Innovation, Quality & Performance Backed By Decades of Experience

www.carellcorp.com
Our Philosophy... To offer the Best Machines...
True Quality & Value are Always Found in the Details...

Our company was founded to fill a need for tough, dependable machines capable of working day after day with minimum down time. This can only be achieved through comprehensive quality engineering toward all aspects of machine construction, even the hidden components. It’s what sets Carell apart from everyone else. From the outset, when you have to Depend on a machine... Depend on... CARELL!

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VALUE ADDED SERVICES by Carell Corporation
Demonstration & Showroom / Testing & Prototype Facility
Tooling Design & Manufacturing / Technical Assistance
Machine Diagnostics & Repair / Process Flow Design / Spare Parts
Dedicated Machine Applications / Extrusion Die Consulting

Some of our Satisfied Clients include:
- General Motors - General Electric - Boeing - Northrup Grumman - NASA - US NAVY
- Titan Tanks - Offshore Inland - BP - General Mills - Mercury and many more!

TUBE and PIPE BENDERS
HEAVY DUTY MANDRELESS & MANDREL BENDERS
½” to 4” Pipe ETM SERIES
Includes Calculation Screens & Limit warnings. Up to 99 programs and impressive cycle times.

INDEX
TUBE and PIPE BENDERS

FEATURES
- All Steel Construction is Heavier for maximum versatility and safety. ND Cast frames!
- Adjustable Bend Angle and spring back Pre-set Digital control with memory
- Manual - Automatic function allows Automatic bend & return with one command
- Bends up to 180° In one Step Quick Change Tooling Standard & Custom Formers Available

CAPACITIES
ETM-60HD: 1½” to 6½”
ETM-80HD: 2” to 10”
ETM-90HD: 2” to 14”
ETM-120HD: 3” to 18”
ETM-150HD: 4” to 22”

M TUBE and PIPE BENDERS

FEATURES
- Mandrel & Mandrelless Models
- Heavy Duty Steel Frames and Compact Designs
- Digital Controls, 50 Programs
- up to 11 Bends Each
- Efficient 2 Speed Drives
- Rear Pinch Safety Return Stroke
- Tooling / Formers Optional in Standard
- and Custom Sizes

CAPACITIES

MANDELLESS & MANDREL BENDERS
½” to 2” Pipe UNI SERIES

FEATURES
- Wide Range of Bending Radii:
- ETM-60HD: 2” to 10”
- ETM-80HD: 2½” to 19”
- ETM-90HD: 2½” to 19”
- ETM-120HD: 2½” to 19”
- ETM-150HD: 2½” to 19”

CAPACITIES
- Optional
- ETM-75: ½” to 12”
- ETM-80: ½” to 16”
- ETM-90: ½” to 19”
- ETM-120: ½” to 22”
- ETM-150: ½” to 22”

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CARELL CORPORATION
FABRICATING MACHINERY
P.O. BOX 850, 34225 Hwy. 31
STAPLETON, AL 36578-0850, U.S.A.
TEL: 251-937-0947 / FAX: 251-937-4742

Proud supporters of: [Images]
NOTES: Chart indicates minimum suggested inside diameter with maximum profile size, using mild steels rolling generally in multiple passes. Data is approximate specified inches u.n.o. Custom tooling for some profiles may be required for volume production and minimum rolling diameters are limited to level of acceptable deformation. The manufacturer and Carell Corp. reserve the right to revise design, construction and specifications without prior notice. Ratings based on material yield of 36KSI. Machines with extended shafts or shortened shafts are available. We build totally custom geometries and configurations for highly specific manufacturing requirement. Call us if you have questions on applications or capacities.

DOUBLE PINCH ANGLE ROLLS

15 MODELS 1° TO 10° ANGLE

SERIES 3000 CAPACITIES & SPECIFICATIONS

<table>
<thead>
<tr>
<th>Model</th>
<th>302HV</th>
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FEATURES

- Three drive rolls, smooth surfaced for optimal profile tractive and surface finish
- Double Pinch Geometry permits pre-bending without removal from the machine
- Dual LED Digital Displays / Emergency stop
- Monolithic single weldment frames heavily reinforced at key load points
- Detached mobile control stand, low voltage controls
- Horizontal/Vertical operation on models 302 thru 314
- NiCoMo Bending rolls hardened for optimal performance
- Top roll drive incorporates overload protection which allows differing roll speeds when bending tall sections
- Variable speed hydraulic drive train 306 - 315 with direct coupled hydraulic motors and planetary speed reducers. Electro-mechanical drive on 302 - 305
- Shafts journal in dual self-aligning high dynamic load roller bearings
- Tri Directional Lateral Guides
- Manual Adjust - 302 - 305
- Hydraulic Powered Models: 306-314

STANDARD EQUIPMENT

- LED Digital Displays on all 3000 Series Angle Rolls
- Telescoping Modular Multi-Component roll set specifically designed to bend standard sections including angle Leg In/Out and Square/Rectangular Tube as well as other shapes in a variety of material types

OPTIONS

- Rolls for tubes, pipes and special profiles
- Tooling for production of half tubes
- Overhead supports for coil production
- Compression and tension tooling for C-channel, & I beam hard way bending
- CNC & CNC Controls with various automation levels for repetitive jobs and production of variable radius bends and parts with multiple bends
- Powered lateral material guides on models 302 - 305
- LED digital displays for lateral guide movements

SERIES 3000 - Designed for Long Life, Reliability & Heavy-Duty Horizontal/Vertical Application.
G50HV

Features:
- Three Driven Shafts
- LED Readouts
- Push Button Controls
- Easy Operation
- Quick Set-up Universal Tooling
- Hydraulic Powered Forming Roll

Pyramid Design with Heavy Weldment Frames - No Castings!

