

PLATE ROLLERS



**The LEADER in
RUGGED
HIGH
POWERED
Bending
Machines**

**4 ROLL HI-TECH SERIES
HYDRAULIC & PNEUMATIC
HIGH SPEED AUTOMATIC ROLLS**

A31 SERIES
Powered Initial Pinch Rolls
w/optional LED Readout, Polished
Rolls & Foot Pedals for Rotation

**4RH-100
SERIES**
Hydraulic 4 Roll
(Shown: EXP Version
w/ optional CNC Controls)

TSI-H SERIES
HYDRAULIC Initial Pinch
Rolls with NEW Offset
Planetary Swing Arm
(Hydraulic Drop End Optional)

www.carellcorp.com



A3I SERIES

POWERED INITIAL PINCH PLATE ROLLS
RUGGED, EFFICIENT, PRECISION COMPONENTS,
HEAVY WELDMENT FRAMES, NO CASTINGS!



Optional Factory Supplied LED Digital Readout w/Auto-repeat (Includes larger console as shown)



Solid Stock Gears Heavy Duty Electro-Mechanical Drive



Manual Pinch Adj. Top Roll Release Lock Pinch & Bend Roll w/ Position Scales



A31 Shown w/ Standard Push Button Console

MODEL	LENGTH	CAPACITY	ROLL Ø	HP.	WT.
A312-104	3'	9GA	4.5"	3.0	1,800
A311-105	3'	3/16"	4.7"	4.5	2,000
A313-106	3'	7/32"	5.1"	5.5	2,300
A314-107	3'	1/4"	5.9"	6.0	3,000
A312-153	5'	11GA	4.5"	3.0	2,100
A311-154	5'	9GA	4.7"	4.5	2,500
A313-155	5'	3/16"	5.1"	5.5	2,700
A314-156	5'	7/32"	5.9"	6.0	3,700
A314-156.5	5'	1/4"	6.7"	8.5	4,200
A315-157	5'	9/32"	7.0"	10.5	4,400
A312-202	6'	14GA	4.5"	3.0	2,700
A313-203	6'	11GA	5.1"	5.5	3,200
A314-204	6'	9GA	5.9"	6.0	4,000
A315-205	6'	3/16"	6.7"	8.5	5,200
A316-206.5	6'	1/4"	7.9"	10.5	8,400
A313-252	8'	14GA	5.5"	5.5	4,000
A314-253	8'	11GA	6.3"	6.0	4,500
A315-254	8'	9GA	7.1"	8.5	6,500
A316-255	8'	3/16"	7.5"	10.5	9,500
A314-302	10'	14GA	6.3"	6.0	5,720

Data is Approximate and subject to change

A3I STANDARD FEATURES

- ▶ Powered Rotation on Top & Pinch Rolls
- ▶ Bending Roll Powered Adjust Up/Down
- ▶ Push Button Controls on Detached Console
- ▶ Forward Release Top Roll w/ Safety Lock
- ▶ Emergency Palm Stop & Safety Trip Wire
- ▶ Keyed Safety Lockout on Control Stand
- ▶ Precision Pinch Adjustment, Manual
- ▶ Linear Scales for Precise Positioning
- ▶ Bend-Pinch Rolls Incline for Cones
- ▶ Controls in 24VAC Low Voltage

A-3I OPTIONAL EQUIPMENT

- ▶ Induction Hardened Rolls 54-56 HRC
- ▶ LED Readout w/ Position Repeat
- ▶ Extended Shafts & Section Dies
- ▶ Alignment and/or Rod Grooves
- ▶ Powered Bend Roll Rotation
- ▶ Foot Pedal Rotation Control
- ▶ Cone Rolling Device
- ▶ Custom Machines

4 ROLL Q41 SERIES
MODELS AVAILABLE IN
IDENTICAL CAPACITIES



PRODUCTION READY - CONNECT TO POWER AND ROLL!

LS SERIES

POWERED INITIAL PINCH ROLLS

Our I.P. Light Gauge Rolls employ a Time-Tested Design & Excellent Safety Features with a Low Initial Investment for **MAXIMUM VALUE**

MODEL A38-13/1.5
 With Standard Controls
 4' x 16Ga.



