

Revolution Machine Tools



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Machine Specifications

RMT Machine Stock Number:	856	Machine - Shipping - Dimensions and Weight	
Manufacture	Roundo	Length x Width x Height	14' x 66" x 64"
Type	Hydraulic 4 Roll Plate Roll	Machine Weight in Lbs.	21,000 Lbs
Model #	PASS - 255	Incoming Power Requirements	
Serial #	SN: 997016	Incoming Voltage	3 PHASE 460V 60 Htz
Mfg. Year	1999	Full Load Current Amps	14 Amps
Status:		Min. Incoming Wire Size	Size 14 Wire
F.O.B. Point	North Salt Lake	Recommended Breaker	20 Amp
		Horse Power	Main Motor 8 HP

Machine Capacity - Capabilities

Machine size	Prebending capacity	Rolling capacity	Diameter of top roll and lower roll	Diameter of side rolls	Motor	Net weight	Gross weight
	mm	mm	mm	mm	1) kW	2) tons	3) tons
110	1250 x 3	1250 x 4.5	110	110	1.5	1.4	1.7
130	1250 x 4	1250 x 6	130	130	2.2	2.0	2.3
150	1250 x 4.5	1250 x 6.5	150	150	2.2	2.2	2.5
110	1500 x 3.5	1500 x 5.5	110	110	1.5	1.6	1.9
130	1500 x 3.5	1500 x 5.5	130	130	2.2	2.2	2.7
150	1500 x 4	1500 x 6	150	150	2.2	2.4	2.9
185	1500 x 5	1500 x 7.5	185	150	3	3.4	3.9
205	1500 x 6.5	1500 x 11	205	160	4	5.0	5.5
230	1500 x 10	1500 x 14	230	195	5.5	7.3	7.8
255	1500 x 12	1500 x 15	255	215	5.5	8.5	9.0
280	1500 x 14	1500 x 21	280	245	11	10.0	10.8
310	1500 x 16	1500 x 23	310	265	11	10.7	11.5
110	2000 x 2	2000 x 3	110	110	1.5	1.7	2.0
130	2000 x 3	2000 x 4.5	135	130	2.2	2.5	2.9
150	2000 x 3.5	2000 x 5.5	150	150	2.2	2.7	3.2
185	2000 x 4.5	2000 x 7	185	150	3	3.8	4.3
205	2000 x 6	2000 x 10	205	160	4	5.7	6.2
230	2000 x 8	2000 x 13	230	195	5.5	7.8	8.4
255	2000 x 10	2000 x 14	255	215	5.5	9.0	9.7
280	2000 x 12	2000 x 18	280	245	11	10.9	11.7
310	2000 x 14	2000 x 20	310	265	11	11.7	12.5
110	2500 x 1.5	2500 x 2.5	110	110	1.5	2.0	2.3
130	2500 x 2.5	2500 x 4	135	130	2.2	2.9	3.4
150	2500 x 3	2500 x 4.5	155	150	2.2	3.1	3.6
185	2500 x 4	2500 x 6.5	185	150	3	4.2	4.7
205	2500 x 5	2500 x 9	205	160	4	6.4	6.9
230	2500 x 6	2500 x 11	230	195	5.5	8.8	9.4
255	2500 x 8	2500 x 13	255	215	5.5	10.0	10.7
280	2500 x 10	2500 x 16	280	245	11	11.9	12.8
310	2500 x 12	2500 x 18	310	265	11	12.7	13.6
150	3000 x 2.5	3000 x 4	150	150	2.2	3.5	4.1
185	3000 x 3	3000 x 5	185	150	3	4.6	5.2
205	3000 x 4	3000 x 7	205	160	4	7.1	7.7
230	3000 x 5	3000 x 9	230	195	5.5	9.8	10.7
255	3000 x 6	3000 x 11	255	215	5.5	11.0	12.0
280	3000 x 8	3000 x 14	280	245	11	12.7	13.7
310	3000 x 10	3000 x 16	310	265	11	13.7	14.7
255	3500 x 4	3500 x 9	255	215	5.5	12.0	13.1
280	3500 x 7	3500 x 12	280	245	11	13.6	14.7
310	3500 x 8	3500 x 14	310	265	11	14.7	15.8

Highest Demand on Performance and Reliability meets lowest overall Cost



PASS 255 equipped with CNC control



PASS 460 in standard condition



PASS 600

ROUND O is the world's leading manufacturer of plate and section bending machines. The company was formed in 1964, and has since delivered more than 15,000 machines to satisfied customers around the globe. ROUND O machines are well-renowned for outstanding performance, reliability and quality.