G80HV

For up to 6" Pipe

- Produce coils for boilers, heaters, solar, geo-thermal, pharmaceutical, petrochemical and other applications.
- Coil 6" pipe down to 1/8" OD tubes or solid rod for springs and flat bars for repetitive ring forming.

Coil Forming Machines

Carell’s New Generation of Coiling Machines

G50HV & G80HVP

Universal Roll Benders

1,000’s of Uses. Designed for Fast High Production Custom Manufacturing Applications & Lighter Ornamental / Decorative Work.

The Carell E-MATIC CE/CN incorporates a rotary bending head, a wide stable base and programmable controls into a unique versatile package. Rugged drive train w/4.5 HP motor + oil bath reducer. Bend to 15° radius. Tooling Sold Separately: Scrolling, Bar Folding, Circle/Curve, Tube Bender, Custom Accessories are all easily available from our warehouse and in-house custom fabricating shop!

Mono-2R

45 Bending Programmed Auto-Cycle

High Speed 2 Roll Precision Ring Roller

Fast & Precise!

E-MATIC CE/CN

5 Machines in One!

World’s Most Versatile Economical Bender

Section Type

Section Size

G50HV

G80HV

3" x 3/8"

4" x 1/2"

4-1/2" x 3/4"

4-1/2" x 3/4"

1-3/4" x 1/2"

1-3/4" x 1/2"

2-1/4" x 1/4"

2-1/4" x 1/4"

2-1/4" x 11GA

2-1/4" x 11GA

3" x 14GA

3" x 14GA

2-3/8" x 2-3/8"

4" x 0.120"

2-3/8" x 2-3/8"

3" x 3/8"

3" x 3/8"

3-3/4" x 2" x 10GA

4" x 0.120"

4" x 0.120"

3-3/4" x 2" x 10GA

4" x 0.120"
Discover The Exclusive Features of The VBH Series!

The most advanced bending technology.

Controls are an essential requirement for precision rolling production. Our controls function just like a tablet with touch-screens: navigating through the options is simplified via menus, shortcuts and with context-sensitive help. Select from the simple, compact DIGIMATIC control to the STRADIVARI 3D-CAD CNC, there’s a PARMIGIANI control for every application.

Instantaneous status display of the entire electrical / hydraulic systems and other components with on-screen schematics and real-time diagnostics.

Our CNC controls features are the result of continuous and technological improvements, including instant on-screen component monitoring, PM indications, “Plug & Play” Field Bus wiring harnesses, digital pressure controls and more that save time and money with increased productivity.

Options:
- Hardened Rolls
- Cone Devices
- Lateral Supports
- Ejectors
- Feed Tables
- Custom Lengths
- Inter-changeable Top Rolls
- Overhead Supports

On-Screen Component Diagnostics & Schematics

“Plug & Play” connectors Using “Field Bus” technology

Active extended diagnostic From the screen you control most all electrical connections around the machine, all PLC modules, all micro switches and more...

PPS Hydrotronic® SYSTEM PRECISION
20 times faster than PLC based electronic controls joined with the hydraulic proportional valves, provides a parallelism precision of about 0.004”

FACILE® ADVANCED WIRING SYSTEM
The FACILE system avoids wiring errors, shorter set-up time and allows quick swapping of cable during component replacement with reliable “Plug & Play” connectors.

Hi-Tech Hydraulic ADVANCED HYDRAULIC SYSTEM With the infinitely variable pressure and the infinitely variable speed adjustment the operator has full control of the process in any bending operation.

“DIGIMATIC” 7” Color touch screen NC
“SAVE&BEND” 10” Color touch screen NC
“FAST” 15” Color touch screen CNC
“STRADIVARI” 19” Color touch screen CNC with 3D CAD Graphics
ISC, HDTs, QAP & QAI SERIES

ANY LENGTH • ANY PATTERN • ANY SHEET THICKNESS, HORIZONTAL OR VERTICAL

CORRUGATED ROLLS

ANY LENGTH • ANY PATTERN • ANY SHEET THICKNESS, HORIZONTAL OR VERTICAL

We supply 3 and 4 roll machines for rolling corrugated sheet of all lengths, thickness and corrugation patterns. Machines are available with standard and CNC controls. Feeding and stacking systems are optional Hydraulic or Mechanical!