4 Roll Versions Available, Call for Specifications

LS STANDARD FEATURES

- ▶ Top & Pinch Rolls Power Driven
- ▶ Foot Pedal Control on Rotation
- ▶ Manual Bend & Pinch Roll Adjust
- ▶ Top Roll Forward Opening
- ▶ Bending Roll Inclines for Cones
- ▶ 3 Rod Rolling Grooves
- ▶ 24VAC Controls, E-Stop & Trip Wire
- ▶ Linear Scales for Positioning

LS OPTIONAL EQUIPMENT

- ▶ Induction Hardened Rolls
- ▶ Cone Rolling Device
- ▶ Power Bend Roll UP/DN
- ▶ Power Bend Roll Rotation
- ▶ LED Readouts
- ▶ Custom Configurations

MODEL	LENGTH	CAPACITY	ROLL Ø	HP.	WT.
A 35-10/1.2	3'	18GA	2.4"	0.75	870
A 38-10/2	3'	14GA	3.0"	1.0	950
A 39-10/3	3'	12GA	3.5"	1.5	1,200
A 38-13/1.5	4'	16GA	3.0"	1.0	1,000
A 39-13/2.5	4'	12GA	3.5"	1.5	1,300
A 38-15/1.3	5'	18GA	3.0"	1.0	1,200
A 39-15/2	5'	14GA	3.5"	1.5	1,400
A 38-20/1	6'	20GA	3.0"	1.0	1,300
A 39-20/1.5	6'	16GA	3.5"	1.5	1,600
A 310-20/2	6'	14GA	4.5"	2.0	2,550

Data is Approximate and subject to change

TSIH DE/STD SERIES I.P. PLATE ROLLS HYDRAULIC DESIGN

Our Hydraulic 3 Roll Initial Pinch Plate Rolls with Offset Planetary Swing Arms improve pre-bending and reduce maintenance. DE Units have drop end yoke and mobile console controls. STD Units have Push Button or Machine-Mounted controls, Cone Device and Extended Shafts.



TSIH DE version
Model 3/3 6' x 10Ga.

DE Shown w/Optional Hydraulic Drop End & LED Readout

DE Version Console With Push Button Controls & Optional LED Readout



Optional Section Bending Dies on STD Versions

TSIH STANDARD FEATURES

- ▶ Hydraulic Positioning of lateral & pinch rolls
- ▶ Hydraulic Tilt of lateral roll for cone rolling
- ▶ Top & Pinch rolls powered in rotation
- ▶ Emergency palm stop & safety trip wire
- ▶ Drop End Yoke for part removal (DE)
- ▶ Extended shafts for optional section dies (STD)
- ▶ Forward opening top roll for part removal (STD)
- ▶ Cone Rolling Device, adjustable (STD)

TSIH OPTIONAL EQUIPMENT

- ▶ Induction Hardened Rolls 54-56 HRC
- ▶ Polished Rolls for bright materials
- ▶ LED Readouts on lateral and/or pinch rolls
- ▶ Section Bending Dies (EXP-STD)
- ▶ Hydraulic Drop End Yoke (DE)
- ▶ Cone Rolling Device (DE)

MODEL	LENGTH	CAPACITY	TOP ROLL DIAMETER	MOTOR HP		WEIGHT (LBS)	L x W x H (inches)
				DRIVE	HYDR		
TSIH-DE135 3/1	3'	1/4"	5.35"	4	1	2,200	71 x 29 x 42
TSIH-DE135 3/2	5'	3/16"	5.35"	4	1	2,640	91 x 29 x 42
TSIH-DE135 3/3	6'	10 GA	5.35"	4	1	3,080	110 x 29 x 42
TSIH-DE135 3/4	8'	12 GA	5.35"	4	1	3,520	130 x 29 x 42
TSIH-DE135 3/5	10'	16 GA	5.35"	4	1	3,960	150 x 29 x 42
TSIH-DE150 5/1	3'	5/16"	5.90"	4.5	1.5	3,080	75 x 31 x 44
TSIH-DE150 5/2	5'	1/4"	5.90"	4.5	1.5	3,520	95 x 31 x 44
TSIH-DE150 5/3	6'	3/16"	5.90"	4.5	1.5	4,180	114 x 31 x 44
TSIH-DE150 5/4	8'	10 GA	5.90"	4.5	1.5	4,620	134 x 31 x 44
TSIH-DE150 5/5	10'	12 GA	5.90"	4.5	1.5	5,500	154 x 31 x 44

The right is reserved to make changes to design, construction and specifications. All data are approximate. Rating capacity indicated for steel plates with yield of 36,000 psi. Cone rolling capacity 60% of rated thickness.