Wide range of Machines
The standard range of 4-roll plate bending machines covers plate thicknesses from 3 mm (1/8") to 100 mm (4") and widths from 1000 mm to 8000 mm (3' to 26'). All machines have unique features needed for high precision and high output rates:

- Outstanding prebending capacities. In many cases, the remaining flat end is as short as one time the plate thickness.
- Fully hydraulic, infinitely variable speed drive and adjustment of the rolls.
- Highest drive torque of any competitive machine.
- Frames made of high-strength steel, fully welded and stress relieved before machining to have sufficient strength to absorb bending forces and to achieve highest possible accuracy.
- Built as standard with such mechanical precision and rigidity that all machines can be equipped with CNC-control.
- Excellent for cone bending, including prebending of cone plate.
- Easy to integrate into a production line when equipped with automatic threading of the plate, automatic section and down-line transport of the finished cylinder.

Construction
Machines from ROUND O are always more powerful and more heavily proportioned in terms of frame, roll size, bearings and drive torque than machines from other suppliers. The result is higher reliability, higher performance and longer service life.

The Rolls and Bearings
The rolls are manufactured of high carbon-content steel forgings for maximum surface hardness. The rolls are crowned to fit the largest possible thickness range within the capacity of the machine. To increase the thickness range further, the machines can be equipped with support rolls for the lower roll.

For machines used for bending stainless steel or when frequent cone bending is anticipated, hardened and ground rolls are recommended. To avoid cracking and wearing issues, the rolls are hardened using the patented Talip surface hardening process, followed by precision grinding and polishing.

All rolls on ROUND O plate bending machines are journalled in spherical roller bearings of the highest quality, resulting in minimal friction losses and longer service life. In addition, the rolls can easily be fitted to achieve the best result in operations such as cone bending.

Ensured Parallelism
The parallelism of the rolls is one of the most crucial factors in achieving good bending results and is absolutely essential for optimal use of CNC controls. This is ensured on all ROUND O machines, even under maximum load.

On PASS machines, the lower roll is adjusted by wedge blocks and a hydraulic cylinder, as shown to the right. This adjustment is very accurate and guarantees perfect parallelism of the rolls.

On PAD machines, the parallelism of the lower roll and both side rolls is electronically regulated by the digital control system. A precision glass-scale linear encoder, fitted to each end of the rolls, monitors the axial position of the roll. This trouble-free system ensures precision under all conditions and makes it possible to easily fit the rolls for cone bending.

Hydraulic Drive and High Drive Torque
All machines have fully hydraulic roll rotation, side roll and lower roll adjustment and drop and control. Combined with infinitely variable speed adjustment, the operator will have full control of the process in every bending situation.

The high drive torque makes it possible to prebend with maximum capacity and to bend a plate with maximum plate thickness down to a small radius in only one pass. All ROUND O 4-roll plate bending machines have precise control of the speed difference between top roll and lower roll in all situations.



1. High fly plate against the lower side roll. Raise the lower roll to pinch the plate. Rotate the plate to prebending position.



2. Operate the foot side roll prebend and roll.



3. Lower the foot side roll and raise the top side roll until it reaches the prebend edge.



4. Continue to roll the plate.



5. The cylinder is finished.

Note: customer must verify what voltage the machine is set at - prior to connecting electrical and running machine

All Information subject to Verification
 If you have any questions Regarding this Specification sheet, please contact us at info@rmtus.com or (844) 768-4636
 Thank You For The Opportunity!

