Advantages of Using Rolla-V

- Highly precision ground
- Modular
- Avoid traditional bending marks
- Minimal marking
- Extremely short flanges possible
- No tool material cross contamination
- Bend close to holes and cut-outs with no deformation
- Fewer tool changes
- Bends laser cut sheets with no tool damage
- Ideal for radius bending
- Exact inside radius
- Ideal for tapped or feathered edges
- Bends up to 30mm thick material (subject to model selected)

APPLICATION AND TECHNICAL DATA

APPLICATION AND TECHNICAL DATA SHEET					
MODEL	**Max Load Capacity**	**Material Thickness**	**Min. Bend Angle**	**Min. Outside Flange**	**Max Outside Radius**
XT1	50t/m (17tn/ft)	0.3mm (.012")	60°	3.2mm (.126")	2.2mm (.087")
Equivalent vee size - 4.57mm (.180")	50t/m (17tn/ft)	0.8mm (.031")	60°	3.2mm (.126")	2.2mm (.087")
Vee gap at 90° - .9mm (.035")	50t/m (17tn/ft)	1.2mm (.047")	60°	3.2mm (.126")	2.2mm (.087")
XT2	70t/m (24tn/ft)	0.5mm (.020")	60°	6.1mm (.240")	4.1mm (.161")
Equivalent vee size - 8.66mm (.341")	70t/m (24tn/ft)	1.0mm (.039")	60°	6.1mm (.240")	4.1mm (.161")
Vee gap at 90° - 1.9mm (.075")	70t/m (24tn/ft)	2.0mm (.079")	60°	6.1mm (.240")	4.1mm (.161")
MODEL 1	100t/m (34tn/ft)	0.7mm (.028")	40°	4.2mm (.165")	3.0mm (.118")
Equivalent vee size - 6.59mm (.259")	100t/m (34tn/ft)	1.1mm (.043")	35°	4.2mm (.165")	2.6mm (.102")
Vee gap at 90° - 1.6mm (.063")	100t/m (34tn/ft)	1.5mm (.059")	35°	4.2mm (.165")	2.2mm (.087")
MODEL 2	150t/m (50tn/ft)	2.0mm (.079")	59°	9.3mm (.366")	6.0mm (.236")
Equivalent vee size - 13.16mm (.518")	150t/m (50tn/ft)	3.0mm (.118")	47°	9.3mm (.366")	5.0mm (.197")
Vee gap at 90° - 3.5mm (.138")	150t/m (50tn/ft)	3.2mm (.126")	47°	9.3mm (.366")	4.8mm (.189")
MODEL 2.5	250t/m (84tn/ft)	2.0mm (.079")	46°	18.6mm (.732")	13.2mm (.520")
Equivalent vee size - 25.17mm (1.0")	250t/m (84tn/ft)	4.0mm (.157")	46°	18.6mm (.732")	12.0mm (.472")
Vee gap at 90° - 7.5mm (.300")	250t/m (84tn/ft)	5.0mm (.196")	55°	18.6mm (.732")	10.8mm (.425")
MODEL 3 GEN 1	250t/m (84tn/ft)	3.0mm (.118")	75°	27.5mm (1.082")	23.0mm (.905")
Equivalent vee size - 36mm (1.42")	250t/m (84tn/ft)	4.0mm (.157")	75°	27.5mm (1.082")	22.0mm (.866")
Vee gap at 90° - 13.3mm (.524")	250t/m (84tn/ft)	6.4mm (.252")	75°	27.5mm (1.082")	19.5mm (.768")
MODEL 3 GEN 2	250t/m (84tn/ft)	2.0mm (.079")	68°	22.5mm (.886")	13.9mm (.547")
Equivalent vee size - 30.22mm (1.19")	250t/m (84tn/ft)	4.0mm (.157")	50°	22.5mm (.886")	11.9mm (.469")
Vee gap at 90° - 6.5mm (.256")	250t/m (84tn/ft)	6.4mm (.252")	50°	22.5mm (.886")	9.5mm (.374")
MODEL 3.5	250t/m (84tn/ft)	6.0mm (.236")	75°	39.0mm (1.535")	20.0mm (.787")
Equivalent vee size - 55.05mm (2.17")	250t/m (84tn/ft)	8.0mm (.315")	75°	39.0mm (1.535")	20.0mm (.787")
Vee gap at 90° - 18.6MM (.732")	250t/m (84tn/ft)	10.0mm (.394")	75°	39.0mm (1.535")	20.0mm (.787")
MODEL 4	300t/m (101tn/ft)	6.0mm (.236")	78°	56.6mm (2.228")	36.4mm (1.433")
Equivalent vee size - 76.51mm (3.01")	300t/m (101tn/ft)	8.0mm (.315")	76°	56.6mm (2.228")	36.4mm (1.433")
Vee gap at 90° - 32.9mm (1.30")	300t/m (101tn/ft)	12.7mm (.500")	73°	56.6mm (2.228")	36.4mm (1.433")

Adjustable models	**Min / Max** (mm)	**Max Load** (t)
RVHD2	16 - 30 (.630-1.181")	150 (50tn/ft)
RVHD2.5	28 - 69 (1.102-2.717")	200 (67tn/ft)
RVHD3	38 - 110 (1.496-4.311")	250 (84tn/ft)
RVHD4	69 - 220 (2.717-8.661")	350 (118tn/ft)

Adjustables are usually used for bending thick materials or for bending large radii - because specific material specs vary we do not provide detailed bend data. Flaring or hole distortion is much reduced, but is influenced by material specification. Radius work is greatly affected by spring-back of the specific material being bent. Minimum flange sizes are greatly affected by the squareness of the component edge.