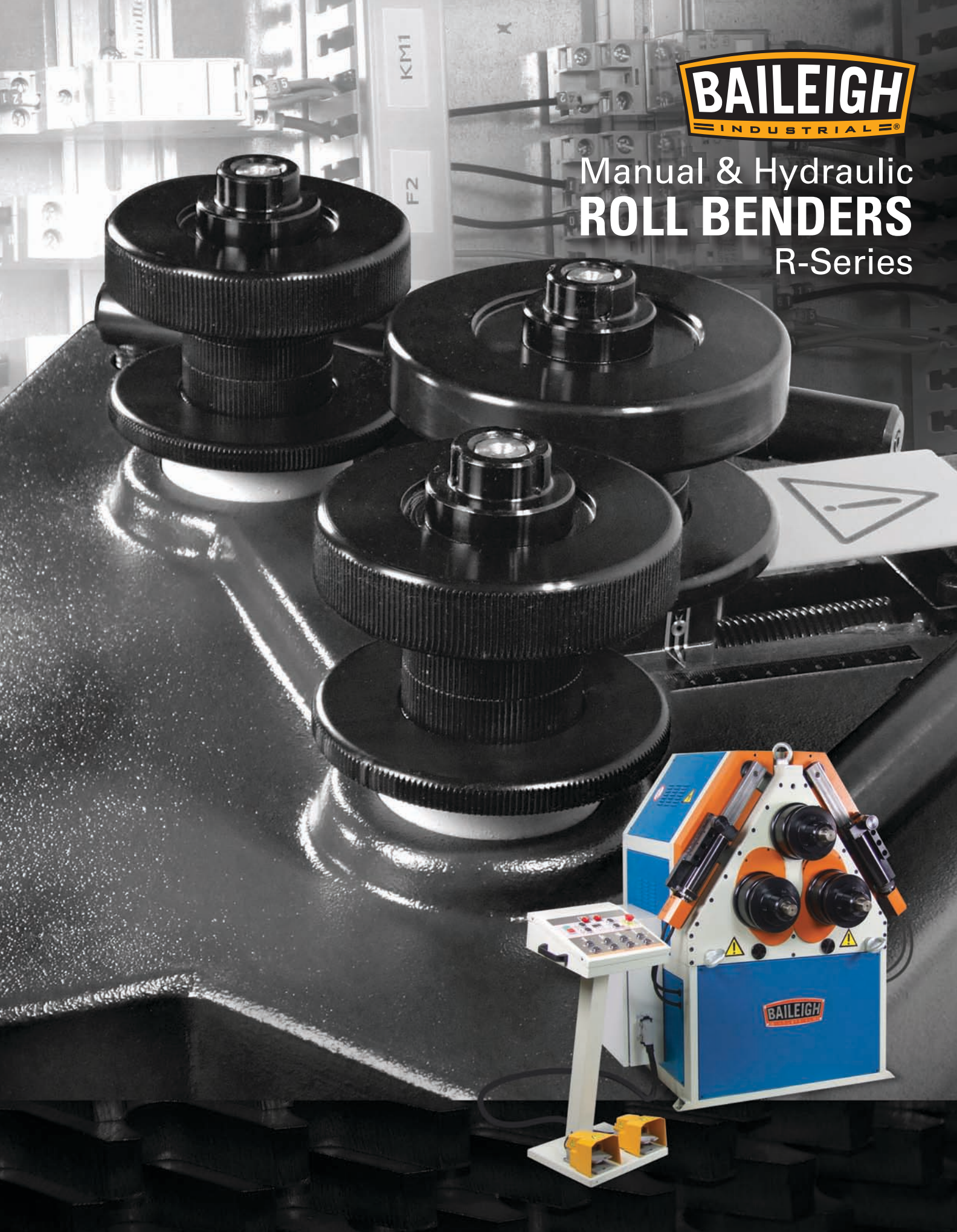




Manual & Hydraulic  
**ROLL BENDERS**  
R-Series



# ROLL BENDING MACHINES

The roll bender line consists of manual or electronic driven single pinch models and hydraulic driven double pinch models with two hydraulic bottom rolls. We have a very diverse line of angle roll bending machines to bend tube, pipe, angle iron, solids, squares, and much more.

