER

Motor	kW	1.5	1.5	4	4	7.5	7.5
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## DIMENSIONS

Length (1)	mm	1900	1900	2170	2170	2400	3710
Length (2)	mm	-	-	2720	2720	2900	4720
Length (3)	mm	-	-	-	-	3400	-
Length (4)	mm	-	-	-	-	3900	-
Width	mm	700	700	1040	1040	1120	-
Height	mm	1220	1250	1340	1370	1460	1230
Weight (1)	kg	560	670	1670	1720	2020	1600
Weight (2)	kg	-	-	1970	2020	2370	2950
Weight (3)	kg	-	-	-	-	2720	3320
Weight (4)	kg	-	-	-	-	3065	-

With one of the largest ranges of Centre Lathes available in the world, ZMM lathes designed and manufactured in Europe are a high quality solution for today's turning requirements. With a manual range of lathes between 325mm – 1600mm swing and CNC and Oil Country options, there is a ZMM machine for most applications. All ZMM Centre Lathes are of the Gap Bed design with precision ground bed and saddle and can be specified with a wide range of optional equipment. The models featured below all have the extra wide 560mm Bed Width for rigidity and strength for the most demanding job



C10T RANGE



CU RANGE

## FEATURES

- European Heavy Duty Build Quality
- Full CE Guarding inc Leadscrew & Chuck Guard
- Newell 2 Axis DRO
- Powered Traverse to Longitudinal Travel
- Quick Change Toolpost
- Thread Chasing Dial
- Coolant System
- 3 Jaw Self Centring Chuck
- 4 Jaw Independent Chuck
- Face Plate

## OPTION

- Taper Turning Attachment



LCC LARGE BORE CNC RANGE

Model	C10T/660	C10TM/760	C10TH/860
<b>Capacity</b>			
Height of Centres mm	330	380	430
Swing over Bed mm	660	760	860
Swing over Cross Slide mm	420	520	620
Swing in gap mm	850	950	1050
Width of Bed mm	560	560	560
Distance between Centres DBC mm	1500, 2000, 3000, 4000, 5000, 6000		
<b>Spindle</b>			
Spindle Nose DIN 55027 No	11	11	11
Spindle Bore mm	103	132	132
Spindle Taper mm	120	140	140
<b>Headstock</b>			
Number of Spindle Speeds	15	17	17
Spindle Speed Range rpm	9-1320	7.5-1015	7.5-1015
Main Motor Power kw	11	11 (15)	15
<b>Feeds</b>			
Number of Feeds	150	150	150
Longitudinal Feed Range mm/rev	0.039-18	0.039-18	0.039-18
Cross Feed Range mm/rev	0.02-9	0.02-9	0.02-9
<b>Threads</b>			
Number of Threads	76	76	76
Metric Thread Range mm	0.5-180	0.5-180	0.5-180
Inch Thread Range Tpi	60-1/6	60-1/6	60-1/6
Module Thread Range	0.125-45	0.125-45	0.125-45
DP Thread Range	240-2/3	240-2/3	240-2/3
<b>Carriage</b>			
Cross Slide Travel mm	410	410	435
Top Slide Travel mm	150	150	150
<b>Tail Stock</b>			
Quill Diameter mm	105	105	105
Quill Taper Morse	6	6	6
Quill Travel mm	225	225	225
Weight for DBC 2000mm kg	4170	4470	4650





MODEL BS30  
STOCK CODE 17400  
415V



MODEL BT60  
STOCK CODE 17401  
415V



MODEL PS30  
STOCK CODE 17402  
415V



MODEL PT60  
STOCK CODE 17403  
415V

The Kepp drill grinding machines provide the perfect solution to easily, quickly and accurately sharpen drill bits. The single arm models can sharpen up to 30mm, whilst the twin arm machines have a maximum capacity of 60mm. The machines are simple to use as the operator places the drill bit into the arm, locates the flute into a positioning pin and swings the arm backwards and forwards. The drill is perfectly ground against the side of the grinding wheel. The operator simply rotates the drill bit 180 degrees and repeats the process to complete.

## FEATURES

- Fast accurate sharpening of drill bits.
- Available as bench models or with pedestal and coolant reservoir.
- Tool rest supplied to auxiliary grinding wheel with single arm models.

### GRINDING WHEEL WITH ARM



## TECHNICAL SPECIFICATIONS

MODEL		BS30	BT60	PS30	PT60
Drill Grinding Capacity	mm	4 - 30	4 - 60	4 - 30	4 - 60
Grinding Cup wheel	mm	200 x 38 x 20	200 x 38 x 20	200 x 38 x 20	200 x 38 x 20
Table size	mm	-	390 x 410	-	390 x 410
Speed	rpm	3000	3000	3000	3000
Motor	kw	0.83	0.83	0.83	0.83
Length	mm	700	980	700	980
Width	mm	250	425	250	425
Height	mm	380	1025	380	1025
Weight	kg	35	55	38	58

### INTRODUCTION

Our range of fabrication machinery has been further refined with new improved products, controllers and benefits. As main agents for renowned worldwide machinery manufacturers we are able to provide full and rapid after sales support to our valued customers. Our team of trained sales staff are on hand to assist in product selection, particularly for the more complex bending operations. Tube, standard sections and specialised extrusions can all be manipulated with our range of machines together with our tooling department.

#### Product overview

##### Imaca Portable Punch Range

The Imaca range of portable punching machines are proving very popular. The ability to punch up to 24mm holes through 16mm Mild Steel plate on site or anywhere in the workshop adds a new dimension to fabricating plates or beams. A unique feature also is the double acting cylinder which allows the punching of stainless steel.



##### Simasv

These specialist horizontal bending machines now include a CNC controller available in two capacities. By entering the X axis for the bending angle and the Y axis for the material length stop, repeatability and accuracy is assured. A comprehensive range of tooling with the capability for 'specials' ensures that these quality machines from Italy are fully utilised.

##### CBC

The CBC range has been greatly increased with four new models for this catalogue. The popular UNI 42, UNI60 and UNI 70 models remain and are now added to with the large capacity UNI 89, which can bend a remarkable 89mm with 8mm wall thickness. In addition the mandrel tube bender range has been expanded with three larger models all with hydraulic clamping.



##### Almi

As sole UK distributors for the Almi pipe notchers we are pleased to launch the NEW high speed X100 model specially designed for the stainless steel tube industry. Whether the requirement is balustrading for a prestigious office block, hotel entrance, shopping mall staircase, luxury yacht or many other applications the Almi tube notcher ensures the highest quality tube joints at any angle up to sixty degrees.

##### Omca

The ART760 machine is also now available as the ART760 NEW/3F especially designed for bevelling stainless steel. Further new models include the large capacity ART910 model which can be used as a self-feed machine. Omca machines are manufactured in Italy and can be found in fabrication workshops, ship yards and training establishments the world over.



## Magnetic Drilling Machines



MODEL EDX LoPro35  
STOCK CODE 19032 110V

MODEL JM201  
110V STOCK CODE 19008,  
240V STOCK CODE 19009



MODEL HOLEMAKER 40  
STOCK CODE 19001 110V  
STOCK CODE 19000 240V



### FEATURES

- Large model range from easily portable lightweight machines to heavy duty workshop machines
- All machines supplied with carrying case
- Powerful magnetic base for secure grip to the workpiece
- 13mm chuck supplied with the HOLEMAKER 40
- EDX LoPro35 – only 200mm height
- Reversible handle for use in tight applications – LoPro35, HOLEMAKER 40, PB32 & PB70
- Forward and reverse motor with variable speed for tapping – PB70
- Mechanical clutch – PB70
- Swivel base through 260° and lateral movement of 22mm – PB100SB
- Soft start motor – PB70, PB100E, PB100SB

TAPPING  
UP TO  
M12



MODEL PB32  
STOCK CODE 19028 110V  
STOCK CODE 19029 240V



MODEL PB70/2  
STOCK CODE 19016 110V  
STOCK CODE 19017 240V



MODEL PB100E  
STOCK CODE 19020 110V  
STOCK CODE 19021 240V

MODEL PB32 COMBI  
STOCK CODE 19030 110V  
STOCK CODE 19031 240V

MODEL PB70  
STOCK CODE 19018 110V  
STOCK CODE 19019 240V

MODEL 100SB (Swivel Base)  
STOCK CODE 19022 110V  
STOCK CODE 19023 240V

### TECHNICAL SPECIFICATIONS

MODEL		LoPro35	JM201	H40	PB32	PB32 COMBI	PB70/2	PB70	PB100E	PB100SB
Clamping force	kgs	1500	980		1000	1000	1500	1500	2000	2000
Motor	Watts	1100	925	1050	770	770	1750	1850	1850	1850
Speed	rpm	390	350	350	380	25/550	120/410	60 - 140/200 - 470	220/260/350/420	220/260/350/420
Length	mm	285	240	290	240	240	330	330	320	320
Width	mm	101	166	180	90	90	110	110	110	110
Height	mm	200	307	380	300	300	445	445	480	480
Weight	kg	10	10.6	10.5	12.5	12.5	22	22	25	25
Cutter Capacity	mm	35 x 30	30	40	32	32	70	70	100	100
Stroke	mm	-	63	100	165	165	200	200	280	280
Twist Drill Capacity	mm	-	12	12	18	18	32	32	32	32
Morse Taper	No	-	-	-	-	-	3	3	3	3

# ATRA & MAG4 Range of Magnetic Drills



MODEL ATRA 3500  
STOCK CODE 19067



MODEL ATRA 5000  
STOCK CODE 19065



MODEL MAG4  
STOCK CODE 19050



MODEL MAG4T  
STOCK CODE 19051

## FEATURES

### ATRA 3500 & 5000

- Unique power feed through the cut saving time and increasing safety.
- Unique load sensor control ensuring cutter force feedback for optimised feed speed.
- Overload protection enabling cutter to be automatically stopped to prevent breakage if there is excessive force.
- Magquick Arbor ensuring tool free cutter replacement.

### MAG4 & MAG4T

- Ultra heavy duty Magnetic Drill with 4 Morse Taper Capacity.
- Can handle Broach cutters up to 130mm dia x 110mm deep.
- Can handle Morse Taper drills up to 47mm diameter.
- Can tap up to M42 (with tap tooling – MAG4T).
- 4 Speeds (Variable – MAG4T).

## TECHNICAL SPECIFICATIONS

Model		Atra 3500	Atra 5000	MAG4	MAG4T
Clamping force	kgs	720	1150		
Motor	Watts	1100	1150	1800	2300
Speed	rpm	950	350/650	85/135/160/250	30-80/50-120 130-350/210-550
Cutter Capacity	mm	35 x 50mm	50 x 75mm	110 x 100mm	130 x 110mm
Twist Drill Capacity	mm	n/a	n/a	47	47
Morse Taper	No	n/a	n/a	4	4
Countersink Capacity		35mm	50mm	63mm	80mm
Tapping Capacity		n/a	n/a	M30	M42
Shank		¾" Magquick	¾" Magquick	1 ¼" Weldon	1 ¼" Weldon
Length	mm	409	613	460	495
Width	mm	237	237	260	255
Height	mm	480	613	570	600
Weight	kg	20	23	31	51



EDX™ Drum Polisher Kit 110V -  
Stock Code 11600



EDX™ Tube Polisher Kit 110V -  
Stock Code 11610



NEBES Bench Grinder Range  
SE RANGE



CE Range



## TECHNICAL SPECIFICATIONS

MODEL	SE-9	SE-10	CE-9	CE-10
Stock Code	17050	17051	17052	17053
Motor Watt/HP	375/0.5	750/1	375/0.5	750/1
RPM:	2800	2800	2800	2800
Wheel Size mm:	150 x 20 x 16	200 x 25 x 20	150 x 20 x 16	200 x 25 x 20
Electrics	1PH/240V	1PH/240V	1PH/240V	1PH/240V
Dimensions cm:	43 x 24 x 31	55 x 29 x 36	51 x 24 x 31	65 x 29 x 36
Weight kG:	11 KG	18	12	20

The New EDX™ Drum Polisher & Tube Polisher is the Cost Effective Solution to your Stainless Finishing Needs. Extremely Versatile & Lightweight, these High Performance Tools produce a Consistent High Grade, Quality Finish which is aesthetically pleasing. Whether you require a Grain Finish Balustrade or a Mirror Finish Sheet, EDX™ will provide you with the effect you require and your customer expects. With a Wide Range of Consumables in stock to compliment these Tools, we can cater for all your Metal Grinding & Finishing Requirement. Contact our Sales & Technical Team for Expert Advice and Pricing.

## FEATURES

- Heavy Duty 1200 Watt Motor.
- Variable Speed for those different applications.
- Drum Polisher Supplied in Kit Case with Inflatable Wheel & Eco Belt Roller Drum Polisher.
- Tube Polisher Supplied in Kit Case with Belts.

## OPTIONS

- 11601 EDX™ Inflatable Wheel.
- 11602 EDX™ Belt Roller

NEBES Range of Bench Grinding Machines are very Heavy Duty and High Performance. Made in Europe and manufactured to the highest standards, these Bench Grinders are also available in 10", 12", 14" and 16" Wheel Dia.

## FEATURES & OPTIONS

- Grinding Wheels Only - SE Range.
- Grinding Wheel & Wire Brush - CE Range.
- 3PH/415V available.
- Pedestal available.

# EP PUNCH Range of Electro Hydraulic Portable Punching Machines

## Fabrication Machinery



MODEL EP-1475V  
STOCK CODE 16512  
110V  
STOCK CODE 16513  
240V



MODEL EP-1406V  
STOCK CODE 16510  
110V  
STOCK CODE 16511  
240V



MODEL EP-19V  
STOCK CODE 16514  
110V  
STOCK CODE 16515  
240V



MODEL EP-2110V  
STOCK CODE 16516  
110V  
STOCK CODE 16517  
240V

### FEATURES

- Fast punching.
- Light weight.
- Compact size.
- Self contained - no additional powerpack.
- Punches round and slotted holes.
- Considerable time savings.
- Adjustable depth stop.
- Ideal for site applications.
- Supplied with base for bench work.
- Steel case included.

### TECHNICAL SPECIFICATIONS

MODEL		EP-1406V	EP-1475V	EP-19V	EP-2110V
Rated Capacity	tonnes	11	11	16	30
Maximum Capacities	mm	14 x 6	14 x 6	19 x 6	22 x 10
Maximum Punching Thickness	mm	6	6	6	10
Punching Stroke	mm	10	10	10	13
Throat Depth	mm	26	37.5	55	65
Weight	kg	8	10	14.5	21
Punching Time	sec	2	2	2	2
Return Time	sec	2	2	2	2



DOUBLE ACTING  
CYLINDER FOR  
SMOOTH 2-WAY  
OPERATION

## FEATURES

- Quick and clean punching of holes
- Almost noiseless operation
- Power inching for precise alignment
- Portable yet powerful
- Can be bench mounted for punching base plates etc.
- Large range of punches and dies available - round, square, slot and special shapes
- 5m hose assembly with quick release couplings
- Pump is interchangeable with any of the punching units
- Pump electric supply - single phase 110 Volt or 240 Volt AC

In case of mild steel, maximum punching thickness must be decided based on the equation of  $0.8 \times$  punching diameter.

## OPTIONS & ACCESSORIES



HANGING HOOK FOR  
SUSPENDING HEAD



SPRING BALANCER USED IN  
CONJUNCTION WITH HOOK

MODEL PP37-60 110V  
STOCK CODE 16540

MODEL PP47-70 110V  
STOCK CODE 16541

MODEL PP47-110 110V  
STOCK CODE 16542



The UNIJIB telescopic swinging jib makes it easy to position an Imaca punch

## TECHNICAL SPECIFICATIONS

MODEL		PP37-60		PP47-70		PP47-110	
Rated Capacity	tonnes	37		47		47	
Punching Capacity		For mild steel	For stainless Steel	For mild steel	For stainless Steel	For mild steel	For stainless Steel
Maximum Punching Thickness	mm	13	6	16	6	16	6
Maximum Punching Diameter	mm	22	22	24	24	24	24
Ram Stroke	mm	21		25		25	
Throat Depth	mm	60		70		110	
Weight	kg	20.5		25.5		30	
Punching Time	sec	7.9		11.8		11.8	

The Morgan Rushworth HSW40 hydraulic steelworkers have 4 stations, are of compact size and have a powerful 40 tonnes capacity.

The universal bolster allows the punching of sheet metal, flat bar, angle iron and the flange of channel and beam. Tooling for special applications is available on request.

Large, heavy-duty tables with guides are part of the extensive range of standard equipment. The machines are equipped with blades for cropping round and square bars, angle iron and for shearing flat bar. A 1M ruled length stop is supplied as standard equipment.

### FEATURES

#### ● PUNCH STATION

The standard punch station enables punching holes with a diameter of up to 38mm. The stroke is fully adjustable.



#### ● ANGLE STATION

Angle iron can be cut at 90° and 45° with either internal or external mitres.



#### ● SECTION CUTTING STATION

Cropping of round and square bar is easily performed with the standard blades. Optional blades and hold downs are available to crop special profiles.



#### ● SHEARING STATION

Thick and thin material can be sheared without the need for blade gap or cutting-angle adjustments. This station also allows flange cutting of angle profiles.



MODEL HSW 40  
STOCK CODE M9000

Technical Specifications see page 58



The HSW 45 and the HSW 60 are compact universal hydraulic steelworkers with 5 workstations and have been designed for volume production with maximum efficiency. Punching, shearing, cropping and notching can be carried out instantly by pressing the moveable foot pedal. The low power inch mode on each workstation enables correct workpiece positioning and tool alignment. Limit-switches allow accurate adjustment of the stroke length to minimise operational time depending on material thickness. At the angle cutting station, angle iron can be cut on every angle from 45° up to 90°, both internal and external with standard tooling.

The machines are supplied with a centralised lubrication system ensuring a easy, simple maintenance programme. Adjustable hold-downs are situated on all work stations to ensure safe and accurate processing of material. A 1M ruled length stop is supplied as standard equipment.



MODEL HSW 45  
STOCK CODE M9001

MODEL HSW 60  
STOCK CODE M9002

## FEATURES

### ● PUNCH STATION

Easy tool change system and swing away stripper with fast manual adjustment ensure a quick setup.



### ● ANGLE STATION

Angle iron can be cut at any angle between 45° and 90°, with either internal or external mitres.



### ● SECTION CUTTING STATION

Cropping of round and square bar is easily performed with the standard blades. Optional blades and hold downs are available to crop special profiles.



### ● SHEARING STATION

Specially designed blade approach angle cuts thin and thick material with minimum distortion.



### ● NOTCHING STATION

This versatile unit is equipped with a rectangular notch unit as standard.



Technical Specifications see page 58

The HST machines are supplied with standard tooling including repetition support tables at punch, shear and notch stations. All five work stations are equipped with easily adjustable hold downs to safely control each operation. Comprehensive safety guards are fitted as standard on all work stations. The HST Range are twin operator machines with the hydraulic system activated by two shielded foot controls, one operating the punch and cylinder, the other operating the shear end cylinder. The shear cylinder provides the power to the three shearing and the notch stations. The system gives accurate power inching at all five work stations and allows the machine to be stopped at any position giving safe and accurate tool setting and work positioning. Centralised lubrication is metered by one-shot system, being only one feature of the low maintenance requirements.

A 1M auto crop ruled length stop and a removable halogen lamp are supplied as standard equipment with all HST machines.



MODEL HST 70	STOCK CODE M9003
MODEL HST 95	STOCK CODE M9004
MODEL HST 125	STOCK CODE M9005
MODEL HST 175	STOCK CODE M9006

Technical Specifications see page 58

**FEATURES****● PUNCH STATION**

Easy tool change system and swing away stripper with fast manual adjustment ensure a quick setup.

**● ANGLE STATION**

This station provides large capacity angle cutting at 90° and 45°. Angles between 45° and 90° can be achieved by first cutting at 90° and then flange trimming to the required angle in the shearing station.

**● SECTION CUTTING STATION**

The machines are fitted as standard with blades for cutting round and square bars. With extra equipment, the machines are able to cut, in this aperture, channel, joist, T-sections and many other special profiles.

**● SHEARING STATION**

The shearing unit is fitted with a simple robust holddown which is adjustable to any thickness of material within the cutting capacity of the machine. The shear feed table with adjustable guides is fitted to allow accurate feeding of materials. The guide can be adjusted to allow mitre cutting up to 45° for flat bars or to trim the flanges of angle.

**● NOTCHING STATION**

The notching station is fitted with a table with adjustable back stops allowing repetitive positioning.

**● AUTO CROP RULED LENGTH STOP**

Standard 1m stop with automatic shearing bypassing the foot switch for production applications. Can be used on all shear stations. Available in 2m and 3m options.



**TECHNICAL SPECIFICATIONS**

MODEL		HSW 40	HSW 45	HSW 60	HST 70	HST 95	HST 125	HST 175
<b>PUNCHING</b>								
DIAMETER x MAXIMUM THICKNESS	mm	20 x 15	22 x 15	28 x 15	26 x 20	33 x 20	35 x 25	40 x 32
MAXIMUM DIAMETER x THICKNESS	mm	38 x 8	38 x 8	38 x 11	57 x 10	57 x 12	57 x 16	57 x 22
STROKE LENGTH	mm	50	50	55	55	80	80	80
THROAT DEPTH	mm	175	175	220	305	355	355	625
LARGEST HOLE DIAMETER - STANDARD	mm	38	38	38	38	57	57	57
LARGEST HOLE DIAMETER - OPTIONAL	mm	57	110	110	160	160	225	225
<b>SHEARING</b>								
FLAT BAR - WIDTH x MAXIMUM THICKNESS	mm	200 x 13	200 x 15	200 x 20	300 x 20	380 x 20	380 x 25	380 x 30
FLAT BAR - MAXIMUM WIDTH x THICKNESS	mm	350 x 6	300 x 12	300 x 15	375 x 15	480 x 15	600 x 15	600 x 20
ANGLE FLANGE TRIM - max 45°	mm	80 x 10	80 x 10	80 x 10	100 x 15	120 x 15	120 x 15	120 x 15
<b>ANGLE CUTTING</b>								
90° CUT	mm	80 x 8	100 x 10	127 x 12	130 x 13	150 x 15	150 x 18	200 x 20
45° MITRE (true int./ext.)	mm	50 x 6	70 x 6	80 x 8	70 x 10	80 x 8	80 x 10	80 x 10
<b>SECTION CUTTING</b>								
ROUND/SQUARE	mm	30/25	30/25	40/35	45	50	55	65/55
CHANNEL/BEAM - (OPTIONAL)	mm	76 x 38	80 x 45	80 x 45	120 x 58	160 x 74	200 x 100	300 x 125
TEE - (OPTIONAL)	mm	38 x 6	40 x 5	40 x 5	90 x 11	100 x 11	120 x 12	150 x 15
<b>NOTCHING</b>								
MATERIAL THICKNESS	mm	-	8	10	10	13	13	16
WIDTH - RECTANGLE	mm	-	35	42	45	52	60	60
DEPTH - RECTANGLE	mm	-	75	100	90	100	100	100
DEPTH - VEE	mm	-	60	60	60	70	80	80
<b>TUBE NOTCH (OPTIONAL)</b>								
MAXIMUM OUTSIDE DIAMETER	mm	40	60	60	83	108	108	165
<b>BENDING (OPTIONAL)</b>								
BAR BENDING - MAXIMUM CAPACITIES	mm	-	100 x 12	150 x 12	250 x 13	250 x 20	250 x 22	250 x 25
SHEET BENDING - MAXIMUM CAPACITIES	mm	-	-	-	500 x 3	500 x 3	700 x 3	700 x 4
<b>PUNCHING AT NOTCH STATION (OPTIONAL)</b>								
THROAT DEPTH	mm	-	85	110	125	125	125	125
MAXIMUM CAPACITY - DIAMETER x THICKNESS	mm	-	18 x 12	20 x 12	38 x 8	38 x 10	38 x 12	38 x 13
<b>TECHNICAL DATA</b>								
MOTOR POWER	kW	3	4	4	5.5	7.5	11	11
NETT WEIGHT	kg	580	1180	1440	1620	2430	3080	6000
LENGTH	mm	1100	1450	1520	1700	1920	2040	2730
WIDTH	mm	550	590	590	710	790	800	1120
HEIGHT	mm	1480	1620	1700	1800	1910	2030	2160

based on material strength of 450 N/mm<sup>2</sup>



The Morgan Rushworth HSP Punch range comprises of 4 models between 70 – 175 tons capacity. They are a cost effective punching solution with enhanced capabilities. All machines in the range are equipped with a 625mm deep throat as standard. The heavy duty support table with scales and backstops, universal die holder for the punching of plate, flat bar, angle iron and flange of channel and beam are all included in the standard execution. The front section of the support table can be removed in order to punch angle iron leg down. All machines are supplied with a Production Pack as standard including a Halogen work lamp and slug collector.

### FEATURES

- Full stroke adjustment
- Low power inching
- High speed hydraulics
- Punch table with multipurpose bolster
- Low maintenance
- Overload relief on hydraulic system
- Easy change punch holder, Swing away punch stripper unit

### TECHNICAL SPECIFICATIONS

MODEL		HSP70	HSP95	HSP125	HSP175
<b>PUNCHING</b>					
DIAMETER x MAXIMUM THICKNESS	mm	26 x 20	33 x 20	34 x 26	40 x 32
MAXIMUM DIAMETER x THICKNESS	mm	57 x 10	57 x 12	55 x 16	57 x 22
STROKE LENGTH	mm	55	80	80	80
THROAT DEPTH	mm	625	625	625	625
LARGEST HOLE DIAMETER - STANDARD	mm	57	57	57	57
LARGEST HOLE DIAMETER - OPTIONAL	mm	110	110	110	125
<b>TECHNICAL DATA</b>					
MOTOR POWER	kW	5.5	7.5	11	11
NETT WEIGHT	kg	2440	3270	3760	5270
LENGTH	mm	1600	1850	2000	2700
WIDTH	mm	900	950	950	1120
HEIGHT	mm	1800	1920	1970	2160

The Morgan Rushworth HSDP Double Punch range comprises of 4 models between 70 – 175 tons capacity. They are a cost effective punching solution enabling two punching operations simultaneously. All machines in the range are equipped with a 625mm deep throat punching station as standard and the other end has a standard 355mm throat depth. The heavy duty support table with scales and backstops, universal die holder for the punching of plate, flat bar, angle iron and flange of channel and beam are all included in the standard execution. The front section of the support table can be removed in order to punch angle iron leg down. All machines are supplied with a Production Pack as standard including a Halogen work lamp and slug collector.



## FEATURES

- Full stroke adjustment
- Low power inching
- Overload relief on hydraulic system
- Easy change punch holder, Swing away punch stripper unit
- Punch table with guides
- Work station guard
- Production pack including Halogen work lamp and slug collector

## TECHNICAL SPECIFICATIONS

MODEL		HSDP70	HSDP95	HSDP125	HSDP175
<b>PUNCHING</b>					
DIAMETER x MAXIMUM THICKNESS	mm	26 x 20	33 x 20	34 x 26	40 x 32
MAXIMUM DIAMETER x THICKNESS	mm	57 x 10	57 x 12	55 x 16	57 x 22
STROKE LENGTH	mm	55	80	80	80
THROAT DEPTH	mm	625	625	625	625
LARGEST HOLE DIAMETER - STANDARD	mm	57	57	57	57
LARGEST HOLE DIAMETER - OPTIONAL	mm	110	110	110	125
<b>TECHNICAL DATA</b>					
MOTOR POWER	kW	5.5	7.5	11	11
NETT WEIGHT	kg	2440	3270	3760	5270
LENGTH	mm	1600	1850	2000	2700
WIDTH	mm	900	950	950	1120
HEIGHT	mm	1800	1920	1970	2160



The Morgan Rushworth HSP NC Punch range is a high production solution for batch run manufacturing. This 2 Axis Linear Rail and Positioning System enables the operator to perform punching operations with no marking or measuring. Once the NC Control has been programmed, the Positioning System moves to punch positions with speed and accuracy while multiplying the productivity of the operator. Available on the HSP 95, 125 and 175 Punches, this solution will increase production and lower costs.



**TECHNICAL SPECIFICATIONS**

MODEL		HSP CNC 95	HSP CNC 125	HSP CNC 175
<b>PUNCHING</b>				
DIAMETER x MAXIMUM THICKNESS	mm	33 x 20	34 x 26	40 x 32
MAXIMUM DIAMETER x THICKNESS	mm	57 x 12	55 x 16	57 x 22
STROKE LENGTH	mm	80	80	80
THROAT DEPTH	mm	625	625	625
LARGEST HOLE DIAMETER - STANDARD	mm	57	57	57
LARGEST HOLE DIAMETER - OPTIONAL	mm	110	110	125
<b>TECHNICAL DATA</b>				
MOTOR POWER	KW	7.5	11	11
NETT WEIGHT	kg	3270	3760	5270
LENGTH	mm	1850	2000	2700
WIDTH	mm	950	950	1120
HEIGHT	mm	1920	1970	2160

**FEATURES**

- 2 Axis NC Linear Rail and Positioning System for speed and accuracy
- No need for hand marking or measuring
- 1000mm x 500mm X + Y Capacity
- User friendly software supplied for quick programming
- Software can store up to 100 programmes
- Mobile Control Pendant with large Display



MODEL HFP 775/30



The Morgan Rushworth HFP range of H frame presses are ideal for a whole variety of bending, forming, pressing, straightening operations. The range extends from 30 tonne up to the powerful 150 tonne models with a choice of distances between the frames. The hydraulic system is equipped with a manometer and a joystick lever to control the operation. A pair of V blocks are supplied as standard equipment.



MODEL HFP 1040/60

### FEATURES

- Easily adjusted bed height with two hardened pins
- Bed designed to accept a variety of supports and jigs according to customer requirements
- Quiet hydraulic system
- Hydraulic cylinder mounted above providing vertical pressure
- Ideal for low or high volume operation.

### TECHNICAL SPECIFICATIONS

MODEL	Power	Distance between frames	Stroke	Advance speed	Return speed	Motor	length	Width	Height	Weight	
Stock code	Tonnes	mm	mm	mm/sec	mm/sec	kw	mm	mm	mm	kg	
HFP 775/30	M4500	30	775	200	8	10	3	1500	700	1800	410
HFP 1040/60	M4501	60	1040	250	8	10	4	1850	700	2100	790
HFP 1070/100	M4502	100	1070	300	8	10	5.5	2050	1000	2200	1520
HFP 1570/100	M4503	100	1570	300	9	10	5.5	2500	1000	2200	1900
HFP 1070/150	M4504	150	1070	300	9	10	11	2050	1000	2270	1620
HFP 1570/150	M4505	150	1570	300	9	10	11	2500	1000	2270	2150



The Morgan Rushworth powered ring rolling machines are available in shaft diameters of 35mm and 50mm. Both models provide a cost effective solution for the bending of various sections, ideal for 'Jobbing' type applications. All machines include a full set of rolls for the bending of flat bar, flat bar on edge, round bar, square bar and box section. Both of the bottom rolls are powered, providing powerful traction, whilst the top adjustable idler roll determines the bending radius according to its position.

MODEL PSR 35/140  
STOCK CODE M6012 415V  
STOCK CODE M6013 240V



MODEL PSR 50/155  
STOCK CODE M6014



### FEATURES

- Operates horizontally or vertically.
- Forward and reverse Foot Pedal.
- Manual roll adjustment with pointer and scale roll position indicator.
- Optional tube rolls available on request



BENDING FLAT BAR ON EDGE



BENDING TUBE



Technical specifications see page 148

MODEL HSR 50/160  
STOCK CODE M6000



MODEL HSR 60/175  
STOCK CODE M6001

MODEL HSR 80/245  
STOCK CODE M6002

MODEL HSR 100/315  
STOCK CODE M6003

MODEL HSR 120/390  
STOCK CODE M6004

PICTURED WITH  
OPTIONAL TIE ROD AND  
HYDRAULIC LATERAL  
GUIDE ROLLS



HSR RANGE MODEL  
PICTURED IN  
HORIZONTAL  
POSITION



The Morgan Rushworth HSR range of hydraulic section bending machines are designed to roll various material sections and are available with shaft diameters from 50mm up to 120mm. The entry level HSR 50/160 model has a single hydraulic ram to adjust the top roll, whilst the remaining machines have twin rams powering both of the lower rolls, providing pre bending capability and the convenience of performing the bending operation with the material in the horizontal position. All of the HSR machines can be operated in either vertical or horizontal plain. The standard rolls supplied with the machine are hardened and have been designed to bend most sections, avoiding the cost of additional tooling. Lateral guide rolls ensure straight and true bending, or if required can be adjusted in order to spiral the material.

### FEATURES

- All three rolls driven for excellent traction
- Smooth rolls ensure minimum material marking
- Hardened rolls
- Moveable control panel
- Digital read out indicating both lower roll position (not HSR 50/160)
- Overload protection device (not HSR 50/160)
- Hydraulically powered rotation - HSR 100/315, HSR 120/390
- Hydraulically adjusted lateral guide rolls in 2 axis - HSR 120/390

### OPTIONS

- Tube rolls
- Digital read out indicating top roll position - HSR 50/160
- Variable speed of rotation
- Spiral bending device
- NC control system
- CNC control system

HSR 80/245 WITH HYDRAULIC SIDE GUIDES



HSR 100/315 CNC WITH I-U-H PULLING SYSTEM



HSR 60/175 CNC WITH SPIRAL ATTACHMENT



HSR 100/315 WITH TIE ROD



HSR 120/390 WITH CENTRAL SUPPORT



HSR 100/315 ROLLING A STREET LAMP WITH NYLON ROLLS



The Morgan Rushworth HSRD are one of the highest capacity ranges of Section Bending machines available. The largest HSRD 550/800 model can effortlessly roll 558mm x 22mm pipe and weighs a remarkable 61 tonnes. In all there are six models in the range starting with the 150mm model, all with powerful hydraulics controlling roll up and down translation, roll rotation and lateral guide roll movement. The HSRD machines are of the double prebending design with both bottom rolls controlled independently with separate digital read out indicating roll position.

