

Luna Bending Rolls

Luna

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LUNA BENDING ROLLS



BENDING ROLLS MBA

Manually operated machine with centerless ground rolls dia. 25 to 45 mm, which are asymmetrically placed. The sides of the machine are made of anodized and solid aluminium. The setting of the bottom and bending rolls is carried out by means of hand-wheels. The bending roll can also be set diagonally for cone bending. The top roll can easily be swung out for the removal of finished work pieces.

Ref. No	4126	-0100	-0209	-0308	-0407	-0506	-0605	-0704	-0803
Size		2/08	3/06	2/09	3/07	3/10	5/08	3/12	5/09
Working length	mm	210	360	210	360	360	510	360	510
Diameter of rolls	mm	25	25	30	30	40	40	45	45
Max sheet thickness (400N/mm ²)	mm	0,8	0,6	0,9	0,7	1,0	0,8	1,2	0,9
Net weight	kg	13	15	16	19	23	29	27	33
Options									
Stand	4126	-0902	-1009	-0902	-1009	-1009	-1108	-1009	-1108
Hardened rolls	On request								



BENDING ROLLS MBL

A motor-powered machine with crowned rolls (tensile strength 700 N/mm²). The upper roll can easily be swung out for the removal of piping. The lower roll is adjusted by a handwheel. The rear roll is adjusted by a lever and can be set diagonally for cone bending. The lower and rear rolls have four different slots for the bending of wire. Working speed 5,5 m/min. 4135 is delivered complete with motor 220/380 V 3-phase, stand as well as foot-operated forward/reverse switch with protective casing. The electrical equipment as per protection form IP54. In CE execution the machine is equipped with emergency stop, brake motor and trip wire.

Ref. No	4135	-0109	-0208	-0307
Size		6/20	10/15	12/12
Working length	mm	675	1010	1260
Diameter of rolls	mm	60	60	60
Max sheet thickness (400N/mm ²)	mm	2,0	1,5	1,25
Motor rating	kW	0,5	0,5	0,5
Net weight	kg	180	215	255
Hardened rolls	On request			



BENDING ROLLS MBE

A manually operated machine with the reduction gear assembly and the roll drive gear located on the left-hand side. This makes it possible to work clockwise, no matter whether the reduction gear is used or not. The top roll can be swung out for removal of the workpiece. The lower roll is adjusted using a handwheel. This roll as well as the bending roll have four different slots for the bending of wire. The setting of the bending rolls is via a worm gear. The bending roll can also be set diagonally for cone bending. 8905 is as standard a bench model but can be equipped with a stand made of tubular steel.

Ref. No	8905	-0058	-0108	-4100
Size		6/15	10/10	10/12
Reduction gear		excl.	incl.	incl.
Working length	mm	675	1020	1020
Diameter of rolls	mm	50	50	55
Max sheet thickness (400 N/mm ²)	mm	1,5	1,0	1,2
Net weight	kg	90	115	125
Options				
Stand	8905	-0173	-0207	-0207
Hardened rolls	On request			



BENDING ROLLS MBK

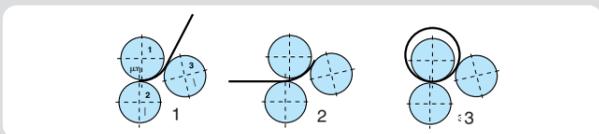
A manually operated machine with rolls (tensile strength 700 N/mm²) of centerless ground steel with reduction gear assembly, which can easily be disengaged. The top roll can easily be swung out for the removal of finished piping. The lower roll is adjusted by means of a handwheel on the right-hand side of the machine. The rear roll is adjusted by a lever and a replaceable gear segment. The bending roll can also be set diagonally for cone bending. The lower and rear rolls have four different slots for the bending of wire.

MBK is as standard a bench model but can be equipped with a stand made of tubular steel.

