



Horizontal Bending Presses



Standard Features

- Cylinder located below the worktable, eliminating obstructions that would normally limit the available workspace.
- Work is performed in a direction moving away from the operator, who is positioned in front of the machine for greater visibility and operator safety.
- Dust wipers on carriage slides to reduce wear from debris
- Centralized forced lubrication system for ease of maintenance
- Patented rapid change tool locking pins (T.22 & T.40) with tapered design eliminating tool post movement for accurate bending.
- Stroke regulation by means of extremely sensitive precision electric limit switches and a graduated measuring rule for precise positioning of the punch stroke.
- Micrometer adjustment of the stroke allows the possibility of adjusting the punch stroke even while the machine is under maximum pressure, eliminating the need for test bends.

Digital Features

- Program and micrometer stroke adjusted through "Simplylogik" CNC control
- Inch or millimeter measuring units
- Precision positioning: +/- .003"
- Forced lubrication through automatic electric pump
- Stroke adjustments possible under maximum bending pressure, eliminating the need for test bends.
- Operation in Manual, Semi-automatic, and Automatic modes
- 35 key touch screen keyboard, 16x2 LED characters, programmable "X"-axis (stroke) and "Y"-axis (feed positioning) with 550 program storage capability
- BENDING FUNCTION: (with die + punch) programming in degrees of the bending angle directly from CN, data setting punch, die, and material thickness
- TUBE BENDING FUNCTION: programming in degrees of the bending angle directly from the CN
- USB port for downloading programs on an external memory stick for saving and/or input data (optional)



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Types of Fixtures and Technical Features

