

# **DI-ACRO/KAUFMANN** **Series M** **One-Pass** **Rolling and** **Curving Machine**

**Combines precision, one-pass,  
curving of full cylinders  
or arc segments  
with simplicity and economy.**

**Curves wide range of diameters;  
all types of metals.**

**Adapts to high production runs/  
short runs/experimental work.**

**Compactly and ruggedly built;  
available with or  
without floor stand.**

*Now . . . Kaufmann Precision Rolls and Tooling Urethane*  
joins DI-ACRO Precision Metalworking Equipment to offer you  
a single source for all your Precision Metalforming Needs.

PLEASE DIRECT ALL INQUIRIES TO YOUR LOCAL DI-ACRO  
DISTRIBUTOR OR TO:

**DI-ACRO**  **HOUDAILLE**

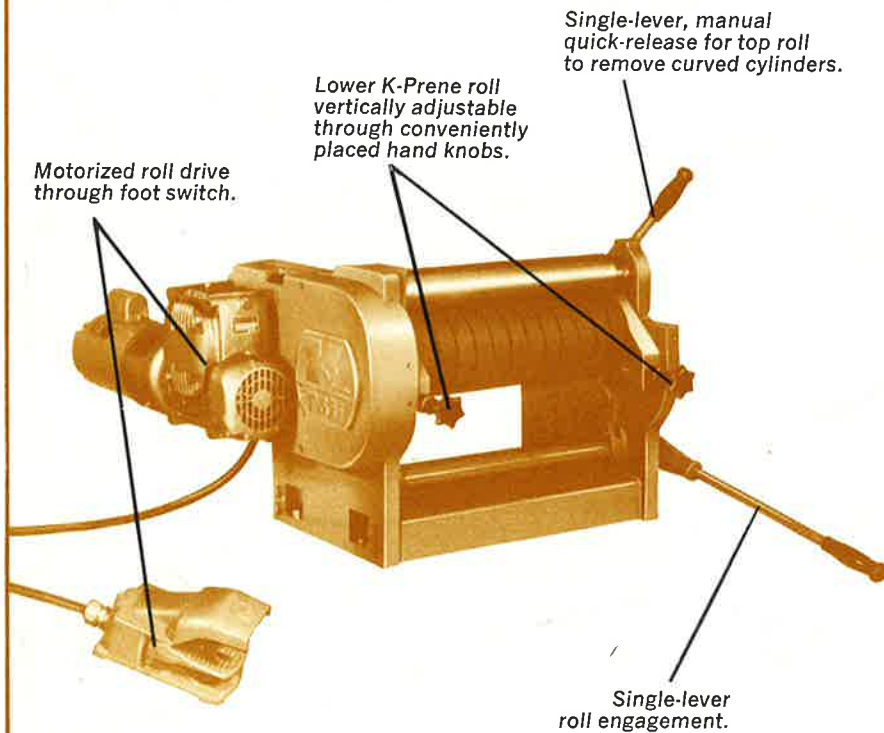
DI-ACRO DIVISION, HOUDAILLE INDUSTRIES, INC.  
LAKE CITY, MINNESOTA 55041



# Series M Rolling and Curving Machines

## FEATURES

Heavy-duty construction for accuracy and rigidity.



Series M incorporates the same patented two-roll, high-pressure curving system as all other Kaufmann machines: the top steel roll acts as a rotating punch; the bottom K-Prene Urethane roll acts as a rotating female die and deflects to literally wrap the blank around the top roll.

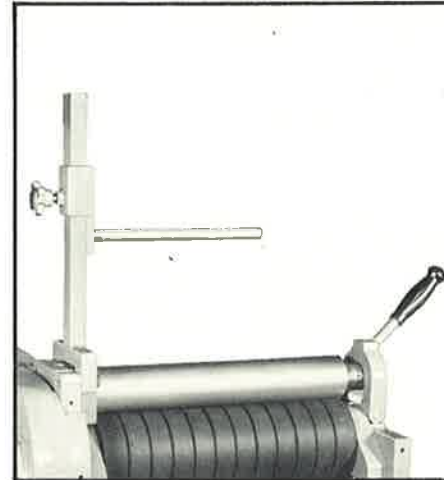
Curving without fluting or kinking, even on piece-parts having holes or cutouts, due

to high forming pressures against a Slip-On Tube. This Slip-On Tube, acting as a "developed punch," fits over the top steel roll and is the only tooling necessary for the job.

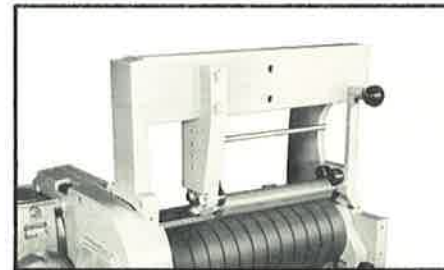
Curving without bowing, resulting in parallel edges, due to patented anti-deflection system.

## ATTACHMENTS

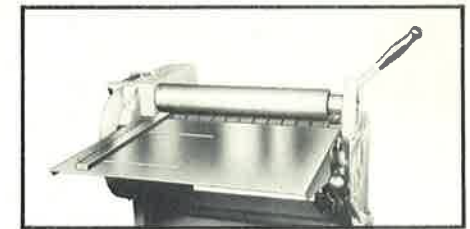
**Slip-On Tubes** — become tooling for job; consist of commercially available tubing.



**Slip-On Tube Support** — supports tubes to prevent pinching curved cylinders against lower roll when removing finished cylinders.



**Small-OD Attachment** — permits rolling diameters as small as one inch; has interchangeable mandrels for variety of diameter-length combinations.



**Feed Table** — machine supported; adjusts for height and feed angle; side guide adjustable for narrower blanks.



**Floor Stand** — 24" high; converts machine to free standing unit.

## SPECIFICATIONS

### Series M, Model M1835

**Capacity:** 16 gage mild steel across full working width.

**Working Width:** 18 inches.

**Piece-Part Diameters:** from 3½" up; from one inch up with Small-OD Attachment.

**Rolls:** Steel roll — 3½" diameter; K-Prene Urethane roll — 6" diameter.

**Rolling Speed:** 16 fpm.

**Motor:** Single-phase, ¾ hp; controlled through Stop/Go Foot Switch, 110 v.

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