

**Celebrating 45 Years of Improving Productivity
for the Sheetmetal Forming Industry**



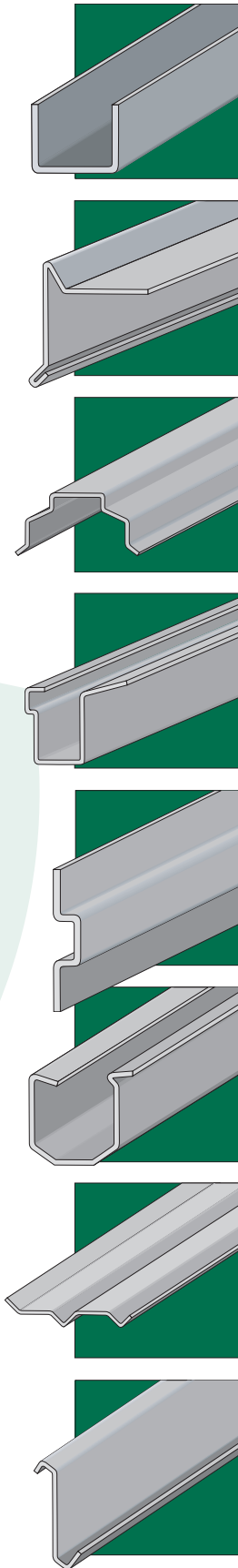
Remanufactured
Model 10 shown with
Optional Light Curtain
and Safety Mat



Model CB-30
Cleat Bender



Model 15



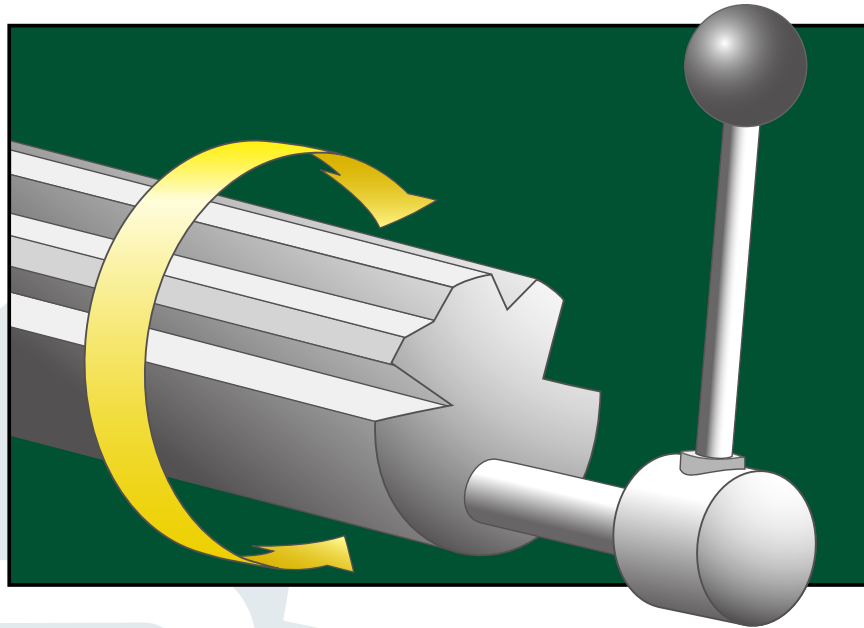
www.rotodie.com



VERSATILE

A Roto-Die® Hydraulic Bender is as simple to operate as a hand brake - but has infinitely more production capacity.

- Merely by rotating the selections lever, one operator can perform all basic sheet-metal forming operations. No dies to change.
- The Roto-Die® Hydraulic Bender forms full-length ducts, gravel stops, standing lock seams, flashing, and hemming operations accurately and economically.
- The compactness inherent in the cylindrical die design permits acute reverse bends not possible with conventional wide-bed machines.
- The Roto-Die® indexes quickly and accurately to all forming stations. Automatic detention assures positive die alignment.
- Centerline machined upper dies are instantly interchangeable in all Roto-Die® openings without special stops or adjustments.

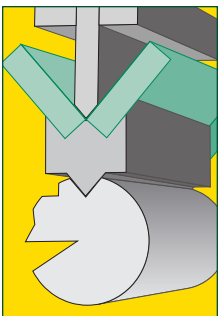


PRODUCTIVE

Most sheet-metal configurations can be formed with one handling by one operator.

