standard equipment

- Two digital read-outs
- Control panel on wheels
- With three driven rolls

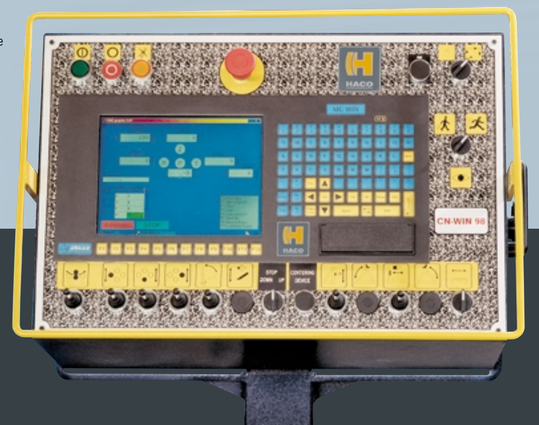
options

- Rolls for round tube
- Rolls for special profiles
- Rolls for channels easy-way
- Special rolls for IPE – IPN – HE
- Special modular rolls for square
- Double-groove rolls for round tube, maximum 150 mm
- Pressure roll for channels and H-beams
- Tooling for simultaneous forming and bending
- Compression tooling for bending UNP profiles
- Universal tooling hydraulic adjustment
- Universal tooling numerical control
- Heat exchanger
- Numerical control MG WIN 98
- CNC Windows 98 pro

CNC-control

Programming process is among the easiest in the industry. Simple and intuitive, it is without comparison. It works following the most standard working platforms. There is an auto-teaching system that allows you to record all the steps of a program by simply rolling the part manually. All ranges of the profiles are graphically filed inside the program for quick and easy selection. After the program has been done, the graphic program shows the bending layout to give a precise idea of how the part will look.

- 500 MGz Graphic Central Processing Unit on Industrial PC, integrated on the machine control panel
- 10,5" LCD display
- IP55 protected keyboard
- 3,5" floppy disk driver on control panel
- Network connectable
- Internet connectable (upon request)
- Exclusive software developed for specific bending needs



HACO

for impressive performances

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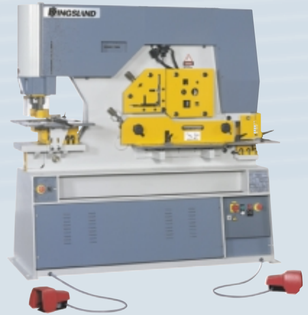
large sheetworking programme

HYDRAULIC PRESSBRAKES
conventional
and CNC controlled

HYDRAULIC SHEARS
conventional
and CNC controlled
up to 32 mm

HYDRAULIC STEELWORKERS
4 and 5 station universal steelworkers for punching, shearing flat, angle and bar cutting, notching up to 1600 kN



ANGLE NOTCHERS
fix and variable angle up to 6 mm

visual: +32 (0)51/22 92 1

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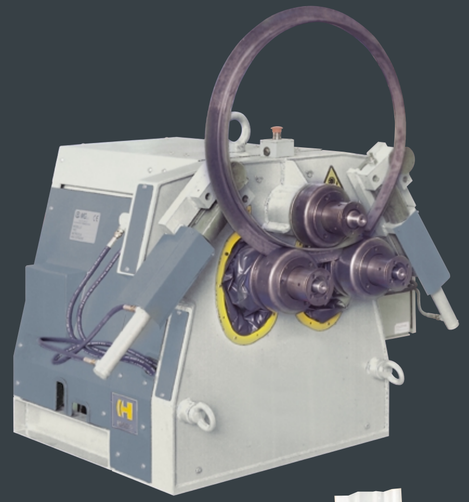
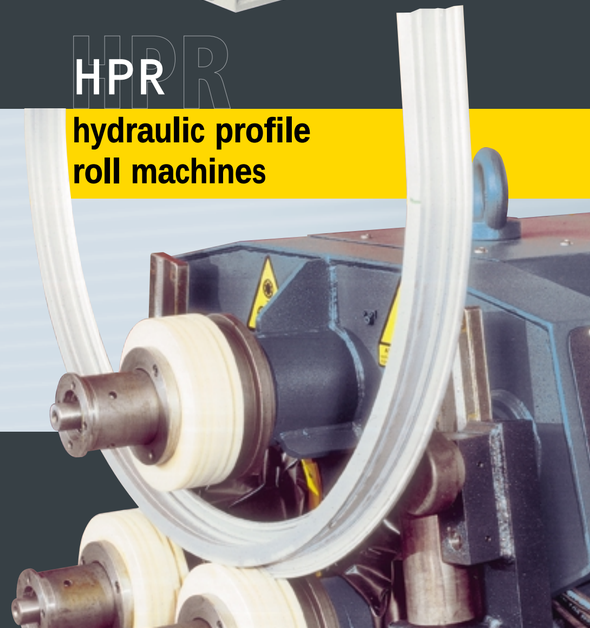