FEATURES

• Capacities from 15” to 96” long x 26 Ga to 3/16”
• Automated bending cycles
• Top roll and pinch rolls driven in rotation
• Hardened, heat treated alloy steel rolls
• High polished, non-marring roll surface finish
• High speed rolling velocity
• Automatic drop-end release at end of cycle
• Compact space-saving designs
• Top support/deflectors
• Sheet feed squaring arm and adjustable back stops
• Automated sheet alignment systems

OPTIONAL EQUIPMENT

• Sheet-Loading systems from pallets or blank stacks
• Cylinder ejector systems
• Multiple pallet blank shuttle systems
• Special machine configurations for dedicated needs
• A variety of CNC, NC or basic controls tailored to your requirements
• Finished part accumulators and take-away conveyors
• Lateral bending rolls powered also in rotation
• Urethane coated rolls
• Interchangeable top rolls

5 Rod Rolling Grooves

Bending Roll Inclines for Cones

Manual Bend & Pinch Roll Adjust

Foot Pedal Control on Rotation

Induction Hardened Rolls 54-56 HRC

Controls in 24VAC Low Voltage

LED Readout w/ Position Repeat

Extended Shafts & Section Dies

Alignment and/or Rod Grooves

Powered Bend Roll Rotation

Foot Pedal Rotation Control

Cone Rolling Device

Custom Machines

INTIAL PINCH PLATE ROLLS

A31 SERIES

POWERED INITIAL PINCH PLATE ROLLS

FEATURES

• Push Button Controls on Detached Console
• Forward Release Top Roll w/ Safety Lock
• Emergency Palm Stop & Safety Trip Wire
• Keyed Safety Lockout on Control Stand
• Precision Pinch Adjustment, Manual
• Linear Scales for Precise Positioning
• Bend Pinch Rolls Incline for Cones

OPTIONS

• Additional LED Readouts
• 2 Speed Rotation
• Variable Speed Rotation
• Hydraulic lateral material support arm
• Hydraulic Overhead Support for (maximum ID 8’), sustaining thin sheet when rolling large diameters

...continued on next page...
Carell Hydraulic Horizontal "Bulldozer" Presses with High Speed Digitally Controlled Options can perform a multitude of bending, forming, straightening, punching and shearing operations. The work bed is heavy duty, oversized & hardened machined for producing complex shapes. The thrust ram is located under the machine bed allowing 360 degrees of unencumbered bending. High strength hardened punches and dies mount to receivers with a massive cross slotted dove tail key. Available from 22 up to 100 Ton Capacities with 100's of Tooling Options Available For Specific Production Needs.

Carell Hydraulic Corner Notching Machines have heavy precision machined GS500 cast alloy work beds and precision ground dual vertical stroke guides on massive cast machine head. Units come with blades, sheet squares, stroke limit control, waste chute and a foot pedal actuator. Models from 3/16" to 5/16" with Fixed and Variable Angle and with a Punching Station option

### CONE ROLLING SYSTEMS

- **3 Roll-V Initial Pinch**
- **4 Roll-V NC Controlled**
- **3 Roll-V w/ LED Readouts**

The High Durometer Urethane coated lower roll allows perfect rolling of polished aluminum alloy, stainless steel or mirror finished materials without surface marring or contamination. Reduce / Eliminate unbent flats and produce perfectly aligned seams with maximum pressure between the top and pinch rolls, perfectly parallel seams are achieved with virtually no unbent flats.

**No finish deterioration of part surface**

**AUTOMATIC CYCLE CONE FORMER**

### VERTICAL PLATE ROLLS

- **3 & 4 ROLL VERTICAL SYSTEMS**
- **SIGNIFICANTLY REDUCE TANK PRODUCTION COSTS!**

The Evolution of Vertical Rolling Technology

Vertical Plate and Sheet Rolls can be built to suit your production needs. Vertical format rolls with no open end yoke have the drive train located at the top. If an open end yoke for material removal is required, the drive train is located at the base of the machine and a pit is generally required so working height is close to the shop floor.

Vertical geometries are available in 3 or 4 Roll Double Pinch as well as 3 Roll Initial Pinch as needs dictate. For specific needs, machines can be built that operate in both the vertical and horizontal positions.

### HORIZONTAL PRESSES

#### T-SERIES

- **Versatile Hydraulic Bulldozer Presses**
- **Perfect shearing of thin & thick materials without operator intervention**

Carell Hydraulic Horizontal "Bulldozer" Presses with High Speed Digitally Controlled Options can perform a multitude of bending, forming, straightening, punching and shearing operations. The work bed is heavy duty, oversized & hardened machined for producing complex shapes. The thrust ram is located under the machine bed allowing 360 degrees of unencumbered bending. High strength hardened punches and dies mount to receivers with a massive cross slotted dove tail key. Available from 22 up to 100 Ton Capacities with 100's of Tooling Options Available For Specific Production Needs.

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### CORNER NOTCHERS

- **NEW! SIMplylogik NC Dual Axis Programmable Controls**
- **New "Digi-T100" Horizontal Press**

**COMPARE for YOURSELF and discover the key economical advantages of Vertical Rolls for Tank Production offered by Carell**

**SIGNIFICANTLY REDUCE TANK PRODUCTION COSTS!**
STIRRUP ACCESSORIES

TRUE MOBILITY — RUGGED FRAMES — LOW MAINTENANCE

BENDERS & COMBINATION MACHINES

REBAR SHEARS

The BEST Solution for your Rebar Fabricating Requirements!

- Safety Shields
- Automatic Cycle Bend/Return
- Foot Pedals & Push Button Controls
- Adjustable Length Stop
- Stirrup Bending Tool
- Spiral Hoop Attachments

Bend more bars together!