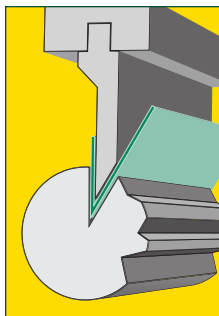
The ram may be jogged, stopped or returned to "up" position at any point of the stroke. It may also be inched for accurate positioning of the work, reducing material loss and gauge-adjustment time.

Disappearing pins are conveniently located for fast one-man positioning in cross-braking (paneling) and rectangular duct forming. Pin gauges are easily removed and relocated.



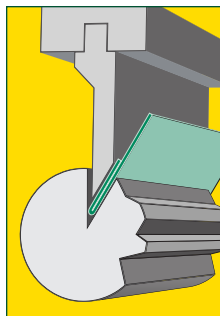
TDC

This combination of TDC Insert Die and Narrow Upper Die allow the forming of TDC Duct.

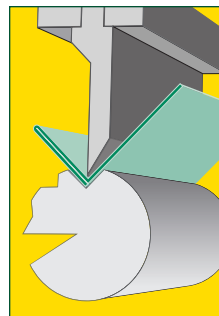


FORMING

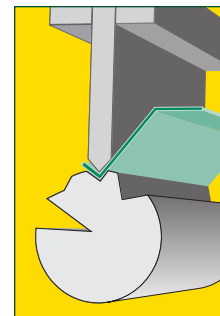
Forming and open hemming are accomplished with standard 30° upper die and No. 37 Roto-Die. Following these sequences, a standing lock seam may be formed without die change or multiple handling of the sheet.



OPEN HEMMING

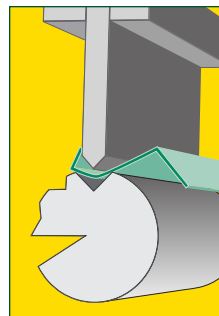


STANDING LOCK SEAM



LOUVRE BLADE FORMING

Many degree-of-bend combinations are quickly and easily formed by bottoming and air-bending.



PROFITABLE

Roto-Die® Hydraulic Benders are engineered to cut costs – labor cost is reduced while shop productivity is increased.

- The patented Roto-Die® principle reduces setup time by as much as 70 per cent, compared with other power-forming equipment. Gauge and clearances are adjusted much quicker than on conventional hand brakes.
- One-man operation cuts labor requirements in half on virtually all hand-brake operations.
- Simple adjustments permit operating speeds up to 50 strokes per minute for maximum production output.
- Multiple handling of sheet stock is kept to a minimum. This allows you to fabricate most commercial ventilating jobs, including the new TDC duct system, in the Roto-Die® in one-fourth the time ordinary benders require.

CHECK THESE FEATURES

- Three models to meet your requirements.
- Proven design - 45 years and thousands of machines in operation.
- All basic sheet metal-forming operations can be made without die change or major adjustments.
- Infinitely variable speed control for easy selection of ram speed.
- Rugged construction for long, trouble-free operation in heavy duty service.
- Best overall value.

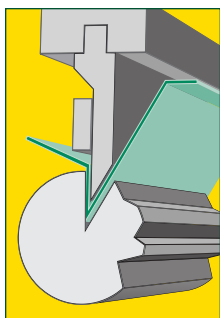
The Roto-Die® system – over 45 years of sheet metal-forming experience. Roto-Die® Hydraulic Benders are shipped complete and ready to tackle your toughest forming jobs.

An extensive, knowledgeable dealer network backed up by factory support is available nationwide to give local service and instruct your personnel. Technical assistance is also available to assist you in obtaining the best production from your machine.

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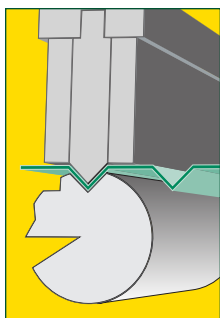


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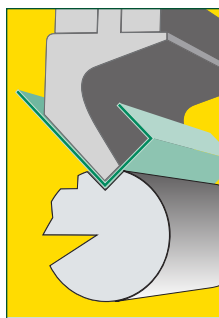
ARCHITECTURAL GRAVEL STOP ADAPTER PLATE

This combination die will form 120" of 24-gauge gravel stop with a 3/4" rise. Easy removal of the rear forming section converts the die to acute-angle forming and hemming operations.



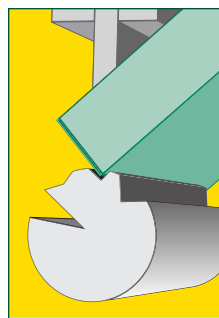
MULTI-FORMING

Damper blades and V-rib shapes may be formed in one stroke in 20-gauge galvanized steel up to 120" long. Shorter lengths may be formed in heavier gauges. The die is adjustable for metals with springback.