MODEL HSRD 150/480	STOCK CODE M6015
MODEL HSRD 180/460	STOCK CODE M6006
MODEL HSRD 240/550	STOCK CODE M6007
MODEL HSRD 280/660	STOCK CODE M6008
MODEL HSRD 300/740	STOCK CODE M6009
MODEL HSRD 360/800	STOCK CODE M6010
MODEL HSRD 550/800	STOCK CODE M6011

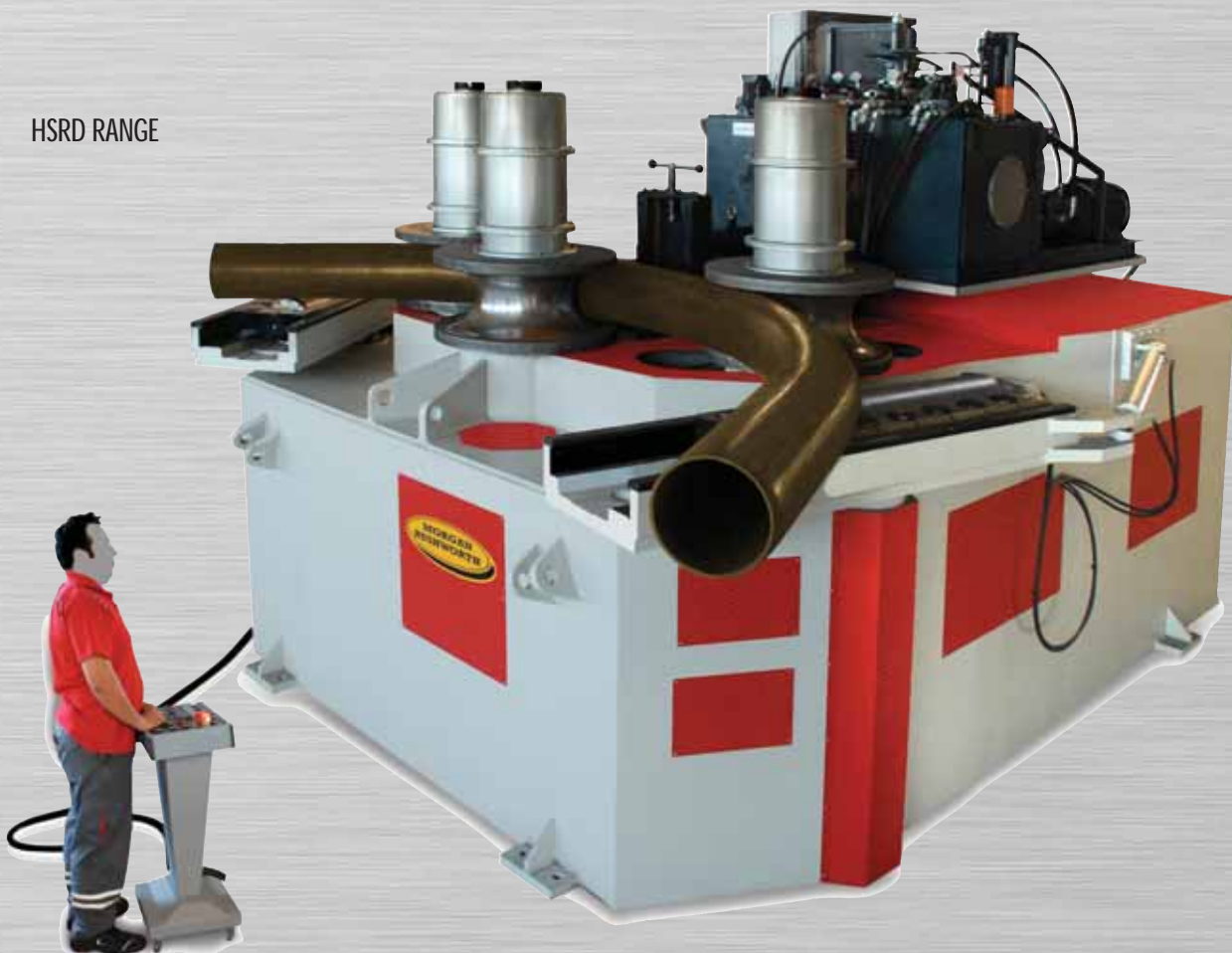
## FEATURES

- All three rolls driven for excellent traction
- Hardened rolls
- Moveable control panel
- Digital read out indicating both back rolls position
- Overload protection device
- Hydraulically powered rotation
- Hydraulically adjusted lateral guide rolls in 2 axis
- Variable speed of rotation

## OPTIONS

- Tube/profile rolls
- Variable speed of rotation
- Spiral bending device
- NC control system
- CNC control system
- Digital display for guide rolls
- I-U-H profile pulling system

HSRD RANGE



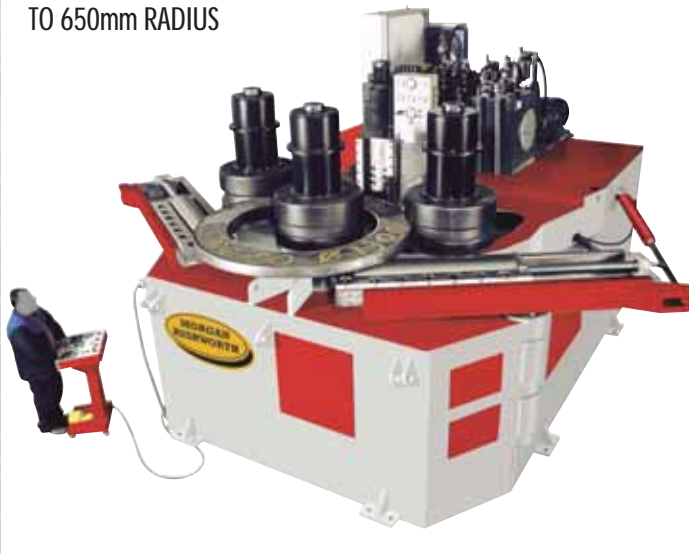
HSRD 280/660 WITH NC CONTROLLER BENDING CHANNEL SECTION TO A "TIGHT" RADIUS



SPECIAL BUILD 4 ROLL HSRD 240/550 MACHINE WITH SPIRAL ATTACHMENT AND CENTRAL SUPPORT



HSRD 360/800 BENDING 90mm x 300mm FLAT BAR ON EDGE TO 650mm RADIUS



HSRD 360/800 FITTED WITH TUBE ROLLS BENDING 305mm PIPE





















HSRD 300/740 WITH CNC CONTROLLER AND MATERIAL POSITION MONITOR



HSRD 550/800 WITH TUBE ROLL BENDING 558mm x 22mm DIAMETER TUBE







































## CAPACITIES

MODEL	PSR 35/140	PSR 50/155	HSR 50/160	HSR 60/175	HSR 80/245	HSR 100/315	HSR 120/390	HSRD 150/480
1. 	50x10 8000	60x10 8000	60x10 8000 20x10 3000	60x20 5000 40x10 2200	100x20 21000 40x10 3000	100x25 16000 40x10 4000	140x30 30000 40x10 5000	150x40 2800
2. 	80x15 7000	120x15 7500	80x15 6000	80x20 12000 50x5 2000	120x30 6000 50x10 2600	200x35 10000 60x10 4000	200x50 10000	270x50 1500
3. 	30x30 7000	35x35 12000	32x32 7000	35x35 14000 15x15 3000	45x45 10000 30x30 3000	60x60 10000 30x30 4000	75x75 8000	95x95 2500
4. 	30 7000	35 8000	35 7000	40 8000	60 10000	70 8000	85 9000	Ø95 2500
5. 	60x2 12000	70x2 12000	60x2 10000 15x1 3500	70x2 16000 25x1.5 2000	100x3 30000 40x2 4000	140x3 30000 50x2 6000	160x4 30000 50x2 6000	150x4 6000
6. 	42.4x3.2 9000	48.3x3.2 9000	60.3x2.9 10000	60.3x3.2 10000	88.9x4 16000	114.3x4.5 16000	139.7x5 16000	168.3x7.11 3500
7. 	50x30x2	50x40x3	60x30x3	80x30x3 60000 30x15x1.5 3000	100x40x3.2 30000 50x25x2 6000	140x40x3 40000 40x20x2 5000	140x50x5	150x50x5
8. 	40x40x3	50x50x3*	45x45x3	60x60x3 40000 20x20x2 2400	70x70x4 30000 40x40x2.7 5000	100x100x5 30000 50x50x2.5 5000	90x90x8	120x5
9. 	40x40x5	50x50x3	50x5 6000 25x3 3500	50x5 5000 30x3 2500	80x8 16000 35x3 5000	100x10 14000 50x6 7000	120x15 13000 50x5 6500	150x18 2000
10. 	40x40x5	50x50x5	45x5 6000 25x3 3500	50x6 10000 30x3 2500	80x8 20000 40x4 5000	100x10 16000 50x6 7000	120x12 11000 50x5 6500	150x15 3000
11. 	50x50x6	50x50x6	50x50x6 6000	70x70x7 10000 30x30x3 3000	80x80x8 14000 70x30x4 4000	100x100x10 12000	120x120x12 12000	150x15 2000
12. 	50x50x6	50x50x6	50x50x6 6000	70x70x6 10000 30x30x3 3000	80x80x8 14000 30x30x4 4000	100x100x10 10000	100x100x10 12000	130x15 2500
13. 	50x50x5	50x50x5	50x50x6 6000	70x70x7 10000 30x30x3 3000	80x80x8 14000 70x30x4 4000	120x120x10 12000	130x130x10 13000	150x15 2000
14. 	50x25x5 4000	60x30x5 5500	80x45x6 8000	85x45x6 8000 30x15x4 3000	140x60x7 12000 60x30x6 4000	200x75x8 12000 180x70x7 8000	240x85x10 10000	UNP 280 2000
15. 	50x25x5 5000	60x30x5 7000	80x45x6 12000	80x45x6 10000 30x15x4 3000	140x60x7 12000 60x30x6 4000	200x75x8 12000 180x70x7 8000	240x85x10 10000	UNO 280 3000
16. 					120x5 8000	180x82 10000	220x98 10000	INP 300 3500
17. 							140x60 30000	UNP 160 12000
18. 						140x66 30000	160x74 35000	HEA 140 4500 HEB 120 4000

## TECHNICAL SPECIFICATIONS

MODEL	PSR 35/140	PSR 50/155	HSR 50/160	HSR 60/175	HSR 80/245	HSR 100/315	HSR 120/390	HSRD 150/480
Section Modulus	cm <sup>3</sup>		6	10	15	45-80	70-120	100-155
Power	kw	0.75	1.5	1.5	4	5.5	11	15
Rolls Ø	mm	137	155	162	177	245	315	480
Shaft Ø	mm	35	50	50	60	80	100	150
Bending Speed	m/min	2.1	4.3	3.3	6.4	4.2	5.4	4
Length	mm	670	730	950	1260	1375	1435	2565
Width	mm	530	830	780	940	1040	1220	1450
Height	mm	1350	1350	1450	1390	1540	1680	2565
Weight	Kg	195	400	500	1080	1600	2240	9200

## CAPACITIES

MODEL	HSRD 180/460	HSRD 240/550	HSRD 280/660	HSR 300/740D	HSRD 360/800	HSRD 550/800	Tooling
1. 	150x35 1000	175x40 1300	200x50 2000	250x60 2000	400x60 3000	460x60 2500 300x90 1300	
2. 	250x40 1000	350x50 900	400x60 2000	450x70 1000	650x100 2000	650x120 1700	
3. 	90x90 1400	110x110 1500	130x130 2000	150x150 2500	240x240 2500	280x280 2500	
4. 	1000 1000	1300 1600	1500 1500	1700 1700	2600 2000	3000 2500	
5. 	160x65 10000	200x75 11000	240x85 12000	260x90 10000	UNP 400 40000	UNP 400 35000	
6. 	Ø168.3x7.1 2500	219.1x8.18 2500	273x9.27 4200	323.9x10.31 4200	508x15.1 15500	558.8x15.88 15000	
7. 	120x8	150x10	180x12	220x12	400x16	450x20	
8. 							
9. 	150x10 1000	160x20 1600	200x20 3000	200x26 2000	200x26 16000	200x26 1300	
10. 	130x15 1200	150x20 1600	180x16 3000	200x20 2000	200x26 1800	200x26 1500	
11. 	150x15 1200	160x20 1400	200x20 1800	200x26 1800	200x28 1500	200x28 1300	
12. 	130x15 1700	150x20 2000	180x18 2500	200x20 2800	200x30 2300	200x30 2000	
13. 	150x15 1300	160x20 1500	200x20 2000	200x28 1800	200x20 1800	200x20 1800	
14. 	INP 300 1200	INP 360 1500	INP 450 2000	IPE 500 2000	INP 1000 5000	INP 1000 5000	
15. 	UNP 300 1100	UNP 360 1200	UNP 450 2000	UNP 500 2000	UNP 1000 4000	UNP 1000 3500	
16. 	UNP 300 1100	UNP 360 1400	UNP 450 2000	UNP 500 2000	UNP 1000 4000	UNP 1000 3500	
17. 	IPE 160 3500	IPE 200 5000	IPE 240 10000	IPE 300 13000	INP 550 20000	INP 550 18000	
18. 	A 120 3500 B 120 2800	A 180 4500 B 160 3200	A 200 9000 B 180 3600	A 220 9600 B 200 5200	A 550 40000 B 500 30000	A 550 40000 B 500 25000	

## TECHNICAL SPECIFICATIONS

MODEL	HSRD 180/460	HSRD 240/550	HSRD 280/660	HSR 300/740D	HSRD 360/800	HSRD 550/800
Max. Section Modulus	cm <sup>3</sup> 110	320	600	700	4700	5500
Power	KW 15	30	37	64	70	99
Rolls Ø	mm 460	550	660	740	800	800
Shaft Ø	mm 180/160	240/220	280/260	300/280	360/360	360/360
Bending Speed	m/min 0 - 7	0 - 7	0 - 7	7	7	7
Length	mm 2400	3360	3800	4350	6580	6580
Width	mm 2000	2240	2850	3350	4820	4820
Height	mm 1695	2055	2220	2250	4090	4310
Weight	kg 9250	16900	18500	26400	48000	61500



The new Morgan Rushworth HSR4 is a revolution in section bending. This Unique new 4 Roll machine brings all the benefits of 4 roll plate bending to section bending.

The end product has virtually no flat end due to the double pinching process.

The Touch Screen NC Control allows for greater repeatability and accuracy with the ability to save configurations.

## FEATURES

- Unique 4 Roll Design
- Ability to double pinch material
- Steel welded Frame
- 2 Rolls Driven
- Hardened and Ground High Tensile Shafts
- NC Control with 100 Configuration Memory





## TECHNICAL SPECIFICATIONS

MODEL		HSR4-40	HSR4-60	HSR4-80	HSR4-100
Shaft Diameter	mm	40	60	80	100
Rolls Diameter	mm	160	200	260	320
Shaft Length	mm	120	150	160	200
Bending Speed	rpm	9.95	8	6.37	4.98
No of Motorised Rolls		2	2	2	2
No of Side Rolls Axes		1	1	1	1
Motor Power	kw	1.5	3	5.5	7.5
Machine Weight	kg	600	1000	2000	3000
Dimensions (LWH)	mm	900x800x800	1200x1100x800	1700x1450x1200	2000x1700x1250

## CAPACITIES

MODEL		HSR4-40		HSR4-60		HSR4-80		HSR4-100	
Profile Type	Rolls	Size	Min Dia	Size	Min Dia	Size	Min Dia	Size	Min Dia
1.	Std	60x10 40x10	500 400	60x10 20x5	500 250	100x20 80x20 30x10	2000 800 300	100x20 30x10	800 400
2.	Std	100x15 60x10	450 350	80x20 50x5	500 250	125x25 60x5	600 300	200x30 160x35 80x5	1200 800 400
3.	Std	35x35 20x20	900 300	32x32 12x12	400 250	45x45 15x15	500 380	60x60 15x15	750 400
4.	Opt	35 30	600 400	35 10	350 250	50 15	500 380	75 15	800 450
5.	Opt	70x2 30x2	1000 500	60x2 15x1.5	600 200	100x2.5 15x1	1200 380	125x2.5 15x1	1400 450
6.	Opt	2" x 2.9 1" x 2.3	1000 350	2" x 3.91 ½" x 2.77	400 200	3" x 5.48 ½" x 2.77	800 380	4" x 6.02 ½" x 2.77	1000 450
7.	Opt	70x30x2 50x40x3	1200 1200	50x25x3 20x15x2	450 250	80x25x3 25x15x2	800 350	100x40x4 25x15x2	1300 450
8.	Opt	50x3 40x3	1700 600	45x3 20x2	600 300	70x3 25x2	1300 400	80x5 25x2	1500 450
9.	Opt	50x50x5 30x30x3	800 600	60x60x6 30x30x4	650 350	80x80x8 30x30x3	800 450	100x100x12 40x40x4	1000 700
10.	Opt	50x50x6 30x30x3	1000 500	50x50x5 30x30x4	550 350	70x70x7 30x30x3	700 450	100x100x10 40x40x4	1000 550
11.	Std	60x7 50x6	700 500	60x7 20x3	550 250	80x9 25x3.5	800 280	100x11 30x4	1000 400
12.	Std	60x7 50x6	700 500	50x6 20x3	500 250	70x8 25x3.5	800 280	90x10 30x4	1000 400
13.	Opt	60x7 50x6	700 500	60x70 20x3	500 250	80x9 30x4	800 300	100x11 30x4	1000 400
14.	Std	UPN 80 UPN 60	1000 700	UPN 80 UPN 30	600 250	UPN 140 UPN 120 UPN 100	1600 1000 800	UPN 180 UPN 30	900 400
15.	Std	UPN 80 UPN 30	1200 800	UPN 65 UPN 30	600 250	UPN 140 UPN 120 UPN 100	1600 1000 800	UPN 180 UPN 30	1000 400
16.	Opt			IPN 80	600	IPN 120 IPN 80	600 400	IPN 180 IPN 80	1000 400

# COMAC LEONARDO & GALILEO Ring Rolling Machines

## Fabrication Machinery



MODEL COMAC  
LEONARDO 5H  
STOCK CODE 20047  
415V

MODEL COMAC GALILEO 50HV  
STOCK CODE 20043 415V



3 ROLLS  
POWERED

All Comac ring rolling machines are manufactured in Italy to the highest quality, with every model carrying a three year parts warranty. The Leonardo and Galileo models are of the pyramid design with hydraulic adjustment of the top bending roll. The renowned 3000 series detailed in the following pages are equipped with two hydraulically adjusted lower rolls enabling powerful prebending of sections. The rolls themselves have been designed to bend flat bar, flat bar on edge, round bar, square bar and box section with minimum tool change. With the exception of the Leonardo all Comac machines are equipped with DRO to indicate roll position, which greatly assist the operator for repeatability and accuracy.

## FEATURES

- Hydraulically adjusted top roll.
- Optional tube rolls available on request
- Universal set of standard rolls able to bend most sections
- All machines able to bend horizontally or vertically.
- Adjustable lateral guide rolls able to spiral material.

### ADDITIONAL FEATURES - LEONARDO L5H

- Hand held control.
- Pointer and scale roll position indicator.

### ADDITIONAL FEATURES - GALILEO 50HV

- Forward and reverse foot pedal.
- Digital read out for roll position.

## CAPACITIES

MODEL	Leonardo 5H	Galileo 50HV	Tooling
1.	80 x 8 8000 25 x 8 2000	80 x 10 8000 25 x 5 2400	STD
2.	120 x 20 8000 30 x 10 2400	120 x 20 8000 50 x 15 2400	STD
3.	40 x 40 12000 15 x 15 2000	40 x 40 6000 15 x 15 2000	STD
4.	45 10000 25 3000	45 8000 25 3000	STD
5.	80 x 2.5 20000 20 x 2 2000	80 x 2.5 20000 25 x 2 2400	SPE
6.	60.3 x 4.5 8000 26.9 x 2.9 3000	60.3 x 4.5 6000 26.9 x 2.9 3000	SPE
7.	60 x 30 x 4 15000 40 x 20 x 3 8000	60 x 30 x 4 8000 80 x 40 x 3 26000	STD
8.	60 x 60 x 3 30000 20 x 20 x 2 4000	60 x 60 x 3 14000 20 x 20 x 2 3000	STD
9.	60 x 60 x 6 6000 25 x 25 x 3 4000	60 x 60 x 6 8000 25 x 25 x 3 4000	STD
10.	60 x 60 x 6 10000 25 x 25 x 3 6000	60 x 60 x 6 10000 25 x 25 x 3 6000	STD
11.	60 x 60 x 7 6000 20 x 20 x 3 2000	60 x 60 x 7 6000 20 x 20 x 3 2000	STD
12.	60 x 60 x 7 7000 20 x 20 x 3 2000	60 x 60 x 7 7000 20 x 20 x 3 2000	STD
13.	70 x 70 x 8 6000 20 x 20 x 3 2000	70 x 70 x 8 6000 20 x 20 x 3 2000	STD
14.	80 x 45 6000 30 x 15 3000	80 x 45 5000 100 x 50 10000	STD
15.	80 x 45 6000 30 x 15 3000	80 x 45 6000 100 x 50 20000	STD

### BENDING FLAT BAR ON EDGE



### BENDING TUBE



### OPTIONAL SCROLLING ATTACHMENT



### OPTIONAL FLAT BAR BENDING ATTACHMENT



## TECHNICAL SPECIFICATIONS

MODEL		LEONARDO 5H	GALILEO 50HV
Shaft Diameter	mm	50	50
Roll Diameter	mm	175	180
Motor	kW	1.5	1.5
Rolling Speed	m/min	4.4	4.4
Length	mm	1150	1150
Width	mm	800	800
Height	mm	1250	1250
Weight	Kg	495	530

# COMAC 3000 SERIES Hydraulic Section Ring Rolling Machines

Fabrication Machinery



## CONTROL SYSTEMS

**PM** Manual adjustment of rolls. Positions referenced on mechanical counters. Roll rotation via foot-pedals.

**PH** Hydraulic adjustment of rolls with push-button controls. Positions referenced on mechanical counters with positive stop. Roll rotation via foot-pedals.

**HV** Hydraulic adjustment of rolls with push-button controls. Positions referenced on digital LED readouts. Roll rotation via foot-pedals.

**HV4** Hydraulic roll positioning with solenoid valves, actuated by push buttons on control desk. Lateral guide rolls with hydraulic adjustment in all 3 axes and position referenced on metric scales (digital readouts available on request).

**P2** Programmable positioner of bending rolls. Suitable for repetitive works to be made in several passes with high repositioning accuracy required. Controlled axes: position of right-hand and left-hand bending roll. Available combined with versions HV.





































**P2X** Programmable positioner of roll rotation and one bending roll. Suitable for bends included in between two straight parts, especially with solid sections. Controlled axes: roll rotation (section feeding) and position of one bending roll. Available combined with versions HV.

## FEATURES

- Three rolls driven for excellent traction.
- Smooth rolls ensure minimum material marking.
- All machines can bend horizontally or vertically.
- Lateral guide rolls with three dimensional adjustment.
- Hydraulically powered rotation - 307, 308, 310 only.
- Manually adjustable roll position - 301PM only.
- Supplied with modular rolls for rolling most profiles.

MODEL 301PM	STOCK CODE	20012 415V
MODEL 301PH	STOCK CODE	20013 415V
MODEL 301HV	STOCK CODE	20014 415V
MODEL 303PH	STOCK CODE	20019 415V
MODEL 303HV	STOCK CODE	20020 415V
MODEL 303P2	STOCK CODE	20111 415V
MODEL 303P2X	STOCK CODE	20112 415V
MODEL 305PH	STOCK CODE	20028 415V
MODEL 305HV	STOCK CODE	20029 415V
MODEL 305HV4	STOCK CODE	20030 415V
MODEL 305P2	STOCK CODE	20115 415V
MODEL 305P2X	STOCK CODE	20116 415V
MODEL 307HV	STOCK CODE	20037 415V
MODEL 307HV4	STOCK CODE	20038 415V
MODEL 307P2	STOCK CODE	20119 415V
MODEL 307P2X	STOCK CODE	20120 415V
MODEL 308HV	STOCK CODE	20041 415V
MODEL 308HV4	STOCK CODE	20042 415V
MODEL 308P2	STOCK CODE	20121 415V
MODEL 308P2X	STOCK CODE	20122 415V
MODEL 3010HV4	STOCK CODE	20048 415V
MODEL 3010P2	STOCK CODE	20125 415V
MODEL 3010P2X	STOCK CODE	20126 415V

## CAPACITIES

MODEL	301	303	305	307	308	310	Tooling
1. 	40 x 6 3000 20 x 5 1500	60 x 10 4500 25 x 5 2000	80 x 18 8000 25 x 5 2800	100 x 25 10000 40 x 8 3300	130 x 25 13000 50 x 10 4000	150 x 40 13000 50 x 10 5000	 STD
2. 	50 x 12 2000	80 x 20 4000	120 x 25 6000	180 x 40 8000	200 x 50 10000	250 x 60 10000	 STD
3. 	20 x 20 3000	32 x 32 4000	45 x 45 5000	65 x 65 8000	75 x 75 8000	100 x 100 15000	 STD
4. 	25 2500	40 4000	55 6000	75 7500	90 10000	115 15000	 STD
5. 	40 x 1.5 4000 12 x 1 1500	60.3 x 2.9 8000 20 x 1.5 2200	101.6 x 2.3 20000 25 x 2 3000	141.3 x 3.6 50000 40 x 2 3500	168.3 x 4 60000 50 x 2 5000	219.1 x 5 80000 60 x 2 6000	 SPE
6. 	33.7 x 2.3 4000	48.3 x 4 5000	76.1 x 4.5 7500	114.3 x 5.6 12000	139.7 x 6 16000	193.7 x 7 25000	 SPE
7. 	30 x 20 x 2	60 x 30 x 2.5	80 x 40 x 4	120 x 60 x 5	140 x 50 x 7	180 x 80 x 10	 STD
8. 	25 x 2	50 x 3	70 x 3.5	80 x 6	100 x 8	140 x 8	 STD
9. 	35 x 5 3500 20 x 3 2000	60 x 6 6000 30 x 4 3500	80 x 8 8000 40 x 4 4000	100 x 12 10000 50 x 5 5000	120 x 15 13000 60 x 6 6000	150 x 15 15000 60 x 6 8000	 STD
10. 	30 x 4 4000 20 x 3 3000	50 x 5 5000 30 x 4 3500	70 x 7 7000 40 x 4 5000	90 x 10 10000 50 x 5 6000	100 x 12 12000 60 x 6 7500	130 x 15 15000 60 x 6 9000	 STD
11. 	35 x 35 x 4 3500	60 x 60 x 7 6000	80 x 80 x 9 8000	100 x 100 x 11 10000	120 x 120 12000	150 x 150 15000	 STD
12. 	30 x 30 x 4 3500	50 x 50 x 6 6000	70 x 70 x 8 8000	90 x 90 x 10 10000	100 x 100 x 11 12000	140 x 140 15000	 STD
13. 	40 x 40 x 5 4000	70 x 70 x 8 7000	90 x 90 x 10 9000	120 x 120 12000	130 x 130 13000	160 x 160 18000	 STD
14. 	40 x 20 3000	80 x 45 5000	120 x 55 8000	180 x 70 8000	220 x 80 8000	300 x 100 10000	 STD
15. 	40 x 20 6000	70 x 40 6000	100 x 50 9000	180 x 70 10000	220 x 80 10000	300 x 100 15000	 STD
16. 		80 x 42 5000	120 x 58 8000	180 x 82 10000	220 x 98 10000	300 x 125 15000	 STD
17. 				120 x 55 22000	140 x 60 30000	180 x 70 60000	 SPE
18. 				140 x 66 25000	160 x 74 28000	200 x 90 30000	 SPE

## TECHNICAL SPECIFICATIONS

MODEL	301	303	305	307	308	310	
Section Modulus	cm <sup>3</sup>	1.5	6	18	45-80	70-120	150-250
Shaft Diameter	mm	35	50	70	100	120	150
Roll Diameter	mm	135	180	245	315	390	475
Motor	kw	1.5	3	4.9	11	15	22
Rolling Speed	m/min	5.8	5.5	6.1	0.7	0.7	0.7
Length	mm	900	1200	1440	1800	1800	2250
Width	mm	500	820	1140	1500	1750	2200
Height	mm	1200	1360	1400	1700	1950	2200
Weight	Kg	350	720	1520	3600	4450	9000

# NARGESA Scrollmaking Machines

## Fabrication Machinery



MODEL MT150R  
STOCK CODE 21133  
240V

MODEL MT150R  
STOCK CODE 21009  
415V

MODEL MT150A  
STOCK CODE 21010  
415V

The Nargesa twisting and bending machines have been designed to cold bend and twist components for the decorative and ornamental ironwork industry. A comprehensive tooling package to enable bar twisting, bar bending and rope braiding is standard with each machine. Optional attachments for tube bending and bow top fencing are available. The quick tool change system ensures minimum down time providing maximum efficiency. The programmable models ensure job repeatability for consistent bending and twisting requirements.



MODEL MT500A  
STOCK CODE 21134  
415V

MT500A AUTOMATIC CONTROL PANEL




## CAPACITIES


MODEL	MT150R/MT150A	MT500A
<b>Twisted Bar</b> (Including Baskets)	mm <input type="checkbox"/> 35 x 8	50 x 10
	mm <input type="checkbox"/> 20	40



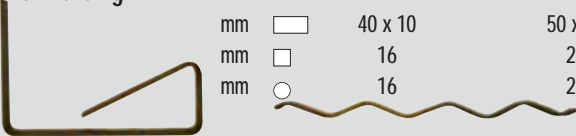
Scrolls	MT150R/MT150A	MT500A
mm <input type="checkbox"/>	40 x 10 to 120 OD	40 x 10 to 120 OD
mm <input type="checkbox"/>	40 x 10 to 220 OD	40 x 10 to 220 OD
mm <input type="checkbox"/>		50 x 10 to 450 OD
<input type="checkbox"/>	16 to 220 OD	16 to 220 OD
<input type="checkbox"/>		25 to 450 OD




Circles	MT150R/MT150A	MT500A
mm <input type="checkbox"/>	16	20
mm <input type="checkbox"/>	16	20



Bar Bending	MT150R/MT150A	MT500A
mm <input type="checkbox"/>	40 x 10	50 x 10
mm <input type="checkbox"/>	16	20
mm <input type="checkbox"/>	16	20



Rope Braiding	MT150R/MT150A	MT500A
mm <input type="checkbox"/>	4 x 10	4 x 20
mm <input type="checkbox"/>	4 x 10	4 x 20



## OPTIONAL

<b>Bow Top Fencing</b>	mm <input type="checkbox"/>	20 to 220 OD	25 to 600 OD
	mm <input type="checkbox"/>	20 to 220 OD	25 to 600 OD
<b>Tube Bending</b>	mm <input type="checkbox"/>	N/A	48.3

## TECHNICAL SPECIFICATIONS

MODEL		MT150R/MT150A	MT500A
Operation		Manual/Automatic	Automatic
Motor	kW	0.37	4.0
Length	mm	1740	2220
Width	mm	650	980
Height	mm	1055	1280
Weight	kg	235	1300

## FEATURES

- Heavy duty construction.
- Rapid cold-bending of round, square and flat bar.
- Quick change tooling.
- MT150A/MT500A - programmable control for job repeatability.
- Comprehensive standard tooling to produce:

### TWISTED BAR



### SCROLLS



### CIRCLES



### BAR BENDING



### BASKETS



# SIMASV Hydraulic Bending Machines

## Fabrication Machinery



T22 STANDARD MODEL

MODEL T22  
STOCK CODE  
21116  
415V

MODEL T40  
STOCK CODE 21119  
415V

MODEL T70  
STOCK CODE 21131  
415V

MODEL T100  
STOCK CODE 21121  
415V



T40 WITH ONE AXIS PROGRAMMER  
PICTURED WITH BENDING TOOLS



T100 WITH TWO AXIS PROGRAMMER  
PICTURED WITH BENDING TOOLS

The Simasv hydraulic horizontal bending machines are ideal for precision bending, straightening, punching and shearing. All models are equipped with powerful hydraulic cylinders located below the table providing an unencumbered working area. This is of particular benefit compared with traditional bending machines and pressbrakes as enclosed bends can be completed without colliding with the machine frame.

Available with capacities from 22 tonnes up to 100 tonnes and with a large range of tooling, these machines have proved capable of performing a whole variety of operations. The two hand wheels at the front of the machine provide micro adjustment during the bending stroke without needing to remove the material. This allows the operator to 'tweak' the bend and once the desired angle has been achieved production bending can begin. The adjustable return stroke can be set with minimum travel, sufficient to reload the material, greatly reducing cycle time.

## FEATURES

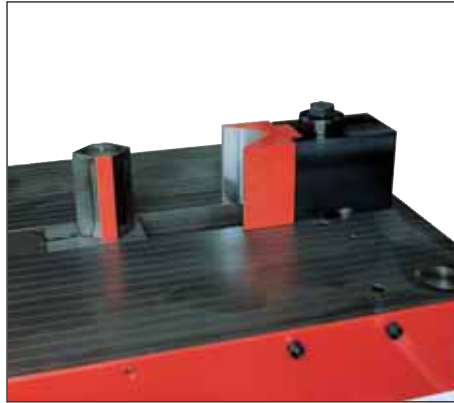
- Very adaptable machine able to render many functions.
- Very quiet operation.
- Rapid change tool pins.
- Stroke regulation by means of extremely sensitive electric limit switches and graduated rule.
- Large range of special tooling.
- Ideal for jobbing or production applications.



