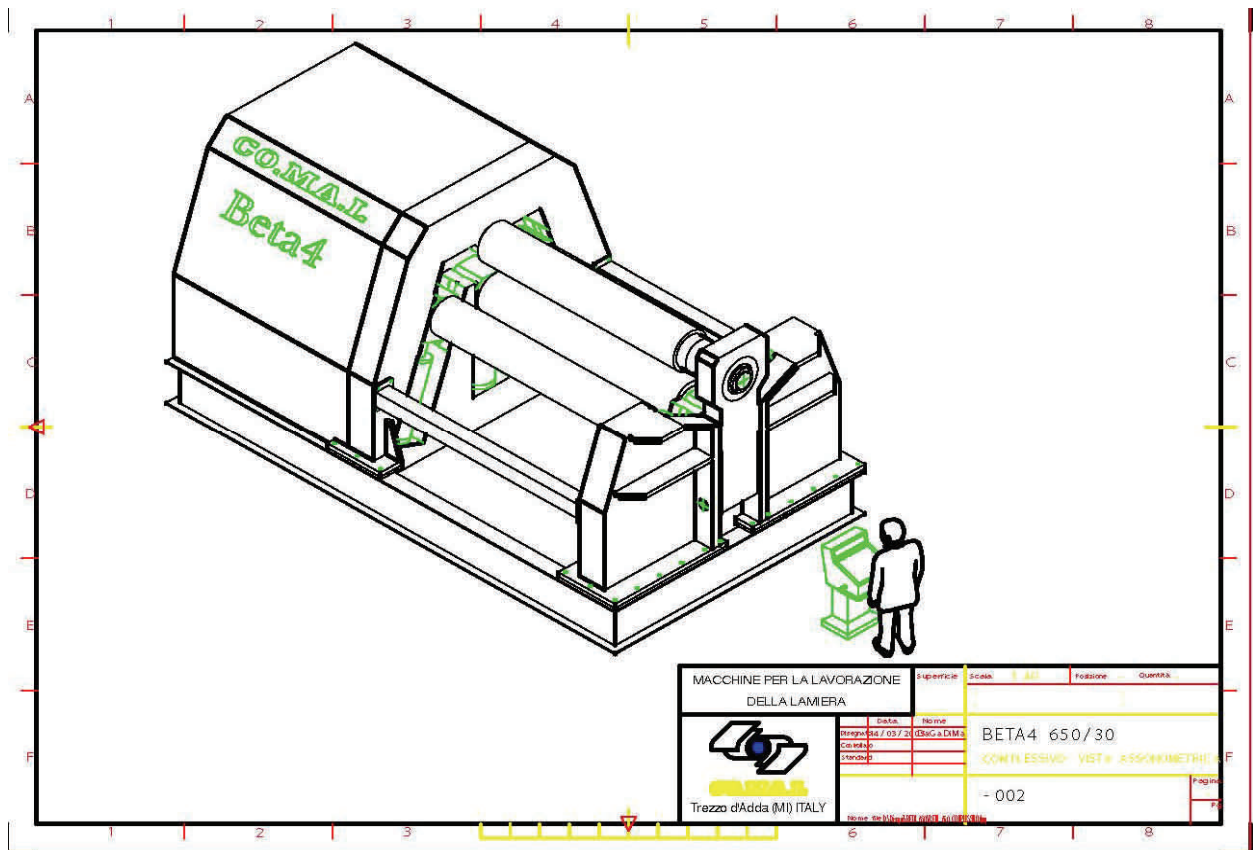


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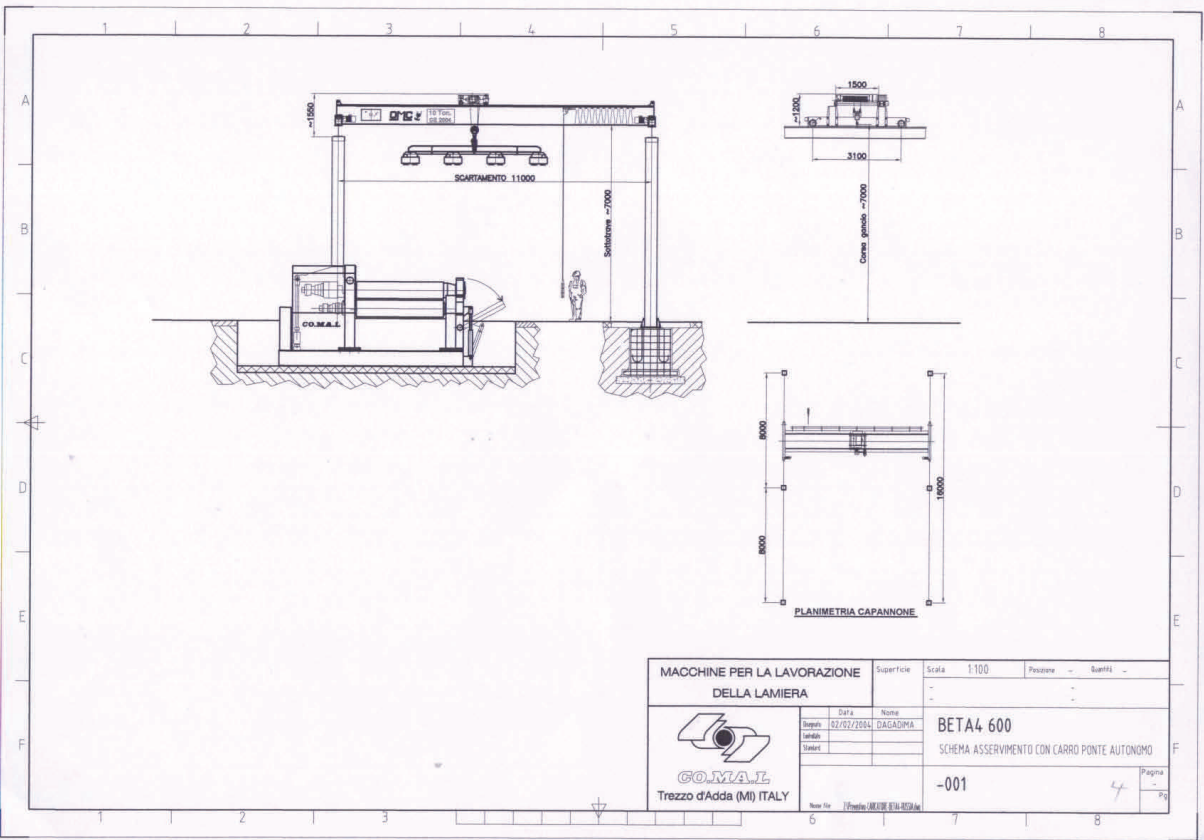
