# Product guides and accessories

**ergo**
**Components**

## Guide bending machine
(manual)  Part. **550**

NEW

### Bending procedure

1. Determine the development of the curve L.

   L = R • K    R = curvature radius
   K = curvature coefficient

| Curvature angle (degrees) | 30° | 60° | 90° | 120° | 150° | 180° |
|---|---|---|---|---|---|---|
| Curvature coefficient K | 0,5 | 1 | 1,5 | 2 | 2,5 | 3 |

2. - Transfer the length L on the guide to be bent and mark the beginning of the curve (X), the end (Z) and the center line (Y) on.
   - Place the guide between the rollers.
   - Using the crank (M), move the sliding roller (1) in contact with the guide.
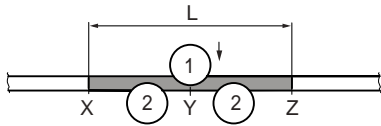


3. - Using the crank (M), adjust the movement of the roller (1) determining the increase in radius.
   - Using the crank (N), rotate the rollers (2) clockwise / anti clockwise, bringing the guide into position of Fig. A and Fig. B.
   To obtain the desired radius curve, a minimum number of steps is required (minimum two radius increments).
   In order to obtain a better fit between the curve and the straight section, it is recommended to go beyond the ends of the curve (points X and Z) by at least 20 mm.
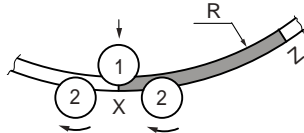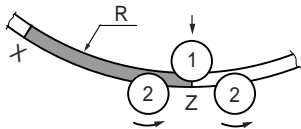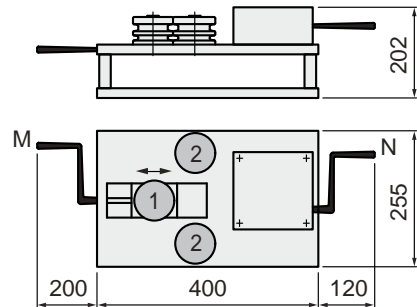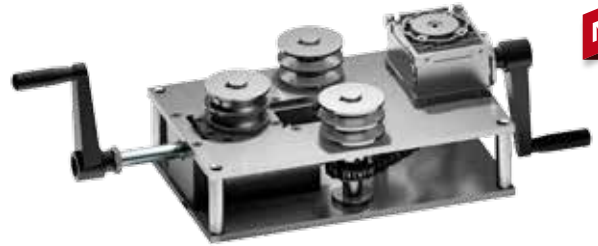
Fig.A



Fig.B





| Code | Weight (Kg) |
|---|---|
| 550 / 90466 | 23 |

**MATERIALS:** Steel and aluminium.
**FEATURES:** Manual functioning.
**BOX QUANTITY:** 1 machine.
**ACCESSORIES:** Bending rollers Part.547.
**FUNCTIONING:** The bending machine is made up of 3 roller shafts, operated manually by cranks.
The crank (M) regulates the movement of the roller (1), determining the increase in the radius of curvature.
The crank (N) activates the rotation of the rollers (2).
The simultaneous rotation of the handles (M) + (N) allows you to obtain the desired curve.

Bending rollers are supplied as accessories.
Each type of guide requires the use of its own bending rollers. The double groove rollers allow two guides of the same type to be bent simultaneously.

The bending machine allows you to create internal and external curves.



**Internal curve**    **External curve**

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