Programmable Stirrup Benders

Easy to Use Selections for Rapid Production

Model | HP | Bend | Shear
--- | --- | --- | ---
ST16 | 1PH | 2 | #9 | #8
ST16 | 3PH | 2 | #9 | #8
PS16 A/C | 3PH | 2 | #10 | #9

Precision & Safety For Every Cut

Model | HP | Shear
--- | --- | ---
C34 EVO 1PH | 3 | #6
C34 EVO 3PH | 3 | #6
C35 EVO 3PH | 4 | #9
C44 EVO 3PH | 4 | #11
C54 EVO 3PH | 5.5 | #14
C56 EVO 3PH | 7.5 | #14
C74 EVO 3PH | 10 | #18

Options: Base & pedal, Pump for lubrication (for standard C)
Screw locator (only C42 C52 C55)

Digital Programming!

Up-To 6 Bending Programs!

Larger Turning Plates with Long Saddles
Reduction Gear & Cutting Arm in a Single Block!

Spiral Model

Model | HP | Min | Max
--- | --- | --- | ---
CAL34 | 1V 5 | #3 | #9
CAL34 | 2V 6 | #3 | #9

HEAVY DUTY SPIRAL DEVICE OPTIONAL
Use with up to 6 bar

Carell Manufactures Tooling in our CNC Machine Shop for Rapid Turn-Around & Enhanced Quality Control

High Quality CNC Manufactured Tooling built to suit your bending machine applications

- Aluminum Extrusions
- Steel/brass/aluminum
- Decorative Hand Rails
- Oversized U and C shapes
- Overwide flats
- Half tube production from flats
- Hard way beam & channel rolling

...Just to name a few

STIRRUP BENDERS

Bend more bars together!

ST16

Computerized Control

PS16

Reduced Dimensions

Make Unit Easy to Carry

ST16

Heavy Duty Spiral

Device Optional

REBAR SHEARS

Better Aesthetic Cut!

Increased Capacity
Simplified Maintenance
2 yr. Warranty

C42

(EVO Series)

C54

(EVO Series)

REBAR BENDERS AND SHEARS

STANDARD & CUSTOM TOOLING

CNC MANUFACTURED TOOLING

Tooling Built for Your Bending Machine Applications

Our Mission is to expand the versatility and capabilities of your roll bending machine.

Carell Corporation provides standard and special order tooling/accessories for our machines as well as other brands. We maintain over 1,000 Optional Tooling Items In-Stock and manufacture Custom Tools with specific needs In-House for rapid delivery to your location.

- REPLACEMENT COMPONENTS
  - Lost a piece or need a smooth surface component for working with soft or delicate material? We stock Smooth and Knurled standard roll components for all machines.

- TUBE & PIPE ROLLS
  - Most common tube OD & Pipe Sizes in Stock. Hardened, Solid Tool Steel. Any Size can be Made. Specify Smooth or Knurled. Also available in Polymer Material for Delicate Finishes.

- CUSTOM ROLLS
  - We manufacture Tooling In-House To Roll a Wide Range of Custom And Special Profile Shapes in a Variety of Material Types.

- TOOLING & SUPPORTS FOR HALF PIPES & COILS
  - 3000 Series Machines can be equipped with tooling for producing half tubes from strip & supports for coiling. Overhead supports (man. or hydraulic) may have coil diameter & pitch adjustment or be interlocked to NC/CNC controls.

- TRACTION TOOLING BEAMS BENT HARD WAY
  - Larger capacity 3000 Series Angle Rolls can be fitted with traction tooling and rolls for effective rolling of beams as well as channels bent in the X-X axis or ‘Hard Way’

- SECTION DIES FOR PLATE ROLLS
  - For Plate Bending Machines with extended shafts, roll sets for profiles and tube or pipe can produced. Call to discuss capacities and pricing.

- "V" GROOVE ROLL
  - Roll Bar Stock and Square tube on a 45° angle to Create a Unique Look. Available for all Models in both Smooth and Knurled. Made of Solid, Hardened, Tool Steel here at Carell Corp.

- CAP RAIL SOLUTION A
  - For Aluminum & Brass Cap Profiles. Three Fully Contoured Polymer Rolls. Six Steel Shoulder Plates May be Required. Call for Capacities.

- CAP RAIL SOLUTION B
  - The Most Economical Cap Solution. 3 Semi-Contoured, Hardened Steel Inserts to Match the Cap. Most Commonly Used With Standard Tooling. Furnished Smooth.

- CAP RAIL SOLUTION C
  - Best Suited For Production Jobs. 3 Fully Contoured, Hardened Steel Rolls Built To Match Your Cap Sample. Furnished Smooth.
Our Eagle CP20 is a 3 roll Pyramid Type, Portable Bench Top, Universal Roll Bending Machine that allows you to roll small to tight profiles as well as large bending diameters with Renowned Eagle Quality and Durability.

The CP20 has more standard features than any other machine this size. They are complete with LED Digital Readouts, Powered Roll Rotation, Universal Tooling Set, Lateral Material Guides, Overload Protection and More!

CP20’s are furnished with a Universal Tooling set of 18 components. Driven lower rolls are knurled for optimum friction. Standard Tooling bends flat bar (bent on flat and on the edge), square/round bar, T's, C's and square tube & rectangular tube. Round tube & pipe and other profiles or extrusions require our optional tooling.

