

SECTION BENDING MACHINES

LEMAS



Design all models are built in 3 rolls pyramid double pinch design; fixed top roll with 2 adjustable side rolls. Equips with 3 direction adjustable guides rolls on both sides to work out the best products. The standard tooling is designed as a combination set for bending angles both leg-out and leg-in, flat bar on flat and on edge, T-bar stem-out and stem-in as well as stem-down, small square bar.

Quality machine frames are built with rugged H beam construction and welded with high quality steel then go through CNC machining and line boring. Main shafts are using high strength alloy steel SNCM439 and toolings are using high strength alloy steel SCM440 and all go through quenching and high frequency heat treatment as standard process. The shafts are journalled in oversized Japanese roller bearings.

Performance the machine equips a low speed piston hydraulic pump with SUMITOMO reducer to offer stable and the greatest drive torque for complete all job in just few passes. A unique function is free adjustable rolling speed for users to get the best and suitable rolling speed on different jobs. All 3 rolls are driven at all time and fully hydraulic powered adjustable 2 bottom rolls and 2 set of guide rolls provide the powerful performance on all section jobs.

Convenient the machine equips with 2 set of digital readouts for showing 2 side rolls position and easy to control the demand diameter. Vertical and horizontal combined design on LH-2RS/LH-3RS models is easy for bending small or big jobs.

MACHINE OVERVIEW



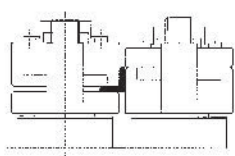
STANDARD EQUIPMENT

1. Drive on all three rolls
One hydraulic motor with gear system (LH-2RS to LH-5RS)
Two hydraulic motor with gear system (LH-6RS and larger models)
2. Automatic compensation for speed difference between rolls via adjustable slip clutch
3. Hydraulically operated bottom rolls
4. Hydraulically operated guide rolls
5. Digital readout for showing bottom rolls position
6. A set of standard universal tooling for bending Angle, Flat bar and T section
7. Portable control console with push buttons for all function

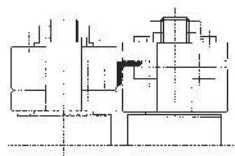
OPTIONAL EQUIPMENT

1. Special tooling for pipe/round bar. Each set of rolls can be designed for one or two different sizes of pipe/round bar.
2. Special tooling for square and rectangular tubing.
3. Combined rolls for I and U beams the easy way, adjustable for all different sizes covering the capacity of the machine.
4. Special tooling for H beam and work together with pulling assembly.
5. Special tooling for special sections and profiles are designed on request.

Standard Tooling



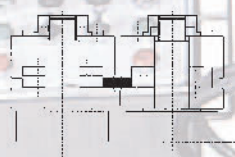
Angle leg-out. The guide rolls support the angle to avoid twist



T section stem-out.

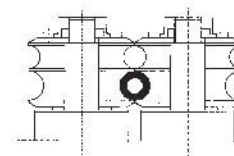


Flat bar on flat



Flat bar on edge

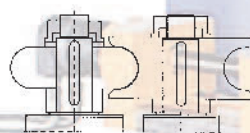
Angle leg-in. The guide rolls support the angle to avoid twist