## Manual Benders

The manual roll bender line consists of three manually driven ring roll benders for bending up to 2 inch tubing. These are great bending machines for the hobbyist or metal artist.

## Manual Top Roll Benders with Electric Drive

These models have greater capacities and are easier to operate with two driven bottom rolls. These powered machines can bend vertically or horizontally for larger section angle bends. All versions in this category have manually adjusted top rolls and are considered single pinch style machines.

## Hydraulic Top Roll Benders with Electric Drive

The roll benders in this category have three driven rolls for extra power. These machines are perfect for production fabrication settings where the fabricator is making hay hoops, spiral stair cases, and much more.

## Double Pinch Angle Roll Benders

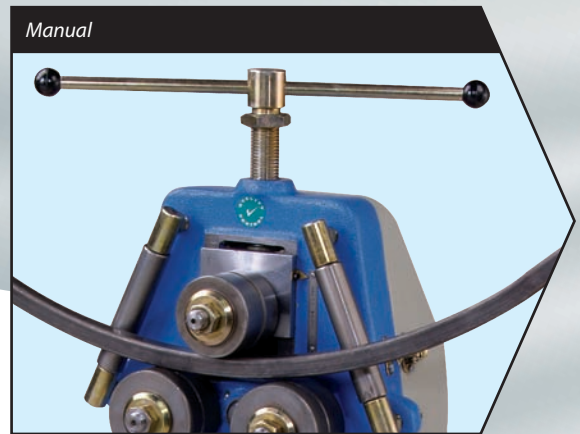
This category offers hydraulically driven roll benders with hydraulic positioning of the two bottom rolls that are coupled to two separate digital readouts. These machines have three hydraulically driven rolls, hydraulically positioning bottom roll, as well as hydraulically driven lateral guide rolls. These machines are for bigger section bending projects or structural applications. A double pinch bender allows the operator to pre-bend and post-bend the material, saving the fabricator time and money.

## Special Orders

Looking for something bigger or more specialized for your application? Let Baileigh take care of those needs as well. We will build to suit almost any need.

**BAILEIGH MEANS . . .  
PRECISION. PERFORMANCE.  
PERFECTION.**

Manual



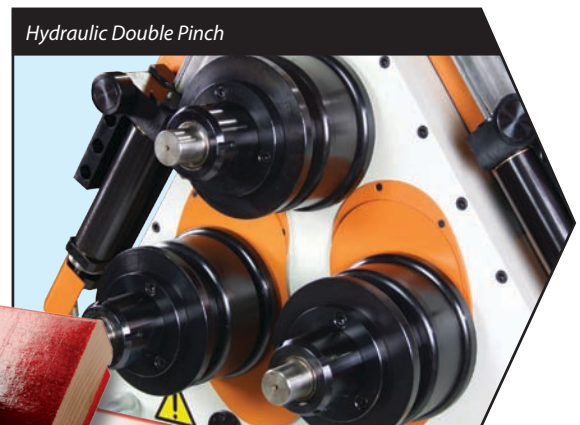
Manual Top Roll



Hydraulic Top Roll



Hydraulic Double Pinch



# R-M7

## Small in Size – Portable

The R-M7's small size makes it highly portable and versatile. Although not for rolling circles, it makes quick work of large radius bends.

