



Technologically  
Advanced

## 4 Rolls Double Pinch Linear Guides

**4HEL** is the most precise and easiest to use series of **4-roll bending rolls** with total pre-bending. Highly technological and innovative, 4HEL bending rolls assure high-productivity with a speed 3/4 times higher than a traditional **pyramid bending roll**. Moreover, thanks to their production methods, the **4HEL bending rolls** can be effectively controlled through numerical control systems.

All models of **Faccin's 4HEL 4-roll bending rolls** are equipped with a rear side roll opposite the feeding side. Used as backing, this roll allows the plate to be rolled to be aligned in an immediate and accurate manner. The plate, moreover, always remains pinched between the two central rolls, thus avoiding accidental slips. This not only optimises pre-bending and rolling operations, but it also assures safer and more precise machining, with the option of being handled entirely by a single operator.

### At a Glance:

- ▣ With the **Linear guide configuration**, the pre-bending operation does not require tilting the plate below the feeding level so horizontal feeding tables may be used, for easier feeding of the plate into the machine.
- ▣ **No need to leave free space on both sides** of the machines, but only at the selected infeed side.
- ▣ The plate can be rolled to the desired diameter immediately after the first pre-bending which is followed by the second end forming, i.e. the second pre-bending. **This processing method** enables the cylindrical ferrule to be made in one pass.
- ▣ **Cone bending processing made easier** by tilting the side rolls and the central roll to respectively set the cone angle and drag the sheet at its largest development.
- ▣ **4HEL series CNC bending rolls** - designed and built by Faccin - are the best solution to bend plates of length between 1500 and 18000 mm with thickness 5 to 150 mm.

The Trusted Partner in  
Metal Forming Machines

### Standard equipment

- ❑ Linear guides for roll motion (RGS)
- ❑ 4 independent bearings supporting the lower rolls (MCS)
- ❑ Bearing seats with double width (WHS)
- ❑ Electronic synchronisation of roll parallelism (EPS)
- ❑ Hardened and polished rolls
- ❑ SIEMENS numerical control
- ❑ Mobile wheel mounted control console
- ❑ Conical device
- ❑ Centralised manual lubrication (pump)
- ❑ Emergency barrier around the machine
- ❑ CE certified machine

### Optional features

- ❑ Side motorised rolls
- ❑ Automatic loading and unloading systems
- ❑ Motorised feeding table
- ❑ Automatic ejector
- ❑ Central and side supports
- ❑ Provision for hot rolling
- ❑ Version with planetary guides (4HEP)
- ❑ Integrated welding system
- ❑ Special colours



Model/Size	Plate mm	Rolling mm	Prebend mm	Top Roll Min. mm	Pinch Roll Min. mm	Side Rolls Min. mm	Rolling Power Hp	Weight Kg	Dimensions mt
4HEL 201	2000	6	5	160	150	130	7	2.500	4,1x1,2x1,3
4HEL 202	2000	10	8	210	180	160	12,5	4.500	4,6x1,3x1,4
4HEL 251	2500	5	4	180	150	130	7	2.900	4,6x1,2x1,3
4HEL 252	2500	8	6	210	180	160	12,5	5.000	5,1x1,3x1,4
4HEL 253	2500	14	10	270	250	190	15	7.700	5,3x1,4x1,5
4HEL 254	2500	20	14	320	300	230	25	10.000	5,5x1,7x1,8
4HEL 301	3000	7	5	210	180	160	12,5	5.000	5,5x1,3x1,4
4HEL 302	3000	12	8	270	250	190	15	8.000	5,7x1,4x1,5
4HEL 303	3000	16	13	320	300	230	25	12.000	5,8x1,7x1,8
4HEL 304	3000	25	20	370	350	250	30	17.000	5,9x2,1x2,2
4HEL 305	3000	30	25	400	390	290	40	21.000	6,1x2,4x2,3
4HEL 306	3000	35	30	430	420	320	50	27.000	6,3x2,5x2,5
4HEL 307	3000	40	35	460	440	360	60	30.000	7,1x2,6x2,6
4HEL 308	3000	55	45	520	490	420	80	42.000	7,5x2,7x2,8
4HEL 309	3000	70	60	630	620	540	130	59.000	8,1x3,3x3,3
4HEL 310	3000	85	75	730	710	620	150	68.000	8,6x3,6x3,6
4HEL 401	4000	7	5	270	250	190	15	9.500	6,8x1,4x1,5
4HEL 402	4000	10	8	320	300	230	25	14.000	6,7x1,7x1,8
4HEL 403	4000	15	12	370	350	250	30	18.000	6,9x2,1x2,2
4HEL 404	4000	18	16	400	390	290	40	22.500	7,2x2,4x2,3
4HEL 405	4000	22	18	430	420	320	50	31.000	7,5x2,5x2,5
4HEL 406	4000	26	22	460	440	360	60	36.000	8,2x2,6x2,6

SPECIAL SIZES AND CAPACITIES AVAILABLE UPON REQUEST. PLEASE SEND US YOUR INQUIRIES.

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