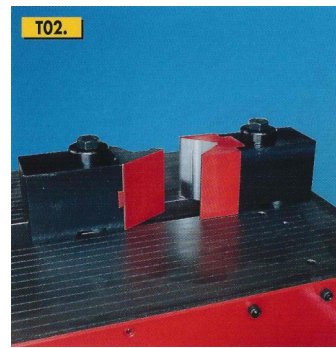
Model		T.22 Scanja	T.40 Super	T.70 Super	T.100 Super
T02. – Bending	L = 4 ⁷ / ₈ ", Flat Stock	4 ³ / ₄ " x 1 ¹ / ₂ "	-	-	-
	L = 6 ¹ / ₄ ", Flat Stock	-	6 ¹ / ₄ " x 1 ¹ / ₈ "	-	-
	L = 7 ⁷ / ₈ ", Flat Stock	-	4 ³ / ₄ " x 1"	7" x 1"	-
	L = 9 ⁷ / ₈ ", Flat Stock	-	-	7 ⁷ / ₈ " x 1 ¹ / ₈ "	9 ⁷ / ₈ " x 1 ¹ / ₈ "
	L = 11", Flat Stock	-	-	-	9" x 1 ³ / ₈ "
	Square Bar	1"	1 ⁵ / ₈ "	2"	2 ¹ / ₂ "
	Round Bar	1 ¹ / ₈ "	1 ³ / ₄ "	2 ¹ / ₄ "	2 ³ / ₄ "
T04.1 – Bending Flat Bar on Edge	Work Piece Dimension	1 ¹ / ₁₆ " x 2 ³ / ₈ "	1 ¹ / ₂ " x 4"	1 ¹ / ₂ " x 6"	1" x 6"
	Minimum Internal ø	3 ¹ / ₈ "	4 ³ / ₄ "	7 ⁷ / ₈ "	11 ¹ / ₈ "
T05.1 – Rotary Pipe Bending	CLR = 2 ¹ / ₂ "	ø 3 ³ / ₄ "	ø 3 ³ / ₄ "	-	-
	CLR = 3 ¹ / ₈ "	ø 1 ¹ / ₄ "	ø 1 ¹ / ₄ "	-	-
	CLR = 5 ¹ / ₈ "	ø 1 ⁵ / ₈ "	ø 1 ⁵ / ₈ "	-	-
T07.01 – Rotary Pipe Bending	CLR = 2 ¹ / ₂ "	-	ø 3 ³ / ₄ "	ø 3 ³ / ₄ "	ø 3 ³ / ₄ "
	CLR = 3 ¹ / ₈ "	-	ø 1 ¹ / ₄ "	ø 1 ¹ / ₄ "	ø 1 ¹ / ₄ "
	CLR = 5 ¹ / ₈ "	-	ø 1 ⁵ / ₈ "	ø 1 ⁵ / ₈ "	ø 1 ⁵ / ₈ "
	CLR = 6 ¹ / ₄ "	-	ø 1 ⁷ / ₈ "	ø 1 ⁷ / ₈ "	ø 1 ⁷ / ₈ "
	CLR = 7 ¹ / ₈ "	-	ø 2 ³ / ₈ "	ø 2 ³ / ₈ "	ø 2 ³ / ₈ "
T08. – Ram-Type Pipe Bending	CLR = 1 ⁵ / ₈ "	3 ³ / ₈ "	3 ³ / ₈ "	3 ³ / ₈ "	3 ³ / ₈ "
	CLR = 2"	1 ¹ / ₂ "	1 ¹ / ₂ "	1 ¹ / ₂ "	1 ¹ / ₂ "
	CLR = 2 ⁵ / ₈ "	3 ³ / ₄ "	3 ³ / ₄ "	3 ³ / ₄ "	3 ³ / ₄ "
	CLR = 3 ³ / ₄ "	1"	1"	1"	1"
	CLR = 6 ¹ / ₈ "	1 ¹ / ₄ "	1 ¹ / ₄ "	1 ¹ / ₄ "	1 ¹ / ₄ "
	CLR = 6 ⁵ / ₈ "	1 ¹ / ₂ "	1 ¹ / ₂ "	1 ¹ / ₂ "	1 ¹ / ₂ "
	CLR = 8 ¹ / ₈ "	-	2"	2"	2"
	CLR = 12"	-	-	2 ¹ / ₂ "	2 ¹ / ₂ "
	CLR = 15 ³ / ₄ "	-	-	-	3"
T09. – Straightening	Maximum Work Piece Height	6"	6"	7 ⁷ / ₈ "	9 ⁷ / ₈ "
T11.1 – Curl Fixture	ø 3", Flat Stock	3 ¹ / ₁₆ " x 1 ¹ / ₈ "	3 ¹ / ₁₆ " x 1 ¹ / ₈ "	3 ¹ / ₁₆ " x 1 ¹ / ₈ "	-
	ø 3", Square Bar	5 ¹ / ₁₆ "	5 ¹ / ₁₆ "	5 ¹ / ₁₆ "	-
	ø 3 ¹ / ₂ ", Flat Stock	3 ¹ / ₁₆ " x 3 ³ / ₄ "	3 ¹ / ₁₆ " x 3 ³ / ₄ "	3 ¹ / ₁₆ " x 1 ¹ / ₂ "	-
	ø 3 ¹ / ₂ ", Square Bar	5 ¹ / ₁₆ "	5 ¹ / ₁₆ "	5 ¹ / ₈ "	-