FLAT BAR BENDING



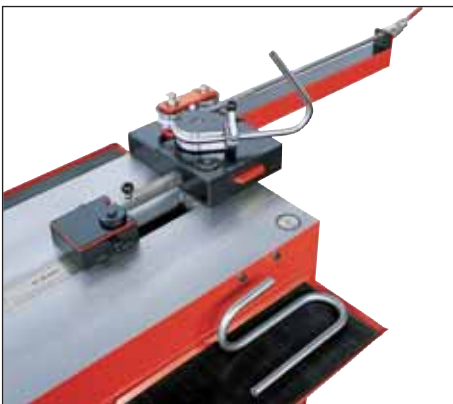
BENDING FOR ENCLOSED SHAPES



FLAT BAR BENDING ON EDGE



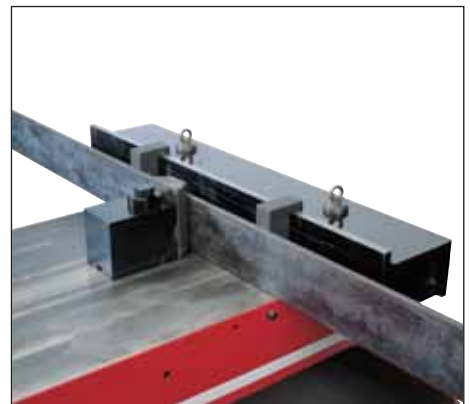
ROTARY TUBE BENDING



HEAVY WALL TUBE BENDING



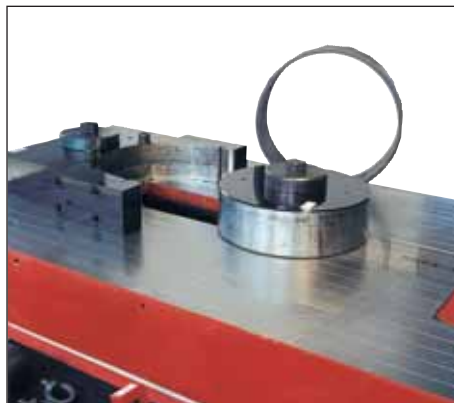
BAR STRAIGHTENING



SCROLL FORMING



CIRCLE FORMING



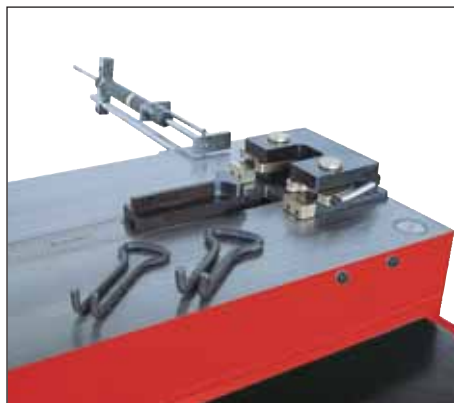
PUNCHING



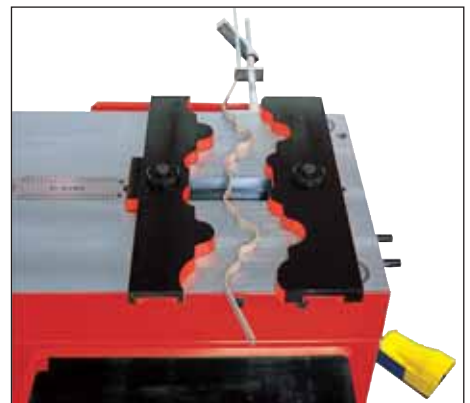
SHEARING



HOOK FORMING



PROFILE FORMING



## FLAT BAR BENDING



## BENDING SAMPLES



OPTIONAL FEED STROKE  
DECIMAL INDICATOR.  
PROVIDES MICRO STROKE  
ADJUSTMENT TO 0.1mm.

## CAPACITIES

MODEL		T22	T40	T70	T100
Rated Capacity	Tonne	22	40	70	100
Max flat bar bending	mm	120 x 15	160 x 20	200 x 28	230 x 35
Max flat bar bending on edge	mm	8 x 100	15 x 100	15 x 15	25 x 150
Max tube bending	mm	48.3	60.3	76.1	88.9
Max height straightening	mm	150	150	200	250
Punching	mm	30 x 4.5	30 x 9	35 x 12	30 x 24
Bar Shearing	mm	10 x 100	15 x 120	15 x 160	20 x 160
Section Shearing	<input type="checkbox"/> mm	80 x 80 x 2	80 x 80 x 2	120 x 120 x 5	120 x 120 x 5
	<input type="checkbox"/> mm	60 x 80 x 2	60 x 80 x 2	120 x 180 x 5	120 x 180 x 5
	<input type="checkbox"/> mm	80 x 80 x 4	80 x 80 x 4	120 x 120 x 5	120 x 120 x 5
	<input type="checkbox"/> mm	80 x 40 x 4	80 x 40 x 4	120 x 60 x 5	120 x 60 x 5

## TECHNICAL SPECIFICATIONS

MODEL		T22	T40	T70	T100
Table size	mm	630 x 1100	625 x 1100	820 x 1720	880 x 1900
Table height	mm	955	955	980	1040
Stroke	mm	200	250	330	330
Approach speed	mm/min	1750	1750	1780	1780
Return speed	mm/min	1980	1980	2218	2051
Min distance from ram to post	mm	120	120	194	242
Max distance from ram to post	mm	320	370	524	572
Motor	kW	1.5	3	5.5	5.5
Length	mm	1150	1150	1860	2000
Width	mm	630	1200	1380	1440
Height	mm	1050	1110	1160	1275
Weight	kg	630	900	1910	2500

# MEMOLI Universal Bending Machine



The Memoli EurekaMatic is designed for high production bending of round, square and flat bar with programmable memories for job repeatability. Optional attachments are mounted on the machine to produce bends, scrolls, circles, twists and bow top fencing.



MODEL EUREKAMATIC  
STOCK CODE 21100  
415V

EUREKAMATIC PICTURED WITH BAR TWISTING ATTACHMENT.

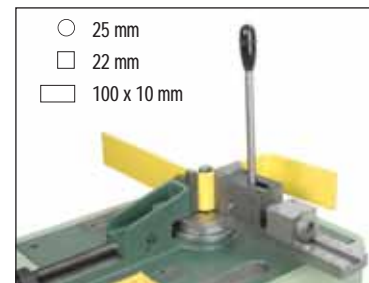


## FEATURES

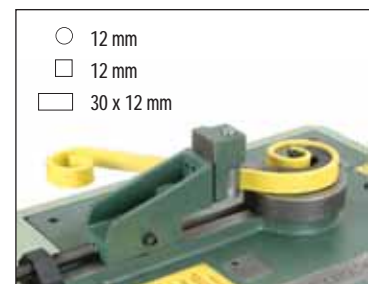
- High capacity production bending.
- Programmable bending angle with 45 memories.
- Easy mounting of optional attachments.
- Horizontal plane of bend - few limitations by machine bed.

## CAPACITIES

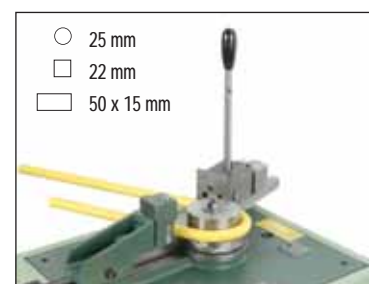
### BAR BENDING ATTACHMENT.



### SCROLL FORMING ATTACHMENT.



### CIRCLE FORMING AND BOW TOP FENCING ATTACHMENT.



### BAR TWISTING ATTACHMENT.



## TECHNICAL SPECIFICATIONS

Motor	Kw	3.0
Length	mm	850
Width	mm	620
Height	mm	980
Weight	Kg	220

## CONTROL PANEL



# CBC Tube Bending Machines

## Fabrication Machinery



MODEL UNI 42 MANUAL  
C/W STAND  
STOCK CODE 21194

MODEL UNI 42  
STOCK CODE 21195  
240V  
MODEL UNI 60  
STOCK CODE 21197  
240V

MODEL UNI 42  
PICTURED WITH  
OPTIONAL BASE

MODEL UNI 42 DIGITAL  
STOCK CODE 21196  
240V  
MODEL UNI 60 DIGITAL  
STOCK CODE 21198  
240V



MODEL UNI 30 DIGITAL  
STOCK CODE 21374  
240V



MODEL UNI 60  
DIGITAL PICTURED WITH  
OPTIONAL BASE

The CBC tube bending machines range from 'easy to use' simple machines to precision programmable production machines. A comprehensive tooling range ensures high bend quality on all models. All formers can be specified with either counterformers or guide rollers depending on material and wall thickness. Optional equipment includes moving arm with positioning stops and plane of bend indicator. The new model CBC UNI 30 model has been especially designed for fast bending of smaller tubes. The new large capacity CBC UNI 89 can effortlessly bend 88.9mm x 8mm wall mild steel tube.

## FEATURES

- Manual UNI 42 provides quality bending at competitive pricing.
- NEW UNI 30 for fast bending of tubes up to 1" gas.
- Superb bend quality.
- Complete tooling service.
- Adjustable limit switch with angle scale standard on UNI 42 and UNI 60.
- Programmer with memories including 'spring back' allowance standard on UNI42 digital, UNI 60 digital, UNI 70/C.
- NEW CBC UNI 89 with large 88.9mm x 8mm bending capacity.

## OPTIONS

- 2 wheeled cabinet available for UNI 42, UNI 42 digital, UNI 60 and UNI 60 digital.
- Moving arm with plane of bend indicator available for UNI 42, UNI 42 Digital, UNI 60 and UNI 60 Digital.
- 110V models.



MODEL UNI 70/C  
STOCK CODE 21199  
415V



MODEL UNI 89  
STOCK CODE 21364  
415V



MODEL UNI 60  
DIGITAL PICTURED WITH OPTIONAL MOVING ARM  
INCLUDING POSITIONING STOPS AND PLANE OF BEND  
INDICATOR.  
MOVING ARM IS AVAILABLE IN 1M, 2M, 3M, 4M AND  
5M LENGTHS

ALL MODELS  
PICTURED WITH  
OPTIONAL  
TOOLING.

CAST IRON FORMER

COUNTERFORMER

ROLLER HOLDER

TIE ROD

PLANE OF BEND  
INDICATOR

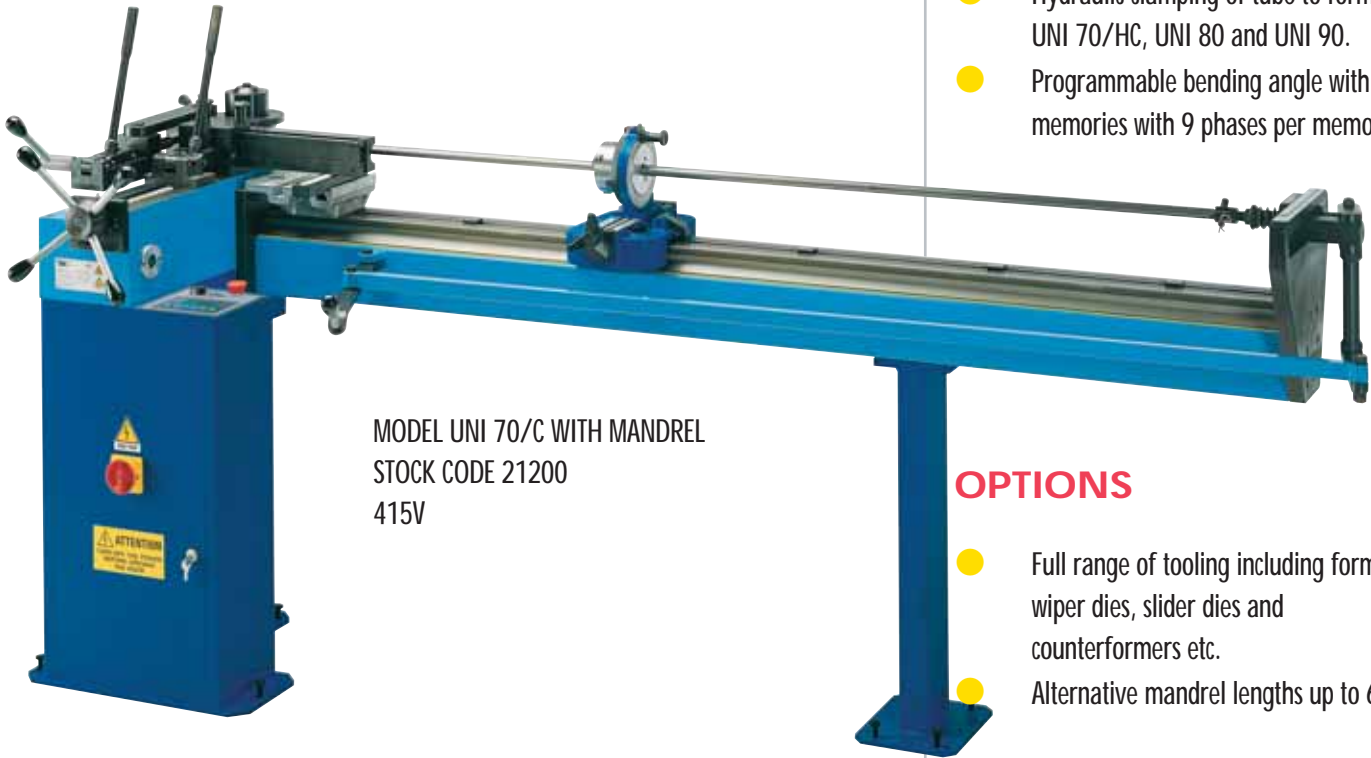
ELECTRO MAGNETIC  
SWITCH FOR ANGLE  
SETTING - STANDARD  
MODELS



## TECHNICAL SPECIFICATIONS

MODEL	UNI 30	UNI 42 MAN	UNI 42	UNI 42 DIG	UNI 60	UNI 60 DIG	UNI 70/C	UNI 89
Capacity mm (Mid Steel)	33.7 x 3.2	42.4 x 3.2	42.4 x 3.2	42.4 x 3.2	48.3 x 3.2	48.3 x 3.2	60.0 x 4	88.9 x 8
Maximum Bending Angle	180	180	180	180	180	180	180	180
Motor Kw	1.1	-	0.56	0.56	0.98	0.98	1.5/2.2	4.8
Programs	50	-	-	50	-	50	70	50
Bends/Program	9	-	-	9	-	9	6	9
Weight Kg	120	18	35	35	60	60	210	650
Length mm	740	400	600	600	580	580	810	1200
Width mm	900	200	170	170	210	210	400	650
Height mm	1000	250	350	350	410	410	1100	1200

The CBC range of mandrel tube bending machines have been designed to meet the requirement to bend thin wall tube to tight radiuses. The mandrel is positioned at the point of bend to prevent wrinkling on the inside and flattening on the outside. A slider guide moves in tandem with the tube to prevent marking, particularly to decorative material such as stainless steel. The HC model has hydraulic clamping to the tube, ensuring there is no slip as the tube is rotated around the mandrel.



MODEL UNI 70/C WITH MANDREL  
STOCK CODE 21200  
415V

## FEATURES

- Quality bending of thin wall tubes.
- Ability to bend stainless steel.
- 2 speed motor.
- 3M mandrel system.
- Plane of bend indicator with positioning stops.
- Manual mandrel extractor - UNI 70/C.
- Hydraulic mandrel extractor - UNI 70/HC, UNI 80 and UNI 90.
- Manual clamping of tube to former - UNI 70/C.
- Hydraulic clamping of tube to former - UNI 70/HC, UNI 80 and UNI 90.
- Programmable bending angle with 50 memories with 9 phases per memory.

## OPTIONS

- Full range of tooling including formers, wiper dies, slider dies and counterformers etc.
- Alternative mandrel lengths up to 6m.

TUBE FORMER



GUIDE ROLLERS



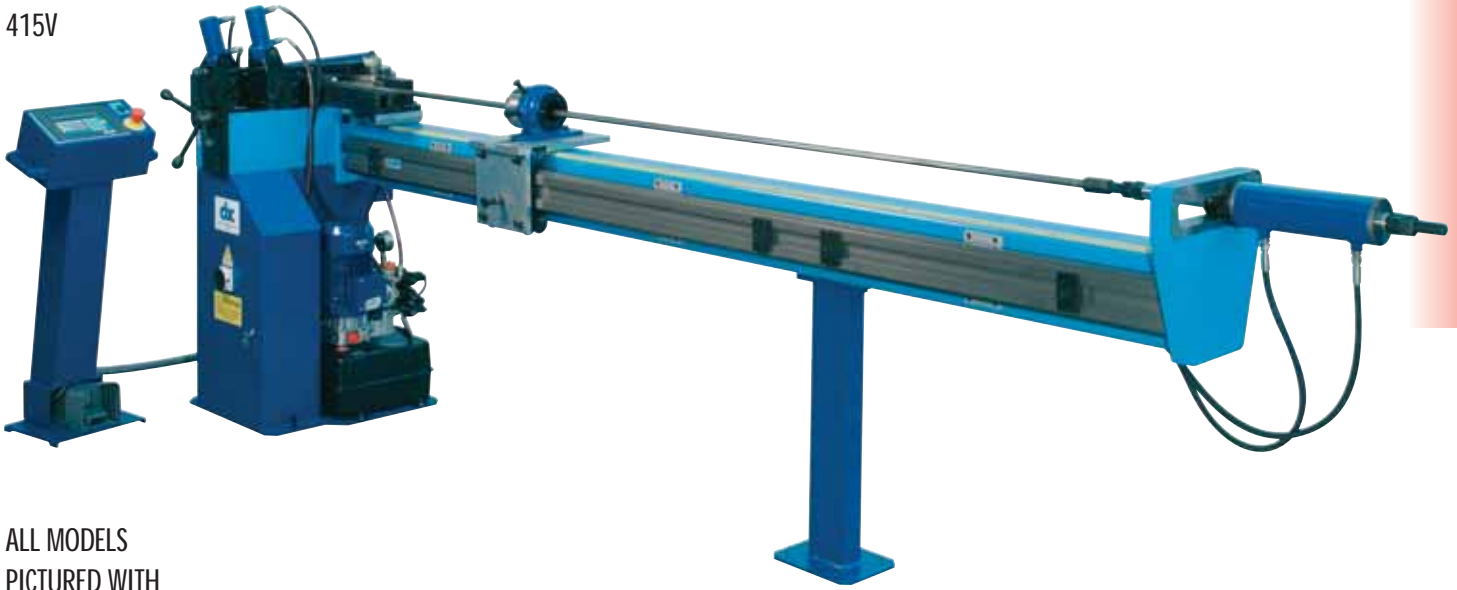
WIPER DIE



SLIDER GUIDE



MODEL UNI 70/HC MANDREL  
 STOCK CODE 21365  
 415V



ALL MODELS  
 PICTURED WITH  
 OPTIONAL  
 TOOLING.



MODEL UNI 80 MANDREL  
 STOCK CODE 21366  
 415V

MODEL UNI 90 MANDREL  
 STOCK CODE 21367  
 415V

FIXED MANDREL FOR 2.5D  
 AND LARGER

ARTICULATED MANDREL  
 FOR 2D - 2.5D



## TECHNICAL SPECIFICATIONS

MODEL		UNI 70/C	UNI 70/HC	UNI 80	UNI 90
Capacity (mild steel)*	mm	50 x 3	50 x 3	76 x 3	90 x 3
Capacity (stainless steel)*	mm	50 x 2	50 x 2	63 x 2	80 x 3
Maximum bending angle	deg	180	180	180	180
Motor	kw	1.5/2.2	1.5/2.2	3	4
Mandrel length	mm	3000	3000	3000	3000
Programs		50	50	50	50
Bends/program		9	9	9	9
Length	mm	3400	3630	3650	3700
Width	mm	810	830	840	840
Height	mm	1100	1270	1270	1270
Weight	kg	410	600	800	1170

\* subject to radius and actual material strength

# MEMOLI Rotary Tube Bending Machines

Fabrication Machinery



MODEL ETM 60  
STOCK CODE 21330  
415V



MODEL ETM 76  
STOCK CODE 21250  
415V

MODEL ETM 89  
STOCK CODE 21340  
415V

## TECHNICAL SPECIFICATIONS

MODEL	ETM 60	ETM 76	ETM 89
Capacity mm (Mid Steel)	60.3x4	76.1x4	88.9x4
Maximum Bending Angle	180	180	180
Motor Kw	2.0	4.0	
Programs	40	40	40
Bends/Program	5	5	5
Weight Kg	200	260	350
Length mm	600	850	850
Width mm	500	620	680
Height mm	780	980	980

The Memoli range of bending machines manufactured in Italy, have been designed for high quality tube bending. Formers for bending metric tubes and 'gas' pipes are readily available together with guide rollers and counterformers. Three models are available with tube bending capacities of up to 60mm, 76mm and 88.9mm, all with programmers for high efficiency production bending.

## FEATURES

- Heavy duty construction.
- Excellent bend quality.
- Quick release guide block.
- Programmer with 40 memories with up to 5 bends per programme.
- Pre bending facility.
- Complete tooling service.
- Gear reduction in oil bath.



ALL MODELS  
PICTURED WITH  
OPTIONAL TOOLING.





MODEL A14  
STOCK CODE  
21011



MODEL E20  
STOCK CODE 21016  
415V



MODEL F16  
STOCK CODE  
21012



MODEL E20S  
STOCK CODE 21024  
415V



MODEL F18  
STOCK CODE  
21013



MODEL AFG PUMP UNIT  
STOCK CODE 21030 110V  
STOCK CODE 21029 240V  
STOCK CODE 21028 415V  
FITS A14, F16 AND F18

Stein and Meyland pipe bending machines are manufactured in Scandinavia to precise standards ensuring long working life. The advanced former design provides increased shrouding around the pipe resulting in optimum bend quality. The A14 model has a reverse action cylinder capable of achieving closed bends. The AFG pump unit available in various voltages completes a full versatile range of machines.

## FEATURES

- Heavy duty.
- A14, F16 and F18 supplied with collapsible revolving base.
- Hardened and ground pistons.
- Hinged cover plates.
- All machines pressure tested for 12 hours before leaving the factory.

## OPTIONS

- Flat bar bender to suit all machines STOCK CODE 21026.
- 180° bending equipment.
- 3 1/2" and 4" bending equipment.

## TECHNICAL SPECIFICATIONS

MODEL	A14	F16	F18	E20/E20S
Capacity	in" 3/8" - 2"	3/8" - 2"	3/8" - 3"	3/8" - 3"
Pressure	kN 140	160	180	180
Motor	Kw -	-	-	1.1
Weight	Kg 86	74	128	168
Length	mm 570	790	800	850
Width	mm 600	600	880	880
Height	mm 840	830	830	620

## Standard Formers

Pipe Dia.	C/L Radius
3/8"	38
1/2"	54
3/4"	75
1"	99
1.1/4"	128
1.12"	143
2"	195
2.12"	288
3"	344
3.12"	510
4"	640

## OPTIONAL FLAT BAR BENDER



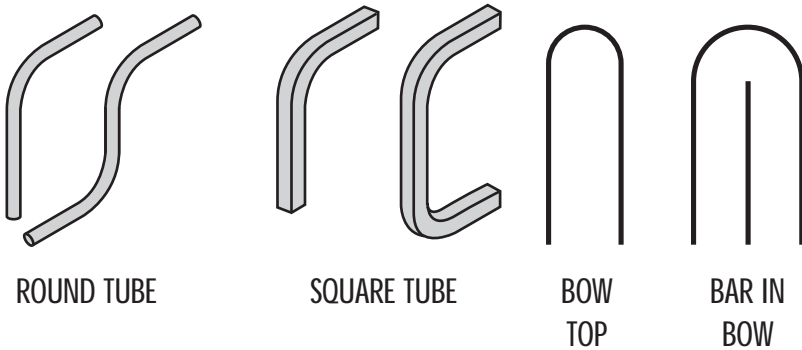


MODEL C100  
STOCK CODE  
21400  
415V

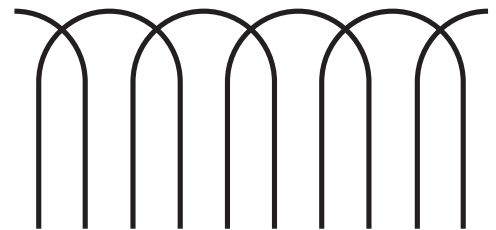
## FEATURES

- Bends round, square and flat bar and tube.
- Bends mild steel, stainless steel and aluminium.
- Ideal for bending thin wall tube to a 'tight' radius.
- Ideal for bow top fencing in thin wall tube with the aid of a mandrel bar to provide a perfect finish. No wrinkling on inside and no flattening on outside of tube.
- Ideal for bow top fencing in round bar.  
12mm bar - 3 bows per bend  
16mm bar - 2 bows per bend  
20mm bar - 1 bow per bend
- Very fast - 180° bend in 3 seconds.

### EXAMPLES OF BENDING TUBES



### EXAMPLES OF BOW TOP FENCING



## TECHNICAL SPECIFICATIONS

MODEL		C100
Max Capacity tube	mm	38
Max Capacity bar	mm	20
Max Diameter	mm	600
Max Bending Angle		180°
Mandrel Length	mm	1620
Motor	Kw	3
Length	mm	1950
Width	mm	950
Height	mm	920
Weight	Kg	220

## OPTIONS

- Tooling for bending round and square tube.
- Tooling for bow top fencing and round bar.

### FLAT BAR BENDING





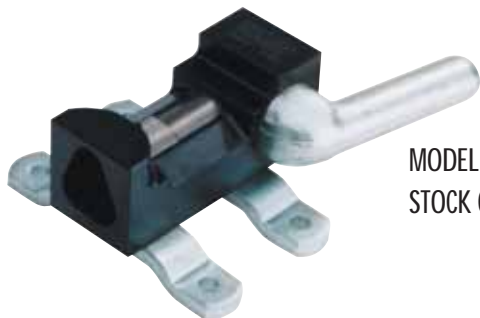
MODEL AL1  
STOCK CODE 17008



MODEL AL2  
STOCK CODE 17009



MODEL AL3  
STOCK CODE 17100



MODEL ALU  
STOCK CODE 17101

The Almi range of pipe notching machines are manufactured in Holland and provide the perfect solution to notching tubes prior to welding. The AL1, AL2 and AL3 manual notchers are an excellent cost effective solution for 90° joins. The AL1-2E motorised model is ideal for intensive use whilst the AL1-2U incorporates a venting slot notch. Large range, fast notching, perfect fit.

MODEL AL1-2E  
STOCK CODE 17102  
415V



MODEL AL1-2U  
STOCK CODE 17103  
415V



## TECHNICAL SPECIFICATIONS

MODEL		AL1	AL2	AL3	ALU	AL1-2E	AL1-2U
Capacity	mm	27.9/34.8/42.8	49.0/61.0	42.8/49.0	-	27.9/34.8/42.8/49.0/61.0	27.9/34.8/42.8/49.0/61.0
Angle Notch to 60°	-	NO	NO	NO	NO	NO	NO
Vent Notch	-	NO	NO	NO	YES	NO	YES
Motor	Kw	-	-	-	-	2.2	2.2
Length	mm	195	205	205	150	650	700
Width	mm	60	85	85	60	350	350
Height	mm	60	85	85	60	350	350
Weight	Kg	8	15	15	7	87	95

# ALMI, KEPP and RVD Pipe Notching Machines

## Fabrication Machinery

There are three new models to our comprehensive pipe notching range. The renowned Almi belt driven pipe notching machine range has been improved and expanded. With the introduction of the new High Speed X100 machine and the added Belt Grinder function on the AL100 & AL150 models, there is a machine for every application. With its powerful 4Kw motor and fast belt speed of 40m/sec, the new X100 can notch at twice the speed of other machines as well as increasing belt life. The X100 is particularly effective for fast notching of stainless steel without discolouration. The new KEPP VA250 Heavy Duty Pipe Notcher takes notching to a new level with the capability of notching 245mm diameter Pipe. The new RVD T100 pipe notcher replaces the outgoing P100 model and now also has the triple function of notching, finishing and heavy grinding with the new rubberised grinding wheel at the rear of the machine.

### FEATURES

- Cost effective notching solution.
- Accurate.
- Saves welding and finishing time.
- AL100, AL150, X100 and T100 can notch aluminium, mild steel and stainless steel.
- T100 equipped with 2 speed motor.
- Ideal for boat building, hand rails, specialised vehicle frames, food process industry etc, etc.
- Superior finished end product resulting in satisfied customers.



MODEL X100  
STOCK CODE 17109  
415V



NEW BELT GRINDER FUNCTION ON  
AL100 & AL150



ALMI AL100U-01 LEVER OPERATION



MODEL AL100U  
STOCK CODE 17104  
415V

MODEL AL150  
STOCK CODE 17105  
415V

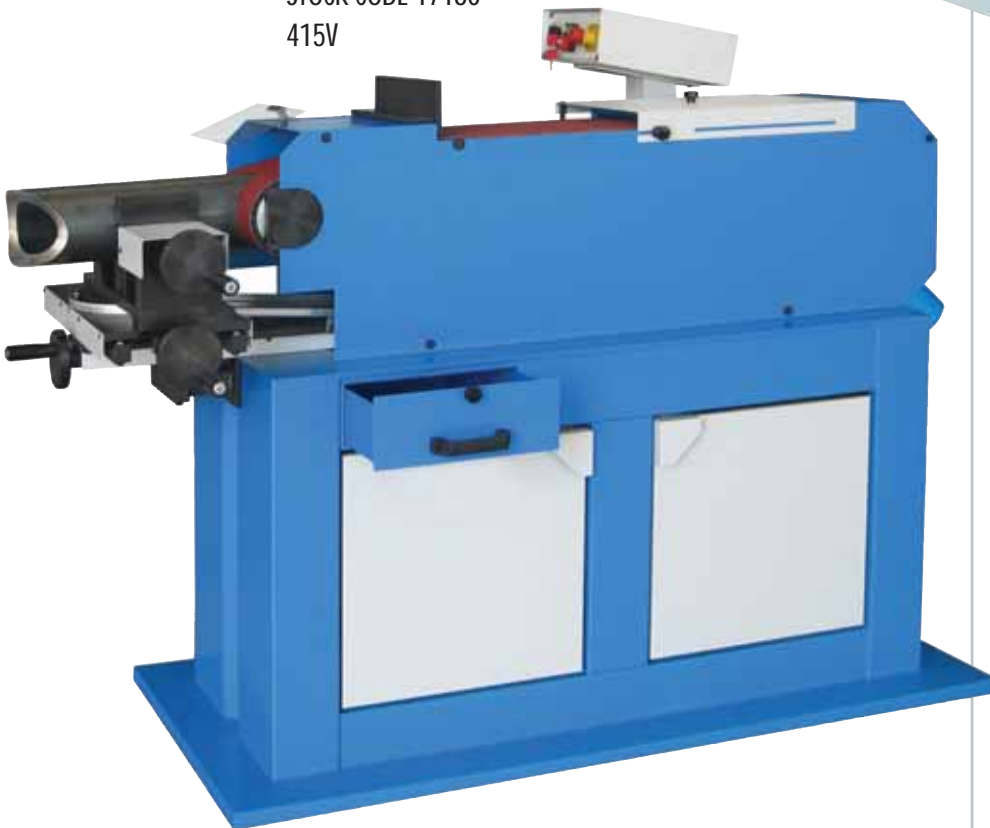


**NEW -  
245mm Diameter Pipe  
Notch Capacity  
KEPP VA250**



MODEL T100  
STOCK CODE 17170  
415V

MODEL VA250  
STOCK CODE 17180  
415V



RVD T100 TRIPLE FUNCTION

PIPE NOTCHING



LINISHING



GRINDING



## TECHNICAL SPECIFICATIONS

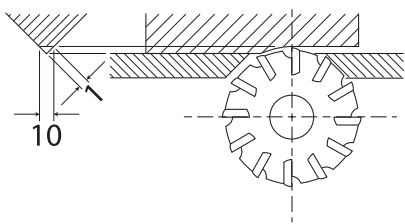
MODEL		AL100U	AL150	X100	T100	VA250
Capacity	mm	20 - 76	20 - 76	20 - 76	20 - 76	245
Angle Notch to 60°	-	YES	YES	YES	YES	YES
Belt Speed	m/sec	30	30	40	15/30	18
Belt	mm	100 x 2000	150 x 2000	100 x 2000	100 x 2000	250 x 2500
Motor	Kw	3	4	4	3	9
Length	mm	1450	1450	1350	1200	1900
Width	mm	650	850	450	650	930
Height	mm	1150	1200	1300	1070	1360
Weight	Kg	200	260	230	215	430

# OMCA Bevelling Machines

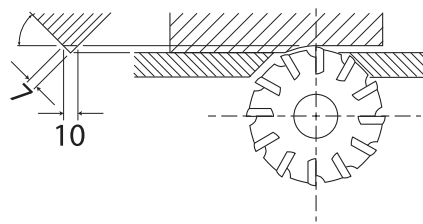
## Fabrication Machinery



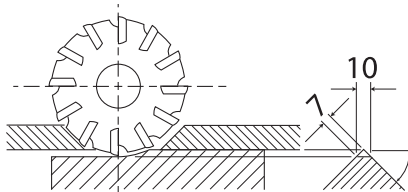
MODEL ART650/A  
STOCK CODE 17300  
415V



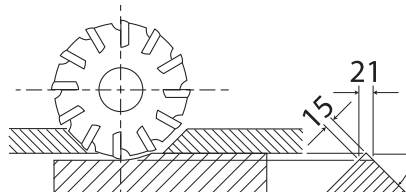
MODEL ART650/A/S  
STOCK CODE 17301  
415V



MODEL ART750/A  
STOCK CODE 17302  
415V



MODEL ART760  
STOCK CODE 17303  
415V



The Omca specialist range of bevelling machines are manufactured in Italy to the highest standards of quality. These machines have proven both popular in the demanding welding and fabrication environment as well as for students at schools and colleges carrying out weld preparation tasks. The bench and portable models are supplied with large diameter milling cutters and can easily create a chamfer up to its maximum capacity in one pass. All models have micrometric depth adjustment and, with the exception of model ART 650/A, inclinable tables from 15 - 45 degrees **NEW** for 2012 - Model ART760 now with inclinable table from 15° - 60°.

## FEATURES

- Powerful three phase motor.
- Bench models equipped with 70mm diameter milling cutters with twelve inserts.
- Portable models equipped with 60mm diameter milling cutters with nine inserts.
- Fast bevelling of steel plates in one pass.
- Micrometric bevel depth adjustment.
- Portable machines are compact and lightweight.

