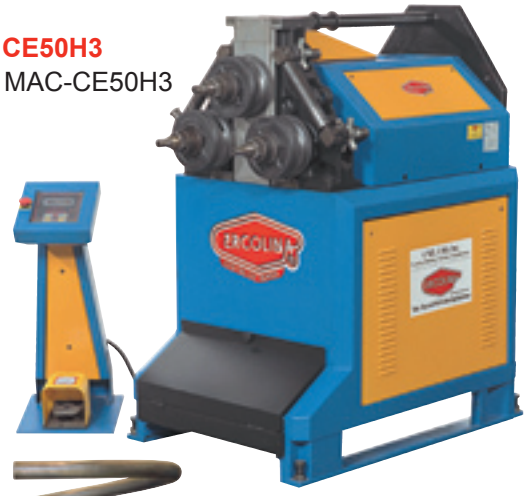
ANGLE ROLLS
CE50 & ER76H3

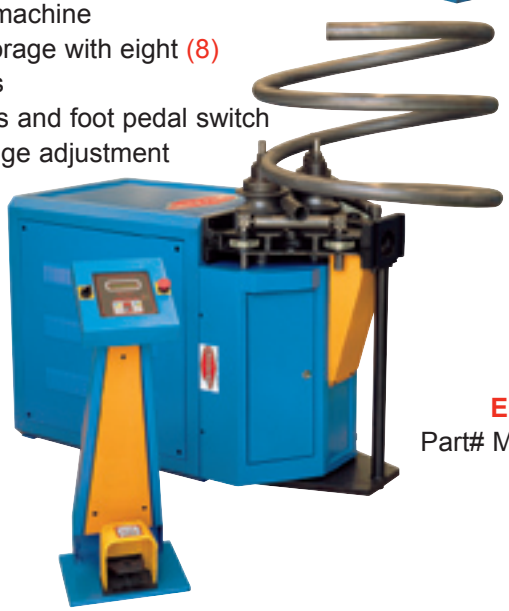
Features

- Bending speeds 20% faster than competitive machines
- Forged roll shafts precision ground and fitted for maximum performance and minimal deflection
- Heavy duty structure and rigid components for high section modulus ratings
- Reinforced engineered mainframe design proven to outperform competitive models
- Patented by Ercolina®; simultaneous downfeed and roll movement to minimize deformation
- Programmable touch pad controls with digital center roll positioning display
- Universal tooling set included with each machine
- 50H3 hydraulic machine with memory storage with eight (8) individual programs and unlimited passes
- Remote pendent with low voltage controls and foot pedal switch
- Threaded roll shafts with micrometric flange adjustment helps eliminate spacer usage
- Inline direct drive roll shaft system
- Optional Anti-twist correction system for angle iron “Leg In” applications

CE50H3
Part# MAC-CE50H3



U.S. Patent
5,970,770;6,173,598
MX Patent
209183



ER76H3
Part# MAC-ER76H3

Dimensions & Specifications

Model	CE50MR3	CE50H3	ER76H3
Roll Shaft Diameter	50mm	50mm	50mm
Center Roll Positioning	Manual with patented torque multiplier	Hydraulic 12 Tons	Hydraulic 12 Tons
Pipe Capacity	2½″ Sch. 40	2½″ Sch. 40	*2½″ Sch. 40
Angle Capacity	2½″ x 2½″ x ¼″	2½″ x 2½″ x ¼″	*2½″ x 2½″ x ¼″
Universal Tooling	Included - 7″ O.D.	Included - 7″ O.D.	Included - 7″ O.D.
Programming	NA	NC - Touch Pad	NC - Touch Pad
Number of Programs	NA	8	1
Shaft Speed	9 RPM	9 RPM	9 / 18 RPM
Distance between Shafts	11.8″	11.8″	11.8″
Drive Motor	2½ hp into planetary	2½ hp into planetary	2½ hp into planetary
Operating Position	Horizontal or Vertical	Horizontal or Vertical	Horizontal or Vertical
Angle Twist Correction	Optional	Optional	Optional
Foot Pedal Stand	Yes	Yes	Yes
Operating Voltage	**220V or 440V 3ph	**220V or 440V 3ph	**220V or 440V 3ph
Height	61″	52″	52″
Length	45″	45″	45″
Width	29″	29″	29″
Shipping Weight	1056 lbs.	1100 lbs.	1100 lbs.

