

Designed for SANDVIK Quality

High rule bender 58-0

Maximum capacity

Height: 60.00 mm

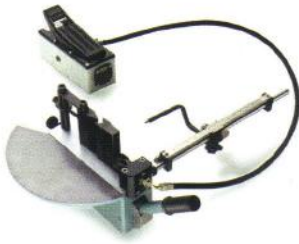
Thickness: 6pt

Height: 100.00 mm

Thickness: 4pt

 **Wahlquist**

High rule bender 58-0



Dimensions

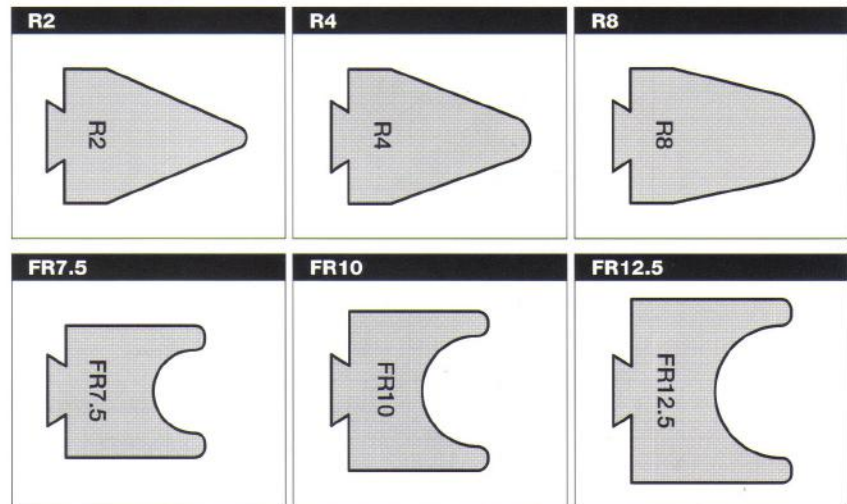
Height	270 mm
Length	620 mm
Width	480 mm
Weight	36 kg

High rule bender 58-0 really takes the hard work out of bending high rules, 6 pt x 60 mm in medium hard grade and 4 pt x 100 mm in hard grade. Closed shapes from 60 mm diameter and more can be bent.

The machine is operated by foot control and is powered by a hydro-pneumatic combination. As standard the machine is supplied with 3 sets of tools, which can be interchanged to give a variety of radii and shapes. Optional tools are available.

The machine is equipped with a fine-treaded adjustable stop for multiple bending.

Standard bending tools



Extra accessories

Analogical or digital caliper for settings down to 0.10 mm, side table for extended working surface.



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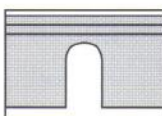


Notching machine 35-0

Maximum cutting capacity

Thickness: 2pt

Type of notch



 **Wahlquist**

Notching machine 35-0



Notching machine 35-0 make notches with a round top in 2 pt medium hard steel rules. As standard the machine is equipped with a tool for 8 mm wide and 17 mm deep notches.

Optional tools for 4, 6 and 10 mm wide notches are available.