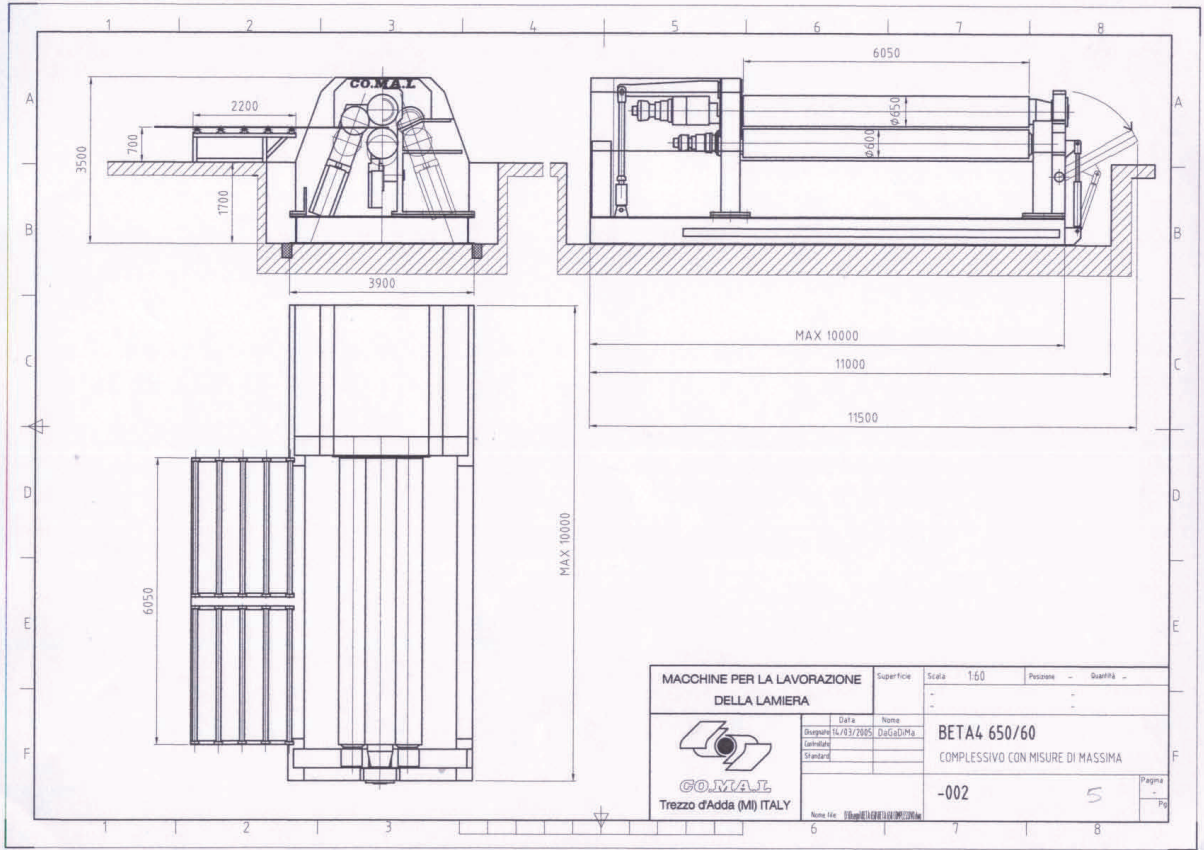
Italian Technology at its best
Designers and builders of quality metal fabrication equipment