HPR

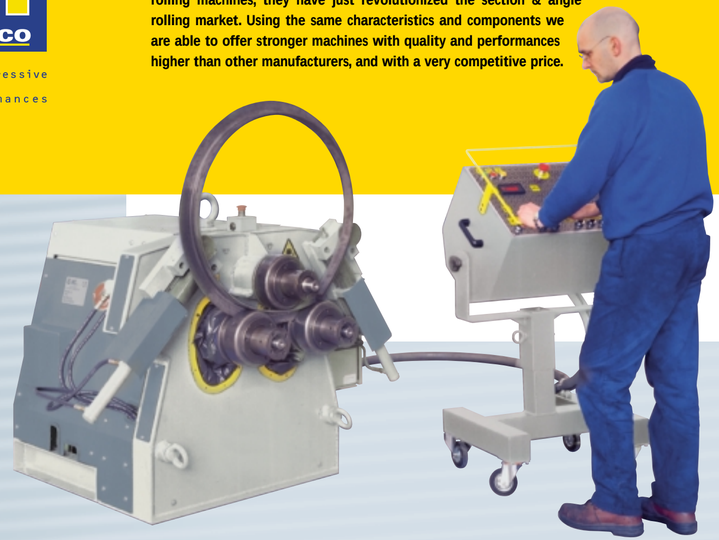
hydraulic profile roll machines



HPR SERIES

for impressive performances

Using the same technology incorporated in their famous 3 & 4-roll plate rolling machines, they have just revolutionized the section & angle rolling market. Using the same characteristics and components we are able to offer stronger machines with quality and performances higher than other manufacturers, and with a very competitive price.



- **Heavy steel manufactured frames**, machined on CNC machining centers to insure extreme accuracy.
- **Three driven rolls**, each with an independent hydraulic planetary motor. Eliminating secondary gearing, connecting arms, chains, synchronisation devices and clutches.
- **Two forming rolls** for reduction of flat ends.
- **Double roll spherical bearing** (SKF or equal) for maximum rigidity.
- **Hydraulic motors** attached directly to each planetary drive, eliminating the loss of torque.
- **Tooling is modular**, it can be configured to roll most standard sections. For rolling pipe, tube, beams or channels the hard way, special tooling can be ordered.

for impressive performances

Legend

- • Bending with standard rolls – 1 set of rolls for each pipe diameter
- * Rolling with special tooling
- ‡ For thin parts or very small radius special rolls are needed
- # Normal series