tooling for Pipes or round bar



tooling for INP/UMP leg-in and leg-out in a combined set



tooling for half tube

TECHNICAL DATA

SETCION	● STANDARD ▲ SPECIAL	LH-2RS	LH-3RS	LH-4RS	LH-5RS	LH-6RS			
	●	50 x 50 x 6 Ø 600	75 x 75 x 9 Ø 800	100 x 100 x 12 Ø 1000	120 x 120 x 12 Ø 1250	150 x 150 x 15 Ø 1000	-	-	-
	●	50 x 50 x 6 Ø 650	75 x 75 x 9 Ø 1000	100 x 100 x 10 Ø 1000	100 x 100 x 12 Ø 1250	130 x 130 x 15 Ø 1200	-	-	-
	●	50 x 50 x 6 Ø 600	75 x 75 x 9 Ø 700	100 x 100 x 12 Ø 800	120 x 120 x 12 Ø 1250	150 x 150 x 15 Ø 1200	-	-	-
	●	50 x 50 x 6 Ø 750	75 x 75 x 9 Ø 1300	100 x 100 x 12 Ø 1500	100 x 100 x 12 Ø 1500	130 x 130 x 15 Ø 1700	-	-	-
	●	50 x 50 x 6 Ø 700	75 x 75 x 9 Ø 1000	100 x 100 x 13 Ø 1200	140 x 140 x 15 Ø 1250	150 x 150 x 15 Ø 1300	-	-	-
	●	70 x 15 Ø 500	80 x 18 Ø 800	100 x 25 Ø 700	120 x 25 Ø 1000	150 x 30 Ø 1000	-	-	-
	●	125 x 25 Ø 500	180 x 20 Ø 500	200 x 35 Ø 600	250 x 30 Ø 1000	250 x 40 Ø 1000	-	-	-
	●	40 x 40 Ø 500	50 x 50 Ø 500	60 x 60 Ø 600	70 x 70 Ø 800	90 x 90 Ø 1200	-	-	-
	▲	Ø 40 Ø 400	60 Ø 600	70 Ø 700	80 Ø 800	100 Ø 1000			
	▲	Ø 60 Ø 600	76 Ø 700	100 Ø 1100	142 Ø 1800	170 Ø 2000			
	▲	40 x 40 x 4	65 x 65 x 6	90 x 90 x 5	100 x 100 x 6.5	120 x 120 x 8			
	▲	100 Ø 600	140 Ø 600	160 Ø 800	200 Ø 900	300 Ø 1100			
	▲	-	-	120 Ø 800	140 Ø 900	180 Ø 1100			
	▲	-	-	100 Ø 800	120 Ø 900	160 Ø 1100			
	▲	-	140 x 60 Ø 600	160 x 65 Ø 800	200 x 75 Ø 900	300 x 100 Ø 1100			
	▲	-	140 x 60 Ø 800	160 x 65 Ø 1000	200 x 75 Ø 1000	300 x 100 Ø 1100			
	▲	-	65 x 42 Ø 4000	80 x 45 Ø 5000	100 x 50 Ø 8000	160 x 65 Ø 9000			
	▲	-	80 Ø 1200	100 Ø 1500	120 Ø 2500	160 Ø 3500			
	▲	-	-	-	-	140 Ø 6000			
Section, Modulus (cm ³)		7-14	18-25	30-40	45-50	95-100			
Power , (hp)		5	5	15	30	30			
Diameter of the Standard rolls, (mm)		220	275	310	400	500			
Shaft diameters top / lower, mm		70 70	85 85	105 105	140 140	180 180			
Weight, (kg)		1700	2000	4500	7000	8500			
L x W x H, (m)		1.7x1.2x1.8	1.9x1.2x1.8	2.9x1.9x2.0	4.3x2.5x3.0	5.0x2.7x3.3			

* We reserve the right to modify the specifications relating to any of the above machines without notice.

1. All data are valid for mild steel with yield point 270 N/mm².
2. Indicated diameters for angle, T, flat and square bars are valid for max. section in one or few passes.
3. Smaller sections can be bent to smaller diameters.
4. Square bar. smallest bending diameter depends on grade of deformation that can be accepted.
5. Machine with extended shafts allows wider sections than specified.
6. 2RS, 3RS, 4RS, combined horizontal/vertical design. 5RS and above models is only vertical design.

● STANDARD EQUIPMENT

1. STANDARD UNIVERSAL TOOLING
2. MOTOR & CONTROLS
3. REMOTE CONTROL PANEL
4. LED POSITION READOUTS
5. HYDRAULIC CONTROL SYSTEM

▲ SPECIAL EQUIPMENT

1. STEEL PIPE, ROUND BAR ROLLS
2. OTHER SECTION ROLLS

SECTION BENDING MACHINES



(in vertical)

LH-3RS



(in horizontal)

LH-6RS



LH-4RS



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