- ◆ Manual Adjustment of Top Roll
- ◆ Manually Powered
- ◆ Portable
- ◆ Includes 1-1/2" Pipe Tooling
- ◆ Quick Change Lower Rolls
- ◆ Excellent for Ornamental Applications, not Intended for Circles
- ◆ Many Optional Tooling Sets Available



SPECIFICATIONS – Model R-M7, Radius Bender*		
Capacity	Size	Min. Radius
Pipe	1.5" / 48 mm	20" / 508 mm
Round Tube	2" / 50 mm	60" / 1,524 mm
Square Tube	2" / 50 mm	70" / 1,778 mm
Rectangle Tube	1 x 2" / 25 x 50 mm	10" / 254 mm
Flat Bar		
Easy Way	1.25" / 32 mm	10" / 254 mm
Roll Adjustment	Manual	
Pinch	Single	
Shaft Center Distance	Adj. (lower rolls)	
Driven Rolls	1	
Speeds	n/a	
Motor	n/a	
Power Requirement	Manual	
Shipping Weight	150 lbs. / 68 kgs.	

\*Not for circles

All Specs based on 60,000PSI (42 Kg/mm2) Tensile Strength – Mild Steel.

# R-M10

## Manual Drive System

The R-M10 roller has a powerful manual drive system that allows for complete rings.

- ◆ Manual Adjustment of Top Roll
- ◆ Manually Powered
- ◆ Great for Doing Complete Circles
- ◆ Hardened Standard Tooling for Long Life
- ◆ A Wide Array of Optional Tooling Sets are Available



SPECIFICATIONS – Model R-M10		
Capacity	Size	Min. Dia.
Pipe	1" (sch. 40) / 33 (3) mm	28" / 711 mm
Round Tube	1.25" (.078") / 32 (2) mm	31.5" / 800 mm
Square Tube	1.2" (.078") / 30 (2) mm	35" / 889 mm
Angle Iron	1.25" (.157") / 32 (40) mm	30" / 762 mm
Solid Square	.75" / 19 mm	20" / 508 mm
Solid Round	.875" / 22 mm	20" / 508 mm
Flat Bar		
Easy Way	2" / 50 mm	15.75" / 400 mm
Hard Way	.75" / 19 mm	6.5" / 165 mm
Roll Adjustment	Manual	
Pinch	Single	
Shaft Diameter	1.181" / 30 mm	
Roll Diameter		
Upper	3.86" / 98 mm	
Lower	4.65" / 115 mm	
Shaft Center Distance	6.7" / 170 mm (lower rolls)	
Driven Rolls	2" / 50 mm	
Speeds	n/a	
Motor	n/a	
Power Requirement	Manual	
Shipping Dimensions (L x W x H)	60" x 44" x 68" / 1,524 x 1,118 x 1,727 mm	
Shipping Weight	435 lbs. / 197 kgs.	

All Specs based on 60,000PSI (42 Kg/mm2) Tensile Strength – Mild Steel.

# R-M40

## Versatile

The R-M40 metal ring roller is perfect for rolling various sections such as hoops, coils of tubing, stair railing pipe, and much more.

- ◆ Manual Adjustment of Top Roll via Ratchet
- ◆ Inverter Driven
- ◆ Variable Speed
- ◆ Overload Protected
- ◆ Includes Hardened Standard Rolls
- ◆ Head Tilts for Vertical and Horizontal Bending
- ◆ Foot Pedal Controlled
- ◆ Many Optional Tooling Sets Available