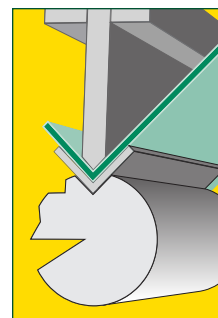
CHANNEL FORMING

90° gooseneck dies (with or without angle inserts) simplify forming light and heavy-gauge channels.



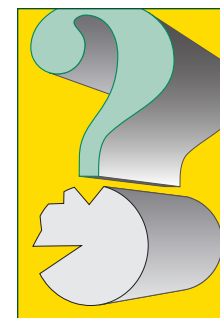
BOX FORMING

Depths to 1-3/4" may be formed with standard dies.



HEAVY-GAUGE FORMING

Machined inserts increase bender capacities up to 120" of 10-gauge material for heavy-gauge or large-radius forming.



SPECIALS

Contact Roto-Die® for specialty dies.

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USA



MODEL 10

(shown with optional front-operated back gauge)
Bending capacity120" x 16 gauge
. 72" x 10 gauge*

MODEL 15

(shown with optional single station)
Bending capacity120" x 14 gauge
.120" x 10 gauge*



MODEL 15/12

(shown with optional single station)
Bending capacity144" x 16 gauge
.144" x 10 gauge*

* Heavy Gauge Angle Insert Required

General Specifications	Model 10	Model 15	Model 15/12
Length of stroke	3"	3"	3"
Strokes per mn. (approx.)	20 to 50	20 to 50	20 to 50
Die Clearance	2-1/8"	2-1/8"	2-1/8"
Die Space	7-1/2"	7-1/2"	7-1/2"
Motor	7-1/2 HP	15 HP	15 HP
Overall Dimensions – Length Front to Back Height	12' 1" 22" 5' 3-1/2"	12' 6-1/4" 22" 6' 1"	14' 6" 22" 6' 1"
Approximate Shipping Weight	5,700 lbs.	8,950 lbs.	10,000 lbs.

STANDARD ACCESSORIES

All units include tooling for five basic forming operations. These dies and accessories are standard:

1-**No. 37** Roto-Die with:
 7° cross-braking groove
 85° die opening 3/8" wide
 85° die opening 7/8" wide
 30° die opening 1/2" wide

1-**No. 1** forming Die 85°

1-**No. 24** hemming Die 30°

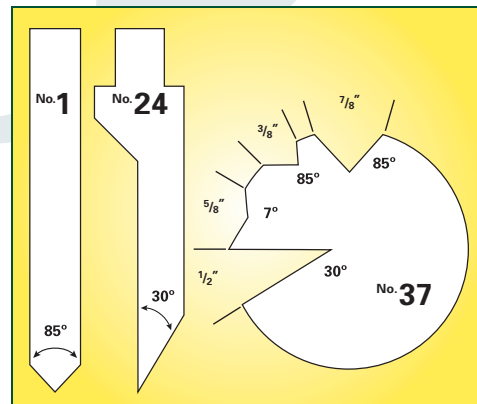
6-No. 50 sheet-support arms with clips

6-No. 52 gauging blocks

6-No. 53 disappearing spring-pin gauges

All models are equipped with depth-of-stroke adjustment with indicators, length-of-stroke adjustment, and motor and controls for 230/460 Volts, 3 Phase 60 Hz. (Other 3 Phase voltages also available.)

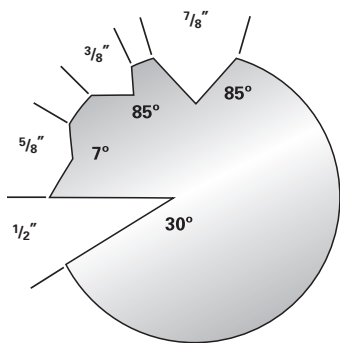
Hydraulic oil and a wrench are also furnished.