## TECHNICAL SPECIFICATIONS

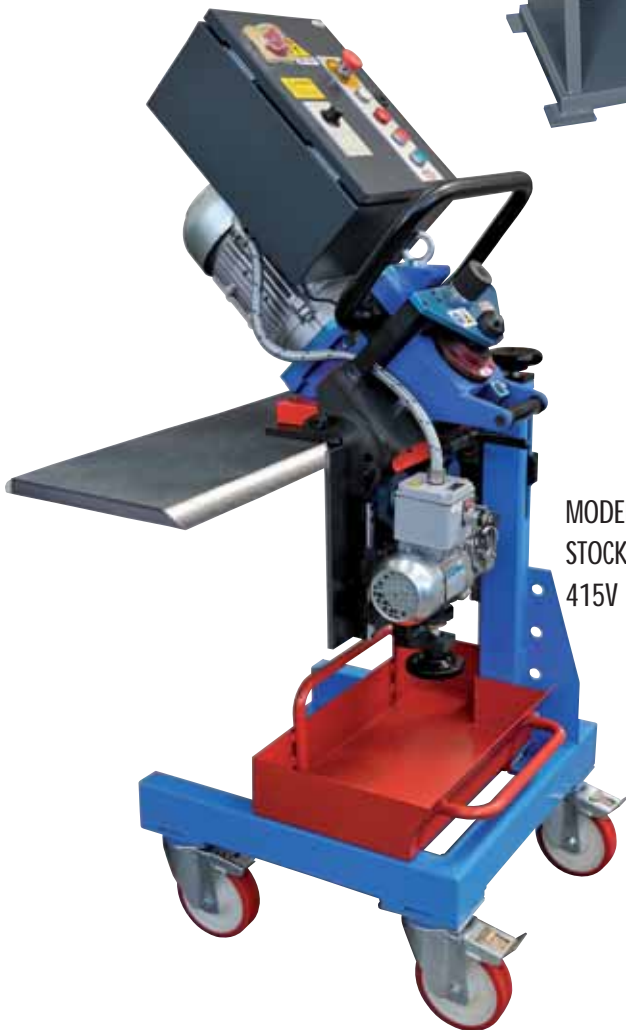
MODEL	mm	ART 650/A	ART 650 A/S	ART 750/A	ART 760
Max Bevel Width at 45°		10	10	10	21
Bevelling Angle Range	°	45	15 - 45	15 - 45	15 - 60
Table Length	mm	500	600	200	200
Motor	Kw	0.56	0.56	0.37	1.0
Length	mm	500	600	250	250
Width	mm	300	350	250	250
Height	mm	500	500	320	370
Weight	kg	52	55	11	17

## OPTIONS

- Device for external bevelling of pipes. ART 790 - STOCK CODE 17304

MODEL BE1  
STOCK CODE 15220  
415V

OPTIONAL BASE  
STOCK CODE 15221



MODEL ART900  
STOCK CODE 17306  
415V

The Bauer BE1 is ideal for the deburring of round/square tube and solid materials. A powerful motor drives a wire brush wheel and rapidly removes internal and external burrs in a single operation. The machine is produced with a two speed motor for effective finishing of ferrous and non ferrous metals.

The new Omca ART 900 has been designed for bevelling heavy plate with large cutting wheels producing a serrated finish, ideal for weld prep. The ART 900 can be used in three ways, firstly as a bench machine for small and medium size work pieces, secondly as a portable machine, or thirdly self-propelled supported with the optional trolley.

## FEATURES

- BE1 – Various gauge wire brush wheels available
- BE1 – Height adjustable material rest
- ART900 – Powerful high capacity machine
- ART900 - Self feed capability
- ART900 – Can bevel mild steel, aluminium, stainless steel, hardox and duplex material

## TECHNICAL SPECIFICATIONS

MODEL		BE1	ART900
Max Tube Capacity	mm	50	50
Material Thickness	mm	-	5 - 50
Bevelling Angle Range	°	-	15 - 60
Motor	Kw	2.2 - 3.0	4
Length	mm	600	920
Width	mm	550	820
Height	mm	570	1580
Weight	kg	50	165

## MODEL ART900 HEAD DETAIL



# KEPP Range of Belt Grinding Machines

Fabrication Machinery



MODEL 150S  
STOCK CODE 17011  
415V

MODEL 75S  
STOCK CODE 17010  
415V

MODEL 75S  
STOCK CODE 17014  
240V

TOP COVER CAN BE SWUNG AWAY FOR FLAT BED LISHING



MODEL 150/DE  
STOCK CODE 17020  
415V



MODEL 200S  
STOCK CODE 17022  
415V

**NEW**

## TECHNICAL SPECIFICATIONS

MODEL		KEPP 75S	KEPP 150S	KEPP 200S
Motor	Kw	3.0	3.6	4.5
Belt Speed	m/s	37	37	18/36
Belt Size	mm	75 x 2000	150 x 2000	200 x 2500
Length	mm	1000	1000	1420
Width	mm	460	520	700
Height	mm	1000	1000	1150
Weight	Kg	85	115	200

The metal removal rate of the Kepp belt grinding machines is phenomenal with a grinding power over fifteen times traditional stone grinders. These powerful machines can radius heavy plate and bar in one operation, avoiding the need to crop or burn the required profile prior to 'dressing'. A 50mm radius in 12mm steel plate is achieved in ten seconds. They have an endless variety of applications for Fabricators, Blacksmiths and many others in the metalworking industry.

## FEATURES

- Extremely powerful grinding performance.
- Highly rigid construction.
- Quick change belt system.
- Adjustable working height.
- Available in 3" and 6" belt widths.
- Eye protection.
- Emergency stop button.
- Dust collection box.





MODEL LFM 610  
STOCK CODE 21500

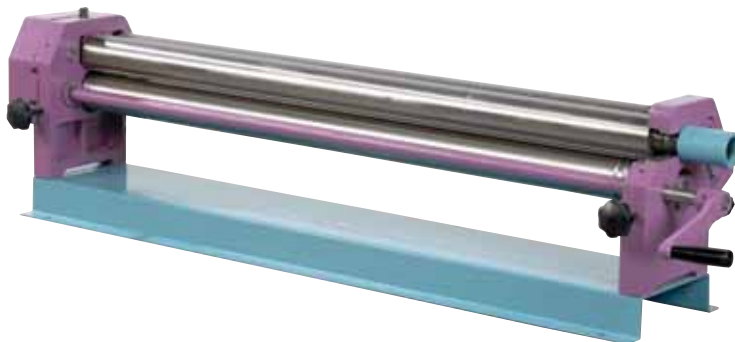
MODEL LFM 1010  
STOCK CODE 21501

MODEL LFM 1300  
STOCK CODE 21502



MODEL LRM 305  
STOCK CODE 21508

MODEL LRM 610  
STOCK CODE 21509



MODEL LRM 1000  
STOCK CODE 21510

MODEL LRM 1300  
STOCK CODE 21511

The Lenz range of LFM hand folders are the box and pan design with removable fingers for added versatility.

They are available in three working lengths with a maximum folding capacity of 1.7mm. The Lenz LRM range of manual bench rolls are designed to bend sheet up to a maximum thickness of 1.5mm. The top roll can swing away for the removal of tubular formed components.

The hardened and ground rolls ensure long working life.

## FEATURES

### LFM

- Box and pan design.
- Hardened and ground fingers
- Beam clamp to ensure material is secure prior to folding.

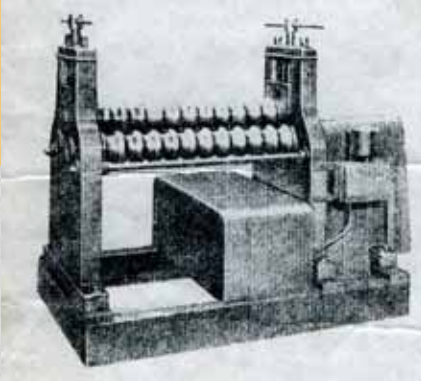
### LRM

- Bench mounted.
- Hardened rolls.
- Top slip roll.
- Easy adjustment of lower pinch roll.

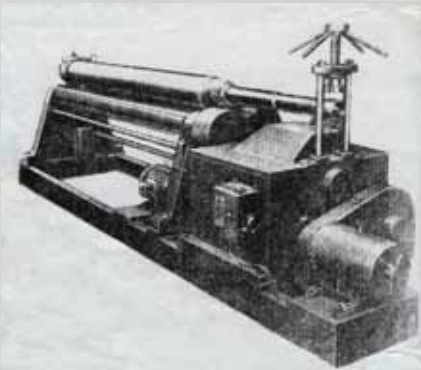
## TECHNICAL SPECIFICATIONS

MODEL		LFM 610	LFM 1000	LFM 1300	LRM 305	LRM 610	LRM 1000	LRM 1300
Capacity	mm	1.0	1.5	1.7	0.8	0.8	0.8	1.5
Bending Length	mm	610	1010	1300	305	610	1000	1300
Max Angle	°	135	150	150	-	-	-	-
Roll Dia	mm	-	-	-	25.4	38	50	75
Length	mm	800	1210	1490	390	830	1320	1580
Width	mm	250	400	400	190	220	250	350
Height	mm	370	980	980	220	300	340	380
Weight	Kg	42	190	220	14	38	86	200

Rushworth bending rolls  
for corrugated sheet  
Circa 1940's



Rushworth Mechanical plate bending  
rolls  
Circa 1950's



Morgan Mechanical Shears  
Circa 1960's

## MISSION STATEMENT

To produce a full range of sheet and plate metalworking machinery that are innovative, well engineered and designed for a long working life.

## THE MORGAN RUSHWORTH HERITAGE

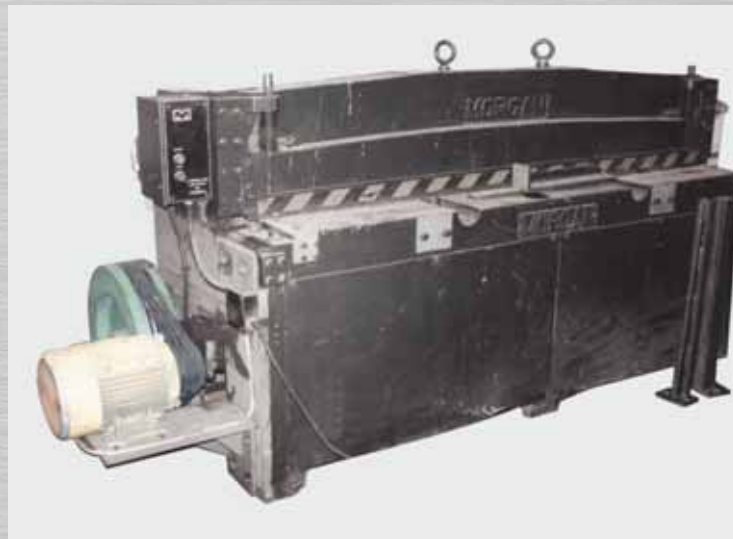
In 1872, during the Victorian era, the Rushworth factory in Sowerby Bridge, Halifax in Yorkshire England began manufacturing plate working machinery. In 1906 in a small workshop in Lye in the West Midlands, the Morgan factory started manufacturing manual sheet metal machines. During the thirties the Morgan Company commenced its long association with the MOD and due to increased demand moved to larger premises in Lye, where the overcrank mechanical guillotine shear was developed. During the forties and fifties this was replaced with the classic undercrank design, being popular both in the UK and overseas.

In 1960 further expansion took place with the purchase of the Providence St. Works, Lye, which was to become their home for nearly half a century. Production now included a full range of manual and powered box and pan folders, bending rolls, guillotine shears and pressbrakes.

Meanwhile the Rushworth Company had steadily grown with a program of continuous improvement, mainly concentrating on large capacity bending rolls and shears. In 1972 the two companies merged to create Morgan Rushworth specialising in both sheet and plate machinery.

By 1974 a third factory in Wrexham was built manufacturing around five hundred folders a year alone. The eighties and nineties was a period of consolidation with the centralising of all production in Lye and the introduction of a new range of hydraulic machines including the HBP folders still manufactured and in use throughout the world today.

In June 2008 the company was acquired by the UK Machinery Group with a commitment to continue and develop the tradition of high quality reliable machines that have become synonymous with Morgan Rushworth.



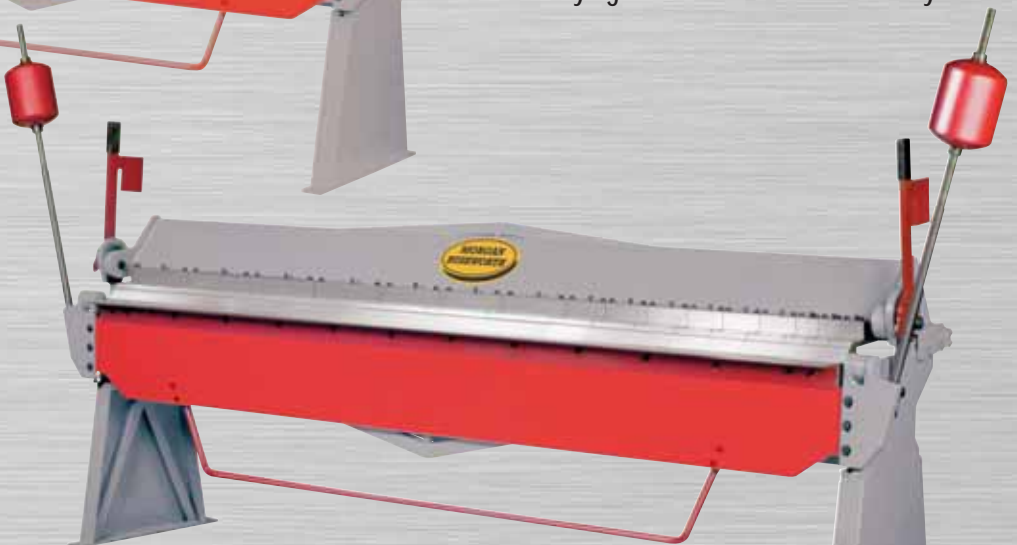


MODEL BPC 1270/2.5  
STOCK CODE M2002



MODEL BPC 2040/2.5  
STOCK CODE M2003

GAS SAFETY STRUT



The four model BPC range of heavy duty Morgan Rushworth Box and Pan folders are available in up to 2.5mm bending capacities and a maximum bending length of 3000mm. The counter balance weights greatly assist the operator, especially during repetition cycles.

Gas struts are fitted to the BPC 2540/2.5 models and up to the BPC 3050/2.0 as standard. This greatly increases operator safety and prevents the beam suddenly closing if the counter balance weights move over top dead centre. Adjustable angle stops are provided as standard to ensure ease of multiple bending. The BPC range have 45° angled fingers which are hardened and ground and supplied in varying widths for ultimate versatility.

MODEL BPC 2540/2.5  
STOCK CODE M2004

MODEL BPC 3050/2.0  
STOCK CODE M2005

**TECHNICAL SPECIFICATIONS**

MODEL	BPC 1270/2.5	BPC 2040/2.5	BPC 2540/2.5	BPC 3050/2.0
Capacity	mm 2.5	2.5	2.5	2.0
Bending Length	mm 1270	2040	2540	3050
Maximum Folding Angle	135°	135°	135°	135°
Quantity & Size of Fingers	mm 6 x 76	2 x 76, 2 x 104,	1 x 63, 1 x 76,	3 x 76, 3 x 127,
	2 x 103	3 x 127, 3 x 158,	1 x 89, 1 x 102,	3 x 153, 3 x 254,
	5 x 127	3 x 287	3 x 127, 4 x 152,	4 x 305
			4 x 305	
Length	mm 1800	2500	3000	3500
Width	mm 650	640	700	720
Height	mm 1200	1050	1100	1120
Weight	Kg 520	890	1190	1490

Box and pan folding technology page 98.



MODEL BPT 1020/2.5  
STOCK CODE M2000

MODEL BPT 1270/2.0  
STOCK CODE M2001

The Morgan Rushworth range of BPT and BPTM folders are of the box and pan design with removable fingers of varying widths for added versatility. The treadle system has been designed for hands free operation to position the material with the aid of a foot operated beam clamp. The new BPTM has the unique feature of manual operation for thin sheets or can be powered to fold heavier gauge sheets. A spring loaded strut ensures easy bending operation. The two adjusting screws at the top of the machine can be altered according to material thickness. The fingers are machined to 45° providing a maximum bending angle of 135°.

**FEATURES**

- Heavy duty with spring assisted bending.
- Bends heavy gauge material.
- Treadle clamping feature provides both hands available for positioning.
- Box and pan design.
- Hardened and ground fingers.
- Dual mode feature – manual or powered folding operation – BPTM only.



**TECHNICAL SPECIFICATIONS**

MODEL		BPT 1020/2.5	BPT 1270/2.0	BPTM 1020/2.75	BPTM 1270/2.5
Capacity	mm	2.5	2.0	2.75	2.5
Bending Length	mm	1020	1270	1020	1270
Maximum Folding Angle		135°	135°	135°	135°
Quantity & Size of Fingers	mm 1 ea	25, 30, 35, 40,	23, 30, 35, 40,	25, 30, 35, 40,	23, 30, 35, 40,
		45, 50, 75, 100	45, 50, 75, 100	45, 50, 75, 100	45, 50, 75, 100
		150, 200, 270	150, 200, 250, 270	150, 200, 270	150, 200, 250, 270
Length	mm	1400	1700	1400	1700
Width	mm	850	850	850	850
Height	mm	1150	1150	1150	1150
Weight	Kg	285	320	527	575

MODEL BPTM 1020/2.75  
STOCK CODE M2015

MODEL BPTM 1270/2.5  
STOCK CODE M2016

Box and pan folding technology page 98.



MODEL HBP 1270/3.0  
STOCK CODE M2006

MODEL HBP 2540/3.0  
STOCK CODE M2007

MODEL HBP 3050/2.0  
STOCK CODE M2008

The HBP range have 45° angled fingers which are hardened and ground and supplied in varying widths for ultimate versatility. Adjustable angle stops are provided as standard to ensure ease of multiple bending.

### TECHNICAL SPECIFICATIONS

MODEL		HBP1270/3.0	HBP2540/3.0	HBP3050/2.0
Capacity	mm	3.0	3.0	2.0
Bending Length	mm	1270	2540	3050
Clamping Beam Lift	mm	50	50	50
Tray Depth	mm	210	210	210
Min. Return Bend (1/2 Capacity)	mm	25	25	25
Maximum Folding Angle		135°	135°	135°
Back Gauge	mm	450	450	450
Quantity & Size of Fingers	mm	1 x 63	1 x 63	1 x 63
		1 x 76	1 x 76	1 x 76
		1 x 89	1 x 89	1 x 89
		2 x 102	1 x 102	1 x 102
		3 x 127	3 x 127	3 x 127
		3 x 152	4 x 152	4 x 152
			4 x 305	1 x 203
				5 x 305
Motor	kW	4	4	4
Length	mm	1780	3050	3560
Width	mm	700	770	770
Height	mm	1260	1260	1260
Weight	kg	950	1850	2210

### FEATURES

- Heavy duty hydraulic range.
- 4-way joystick control, providing 'inching' of the powered clamping & folding.
- 45° blades.
- Folding angle stop for repetition folds.
- Crowning of the folding beam reinforcing angle.
- Adjustment of the clamping and folding beams.
- Safe clamping speed.
- 450mm manual ruled back gauge.

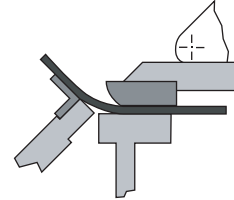
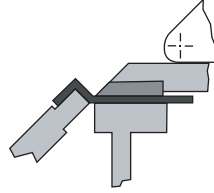
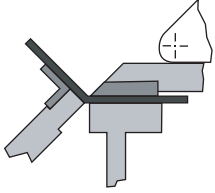


Box and pan folding technology page 98.

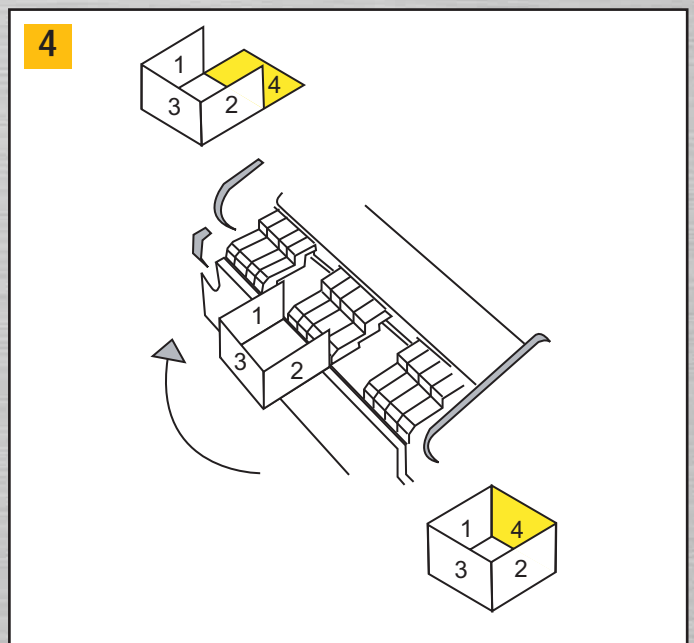
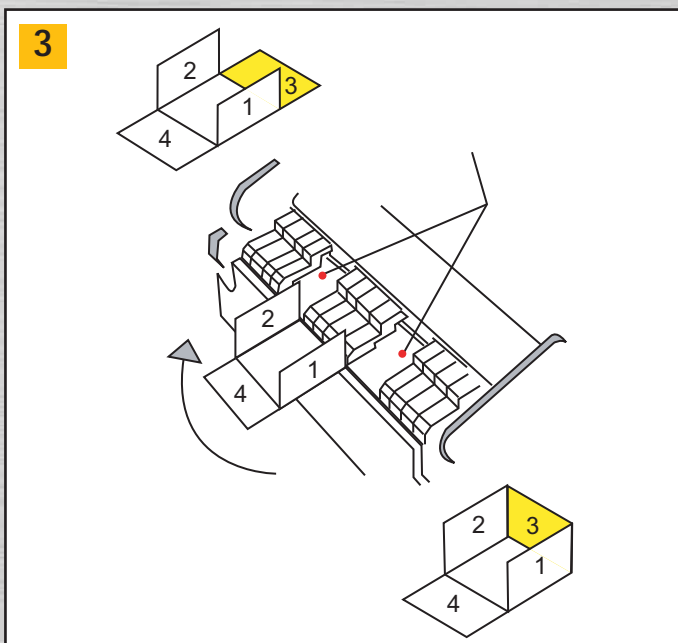
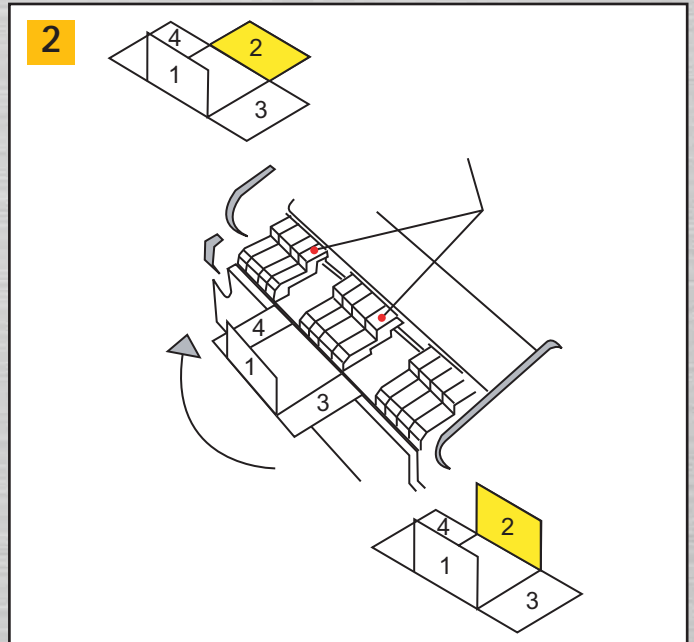
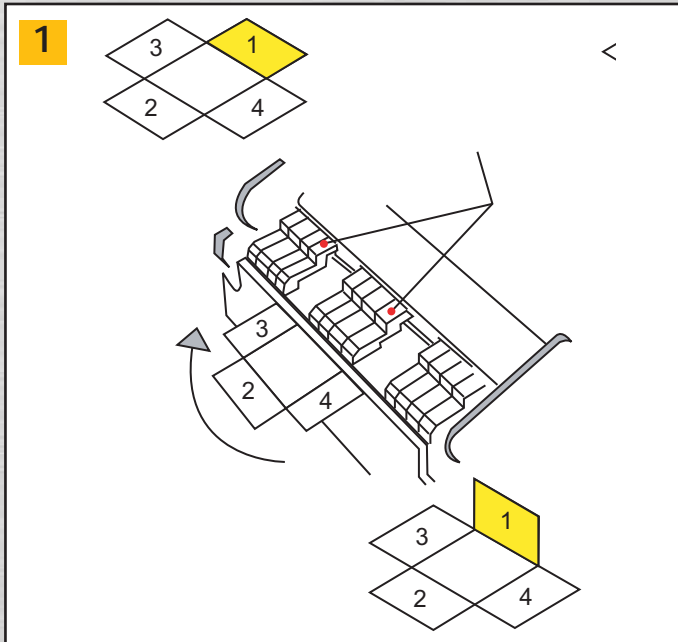
CONVENTIONAL FOLD

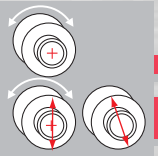
MINIMUM RETURN BEND

OPTIONAL RADIUS BENDING



**BPC, BPT, BPTM & HBP FOLDING TECHNOLOGY**

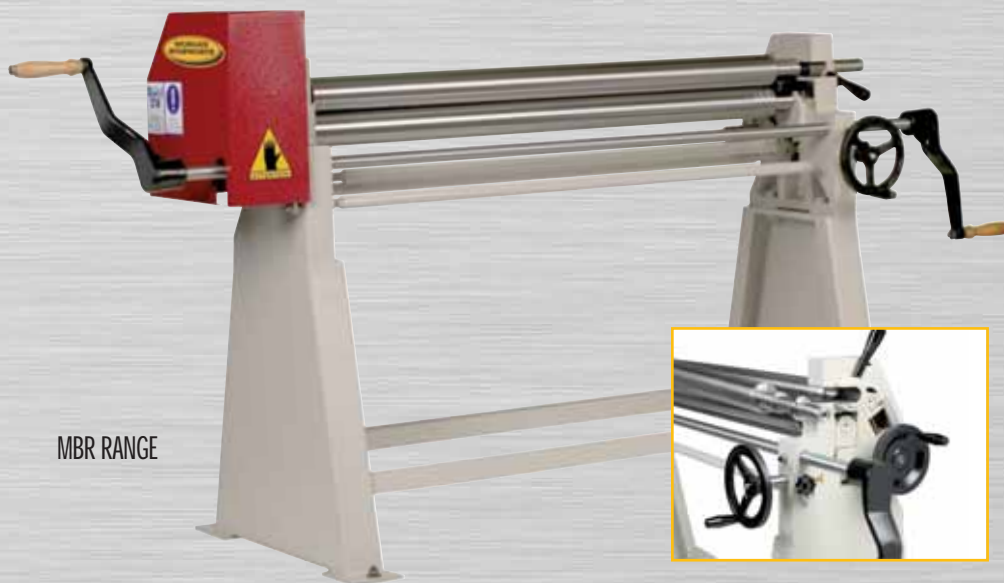
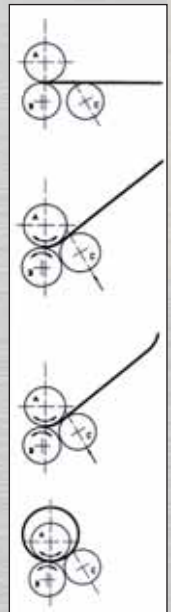




DBR RANGE

The Morgan Rushworth DBR and MBR Manual Rolls range from 0.6mm - 3.0mm capacity with various lengths up to 2050mm. All models are of the asymmetric design providing pre bending capability. The top slip roll allows removal of cylindrical components.

**ASYMMETRICAL  
BENDING**



MBR RANGE

**FEATURES**

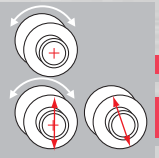
- Top roll to slip.
- Cast iron body.
- Manual pinching of bottom roll.
- Manually adjusted side roll for up and down translation.
- Cone bending.

**OPTIONS**

- Induction hardened rolls.

**TECHNICAL SPECIFICATIONS**

MODEL	STOCK CODE	BENDING LENGTH mm	PRE BENDING mm	MAX THICKNESS mm	TOP ROLL DIA. mm	LENGTH mm	HEIGHT mm	WIDTH mm	WEIGHT kg
DBR 1050/46	M3000	1050	0.6	0.8	46	1300	1100	700	240
DBR 1050/56	M3001	1050	0.8	1.0	56	1300	1100	700	270
MBR 1050/70	M3003	1050	1.5	1.8	70	1800	1100	700	320
MBR 1050/90	M3004	1050	3.0	3.3	90	2100	1130	800	490
MBR 1250/75	M3005	1250	1.5	2.0	75	2300	1100	800	460
MBR 1250/90	M3006	1250	2.5	3.0	90	2350	1130	800	510
MBR 1550/70	M3007	1550	1.0	1.2	70	2100	1100	700	520
MBR 1550/90	M3008	1550	2.2	2.5	90	2600	1130	800	590
MBR 2050/95	M3009	2050	1.5	1.8	95	3030	1130	800	600



The PBR and SBR Powered Top Roll to slip models, range from 1.0mm - 5mm with a maximum bending length up to 2050mm. The rugged heavy duty cast iron frame ensures long working life. The asymmetric roll configuration enables pre bending capability.



PBR RANGE

### FEATURES

- Powered bending capability.
- Powered top and bottom rolls with foot operated forward and reverse control.
- Brake motor.
- Cone bending.
- Manually adjusted side roll for up and down translation.
- Manual pinching of bottom roll.

### OPTIONS

- Induction hardened rolls.
- Powered side roll up and down translation.
- DRO for roll position.

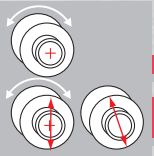


SBR RANGE MODEL PICTURED WITH OPTIONAL DRO ON FOOTPEDAL

### TECHNICAL SPECIFICATIONS

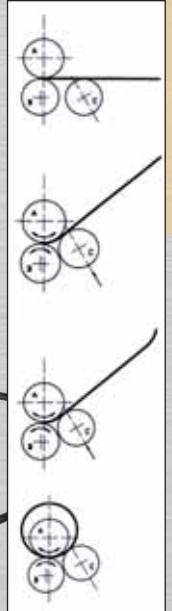
MODEL	STOCK CODE	BENDING LENGTH	PRE BENDING	MAX THICKNESS	TOP ROLL DIA.	MOTOR	LENGTH	HEIGHT	WIDTH	WEIGHT
		mm	mm	mm	mm	kW	mm	mm	mm	kg
PBR 1050/70	M3010	1050	1.5	1.8	70	1.1	1800	1100	700	350
PBR 1050/90	M3011	1050	3.0	3.3	90	1.1	2100	1130	800	520
PBR 1250/75	M3012	1250	1.5	2.0	75	1.1	2300	1100	800	490
PBR 1250/90	M3013	1250	2.5	3.0	90	1.1	2350	1130	800	540
PBR 1550/70	M3014	1550	1.0	1.2	70	1.1	2100	1100	700	550
PBR 1550/90	M3015	1550	2.2	2.5	90	1.1	2600	1130	800	620
PBR 2050/95	M3016	2050	1.5	1.8	95	1.1	3030	1130	800	650
SBR 1050/110	M3017	1050	4.0	5.0	110	2.2	1820	1150	850	1080
SBR 1050/130	M3018	1050	5.0	6.0	130	2.2	1820	1200	900	1220
SBR 1270/110	M3019	1270	3.5	4.0	110	2.2	2020	1150	850	1150
SBR 1270/120	M3020	1270	4.0	4.5	120	2.2	2020	1150	850	1250
SBR 1270/140	M3021	1270	5.0	6.0	140	2.2	2020	1200	900	1365
SBR 1550/110	M3022	1550	3.0	3.5	110	2.2	2320	1150	850	1250
SBR 1550/130	M3023	1550	4.0	4.5	130	2.2	2370	1200	900	1360
SBR 2050/110	M3024	2050	2.0	3.0	110	2.2	2820	1150	850	1350
SBR 2050/130	M3025	2050	3.0	4.0	130	2.2	2820	1200	900	1480
SBR 2050/140	M3026	2050	4.0	4.5	140	2.2	2820	1200	900	1530





ASBR RANGE  
MODEL PICTURED WITH  
OPTIONAL PROFILE  
BENDING ROLLS AND  
POWERED LOWER ROLL

ASYMMETRICAL  
BENDING



SWING AWAY TOP ROLL



CONE BENDING DEVICE



### FEATURES

- Top roll to slip.
- Heavy duty strong welded steel construction.
- Motorised side roll for up and down translation.
- Induction hardened rolls.
- Asymmetric roll configuration.
- Cone bending device.
- High powered production range.

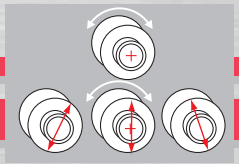
### OPTIONS

- Powered lower roll up and down movement for pinching.
- Extended rolls for profile bending.
- D.R.O. for side roll position.

The powerful ASBR models feature induction hardened rolls as standard. Motorised side roll up and down translation ensures easy pre-bending of material. ASBR machines are available up to 3100mm bending width.

### TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	BENDING LENGTH mm	PRE BENDING mm	MAX THICKNESS mm	TOP ROLL DIA. mm	MIN BEND DIA. mm	MOTOR kW	BENDING SPEED m/min	LENGTH mm	HEIGHT mm	WIDTH mm	WEIGHT kg
ASBR 1050/150	M3125	1050	7	8	150	225	3	5	2750	1040	800	1350
ASBR 1050/190	M3126	1050	9	10	190	285	4	5	2850	1070	890	1600
ASBR 1600/140	M3027	1600	5	6	140	210	2.2	6	2800	1060	750	1450
ASBR 1600/170	M3028	1600	7	8	170	255	4	4.5	3150	1130	820	1900
ASBR 2100/170	M3029	2100	5	6	170	255	4	4.5	3650	1130	820	2300
ASBR 2100/190	M3030	2100	6	7	190	285	4	5	3900	1200	920	3600
ASBR 2100/200	M3031	2100	7	8	200	300	5.5	5	3900	1250	950	3800
ASBR 2600/140	M3032	2600	3	4	140	225	2.2	6	3150	1130	820	1900
ASBR 2600/170	M3033	2600	4	5	170	255	4	4.5	4150	1130	820	2750
ASBR 2600/190	M3034	2600	5	6	190	285	4	5	4400	1200	920	4200
ASBR 2600/200	M3035	2600	6	7	200	300	5.5	5	4400	1250	950	4400
ASBR 3100/170	M3036	3100	3	4	170	255	4	4.5	4650	1130	820	3200
ASBR 3100/190	M3037	3100	4	5	190	285	4	5	4650	1200	920	4600
ASBR 3100/200	M3038	3100	5	6	200	300	5.5	5	4650	1250	950	4800



The Morgan Rushworth DPBM-4 range of rolls have been designed to bend thin sheets and medium size plate material up to a width of 3100mm. The 4 roll design allows for double pre bending with its powerful linear action hydraulic cylinders. The lower roll is hydraulically raised to 'pinch' the material which greatly assists the operator for precision bending. Hydraulic drop end ensures effortless removal of tubular components. The standard machines have three digital readouts to indicate the position of all the moving rolls, whilst the optional NC controller can be programmed for accuracy and volume production.

### FEATURES

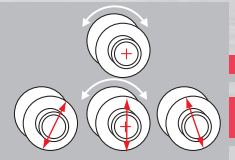
- Powered top roll rotation with electric motor and planetary gearbox.
- Powered lower roll rotation with Cardan joint system and hydraulically raised and lowered.
- Linear hydraulically powered side rolls for up and down translation.
- Hydraulic drop end and tilt ensures easy removal of material.
- DRO for all three moveable rolls.
- Induction hardened rolls.
- Cone bending device.
- Welded steel construction.
- Safety trip wire around the machine.
- Mobile control panel.