Beta 4—Under construction

Beta 4 *Super Heavy Duty*

*Double Pinch Four Roll
Hydraulic Plate Bending
Machines/ Rectilinear slides*



Machine Standard Features:

- **Frame built of laser cut high strength steel, welded, stress relieved and sand blasted.**
- **All UL listed GE electrical components or equivalent installed in a UL listed NEMA 12 equivalent electrical cabinet with master breaker**
- **Hardened rolls to HRC 54-56**
- **Hydraulic unit by Rexroth and valves by Aron**
- **Top and pinching rolls are powered individually with hydraulic motor/ epicyclic gear reducer sets.**
- **Hydraulic drop-end**
- **Automatic rolls parallelism by a micro processor**
- **Tilting of the bending rolls by means of proportional valves and PLC**
- **Top roll hydraulic balancing system**
- **Bending rolls assembled on heavy duty SKF bearings**
- **Centralized lubrication by means of a hand pump**
- **Cone bending device**
- **Tilting of bending roll directly from controls console**
- **Separate controls console on wheels**
- **Four digital readouts (two for each bending roll)**
- **Safety devices and operating manual according to CE norms**

Optional Features and Equipment

- Polished, ground or chrome plated rolls
- Quick-change interchangeable top roll
- Powered bending rolls each with its individual hydraulic motor/ epicyclic gear reducer
- Variable speed
- NC and CNC options
- Vertical hydraulic support max. \varnothing 2500 mm/ 98" & max. weight 1600 Kg/ 3530 lbs
- Vertical hydraulic support max. \varnothing 3600 mm/ 141" & max. weight 2200 Kg/ 4850 lbs
- Vertical hydraulic support max. \varnothing 4300 mm/ 170" & max. weight 5000 Kg/ 10000 lbs
- Hydraulic side-support Max. 1500 Kg/ 3310 lbs
- Hydraulic side-support Max. 3000 Kg/ 6615 lbs
- Hydraulic side-support Max. 4200 Kg/ 9262 lbs