SPECIFICATIONS – Model R-M40		
Capacity	Size	Min. Dia.
Pipe	1.5" (sch. 40) / 48 (3.6) mm	28" / 711 mm
Round Tube	2" (.078") / 50 (2) mm	27.55" / 700 mm
Square Tube	1.5" (.083") / 38 (2.1) mm	39" / 991 mm
Angle Iron	1.5" (.1875") / 38 (4.7) mm	22" / 558 mm
Solid Square	1.25" / 32 mm	20" / 508 mm
Solid Round	1.375" / 35 mm	24" / 610 mm
Flat Bar		
Easy Way	3" (.5") / 76 (13) mm	15.75" / 400 mm
Hard Way	2.25" (.375") / 57 (9.5) mm	20" / 508 mm
Roll Adjustment	Manual	
Pinch	Single	
Shaft Diameter	1.181" / 30 mm	
Roll Diameter		
Upper	5.118" / 130 mm	
Lower	5.118" / 130 mm	
Shaft Center Distance	10.88" / 276 mm (lower rolls)	
Driven Rolls	2	
Speeds	10.6 – 21.2 rpm. (variable)	
Motor	1.5 hp.	
Power Requirement	220V – 1 ph. — 50/60 hz.	
Shipping Dimensions (L x W x H)	60" x 44" x 68" / 1,524 x 1,118 x 1,727 mm	
Shipping Weight	560 lbs. / 254 kgs.	

All Specs based on 60,000PSI (42 Kg/mm<sup>2</sup>) Tensile Strength – Mild Steel.

# R-M55

## Built To Last

The R-M55 ring roll bender is a robustly built and powerful pipe roller capable of bending up to 2" Schedule 40 pipe.

- ◆ Manual Adjustment of Top Roll
- ◆ Inverter Driven
- ◆ Variable Speed
- ◆ Overload Protected
- ◆ Includes Hardened Standard Rolls
- ◆ Vertical and Horizontal Bending
- ◆ Foot Pedal Controlled
- ◆ Many Optional Tooling Sets Available



SPECIFICATIONS – Model R-M55		
Capacity	Size	Min. Dia.
Pipe	2" (sch. 40) / 60 (4) mm	40" / 1,016 mm
Round Tube	2.75" (.083") / 70 (2.1) mm	60" / 1,524 mm
Square Tube	2" (.083") / 50 (2.1) mm	48" / 1,219 mm
Angle Iron	2" (.250") / 50 (6.3) mm	28" / 711 mm
Solid Square	1.375" / 35 mm	20" / 508 mm
Solid Round	1.375" / 35 mm	20" / 508 mm
Flat Bar		
Easy Way	4" (.5") / 101 (12.7) mm	20" / 508 mm
Hard Way	2.25" (.375") / 57 (9.5) mm	20" / 508 mm
Roll Adjustment	Manual	
Pinch	Single	
Shaft Diameter	1.968" / 50 mm	
Roll Diameter		
Upper	5.827" / 148 mm	
Lower	5.827" / 148 mm	
Shaft Center Distance	13.12" / 333 mm (lower rolls)	
Driven Rolls	2	
Digital Readout	n/a	
Speeds	13.6 – 27.2 rpm. (variable)	
Motor	1.5 hp.	
Power Requirement	220V – 1 ph. — 50/60 hz.	
Shipping Dimensions (L x W x H)	60" x 44" x 68" / 1,524 x 1,118 x 1,727 mm	
Shipping Weight	925 lbs. / 419 kgs.	

All Specs based on 60,000PSI (42 Kg/mm<sup>2</sup>) Tensile Strength – Mild Steel.

# R-M55H

## Economically Priced

Based on the popular R-M55, the R-M55H is perfect for the fabricator who wants a hydraulic top roll adjustment at an economical price.

- ◆ Hydraulic Adjustment of Top Roll
- ◆ Inverter Driven
- ◆ Variable Speed
- ◆ Overload Protected
- ◆ Includes Hardened Standard Rolls
- ◆ Vertical and Horizontal Bending
- ◆ Foot Pedal Controlled
- ◆ Digital Readout
- ◆ Many Optional Tooling Sets Available