DPBM-4 RANGE MODEL  
PICTURED WITH OPTIONAL  
CENTRAL SUPPORT

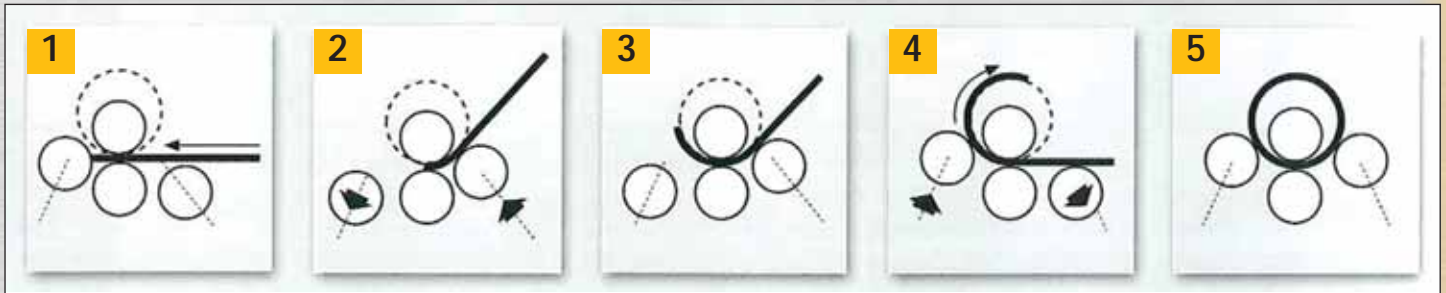


### OPTIONS

- NC controller.
- Hydraulic side supports.
- Hydraulic central support.



## DPBM-4 ROLL BENDING



STANDARD MACHINE

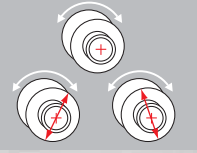
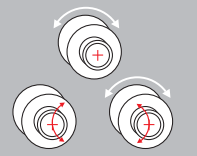
STANDARD MACHINE

NC MACHINE



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	BENDING LENGTH mm	PRE BENDING mm	MAX THICKNESS mm	TOP/BOTTOM ROLL DIA. mm	SIDE ROLLS DIA. mm	MOTOR kw	LENGTH mm	WIDTH mm	HEIGHT mm	WEIGHT kg
DPBM-4 1270/80	M3244	1270	1.5	2	80	80	1.1 + 0.75	2570	950	960	1250
DPBM-4 1270/100	M3245	1270	2	3	100	90	1.1 + 0.75	2570	950	960	1350
DPBM-4 1270/130	M3246	1270	4	5	130	130	1.5 + 0.75	3020	1150	1110	2150
DPBM-4 1270/150	M3247	1270	5	7	150	130	2.2 + 1.1	3020	1150	1110	2155
DPBM-4 1270/180	M3248	1270	7.5	10	180	150	3.0 + 1.1	3070	1350	1290	2700
DPBM-4 1270/200	M3249	1270	10	12	200	180	4.0 + 1.5	3070	1350	1290	3000
DPBM-4 1550/80	M3250	1550	1	1.5	80	80	1.1 + 0.75	2850	950	960	1350
DPBM-4 1550/100	M3251	1550	1.5	2	100	90	1.1 + 0.75	2850	950	960	1500
DPBM-4 1550/130	M3252	1550	3.5	4.5	130	130	1.5 + 0.75	3300	1150	1110	2250
DPBM-4 1550/150	M3253	1550	4.5	6.5	150	130	2.2 + 1.1	3300	1150	1110	2370
DPBM-4 1550/180	M3254	1550	7	9	180	150	3.0 + 1.1	3350	1350	1290	2900
DPBM-4 1550/200	M3255	1550	9	11	200	180	4.0 + 1.5	3350	1350	1290	3250
DPBM-4 1550/220	M3256	1550	10	12	220	180	5.5 + 1.5	3500	1500	1370	4250
DPBM-4 1550/250	M3257	1550	12	15	250	200	7.5 + 1.5	3500	1500	1370	4650
DPBM-4 2050/130	M3258	2050	3	4	130	130	1.5 + 0.75	3800	1150	1110	2450
DPBM-4 2050/150	M3259	2050	4	6	150	130	2.2 + 1.1	3800	1150	1110	2800
DPBM-4 2050/180	M3260	2050	6	8	180	150	3.0 + 1.1	3850	1350	1290	3300
DPBM-4 2050/200	M3261	2050	8	10	200	180	4.0 + 1.5	3850	1350	1290	3750
DPBM-4 2050/220	M3262	2050	9	11	220	180	5.5 + 1.5	4000	1500	1370	4800
DPBM-4 2050/250	M3263	2050	10	12	250	200	7.5 + 1.5	4000	1500	1370	5350
DPBM-4 2550/150	M3264	2550	3	4	150	130	2.2 + 1.1	4300	1150	1110	3230
DPBM-4 2550/180	M3265	2550	4	6	180	150	3.0 + 1.1	4350	1350	1290	3700
DPBM-4 2550/200	M3266	2550	6	8	200	180	4.0 + 1.5	4350	1350	1290	4250
DPBM-4 2550/220	M3267	2550	7	9	220	180	5.5 + 1.5	4500	1500	1370	5400
DPBM-4 2550/250	M3268	2550	8	10	250	200	7.5 + 1.5	4500	1500	1370	6100
DPBM-4 3100/180	M3269	3100	3	4	180	150	3.0 + 1.1	4850	1350	1290	4100
DPBM-4 3100/200	M3270	3100	4	6	200	180	4.0 + 1.5	4850	1350	1290	4750
DPBM-4 3100/220	M3271	3100	6	8	220	180	5.5 + 1.5	5000	1500	1370	6000
DPBM-4 3100/250	M3272	3100	7	9	250	200	7.5 + 1.5	5000	1500	1370	6800



Sheetmetal &  
Plateworking



DPBH-3 RANGE WITH TYPE A SHAFTS

The DPBH-3 hydraulic bending rolls are of the pyramid style with all three rolls hydraulically driven. The models with roll diameters up to 300mm are fitted with the type A shaft design with orbital action for up and down translation. The machines with roll diameters from 320mm to 550mm are equipped with the type B shaft design with linear action for up and translation. All models have hydraulic drop end and are supplied with DRO to indicate roll position.

HYDRAULIC DROP END



CONE BENDING DEVICE



DPBH-3 RANGE WITH TYPE B  
SHAFTS. MODEL PICTURED  
WITH OPTIONAL HYDRAULIC  
SIDE AND CENTRAL  
SUPPORTS

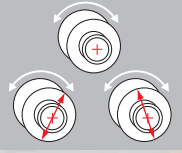
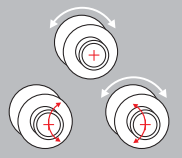


## FEATURES

- Hydraulic driven rolls.
- Hydraulic drop end and top roll tilt.
- Hydraulic up and down roll movement.
- Induction hardened rolls.
- DRO for both side rollers.
- Double pre bending to front and rear edge of plate.
- Cone bending device.
- Welded steel construction.
- Safety trip wire around the machine.
- Mobile control panel.

## OPTIONS

- Side and central supports for large sheet metal diameters.
- Extended rolls.
- Profile rolls.
- Material feed table.

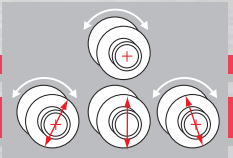


### DPBH-3 ROLL BENDING



### TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	BENDING LENGTH mm	PRE BENDING mm	MAX THICKNESS mm	TOP ROLL dia mm	BOTTOM ROLLS dia mm	MOTOR kw	LENGTH mm	WIDTH mm	HEIGHT mm	WEIGHT kg
DPBH-3 2050/210	M3500	2050	8	10	210	190	7.5	3400	1200	1300	4200
DPBH-3 2050/240	M3501	2050	10	13	240	220	7.5	3400	1300	1450	5060
DPBH-3 2050/280	M3502	2050	13	16	280	260	11	4100	1400	1550	7650
DPBH-3 2050/300	M3503	2050	16	20	300	280	11	4100	1500	1550	8110
DPBH-3 2050/320	M3504	2050	20	25	320	310	22	4600	1950	1750	10450
DPBH-3 2050/350	M3505	2050	25	30	350	330	22	4600	2000	1750	10980
DPBH-3 2050/380	M3506	2050	30	35	380	360	37	4600	2100	1850	13010
DPBH-3 2050/420	M3507	2050	35	40	420	400	37	4700	2250	2250	15990
DPBH-3 2050/460	M3508	2050	40	50	460	440	45	5050	2250	2350	21020
DPBH-3 2050/500	M3509	2050	45	55	500	480	51	5200	2500	2800	29800
DPBH-3 2050/550	M3510	2050	50	60	550	530	66	5500	2600	3000	35040
DPBH-3 2550/210	M3511	2550	6	8	210	190	7.5	3900	1200	1300	4570
DPBH-3 2550/240	M3512	2550	8	10	240	220	7.5	3900	1300	1450	5670
DPBH-3 2550/280	M3513	2550	10	13	280	260	11	4600	1400	1550	7710
DPBH-3 2550/300	M3514	2550	13	16	300	280	11	4600	1500	1550	9150
DPBH-3 2550/320	M3515	2550	16	20	320	310	22	5100	1950	1750	11450
DPBH-3 2550/350	M3516	2550	20	25	350	330	22	5100	2000	1750	12030
DPBH-3 2550/380	M3517	2550	25	30	380	360	37	5400	2100	1850	15100
DPBH-3 2550/420	M3518	2550	30	35	420	400	37	5200	2250	2250	18540
DPBH-3 2550/460	M3519	2550	35	45	460	440	45	5550	2350	2350	22900
DPBH-3 2550/500	M3520	2550	40	50	500	480	51	5800	2500	2800	33780
DPBH-3 2550/550	M3521	2550	45	55	550	530	66	6000	2600	3000	38980
DPBH-3 3100/210	M3522	3100	4	6	210	190	7.5	4400	1200	1300	5205
DPBH-3 3100/240	M3523	3100	6	8	240	220	7.5	4400	1300	1450	6980
DPBH-3 3100/280	M3524	3100	8	10	280	260	11	5100	1400	1550	8410
DPBH-3 3100/300	M3525	3100	10	13	300	280	11	5100	1500	1550	9800
DPBH-3 3100/320	M3526	3100	13	16	320	310	22	5600	1950	1750	13450
DPBH-3 3100/350	M3527	3100	16	20	350	330	22	5600	2000	1750	14260
DPBH-3 3100/380	M3528	3100	20	25	380	360	37	5600	2100	1850	17140
DPBH-3 3100/420	M3529	3100	25	30	420	400	37	5700	2250	2250	20980
DPBH-3 3100/460	M3530	3100	30	40	460	440	45	6050	2250	2350	24780
DPBH-3 3100/500	M3531	3100	35	45	500	480	51	6200	2500	2800	35260
DPBH-3 3100/550	M3532	3100	40	50	550	530	66	6500	2600	3000	42790
DPBH-3 4100/240	M3533	4100	3	4	240	220	7.5	5400	1300	1450	7620
DPBH-3 4100/280	M3534	4100	4	6	280	260	11	6100	1400	1550	10790
DPBH-3 4100/300	M3535	4100	6	8	300	280	11	6100	1500	1550	11830
DPBH-3 4100/320	M3536	4100	8	10	320	310	22	6600	1950	1750	15620
DPBH-3 4100/350	M3537	4100	10	12	350	330	22	6600	2000	1750	17860
DPBH-3 4100/380	M3538	4100	13	16	380	360	37	6900	2100	1850	20600
DPBH-3 4100/420	M3539	4100	16	20	420	400	37	6900	2250	2250	23350
DPBH-3 4100/460	M3540	4100	20	30	460	440	45	7050	2350	2350	32450
DPBH-3 4100/500	M3541	4100	25	35	500	480	51	7200	2500	2800	39860



The DPBH-4 hydraulic bending rolls are available with roll diameters ranging from 280mm up to the large 680mm machines. The 4 roll design is extremely powerful, with 3 of the rolls hydraulically driven and the fourth lower roll hydraulically adjusted up and down to pinch the material into position. This feature greatly assists the operator, especially during multiple radius bending as the work piece is always held. All models have hydraulic drop end and are supplied with DRO to all three adjusting rolls to indicate roll position.

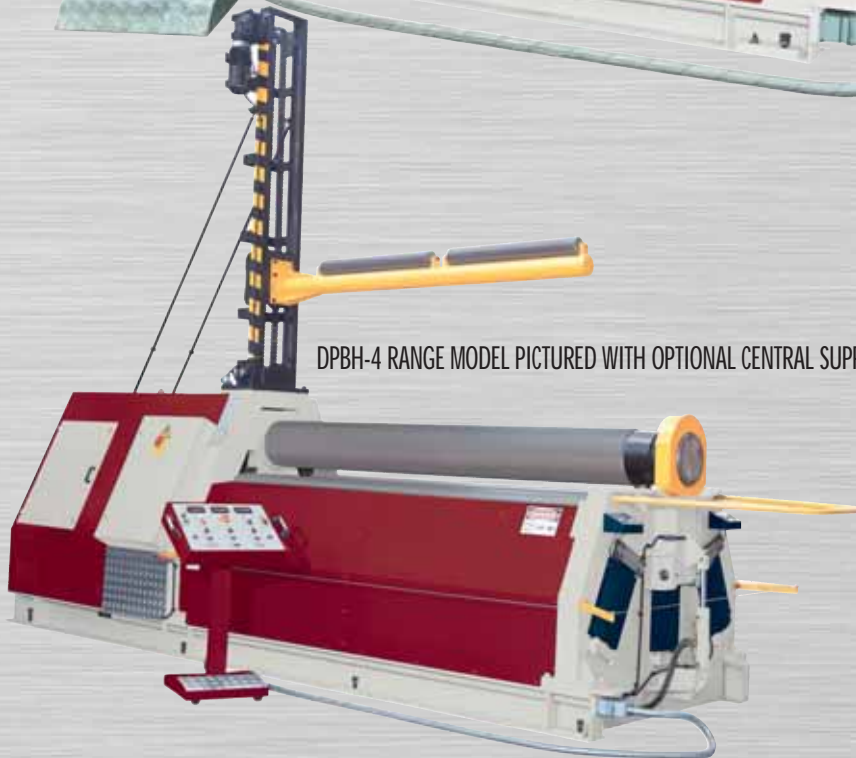
DPBH-4 RANGE



**FEATURES**

- Hydraulic driven rolls.
- Hydraulic drop end and top roll tilt.
- Hydraulic up and down roll movement.
- Hydraulic pinching.
- Induction hardened rolls.
- DRO for both side rollers.
- Double pre bending to front and rear edge of plate.
- Cone bending device.
- Welded steel construction.
- Safety trip wire around the machine.
- Mobile control panel.
- Two speed.
- Central lubrication system.

DPBH-4 RANGE MODEL PICTURED WITH OPTIONAL CENTRAL SUPPORT



**OPTIONS**

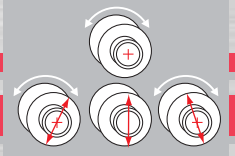
- Side and central sheet supports.
- Ground and polished rolls.
- Variable speed.
- NC controller.
- CNC controller.

4 ROLL BENDING

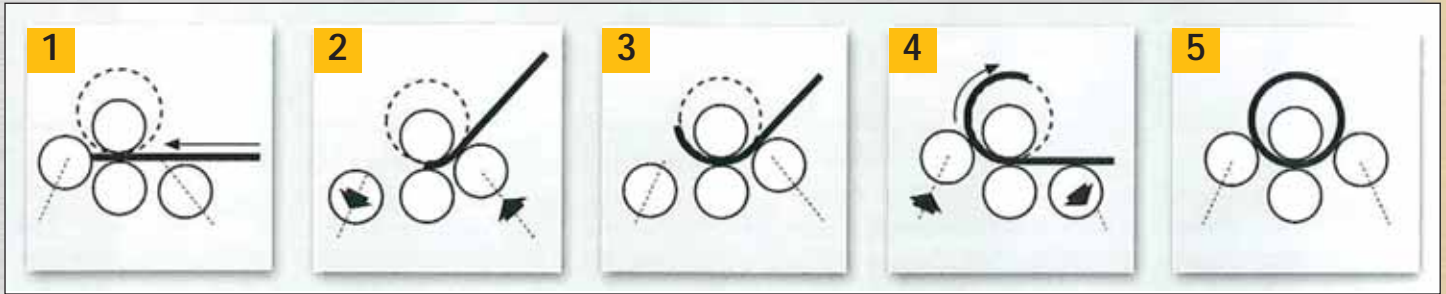
STANDARD CONTROL PANEL

OPTIONAL CNC CONTROL PANEL





### DPBH-4 ROLL BENDING



### TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	BENDING LENGTH mm	PRE BENDING mm	MAX THICKNESS mm	TOP/BOTTOM ROLL dia mm	SIDE ROLLS dia mm	MOTOR kw	LENGTH mm	WIDTH mm	HEIGHT mm	WEIGHT kg
DPBH-4 2050/280	M3543	2050	16	20	280	220	15	4750	1650	1800	8550
DPBH-4 2050/320	M3544	2050	20	25	320	240	18.5	4800	1800	1900	10240
DPBH-4 2050/350	M3545	2050	25	30	350	260	22	5000	2200	1900	1190
DPBH-4 2050/380	M3546	2050	30	40	380	300	30	5100	2300	2000	13200
DPBH-4 2050/400	M3547	2050	35	45	400	300	38.5	5200	2350	2300	14990
DPBH-4 2050/460	M3548	2050	40	50	460	380	38.5	5250	2350	2600	20050
DPBH-4 2050/500	M3549	2050	50	55	500	400	45	5400	2490	2600	31000
DPBH-4 2050/550	M3550	2050	50	60	550	450	66	5500	2860	2900	40150
DPBH-4 2550/280	M3551	2550	12	16	280	220	15	5250	1700	1800	9200
DPBH-4 2550/320	M3552	2550	16	20	320	240	18.5	5300	1800	1900	11300
DPBH-4 2550/350	M3553	2550	20	25	350	260	22	5400	2200	1900	13200
DPBH-4 2550/380	M3554	2550	25	30	380	300	30	5450	2290	2000	16720
DPBH-4 2550/400	M3555	2550	30	40	400	300	38.5	5700	2320	2300	17950
DPBH-4 2550/460	M3556	2550	35	45	460	380	38.5	6000	2400	2600	22450
DPBH-4 2550/500	M3557	2550	40	50	500	400	45	6000	2510	2600	32980
DPBH-4 2550/550	M3558	2550	45	55	550	450	66	6000	2860	2900	43560
DPBH-4 3100/280	M3559	3100	10	12	280	220	15	5800	1720	1800	10040
DPBH-4 3100/320	M3560	3100	12	16	320	240	18.5	5950	1810	1900	12980
DPBH-4 3100/350	M3561	3100	16	20	350	260	22	6100	2280	1900	15090
DPBH-4 3100/380	M3562	3100	20	25	380	300	30	6150	2320	2000	18200
DPBH-4 3100/400	M3563	3100	25	30	400	300	38.5	6250	2340	2300	20060
DPBH-4 3100/460	M3564	3100	30	40	460	380	38.5	6400	2390	2600	24660
DPBH-4 3100/500	M3565	3100	35	45	500	400	45	6550	2470	2600	36070
DPBH-4 3100/550	M3566	3100	40	50	550	450	66	6720	2680	2900	46790
DPBH-4 3100/580	M3567	3100	45	60	580	480	73	7180	2920	2980	55200
DPBH-4 3100/620	M3568	3100	60	70	620	520	123	7300	3280	3200	62100
DPBH-4 3100/680	M3569	3100	70	85	680	580	150	7750	3480	3550	82360
DPBH-4 4100/280	M3570	4100	6	8	280	220	15	6500	1740	1800	13100
DPBH-4 4100/320	M3571	4100	8	10	320	240	18.5	6700	1830	1900	16070
DPBH-4 4100/350	M3572	4100	10	12	350	260	22	6920	2290	1900	18750
DPBH-4 4100/380	M3573	4100	12	16	380	300	30	7040	2340	2000	22350
DPBH-4 4100/400	M3574	4100	16	20	400	300	38.5	7250	2390	2300	25070
DPBH-4 4100/460	M3575	4100	20	25	460	380	38.5	7340	2560	2600	31100
DPBH-4 4100/500	M3576	4100	25	35	500	400	45	7430	2600	2600	41870
DPBH-4 4100/550	M3577	4100	30	40	550	450	66	7650	2880	2900	54310



MODEL HFA 220/6  
STOCK CODE M4000

MODEL HVA 220/6  
STOCK CODE M4001  
415V



MODEL HVA 250/10  
STOCK CODE M4002  
415V

The Morgan Rushworth range of hydraulic corner notching machines consist of 220mm x 6mm fixed angle, 220mm x 6mm variable angle and 250mm x 10mm variable angle. All Morgan Rushworth corner notchers are designed and manufactured for a long working life.

## FEATURES

- Rigid head and GS500 cast iron workbench with conical grooves for optimal adherence of the squares.
- Cut can start from top of blades or from the base.
- Automatic adjustment of gap between blades from 1 to 6mm (patented).
- Set of goniometric squares.

### HVA 250/10

- Large capacity model.
- Robust "C" shaped structure that is capable of supporting considerable stress.

## TECHNICAL SPECIFICATIONS

MODEL	HFA 220/6	HVA 220/6	HVA 250/10
Cutting Angle	90°	30° - 140°	30° - 135°
Blade Length	mm 220	220	250
Cutting Capacity Mild	mm 6	6	10
Cutting Capacity S/Steel	mm 4	4	6
Motor	kw 3	3	5.5
Strokes/min	35	35	40
Work Table	mm 650 x 650	950 x 890	1020-800
Length	mm 650	950	1430
Width	mm 750	1000	1300
Height	mm 1050	1150	1600
Weight	kg 540	870	1415

## OPTIONS

- Stainless steel cutting blades.



MODEL PSTS WITH PNEUMATIC  
CONTROL

MODEL ASTS 550/1  
STOCK CODE M1069

MODEL PSTS 550/1  
STOCK CODE M1070

MODEL ASTS 1320/1.6  
STOCK CODE M1000

MODEL ASTS 1320/1.6ST  
STOCK CODE M1000ST



The Morgan Rushworth ASTS and PSTS treadle guillotines are manufactured in two capacities and are ideal for fast shearing of thin sheets. The treadle design allows for hands free operation for accurate positioning of material. The ASTS range is available in two capacities and the pneumatic PSTS in the smaller 550mm size for volume production.

### FEATURES

- Cast iron frame.
- Fabricated steel frame – ASTS 1320/1.6ST.
- Surface ground bed.
- Hardened and ground blades.
- Upper blade can be turned.
- Pneumatic operation – PSTS 550/1.

REAR VIEW -ASTS 550/1



REAR VIEW WITH GUARD REMOVED - ASTS 1320/1.6

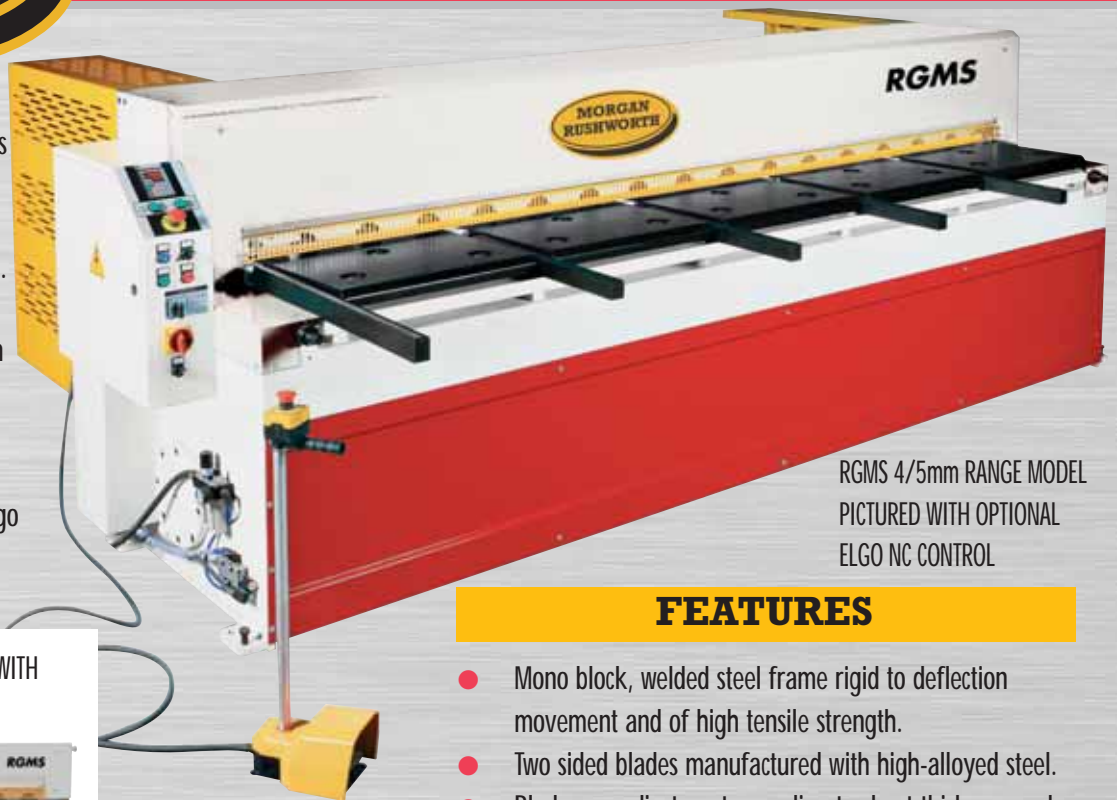
### TECHNICAL SPECIFICATIONS

MODEL		ASTS 550/1.0	PSTS 550/1.0	ASTS 1320/1.6
Cutting Capacity	mm	1	1	1.6
Shear length	mm	550	550	1320
Speed	Strokes/min	-	15	-
Back gauge	mm	600	600	820
Front gauge	mm	-	-	330
Length	mm	500	500	1320
Width	mm	730	730	1180
Height	mm	980	980	1200
Weight	kg	135	155	460



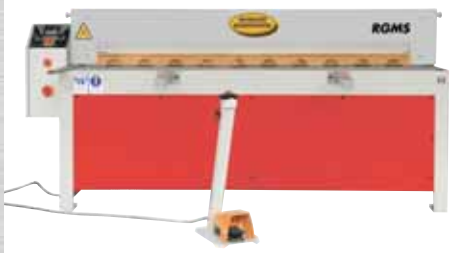
## Sheetmetal & Plateworking

The RGMS range of mechanical guillotines are designed for fast accurate cutting of mild steel up to 5mm. Now available in eleven capacities with either the standard manually operated backgauge or the optional advanced Elgo NC programmable powered backgauge.



RGMS 4/5mm RANGE MODEL  
PICTURED WITH OPTIONAL  
ELGO NC CONTROL

RGMS 3mm RANGE MODEL PICTURED WITH  
OPTIONAL ELGO NC CONTROL



## FEATURES

- Mono block, welded steel frame rigid to deflection movement and of high tensile strength.
- Two sided blades manufactured with high-alloyed steel.
- Blade gap adjustment according to sheet thickness and type for quality cutting – 4mm and 5mm models.
- Automatically activated hold down system avoiding sheet sliding during cutting action.
- Manual backgauge operated by hand wheel with distance counter
- Support table with roller bearings – 4mm and 5mm models.
- Front support arms with ruler, suitable for long sheet cutting.
- Foot pedal available for single or continuous cutting.

## OPTIONS

- Front support system with ruler up to 3 meters.
- Pneumatic sheet support and unloading system.
- 1000mm backgauge.
- Elgo NC programmable back gauge.

## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	CUTTING LENGTH	CUTTING CAPACITY	CUTTING ANGLE	STROKE PER MINUTE	MOTOR	TABLE WIDTH	TABLE HEIGHT	BACKGAUGE ADJUSTMENT	LENGTH	WIDTH	HEIGHT	WEIGHT
		mm	mm			kw	mm	mm	mm	mm	mm	mm	kg
RGMS 1350/3.0	M1039	1350	3	2°20'	35	3	420	850	750	1718	1370	1200	965
RGMS 1550/3.0	M1040	1550	3	2°20'	35	3	420	850	750	1950	1370	1200	990
RGMS 2050/3.0	M1041	2050	3	2°20'	35	3	420	850	750	2420	1370	1200	1250
RGMS 2550/2.5	M1042	2550	2.5	1°30'	35	3	420	850	750	2900	1370	1200	1370
RGMS 3050/2.0	M1043	3050	2	1°30'	35	3	420	850	750	3450	1370	1200	1600
RGMS 1550/4.0	M1044	1550	4	2°25'	41	7.5	450	850	750	1950	2300	1300	1500
RGMS 2050/4.0	M1045	2050	4	2°25'	41	7.5	450	850	750	2560	2300	1500	2600
RGMS 2550/4.0	M1046	2550	4	2°25'	41	7.5	450	850	750	3100	2300	1500	3100
RGMS 3050/4.0	M1047	3050	4	2°25'	41	7.5	450	850	750	3700	2300	1500	3550
RGMS 1050/5.0	M1048	1050	5	2°7'	34	7.5	450	850	750	1950	2300	1500	1700
RGMS 1550/5.0	M1049	1550	5	2°7'	34	7.5	450	850	750	1950	2300	1500	1900

The Morgan Rushworth Range of mechanical guillotines are designed for fast cutting of steel sheets up to 4mm. Motorised backgauge with NC controller, quick blade adjustment, front squaring arm and table with rollerways ensures easy yet accurate shearing.

## FEATURES

- Mono block, welded steel frame rigid to deflection movement and of high tensile strength.
- Two sided blades manufactured with high-alloyed steel.
- Blade gap adjustment according to sheet thickness and type for quality cutting.
- Automatically activated hold down system avoiding sheet sliding during cutting action.
- Motorised back gauge system with Elgo NC control.
- Support table with roller bearings.
- Front support arms with ruler, suitable for long sheet cutting.
- Foot pedal available for single or continuous cutting.

## OPTIONS

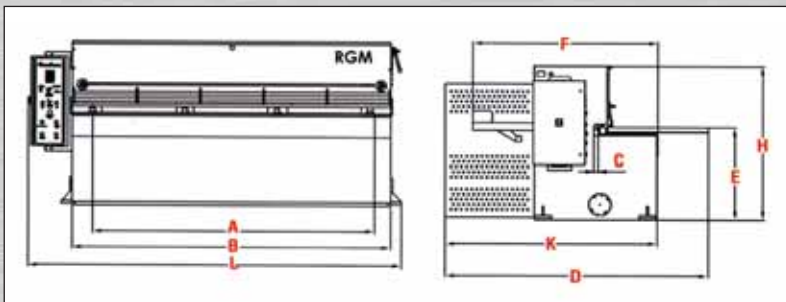
- Angle Gauge.
- Sheet support and unloading system to move the sheets from front to back.
- Pneumatic sheet support and unloading system.
- Motorised blade gap adjustment.
- Front support system with ruler up to 3 meters.
- Automatic central lubricating system.
- Stainless steel cutting blades.



MODEL RGM 2600/4



REAR VIEW WITH MOTORISED BACK GAUGE



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	CUTTING LENGTH	CUTTING CAPACITY (42 kg/mm <sup>2</sup> )	CUTTING CAPACITY (70 kg/mm <sup>2</sup> )	CUTTING ANGLE	STROKE PER MINUTE	PRESSURE	MAIN MOTOR	BACKGAUGE MOTOR	BLADE GAP ADJUSTMENT	BACKGAUGE SPEED	BACKGAUGE TRAVEL	TABLE WIDTH	No. OF SHEET SUPPORT ARMS	TABLE LENGTH	THROAT DEPTH	MACHINE WIDTH	TABLE HEIGHT	WIDTH	TRANSPORT WIDTH	LENGTH	HEIGHT	WEIGHT
		A mm					Ton	kw	kw	mm	mm/sec	mm	mm		B mm	C mm	D mm	E mm	K mm	F mm	L mm	H mm	kg
RGM 1400/3	M1001	1400	3	1.8	2.4°	34	0.8	3	0.75	0.05-0.4	110	600	430	2	1626	-	2050	830	1600	1550	2010	1250	1580
RGM 2100/3	M1002	2100	3	1.8	1.6°	34	0.8	3	0.75	0.05-0.4	110	600	430	2	2326	-	2050	830	1600	1550	2710	1250	1800
RGM 1500/4	M1037	2100	4	2.5	1.7°	42	2	7.5	0.75	0.05-0.5	110	800	580	2	1870	100	2735	900	2250	2210	2300	1550	3300
RGM 2100/4	M1038	2100	4	2.5	1.5°	42	2	7.5	0.75	0.05-0.5	110	800	580	2	2410	100	2735	900	2250	2210	2900	1550	4000
RGM 2600/4	M1003	2600	4	2.5	1.5°	42	2	7.5	0.75	0.05-0.5	110	800	580	2	2910	100	2735	900	2250	2210	3400	1550	4400
RGM 3100/4	M1004	3100	4	2.5	1.5°	42	2	7.5	0.75	0.05-0.5	110	800	580	2	3410	100	2735	900	2250	2210	3900	1550	4950



HSG RANGE

The Morgan Rushworth HSG range of guillotines are now equipped with the touch screen control which operates the NC powered backgauge. The heavy duty swing beam design ensures a long working life and quiet operation with the advanced hydraulic system. Front squaring arms with sheet supports are fitted as standard and roller ways fitted to the bed ensure ease of material handling. Quick blade gap adjustment at the side of the machine ensures good cut finish of all material thicknesses up to the capacity of the machine.

REAR VIEW WITH MOTORISED BACKGAUGE

**FEATURES**

- Touch screen NC controller.
- One-piece honed and chrome plated double acting powerful cylinders.
- High quality top and bottom blades  
Bottom: 4 Top: 2 cutting sides.
- Easily adjustable blade gap adjustment system from single point.
- Bosch - Rexroth hydraulic system.
- High pressurized silent Atos pump.
- Fast and powerful back gauge with 1000mm distance, moving by ballscrew shafts, with automatic swing away feature.
- Powerful material hold downs to prevent sheet sliding during cutting action.
- Cutting length adjustment allowing stroke adjustment for shorter sheets reducing the cutting time.
- Support table with roller bearings
- Front support arms with ruler and flip-stop.
- Foot pedal available for single or continuous cutting.
- Cutting line illumination.
- Rear guard with photo-cell.