Data is Approximate and subject to change

Cover Photo: TSIH STD 3' x 1/4" w/optional LED Readout & Section Dies



These rolls include 24 Volt controls, multiple safety stops and lockout devices. The employer of the operator is responsible for providing and insuring the usage of point of operation guards and/or properly applied and adjusted point of operation devices as required to meet OSHA, state and local safety requirements.

4RH-100 SERIES 4-ROLL PLATE ROLLS HYDRAULIC DOUBLE PINCH



4RH100 4/2 5' x 3/16"
With Optional NC Controls

Our 4 Roll Machines pre-bend with rounder seam edges, feature flat feeding and reduced cycle times. Heavier weldment frames ensure maximum rigidity and higher rolling tolerances. Rolls are journaled in spherical roller bearings and move in power efficient linear guides.

MODEL	LENGTH	CAPACITY	ROLL Ø	HP	WT.
4RH-100 4/1	3'	1/4"	6.7"	4	3,900
4RH-100 4/2	5'	7/32"	6.7"	4	4,600
4RH-100 4/3	6'	3/16"	6.7"	4	5,300
4RH-100 4/4	8'	9 GA	6.7"	4	5,900
4RH-100 4/5	10'	12 GA	6.7"	4	6,500

Data is Approximate and subject to change



4RH-100 w/optional CNC & Hydraulic Overhead Support

4RH-100 STANDARD FEATURES

- ▶ **TOTALLY Hydraulic:** roll movement, top/pinch roll rotation & drop end yoke for max. efficiency and reduced maintenance
- ▶ Mobile Control Console w/ Push Buttons
- ▶ Emergency palm stop & safety trip wire
- ▶ 24VAC Low Voltage Controls

4RH-100 OPTIONAL EQUIPMENT

- ▶ Induction Hardened Rolls 54-56 HRC
- ▶ Polished Rolls for bright materials
- ▶ Cone Rolling Device, Collar Type
- ▶ LED Readouts on lateral & pinch rolls
- ▶ PLC and CNC Automatic Controls
- ▶ Overhead & Lateral Supports, Feed Tables & Ejectors

HI-TECH SERIES

4 ROLL AUTOMATIC

HI-TECH 4-Roll Automatic Machines rapidly roll parts from start to finish at the single touch of a button.

Engineered for high-speed automatic rolling. Parts exit weld ready. Create production cells with optional loaders, ejectors, cut to length lines or CNC controls. Units can be built to a specific length, roller size or automation level.

HT w/ Optional Loader / Ejector



HTH with optional CNC, Loader / Ejector & Parts accumulator

HTH with optional CNC, Ejector & Feed Table

HI-TECH FEATURES

- High Speed Automated Cycle
- Hardened & Polished Rolls
- Overhead Sheet Support
- Feed Squaring Arms (HT)

HI-TECH OPTIONS

- Loading / Eject Systems
- CNC Control Upgrade
- Custom Feed Tables
- Custom Machines