Dimensions

Height	130 mm
Length	700 mm
Width	300 mm
Weight	12 kg

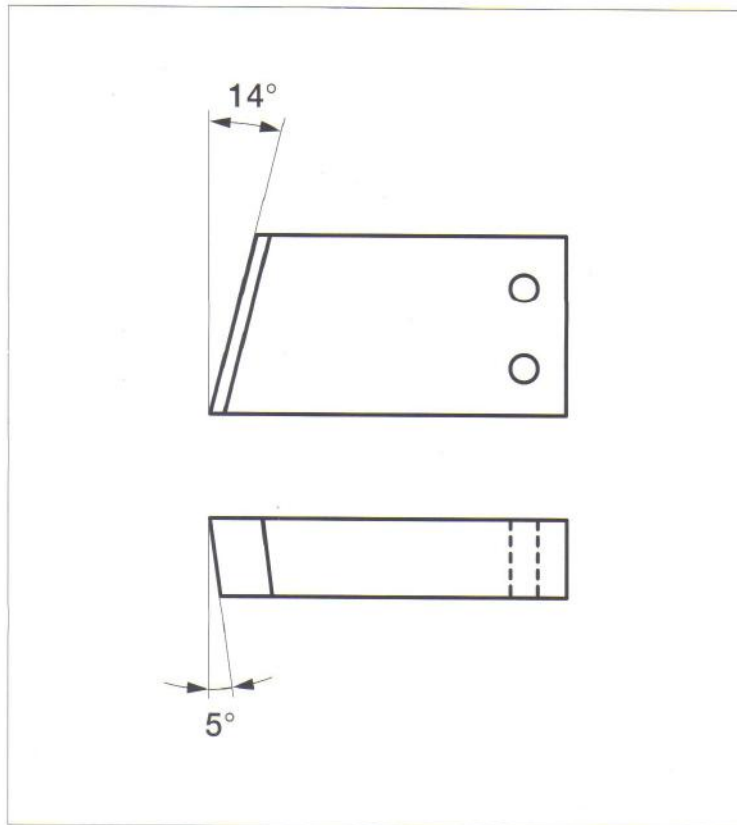


Figure 1

Maintenance

Reground the tools when necessary and before they are blunt. Respect the original grinding angles. See figure 1.

Lubricate the tools daily with some very thin oil.



Notching machine 41-0

Maximum cutting capacity

Thickness: 3pt

Types of notches



 **Wahlquist**

Notching machine 41-0



Dimensions

Width	
with handle	500 mm
without handle	165 mm
Height	
with handle	390 mm
without handle	215 mm
Width	
with rule stop	370 mm
without rule stop	115 mm
Weight	13 kg

Notching machine 41-0 has a smooth and powerful pulling action. It can make both rectangular notches and notches with round top in 3 pt medium hard steel rules. As standard the machine is equipped with a tool for rectangular notches of 6 mm width. The depth can be varied with a depth gauge. The machine has an easily adjustable rule stop. The unique tool design, "parrots beak" also permits notching of already bent rules.

Optional tools for 8 mm wide rectangular notches and for 3, 6 and 8 mm wide notches with a rounded top are available.

Mounting the machine

Bolt the machine to a stable work bench. We recommend that a small box for collecting the scrap pieces is fit under the notching tool.

Lock the handle with the Allen screw.

Put in the rule stop.

Operating instructions

Adjust the depth gauge to desired depth of the notch.

When notching several identical pieces, use the rule stop to get notches in the same place.

Maintenance

Regrind the tools when necessary and before they are blunt. Respect the original grinding angles. Note that usually it is enough to grind the punch only.

Lubricate the tools daily, with some very thin oil.

Lubricate the moving parts every 6 months. To get access – remove the side plate.

Changing the tools

Loosen the screw that locks the female tool (right side).

Put in the notching tools. Fix the punch temporarily.

Adjust the position of the female tool depthwise so that the punch fits into it.

Adjust (with the screw on the top of the punch) the position of the punch so that it penetrates at least 0,5 mm into the female tool at the end of the cut. Tighten the holding screw.

With the punch penetrating into the female, lock the female with the tightening screw on the right hand side.

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Designed for SANDVIK Quality

Pneumatic bender 33-0

Maximum capacity

Height: 50.00 mm

Thickness: 4pt

 **Wahlquist**

Pneumatic bender 33-0



33-0 foot-operated bender is pneumatically powered for faster and easier batch production of identical shapes with high repetitional accuracy. It is equipped with a precision measuring instrument for settings down to 0,10 mm.

The maximum capacity is 50,00 mm high x 4 pt thick medium hard steel rules.

Figure below shows tools supplied with the bender.

The bender can also be supplied without pneumatics.