OPTIONAL CNC CYBELEC DNC 61G CONTROLLER



OPTIONAL LASER CUTTING LINE

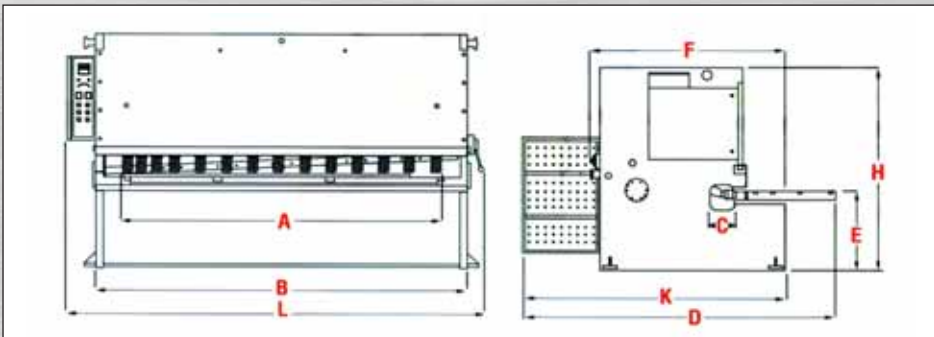


SWING AWAY GUARD WITH SAFETY INTERLOCK SWITCH FOR ALIGNMENT OF ANGLED CUTS



## OPTIONS

- CNC Cybelec DNC 61G controller. Blade gap, stroke adjustment and backgauge position are automatically adjusted from the control panel.
- Pneumatic sheet support system.
- Pneumatic sheet unloading system.
- Automatic stacking system.
- Laser cutting line to enable the operator to shear angled or drawn cutlines.
- Finger protective light curtain.
- Oil coolant.
- Longer front arms or squaring arm.
- Angle gauge.
- Stainless steel cutting blades.



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	CUTTING LENGTH	CUTTING CAPACITY (45 kg/mm <sup>2</sup> )	CUTTING CAPACITY (70 kg/mm <sup>2</sup> )	CUTTING ANGLE	STROKE	STROKE PER MINUTE	No. OF HOLD DOWNS	PRESSURE	MAIN MOTOR	BACKGAUGE MOTOR	BACKGAUGE TRAVEL	BACKGAUGE SPEED	OIL CAPACITY	BLADE GAP ADJUSTMENT	No. OF SHEET SUPPORT ARMS	TABLE LENGTH	THROAT DEPTH	MACHINE WIDTH	TABLE HEIGHT	WIDTH	TRANSPORT WIDTH	HEIGHT	LENGTH	WEIGHT
		A mm							Ton	kw	kw	mm	mm/sec		mm		B mm	C mm	D mm	E mm	K mm	F mm	H mm	L mm	kg
HSG 2600/6	M1005	2600	6	4	1.2	-	20	13	12	11	0.75	1000	110	150	0,05-0,8	2	2835	-	2700	800	2170	1880	1550	3395	5000
HSG 3100/6	M1006	3100	6	4	1.2	-	18	15	12	11	0.75	1000	110	150	0,05-0,8	2	3335	-	2700	800	2170	1880	1550	3895	5500
HSG 4100/6	M1007	4100	6	4	1.2	-	15	20	12	11	0.75	1000	110	150	0,05-0,8	2	4355	-	2750	800	2230	1930	1600	4915	7000
HSG 2600/8	M1008	2600	8	5	1.5	-	18	13	15	15	0.75	1000	110	170	0,05-1,0	2	2865	-	2840	800	2320	2020	1600	3450	6100
HSG 3100/8	M1009	3100	8	5	1.5	-	16	15	15	15	0.75	1000	110	170	0,05-1,0	2	3365	-	2840	800	2320	2020	1600	3950	7000



HSGS RANGE

The HSGS range of hydraulic swing beam is equipped with the new advanced front light guard design. This consists of multiple beams directed across the front of the blade and hold downs, which immediately switches the machine off if interrupted. The advantage of this innovative system ensures both increased operator safety and vastly improved vision to the work piece as the traditional guard is no longer necessary. The HSGS range also benefits from the standard fitment of stainless steel cutting blades. The Elgo NC controller ensures accurate cutting and complete cutting lists with quantities can be programmed for efficiency.



HSGS REAR VIEW WITH  
POWER BACK GAUGE WITH  
SWING AWAY FEATURE

## FEATURES

- ELGO 9521 NC controller.
- One-piece honed and chrome plated double acting powerful cylinders.
- Stainless steel cutting blades  
Bottom: 4 Top: 2 cutting sides.
- Easily adjustable blade gap adjustment system from single point.
- Bosch - Rexroth hydraulic system.
- High pressurized silent Atos pump.
- Fast and powerful back gauge with 750mm distance, moving by ballscrewed shafts, with automatic swing away feature.
- Powerful hydraulic material hold downs.
- Cutting length adjustment allowing stroke adjustment for shorter sheets and shorten the cutting time.
- Support table with roller bearings
- Front support arms with ruler and flip-stop.
- Foot pedal available for single or continuous cutting.
- Cutting line illumination.
- Rear guard with photo-cell.

STANDARD MANUAL BLADE GAP ADJUSTMENT



OPTIONAL POWERED BLADE GAP ADJUSTMENT

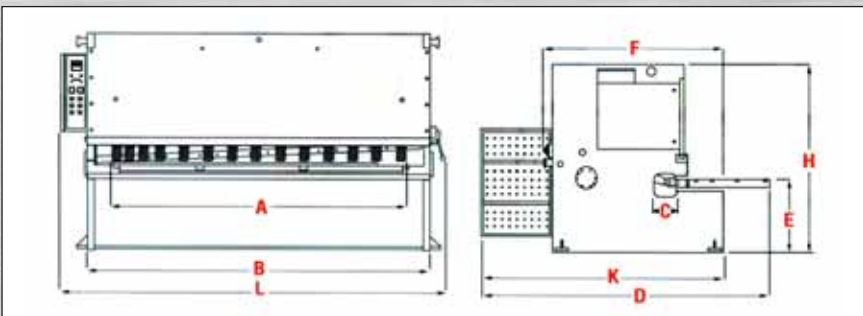


Requires Delem DAC 310 control

OPTIONAL PNEUMATIC REAR SHEET SUPPORTS



OPTIONAL DAC 310 CONTROLLER



## OPTIONS

- Delem DAC 310 controller.
- Delem DAC 310 controller with powered blade gap adjustment.
- Pneumatic sheet supports.
- Angle gauge.
- Longer squaring arm and support arms.
- 1000mm backgauge.

## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	CUTTING LENGTH	CUTTING CAPACITY (45 kg/mm <sup>2</sup> )	CUTTING CAPACITY (70 kg/mm <sup>2</sup> )	CUTTING ANGLE	STROKE PER MINUTE	No. OF HOLD DOWNS	MAIN MOTOR	BACKGAUGE MOTOR	BACKGAUGE TRAVEL	OIL CAPACITY	TABLE LENGTH	MACHINE WIDTH	TABLE HEIGHT	WIDTH	TRANSPORT WIDTH	HEIGHT	LENGTH	WEIGHT
		A mm						kw	kw	mm		B mm	D mm	E mm	K mm	F mm	H mm	L mm	kg
HSGS 2600/6 NC	M1057	2560	6	4	1.6	24	15	11	0.37	750	160	2760	2940	800	2460	1740	1570	3190	4800
HSGS 3100/6 NC	M1058	3060	6	4	1.6	20	17	11	0.37	750	160	3260	3000	800	2520	1800	1570	3690	5600
HSGS 3100/8 NC	M1059	3060	8	5	1.8	13	17	15	0.37	750	160	3305	3130	800	2650	1930	1650	3735	6550
HSGS 3700/6 NC	M1060	3660	6	4	1.2	18	20	11	0.37	750	160	3965	3130	800	2650	1930	1650	4395	7400
HSGS 4100/6 NC	M1061	4060	6	4	1.2	12	23	11	0.37	750	160	4305	3220	900	2740	2020	1750	4735	9500



BHG RANGE

**FEATURES**

The Morgan Rushworth BHG range of guillotines are now equipped with the touch screen control which operates the NC powered backgauge. The heavy duty swing beam design ensures a long working life and quiet operation with the advanced hydraulic system. The reinforced open throat design, with removable guard enables long sheets to be sheared. Front squaring arms with sheet supports are fitted as standard and roller ways fitted to the bed ensure ease of material handling.

- Touch screen NC controller.
- One-piece honed and chrome plated double acting powerful cylinders.
- High quality top and bottom blades  
Bottom: 4 Top: 2 cutting sides.
- Easily adjustable blade gap adjustment system from single point.
- Bosch - Rexroth hydraulic system.
- High pressurized silent Atos pump.
- Fast and powerful back gauge with 1000mm distance, moving by ballscrewed shafts, with automatic swing away feature.
- Powerful material hold downs to prevent sheet sliding during cutting action.
- Cutting length adjustment allowing stroke adjustment for shorter sheets and shorten the cutting time.
- Support table with roller bearings
- Front support arms with ruler and flip-stop.
- Foot pedal available for single or continuous cutting.
- Cutting line illumination.
- Rear guard with photo-cell.

REAR VIEW WITH MOTORISED BACKGAUGE





## OPTIONS

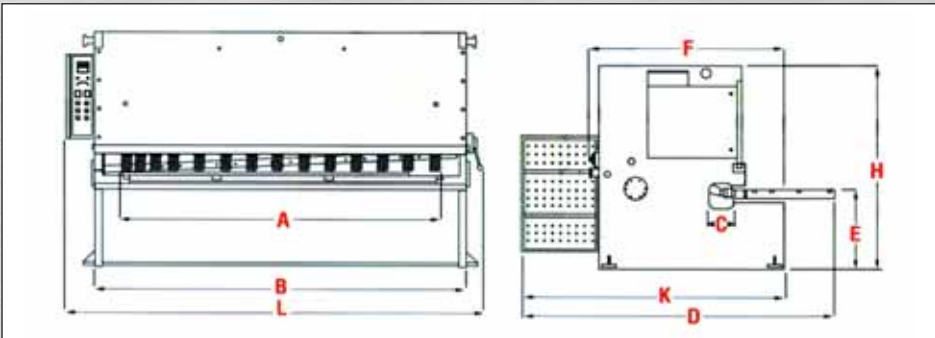
OPTIONAL CNC CYBELEC DNC 61G CONTROLLER



OPTIONAL LASER CUTTING LINE



- CNC Cybelec DNC 61G controller. Blade gap, stroke adjustment and backgauge position are automatically adjusted from the control panel.
- Pneumatic sheet support system.
- Pneumatic sheet unloading system.
- Automatic stacking system.
- Laser cutting line to enable the operator to shear angled or drawn cutlines.
- Finger protective light curtain.
- Oil coolant.
- Longer front arms or squaring arm.
- Angle guage.
- Stainless steel cutting blades.



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	CUTTING LENGTH	CUTTING CAPACITY (45 kg/mm <sup>2</sup> )	CUTTING CAPACITY (70 kg/mm <sup>2</sup> )	CUTTING ANGLE	STROKE	STROKE PER MINUTE	No. OF HOLD DOWNS	PRESSURE	MAIN MOTOR	BACKGAUGE MOTOR	BACKGAUGE TRAVEL	BACKGAUGE SPEED	OIL CAPACITY	BLADE GAP ADJUSTMENT	No. OF SHEET SUPPORT ARMS	TABLE LENGTH	THROAT DEPTH	MACHINE WIDTH	TABLE HEIGHT	WIDTH	TRANSPORT WIDTH	HEIGHT	LENGTH	WEIGHT
		A															B	C	D	E	K	F	H	L	kg
		mm							Ton	kw	kw	mm	mm/sec		mm		mm	mm	mm	mm	mm	mm	mm	mm	mm
BHG 3100/10	M1010	3100	10	6	2	175	13	14	24	22	0.75	1000	110	260	0,05-1,3	2	3480	250	3315	900	2740	2200	2050	3900	10250
BHG 3100/13	M1011	3100	13	8	2	180	11	14	31	22	0.75	1000	110	310	0,05-1,5	2	3528	250	3400	900	2860	2230	2125	4000	12000
BHG 3100/16	M1012	3100	16	10	2.5	205	10	14	42	30	1.1	1000	110	500	0,05-1,9	2	3620	260	3620	900	3075	2250	2340	4050	17600
BHG 3100/20	M1013	3100	20	13	2.5	210	8	14	54	37	1.1	1000	110	500	0,05-2,3	2	3690	350	3660	900	3100	2270	2370	4150	22000
BHG 4100/10	M1014	4100	10	6	2	190	10	18	28	22	0.75	1000	110	260	0,05-1,5	3	4480	250	3400	1000	2820	2200	2160	4860	14000
BHG 4100/13	M1015	4100	13	8	2	205	9	18	40	22	0.75	1000	110	310	0,05-1,5	3	4528	250	3450	1000	2920	2240	2220	4930	16500
BHG 4100/16	M1016	4100	16	10	2.5	240	8	18	52	30	1.1	1000	110	500	0,05-1,9	3	4620	260	3620	1000	3060	2260	2475	5050	23700
BHG 4100/20	M1017	4100	20	13	2.5	250	8	18	67	37	1.1	1000	110	500	0,05-2,3	3	4690	350	3645	1100	3120	2270	2640	5110	25000
BHG 6100/10	M1018	6100	10	6	2	255	6	26	44	22	1.1	1000	110	260	0,05-1,0	5	6540	250	3630	1050	3120	2300	2500	7000	27000
BHG 6100/13	M1019	6100	13	10	2	260	6	26	60	22	1.1	1000	110	310	0,05-1,5	5	6580	250	3630	1050	3120	2300	2645	7100	29500
BHG 6100/16	M1020	6100	16	10	2.5	315	5	26	76	30	1.1	1000	110	500	0,05-1,9	5	6670	275	3650	1050	3150	2320	2820	7175	37500
BHG 6100/20	M1021	6100	20	13	2.5	325	5	26	96	37	1.1	1000	110	500	0,05-2,3	5	6740	300	3675	1050	3150	2320	3100	7325	50000



The powerful BHGS range of hydraulic swing beam is equipped with the new advanced front light guard design. This consists of multiple beams directed across the front of the blade and hold downs, which immediately switches the machine off if interrupted. The advantage of this innovative system ensures both increased operator safety and vastly improved vision to the work piece as the traditional guard is no longer necessary. The BHGS range also benefits from the standard fitment of stainless steel cutting blades. The Elgo NC controller ensures accurate cutting and complete cutting lists with quantities can be programmed for efficiency.

BHGS REAR VIEW INDICATING POWER BACK GAUGE WITH SWING AWAY FEATURE



## FEATURES

- ELGO 9521 NC controller.
- One-piece honed and chrome plated double acting powerful cylinders.
- Stainless steel cutting blades  
Bottom: 4 Top: 2 cutting sides.
- Easily adjustable blade gap adjustment system from single point.
- Fast and powerful back gauge with 1000mm distance, moving by ballscrewed shafts, with automatic swing away feature.
- Powerful hydraulic material hold downs prevent sheet sliding during cutting action.
- Cutting length adjustment allowing stroke adjustment for shorter sheets and shorten the cutting time.
- Support table with roller bearings
- Front support arms with ruler and flip-stop.
- Foot pedal available for single or continuous cutting.
- Cutting line illumination.
- Rear guard with photo-cell.

## OPTIONS

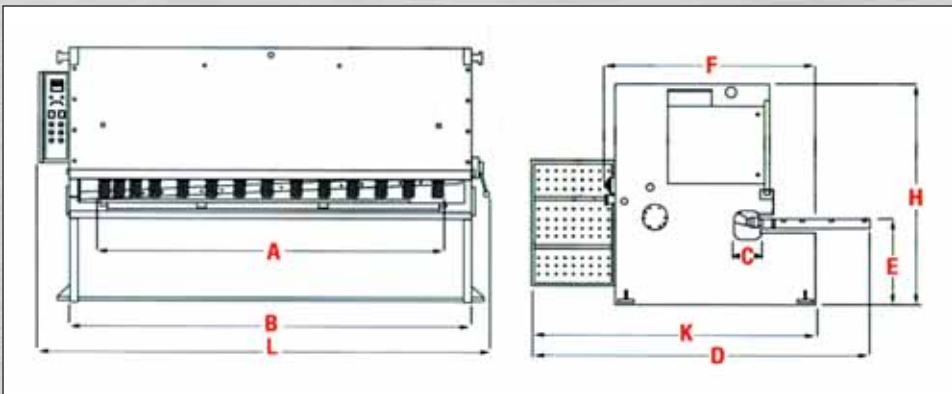
OPTIONAL DAC 310 CONTROLLER



OPTIONAL LASER CUTTING LINE



- Delem DAC 310 controller. Blade gap, stroke adjustment and backgauge position are automatically adjusted from the control panel.
- Pneumatic sheet support system.
- Pneumatic sheet unloading system.
- Automatic stacking system.
- Laser cutting line to enable the operator to shear angled or drawn cutlines.
- Finger protective light curtain.
- Oil coolant.
- Longer front arms or squaring arm.
- Angle guage.
- Stainless steel cutting blades.



OPTIONAL POWERED BLADE GAP ADJUSTMENT, REQUIRES DELEM DAC 310 CONTROL



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	CUTTING LENGTH	CUTTING CAPACITY (45 kg/mm <sup>2</sup> )	CUTTING CAPACITY (70 kg/mm <sup>2</sup> )	CUTTING ANGLE	STROKE PER MINUTE	No. OF HOLD DOWNS	MAIN MOTOR	BACKGAUGE MOTOR	BACKGAUGE TRAVEL	OIL CAPACITY	TABLE LENGTH	THROAT DEPTH	MACHINE WIDTH	TABLE HEIGHT	WIDTH	TRANSPORT WIDTH	HEIGHT	LENGTH	WEIGHT
		A										B	C	D	E	K	F	H	L	kg
		mm						kw	kw	mm		mm	mm	mm	mm	mm	mm	mm	mm	mm
BHGS 3100/6 NC	M1062	3060	6	4	1.5	18	17	11	0.37	1000	170	3340	250	3100	800	2600	1600	1825	3770	7000
BHGS 3100/10 NC	M1063	3060	10	6	2	12	17	22	0.37	1000	170	3420	250	3275	800	2775	1775	1850	3850	9200
BHGS 3100/13 NC	M1064	3060	13	8	2.4	12	17	30	0.37	1000	220	3450	250	3485	900	2985	1985	2060	3880	11500
BHGS 3100/16 NC	M1065	3060	16	10	2.7	7	17	30	0.55	1000	220	3410	250	3550	900	3150	2150	2230	3840	15500
BHGS 3100/20 NC	M1066	3060	20	13	3	7	18	37	0.55	1000	280	3470	250	3540	900	3140	2140	2440	3900	19600
BHGS 4100/10 NC	M1067	4060	10	6	2	10	23	22	0.37	1000	170	4370	250	3375	800	2975	1975	1910	4800	13000
BHGS 4100/13 NC	M1068	4060	13	8	2.2	8	23	30	0.37	1000	220	4400	250	6750	900	2975	1975	2160	4830	16100



HSV CNC RANGE

The Morgan Rushworth HSV CNC range of variable rake guillotines are heavy duty, strong machines designed for a long working life. The CNC controller automatically calculates and adjusts the blade gap, the back gauge position, cutting angle and stroke length simultaneously once the data is entered. Therefore the strokes per minute cutting cycle is significantly increased. The cutting angle automatically adjusts according to material thickness minimising the twisting of sheet during the cutting cycle.



REAR VIEW WITH MOTORISED  
BACKGAUGE AND OPTIONAL  
PNEUMATIC SHEET SUPPORT  
SYSTEM

SWING AWAY GUARD WITH SAFETY INTERLOCK  
SWITCH FOR ALIGNMENT OF ANGLED CUTS



HSV MODELS - REINFORCED THROAT  
ARRANGEMENT FOR SHEARING LONG  
SHEETS



## FEATURES

- Cybelec DNC60 CNC controlling blade gap, back gauge, stroke and cutting angle.
- 1000mm swing away back gauge.
- One-piece honed and chrome plated double acting powerful cylinders.
- High quality top and bottom blades  
Bottom: 4 Top: 2 cutting sides.
- Bosch - Rexroth hydraulic system.
- High pressurized silent Atos pump.
- Powerful material hold downs to prevent sheet sliding during cutting action.
- Support table with roller bearings
- Front support arms with ruler and flip-stop.
- Foot pedal available for single or continuous cutting.
- Cutting line illumination.
- Rear guard with photo-cell.

OPTIONAL LASER CUTTING LINE

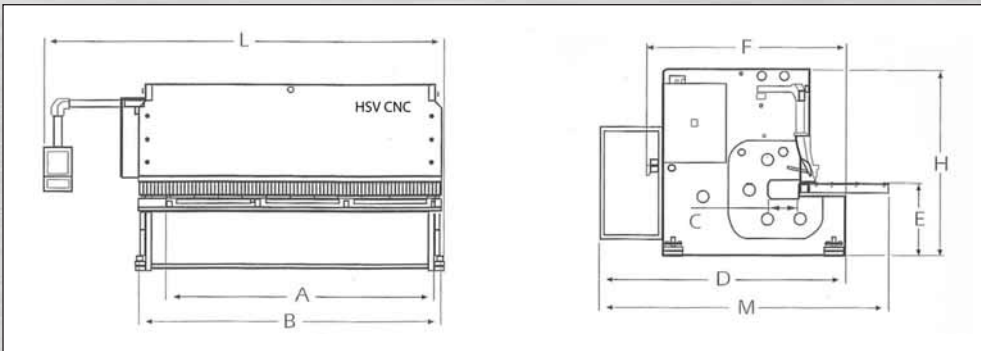


POWERFUL HOLD DOWN CYLINDERS



## OPTIONS

- Laser cutting line to enable the operator to shear angled or drawn cutlines.
- Angle gauge.
- Pneumatic sheet support system.
- 500mm throat depth.
- Extended front squaring arm.
- Front light curtain.
- Stainless steel cutting blades.



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	CUTTING LENGTH	CUTTING CAPACITY (45 kg/mm <sup>2</sup> )	CUTTING CAPACITY (70 kg/mm <sup>2</sup> )	CUTTING ANGLE	STROKE PER MINUTE	NO. OF HOLD DOWNS	PRESSURE	MAIN MOTOR	BACKGAUGE MOTOR	BACKGAUGE TRAVEL	OIL CAPACITY	BLADE GAP ADJUSTMENT	BACKGAUGE SPEED	NO. OF SHEET SUPPORT ARMS	TABLE LENGTH	THROAT DEPTH	MACHINE WIDTH	TABLE HEIGHT	TRANSPORT WIDTH	LENGTH	WIDTH	HEIGHT	WEIGHT
		A mm							Ton	kw	mm	lt	mm	mm/sec		B mm	C mm	D mm	E mm	F mm	L mm	M mm	H mm	kg
HSV CNC 3100/6	M1022	3100	6	4	0.5-1.5	16-24	14	12	11	0.75	1000	150	0.05-0.8	110	2	3500	350	2315	900	2200	4980	2900	2225	8300
HSV CNC 3100/10	M1023	3100	10	6	0.5-2	12-22	14	24	22	1.1	1000	260	0.05-1.3	110	2	3640	350	2425	900	2265	5100	3000	2250	11200
HSV CNC 3100/13	M1024	3100	13	8	0.5-2	11-20	14	31	22	1.1	1000	310	0.05-1.5	110	2	3680	350	2570	900	2315	5110	3100	2300	13450
HSV CNC 3100/16	M1025	3100	16	10	0.5-2.5	9-16	14	42	30	1.1	1000	500	0.05-1.9	110	2	3760	350	2700	900	2340	5210	3240	2400	18700
HSV CNC 3100/20	M1026	3100	20	13	0.5-2.5	7-13	14	54	37	1.1	1000	500	0.05-2.3	110	2	3800	350	2700	900	2355	5220	3240	2500	20700
HSV CNC 4100/6	M1027	4100	6	4	0.5-1.5	14-22	18	15	11	0.75	1000	150	0.05-0.8	110	3	4500	350	2315	950	2200	6000	2900	2300	13100
HSV CNC 4100/10	M1028	4100	10	6	0.5-2	10-17	18	28	22	1.1	1000	260	0.05-1.3	110	3	4640	350	2580	1000	2270	6100	3125	2550	17000
HSV CNC 4100/13	M1029	4100	13	8	0.5-2	9-15	18	40	22	1.1	1000	310	0.05-1.5	110	3	4680	350	2700	1000	2325	6120	3240	2650	20000
HSV CNC 4100/16	M1030	4100	16	10	0.5-2.5	7-13	18	52	30	1.1	1000	500	0.05-1.9	110	3	4760	350	2700	1000	2340	6220	3240	2750	26500
HSV CNC 4100/20	M1031	4100	20	13	0.5-2.5	6-11	18	67	37	1.1	1000	500	0.05-2.3	110	3	4800	350	2700	1000	2355	6220	3270	2850	31000
HSV CNC 6100/6	M1032	6100	6	4	0.5-1.5	9-15	26	20	18.5	1.1	1000	260	0.05-0.8	110	4	6600	350	2375	1000	2285	8250	2950	2750	25750
HSV CNC 6100/10	M1033	6100	10	6	0.5-2	8-13	26	44	22	1.1	1000	260	0.05-1.3	110	4	6680	350	2375	1100	2285	8265	2950	2900	28800
HSV CNC 6100/13	M1034	6100	13	8	0.5-2	6-11	26	60	22	1.1	1000	310	0.05-1.5	110	4	6720	350	2535	1100	2330	8365	3050	3000	32300
HSV CNC 6100/16	M1035	6100	16	10	0.5-2.5	5-9	26	76	30	1.1	1000	500	0.05-1.9	110	4	6820	350	2700	1100	2350	8400	3240	3150	41100
HSV CNC 6100/20	M1036	6100	20	13	0.5-2.5	4-7	26	96	37	1.1	1000	500	0.05-2.3	110	4	6940	350	2730	1100	2375	8415	3240	3300	55600



PB RANGE MODEL PICTURED WITH  
OPTIONAL LASER TOOL GUARD

The conventional PB series pressbrakes are manufactured with a heavy duty welded steel frame with strong torsion bar and hydro mechanical balancing system ensuring a long working life. PB machines range from 35 tonnes through to 300 tonnes with a bending length of up to 4100mm.

All PB machines accept euro style tooling and are supplied with digital readouts for stroke control and for the power backgauge position.

Side and rear guards with electrical interlocks are fitted as standard for increased safety.

## FEATURES

- European style top tool holders with wedge adjustment.
- Standard tooling: Gooseneck top tool and multi-vee bottom tool.
- Front operated, 750mm ballscrew backgauge with digital readout control (to 0.1mm precision) and two finger-stops with micro-adjustable height.
- Ram stroke control by precision mechanical-stops built into each cylinder and electrically adjusted by push-buttons with a digital position display.
- Independent position control of one cylinder-stop to provide fine angle adjustment and/or conical bending possibility.
- Pressure switch and gauge to regulate bending tonnage and to prevent overbending due to bottoming of tools.
- Pre-set, two-speed bending cycle giving fast approach, slow bending and fast return.
- 3-function footswitch: normal bending, beam pause at any stroke point, automatic beam return upon release of footswitch.
- Pendant control unit.
- Hand screw clamps and chains to align and secure bottom die.
- Two backgauge fingers.
- Two front support arms.

BACKGAUGE FINGER DETAIL



STANDARD EURO TOOLING



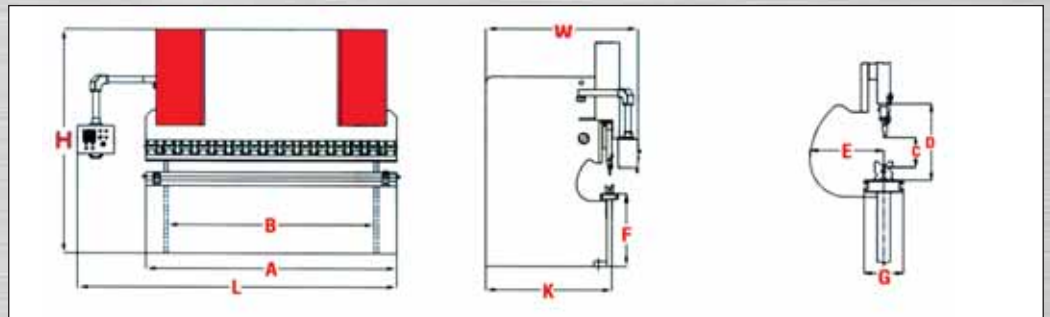
For technical specification of standard tooling supplied see page 131

REAR VIEW



## OPTIONS

- Programmable (NC) control for Y (stroke) and X (backgauge) axes.
- 1000mm backgauge length.
- Top tool quick release clamps.
- Laser tool guard.
- Anti deflection system.
- Additional backgauge fingers.
- Additional front support arm.



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	BENDING POWER	BENDING LENGTH	DIST BETWEEN COLUMNS	Y RAPID SPEED	Y WORKING SPEED	Y RETURN SPEED	TRAVEL IN X AXIS	OIL CAPACITY	MOTOR POWER	STROKE	DAYLIGHT	THROAT DEPTH	TABLE HEIGHT	TABLE WIDTH	MACHINE WIDTH	LENGTH	HEIGHT	WIDTH	WEIGHT
		A mm	B mm	mm/sec	mm/sec	mm/sec	mm	lit	kw	C mm	D mm	E mm	F mm	G mm	K mm	L mm	H mm	W mm	kg	
PB 1250/40	M5000	35	1250	1070	100	10	70	750	80	4	150	470	410	800	140	1270	2150	2150	1570	2200
PB 2100/40	M5001	40	2100	1600	90	10	70	750	80	4	80	410	310	800	140	1270	3100	2150	1570	3000
PB 2600/60	M5002	60	2600	2050	90	9	65	750	100	5.5	110	450	310	860	140	1290	3100	2150	1590	4800
PB 2600/90	M5003	90	2600	2050	80	10	80	750	130	7.5	120	475	310	860	170	1300	3100	2270	1650	5650
PB 3100/90	M5004	90	3100	2550	95	10	80	750	170	7.5	120	460	310	870	140	1300	4350	2270	1650	6500
PB 3100/120	M5005	120	3100	2550	100	10	90	750	170	11	130	485	310	870	170	1620	4350	2370	2250	7950
PB 3100/160	M5006	160	3100	2550	90	8	75	750	180	11	140	510	310	870	200	1620	4350	2450	2250	8700
PB 3100/200	M5007	200	3100	2550	100	8	75	750	210	15	150	525	310	880	240	1630	4350	2520	2250	10500
PB 3100/240	M5008	240	3100	2550	70	8	55	750	210	18.5	160	580	310	880	280	1650	4350	2650	2250	12000
PB 3100/300	M5009	300	3100	2550	80	9	60	750	240	22	180	595	380	900	380	1870	4350	2850	2400	17000
PB 3700/160	M5010	160	3700	3250	90	8	75	750	210	11	140	500	310	870	170	1430	4950	2450	1850	11200
PB 3700/200	M5011	200	3700	3250	100	8	75	750	210	15	150	540	310	880	240	1650	4950	2520	2200	12500
PB 3700/240	M5012	240	3700	3250	70	8	55	750	260	18.5	160	565	310	880	240	1650	4950	2650	2250	14000
PB 4100/160	M5013	160	4100	3550	90	8	75	750	260	11	140	500	310	880	170	1430	5300	2450	1950	12500
PB 4100/200	M5014	200	4100	3550	100	8	75	750	260	15	150	510	310	880	200	1650	5300	2520	2200	14500
PB 4100/240	M5015	240	4100	3550	100	8	55	750	260	18.5	160	565	310	880	240	1650	5300	2650	2050	15000
PB 4100/300	M5016	300	4100	3550	80	9	60	750	300	22	180	595	380	900	280	1870	5300	2850	2400	18500



PB CNC RANGE MODEL PICTURED WITHOUT STANDARD CE FRONT LIGHT GUARDS

Technical Specifications see page 126

The Morgan Rushworth PB CNC series 3 axis hydraulic pressbrake are manufactured with a heavy duty welded steel frame and has been developed to fulfill a criteria for high production speed machines. The synchro system is provided by synchronised cylinders with proportional valve technology ensuring precise bending angles. The Cybelec DNC60PS control is fitted as standard combining ease of operation with high processing efficiency. PB CNC range from 40 ton through to 2 x 2000 ton tandem machines.

CYLINDERS WITH CHROME PLATED PISTONS ARE TESTED UNDER HUGH PRESSURE



SECTIONED EURO STYLE TOOL HOLDER



REAR VIEW

CYBELEC DNC 60PS CONTROL PANEL



For technical specification of standard tooling supplied see page 131



PRECISE MULTI-AXES BACK GAUGE FINGERS



OPTIONAL WILA MANUAL  
ANTI-DEFLECTION SYSTEM



OPTIONAL WILA MOTORISED  
ANTI-DEFLECTION SYSTEM

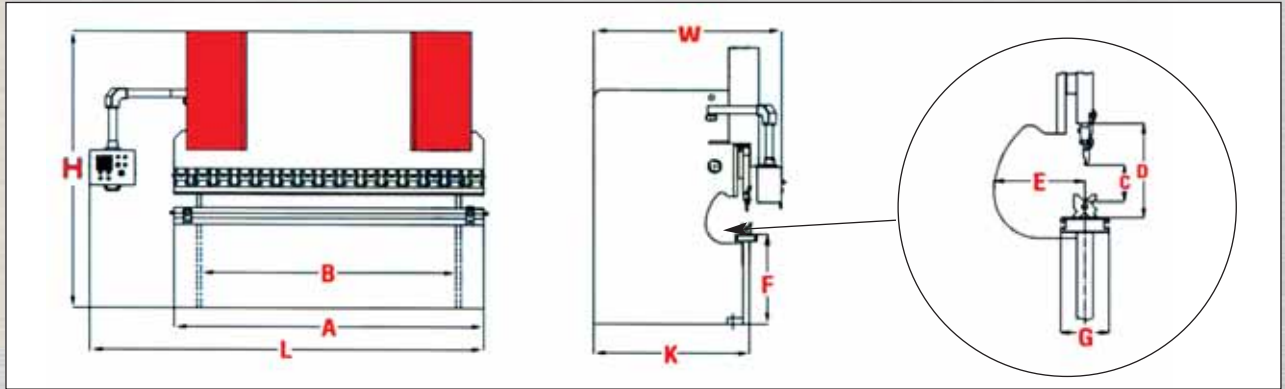


**OPTIONS**

- Manual WILA manual anti-deflection system.
- Motorized WILA manual anti-deflection system which operates automatically according to tonnage applied.
- Pneumatic top tool holding system.
- Hydraulic top and bottom tool holding system.
- Sliding front arms with bearing rollers.
- Automatic slide greasing system.
- Special throat depth (500, 600 and 750mm).