	ø 4 ¹ / ₈ ", Flat Stock	1 ¹ / ₄ " x 1 ³ / ₈ "	1 ¹ / ₄ " x 1 ³ / ₈ "	3 ¹ / ₁₆ " x 1 ¹ / ₂ "	-
	ø 4 ¹ / ₈ ", Square Bar	7 ¹ / ₁₆ "	7 ¹ / ₁₆ "	1 ¹ / ₁₆ "	-
	ø 7 ¹ / ₄ ", Flat Stock	-	1 ¹ / ₄ " x 1 ³ / ₈ "	3 ¹ / ₁₆ " x 1 ¹ / ₂ "	-
	ø 7 ¹ / ₄ ", Square Bar	-	7 ¹ / ₁₆ "	1 ¹ / ₁₆ "	-
T12.01 – Circles & Slots	Flat Stock	3 ³ / ₈ " x 4 ³ / ₄ "	3 ³ / ₄ " x 4 ³ / ₄ "	1 ⁵ / ₁₆ " x 6 ¹ / ₄ "	1 ³ / ₈ " x 7"
	Square Bar	3 ³ / ₄ "	1 ⁹ / ₁₆ "	1 ³ / ₄ "	2 ⁷ / ₁₆ "
	Round Bar	1"	1 ³ / ₄ "	2"	2 ³ / ₄ "
	ø Internal	7 ⁷ / ₈ "	7 ⁷ / ₈ "	11 ³ / ₄ "	11 ³ / ₄ "
T13.01 – Gutters	ø 105	1 ¹ / ₈ " x 1 ¹ / ₄ "	1 ¹ / ₈ " x 5 ¹ / ₁₆ "	-	-
	ø 125				
	ø 145				
	ø 165				
T15.1 – Punching	ø 5 ⁵ / ₈ "	5 ¹ / ₁₆ "	1 ¹ / ₂ "	1 ¹ / ₂ "	1 ¹ / ₂ "
	ø 3 ³ / ₄ "	1 ¹ / ₄ "	1 ⁷ / ₃₂ "	2 ¹ / ₃₂ "	2 ¹ / ₃₂ "
	ø 1 ¹ / ₈ "	1 ¹ / ₆₄ "	1 ¹ / ₃₂ "	1 ⁷ / ₃₂ "	1 ¹⁵ / ₁₆ "
	ø 1 ¹ / ₈ "	5 ¹ / ₃₂ "	5 ¹ / ₁₆ "	1 ¹⁵ / ₃₂ "	2 ²⁵ / ₃₂ "
T16.3 – Shearing	Flat Stock	3 ³ / ₈ " x 4"	1 ¹ / ₂ " x 4 ³ / ₄ "	1 ¹ / ₂ " x 6 ¹ / ₄ "	3 ³ / ₄ " x 6 ¹ / ₄ "
T17.1 – Universal Shearing	Square Tube	3 ¹ / ₈ " x 3 ¹ / ₈ ", t=5 ⁵ / ₆₄ "	3 ¹ / ₈ " x 3 ¹ / ₈ ", t=5 ⁵ / ₆₄ "	4 ³ / ₄ " x 4 ³ / ₄ ", t=3 ³ / ₁₆ "	4 ³ / ₄ " x 4 ³ / ₄ ", t=3 ³ / ₁₆ "
	Rectangle Tube	2 ³ / ₈ " x 3 ¹ / ₈ ", t=5 ⁵ / ₆₄ "	2 ³ / ₈ " x 3 ¹ / ₈ ", t=5 ⁵ / ₆₄ "	4 ³ / ₄ " x 7", t=3 ³ / ₁₆ "	4 ³ / ₄ " x 7", t=3 ³ / ₁₆ "
	Angle (Equal Legs)	3 ¹ / ₈ " x 3 ¹ / ₈ ", t=5 ⁵ / ₃₂ "	3 ¹ / ₈ " x 3 ¹ / ₈ ", t=5 ⁵ / ₃₂ "	4 ³ / ₄ " x 4 ³ / ₄ ", t=3 ³ / ₁₆ "	4 ³ / ₄ " x 4 ³ / ₄ ", t=3 ³ / ₁₆ "
	Angle (Unequal Legs)	1 ¹ / ₈ " x 3 ¹ / ₈ ", t=5 ⁵ / ₃₂ "	1 ¹ / ₈ " x 3 ¹ / ₈ ", t=5 ⁵ / ₃₂ "	4 ³ / ₄ " x 1 ³ / ₄ ", t=3 ³ / ₁₆ "	4 ³ / ₄ " x 1 ³ / ₄ ", t=3 ³ / ₁₆ "
	U-Channel	3 ¹ / ₈ " x 1-9/16", t=5 ⁵ / ₃₂ "	3 ¹ / ₈ " x 1-9/16", t=5 ⁵ / ₃₂ "	4 ³ / ₄ " x 2 ³ / ₈ ", t=3 ³ / ₁₆ "	4 ³ / ₄ " x 2 ³ / ₈ ", t=3 ³ / ₁₆ "
T18.01 – T-Groove Shearing		-	1 ¹ / ₈ " x 1 ¹ / ₈ ", t=3 ³ / ₁₆ "	-	-

