



FST

FABRICATION SOLUTIONS & TECHNOLOGIES

AN IMCAR® COMPANY



4RH

4 ROLL PLATE BENDING MACHINES



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4RH NC



TECHNICAL FEATURES

- Hydraulic 4 roll plate bending machine with double pre-bending
- Useful length from 3' to 20'
- Thickness from 1/8" up to 5"
- Fully hydraulic movement of rolls and drop end
- CNC machined main frame components
- Oversized hydraulic cylinders to reduce working pressure and ultimately increase machine longevity and overall durability
- No mechanical movements as found in planetary designs, therefore insuring maximum machine durability
- Linear guide design for maximum power and high quality pre-bending
- Two hydraulic motors with planetary reducers for rotation of lateral rolls
- Hardened rolls
- Industrial grade mobile control console on wheels
- Push buttons controls for parallel movement and rotation of rolls
- Hydraulic drop end operation from control desk
- Hydraulic parallelism of lateral and pinching rolls maintained by PLC and proportional valve system
- Hydraulic inclination of lateral rolls for conical bending direct from control desk through selector switches
- Adjustment of pinch by regulator and pressure gauge with easily adjustable outside switch located on the machine
- CNC controls for automatic production and repeatability



4RH NC TECHNICAL SPECIFICATIONS

4RH MODEL	Useful Length	Pre-bend Capacity			Rolling Capacity	Roll Diameters		HP	Overall Dimensions L x W x H	Weight (lbs.)
		1,2x	3x	5x		Central Roll	Lateral Rolls			
		Ø Top roll (Thickness in inches)								
6/3	6'	1/4	5/16	3/8	7/16"	8.66"	7.5"	7.50	142 x 54 x 48	9,950
8/3	6'	5/16	7/16	1/2	5/8"	9.5"	8.25"	7.50	142 x 56 x 50	11,250
10/3	6'	3/8	1/2	9/16	3/4"	10.6"	9.5"	10.00	154 x 63 x 61	15,500
12/3	6'	1/2	5/8	3/4	7/8"	11.8"	10.25"	14.75	162 x 69 x 61	22,100
15/3	6'	9/16	3/4	7/8	1"	12.6"	11"	21.00	162 x 71 x 63	23,600
17/3	6'	11/16	7/8	1	1-1/4"	14.2"	12.6"	25.00	170 x 79 x 75	29,800
6/4	8'	3/16	5/16	3/8	3/8"	8.66"	7.5"	7.50	162 x 54 x 48	11,250
8/4	8'	1/4	1/4	7/16	7/16"	9.5"	8.25"	7.50	162 x 55 x 50	13,000
10/4	8'	5/16	7/16	1/2	9/16"	10.6"	9.5"	10.00	174 x 63 x 61	17,700
12/4	8'	3/8	1/2	5/8	3/4"	11.8"	10.25"	14.75	181 x 69 x 61	24,700
15/4	8'	1/2	5/8	3/4	7/8"	12.6"	11"	21.00	182 x 71 x 63	26,500
17/4	8'	9/16	3/4	7/8	1"	14.2"	12.6"	25.00	189 x 79 x 75	34,200
6/5	10'	1/8	3/16	1/4	5/16"	8.66"	7.5"	7.50	183 x 53 x 48	12,600
8/5	10'	3/16	5/16	5/16	3/8"	9.5"	8.3"	7.50	183 x 55 x 50	14,800
10/5	10'	1/4	5/16	3/8	7/16"	10.6"	9.5"	10.00	195 x 63 x 61	19,900
12/5	10'	5/16	7/16	1/2	5/8"	11.8"	10.25"	14.75	203 x 69 x 61	27,400
15/5	10'	3/8	1/2	9/16	3/4"	12.6"	11"	21.00	203 x 71 x 63	29,400
17/5	10'	1/2	5/8	3/4	7/8"	14.2"	12.6"	25.00	211 x 79 x 75	38,400
6/7	12'	14 ga	1/8	3/16	3/16"	8.66"	7.5"	7.50	221 x 53 x 48	15,000
8/7	12'	1/8	3/16	1/4	1/4"	9.5"	8.3"	7.50	232 x 55 x 50	17,700
10/7	12'	1/8	3/16	1/4	5/16"	10.6"	9.5"	10.00	233 x 63 x 61	23,600
12/7	12'	3/16	1/4	5/16	3/8"	11.8"	10.25"	14.75	240 x 69 x 61	32,700
15/7	12'	1/4	5/16	3/8	7/16"	12.60"	11"	21.00	240 x 71 x 63	35,100
17/7	12'	5/16	7/16	1/2	5/8"	14.2"	12.6"	25.00	248 x 79 x 75	47,000