DIES & EQUIPMENT OPTIONS

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#37 LOWER ROTARY DIE



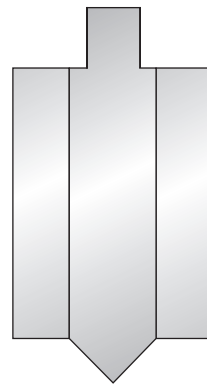
#24 HEMMING DIE



#1 FORMING DIE

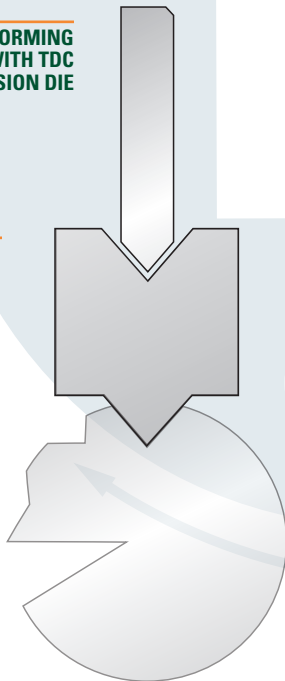


GRAVEL STOP ADAPTER PLATE



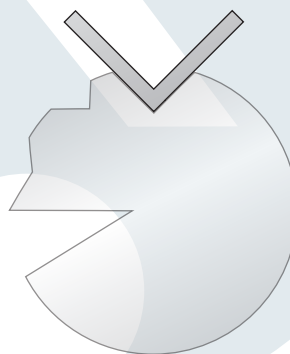
ADJUSTABLE DAMPER DIE

NARROW #1 FORMING DIE USED WITH TDC CONVERSION DIE

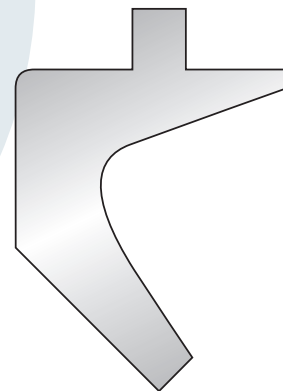


TDC/TDF CONVERSION DIE

HEAVY GAUGE ANGLE INSERT



#5 GOOSENECK DIE



Single Station Depth-of-Stroke Adjustment System (RD00001)



Front Operated Back Gauge (RD00975)
Rear-Operated Back Gauge Part# RD00900

OPEN-END CLEAT BENDER

PNEUMATICALLY OPERATED

- Wide jaws allow forming in 1/2" increments
- Adjustable cleat settings
- Front-mounted quick-release valves
- Large, stainless steel feed table resists rust
- Built in America and backed with a full One-Year Warranty



Model CB30

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USA



OPEN-END DESIGN ALLOWS L-SHAPED DUCTS TO BE FORMED

Mild Steel Capacity	20 Gauge and Lighter
Bend Length	3" thru 29-1/2"
Bend Width	7/16" thru 1/2" Preset
Table Height	36"
Air Consumption (per Stroke)	<0.5 Cubic Feet/@ 100 PSI
Strokes per Minute (Approx.)	0 to 50
Machine Weight	500 pounds



REMANUFACTURING PROGRAM

Roto-Die will remanufacture your machine to the latest specifications or sell you a remanufactured machine. Remanufactured machines carry the same full one-year warranty as our new machines.

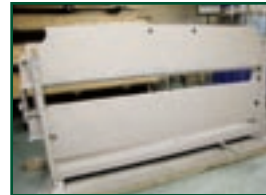
Please contact Roto-Die for availability and pricing.



Have your old machine completely remanufactured into a brand new machine. Everything is replaced on the machine except the original bed, ram, and sideplate weldment. All new dies are included.

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Front



Rear



Old machine before paint removal

Machine ready for welding inspection and repair

Base coat application

Final coat application

Final assembly

INTRODUCING THE NEW ROTO-DIE® SAFETY SYSTEM

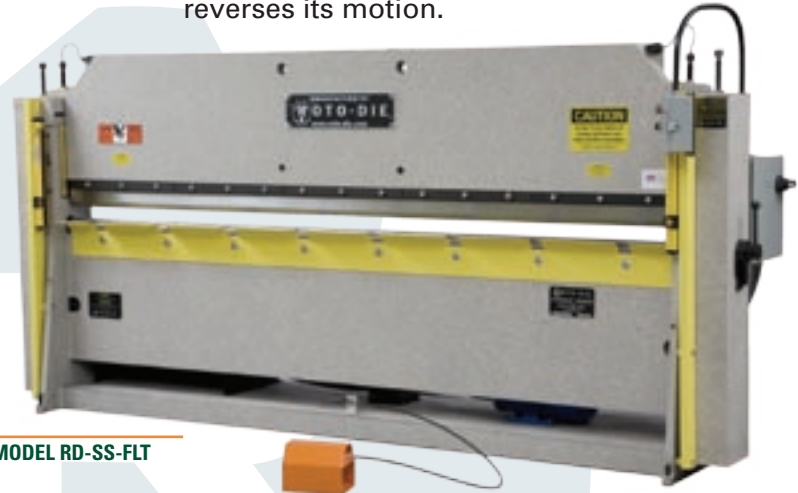
Roto-Die, Inc. introduces two new Safety Systems compatible with ALL Roto-Die® machines. Both models are shipped complete with everything required for installation.