The present theoretical data are calculated considering the working of metal material with tensile stress: R=420 N/mm².
All specifications are subject to change without notice.

Types of Fixtures



T.50.4
PS3000 Programmable Positioning Device



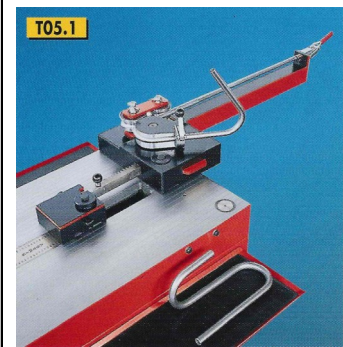
T02.
Die and Punch for Bending w/ Rapid Coupling



T03.
Die and Punch for Narrow "U" Bending



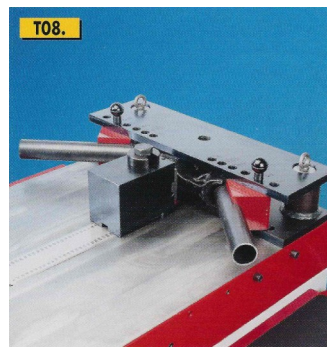
T04.1
Bending Fixture for Bending Flat Bar on Edge



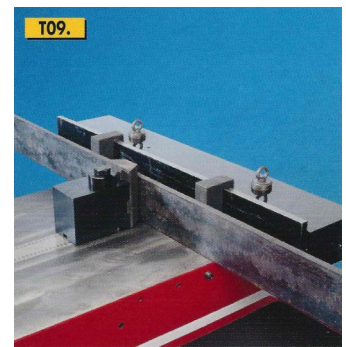
T05.1
Rotary Pipe Bending Fixture



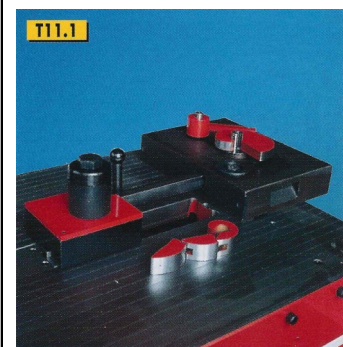
T07.01
Super Rotary Pipe Bending Fixture