### SPECIFICATIONS – Model R-M55H

Capacity	Size	Min. Dia.
Pipe	2" (sch. 40) / 60 (4) mm	40" / 1,016 mm
Round Tube	2.75" (.083") / 70 (2.1) mm	60" / 1,524 mm
Square Tube	2" (.083") / 50 (2.1) mm	48" / 1,219 mm
Angle Iron	2" (.250") / 50 (6.3) mm	28" / 711 mm
Solid Square	1.375" / 35 mm	20" / 508 mm
Solid Round	1.375" / 35 mm	20" / 508 mm
Flat Bar		
Easy Way	4" (.5") / 101 (12.7) mm	20" / 508 mm
Hard Way	2.25" (.375") / 128.5 (9.5) mm	20" / 508 mm
Roll Adjustment	Hydraulic	
Pinch	Single	
Shaft Diameter	1.968" / 50 mm	
Roll Diameter		
Upper	5.827" / 148 mm	
Lower	5.827" / 148 mm	
Shaft Center Distance	13.12" / 333 mm (lower rolls)	
Driven Rolls	2	
Digital Readout	n/a	
Speeds	13.6 – 27.2 rpm. (variable)	
Motor	1.5 hp.	
Power Requirement	220V – 1 ph. — 50/60 hz.	
Shipping Dimensions (L x W x H)	60" x 44" x 68" / 1,524 x 1,118 x 1,727 mm	
Shipping Weight	1,000 lbs. / 453 kgs.	

All Specs based on 60,000PSI (42 Kg/mm<sup>2</sup>) Tensile Strength – Mild Steel.

# R-H45

## For Tough Jobs

With three driven rolls, the R-H45 makes quick work of the hardest applications.

- ◆ Three Driven Rolls
- ◆ Hydraulic Adjustment of Top Roll
- ◆ Inverter Driven
- ◆ Variable Speed
- ◆ Overload Protected
- ◆ Includes Hardened Standard Rolls
- ◆ Vertical and Horizontal Bending
- ◆ Foot Pedal Controlled
- ◆ Digital Readout
- ◆ Many Optional Tooling Sets Available



### SPECIFICATIONS – Model R-H45

Capacity	Size	Min. Dia.
Pipe	2" (sch. 40) / 60 (4) mm	48" / 1,219 mm
Round Tube	2.75" (.083") / 70 (2.1) mm	60" / 1,524 mm
Square Tube	2" (.120") / 50 (3) mm	51" / 1,295 mm
Angle Iron	2" (.250") / 50 (6.3) mm	28" / 711 mm
Solid Square	1.375" / 35 mm	28" / 711 mm
Solid Round	1.5" / 38 mm	28" / 711 mm
Flat Bar		
Easy Way	4" (.75") / 101 (19) mm	28" / 711 mm
Hard Way	3.25" (.375")	28" / 711 mm
Roll Adjustment	Hydraulic	
Pinch	Single	
Shaft Diameter	1.772" / 45 mm	
Roll Diameter		
Upper	5.827" / 148 mm	
Lower	5.827" / 148 mm	
Shaft Center Distance	9.562" / 242 mm (lower rolls)	
Driven Rolls	3	
Digital Readout	Yes	
Speed	12 rpm.	
Motor	3 hp.	
Power Requirement	220V – 1 ph. — 50/60 hz.	
Shipping Dimensions (L x W x H)	60" x 44" x 68" / 1,524 x 1,118 x 1,727 mm	
Shipping Weight	1,188 lbs. / 538 kgs.	

All Specs based on 60,000PSI (42 Kg/mm<sup>2</sup>) Tensile Strength – Mild Steel.

# R-H55

## For the Toughest Jobs

The R-H55 takes the R-H45 to the next level, with a huge 2-1/2" Schedule 40 capacity. It will handle even the toughest jobs.

