

## 4-Roll Double Pinch Bending Roll with Linear Guides

*Technologically  
Advanced*



4HEL is the most precise and easiest to use series of 4-roll bending rolls with total pre-bending. Highly technological and innovative, 4HEL bending rolls assure high productivity with a speed 3-4 times higher than a traditional pyramid bending roll. Moreover, thanks to their production methods, the 4HEL bending rolls can be effectively controlled through numerical control systems.

All models of Faccin's 4HEL 4-roll bending rolls are equipped with a rear side roll opposite the feeding side. Used as backing, this roll allows the plate to be aligned in an immediate and accurate manner. The plate, moreover, always remains pinched between the two central rolls, thus avoiding accidental slips. This not only optimises pre-bending and rolling operations, but it also ensures safer and more precise machining, with the option of being handled entirely by a single operator through the use of a powerful CNC.

With the 4-roll configuration, the pre-bending operation does not require tilting the plate below the feeding level (as in traditional 3 roll bending rolls) so horizontal feeding tables may be used, for easier feeding of the plate into the machine.

With the 4HEL 4-roll there's no need to leave free space on both sides of the machines, but only at the selected infeed side.

With the 4HEL 4-roll machine, the plate can be formed in one single pass. In fact, after the first pre-bending, the plate is rolled to the desired diameter and then the second end forming is automatic.

Cone bending processing is made easier by tilting the side rolls and the pinching roll to respectively set the cone angle and drag the sheet at its largest development.

The 4HEL machines are well known for their reliability thanks to their over dimensioned structure and the centralised lubrication system. The Linear Guide Design (RGS) increases their bending precision by minimising the distance between the bending points.

Special design solutions like the Double Bearing System (MCS) are expressly used to have a better absorption of the maximum loads. The combination of top-quality components, the Hi-Tech hydraulics of the FaccinAp and EPS system make the 4HEL one of the most technologically advanced plate roll on the market.

The 4HEL series of CNC bending rolls - designed and built by Faccin - are the best solution to bend plates from less than 1m and up to 10m with thicknesses 5 to 150 mm.

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### Standard equipment

- ✓ Linear guides for roll motion (RGS)
- ✓ 4 independent bearings supporting the lower rolls (MCS)
- ✓ Bearing seats with double width (WHS)
- ✓ Electronic synchronisation of roll parallelism (EPS)
- ✓ Hardened and polished rolls and conical device
- ✓ Siemens numerical control
- ✓ Mobile wheel mounted control console
- ✓ Faccin Advantage Package - FaccinAp
- ✓ Centralised lubrication system (pump)
- ✓ Emergency barrier around the machine
- ✓ CE certified machine

### Optional features

- ✓ Side motorised rolls
- ✓ Automatic loading and unloading systems
- ✓ Motorised feeding table
- ✓ Automatic ejector
- ✓ Central and side supports
- ✓ Provision for hot rolling
- ✓ Version with planetary guides (4HEP)
- ✓ Integrated welding system
- ✓ Special colours
- ✓ CNC Siemens numerical control



Capacity (mm)	Rolls length (mm)	Rolling mild steel (mm)	Pre-bending mild steel (mm)	Rolling stainless steel (mm)	Pre-bending stainless steel (mm)	Minimum Top roll (mm)	Dimension (m)
2000x6	2050	6	5	5	4	160	3,8x1,2x1,1
2000x11	2050	11	8	9.5	7	210	3,9x1,2x1,2
2500x8	2550	8	6	7	5	210	4,4x1,2x1,2
2500x12	2550	12	8	10.5	7	260	4,6x1,5x1,4
2500x14	2550	14	10	12	8.5	270	5,3x1,4x1,5
2500x20	2550	20	15	17	13	320	5,3x1,9x1,8
3050x7	3100	7	5	6	4	210	5,0x1,2x1,2
3050x12	3100	12	8	10	7	270	5,7x1,4x1,5
3050x16	3100	16	13	14	11	320	5,8x1,9x1,8
3050x20	3100	20	15	17	13	370	5,8x2,0x1,8
3050x30	3100	30	25	26	21	400	6,2x2,0x2,4
3050x36	3100	36	30	31	26	430	6,4x2,1x2,6
3050x42	3100	42	35	36	30	460	7,0x2,3x2,9
3050x55	3100	55	45	47	39	520	7,0x2,6x3,1
3050x65	3100	65	52	56	45	630	7,4x2,9x3,4
3050x85	3100	85	70	73	60	730	7,8x3,7x3,8
4000x7	4050	7	5	6	4.5	270	6,4x1,5x1,4
4000x10	4050	10	8	8.5	7	320	6,8x1,9x1,8
4000x15	4050	15	12	13	10	370	6,9x2,1x2,0
4000x18	4050	18	15	16	13	400	7,1x2,1x2,4
4000x22	4050	22	18	19	16	430	7,3x2,1x2,6
4000x30	4050	30	25	26	22	460	7,3x2,4x2,5

• Special sizes and capacities available upon request. Please send us your inquiries.

• Data can be changed without prior notice in consideration of continuing technological improvements.