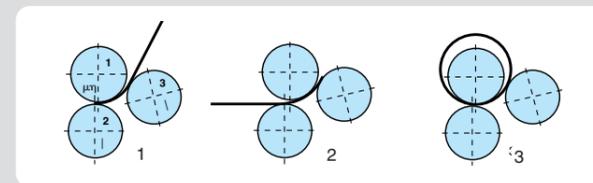
Ref. No	4132	-0102	-0201	-0300
Size		6/20	10/15	12/12
Working length	mm	675	1010	1260
Diameter of rolls	mm	60	60	60
Max sheet thickness (400N/mm ²)	mm	2,0	1,5	1,25
Net weight	kg	140	175	215
Options				
Stand	4132	-0458	-0508	-0607
Hardened rolls	On request			

MBF - 6/15, 10/10, 10/12. Motor-powered with stand

The MBF, is delivered complete with motor 220/380V 3-phase, stand as well as foot-operated forward/reverse switch with protecting casing-protection form IP54. Motorrating: 0,37kW. Working speed: 5,4-5,9 m/min. In CE-execution machine is equipped with emergency stop, brake motor and trip wire.

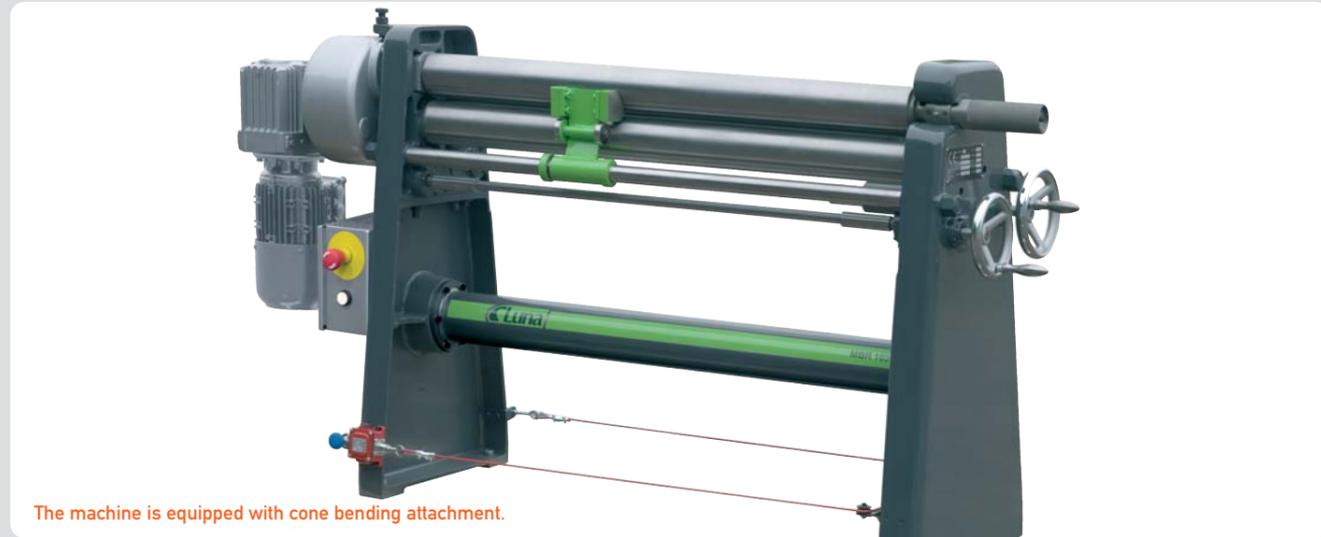


Prebending in bending rolls Luna MBA, MBK, MBL, MBR, MBE and MBF. Prebending can be carried out in all machines with asymmetrically mounted rolls. When bending a sheet a straight part is always left at the beginning of the sheet. One way of avoiding this straight part is to prebend the sheet.



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The machine is equipped with cone bending attachment.