- ◆ Three Driven Rolls
- ◆ Hydraulic Adjustments of Top Roll
- ◆ Includes Hardened Standard Rolls
- ◆ Vertical and Horizontal Bending
- ◆ Foot Pedal Controlled
- ◆ Digital Readout
- ◆ Many Optional Tooling Sets Available



SPECIFICATIONS – Model R-H55		
Capacity	Size	Min. Dia.
Pipe	2.5" (sch. 40) / 73 (5) mm	40" / 1,016 mm
Round Tube	4" (.083") / 101 (2.1) mm	72" / 1,828 mm
Square Tube	2.75" (.083") / 70 (2.1) mm	54" / 1,371 mm
Angle Iron	3" (.250") / 76 (6.3) mm	36" / 914 mm
Solid Square	1.75" / 44 mm	28" / 711 mm
Solid Round	2" / 50 mm	28" / 711 mm
Flat Bar		
Easy Way	5" (.75") / 127 (19) mm	28" / 711 mm
Hard Way	3.5" (.675") / 89 (17) mm	32" / 812 mm
Roll Adjustment	Hydraulic	
Pinch	Single	
Shaft Diameter	2.165" / 55 mm	
Roll Diameter		
Upper	6.693" / 170 mm	
Lower	6.693" / 170 mm	
Shaft Center Distance	11.875" / 301 mm (lower rolls)	
Driven Rolls	3	
Digital Readout	Yes	
Speed	11 rpm.	
Motor	5 hp.	
Power Requirement	220V, 400V – 3 ph. — 50/60 hz.	
Shipping Dimensions (L x W x H)	60" x 44" x 68" / 1,524 x 1,118 x 1,727 mm	
Shipping Weight	1,728 lbs. / 783 kgs.	

All Specs based on 60,000PSI (42 Kg/mm<sup>2</sup>) Tensile Strength – Mild Steel.

# R-H85

## Double Pinch Design

The R-H85 is a great entry into large material roll bending, it's double pinch design is great for reducing waste on the ends of material.

- ◆ Three Driven Rolls
- ◆ Double Pinch
- ◆ Overload Protected
- ◆ Hydraulic Drive
- ◆ Hydraulic Lateral Angle Guides
- ◆ Includes Hardened Standard Rolls
- ◆ Vertical and Horizontal Bending
- ◆ Foot Controlled
- ◆ Digital Readout
- ◆ Many Optional Tooling Sets Available



SPECIFICATIONS – Model R-H85		
Capacity	Size	Min. Dia.
Pipe	3" (sch. 40) / 89 (5.4) mm	63" / 1,600 mm
Round Tube	4" (.120") / 101 (3) mm	118" / 2,997 mm
Square Tube	2.75" (.157") / 70 (4) mm	118" / 2,997 mm
Angle Iron	3.375" (.250") / 85 (6.3) mm	68" / 1,727 mm
Solid Square	2" / 50 mm	46" / 1,168 mm
Solid Round	2.375" / 60 mm	40" / 1,016 mm
Flat Bar		
Easy Way	5" (1") / 127 (25.5) mm	24" / 609 mm
Hard Way	4" (.787") / 101 (20) mm	83" / 2,108 mm
Roll Adjustment	Hydraulic	
Pinch	Double	
Shaft Diameter	3.15" / 80 mm	
Roll Diameter		
Upper	9.65" / 245 mm	
Lower	9.65" / 245 mm	
Driven Rolls	3	
Digital Readout	Yes	
Speed	5.2 rpm.	
Motor	10.5 hp.	
Power Requirement	220V, 400V – 3 ph. — 50/60 hz.	
Shipping Dimensions (L x W x H)	60" x 60" x 68" / 1,524 x 1,524 x 1,727 mm	
Shipping Weight	3,550 lbs. / 1,610 kgs.	

All Specs based on 60,000PSI (42 Kg/mm<sup>2</sup>) Tensile Strength – Mild Steel.

# R-H120

## A Real Workhorse

With its hydraulic angle tools and large capacity, the R-H120 is a real workhorse.