CP30 Series

- LED Digital Readout*
- Three Roll Universal Benders
- 25% Heavier Main Frames in Solid Steel w/lifetime warranty
- High Strength Hardened Steel Shafts
- TEFC Electric Motors, CE Certified
- Lower Shafts Driven, Top Shaft Idle
- Universal Roll Set, Hardened, 24 pieces
- Thermal Overload Protection & E-stops
- Lateral Material Guides w/ bearings, variable rake angle, & recessed hex adjustment.

These features not on ‘look-alike’ machines

- Flush Faced Frame and Electrical Cabinet
- Dual, High Dynamic Load Bearings on shafts
- Top Roll Journal on Adjustable Guides & Ways
- Illustrated User Manual & Tool Kit

**Options / Accessories**

- Tube & Pipe Rolls
- Wide Flat & Tight Diameter Rolls
- Rolls & Guides for Angle In/Out
- Bar Twist & Scroll Tooling
- CAP RAIL ROLLS
- Rolls for Extrusions/Other Shapes

**Model Legend**

- M 1 Speed, 220V, Single Phase
- P 2 Speed, 220V, Three Phase
- R Rotating Horizontal/Vertical
- E 1 Speed, with LED

**Specifications**

<table>
<thead>
<tr>
<th>Shaft OD</th>
<th>Roll OD</th>
<th>Power</th>
<th>Power</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-3/16” (30 mm)</td>
<td>5” (128 mm)</td>
<td>1.15 HP 220V-3-60Hz</td>
<td>1.50 HP 220V-1-60Hz</td>
<td>550 Lbs, approx.</td>
</tr>
</tbody>
</table>

**CP30 Series Capacities**

<table>
<thead>
<tr>
<th>SHAPE</th>
<th>MAX SIZE/MIN ID</th>
<th>NOTES</th>
</tr>
</thead>
<tbody>
<tr>
<td>1” x 1/8”</td>
<td>3/8” x 1/8”</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>1-1/8” x 1/8”</td>
<td>7/16” x 1/8”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>1-1/8” x 1/16”</td>
<td>1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>1-3/4” x 1/16”</td>
<td>1” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>2-3/4” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>3” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>3-1/2” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>4” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>4-1/2” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>5” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>6” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>7” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>8” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
<tr>
<td>9” x 1/16”</td>
<td>1-1/4” x 1/16”</td>
<td>Optional Rolls</td>
</tr>
</tbody>
</table>

*On some sections for limited quantities it may be possible to use standard rolls. For optimum results or if production runs are required, it is necessary to use optional rolls and or optional additional tooling.

**Standard Features & Equipment**

- 3 Roll Universal Bender w/ bench mountable position
- Rugged Steel Frame, normalized, produced on CNC machining centers
- Shafts in High Strength Steel, heat treated, journaled in roller bearings
- Electronic LED Digital Display makes accurate repetitive parts easy
- Universal rolls, hardened alloy steel 55 HRC, bend most standard sections
- Oil Bath Speed Reducer powered by 220V-3-60Hz bi-directional TEFC motor
- Forming roll journal moves on Hardened Slide-Ways with Adjustable Gibbs
- Lateral Material Guides, adjust to create spiral pitch or correct twist on difficult jobs, guides rotate inwards for contact when rolling tight diameters
- Racks in 24-5V Low Voltage, complete with overload protection
- Illustrated instruction manual, English (Spanish upon request)

**Options/Accessories**

- Rolls for round tube/pipes, Cap Rail, Angles, Wide Flats
- Tight Diam. Rolls • Base Stand • Custom Tooling

**Specifications**

<table>
<thead>
<tr>
<th>Positioning</th>
<th>Manual Repeat Roll, LED Readout</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shaft Dia.</td>
<td>3/4” (20mm)</td>
</tr>
<tr>
<td>Roll Dia.</td>
<td>3-1/4”</td>
</tr>
<tr>
<td>Speed</td>
<td>9 fpm</td>
</tr>
<tr>
<td>Power</td>
<td>0.44 HP</td>
</tr>
<tr>
<td>Dimensions</td>
<td>26”x10”x25”</td>
</tr>
<tr>
<td>Weight</td>
<td>160 lbs</td>
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</tbody>
</table>
**CP40H-H2-M SERIES**

**CP40 FEATURES AND BENEFITS**
- 3 Roll Pyramid Universal Roll Bender
- DP7 Programmable Control, Digital Radius Readout Capability, 400 Auto Repeat Memory (H/H2), LED Readout (M)
- Powerful Easy to use Pyramid Style
- High Strength Hardened Shafts
- 25% Heavier Main Frames in Solid Steel with Limited Lifetime Warranty
- Universal Bending Roll Set 18 pcs.
- All Dual Bearings, No Bushings
- Flush Electrical Panels, NEMA Type
- Detached Mobile Operator Consoles
- Dual Pedal Controlled Rotation
- Dual E-Stop Buttons
- Lateral Guides with Bearings, Variable Angle, Heavy Duty with Easy, Hex Ratchet Adjustments on Thrust
- TEFC Motors, Overload Protected

**OPTIONS / ACCESSORIES**
- Tube & Pipe Rolls
- Wide Flat & Tight Diameter Rolls
- Rolls & Guides for Angle In/Out
- Bar Twisting & Scrolling Tools
- Rolls for Extrusions & Other Shapes CAP RAIL ROLLS