* Capacity based on mild steel with machine in “Low bending speed”
** 3 phase machines can be used with minimum 5hp rotary phase convertor

Refer to Page 30 for Bending Capacities

Minimum Radius Guide for Ercolina® CE Machines

On Mild Steel Material

Profile Type	CE40 / ER60			CE50 / ER76			CE70			CE100		
	Profile Dimensions	Min. CLR Inches	Wall	Profile Dimensions	Min. CLR Inches	Wall	Profile Dimensions	Min. CLR Inches	Wall	Profile Dimensions	Min. CLR Inches	Wall
Pipe	½"	6	.095	¾"	6	.120	½"	8	.095	4"	24	.187
	1"	10	.120	2"	12	.156	3"	24	.216	4"	32	.200
	2"	18	.120	2½"	16	.134						
Tube	1"	6	.120	1"	6	.120	⅞"	8	.065	1 3/16"	10	.079
	1⅜"	8	.120	2½"	20	.203	4"	47	.120	4¾"	40	.157
	2¾"	24	.049	3⅛"	24	.083				5 9/16"	71	.125
Square Tube	13/16" x 13/16"	6	.065	13/16" x 13/16"	6	.083	1" x 1"	8	.065	1 13/16" x 1 13/16"	10	.079
	1 9/16" x 1 9/16"	16	.083	2" x 2"	20	.120	3" x 3"	47	.120	4" x 4"	63	.157
	2"x 2"	24		2½" x 2½"	30	.120						
Rectangular Tube	13/16" x 7/16"	6	.065	1" x 7/16"	6	.083	1¼" x ⅝"	8	.065	1¼" x ⅝"	12	.079
Hardway	1 9/16" x 13/16"	18	.095	2½" x 1 9/16"	18	.120	4" x 2"	82	.120	4" x 2"	82	.157
	2" X 1"	24	.095	3⅛" x 1 13/16"	34	.120						
Rectangular Tube	13/16" x 7/16"	8	.078	13/16" x ⅝"	6	.083	1¼" x ⅝"	8	.065	1¼" x ⅝"	12	.079
Easyway	2" X 1"	20	.095	2½" x1 9/16"	24	.120	4¾" x 1⅝"	47	.160	4" x 2"	79	.157
	2½" x 1 3/16"	32	.095	3⅛" x 1 3/16"	32	.120						
Oval tube	13/16" x 7/16"	8	.059	13/16" x ⅝"	8	.065	2" x 1"	8	.080	1¼" x ⅝"	12	.059
Hardway	2" x 1"	24	.095	2½" x 1 3/16"	24	.095	4" x 2"	47	.118	4" x 2"	40	.125
Oval tube	13/16" x 7/16"	6	.058	13/16" x ⅝"	8	.065	2" x 1"	8	.080	1¼" x ⅝"	12	.059
Easyway	2" x 1 3/16"	24	.095	2½" x 1 3/16"	24	.095	4¾" x 1⅝"	47	.125	4" x 2"	40	.125
Round solid	¾"	4	NA	13/16"	4	NA	1¼"	6	NA	½"	8	NA
	1 3/16"	10	NA	1 9/16"	10	NA	2⅜"	16	NA	2⅜"	20	NA
Square solid	⅝"	4	NA	⅝"	4	NA	1¼"	6	NA	½"	12	NA
	1"	8	NA	1 3/16"	8	NA	2"	16	NA	2⅜"	20	NA
	1 3/16"	10	NA	1 9/16"	10	NA						
Rectangular solid	1½" x 7/16"	4	NA	13/16" x 7/16"	6	NA	1¼" x 1¼"	8	NA	1¼" x ¼"	10	NA