- ◆ Three Driven Rolls
- ◆ Double Pinch
- ◆ Overload Protected
- ◆ Hydraulic Drive
- ◆ Hydraulic Lateral Angle Guides
- ◆ Includes Hardened Standard Rolls
- ◆ Vertical and Horizontal Bending
- ◆ Foot Pedal Controlled
- ◆ Digital Readout
- ◆ Many Optional Tooling Sets Available



SPECIFICATIONS – Model R-H120		
Capacity	Size	Min. Dia.
Pipe	4.5" (.sch. 40) / 127 (6) mm	73" / 1,854 mm
Round Tube	5.5" (.120") / 140 (3) mm	118" / 2,997 mm
Square Tube	4" (.196") / 101 (5) mm	118" / 2,997 mm
Angle Iron	4" (.393") / 101 (10) mm	63" / 1,600 mm
Solid Square	2.375" / 60 mm	40" / 1,016 mm
Solid Round	2.75" / 70 mm	32" / 813 mm
Flat Bar		
Easy Way	7.875" (1.375") / 200 (35) mm	40" / 1,016 mm
Hard Way	4" (.984") / 101 (25) mm	63" / 1,600 mm
Roll Adjustment	Hydraulic	
Pinch	Double	
Shaft Diameter	3.937" / 100 mm	
Roll Diameter		
Upper	12.40" / 315 mm	
Lower	12.40" / 315 mm	
Driven Rolls	3	
Digital Readout	Yes	
Speed	5.5 rpm.	
Motor	5.5 hp.	
Power Requirement	220V – 3 ph. — 50/60 hz.	
Shipping Dimensions (L x W x H)	63" x 62" x 77" / 1,600 x 1,575 x 2,083 mm	
Shipping Weight	4,975 lbs. / 2,257 kgs.	

All Specs based on 60,000PSI (42 Kg/mm2) Tensile Strength – Mild Steel.

# R-H150

## Massive Capacity

The R-H150 has a massive capacity of 5-1/2" Schedule 40. It can handle almost anything thrown its way.

- ◆ Three Driven Rolls
- ◆ Double Pinch
- ◆ Overload Protected
- ◆ Hydraulic Drive
- ◆ Hydraulic Lateral Angle Guides
- ◆ Includes Hardened Standard Rolls
- ◆ Vertical and Horizontal Bending
- ◆ Foot Pedal Controlled
- ◆ Digital Readout
- ◆ Integrated Stiffening Rods
- ◆ Many Optional Tooling Sets Available

