

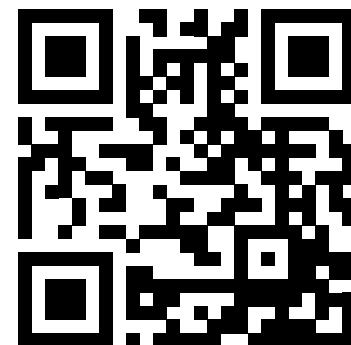
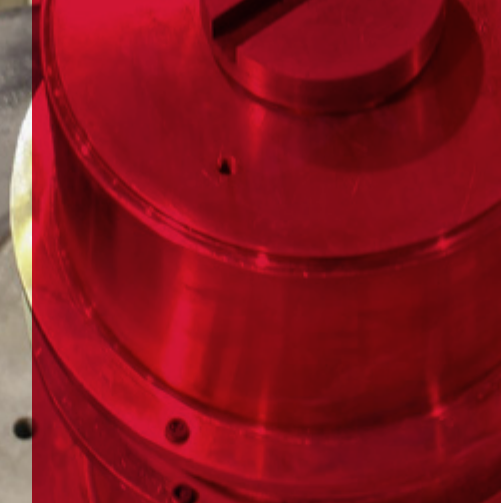
NO LIMIT ON SIZE ROLL UP TO **THE LARGEST**

AKYAPAK offers a broad range of sizes of large angle bending rolls. All AKYAPAK APK angle rolls have extremely strong frames constructed of welded ST-52 steel. Thanks to the combination of large roll shaft diameters and oversized bearing assemblies, APK machines can produce more bending power and torque with less flexing of the roll shafts. Less flexing produces rolled parts with less deformation.

All 3 rolls are driven at all times via hydraulic motors and planetary gearboxes. Large hydraulic cylinders are used to adjust the two bending roll positions independently of each other. The standard rolls are induction hardened and can roll a wide variety of sections.

The guide rolls are independently adjustable hydraulically in three axes, helping to reduce the twist when rolling asymmetric sections like angles and helping to support large sections being fed into and out of the machine. Because their adjustment is independent of the bending roll movements, the guide rolls can even be used to calibrate the rolled diameters.

A wide variety of options, such as devices for rolling beams and channels on X-X axis, material supports, and special rolls for pipe, round, square and rectangular tubing and other sections are available.