BENDING ROLLS MBR

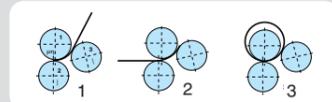
A motor-powered modern machine with rolls in needle bearings. All rolls have tensile strength of 700 N/mm² and are crowned to ensure even pressure between the rolls along the length of the machine. The setting of the upper and lower rolls is by handwheels via wormgears. The upper and lower rolls are driven by a worm gear motor. All transmission is built into one side of the machine – thus it is easy to swing out the upper roll for removal of the workpiece. Working speed – 3,8-4,8 m/min. 8266 is delivered complete with 230/400 V, 3-phase motor, a foot-operated forward and reverse switch with a protective casing – protection form IP54 – and also scales for the position of the bending roll. In CE execution the machine is equipped with emergency stop, trip wire and brake motor.

Ref. No	8266	-0127	-0143	-0168	-0184	-0010	-0028	-0036	-0044	-0051	-0069	-0077
Size		10/25	12/20	15/15	20/10	10/30	12/25	15/20	20/15	10/40	12/35	15/30
Working length	mm	1040	1290	1540	2040	1040	1290	1540	2040	1040	1290	1540
Max sheet thickness*	mm	2,5	2,0	1,5	1,0	3,0	2,5	2,0	1,5	4,0	3,5	3,0
Diameter of rolls	mm	80	80	80	80	90	90	90	90	100	100	100
Motor rating	kW	0,75	0,75	0,75	0,75	0,75	0,75	0,75	0,75	1,1	1,1	1,1
Net weight	kg	400	440	480	560	440	490	530	625	665	725	785

Ref. No	8266	-0085	-0093	-0101	-0200	-0309	-0507	-0549	-1208	-1307	-1406	-1505
Size		20/20	25/10	10/50	12/45	15/40	20/25	25/15	10/55	12/50	15/45	20/30
Working length	mm	2040	2540	1040	1290	1540	2040	2540	1040	1290	1540	2040
Max sheet thickness*	mm	2,0	1,0	5,0	4,5	4,0	2,5	1,5	5,5	5,0	4,5	3,0
Diameter of rolls	mm	100	100	110	110	110	110	110	120	120	120	120
Motor rating	kW	1,1	1,1	1,1	1,1	1,1	1,1	1,1	1,1	1,1	1,1	1,1
Net weight	kg	905	1025	700	770	840	975	1110	745	825	905	1060

Ref. No	8266	-1554	-1604	-1703	-1802	-1901	-1950	-2008	-2107	-2206	-2305	-2424
Size		25/20	10/60	12/55	15/50	20/35	25/25	10/65	12/60	15/55	20/40	25/30
Working length	mm	2540	1040	1290	1540	2040	2540	1040	1290	1540	2040	2540
Max sheet thickness*	mm	2,0	6,0	5,5	5,0	3,5	2,5	6,5	6,0	5,5	4,0	3,0
Diameter of rolls	mm	120	130	130	130	130	130	140	140	140	140	140
Motor rating	kW	1,1	2,2	2,2	2,2	2,2	2,2	2,2	2,2	2,2	2,2	2,2
Net weight	kg	1225	960	1055	1140	1320	1500	1015	1120	1220	1425	1630

* 400 N/mm²



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Options



Digital Display
The machine can also be equipped with digital display.



Cone bending attachment with trailing shoe
To facilitate cone bending on the 8266 the machine can be delivered with diagonal setting of the bending roll. The trailing shoe is provided with hardened and ground lugs. The design allows many cones to be produced. The trailing shoe can also be dropped and set along the whole length of the machine.



Pivoting Top Roll
Pivoting top roll for easy removal of finished workpieces. Standard.



Control Panel
When the machine is required with either a powered bending roll, and/or powered lower roll, it is recommended that the machine is also fitted with a portable control.



Special Rolls
For special applications the machines can be equipped with rolls which have a hardened and ground surface, rolls with grooves or adiprene coating.