T08.
Ram Bending Fixture



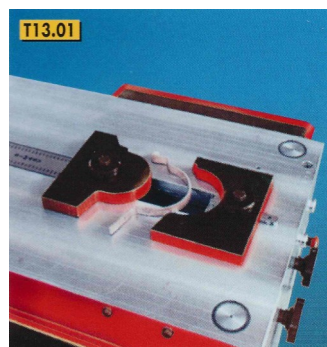
T09.
Straightening Fixture



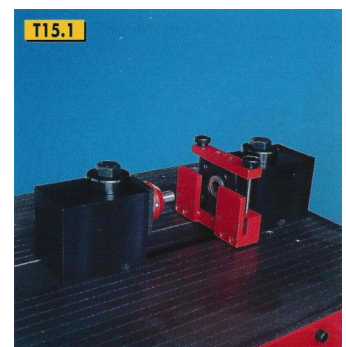
T11.1
Curl Fixture



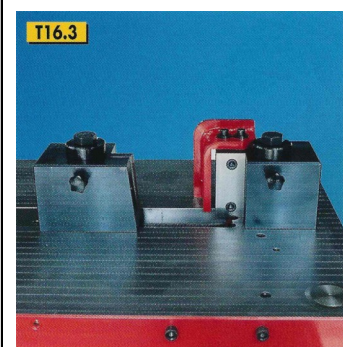
T12.01
Fixture for Circles



T13.01
Gutter Support Fixture



T15.1
Punching Fixture



T16.3
Shearing Fixture



T17.1
Universal Shearing Fixture for Pipes



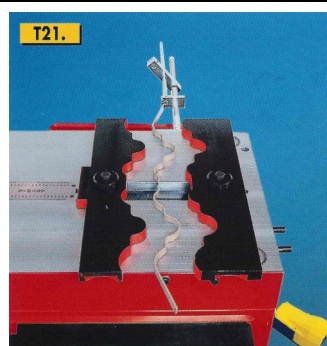
T18.01
T-groove Shearing Fixture



T19.01
Handle Forming Fixture



T20.01
Fixture for Molding Hooks



T21.
Multiple Shape Fixture

Machine Technical Features

Model		T.22 Scanja
Table Dimension		24¾" x 43¼"
Table Height from Floor		36½"
Stroke of the Movable Punch		7⅞"
Adjustment of the Working and Return Stroke of the Movable Punch		•
Approach Speed of the Movable Punch		68⅞"/min
Speed Selection Device		•
Maximum Thrust Force of the Movable Punch		48,501½ lbs.
Power		1½ kW 2½ HP
Protection and Lubrication of the Slides		Manual Operation Pump
Size of the Movable and Fixed Pin Quick Coupling		Ø 55mm
Standard Pin Height		4¾"
Hydraulic Oil Tank Capacity		11⅞" gal.
Side Consoles for Tooling		Optional
Working Capacity		See the table specifying the effective working capacities of every type of machine equipped with the suitable fixture.
Outside Dimensions	Width	24¾"
	Length	45¼"
	Height	41⅓"
	Weight	1,390 lbs.



T.22 & T.40 Chameleon - CE2 Roller	
Diameter of Shafts on Bending Machine	Ø 1⅞"
Diameter of Rollers on Bending Machine	5" - 6½"
Motor Power of Bending Machine	¾ kW 1 HP
Revolutions per Minute of the Bending Machine	5/10 rpm

Model	T.40 Super	T.70 Super	T.100 Super
Table Dimension	24½" x 43¼"	32¼" x 67⅞"	34⅝" x 74¼"
Table Height from Floor	37½"	38½"	40⅞"
Auxiliary Side Holes on Table	•	•	•
Stroke of the Movable Punch	9¾"	13"	13"
Adjustment of the Working and Return Stroke of the Movable Punch	•	•	•
Approach and Return Speeds of Movable Punch	69"/min 78"/min	70"/min 87"/min	70"/min 81"/min
Working Speed of the Movable Punch	18½"/min	25½"/min	18⅞"/min
Speed Selection Device	•	•	•
Maximum Working Pressure	3,626 psi	3,336 psi	3,626 psi
Maximum Thrust Force of the Movable Punch	84,826 lbs.	149,719½ lbs.	213,620½ lbs.
Power	3 kW 4 HP	5½ kW 7½ HP	5½ kW 7½ HP
Protection and Lubrication of the Slides	Manual Pump	Automatic Pump	
Min. & Max. Distances Between Centers of the Movable Punch and Fixed Pin	4⅝" 14½"	7⅝" 20⅝"	9½" 22½"
Size of the Movable and Fixed Pin	-	Ø 80mm	Ø 100mm
Size of the Movable and Fixed Pin Quick Coupling	Ø 55mm Ø 63mm	-	-
Hydraulic Oil Tank Capacity	18½ gal.	37 gal.	42¼ gal.
Side Consoles for Tooling	Two	Two	Two
OPTIONAL – Decimal Reading of the Stroke	.004"	.004"	.004"
Working Capacity	See the table specifying the effective working capacities of every type of machine equipped with the suitable fixture.		
Outside Dimensions	Width	47¼"	54⅓"
	Length	45¼"	73¼"
	Height	43⅝"	45⅓"
	Weight	2,095 lbs.	4,215 lbs.