Hardway	2" x 5/16"	10	NA	2" x ½"	8	NA	4" x ½"	24	NA	4¾" x ¾"	30	NA
	2" x 7/16"	18	NA	2½" x ½"	18	NA						
Rectangular solid	13/16" x 7/16"	6	NA	2" x 7/16"	6	NA	1¼" x ⅜"	8	NA	2" x ⅜"	10	NA
Easyway	2½" x ⅝"	8	NA	4" x ⅝"	8	NA	5½" x 1¼"	16	NA	8 x 1 3/16"	20	NA
	3⅛" x ⅝"	24	NA	4" x 13/16"	24	NA						
Angle "Leg Out"	1" x 1"	8	.156	1" x 1"	8	.156	1¼" x 1¼"	10	.160	1¼" x 1¼"	10	.187
	1½" x 1½"	12	.120	2" x 2"	12	.236	3¼" x 3¼"	24	.375	3¼" x 3¼"	20	.500
	2" x 2"	16	.236	2½" x 2½"	16	.236				4" x 4"	24	.500
Angle "Leg In"	13/16" x 13/16"	10	.120	1" x 1"	8	.120	1¼" x 1¼"	10	.160	1¼" x 1¼"	10	.187
	1" x 1"	14	.156	2" x 2"	12	.236	3¼" x 3¼"	32	.375	3¼" x 3¼"	20	.500
	2" x 2"	28	.236	2½" x 2½"	30	.236				4" x 4"	24	.500
T "Leg Out"	13/16" x 13/16"	6	.120	13/16" x 13/16"	6	.120	1" x 1"	8	.125	13/16" x 13/16"	8	.187
	1" x 1"	8	.156	2" x 2"	8	.236	4¾" x 4¾"	24	.375	4" x 4"	20	.375
	2" x 2"	12	.236	2½" x 2½"	12	.236						
T "Leg In"	13/16" x 13/16"	6	.120	13/16" x 13/16"	6	.120	1" x 1"	8	.125	13/16" x 13/16"	10	.187
	1½" x 1½"	8	.156	2" x 2"	8	.236	4¾" x 4¾"	24	.375	4" x 4"	20	.375
	2" x 2"	12	.236	2½" x 2½"	16	.236						
C "Leg Out"	13/16" x ⅝"	6	.156	13/16" x ⅝"	6	.156	1¼"	12	.125	1 9/16" x 1⅜"	10	.187
	2" x 1 3/16"	14	.236	3⅛" x 1 13/16"	12	.236	6¼"	24	.250	8¾" x 3⅛"	59	.375
C "Leg In"	1 9/16" x 13/16"	6	.203	1 9/16" x 13/16"	6	.203	1¼"	12	.125	1 9/16" x 1⅜"	10	.187
	2½" x 1 3/16"	14	.236	3⅛" x 1 13/16"	12	.236	6¼"	24	.250	8¾" x 3⅛"	59	.375
C "Leg Up"	1 3/16" x ⅝"	12	.156	1 3/16" x ⅝"	12	.156	1¼"	10	.060	1 3/16" x 1 9/16"	10	.157
	2" x 1"	18		2½" x 1 3/16"	20	.236	2⅜"	28	.125	4" x 2"	39	.250
H Profile "Leg Up"							3¼"	24		3⅛"	20	NA
							6¼" x 2½"	47		8¾"	59	
H profile "Leg In"							3¼"	24		4"	39	
							6¼"	47		4¾"	63	

1. Capacities based on mild grade material, number of bending passes may vary. 2. Tie Bar accessory may be required for bending large profiles. 3. Two roll drive machines increase minimum CLR. 4. ER60/76 capacities based on "low bending speed", high speed may reduce machine capacity. Consult CML USA Inc. Ercolina® with application questions.