**NO CASTINGS**
in our Machines!

**SPECIFICATIONS**

<table>
<thead>
<tr>
<th>SHAPE</th>
<th>MAX SIZE/MIN ID</th>
<th>NOTES</th>
</tr>
</thead>
<tbody>
<tr>
<td>4&quot; x 180°</td>
<td>1500 Lbs</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>5&quot; x 180°</td>
<td>1500 Lbs</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>6&quot; x 180°</td>
<td>1500 Lbs</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>7½&quot; x 180°</td>
<td>1500 Lbs</td>
<td>Optional Threading</td>
</tr>
<tr>
<td>8½&quot; x 180°</td>
<td>1500 Lbs</td>
<td>Optional Threading</td>
</tr>
<tr>
<td>9½&quot; x 180°</td>
<td>1500 Lbs</td>
<td>Optional Threading</td>
</tr>
</tbody>
</table>

**Simply the Best Benders**

**CP60-H Features and Benefits**
- 3 Roll Pyramid Universal Roll Bender
- DP7 Programmable Control, Digital Radius Readout Capability, 400 Auto Repeat Memory
- Powerful Easy to use Pyramid Style
- High Strength Hardened Shafts
- 25% Heavier Main Frames in Solid Steel w/ Limited Lifetime Warranty
- Universal Bending Roll Set 18 pcs.
- All Dual Bearings, No Bushings
- Flush Electrical Panels, NEMA Type
- Detached Mobile Operator Consoles
- Dual Pedal Controlled Rotation
- Dual E-Stop Buttons
- Lateral Guides w/ Bearings, Variable Angle, Heavy Duty with Easy, Hex Ratchet Adjustments on Thrust
- TEFC Motors, Overload Protected
- Illustrated Instruction Manual & Tool Kit

**CP60 CAPACITIES**

<table>
<thead>
<tr>
<th>SHAPE</th>
<th>MAX SIZE/MIN ID</th>
<th>NOTES</th>
</tr>
</thead>
<tbody>
<tr>
<td>3½&quot; x 12 GA</td>
<td>ø60&quot;</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>4&quot; x 12 GA</td>
<td>ø40&quot;</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>4½&quot; x 12 GA</td>
<td>ø42&quot;</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>5 x 1&quot;</td>
<td>ø26&quot;</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>5&quot; x 2&quot;</td>
<td>ø36&quot;</td>
<td>Standard Rolls</td>
</tr>
</tbody>
</table>

**Features and Benefits**
- 400 Position Memory
- Direct Radius Input Control
- Solid Steel Frames
- Vertical / Horizontal Operation
- Dual E-Stop
- Patented / Reversible Braking System
- E• Stops
- Dual
- Telescopic w/ Bearings, w/ Lateral Guides
- 18 Piece Hardened Universal Roll Set
- Heavy Duty Roll Sets

**Eagle Quality is in the Details...**

Disclaimers: Roll bending machines distributed by Eagle Bending Machines, Inc. are sold subject to the Standard Terms and Conditions of Sale. Literature, specifications, illustrations, representations, and information herein are all subject to change without notification. No warranty is expressed or implied as to the accuracy of information herein and no representation of the machines or their parts herein is made as to their fitness for any particular use or intended use. Eagle Bending Machines, Inc. disclaims and specifically excludes all warranties, express or implied, including, but not limited to, any implied warranty of merchantability or fitness for a particular purpose. Eagle Bending Machines, Inc. shall in no event be held responsible for any direct, indirect, incidental, special, or consequential damages arising from the use or inability to use this literature. Eagle Bending Machines, Inc. reserves the right to change the appearance and specifications of machines and the equipment and accessories described herein, at any time, without further notice. No representation of the machines or their parts herein is made as to their fitness for any particular use or intended use. Eagle Bending Machines, Inc. disclaims and specifically excludes all warranties, express or implied, including, but not limited to, any implied warranty of merchantability or fitness for a particular purpose. Eagle Bending Machines, Inc. shall in no event be held responsible for any direct, indirect, incidental, special, or consequential damages arising from the use or inability to use this literature.
### BA SERIES CNC

**BA35**  
- **Features**
  - Full PC/Windows Based CNC Controls
  - Exclusive BPR Direct Radius "PRO-Bending" Program
  - Direct Radius Input & On-Board CAD Graphics allow the operator to visualize and edit shapes on screen
  - Automatic Interpolation-Blending between bends speeds up and simplifies programming
  - Standard Shape program Archive of most common shapes
  - Servo Controlled Bending Roll Movement offers Industries Highest Level of Material Variance Control & Bending Precision
  - Large Full Color Graphic Screen Interface
  - Unlimited Program Memory, Hard Drive + USB Port
  - RS-232 Serial Port enables use of external Lap-Top
  - Automatic Interpolation/Blending & Mirror Imaging Functions
  - Variable Speed Rotation & Rise/Decent of Bending Roll
  - Air Oil Heat Exchanger Maintains oil at Constant Temp.

**BA20**  
- **Features**
  - Roll bending machines distributed by Eagle Bending Machines Inc. are designed and manufactured to comply with ANSI B97.1-1990 and CE standards. The manufacturer of this equipment is responsible for providing and ensuring the usage of point of operation guards and/or properly applied and adjusted point of operation guards.