HT PNEUMATIC 4-ROLL AUTO-CYCLE

MODEL	LENGTH	CAPACITY	ROLL Ø	SPEED
HT 5/60	20"	20 Ga	2.36"	18 fpm
HT 10/60	39"	24 Ga	2.36"	18 fpm
HT 13/60	51"	26 Ga	2.36"	18 fpm
HT 5/76	20"	18 Ga	3.00"	24 fpm
HT 10/76	39"	22 Ga	3.00"	24 fpm
HT 13/76	51"	24 Ga	3.00"	24 fpm
HT 5/86	20"	16 Ga	3.38"	26 fpm
HT 10/86	39"	20 Ga	3.38"	26 fpm
HT 13/86	51"	22 Ga	3.38"	26 fpm
HT 15/86	60"	24 Ga	3.38"	26 fpm
HT 5/96	20"	14 Ga	3.77"	30 fpm
HT 10/96	39"	16 Ga	3.77"	30 fpm
HT 13/96	51"	20 Ga	3.77"	30 fpm
HT 15/96	60"	22 Ga	3.77"	30 fpm
HT 5/106	20"	13 Ga	4.17"	32 fpm
HT 10/106	39"	14 Ga	4.17"	32 fpm
HT 13/106	51"	16 Ga	4.17"	32 fpm
HT 15/106	78"	18 Ga	4.17"	32 fpm

Data is Approximate and subject to change

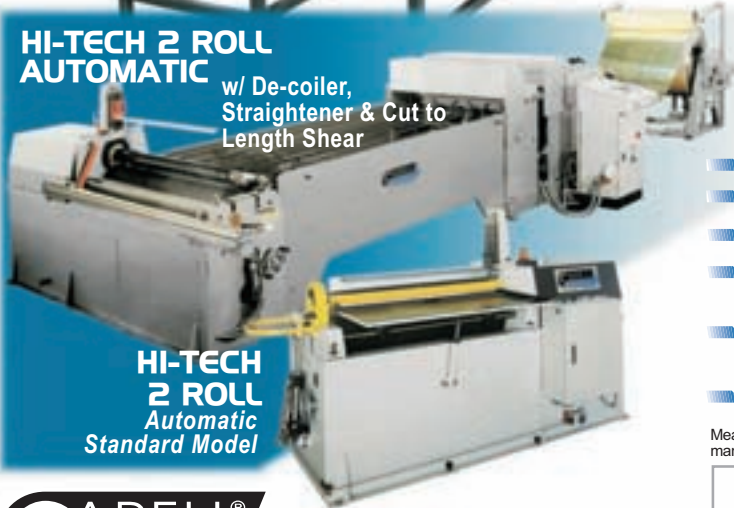
HTH HYDRAULIC 4-ROLL AUTO-CYCLE NC

MODEL	LENGTH	CAPACITY	ROLL Ø	SPEED
HTH 10/130	39"	11 Ga	5.1"	20 fpm
HTH 15/130	60"	14 Ga	5.1"	20 fpm
HTH 20/130	78"	16 Ga	5.1"	20 fpm
HTH 10/150	39"	9 Ga	5.9"	20 fpm
HTH 15/150	60"	11 Ga	5.9"	20 fpm
HTH 20/150	78"	14 Ga	5.9"	20 fpm
HTH 10/170	39"	3/16"	6.7"	20 fpm
HTH 15/170	60"	9 Ga	6.7"	20 fpm
HTH 20/170	78"	12 Ga	6.7"	20 fpm

Data is Approximate and subject to change

HI-TECH 2 ROLL AUTOMATIC

w/ De-coiler, Straightener & Cut to Length Shear



HI-TECH 2 ROLL Automatic Standard Model

HT-2 ROLL FEATURES

- High Speed One Pass Rolling
- Quick Set-up and Adjustment
- Eliminates Flats at Seams
- Tight Tolerance Rolling regardless of cutouts or perforations
- Can be fitted with Automatic Loader and Ejector
- Many Sizes Available!



"FLEX ROLL" Change Rolling Diameters Quickly from 4.75" to 17" using 28GA to 24GA Material



Precision Pinch Pressure Regulation

Measurements in inches, all data are approximate, capacities based on mild steel max. Yield 36,000 psi. The manufacturer and Carell Corp. reserve the right to revise design, construction and specifications without prior notice.



FABRICATING MACHINERY
See these and our full line of profit enhancing machines at our website:

TEL: (251) 937-0948
FAX: (251) 937-0957
sales@carellcorp.com

EXCLUSIVE NORTH AMERICAN DISTRIBUTORS
P.O. Box 850 • Stapleton, AL 36578-0850

www.carellcorp.com

inhousecarell0213308