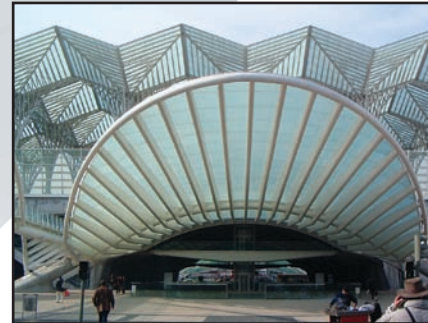
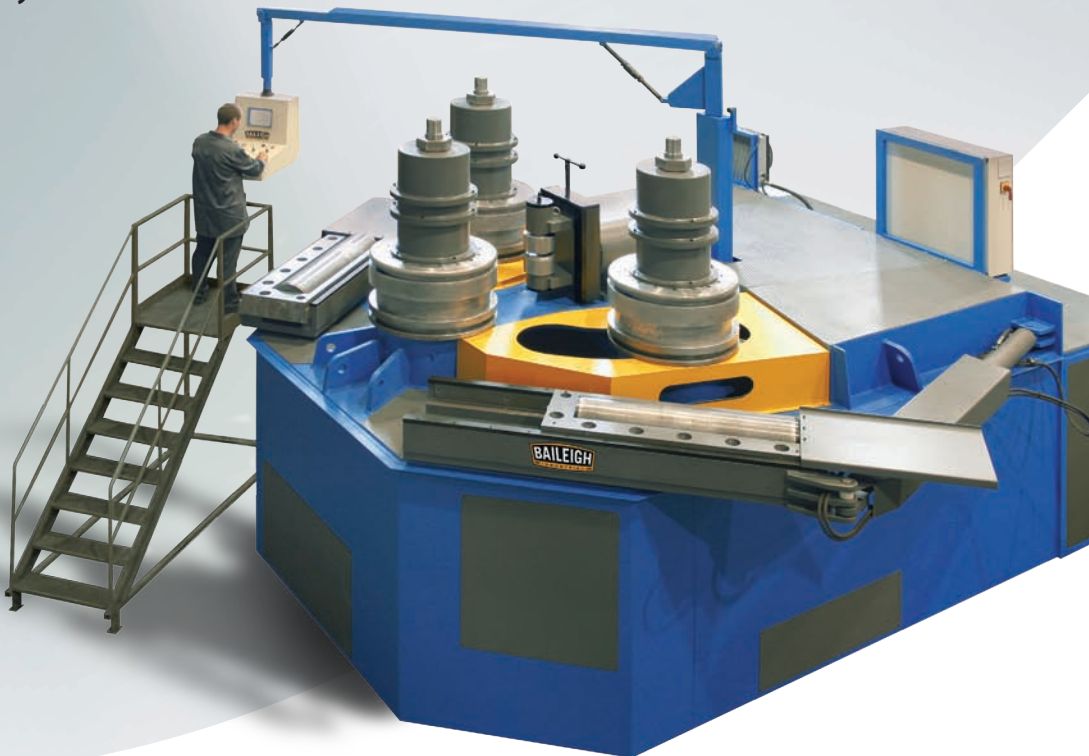
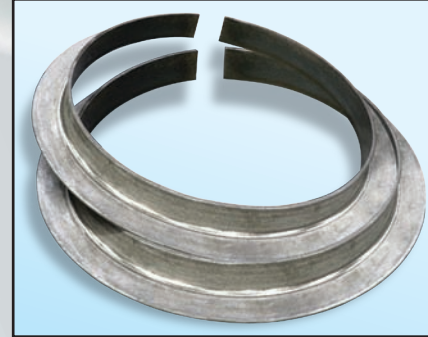


SPECIFICATIONS – Model R-H150		
Capacity	Size	Min. Dia.
Pipe	5.5" (.sch. 40) / 140 (5) mm	73" / 1,854 mm
Round Tube	6.250" (.125") / 159 (3) mm	118" / 2,997 mm
Square Tube	4" (.196") / 102 (5) mm	118" / 2,997 mm
Angle Iron	4.75" (.5") / 120 (6.3) mm	60" / 1,524 mm
Solid Square	3" / 76 mm	32" / 813 mm
Solid Round	3.375" / 86 mm	36" / 914 mm
Flat Bar		
Easy Way	7.875" (2") / 200 (50) mm	40" / 1,016 mm
Hard Way	5.5" (1.125") / 139 (28) mm	118" / 2,997 mm
Roll Adjustment	Hydraulic	
Pinch	Double	
Shaft Diameter	4.724" / 120 mm	
Roll Diameter		
Upper	15.354" / 390 mm	
Lower	15.354" / 390 mm	
Driven Rolls	3	
Digital Readout	Yes	
Speed	3.25 rpm.	
Motor	20 hp.	
Power Requirement	220V – 3 ph. — 50/60 hz.	
Shipping Dimensions (L x W x H)	80" x 67" x 82" / 2,032 x 1,702 x 2,083 mm	
Shipping Weight	10,400 lbs. / 4,717 kgs.	

All Specs based on 60,000PSI (42 Kg/mm2) Tensile Strength – Mild Steel.

# Special Order

*Besides the standard roll benders that we carry in stock, Baileigh Industrial, Inc. has special order roll bender models available for larger rolling projects like I-Beams for bridges, roof cross sections for malls and airport terminals, pipe lines, and much more. Please discuss your requirements in detail with your Baileigh Industrial representative so they can provide a solution to your needs.*



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