SPECIFICATIONS— Beta 4

RATED AT 50,000 PSI or 350 N/mm² MATERIAL YIELD STRENGTH AND ROLLING AT FULL USEFUL LENGTH

MODEL	THICKNESS CAPACITY WHEN ROLLED PART DIAMETER IS:				USEFUL ROLL LENGTH	TOP & PINCH ROLLS Øs (TR)	BENDING ROLLS Øs (BR)	MACHINE WORKING HEIGHT	MACHINE DIMENSIONS & WEIGHT			POWER	
	1,4xTR	3xTR	5xTR	10xTR					LENGTH	WIDTH	HEIGHT		WEIGHT
B4/480/21	34mm 1.338"	45mm 1.771"	49mm 1.929"	53mm 2.086"	2100mm 82"	480mm 18.898"	440mm 18.898"	1850mm 73"	5900mm 232"	2900mm 114"	2800mm 110"	29000Kg 63945 lbs	30Kw 40HP
B4/480/26	28mm 1.102"	36mm 1.417"	39mm 1.535"	42mm 1.653"	2600mm 102"	480mm 18.898"	440mm 18.898"	1850mm 73"	6400mm 252"	2900mm 114"	2800mm 110"	32500Kg 71665 lbs	30Kw 40HP
B4/480/31	25mm 0.984"	32mm 1.259"	35mm 1.377"	37mm 1.456"	3100mm 122"	480mm 18.898"	440mm 18.898"	1850mm 73"	6900mm 272"	2900mm 114"	2800mm 110"	36500Kg 80485 lbs	30Kw 40HP
B4/480/41	19mm 0.748"	25mm 0.984"	27mm 1.062"	29mm 1.141"	4100mm 161"	480mm 18.898"	440mm 18.898"	1850mm 73"	7900mm 311"	2900mm 114"	2800mm 110"	44800Kg 98785 lbs	30Kw 40HP
	1,4xTR	3xTR	5xTR	10xTR									
B4/550/21	42mm 1.653"	55mm 2.165"	60mm 2.362"	65mm 2.559"	2100mm 82"	550mm 21.654"	500mm 21.654"	1950mm 77"	6200mm 244"	3100mm 122"	3000mm 118"	38500Kg 84895 lbs	37Kw 50HP
B4/550/26	34mm 1.338"	45mm 1.771"	48mm 1.889"	46mm 2.047"	2600mm 102"	550mm 21.654"	500mm 21.654"	1950mm 77"	6700mm 264"	3100mm 122"	3000mm 118"	42800Kg 94375 lbs	37Kw 50HP
B4/550/31	28mm 1.102"	37mm 1.456"	40mm 1.574"	43mm 1.692"	3100mm 122"	550mm 21.654"	500mm 21.654"	1950mm 77"	7200mm 283"	3100mm 122"	3000mm 118"	47800Kg 105400 lbs	37Kw 50HP
B4/550/41	22mm 0.866"	28mm 1.102"	30mm 1.181"	33mm 1.299"	4100mm 161"	550mm 21.654"	500mm 21.654"	1950mm 77"	7700mm 303"	3100mm 122"	3000mm 118"	57200Kg 126130 lbs	37Kw 50HP
	1,4xTR	3xTR	5xTR	10xTR									
B4/640/21	52mm 2.047"	66mm 2.598"	72mm 2.834"	77mm 3.031"	2100mm 82"	640mm 25.197"	590mm 25.197"	2150mm 85"	6500mm 256"	3700mm 146"	3500mm 138"	49800Kg 109810 lbs	75Kw 100HP
B4/640/26	42mm 1.653"	54mm 2.125"	59mm 2.322"	63mm 2.480"	2600mm 102"	640mm 25.197"	590mm 25.197"	2150mm 85"	7000mm 276"	3700mm 146"	3500mm 138"	55800Kg 123040 lbs	75Kw 100HP
B4/640/31	35mm 1.377"	45mm 1.771"	49mm 1.929"	52mm 2.047"	3100mm 122"	640mm 25.197"	590mm 25.197"	2150mm 85"	7500mm 295"	3700mm 146"	3500mm 138"	62200Kg 137155 lbs	75Kw 100HP
B4/640/41	29mm 1.141"	37mm 1.456"	40mm 1.574"	43mm 1.692"	4100mm 161"	640mm 25.197"	590mm 25.197"	2150mm 85"	8000mm 315"	3700mm 146"	3500mm 138"	74400Kg 164055 lbs	75Kw 100HP