**BA55**  
- **Features**
  - Three Drive Rolls Universal Profile Bender Initial Pinch Geometry for Serial Production
  - Hydraulic Up / Down Movement on Forming Roll
  - High Strength Hardened Shafts w/Roller Bearings
  - Universal Bending Rolls, Smooth, Induction Hardened
  - Vertical & Horizontal Working Position (BNCPS 35 & )
  - Push Button Controls, Detached Console
  - Dual Pedal Controlled Rotation
  - DP7 Programmable Controls, Digital Radius Readout
  - Capability, 400 Memory Automatic Position
  - Repeat "APR" System
  - LED Readout, Large High Brightness, 24VAC Controls
  - Flush Mount Switch Gear Panel with Safety Lamps
  - Bending Roll Moving on Adjustable, Hardened Gibs
  - Adjustable Lateral Material Guide
  - Service Tools and Illustrated Manual

### BA CAPACITIES

<table>
<thead>
<tr>
<th>SHAPE</th>
<th>Maximum Size &amp; Minimum I.D.</th>
</tr>
</thead>
<tbody>
<tr>
<td>20</td>
<td>1.56&quot; x 0.04&quot; x 0.04&quot;</td>
</tr>
<tr>
<td>35</td>
<td>2.18&quot; x 0.04&quot; x 0.04&quot;</td>
</tr>
<tr>
<td>40</td>
<td>2.79&quot; x 0.04&quot; x 0.04&quot;</td>
</tr>
<tr>
<td>50</td>
<td>3.40&quot; x 0.04&quot; x 0.04&quot;</td>
</tr>
<tr>
<td>55</td>
<td>4.01&quot; x 0.04&quot; x 0.04&quot;</td>
</tr>
</tbody>
</table>

### CPS CAPACITIES

<table>
<thead>
<tr>
<th>SHAPE</th>
<th>Maximum Size &amp; Minimum I.D.</th>
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</thead>
<tbody>
<tr>
<td>20</td>
<td>1.56&quot; x 0.04&quot; x 0.04&quot;</td>
</tr>
<tr>
<td>35</td>
<td>2.18&quot; x 0.04&quot; x 0.04&quot;</td>
</tr>
<tr>
<td>50</td>
<td>3.40&quot; x 0.04&quot; x 0.04&quot;</td>
</tr>
</tbody>
</table>

### OPTIONS/ACCESSORIES

- Rolls for Tube, Pipe, Round and Square
- Custom Rolls for Extrusions & Special Sections
- Special Voltages Upon Request

### STANDARD EQUIPMENT

- Adjustable Lateral Material Guides
- Service Tools + Illustrated Manual

### Simply the Best Benders

**CPS SERIES Universal Section Roll**

**CPS-20 H/V**

**CPS-35**

**CPS-50**

**FEATURES**

- Three Drive Rolls Universal Profile Bender Initial Pinch Geometry for Serial Production
- Hydraulic Up / Down Movement on Forming Roll
- High Strength Hardened Shafts w/Roller Bearings
- Universal Bending Rolls, Smooth, Induction Hardened
- Vertical & Horizontal Working Position (BNCPS 35 & )
- Push Button Controls, Detached Console
- Dual Pedal Controlled Rotation
- DP7 Programmable Controls, Digital Radius Readout
- Capability, 400 Memory Automatic Position
- Repeat "APR" System
- LED Readout, Large High Brightness, 24VAC Controls
- Flush Mount Switch Gear Panel with Safety Lamps
- Bending Roll Moving on Adjustable, Hardened Gibs
- Adjustable Lateral Material Guide
- Service Tools and Illustrated Manual

**VERSIIONS 20 - 35 - 50**

**CPS (Standard)**

Models 20, 35 & 50 with Single Rolling Speed and all Features as listed to the left

**CPS-REV (Variable Rolling Speed)**

CPS Version + Step-less variable speed, digital Inverter and potentiometer for precision bending aluminum extrusions and extreme tight diameters

**CPS-AUT (Automatic Bend Execution)**

REV Version + Programmable Control and Proximity Sensors to execute a bend in a production environment
ZM402 & ZH402 are 3 roll, pyramid type Universal Roll Bending Machines with manually or hydraulically adjusted forming roll. Our units roll standard/special sections & tube/pipes in a variety of metal types. These machines are Superior in Every Aspect with a Solid Steel MAINFrame! We use no castings in our machines unlike many other roll-to-roll brands.

Our Efficient Pyramid Design uses a wide lower-inter-axis and extended forming roll vertical travel to maximize bending power.

Compare our Superior Warranty to other brands and discover the Eagle difference!