		MODEL	HPR60 dimensions	HPR60 inside Ø	HPR80 dimensions	HPR80 inside Ø	HPR110 dimensions	HPR110 inside Ø	HPR140 dimensions	HPR140 inside Ø	HPR160 dimensions	HPR160 inside Ø	HPR180 dimensions	HPR180 inside Ø	HPR200 dimensions	HPR200 inside Ø	HPR250 dimensions	HPR250 inside Ø
1	•		70 x 10 25 x 5	1.400 250	90 x 20 25 x 5	1.200 300	100 x 25 40 x 8	1.200 330	140 x 25 50 x 10	1.800 450	150 x 40 50 x 10	1.500 540	170 x 40 50 x 10	1.800 600	180 x 45 80 x 10	1.800 700	200 x 50 80 x 10	1.800 850
2	•		100 x 20	1.400	140 x 30	1.000	180 x 35	1.000	200 x 50	1.600	250 x 60	1.500	250 x 60	1.800	350 x 60	2.000	400 x 70	2.000
3	•		38	400	50 x 50	600	60	750	80	1.000	95	1.200	105	1.350	115	1.500	125	1.800
4	•		35	380	60	500	75	750	100	1.100	110	1.100	125	1.300	135	1.350	150	1.700
5			80 x 2 25 x 1,5	1.200 300	120 x 3 25 x 1,5	2.000 400	140 x 3 50 x 2	2.800 450	180 x 4 60 x 2	4.000 550	200 x 4 60 x 2	4.000 550	240 x 5 60 x 2	6.000 700	275 x 5 60 x 2	8.000 800	320 x 5 100 x 3	10.000 1.300
6			60,3 x 4 48,3 x 4	600 400	88,8 x 5 76,1 x 8	900 600	114,3 x 5 88,9 x 10	1.200 900	168 x 5,4 114 x 16	2.000 1.300	159 x 5,5 21,3	1.400 500	193,7 x 8 139 x 20	2.300 1.100	219,1 152,4	3.500 1.300	273 x 7,1 152 x 35	4.200 1.400
7	•‡		75 x 25 x 3		100 x 40 x 4		120 x 50 x 4	Ø 2.000	160 x 60 x 6	Ø 2.500	180 x 70 x 8	Ø 2.400	200 x 75 x 8	Ø 4.000	220 x 80 x 8	Ø 5.000	230 x 100 x 10	Ø 6.000
8	•‡		50 x 4	Ø 1.500	70 x 70 x 4	Ø 1.500	80 x 5	Ø 2.000	100 x 10	Ø 3.500	125 x 10	Ø 3.500	150 x 10	Ø 6.000	165 x 10	Ø 6.000	180 x 12	Ø 10.000
9	•		70 x 70 x7 30 x 4	700 650	90 x 90 x 10 30 x 4	1.000 460	100 x 100 x 12 40 x 5	1.120 520	140 x 15 50 x 5	1.400 720	150 x 16 50 x5	1.500 720	180 x 18 60 x 6	1.800 920	200 x 20 60 x 6	2.200 1.000	200 x 25 80 x 8	2.500 1.300
10	•		60 x 60 x 6 30 x 4	600 500	80 x 80 x 8 30 x 4	900 750	100 x 100 x 10 40 x 5	2.500 400	140 x 12 50 x 5	2.300 580	150 x 14 50 x 5	1.500 550	180 x 15 60 x 6	3.000 780	200 x 18 60 x 6	4.000 800	200 x 20 80 x 8	3.000 1.100
11	•#		70	800	90	800	100	1.000	135	1.400	150	1.600	160	1.900	200	2.200	225	2.500
12	•		60	800	90	800	90	1.000	120	1.400	150	1.600	150	1.900	180	2.200	200	2.500
13	•		80	800	90	800	120	1.200	140	1.500	150	1.600	170	2.200	220	2.500	230	3.000
14	•		100 x 50	800	140 x 55	650	180 x 700	800	260 x 90	1.000	300 x 100	1.400	360 x 150	1.300	425 x 150	1.400	475 x 150	1.500
15	•		100 x 50	800	140 x 55	650	180 x 70	1.000	220 x 80	1.000	300 x 100	1.500	360 x 150	1.500	425 x 150	1.400	475 x 150	2.500
16	•	INP			140 x 58	700	180 x 82	1.100	180 x 82	1.300	300 x 125	1.400	360 x 143	1.200	425 x 163	1.200	450 x 170	1.500
17	•	HE					A: 120 B: 100	A: 1.000 B: 1.200	A: 180 B: 160 M: 120	A: 1.800 B: 1.500 M: 1.400	A: 200 B: 180 M: 140	A: 2.500 B: 1.800 M: 1.400	A: 220 B: 200 M: 160	A: 2.500 B: 2.000 M: 2.000	A: 240 B: 220 M: 180	A: 2.700 B: 2.500 M: 2.500	A: 280 B: 240 M: 200	A: 3.000 B: 3.000 M: 2.800
18	*	UNP					120 x 55 80 x 45	3.400 1.600	160 x 65 80 x 45	4.500 1.600	180 x 70 80 x 45	5.000 1.600	200 x 75 100 x 50	6.000 2.000	220 x 80 100 x 50	7.500 2.000	260 x 90 120 x 55	10.000 2.000
19	*	INP					140 x 66 80 x 42	2.400 1.200	180 x 82 120 x 66	2.800 1.500	200 x 90 120 x 66	2.800 1.500	220 x 98 120 x 66	3.000 1.500	260 x 113 140 x 66	3.500 1.800	300 x 125 140 x 66	4.000 1.800
20	*	HE					A: 100	A: 2.200	A: 140 B: 120	A: 3.000 B: 1.400	A: 160 B: 140 M: 100	A: 3.000 B: 2.500 M: 1.500	A: 180 B: 160 M: 120	A: 6.000 B: 2.400 M: 1.600	A: 200 B: 180 M: 140	A: 7.000 B: 4.800 M: 2.000	A: 240 B: 220 M: 160	A: 9.000 B: 7.000 M: 3.000
		W cm³	10		30		50		130		160		200		250		300	
		min./speed	5		5		5		5		5		5		5		5	
		HP power	3		4		7,5		15		18,5		22		30		45	
		shafts diameter	60		80		110		140		160		190		210		250	
		rolls diameter	215		265		350		400		485		580		650		680	
		weight	920		1.650		2.950		4.000		6.800		13.200		24.000		29.000	
		length x width x height	1.284 x 1.075 x 940		1.535 x 1.378 x 1.220		1.779 x 1.622 x 1.501		2.030 x 1.802 x 1.637		2.100 x 2.100 x 1.965		3.084 x 2.887 x 2.563		3.325 x 3.125 x 2.845		3.900 x 2.980 x 2.850	

Specifications can be changed without prior notice.