Optional equipment	Diameter of rolls		
	ø 80-90 mm	ø 100-110-120 mm	ø 130-140 mm
Cone bending attachment	8266-0556	8266-0606	8266-0606
Handwheel w. dial register	8266-4780	8266-4780	8266-4780
Motor-powered bending roll	8266-0804	8266-0903	8266-3006
Motor-powered lower roll	8266-3055	8266-4004	8266-4004
Portable control panel	8266-4152	8266-4202	8266-4202
Frequency control	8266-4301	8266-4400	8266-4509
Digital readout Hardened rolls, Adiprene coated rolls	On request		

LUNA BENDING ROLLS



BENDING ROLLS MBS Symetric Rolls

MBS is a simple, robust and manually operated machine made of cast iron. All rolls (tensile strength 700 N/mm²) are crowned to ensure identical bendings. The lower rolls are fixed mounted while the upper roll is adjustable by means of two screw spindles and can be set for cone bending. One side bracket can be bent outwards for the removal of finished piping. On special request the machine can be provided with cone bending attachment.

Ref. No	8263	-0104	-0203	-0302	-0609	-0708	-0807	-1102	-1201	-1300	-1607	-1706	-1805	-2100	-2209	-2308
Size	10/35	10/50	10/60	12/30	12/40	12/50	15/25	15/35	15/40	17/15	17/25	17/30	20/10	20/15	20/20	
Working length	mm	1020	1020	1020	1270	1270	1270	1525	1525	1525	1770	1770	1770	2020	2020	2020
Max sheet thickness (400 N/mm ²)	mm	3,5	5,0	6,0	3,0	4,0	5,0	2,5	3,5	4,0	1,5	2,5	3,0	1,0	1,5	2,0
Diameter of rolls	mm	90	100	110	90	100	110	90	100	110	90	100	110	90	100	110
Net weight	kg	295	410	460	330	450	510	355	490	560	400	530	610	435	570	660
Options																
Hardened rolls	On request															



BENDING ROLLS MBT Symetric Rolls

MBT is like the MBS in the design and is motor-powered and delivered complete with motor 220/380 V 3-phase as well as foot-operated forward and reverse switch with a protective casing – protection form IP54. In CE execution the machine is equipped with emergency stop, trip wire and brake motor. On special request the machine can be provided with cone bending attachment.

Ref. No	8264	-0103	-0202	-0301	-0400	-0509	-0608	-0707	-0806	-0905	-1002	-1101	-1200	-1309	-1408	-1507
Size		10/35	10/50	10/60	10/70	10/80	12/30	12/40	12/50	12/60	12/70	15/25	15/35	15/40	15/50	15/60
Working length	mm	1020	1020	1020	1020	1020	1270	1270	1270	1270	1270	1525	1525	1525	1525	1525
Max sheet thickness (400 N/mm ²)	mm	3,5	5,0	6,0	7,0	8,0	3,0	4,0	5,0	6,0	7,0	2,5	3,5	4,0	5,0	6,0
Diameter of rolls	mm	90	100	110	120	130	90	100	110	120	130	90	100	110	120	130
Motor rating	kW	0,75	1,1	1,1	1,5	1,5	0,75	1,1	1,1	1,5	1,5	0,75	1,1	1,1	1,5	1,5
Net weight	kg	310	430	480	670	725	345	470	530	730	795	380	510	580	790	865

Ref. No	8264	-1606	-1705	-1804	-1903	-2000	-2109	-2208	-2307	-2406	-2505	-	-	-
Size		17/15	17/25	17/30	17/40	17/50	20/10	20/15	20/20	20/30	20/40	25/10	25/15	25/20
Working length	mm	1770	1770	1770	1770	1770	2020	2020	2020	2020	2020	2520	2520	2520
Max sheet thickness (400 N/mm ²)	mm	1,5	2,5	3,0	4,0	5,0	1,0	1,5	2,0	3,0	4,0	1,0	1,5	2,0
Diameter of rolls	mm	90	100	110	120	130	90	100	110	120	130	110	120	130
Motor rating	kW	0,75	1,1	1,1	1,5	1,5	0,75	1,1	1,1	1,5	1,5	1,1	1,5	1,5
Net weight	kg	415	550	630	850	835	450	590	680	910	1005	780	1030	1145
Options														
Hardened rolls	On request													