CHARACTERISTICS
- 3 Roll Universal Benders w/Dual Working Positions
- Lower Rolls Powered & Knurled for Optimal Traction
- Top Roll Idle, Adjustable Up/Down for Bending Radius
- LED Digital Readout monitors top roll position
- Operate Both in Horizontal & Vertical Positions
- Rugged Solid Steel Frames, NO CASTINGS
- All Shafts Rotate on Dual Bearings, NO BUSHINGS
- Top Journal Hardened Guides/Ways - ADJUSTABLE
- Dual Pedal Controlled Rotation
- Dual E-Stop Buttons
- Heavy Duty Adjustable Lateral Guides w/Bearings
- Compact, Robust, Low Maintenance Pyramid Design

STANDARD EQUIPMENT
- Universal Rolls, 18 pcs • Palm E-Stop • 24V Controls
- 3 Way Adjustable Lateral Material Guides & LED Readout
- Motor Overload Protection & Magnetic Cut-out

OPTIONS/ACCESSORIES
- Rolls for round tube/pipe, Cap Rail, Angles, Wide Flats
- Tight Diam. Rolls • Twist & Scroll Tools • Custom Tooling

SPECIFICATIONS
- Positioning
  Repeat Ref. • LED Readout
  Shaft Dia. 1.57”
  Roll Dia. 6.38”
  Speed 14.5 fpm
  Power H-260 M 1.75
  Dimensions 32”X94”X37”
  Weight 950/890lbs

- 2 VERSIONS w/Horiz./Vert. Operation


ZH402 CAPACITIES

<table>
<thead>
<tr>
<th>SHAPE</th>
<th>MAX SIZE</th>
<th>MIN ID</th>
<th>NOTES</th>
</tr>
</thead>
<tbody>
<tr>
<td>2&quot; x 11/16&quot; 86G</td>
<td>Standard Rolls</td>
<td>2&quot; x 3/4&quot; 86G</td>
<td>Standard Rolls</td>
</tr>
<tr>
<td>2&quot; x 15/64&quot; 86G</td>
<td>Standard Rolls</td>
<td>2&quot; x 1&quot; 86G</td>
<td>Special Rolls</td>
</tr>
<tr>
<td>2&quot; x 5/16&quot; 86G</td>
<td>Special Rolls</td>
<td>2&quot; x 3/4&quot; 86G</td>
<td>Optional Bending</td>
</tr>
<tr>
<td>2&quot; x 13/32&quot; 86G</td>
<td>Standard Rolls</td>
<td>2&quot; x 1&quot; 86G</td>
<td>Optional Bending</td>
</tr>
<tr>
<td>2&quot; x 1/8&quot; 86G</td>
<td>Standard Rolls</td>
<td>2&quot; x 3/4&quot; 86G</td>
<td>Optional Tooling</td>
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<tr>
<td>2&quot; x 5/64&quot; 86G</td>
<td>Optional Rolls</td>
<td>2&quot; x 1&quot; 86G</td>
<td>Optional Bending</td>
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<tr>
<td>2&quot; x 1/16&quot; 86G</td>
<td>Optional Rolls</td>
<td>2&quot; x 3/4&quot; 86G</td>
<td>Optional Tooling</td>
</tr>
</tbody>
</table>

On some sections for limited quantities, it may be possible to use standard rolls. For application means of production runs are required. It is recommended to use optional rolls and or optional tooling.

Simply the Best Benders

EAGLE BENDING MACHINES MAXIMIZES YOUR ROLLING INVESTMENT

Eagle Bending Machines are tested and ready for Fast Delivery with the largest “off the shelf” tooling supply in the USA! Premium Features Available on Eagle/BPR Universal Roll Bending Machines

Large LED Digital Displays for precision repeatability • Versatile New modular hardened rolls bend more shapes, vertical & horizontal operation

- Auto Repeat Systems • Safety & Ergonomics
- Lower working heights, wider frames, multiple E-Stops, 24VAC controls, isolating foot pedals eliminate vibration

Optimal Equipment and Versions: Rolls for round tube/pipes/rod special profiles & serial production, Cam Guides for angle leg-in, variable speed drives, BA CNC Controls, Scroll tools & more!

MATERIAL CP20 BA55 CPS20 CP30 CPS30 Z402 M-H Z402 M-H2-H BA40 BA50 CPS50 Bas5 CPS60 BA60

| Flats, Hard | 1-1/4 1/4 | 1-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 |
| Flats, Easy | 1-1/4 1/4 | 1-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 | 2-1/4 1/4 |
| Square Bar | 1/2 1/8 | 1/2 1/8 | 1-1/8 1/16 | 1-1/8 1/16 | 1-1/8 1/16 | 1-1/8 1/16 | 1-1/8 1/16 | 1-1/8 1/16 | 1-1/8 1/16 |
| Angle, Leg Out | 3/4 1/4 | 3/4 1/4 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 |
| Angle, Leg In | 3/4 1/4 | 3/4 1/4 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 | 1-1/4 1/16 |
| Tee, Leg Out | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 |
| Tee, Leg In | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 |
| C, Legs-In | 1-1/4 1/8 | 1-1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 |
| C, Legs-Out | 1-1/4 1/8 | 1-1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 | 2 1/4 1/8 |
| Round Bar | 1/2 1/8 | 1/2 1/8 | 1-1/4 1/8 | 1-1/4 1/8 | 1-1/4 1/8 | 1-1/4 1/8 | 1-1/4 1/8 | 1-1/4 1/8 | 1-1/4 1/8 |
| Round Tube | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 | 1 | 1 0.125 |
| Rectangular Tube | 3/4X1X1/16 | 3/4X1X1/16 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 |
| Rect Tube | 1-1/4X3/16X1/16 | 1-1/4X3/16X1/16 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 | 2X1X1/4 |

Machine Version Key: H=Hydraulic Roll Adj. • M=Manual Roll Adj. • P=Horizontal/Vertical Operation • P=Foot Controls • ZV=Dual Speed • REV=Variable Speed • HD=Two Driven Rolls • BA=Bent CNC

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