Safety System Features:

- New Main Control Panel including Lockout/Tagout requirements
- 18" Category 4 Light Curtain to offer maximum protection above the upper die and below the lower die
- 48" x 120" Category 4 Safety Mat (Model RD-SS-FLN only)
- Self-Monitoring Redundant Valves
- Push-button operator station
- Front fixed-guard for added safety in the die area
- New piping, high-pressure fittings and installation hardware
- Manual jog of upper die remains intact

Model RD-SS-RG: Per ANSI Spec. 11.5 Supplemental Guards shall be used to protect all areas of access to the Point of Operation which are unprotected by the Light Curtain. Model RD-SS-RG is a 72" high guard unit for the rear perimeter of the machine.

Model RD-SS-FLT: This model contains a fixed Light Curtain that is mounted close to the upper die and is **used when bending flat sheet metal only**. If any obstruction breaks the beam of light during operation of the press, the upper die stops and reverses its motion.



MODEL RD-SS-FLT

Model RD-SS-FLN: This model offers a selector switch that allows the operator to **choose between Non-TDC (flat) and TDC (flanged) bending**. When TDC mode is selected, the Light Curtain is disengaged and the Safety Mat is engaged. The operator places the TDC Duct in the die and then steps off the Safety Mat to actuate the Foot Pedal. If anyone steps on the Safety Mat during operation of the press, the upper die stops and reverses its motion. When Non-TDC (flat) mode is selected, the Safety Mat is disengaged and the Light Curtain is engaged. Operation is the same as RD-SS-FLT.



MODEL RD-SS-FLN

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Please visit our new website to learn more about our company, and to find detailed information on new products, current products, and our remanufacturing program. In addition, you will also find our contact information and an updated Trade Show calendar.

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The screenshot shows the Roto-Die website homepage with a green and blue color scheme. At the top, there is a navigation menu with links for HOME, ABOUT US, PRODUCTS, PARTS & OPTIONS, REMANUFACTURING PROGRAM, NEWS & EVENTS, and CONTACT ROTO-DIE. The main content area features a large banner for a 'NEW SAFETY SYSTEM NOW AVAILABLE' with a 'CLICK HERE FOR DETAILS!' call to action and a video link. To the right of the banner is an image of a large industrial machine and a smaller control unit, with a 'MADE IN USA' logo. Below the banner is a section for 'SEE US AT METALCON 2007' with event details and the METALCON logo. Further down, there is a 'Markets Served' section with four categories: METAL ROOFING, HVAC, INDUSTRIAL, and AVIATION, each with a representative image. The footer contains the Roto-Die logo, contact information, and a list of links.

Roto-Die, Inc. warrants that the equipment manufactured by it shall be free from substantial defects in material and workmanship. Should any part thereof be found within one year from date of shipment to be so defective at the time furnished, Roto-Die will repair or replace such part f.o.b. Roto-Die, Inc.'s factory upon such part being returned to Roto-Die, Inc. transportation charges prepaid. This warranty shall not apply to any part which shall have been repaired or altered out-side of Roto-Die, Inc.'s factory in any way.

With respect to standard apparatus furnished but not manufactured by Roto-Die, Inc., such as pneumatic cylinders controls, etc., Roto-Die, Inc. will extend to purchaser the same warranty or guarantee as is given Roto-Die, Inc. by their respective manufacturers.

THERE ARE NO WARRANTIES, EXPRESSED OR IMPLIED, OF MERCHANTABILITY, FITNESS OR OTHERWISE WHICH EXTEND BEYOND THE FOREGOING WARRANTY.

Purchaser's sole and exclusive remedy and Roto-Die, Inc.'s limit of liability for any and all losses or damages resulting from defective equipment or from any other cause, shall be, at Roto-Die, Inc.'s option, the repair, or the replacement of such equipment. In no event shall Purchaser have any remedy or Roto-Die, Inc. any liability in excess of the purchase price of the particular equipment with respect to which the losses or damages occurred, and the Purchaser shall have no remedy or Roto-Die, Inc. any liability for consequential or special damages.

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