



**CPS/BA**  
SERIES

AMERICA'S PREFERRED CHOICE

CPS50



BA35CNC



THE NAME BRAND THAT SETS THE STANDARDS



BENDING MACHINES



# CPS-BA CAPACITIES

Based on Mild Steels

**20**      **35**      **50**  
**Maximum Size - Minimum Diameter**

 1 x 1/4 Ø 8"      2 x 3/8 Ø 14"      2-3/4 x 1/2 Ø 20" \*

 1-3/4 x 3/8 Ø 12"      3-1/2 x 5/8 Ø 16"      4 x 5/8 Ø 14" \*

 1-1/8 Ø 5"      1-1/4 Ø 16"      1-1/2 Ø 24"

 3/4 x 3/16 Ø 8"      1-1/2 x 1/4 Ø 16"      2-1/4 x 1/4 Ø 30" \*

 3/4 x 3/16 Ø 10"      1-1/2 x 1/4 Ø 22"      2-1/4 x 1/4 Ø 38"

 1 Ø 6"      2 Ø 14"      2-1/2 Ø 20"

 1 Ø 6"      2 Ø 16"      2-1/2 Ø 20"

 1-1/4 Ø 8"      2-1/2 Ø 18"      3-3/4 Ø 26" \*

 1-1/4 Ø 10"      2-1/2 Ø 20"      3-3/4 Ø 30" \*

 1/2 Ø 4"      1-1/4 Ø 16"      1-1/2 Ø 24"

 1/2 Ø 12"      1-1/2 Ø 20"      2 Ø 36"

 1-1/4 x 1/16 Ø 16"      2-1/2 x 1/16 Ø 30"      2-12 x 10ga. Ø 34"

 3/4 x 1/16 Ø 12"      1-1/2 x 1/8 Ø 40"      2-1/4 x 1/8 Ø 50" \*

 1-1/4 x 3/8 x 1/16      2 x 1-1/4 x 1/8      2-3/4 x 1-1/2 x 1/8 \*

**Bending Adjustment**      Hydraulic      Hydraulic      Hydraulic

**Driven Rolls**      3      3      3

**Rolling Speed fpm**      10      13      16

**Working Plane**      Vertical      Vert./Horiz.      Vert./Horiz.

**Repeat Control**      Auto repeat      Auto-Repeat      Auto-Repeat

**Installed Power HP**      0.75      2.25      4.75

**Approx. Dimensions**      13 x 24 x 45 h      27 x 32 x 40 h      33 x 44 x 49 h

**Approx. Ship wt. lbs.**      400      1100      1650

\* On some sections for limited quantities it may be possible to use standard rolls. In order to achieve optimum results or if production runs are required, it is necessary to use optional rolls.

Chart indicates minimum suggested inside bending diameters at maximum section size using mild steel - Specifications subject to change/modification without prior notice - Data is approximate - Contact your authorized dealer for specific tooling capabilities/requirements on shapes and sizes to be bent. Special rolls and/or tooling may be required for some angle, channel rolling and/or for serial production on some sections - Bending I.D.'s may be limited by predicted material distortion



CPS-20, 35 & 50 AUTOMATIC

Lateral Guides  
w/ Multiple  
Positions



Special  
Guides for  
Angle Leg-In  
Shown

## Tube / Pipe (Round)

- 1 Set of 3 rolls required for each tube or pipe size

## Tube (Square, Rectangular)

- Special Rolls may enhance results or be required on some tube

## Angle Rolled Leg-Out and In

- Optional Lateral Material Guides with adjustable cam roller required for rolling angles leg-in
- Optional Tapered Roll pair suggested for rolling angle both leg-in and out

## BA-CNC Rolls

- BA 20, 35 & 50 CNC versions require dedicated rolls, Optional universal type custom tooling available







CPS-20 Vertical



BA20-CNC



CSP-35



BA35-CNC



BA35 Continuous Coiling



CPS-50



BA50-CNC



Models 35 & 50 Operate in Horizontal & Vertical Mode



CPS-20, 35 & 50 Controls LED w/ 40 Position Memory



BA Series Controls w/ Industrial PC



BA Ovals, Bows & Spirals



# ROLL WITH AN ORIGINAL - ROLL WITH EAGLE!

With over 16,000 machines produced, satisfied users worldwide are rolling with original EAGLE BPR Universal Bending machines. Discover the advantages and ask for free information on our line of section benders, angle rolls, plate rolls and tube/pipe benders. CD's and VHS videos available.

## FEATURES

- Three Driven Rolls Universal Profile Bender
- Initial Pinch Geometry for Serial Production
- Hydraulic Up / Down Movement on Forming Roll
- High Strength Hardened Shafts with Roller Bearings
- Universal Bending Rolls, Smooth, Induction Hardened
- Horizontal & Vertical Working Position (Models 35 & 50)
- Push Button Controls, Detached Console w/ E Stop
- LED Readout, Large High Brightness, 24VAC Controls
- 40 Memory Automatic Position Repeat "APR" System
- Flush Mount Switch Gear Panel with Safety Lamps
- Bending Roll Moving on Adjustable, Hardened Gibbs

## STANDARD EQUIPMENT

- LED Readout with 40 Position Memory
- Universal Bending Rolls, Hardened
- Adjustable Lateral Material Guides
- Lifting / Hoisting / Transport Eyes
- Service Tools + Instruction Manual

## OPTIONS/ACCESSORIES

- Rolls for Tube-Pipe, Round and Square
- Rolls for Angle Leg-In and Out
- Lateral Guides for Angle Leg-In (35 & 50)
- Custom Rolls for Extrusions and Special Sections
- Special Voltages Upon Request



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## VERSIONS 20 - 35 - 50

### CPS ( Standard )

Models 20, 35 & 50 with Single Rolling Speed and all Features as listed to the left

### CPS-REV ( Variable Rolling Speed )

CPS with Stepless Variable Speed, zero to maximum for precision rotation control

### CPS-AUT ( Automatic Bend Execution )

REV with Programmable Control and Proximity Sensors to mass-produce a single radius bend

### BA ( Full PC/Windows Based CNC Controls )

- Exclusive BPR Direct Radius "PRO-Bending" Program
- Direct Radius Input & On-Board CAD Graphics allow the operator to visualize and edit shapes on screen
- Accepts Auto-CAD DXF file downloads
- Automatic Interpolation-Blending between bends speeds and simplifies programming
- Standard Shape Program Archive of most common shapes
- Servo Controlled Bending Roll Movement offers the Industries Highest Level of Material Variance Control and Bending Precision
- Large Full Color Flat Screen Graphic Operator Interface
- Unlimited Program Memory, Hard Drive + 3.5" Floppy
- RS-232 Serial Port enables use of external devices
- Variable Speed Rotation & Rise/Decent of Bending Roll
- Air Oil Heat Exchanger Maintains Oil at Constant Temp.

Note: BA Units Require Dedicated Rolls (Optional)



CPS/BA0604

Roll bending machines distributed by Eagle Bending Machines, Inc. are designed and manufactured to comply with ANSI B11.12, 1996 standards. 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.

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