Dimensions

Height	1210 mm
Length	520 mm
Width	520 mm
Weight	70 kg

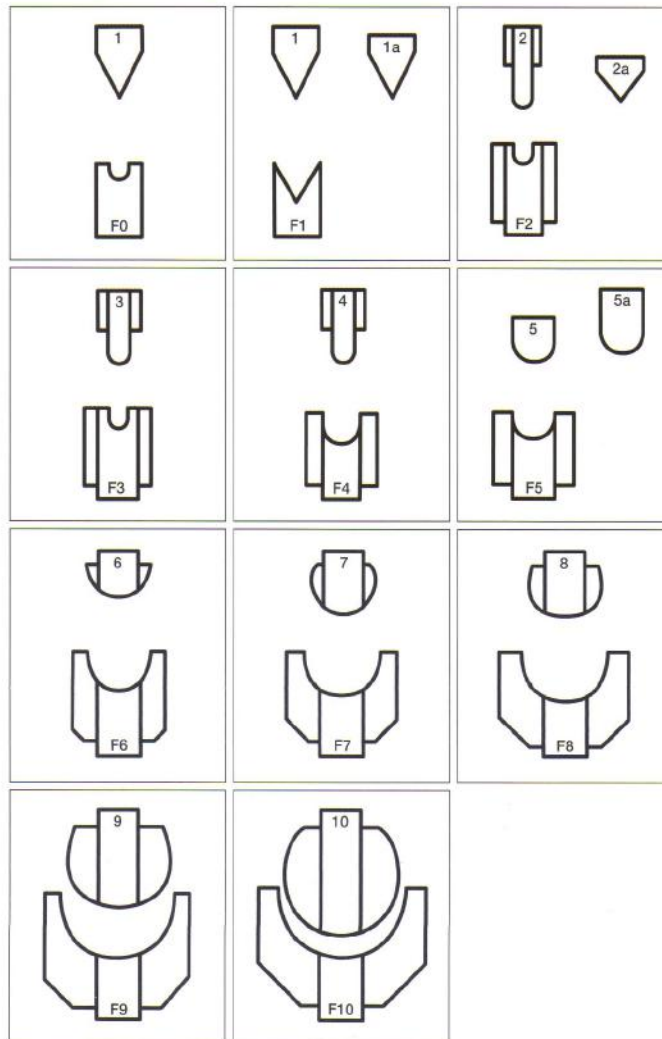
Extra accessories

Digital caliper

Tool No. Radius, mm

F0-1	0.35
F1-1-1a	0.5
F2-2-2a	1.5
F3-3	2.0
F4-4	2.5
F5-5-5a	3,5
F6-6	4.5
F7-7	6.0
F8-8	7.5
F9-9	9.5
F10-10	12.0