SPECIFICATIONS— *Beta 4 (cont'd)*

RATED AT 50,000 PSI or 350 N/mm² MATERIAL YIELD STRENGTH AND ROLLING AT FULL USEFUL LENGTH

MODEL	THICKNESS CAPACITY WHEN ROLLED PART DIAMETER IS:			USEFUL ROLL LENGTH	TOP & PINCH ROLLS Øs (TR)	BENDING ROLLS Øs (BR)	MACHINE WORKING HEIGHT	MACHINE DIMENSIONS & WEIGHT					
	1,4xTR	3xTR	5xTR					10xTR	LENGTH	WIDTH	HEIGHT	WEIGHT	POWER
B4/750/21	64mm 2.519"	85mm 3.346"	90mm 3.543"	96mm 3.779"	2100mm 82"	750mm 29.528"	700mm 29.528"	2650mm 104"	7000mm 276"	4100mm 161"	4000mm 157"	71000Kg 156555 lbs	90Kw 120HP
B4/750/26	54mm 2.125"	68mm 2.677"	75mm 2.952"	78mm 3.070"	2600mm 102"	750mm 29.528"	700mm 29.528"	2650mm 104"	7500mm 295"	4100mm 161"	4000mm 157"	81200Kg 179050 lbs	90Kw 120HP
B4/750/31	45mm 1.771"	57mm 2.244"	63mm 2.480"	68mm 2.677"	3100mm 122"	750mm 29.528"	700mm 29.528"	2650mm 104"	8000mm 315"	4100mm 161"	4000mm 157"	92000Kg 202860 lbs	90Kw 120HP
B4/750/41	32mm 1.259"	40mm 1.574"	43mm 1.692"	46mm 1.811"	4100mm 161"	750mm 29.528"	700mm 29.528"	2650mm 104"	9000mm 354"	4100mm 161"	4000mm 157"	112000Kg 246690 lbs	90Kw 120HP

Note: A roll, which is supported from both ends, will experience deflection from its centerline throughout its length when any force is applied to it anywhere between the supports. Since it is imperative for the rolls to make full contact with the work-piece during forming to avoid deformation of the cylinder rolled, a method was devised to compensate for the deflection by cambering the rolls. The camber, within a certain range of thickness, will compensate for the undesirable deflection. Beyond that, "cheating of the rolls is required by shimming the plate with cardboard or thin stock to avoid rolling concave or convex cylinders, in our industry's terms "Hour glass" and "Barrel" effects.