AKYAPAK USA[®]
METALWORKING TECHNOLOGIES

APK

ANGLE BENDING ROLLS

MODELS: 1000 - 800 - 550 - 360 - 300 - 280 - 240 - 180

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Technical Specifications	APK 180		APK 240		APK 280		APK 300		APK 360		APK 550		APK 800		APK 1000		Dies
	Size and diameter inch.	min Ø	Size and diameter inch.	min Ø	Size and diameter inch.	min Ø	Size and diameter inch.	min Ø	Size and diameter inch.	min Ø	Size and diameter inch.	min Ø	Size and diameter inch.	min Ø	Size and diameter inch.	min Ø	
1	6" X 5/8"	85"	6" X 1"	100"	8" X 1"	120"	8" X 1-1/8"	80"	8" X 1-1/4"	60"	8"x1"	51"	8"x1-1/4"	70"	8"x1-1/4"	135"	AD
2	5"X3/4"	85"	6" X 1"	130"	8" X 3/4"	140"	8" X1"	100"	8" X 1-1/4"	70"	8"x1"	59"	8"x1-1/4"	80"	8"x1-1/4"	135"	AD
3	WT6"	60"	WT6"	90"	WT8"	100"	WT8"	70"	WT8"	50"	8"x1"	51"	WT8"	60"	WT7"x404"	135"	AD
4	WT5"	65"	WT6"	110"	WT8"	120"	WT8"	100"	WT8"	60"	8"x118"	79"	WT8"	60"	WT7"x404"	135"	AD
5	WT6"	60"	WT6"	85"	WT8"	100"	WT8"	70"	WT8"	50"	8"x079"	71"	WT7"x365"	80"	WT7"x404"	135"	AD
6	6" X 1/2"	70"	8" X 1-1/4"	100"	10" X 1-1/4"	80"	10" X 2-1/2"	80"	16" X 2-3/8"	120"	17"x23" 11"x3.5"	118" 51"	20"x5"	120"	20"x6"	120"	A
7	8" X 2"	40"	12" X 2-1/2"	45"	16" X 3"	80"	18" X 3"	80"	22" X 4"	70"	25"x47"	67"	40"x6"	70"	40"x7"	120"	A
8	3-1/2"	45"	4-1/2"	60"	5-1/2"	60"	6"	80"	10"	100"	11"x11"	100"	12"x12"	100"	14"x14"	120"	A
9	4-3/8"	55"	5"	50"	6"	60"	7"	80"	10-1/2"	80"	118"	100"	14"	90"	16-1/2"	150"	B
10	6" sch40	85"	8" sch.40	100"	10" sch.40	160"	12" sch.40	160"	20" sch.40	600"	22" sch.40	700"	24" sch.40	600"	24" sch.80	750"	B
11	5" X 5/16"		6" X 3/8"		7" X 1/2"		9" X 1/2"		16" X 5/8"		17"x1"		20"x3/4"		24"x3/4"		B
12	C12 X 30#	40"	C15 X 50#	60"	MC18 X 58#	60"	MC18 X 58#	40"	MC18 X 58#	60"	MC18 X 58#	60"	MC18 X 58#	60"	MC18 X 58#	135"	B
13	C12 X 30#	45"	C15 X 50#	70"	MC18 X 58#	60"	MC18 X 58#	42"	MC18 X 58#	60"	MC18 X 58#	60"	MC18 X 58#	60"	MC18 X 58#	135"	B
14	W8 X 31#	45"	W12 X50#	60"	W16 X 67#	80"	W16 X 77#	80"	W33 X 241#	200"	W33 X 241#	200"	W40 X 503#	200"	W40X593#	200"	B
15	W12 X 35#	45" 45"	W14 X38#	60" 60"	W18 X 76#	100"	W21 X 93#	80"	W36 X 210#	200"	W36 X 210#	200"	W36X527#	200"	W40X593#	200"	B
16	C7 X 1225"	350"	C9 X1875#	410"	MC10 X 41"	450"	MC12 X 50"	350"	MC18 X 58#	700"	MC18 X 58#	700"	MC18 X 58#	700"	MC18 X 58#	700"	BC
17	W6 X 16#	120"	W6 X 21#	200"	W10 X 33#	400"	W12 X 35#	500"	W24 X 117#	150"	W24 X 117#	150"	W30X132#	2500"	W40 X 183#	2000"	BC
18	W5 X 19#	120" 100"	W6 X 25#	150"	W8 X 40#	400"	W10 X 35#	400"	W16 X 100#	108"	W16 X 100#	108"	W24X162#	1300"	W40 X 211#	1400"	BC
Max. Section Modulus (in³)	6.7 in³		19.5 in³		36.6 in³		42.7 in³		286 in³		335 in³		427 in³		671 in³		
Motor Size (hp)	20		40		50		85		95		99		147		214		
Dies Diameter (inch)	18.12"		21.65"		26.00"		29.13"		31.50"		31.5"		33"		33"		
Shaft Diameters (inch)	7.1"/6.3"		9.5"/8.7"		11"/10.3"		11.8/11"		14.2"		14.17"/14.17"		15.75"/15.75"		20.47"/16.54"		
Rolling Speed	0-20/ min.		0-20/ min.		0-20/ min.		0-20/ min.		0-20/ min.		0-20/ min.		0-20/ min.		0-20/ min.		
Weight (lbs.)	20.400		35.860		40.800		58.080		113.300		61.500		75.100		85.250		
WxLxH (inch)	79" X 95" X 67"		88" X 132" X 81"		112" X 150" X 88"		132" X 171" X 89"		197" X 224" X 126"		190"x259"x170"		217" x272" x169"		236"x287"x165"		

EXPLANATION
 A: Standard rolls | B: Special rolls | C: Pulling device
 D: For bending without deformation and for serial production special rolls are requested.

Data based upon 36.000PSI yield point. All specifications are subject to change without notice.

Equipment:

- Welded machine frame using ST-52 steel.
- Hydraulic variable speed drive on all 3 rolls.
- Hydraulic adjustment of the bending rolls.
- Six-directional fully hydraulic guide rolls.
- Digital readouts for the bending roll positions.
- Gears made from special steel.
- Shafts made from special steel and hardened and ground.
- One-shot lubrication system.
- Moveable control panel on wheels.
- Machines with vertical shafts for rolling in the horizontal plane.
- Electrics for 3/60/230/460. Other voltages on request.

Optional Equipment:

- Special rolls for pipe, tubing and other profiles.
- Device for rolling beams and channels on X-X axis.
- Spiral bending attachment.
- Joystick controls.
- Micro-hydraulic speed adjustment for the bending rolls.
- Extended length roll shafts.
- Digital readouts for the guide rolls.
- NC Playback Control System.
- CNC Graphic Control System.