4RH-NC SOLUTIONS FOR HEAVIER PLATE APPLICATIONS

4RH MODEL	Useful Length	Pre-bend Capacity			Rolling Capacity	Roll Diameters		HP	Overall Dimensions L x W x H	Weight (lbs.)
		1,2x 3x 5x (Thickness in inches)	Ø Top roll			Central Roll	Lateral Rolls			
20/3	6'	3/4	1	1-1/8	1-3/8"	15.35"	13.75"	25	170 x 81 x 75	30,700
25/3	6'	1	1-1/4	1-3/8	1-3/4"	16.5"	14.5"	30	181x 95 x 83	45,000
30/3	6'	1-1/4	1-3/8	1-1/2	2"	18.1"	16.1"	30	185 x 99 x 87	47,200
35/3	6'	1-3/8	1-3/4	2	2-1/4"	19.7"	17.3"	41	193 x 110 x 99	59,600
40/3	6'	1-1/2	2	2-1/4	2-1/2"	21.6"	19.3"	50	201 x 126 x 114	77,200
50/3	6'	2	2-1/2	2-3/8	3-1/2"	23.6"	21.25"	74	229 x 134 x 122	99,250
20/4	8'	11/16	7/8	1	1-1/4"	15.4"	13.8"	25	189 x 81 x 75	35,100
25/4	8'	3/4	1	1-1/8	1-3/8"	16.5"	14.6"	30	201 x 95 x 83	50,500
30/4	8'	1	1-1/4	1-3/8	1-3/4"	18.1"	16.1"	30	205 x 99 x 87	53,600
35/4	8'	1-1/4	1-1/2	1-3/8	2"	19.7"	17.3"	41	213 x 110 x 99	67,300
40/4	8'	1-3/8	1-3/4	2	2-1/4"	21.7"	19.3"	50	221 x 126 x 114	86,000
50/4	8'	1-1/2	2	2-1/4	2-5/8"	23.6"	21.25"	74	248 x 134 x 122	110,300
20/5	10'	5/8	3/4	7/8	1"	15.4"	13.8"	25	211 x 79 x 75	39,300
25/5	10'	11/16	7/8	1	1-1/4"	16.5"	14.6"	30	223 x 95 x 83	55,800
30/5	10'	3/4	1	1-1/8	1-3/8"	18.1"	16.1"	30	227 x 99 x 87	60,000
35/5	10'	1	1-1/4	1-3/8	1-3/4"	19.7"	17.3"	41	236 x 110 x 99	75,000
40/5	10'	1-1/4	1-3/8	1-3/4	2"	21.7"	19.3"	50	244 x 126 x 114	94,800
50/5	10'	1-3/8	1-3/4	2	2-1/4"	23.6"	21.25"	74	270 x 134 x 122	121,300
20/7	12'	3/8	1/2	9/16	3/4"	15.4"	13.8"	25	248 x 81 x 75	47,900
25/7	12'	1/2	5/8	3/4	7/8"	16.5"	14.5"	30	260 x 95 x 83	66,400
30/7	12'	9/16	3/4	13/16	1"	18.1"	16.1"	30	264 x 99 x 87	72,800
35/7	12'	11/16	7/8	1	1-1/4"	19.7"	17.3"	41	272 x 110 x 99	90,400
40/7	12'	3/4	1	1-1/8	1-3/8"	21.6"	19.3"	50	280 x 126 x 114	112,500
50/7	12'	1	1-1/4	1-3/8	1-3/4"	23.6"	21.25"	74	307 x 134 x 122	143,300