Bending tool range



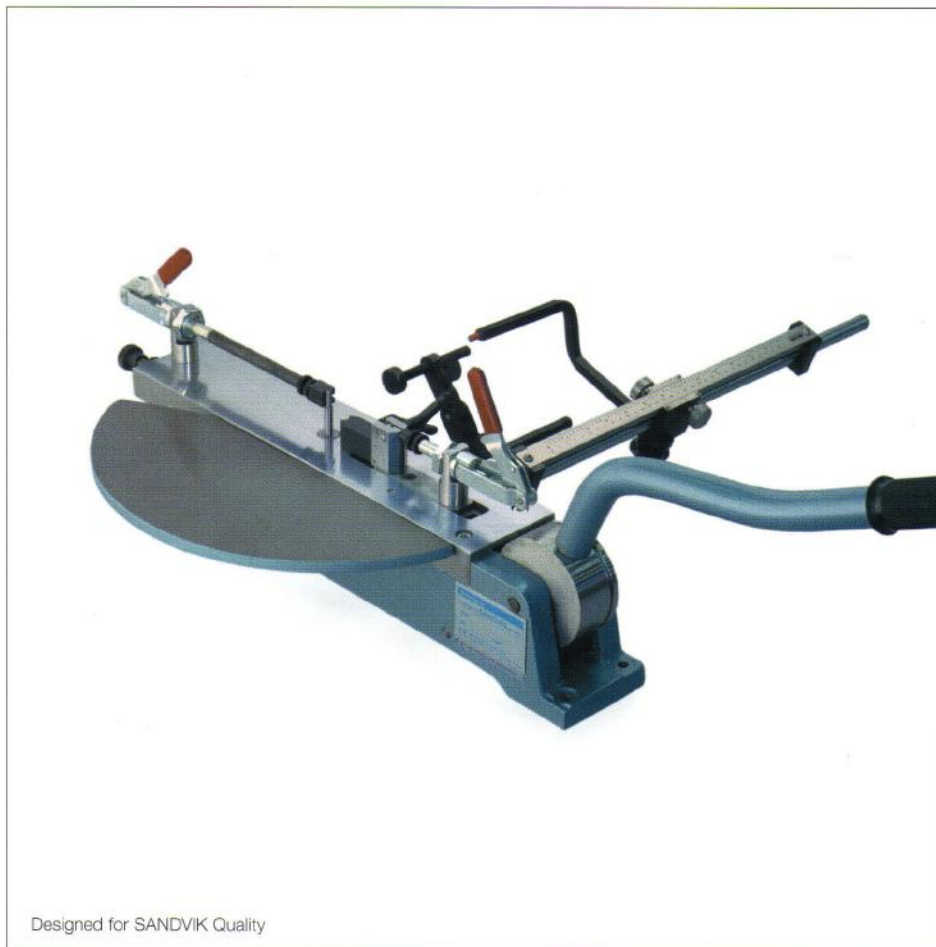
Operating instructions

The first angle is bent, after which the necessary setting adjustments are made. Identical bendings can then be carried out by pressing the pneumatic pedal. The ingenious tools fastener permits a rapid change of tools which means considerable time savings. Do not overload the machine. For bending 3 pt rules take a female tool with one number higher than the male tool and for 4 pt two numbers higher. Lubricate weekly with thin oil.



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Rule bender 34-0

Maximum capacity

Height: 23.80 mm

Thickness: 2pt

 **Wahlquist**

Rule bender 34-0



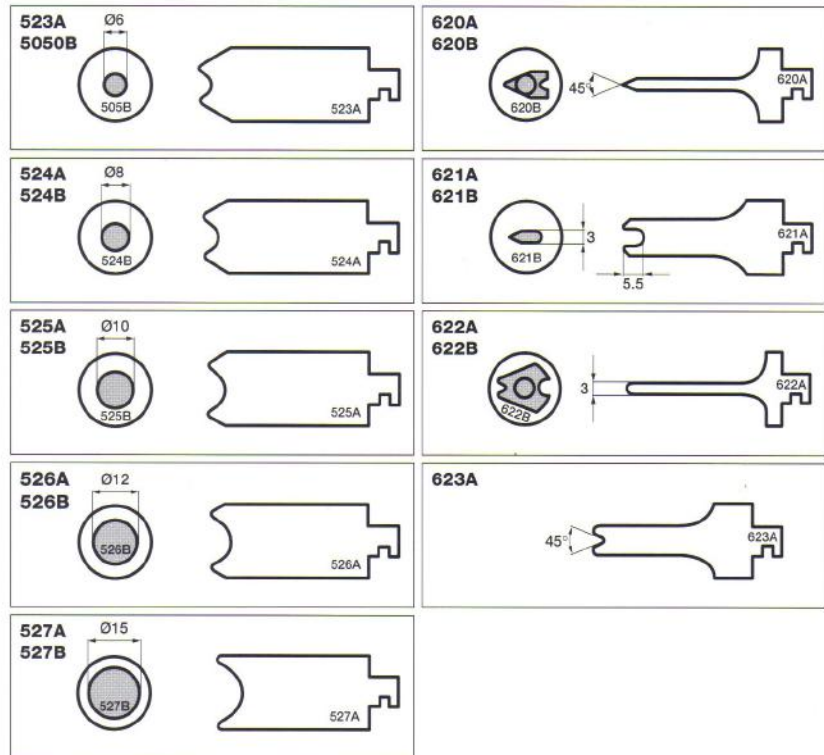
In hand-operated Rule bender 34-0, tight and complicated shapes can be bent in one piece. It has a quick-grip device for rapid tool change in the multiple bending of small, closed parts. As standard the machine is supplied with a set of tools including angle and radius bending dies for direct bending of given angles and radii.

The maximum capacity of this tool set is 23,80 mm high x 2 pt thick medium hard steel rules.

Dimensions

Height	280 mm
Length	1040 mm
Width	250 mm
Weight	28 kg

Standard bending tools



Extra accessories

Standard or digital calipers, side table and tools for 3 pt thick medium hard steel rules.