**FEATURES**

- Sick light guards.
- Mono block, welded steel frame.
- Bosch-Rexroth hydraulic system.
- High quality Walter shield hydraulic connection fittings.
- High pressurized silent ATOS Hydraulic pump.
- 800mm length back gauge moving on ball-screwed shafts, back gauge bar can be adjusted at several points.
- Euro style tool holders.
- Hardened and ground segmented top tooling system.
- Ground bottom tool made of 42CrMo.
- Honed hydraulic cylinders and chrome coated pistons.
- Front arms with T-slots and mm scale.
- 400mm throat depth.
- Metric and inch working modes.
- Functional and moveable control panel.
- Cybelec DNC 60P controller.
- Y1 + Y2 + X axis.
- Synchronization control of Y1 + Y2 axis by  $\pm 0.01$  accuracy linear encoders is provided by means of hydro-electrical technique, with servo valves.
- AC motorised back gauge system with ball-screwed shaft in X-axis, Analogue Dynamic, Fast Servo controlled back gauge.
- Proportional hydraulic valve system.
- High accuracy encoders.
- Ability to achieve required angle by entering material type, width, length and thickness.
- Automatic adjustment of back gauge position according to the bending program.
- Automatic calculation of required stroke for the required bending angle.
- Multiple point parallelism adjustable back gauge bar, back gauge fingers with the accuracy of 0.01.



**TECHNICAL SPECIFICATIONS**

MODEL	STOCK CODE	BENDING POWER	BENDING LENGTH	DIST BETWEEN COLUMNS	Y RAPID SPEED	Y WORKING SPEED	Y RETURN SPEED	TRAVEL IN X AXIS	SPEED OF X AXIS STANDARD AC AXES	SPEED OF X AXIS DYNAMIC SERVO AXES	TRAVEL IN R AXIS	OPERATIONAL SPEED OF DYNAMIC SERVO R AXES	BACKGAUGE FINGER BLOCKS	NUMBER OF SHEET SUPPORT ARMS	OIL CAPACITY	MOTOR POWER	STROKE	DAYLIGHT	THROAT DEPTH	TABLE HEIGHT	TABLE WIDTH	MACHINE WIDTH	LENGTH	HEIGHT	WIDTH	WEIGHT
		Ton	A mm	B mm	mm/sec	mm/sec	mm/sec	mm	mm/sec	mm/sec	mm	mm/sec	Amount	Amount	LI.	kw	C mm	D mm	E mm	F mm	G mm	K mm	L mm	H mm	W mm	kg
PB CNC 1270/40	M5017	35	1270	1000	150	17	170	500	250	350	150	180	2	2	100	5.5	100	308	200	900	90/100	1245	2150	2150	1550	2800
PB CNC 2100/35	M5018	35	2100	1550	150	17	170	500	250	350	150	180	2	2	100	5.5	100	308	200	900	90/120	1245	2900	2150	1550	3500
PB CNC 2600/80	M5019	80	2600	2050	100	10	90	500	250	350	150	180	2	2	150	7.5	180	422	400	900	90/200	1550	3750	2750	1950	6000
PB CNC 2600/120	M5020	120	2600	2050	100	10	90	500	250	350	150	180	2	2	200	11	180	429	400	900	90/220	1560	3750	2800	1950	7100
PB CNC 3100/80	M5021	80	3100	2550	100	10	90	500	250	350	150	180	2	2	150	7.5	180	429	400	900	90/200	1550	4250	2800	1950	7000
PB CNC 3100/120	M5022	120	3100	2550	100	10	90	500	250	350	150	180	2	2	200	11	180	429	400	900	90/220	1560	4250	2800	2050	8600
PB CNC 3100/160	M5023	160	3100	2550	100	9	90	500	250	350	150	180	2	2	200	15	180	429	400	900	100/220	1570	4250	2800	2150	9500
PB CNC 3100/200	M5024	200	3100	2550	100	9	90	500	250	350	150	180	2	2	200	15	200	447	400	900	100/240	1580	4550	2850	2250	11000
PB CNC 3100/250	M5025	250	3100	2550	100	8	90	500	250	350	150	180	2	2	300	18.5	250	517	400	900	100/300	1790	4550	2950	2350	15000
PB CNC 3100/300	M5026	300	3100	2550	100	8	90	500	250	350	150	180	2	2	300	22	250	539	400	900	120/360	1800	4550	3050	2450	17000
PB CNC 3100/400	M5027	400	3100	2550	100	8	90	500	250	350	150	180	2	2	400	30	300	585	400	1000	120/340	1800	4350	3250	2450	22000
PB CNC 3760/160	M5028	160	3760	3250	100	9	90	750	250	350	150	180	2	2	200	15	180	429	400	950	100/220	1580	4900	2900	2150	12000
PB CNC 3760/200	M5029	200	3760	3250	100	9	90	750	250	350	150	180	2	2	200	15	200	447	400	950	100/240	1590	5100	3050	2250	14500
PB CNC 3760/300	M5030	300	3760	3250	100	8	90	750	250	350	150	180	2	2	300	22	250	534	400	1000	120/290	1800	5100	2850	2450	19000
PB CNC 4100/120	M5031	120	4100	3550	100	10	90	750	250	350	150	180	2	2	200	11	180	429	400	900	90/220	1570	5150	2950	2050	11000
PB CNC 4100/160	M5032	160	4100	3550	100	9	90	750	250	350	150	180	2	2	200	15	180	429	400	1000	100/220	1580	5150	3050	2150	13000
PB CNC 4100/200	M5033	200	4100	3550	100	9	90	750	250	350	150	180	2	2	200	15	200	447	400	1000	120/220	1590	5150	3050	2250	15000
PB CNC 4100/250	M5034	250	4100	3550	100	8	90	750	250	350	150	180	2	2	300	18.5	250	502	400	1000	120/250	1800	5150	3150	2350	17900
PB CNC 4100/300	M5035	300	4100	3550	100	8	90	750	250	350	150	180	2	2	300	22	250	519	400	1000	120/300	1800	5350	3250	2450	19600
PB CNC 4100/400	M5036	400	4100	3550	100	7	90	750	250	350	150	180	2	2	400	30	300	585	400	1000	120/340	1800	5450	3150	2550	24500
PB CNC 6100/200	M5037	200	6100	5100	100	9	90	750	250	350	150	180	4	4	200	15	200	445	400	1100	120/250	1600	7400	3150	2250	20000
PB CNC 6100/300	M5038	300	6100	5100	100	8	90	750	250	350	150	180	4	4	300	22	250	514	400	1100	120/300	1800	7500	3350	2450	33000
PB CNC 6100/400	M5039	400	6100	5100	100	7	90	750	250	350	150	180	4	4	400	30	300	585	400	1100	120/320	1800	7650	3800	2550	38000
PB CNC 6100/500	M5040	500	6100	5050	100	7	60	750	250	350	200	180	4	4	500	37	350	600	500	1100	120/340	2000	7450	3700	2650	46000
PB CNC 6100/600	M5041	600	6100	5100	80	6	60	750	250	350	200	180	4	4	500	37	350	600	500	900	150/350	2000	7900	4100	2452	55000



PBS CNC RANGE MODEL PICTURED WITH  
OPTIONAL LASER TOOL GUARD

The new Morgan Rushworth PBS CNC range of hydraulic pressbrakes are fitted with the new ESA CNC controller to enable off line programming from PC. Multi bend operations with complex forms can thus be effectively managed reducing operator error and over or under bending. The Y1 and Y2 axis are fully synchronised and accurate to 0.01mm with proportional valve technology. Monoblock welded steel frame ensures minimum deflection under maximum load. The PBS CNC range spans 1250mm x 40T machines up to 4100mm x 300T models. A comprehensive range of options including anti deflection tables are available to fully 'tailor' machines to customer requirements.

#### QUICK RELEASE CLAMPS



#### REAR VIEW



#### STANDARD CNC CONTROL PANEL



OPTIONAL R AXIS CNC REAR BACK GAUGE WITH FINGER DETAIL



STANDARD REAR CNC REAR BACK GAUGE WITH FINGER DETAIL



OPTIONAL MANUAL ANTI DEFLECTION TABLE



OPTIONAL CNC ANTI DEFLECTION TABLE



OPTIONAL FRONT LASER PROTECTION



EURO 2009 BOTTOM TOOLING

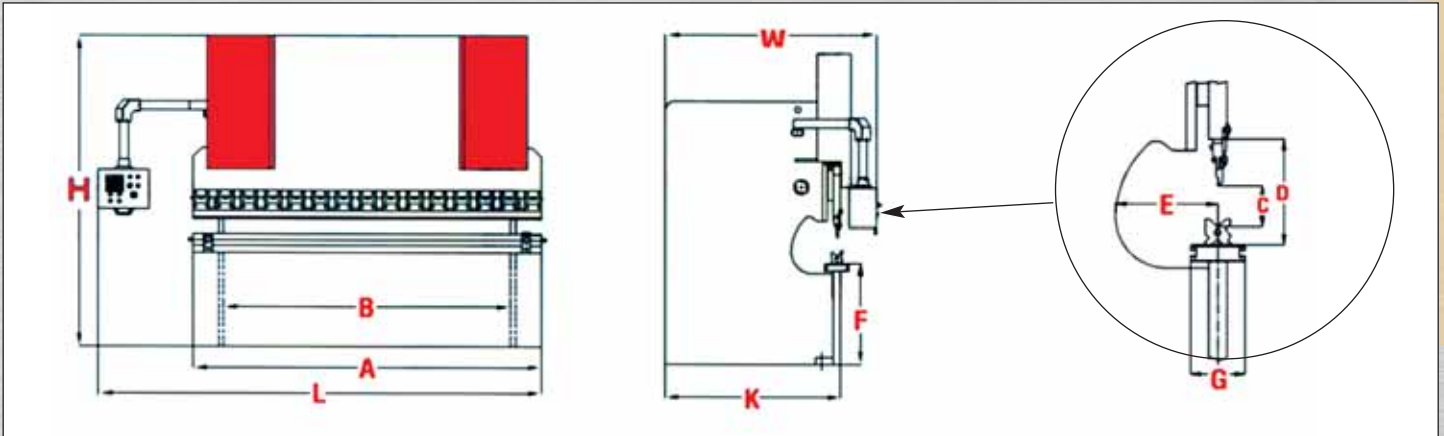


## FEATURES

- Strong rigid welded Monoblock frame able to withstand deflection under load.
- Sick CE front light guards
- User friendly ESA CNC system with 2D auto bend sequence computations and large tool library.
- Full off line 2D graphical view programming software which can be transferred to the controller with USB flash disc.
- Ideal for multi bending of complex operations, especially where volume production with accurate repeatability is required.
- Bend accuracy at least five times higher than conventional pressbrakes.
- Fully synchronised Y1 and Y2 axis, accurate to 0.01mm with proportional valve technology.
- Hydraulic ram travel guided in low friction slideways.
- Fast CNC backgauge with AC servo drive.
- Euro style top clamps with intermediaries and quick release tool clamps.
- Sectionalised goose neck top tool.
- Sectionalised multi vee bottom die.
- High stroke and daylight opening.
- Deep throat design
- Two front support arms on adjustable linear rail
- Dual foot switch console with emergency stop.
- Swivelling pendant arm.
- Rear guard with photo cell safety beam.
- Ventilated electrical cabinet.

## OPTIONS

- Manual anti deflection table
- CNC anti deflection table
- S540 2D colour graphical CNC controller
- Extra backgauge fingers



## TECHNICAL SPECIFICATIONS

MODEL	STOCK CODE	BENDING POWER	BENDING LENGTH	DIST BETWEEN COLUMNS	Y RAPID SPEED	Y WORKING SPEED	Y RETURN SPEED	TRAVEL IN X AXIS	SPEED OF X AXIS STANDARD AC AXES	TRAVEL IN R AXIS	OPERATIONAL SPEED OF DYNAMIC SERVO R AXES	BACKGAUGE FINGER BLOCKS	NUMBER OF SHEET SUPPORT ARMS	OIL CAPACITY	MOTOR POWER	STROKE	DAYLIGHT	THROAT DEPTH	TABLE HEIGHT	TABLE WIDTH	MACHINE WIDTH	LENGTH	HEIGHT	WEIGHT
		Ton	A mm	B mm	mm/sec	mm/sec	mm/sec	mm	mm/sec	mm	mm/sec	Amount	Amount	Li.	kw	C mm	D mm	E mm	F mm	G mm	K mm	L mm	H mm	kg
PBS CNC 1250/40	M5042	40	1250	1070	100	10	100	1000	350	160	240	2	2	80	4	215	455	410	800	60	1470	2150	2250	3300
PBS CNC 2100/60	M5043	60	2100	1600	90	9.4	80	1000	350	160	240	2	2	140	5.5	210	475	410	880	60	1580	2900	2542	5400
PBS CNC 2600/60	M5044	60	2600	2050	100	9.4	80	1000	350	160	240	2	2	140	5.5	210	475	410	880	60	1580	3750	2542	6200
PBS CNC 2600/90	M5045	90	2600	2050	90	9.4	80	1000	350	160	240	2	2	140	7.5	260	530	410	890	60	1580	3750	2605	7100
PBS CNC 3100/90	M5046	90	3100	2550	100	9.4	80	1000	350	160	240	2	2	140	7.5	260	530	410	880	60	1590	4350	2605	7900
PBS CNC 3100/120	M5047	120	3100	2550	100	9.6	80	1000	350	160	240	2	2	140	11	260	530	410	890	60	1590	4350	2905	8400
PBS CNC 3100/160	M5048	160	3100	2550	100	7.7	80	1000	350	160	240	2	2	210	15	260	530	410	890	60	1600	4350	2905	9700
PBS CNC 3100/200	M5049	200	3100	2550	100	7.7	80	1000	350	160	240	2	2	210	18.5	260	530	410	880	90	1600	4350	2905	10000
PBS CNC 3100/240	M5050	240	3100	2550	90	7.6	80	1000	350	160	240	2	2	210	22	260	530	410	880	90	1610	4350	2905	11000
PBS CNC 3100/300	M5051	300	3100	2550	90	9.1	80	1000	350	160	240	2	2	280	22	320	660	500	905	280	1815	4350	3150	15000
PBS CNC 3700/120	M5052	120	3700	3250	100	9.6	80	1000	350	160	240	2	2	210	11	260	530	410	870	60	1630	4950	2905	11000
PBS CNC 3700/160	M5053	160	3700	3250	100	7.7	80	1000	350	160	240	2	2	210	15	260	530	410	880	60	1600	4950	2905	11500
PBS CNC 3700/200	M5054	200	3700	3250	100	7.7	80	1000	350	160	240	2	2	210	18.5	260	530	410	880	90	1600	4950	2905	12000
PBS CNC 3700/240	M5055	240	3700	3250	90	7.6	80	1000	350	160	240	2	2	210	22	260	530	410	880	90	1610	4950	2905	13500
PBS CNC 3700/300	M5056	300	3700	3250	90	9.1	80	1000	350	160	240	2	2	280	22	320	635	500	980	280	1820	4950	3200	17000
PBS CNC 4100/160	M5057	160	4100	3550	100	7.7	80	1000	350	160	240	2	2	210	15	260	530	410	880	60	1600	5250	2905	12000
PBS CNC 4100/200	M5058	200	4100	3550	100	7.7	80	1000	350	160	240	2	2	210	18.5	260	530	410	880	90	1600	5250	2905	12500
PBS CNC 4100/240	M5059	240	4100	3550	90	7.6	80	1000	350	160	240	2	2	210	22	260	530	410	880	90	1610	5250	2905	14000
PBS CNC 4100/300	M5060	300	4100	3550	90	9.1	80	1000	350	160	240	2	2	280	22	320	635	500	980	280	1820	5250	3200	18500

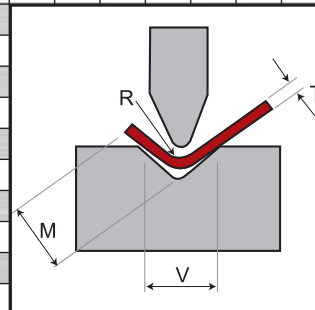
The Morgan Rushworth PB NC, PB CNC and the new range PBS CNC are all supplied with 'Euro' style top tooling, in two heights depending on the machine capacity. The bottom tooling for the smaller capacity CNC machines are also equipped with 'Euro' style tooling with 4 way vee dies. All Euro tooling is supplied in 415mm and 835mm lengths and configured according to the length of the machine. The bottom tooling supplied with the entire PB NC range and the larger CNC machines are full length, one piece and available with 4 way or 6 way vees.

The chart on the opposite page details the standard tooling supplied with each machine. Optional tooling including safe edge, large vee dies, bull nose top tools, over 90 degree bending and many other applications are specified on pages 88 – 93. Segmented tooling is also available for 'box and pan' type bending to allow for the return legs.

### TONNAGE CALCULATOR

T = Steel thickness (mm) R = Internal radius of bend (mm) M = Minimum return bend (mm) V = Bottom die Vee width (mm) L = Bending length (mm)

T mm	0.7	0.8	1	1.3	1.6	2	2.7	3	3.3	4	5	5.5	6.5	7	8	10	11	13	16	19	21	23	24.5	26	28	32	41	48	R (mm)	
	2.8	3.5	4	6	7	9	11	13	14	17	22	24	28	31	35	42	90	56	70	80	90	100	105	110	130	140	170	200	M (mm)	
	4	5	6	8	10	12	15	18	20	25	30	35	40	45	50	60	70	80	100	120	130	140	150	160	180	200	250	300	V (mm)	
0.5	4	3	2	2																									Ton/m	
0.6	5	4	3.5	3	2																									Ton/m
0.8		8	7	5	4	2																								Ton/m
1.0			10	8	6	5	4																							Ton/m
1.2				10	8	6	5	4																						Ton/m
1.5					13	12	9	7	7																					Ton/m
1.8						16	13	11	10	8																				Ton/m
2.0							16	14	12	10	8																			Ton/m
2.5								21	20	15	12	11																		Ton/m
3.0									27	22	18	15	13																	Ton/m
3.5										29	24	21	18	16																Ton/m
4.0											32	27	24	21	19															Ton/m
4.5												35	30	27	24	20														Ton/m
5.0													37	33	30	25	21													Ton/m
6.0														48	43	36	31	27												Ton/m
7.0															58	49	42	37	29											Ton/m
8.0																64	55	48	42	32										Ton/m
10																	85	75	60	50	46									Ton/m
12																		107	86	72	66	61								Ton/m
13																			101	84	76	72	67							Ton/m
14																				98	90	84	78	73						Ton/m
15																					103	96	90	84	75					Ton/m
16																						109	102	95	85	76				Ton/m
18																							129	120	107	97	77			Ton/m
20																								149	132	119	95	80		Ton/m
25																									207	186	149	124		Ton/m
30																										268	215	179		Ton/m

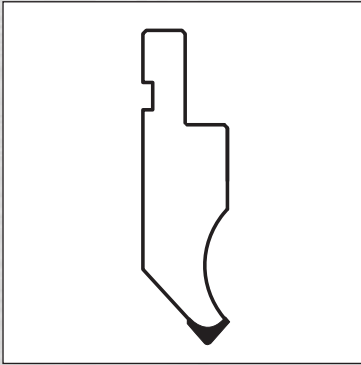


**TONNAGE CALCULATOR**

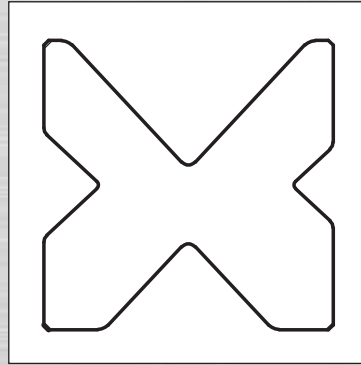
$$\text{Tonnes} = \frac{1.42 \times S \times T^2 \times L}{1000 \times V}$$

S = Tensile Strength (kg/mm<sup>2</sup>)  
 Mild Steel = 45  
 Stainless Steel = 60  
 Aluminium = 30

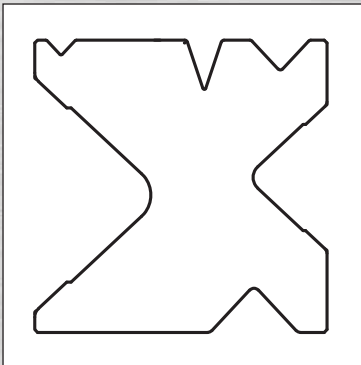
**STANDARD PRESSBRAKE TOOLING**



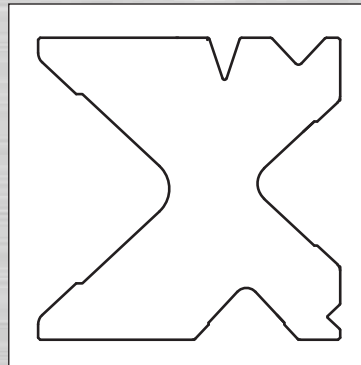
**GOOSE NECK TOP TOOL**  
  
EURO 1010/A/85/0.8  
EURO 1010/A/85/0.8/105



**4 WAY VEE DIE BOTTOM TOOL**  
  
EURO 2009  
1061  
1062  
1071  
1081



**6 WAY VEE DIE BOTTOM TOOL**  
  
AB6 3-4  
AB6 5-6  
AB6 7-8  
AB6 9-10

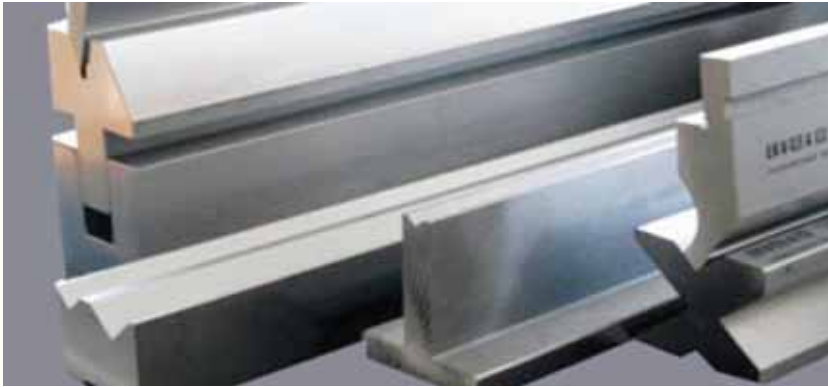


**6 WAY VEE DIE BOTTOM TOOL**  
  
AB6 11-12  
AB6 16

MODEL	GOOSE NECK TOP TOOL REFERENCE	TOP TOOL OVERALL HEIGHT mm	BOTTOM TOOL REFERENCE	BOTTOM TOOL No. OF VEE'S	BOTTOM TOOL VEE SIZES mm	BOTTOM TOOL OVERALL SIZE mm
<b>PB NC RANGE</b>						
1250/40, 2100/40, 2600/60, 3100/90	1010/A/85/0.8	96.5	AB6 3-4	6	8, 10, 15, 20, 26, 40	70 x 70
2600/90, 3100/120, 3700/160, 4100/160	1010/A/85/0.8	96.5	AB6 5-6	6	10, 12, 16, 26, 40, 60	90 x 90
3100/160,	1010/A/85/0.8	96.5	AB6 7-8	6	10, 12, 20, 30, 50, 80	100 x 100
4100/200	1010/A/85/0.8/105	135	AB6 7-8	6	10, 12, 20, 30, 50, 80	100 x 100
3100/200, 3700/200, 3700/240, 4100/240	1010/A/85/0.8/105	135	AB6 9-10	6	12, 15, 26, 40, 60, 100	125 x 125
3100/240, 4100/300,	1010/A/85/0.8/105	135	AB6 11-12	6	12, 15, 26, 50, 80, 125	145 x 145
3100/300	1010/A/85/0.8/105	135	AB6 16	6	20, 25, 40, 80, 100, 170	200 x 200
<b>PB CNC RANGE</b>						
1270/40 – 3100/160	1010/A/85/0.8	96.5	2009	4	16, 22, 35, 50	60 x 60
3760/200, 4100/200,	1010/A/85/0.8	96.5	1062	4	22, 35, 50, 80	120 x 120
3100/200	1010/A/85/0.8	96.5	1061	4	35, 50, 80, 110	160 x 160
6100/300	1010/A/85/0.8/105	135	1062	4	22, 35, 50, 80	120 x 120
3760/250, 4100/250,	1010/A/85/0.8/105	135	1061	4	35, 50, 80, 110	160 x 160
3100/250, 3760/300, 4100/300	1010/A/85/0.8/105	135	1071	4	60, 80, 100, 120	180 x 180
3100/300, 4100/400, 6100/400, 6100/500	1010/A/85/0.8/105	135	1081	4	60, 80, 100, 140	200 x 200
<b>PBS CNC RANGE</b>						
1250/40 - 4100/160	1010/A/85/0.8	96.5	2009	4	16, 22, 35, 50	60 x 60
3100/200 - 4100/240	1010/A/85/0.8/105	135	2009	4	16, 22, 35, 50	60 x 60
3700/300, 4100/300	1010/A/85/0.8/105	135	AB6 11-12	6	12, 15, 26, 50, 80, 125	145 x 145
3100/300	1010/A/85/0.8/105	135	AB6 16	6	20, 25, 40, 80, 100, 170	200 x 200

# PRESSBRAKE TOOLING and Guillotine Blades

## Pressbrake Tooling



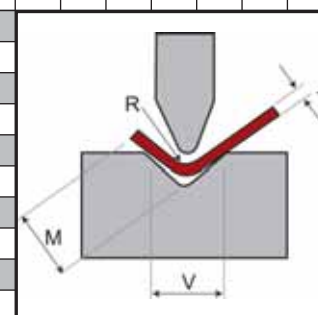
The following five pages detail the various types and technical drawings of the standard range of pressbrake tooling available from Bison Machinery. Goose neck top tools are particularly useful for double bend 'U' shape brackets to avoid the leg from the first bend colliding with the top tool. The 35 degree tools are designed for over bending requirements as well as for the first stage bending for safe edge tooling. Segmented tooling allows for return bending and is necessary for box making after the corners have first been notched. The bull nose tooling is ideal for bending thicker materials as the tonnes per meter rating are very high. The chart below indicates the tonnage required for various bending operations and includes a quick calculation formula.

Guillotine blades are also supplied for virtually every guillotine and corner notcher. Drawings for most machines are kept on file, but in the event of a special we are able to copy any blade with a sample.

## TONNAGE CALCULATOR

T = Steel thickness (mm) R = Internal radius of bend (mm) M = Minimum return bend (mm) V = Bottom die Vee width (mm) L = Bending length (mm)

T mm	0.7	0.8	1	1.3	1.6	2	2.7	3	3.3	4	5	5.5	6.5	7	8	10	11	13	16	19	21	23	24.5	26	28	32	41	48	R (mm)			
	2.8	3.5	4	6	7	9	11	13	14	17	22	24	28	31	35	42	56	70	80	90	90	100	105	110	130	140	170	200	M (mm)			
	4	5	6	8	10	12	15	18	20	25	30	35	40	45	50	60	70	80	100	120	130	140	150	160	180	200	250	300	V (mm)			
0.5	4	3	2	2																										Ton/m		
0.6	5	4	3.5	3	2																										Ton/m	
0.8		8	7	5	4	2																									Ton/m	
1.0			10	8	6	5	4																								Ton/m	
1.2				10	8	6	5	4																							Ton/m	
1.5					13	12	9	7	7																						Ton/m	
1.8						16	13	11	10	8																					Ton/m	
2.0							16	14	12	10	8																				Ton/m	
2.5								21	20	15	12	11																			Ton/m	
3.0									27	22	18	15	13																		Ton/m	
3.5										29	24	21	18	16																	Ton/m	
4.0											32	27	24	21	19																Ton/m	
4.5												35	30	27	24	20															Ton/m	
5.0													37	33	30	25	21														Ton/m	
6.0														48	43	36	31	27													Ton/m	
7.0															58	49	42	37	29												Ton/m	
8.0																64	55	48	42	32											Ton/m	
10																	85	75	60	50	46										Ton/m	
12																		107	86	72	66	61									Ton/m	
13																			101	84	76	72	67								Ton/m	
14																				98	90	84	78	73							Ton/m	
15																					103	96	90	84	75						Ton/m	
16																						109	102	95	85	76					Ton/m	
18																							129	120	107	97	77					Ton/m
20																								149	132	119	95	80				Ton/m
25																									207	186	149	124				Ton/m
30																											268	215	179			Ton/m

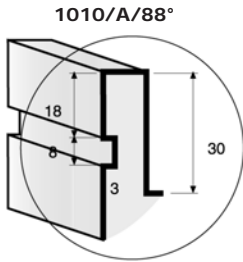


**TONNAGE CALCULATOR**

$$\text{Tonnes} = \frac{1.42 \times S \times T^2 \times L}{1000 \times V}$$

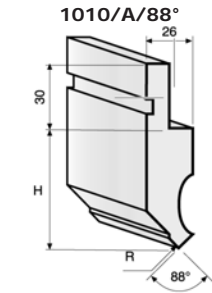
S = Tensile Strength (kg/mm<sup>2</sup>)  
 Mild Steel = 45  
 Stainless Steel = 60  
 Aluminium = 30





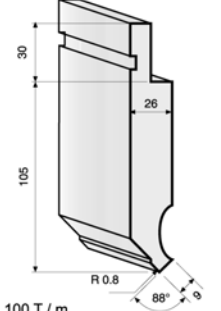
1010/A/88°

R = 0.2 mm / H = 66.90  
 R = 0.8 mm / H = 66.60  
 R = 1.5 mm / H = 65.90  
 R = 2.3 mm / H = 65.60  
 R = 3 mm / H = 65.25