SPECIFICATIONS— *Beta 4*

RATED AT 36,000 PSI or 250 N/mm² MATERIAL YIELD STRENGTH AND ROLLING AT FULL USEFUL LENGTH

MODEL	THICKNESS CAPACITY WHEN ROLLED PART DIAMETER IS:				USEFUL ROLL LENGTH	TOP & PINCH ROLLS Øs (TR)	BENDING ROLLS Øs (BR)	MACHINE WORKING HEIGHT	MACHINE DIMENSIONS & WEIGHT			POWER	
	1,4xTR	3xTR	5xTR	10xTR					LENGTH	WIDTH	HEIGHT		
	LENGTH	LENGTH	LENGTH	LENGTH									
B4/480/21	41mm 1.614"	53mm 2.086"	57mm 2.244"	62mm 2.440"	2100mm 82"	480mm 18.898"	440mm 18.898"	1850mm 73"	5900mm 232"	2900mm 114"	2800mm 110"	29000Kg 63945 lbs	30Kw 40HP
B4/480/26	33mm 1.299"	43mm 1.692"	46mm 1.811"	49mm 1.929"	2600mm 102"	480mm 18.898"	440mm 18.898"	1850mm 73"	6400mm 252"	2900mm 114"	2800mm 110"	32500Kg 71665 lbs	30Kw 40HP
B4/480/31	30mm 1.181"	38mm 1.496"	41mm 1.614"	44mm 1.732"	3100mm 122"	480mm 18.898"	440mm 18.898"	1850mm 73"	6900mm 272"	2900mm 114"	2800mm 110"	36500Kg 80485 lbs	30Kw 40HP
B4/480/41	22.5mm 0.885"	30mm 1.200"	32mm 1.279"	34mm 1.358"	4100mm 161"	480mm 18.898"	440mm 18.898"	1850mm 73"	7900mm 311"	2900mm 114"	2800mm 110"	44800Kg 98785 lbs	30Kw 40HP
	1,4xTR	3xTR	5xTR	10xTR									
B4/550/21	50mm 1.988"	64mm 2.539"	69mm 2.716"	74mm 2.913"	2100mm 82"	550mm 21.654"	500mm 21.654"	1950mm 77"	6200mm 244"	3100mm 122"	3000mm 118"	38500Kg 84895 lbs	37Kw 50HP
B4/550/26	42mm 1.653"	53mm 2.086"	56mm 2.204"	62mm 2.440"	2600mm 102"	550mm 21.654"	500mm 21.654"	1950mm 77"	6700mm 264"	3100mm 122"	3000mm 118"	42800Kg 94375 lbs	37Kw 50HP
B4/550/31	33mm 1.299"	43mm 1.692"	47mm 1.850"	50mm 1.968"	3100mm 122"	550mm 21.654"	500mm 21.654"	1950mm 77"	7200mm 283"	3100mm 122"	3000mm 118"	47800Kg 105400 lbs	37Kw 50HP
B4/550/41	25mm 0.984"	32mm 1.259"	34mm 1.338"	37mm 1.456"	4100mm 161"	550mm 21.654"	500mm 21.654"	1950mm 77"	7700mm 303"	3100mm 122"	3000mm 118"	57200Kg 126130 lbs	37Kw 50HP
	1,4xTR	3xTR	5xTR	10xTR									
B4/640/21	60mm 2.362"	76mm 2.992"	82mm 3.228"	87mm 3.307"	2100mm 82"	640mm 25.197"	590mm 25.197"	2150mm 85"	6500mm 256"	3700mm 146"	3500mm 138"	49800Kg 109810 lbs	75Kw 100HP
B4/640/26	50mm 1.968"	60mm 2.362"	64mm 2.520"	68mm 2.677"	2600mm 102"	640mm 25.197"	590mm 25.197"	2150mm 85"	7000mm 276"	3700mm 146"	3500mm 138"	55800Kg 123040 lbs	75Kw 100HP
B4/640/31	42mm 1.653"	54mm 2.125"	59mm 2.322"	64mm 2.519"	3100mm 122"	640mm 25.197"	590mm 25.197"	2150mm 85"	7500mm 295"	3700mm 146"	3500mm 138"	62200Kg 137155 lbs	75Kw 100HP
B4/640/41	34mm 1.338"	43mm 1.692"	46mm 1.811"	50mm 1.968"	4100mm 161"	640mm 25.197"	590mm 25.197"	2150mm 85"	8000mm 315"	3700mm 146"	3500mm 138"	74400Kg 164055 lbs	75Kw 100HP

SPECIFICATIONS— Beta 4 (cont'd)

**RATED AT 36,000 PSI or 250N /mm² MATERIAL YIELD STRENGTH
AND ROLLING AT FULL USEFUL LENGTH**

MODEL	THICKNESS CAPACITY WHEN ROLLED PART DIAMETER IS:				USEFUL ROLL LENGTH	TOP & PINCH ROLLS Øs (TR)	BENDING ROLLS Øs (BR)	MACHINE WORKING HEIGHT	MACHINE DIMENSIONS & WEIGHT			POWER	
	1,4xTR	3xTR	5xTR	10xTR					LENGTH	WIDTH	HEIGHT		WEIGHT
B4/750/21	75mm	96mm	103mm	110mm	210mm	750mm	700mm	2650mm	7000mm	4100mm	4000mm	71000Kg	90Kw
	2.952"	3.779"	4.055"	4.330"	82"	29.528"	29.528"	104"	276"	161"	157"	156555 lbs	120HP
B4/750/26	63mm	78mm	85mm	88mm	2600mm	750mm	700mm	2650mm	7500mm	4100mm	4000mm	81200Kg	90Kw
	2.480"	3.070"	3.346"	3.464"	102"	29.528"	29.528"	104"	295"	161"	157"	179050 lbs	120HP
B4/750/31	52mm	65mm	71mm	76mm	3100mm	750mm	700mm	2650mm	8000mm	4100mm	4000mm	92000Kg	90Kw
	2.047"	2.559"	2.795"	2.992"	122"	29.528"	29.528"	104"	315"	161"	157"	202860 lbs	120HP
B4/750/41	40mm	49mm	52mm	56mm	4100mm	750mm	700mm	2650mm	9000mm	4100mm	4000mm	112000Kg	90Kw
	1.574'	1.929"	2.047"	2.204"	161"	29.528"	29.528"	104"	354"	161"	157"	246690 lbs	120HP

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