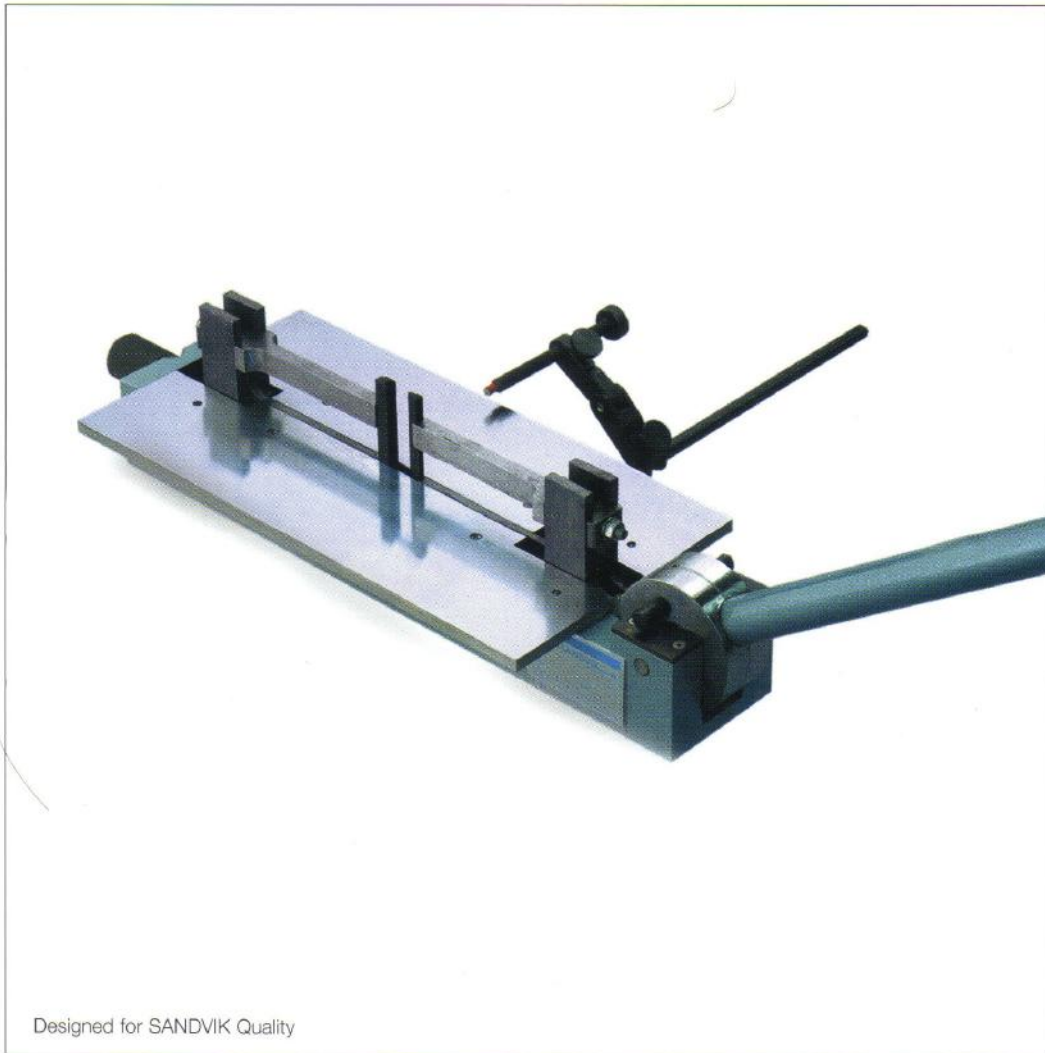
Maintenance

The tools need correct support of the device-little over pressure gives correct bending angle. Lubricate weekly with thin oil.



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Rule bender 45-0

Maximum capacity

Height: 50.00 mm

Thickness: 4pt

Rule bender 45-0



Rule bender 45-0 offers the same rational and exact rule bending technique as the well-known foot-operated bending machines 33-0.

As standard the 45-0 bender is supplied with male- and female tools, F0-5, totally 14 pieces. See below.

The bending machine is equipped with a fine threaded precision gauge.

Dimensions

Height	140 mm
Length	1000 mm
Width	530 mm
Weight	32 kg

Extra accessories

A 24 piece tool set.
Standard or digital calipers.

Tool No.	Radius, mm
F0-1	0,35
F1-1-1a	0,5
F2-2-2a	1,5
F3-3	2,0
F4-4	2,5
F5-5-5a	3,5

Bending tool range