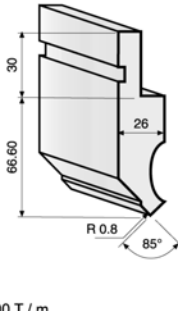
100 T / m

1010/A/88°/0.8/105



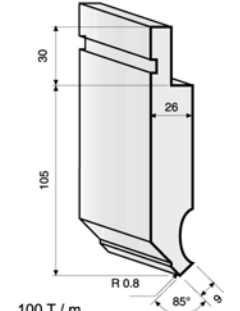
100 T / m

1010/A/85°/0.8



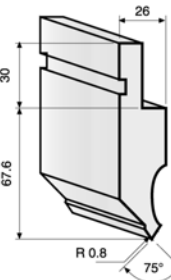
100 T / m

1010/A/85°/0.8/105



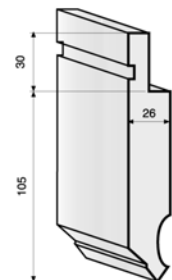
100 T / m

1010/A/75°/0.8



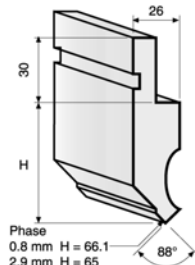
100 T / m

1010/A/75°/0.8



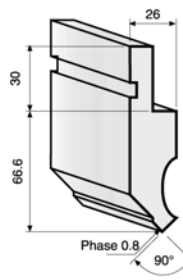
100 T / m

1010/88°



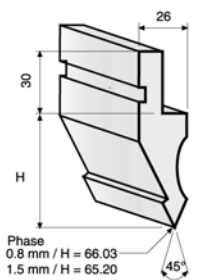
100 T / m

1010/90°/0.8



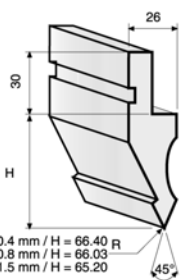
100 T / m

1011/45°



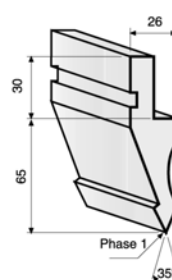
70 T / m

1011/A/45°



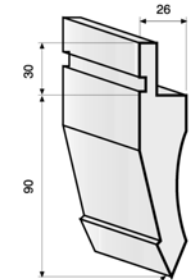
70 T / m

3864/35°/1



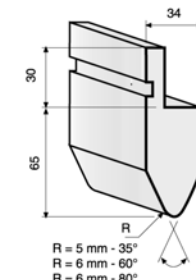
50 T / m

1012/35°/1



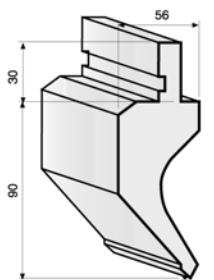
50 T / m

1013



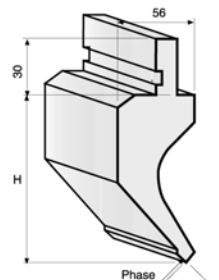
100 T / m

1014/A/75°/0.8



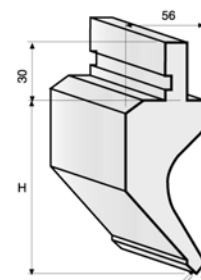
50 T / m

1014/88°



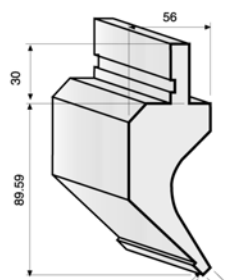
50 T / m

1014/A/88°



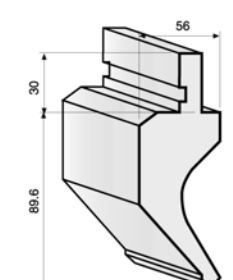
50 T / m

1014/88°/0.8/6



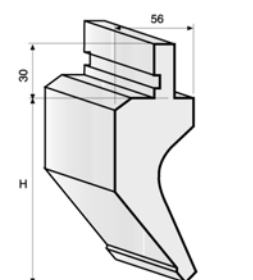
50 T / m

1014/90°/0.8



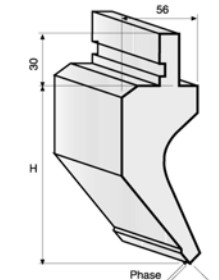
50 T / m

1015/A/88°



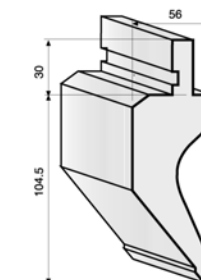
50 T / m

1015/88°



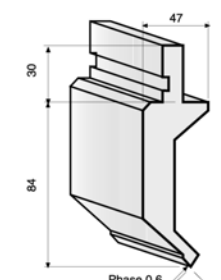
50 T / m

1015/90°/1



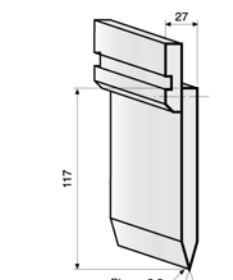
50 T / m

1016/A/0.6



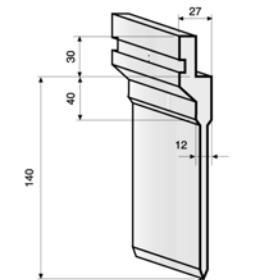
15 T / m

1017/26°/0.8

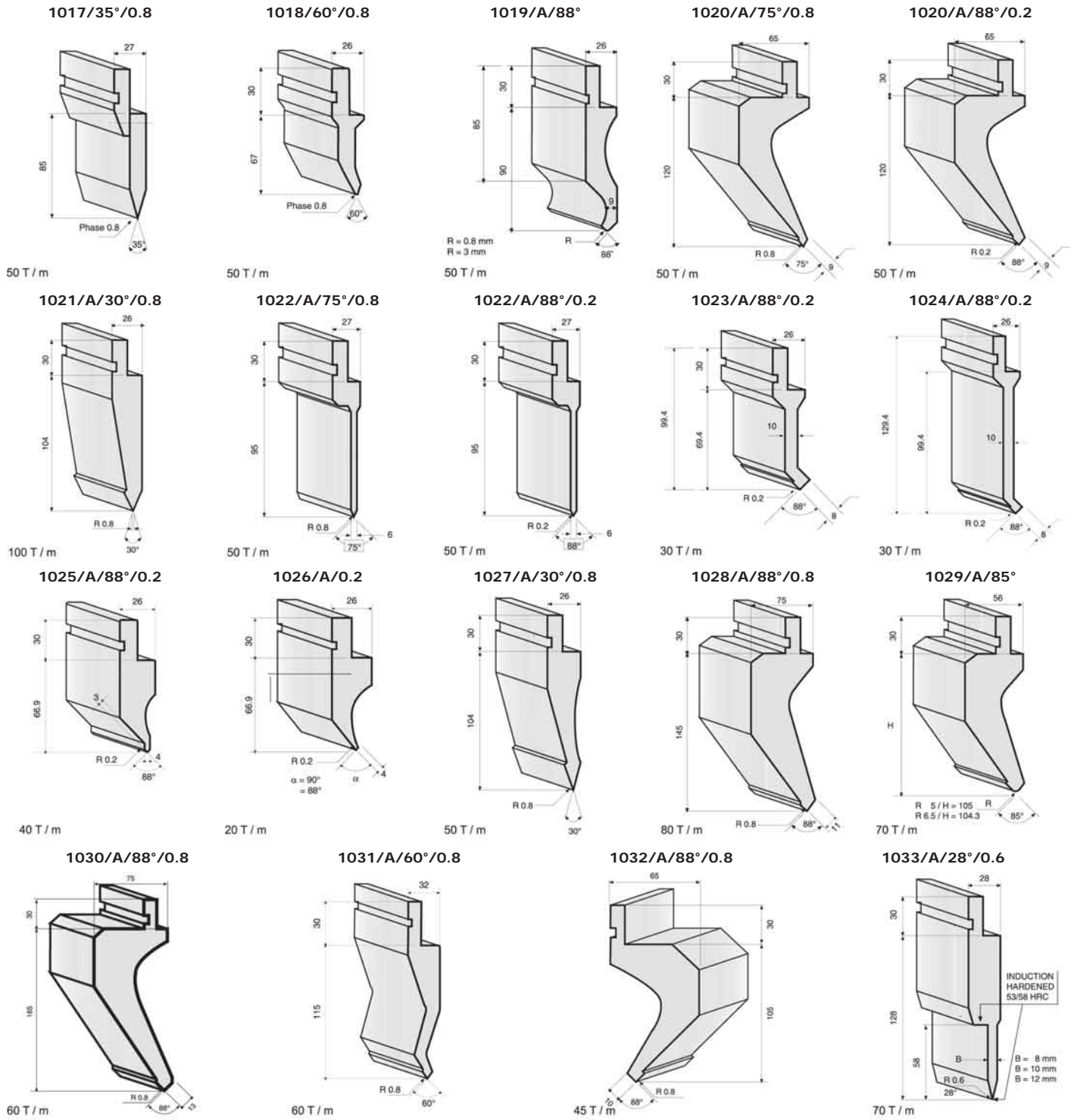


50 T / m

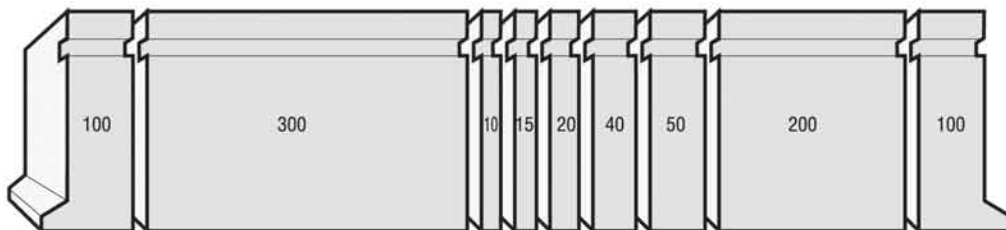
1017/A/30°/0.8/W



40 T / m



SECTIONS



**4003**

100 T / m

**4004**

100 T / m

**4005**

100 T / m

**4002**

100 T / m

**4009R**

100 T / m

**1034/A/85°/2**

90 T / m

**1035/A/85°/1.25**

90 T / m

**1036/A/60°/0.8**

70 T / m

**1037/A/60°/2**

100 T / m

**1038/A/26°/0.8**

100 T / m

**1039/A/26°/1.5**

100 T / m

**3006**

100 T / m

**3007**

3007 Z (mm)	3007 Z (mm)
160 <sub>i</sub>	1.0
160 <sub>i</sub>	1.5
150 <sub>i</sub>	2.0
140 <sub>i</sub>	2.5
90 <sub>i</sub>	3.0
90 <sub>i</sub>	3.5
90 <sub>i</sub>	4.0
90 <sub>i</sub>	4.5
90 <sub>i</sub>	5.0
90 <sub>i</sub>	5.5
90 <sub>i</sub>	6.0
90 <sub>i</sub>	6.5
90 <sub>i</sub>	7.0
90 <sub>i</sub>	7.5
90 <sub>i</sub>	8.0

30 T / m

**2008**

100 T / m

**2009**

100 T / m

**2009/60°**

80 T / m

**2009 SPEC**

30 T / m

**2011/A/18/30°**

80 T / m

**2011/A/32/45°**

40 T / m

**2011/32/85°**

100 T / m

**2011/40/45°**

100 T / m

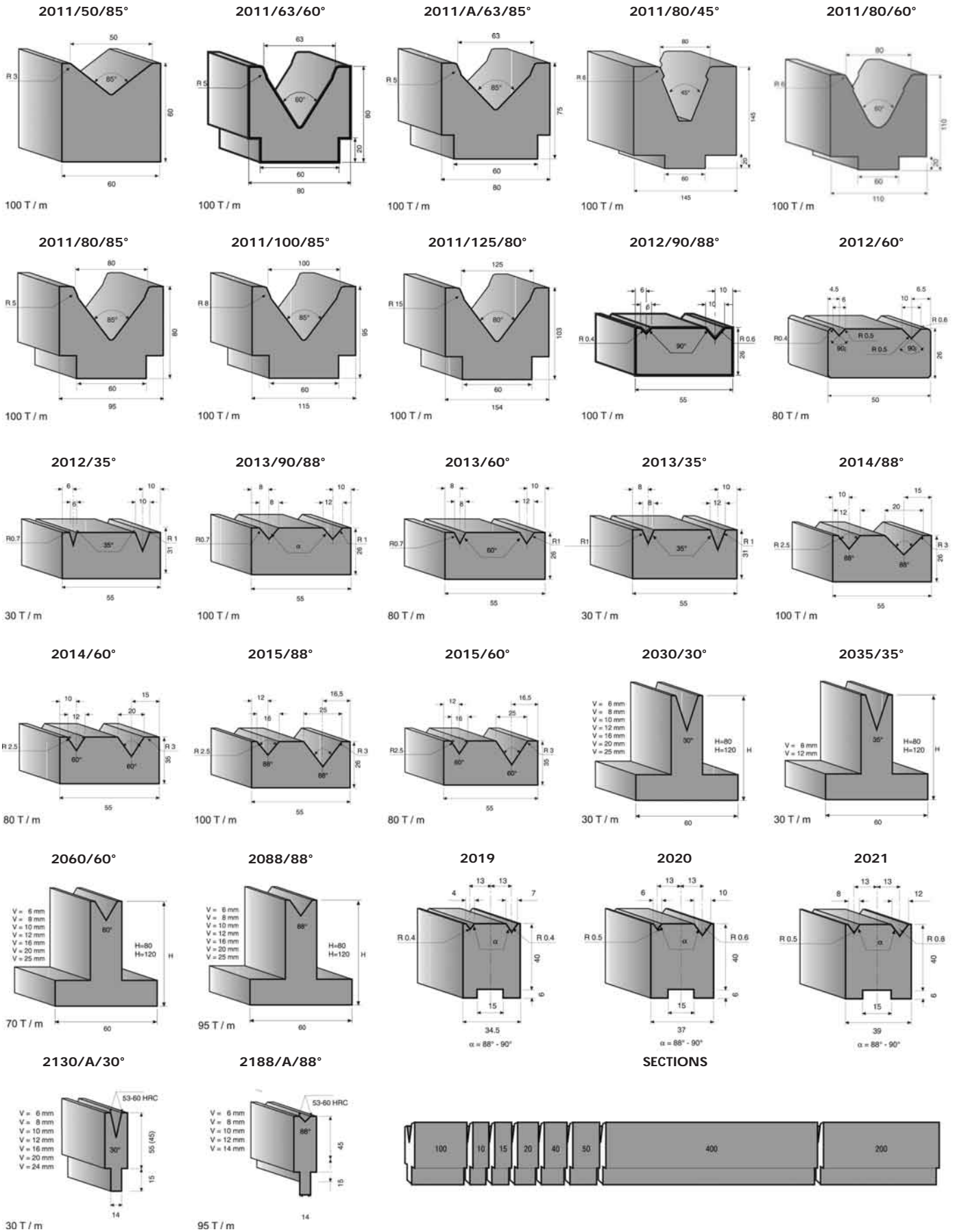
**2011/40/85°**

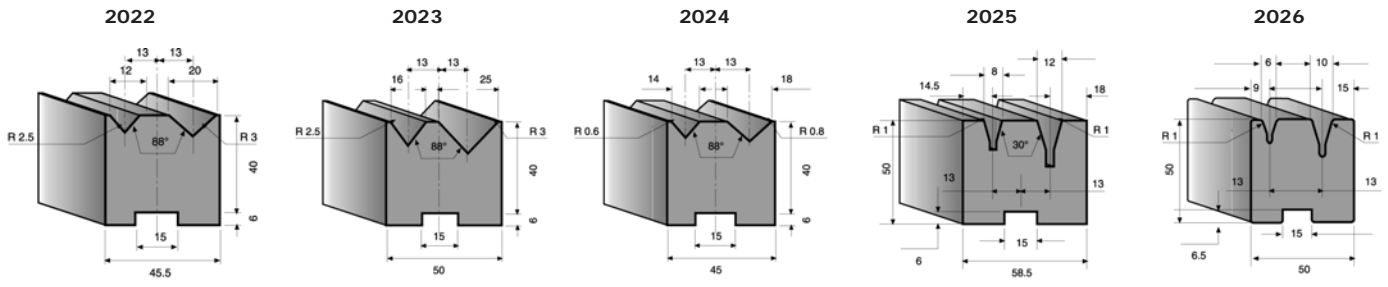
100 T / m

**2011/50/45°**

100 T / m

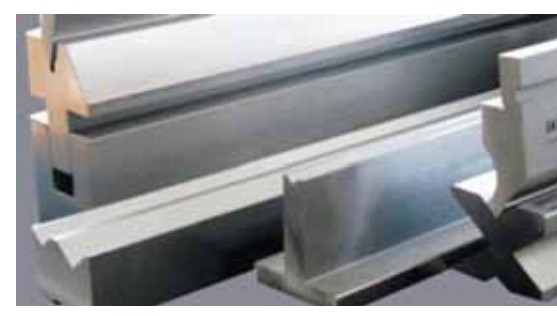
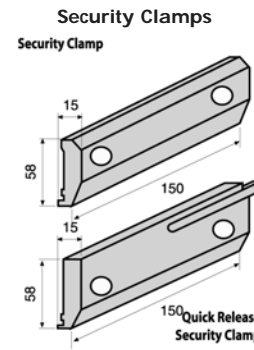
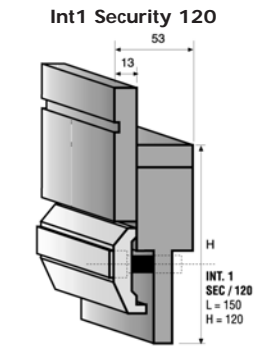
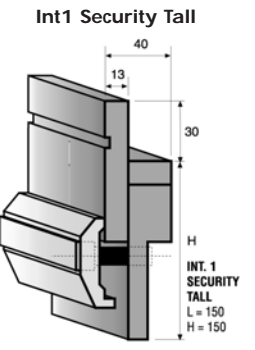
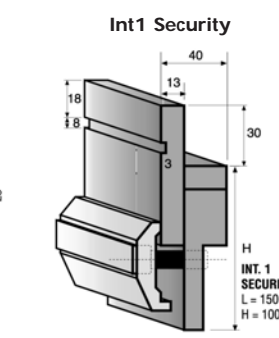
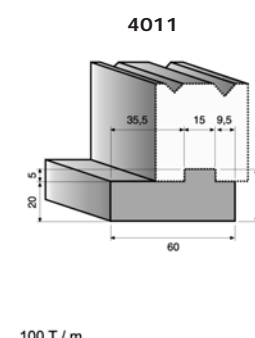
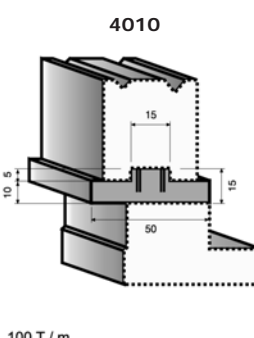
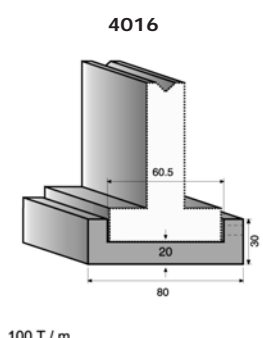
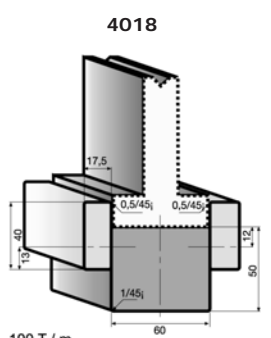
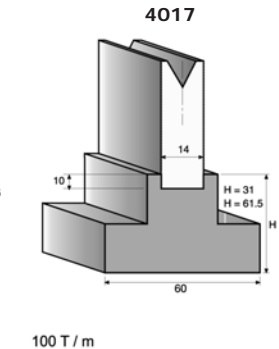
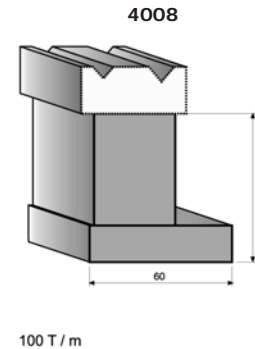
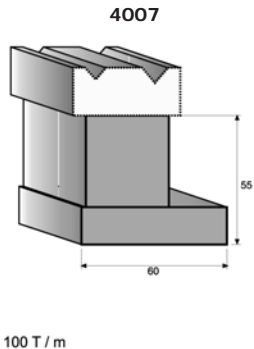
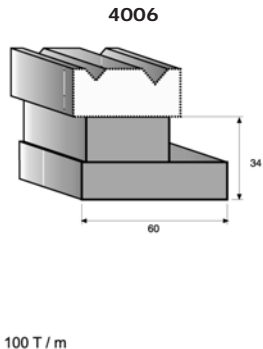
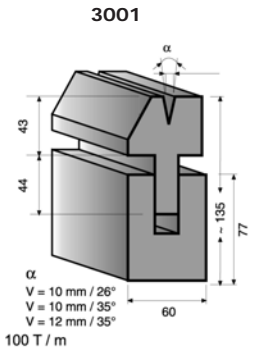
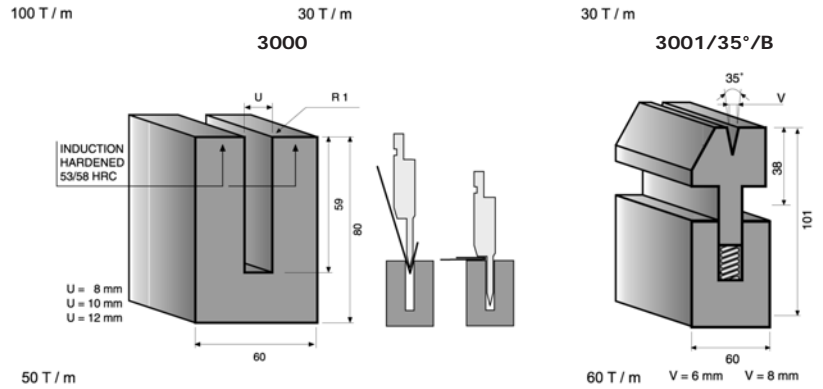
# EUROSPEC PRESSBRAKE TOOLING





100 T / m  
**BENDING CHART\***  
 Acc.R.45 Kg/mm<sup>2</sup>

S mm	A mm	Ton/M	2xS	Ton/M
0,6	3	9	1,2	23
0,8	3	12	1,6	32
1	3,5	15	2	40
1,25	3,5	17	2,5	50
1,5	4,6	22	3	63
2	5,5	30	4	80
2,5	6,5	55	5	90
3	8	70	6	100



# ROBOCUT KZ300 CNC PLASMA CUTTING SYSTEM

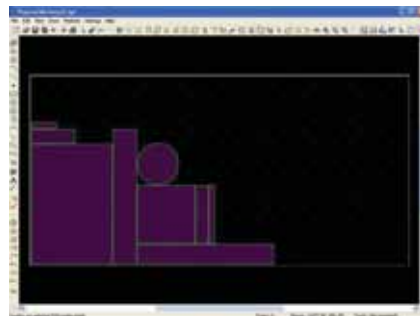
Sheetmetal & Plateworking

MODEL KZ300  
STOCK CODE 16700



The ROBOCUT KZ300 is a powerful and accurate CNC Plasma cutting system. Versatile and easy to use, the KZ300 features a large cutting table of 3.0 x 1.5 metres.

Depending on the Plasma Power Source supplied, the KZ300 has a maximum cutting capacity of 32mm in mild steel. The included DesignEdge Software designed exclusively for plasma cutting, quickly creates impressive designs. You can easily import and reproduce almost any shape from scanned images to computer fonts to common drawing programs. Traditional programming and processing steps have been eliminated and replaced with a graphic interface where you work directly with the images you want to cut.



## FEATURES

- 32mm Maximum Mild Steel Cutting Capacity
- Windows based CNC Design and Control Software for reading and converting CAD files, scanned pictures etc
- Unique Nesting Program for maximum material usage
- Digital Height Control for optimum cutting performance
- Comprehensive Video Manual

## BENEFITS

- Bring CNC Plasma cutting in-house
- Cut from 0.3mm – 32mm material
- Cut the parts you want when you want them
- Use the machine for hand plasma cutting also

The ACP Compact Air Plasma cutting machines have been especially designed for simple, accurate and fast cutting of sheet material up to 19mm. The ACP is equipped with the class leading Hypertherm Powermax 105 power source line utilising single gas technology of either air or nitrogen together with an easy to use operator friendly CNC controller. The result is a mechanised systems delivering high productivity, low operating cost, superior cut quality and unsurpassed reliability. The table size is 3000mm x 1500mm and is ideal for the HVAC, catering equipment and many other industries.

**FEATURES**

- Strong fabricated frame and bed
- Compact size
- Linear bearings fitted to the rails
- Advanced Hypertherm technology



MODEL ACP 1530/1650

**HYPERTHERM CUTTING TECHNOLOGY**



**OPTIONS**

- High definition Hypertherm HPR130 power source

**TECHNICAL SPECIFICATIONS**

MODEL	STOCK CODE	CUTTING WIDTH	CUTTING LENGTH	CUTTING THICKNESS PIERCE		CUTTING THICKNESS FROM EDGE		MACHINE WIDTH	MACHINE LENGTH	MACHINE WEIGHT
				MILD STEEL	STAINLESS STEEL	MILD STEEL	STAINLESS STEEL			
		mm	mm	mm	mm	mm	mm	mm	mm	kg
ACP 1530/1650	M8040	1500	3000	19	16	32	25	1950	3250	2200

The Morgan Rushworth range of Hyperformance High Definition XD CNC plasma machines offer virtually dross free cutting of profiles in mild steel, stainless steel and aluminium sheet and plate material. The XD TrueHole technology from Hypertherm represents one of the most advanced machines available with finish quality approaching that of laser machines. Additional plasma units can be fitted for simultaneous operation to further increase production times and if required oxygen torches can be specified to cut material thicknesses of up to 300mm.

The Hypertherm MicroEDGE CNC or EdgePRO CNC can accept drawings in DXF and DWG file format from a disk, CD, via the USB port or through an ethernet connection. Alternatively standard shapes that have been preloaded can be edited and dimensioned as required with the keypad control and visualised on the LCD screen.

Morgan Rushworth Plasma machines are available with table sizes of 1250mm x 2500mm up to 6000mm x 36000mm. All Morgan Rushworth plasma machines require an extraction/filtration system, which can be supplied as optional equipment, or connected to a new or existing factory ducted system.

**HDP PLASMA IN ACTION****HIGH EFFICIENCY HYPERTHERM TORCH**





# HDP HYPERFORMANCE HIGH DEFINITION XD CNC PLASMA CUTTING MACHINES

HDP PLASMA IN ACTION



CNC EDGE PRO CONTROL UNIT



CNC BEVELING TORCH



CNC CUTTING TUBE



HDP PLASMA MACHINE 3M X 12M



**FEATURES**

- HyPerformance High Definition plasma cutting technology
- **NEW** advanced XD technology with patented LongLife<sup>®</sup>, PowerPierce<sup>®</sup> and with optional equipment TrueHole<sup>™</sup> capability
- Superior consistent quality dross free finish without the requirement for secondary operation
- Maximised productivity
- Minimised operating costs
- Unmatched reliability
- Electrical current and gas pressure applied in a gradual controlled manner at the beginning and at the end of the cut resulting in an increase of seamable life of six to eight times greater than comparable traditional systems
- High efficiency Hypertherm plasma unit and windows based MicroEDGE CNC controller to ensure perfect operational harmony
- 180mm touch screen LCD display
- Large range of standard table sizes up to a huge 6m x 36M, with special sizes available on request
- Strong steel frame designed to withstand constant high speed production
- X and Y axis travel on precision linear guide rails
- Fast positioning with Siemens brushless AC servo motor
- Positioning accuracy to 0.01mm
- Hypertherm plasma units available in four capacities - HPR130, HPR260, HPR400 and HPR800
- Automatic torch ignition and height control
- Arc voltage feedback to control optimum torch height position
- Mechanical and electronic collision avoidance system
- Marking and cutting of material performed with the same plasma torch
- Fume extraction system beneath the table with exhaust connection at rear of machine that can be connected to factory extraction system or to optional filtration unit

**OPTIONS**

- Additional plasma torches
- Oxygen torch for large capacity cutting
- High efficiency filtration unit
- Automatic gas console
- Auto nesting software to calculate maximum use of material to reduce wastage

CNC MICROEDGE CONTROL UNIT



HYPERTHERM HYPERFORMANCE PLASMA UNIT



OPTIONAL EXTRACTION/FILTRATION UNIT



**TECHNICAL SPECIFICATIONS**

MODEL	STOCK CODE	CUTTING WIDTH	CUTTING LENGTH	CUTTING THICKNESS PIERCE		CUTTING THICKNESS FROM EDGE		CUTTING THICKNESS (OPT)-OXY with table	CUTTING THICKNESS (OPT)-OXY without table	MACHINE WIDTH	MACHINE LENGTH
				MILD STEEL	STAINLESS STEEL	MILD STEEL	STAINLESS STEEL				
		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
HDP 1225/130	M8000	1250	2500	32	20	38	25	200	300	2750	4000
HDP 1225/260	M8001	1250	2500	38	32	64	50	200	300	2750	4000
HDP 1530/130	M8002	1500	3000	32	20	38	25	200	300	3000	4500
HDP 1530/260	M8003	1500	3000	38	32	64	50	200	300	3000	4500
HDP 2040/130	M8004	2000	4000	32	20	38	25	200	300	3500	5500
HDP 2040/260	M8005	2000	4000	38	32	64	50	200	300	3500	5500
HDP 2060/130	M8006	2000	6000	32	20	38	25	200	300	3500	7500
HDP 2060/260	M8007	2000	6000	38	32	64	50	200	300	3500	7500
HDP 2080/130	M8008	2000	8000	32	20	38	25	200	300	3500	9500
HDP 2080/260	M8009	2000	8000	38	32	64	50	200	300	3500	9500
HDP 3060/130	M8010	3000	6000	32	20	38	25	200	300	4500	7500
HDP 3060/260	M8011	3000	6000	38	32	64	50	200	300	4500	7500
HDP 3080/130	M8012	3000	8000	32	20	38	25	200	300	4500	9500
HDP 3080/260	M8013	3000	8000	38	32	64	50	200	300	4500	9500
HDP 3012/130	M8014	3000	12000	32	20	38	25	200	300	4500	13500
HDP 3012/260	M8015	3000	12000	38	32	64	50	200	300	4500	13500
HDP 3018/130	M8016	3000	18000	32	20	38	25	200	300	4500	19500
HDP 3018/260	M8017	3000	18000	38	32	64	50	200	300	4500	19500
HDP 3024/130	M8018	3000	24000	32	20	38	25	200	300	4500	25500
HDP 3024/260	M8019	3000	24000	38	32	64	50	200	300	4500	25500
HDP 4060/130	M8020	4000	6000	32	20	38	25	200	300	5500	7500
HDP 4060/260	M8021	4000	6000	38	32	64	50	200	300	5500	7500
HDP 4012/130	M8022	4000	12000	32	20	38	25	200	300	5500	13500
HDP 4012/260	M8023	4000	12000	38	32	64	50	200	300	5500	13500
HDP 6012/130	M8024	6000	12000	32	20	38	25	200	300	7500	13500
HDP 6012/160	M8025	6000	12000	38	32	64	50	200	300	7500	13500
HDP 6024/130	M8026	6000	24000	32	20	38	25	200	300	7500	25500
HDP 6024/260	M8027	6000	24000	38	32	64	50	200	300	7500	25500
HDP 6036/130	M8028	6000	36000	32	20	38	25	200	300	7500	37500
HDP 6036/260	M8029	6000	36000	38	32	64	50	200	300	7500	37500

### ROLL FORMER

MODEL RF 5/1.0  
STOCK CODE M7000

MODEL RF 7/1.6  
STOCK CODE M7001



The Morgan Rushworth RF range of heavy duty Rollforming and flanging machinery are designed to join straight or curved sheet metal material. A full range of tooling is available to achieve the various connection methods required, including the ingenious snap lock system for valuable time saving right angle joins.

### SNAP LOCK FORMER

MODEL RFS 9/1.0  
STOCK CODE M7004



### ROLL FORMER & FLANGER

MODEL RFF 5/1.0  
STOCK CODE M7002

MODEL RFF 7/1.6  
STOCK CODE M7003



## CAPACITIES

Model				RF 5/1.0	RF 7/1.6	RFF 5/1.0	RFF 7/1.6	RFS 9/1.0	RFL 1.6	RFLS 1.0
Roll A	-	Pittsburg Lock	STD	mm	0.5-1.0	0.5-1.6	0.5-1.0	0.5-1.6	-	-
Roll B	-	Double Seam	OPT	mm	0.5-1.0	0.5-1.2	0.5-1.0	0.5-1.6	-	-
Roll C	-	Flat Drive Cleat	OPT	mm	0.5-1.0	0.5-1.0	0.5-1.0	0.5-1.0	-	-
Roll D	-	Right Angle Flange	OPT	mm	0.5-1.0	0.5-1.2	0.8-1.2	0.5-1.2	-	-
Roll E	-	Plain Seam	OPT	mm	-	0.5-1.0	-	0.5-1.2	-	-
Roll F	-	Standing Seam	OPT	mm	-	0.5-1.0	-	0.5-1.2	-	-
Roll G	-	Pittsburg Snap Lock	STD	mm	-	-	-	0.5-1.0	-	-
Roll H	-	Crimped Flange	STD	mm	-	-	-	0.5-1.0	-	-
Type J	-	Flange Form	STD	mm	-	-	0.5-1.0	0.5-1.6	-	0.5-1.6
Type K	-	Crimp to Flange	STD	mm	-	-	-	-	-	0.5-1.0

## TECHNICAL SPECIFICATIONS

Model				RF 5/1.0	RF 7/1.6	RFF 5/1.0	RFF 7/1.6	RFS 9/1.0	RFL 1.6	RFLS 1.0
No. of stations				5	7	5	7	9	-	-
Forming speed	m/min			6	5	6	5	6	3	3
Motor	kw			0.75	1.5	0.75	1.5	1.5	0.75	0.75
Length	mm			1065	1460	1065	1460	1650	610	1000
Width	mm			510	620	510	620	620	610	660
Height	mm			940	990	1070	1130	1020	1020	1020
Weight	kg			105	250	135	280	290	105	130

**FLANGER**

MODEL RFL 1.6  
STOCK CODE M7005



**FEATURES**

**RF**

- Type A Pittsburgh rolls fitted as standard
- Fast straight forming in one pass
- Available in 1.0mm and 1.6mm capacities
- Auxiliary drive shafts fitted to accept optional rolls

**RFF**

- As RF but with the useful feature of a flanging unit, forming roll type J, fitted to the top of the machine in order to perform radius joins

**RFS**

- Type G rolls fitted as standard to perform Pittsburgh style profile but with return leg to accept type H flange
- Type H rolls fitted as standard to perform a right angle flange which is crimped to snap into type G profile to produce a virtually unbreakable joint
- No exposed sharp edges after join completed
- Fast straight forming in one pass

**RFL**

- Produces type J right angle flange for curved material
- 1.6mm capacity

**RFLS**

- Twin station flanging capability
- First station produces type J right angle flange for curved material
- Second station produce type K crimp to the flange, to allow the material to snap into type G profile for curved applications

**FORMING ROLLS**

Roll A - Pittsburgh lock



Roll B - Double seam



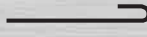
Roll C - Flat drive cleat



Roll D - Right angle flange



Roll - Plain seam



Roll - Standing seam



Roll G - Pittsburgh snap lock



Roll H - Crimped flange



Type J - Flange



Type K - Crimp to flange



FLANGER & SNAP LOCK

MODEL RFLS 1.0  
STOCK CODE M7006





The Morgan Rushworth range of MS, PS and HPS swaging machines are available in manual, powered and hydraulic variants. Swaging machines are designed to form various shapes to sheet material and are particularly suited for tubular ductwork applications. Easily interchangeable rolls are included as standard equipment to form the specific shape required. The PSC pneumatic seam closer is designed to close a double seam joint, with a professional uniform finish. The motorised top roll is pneumatically lowered onto the material and raised at the completion of the closed seam.

MODEL PS 250/1.25  
STOCK CODE M7009

MODEL PS 260/2.5  
STOCK CODE M7010

MODEL PS 260/4.0  
STOCK CODE M7011



**TECHNICAL SPECIFICATION**

Model		MS 250/1.25	PS 250/1.25	PS 260/2.5	PS 260/4.0	HPS 260/4.0
Thickness	mm	1.25	1.25	2.5	4	4
Roll Distance	mm	62	62	92	132	132
Roll Body Distance	mm	250	250	260	260	260
Motor Power	kw	-	0.7	1.5	2.2	2.2 + 0.75
Length	mm	600	700	1200	1500	1600
Width	mm	550	600	700	800	900
Height	mm	350	1300	1200	1200	1200
Weight	kg	50	170	295	350	450



MODEL HPS 260/4.0  
STOCK CODE M7012

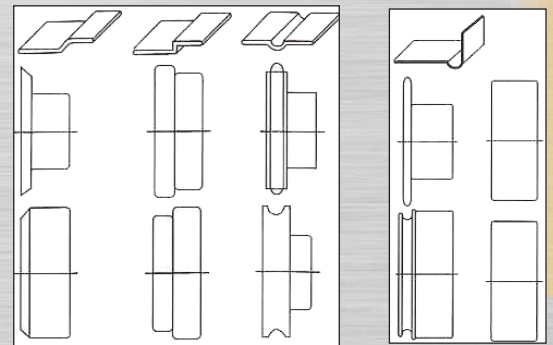
TOP WHEEL WITH  
PNEUMATIC ADJUSTMENT



MODEL PSC 1320/1.2  
STOCK CODE M7014



**FORMING ROLLS**



Standard forming rolls for all models

Additional forming rolls for models MS 125 and PS 125

**FEATURES**

- Steel welded frame
- Adjustable idler roll
- Adjustable end stop
- Reduction motor with brake - PS and HPS
- Hydraulic top roll adjustment - HPS 400
- 3 sets of standard rolls - PS 250, PS 400 and HPS 400
- 5 sets of standard rolls - MS 125 and PS 125
- Optional special rolls available

**MODEL PSC**

- Fast closing of seams
- Professional finish
- Pneumatically operated top roll
- Adjustable operating pressure

**TECHNICAL SPECIFICATION**

Model	PSC 1320/1.2	
Thickness	mm	1.2
Max working length	mm	1320
Min tube diameter	mm	140
Max tube diameter	mm	1000
Working pressure	bar	8
Motor	kw	0.37
Length	mm	1800
Width	mm	900
Height	mm	1650
Weight	kg	300



Denmore Place,  
Denmore Industrial Estate,  
Bridge of Don,  
Aberdeen AB23 8JS

**Tel** +44 (0) 1224 709000

**Fax** +44 (0) 1224 709754

**Email** [sales@rsmachinery.co.uk](mailto:sales@rsmachinery.co.uk)

**Visit** [www.rsmachinery.co.uk](http://www.rsmachinery.co.uk)

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