

ChannelBender Series®



Automated Channel Letter Solutions



ChannelBender Series



ChannelBender Series

The ChannelBender Series by SDS is the most complete, cutting-edge, line of channel letter fabrication solutions. From bending, flanging, notching, broaching, hole punching, and sanding, to automatic trim cap processing and stapling, we have a solution that will make your business more productive, more efficient, and more profitable.

Whether you are looking to bring channel letter fabrication in-house, lower production costs, improve efficiency, or increase production capacity there is a ChannelBender Series solution that will deliver exactly what you're looking for.

ChannelBender Series

	ChannelBender EX	ChannelBender SXP	ChannelBender XD	ChannelBender R/T
Price	\$\$	\$\$\$\$\$	\$\$\$\$\$	\$\$\$
Notching	✓	✓	✓	✓
Flanging	✓	✓	✓	
Hole Punching		6.35mm and 3mm		
Broaching		✓	✓	✓
Coil Thickness*	0.8mm - 1.6mm	0.8mm - 1.6mm	0.8mm - 2.0mm	0.66mm - 1.6mm
Coil Height	25.4mm - 152.4mm	25mm - 203.8mm	38mm - 216mm	25mm - 127mm
Trimless		✓		✓
Mild Steel	***	*****	*****	*****
Stainless Steel	***	*****	*****	*****

*depending on the type of metal coil

U.S. Patent Nos. 5475992; 5589090; 5787750; 5870919; 5966974; 5992485; 6128940; 6405574; 8327679; 7694543; 7441434; and 7878039. Other U.S. and international patents pending.
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ChannelBender EX

Full featured, entry-level channel letter bending machine that delivers the best combination of value and performance in the sign industry.

The EX model is SDS KOREA's lowest cost, complete solution for manufacturing both front-lit and halo-lit channel letters from the most commonly used material heights and thicknesses.



ChannelBender SXP

The SXP is the flagship letter bending machine in the SDS KOREA ChannelBender Series. The SXP is by far, the most advanced channel letter bender available to the sign making industry. This machine can form traditional face-lit or halo-lit channel letters of nearly any height and anywhere from 25mm to 203.8mm deep.

The SXP can also process specialty materials like our Trimless LetterForm, brushed and polished stainless, and even mild steel. Just imagine having the capability to automatically form letters as small as 76.2mm tall and serifs as small as 4.76mm. No other machine in the industry even comes close.

ChannelBender Series



ChannelBender R/T

ChannelBender R/T is a specialized system dedicated exclusively to forming high-end fabricated, halo-lit or Trimless® letters without a flange. The R/T can process brushed or polished stainless steel, polished brass, aluminum, mild steel and even copper. This bender can form letters from strips or coils and can process material heights from 25mm to 127mm in height and 0.66mm to 1.6mm in thickness.



ChannelBender XD

The XD from SDS KOREA has proven that innovation and superior engineering can solve many fabrication challenges that the sign making industry is facing. By automating the tedious process of forming channel letters out of thick materials like 2.0mm aluminum and 18 gauge mild or stainless steel, the ChannelBender XD has proven itself to be the workhorse of the industry. No other machine in the industry comes close to matching the extra duty capabilities of the XD model.



*Coil Stand Not Included

ChannelSander®

ChannelSander reduces production time and slashes labor costs by automatically scuffing mill finish and pre-painted channel letter coil with Scotch-Brite pads. The sanding process is completed prior to forming letters on your channel letter bender. The sander also has an integrated brush and vacuum system to prevent dust and debris from being dragged into your expensive bending machine. The aggressiveness of the scuffing can be controlled by changing the coarseness of the Scotch-Brite pads and/or adjusting the variable speed motors. By pre-scuffing your channel letters, they will be one step closer to receiving a gorgeous custom-painted finish.



ChannelTrimmer™

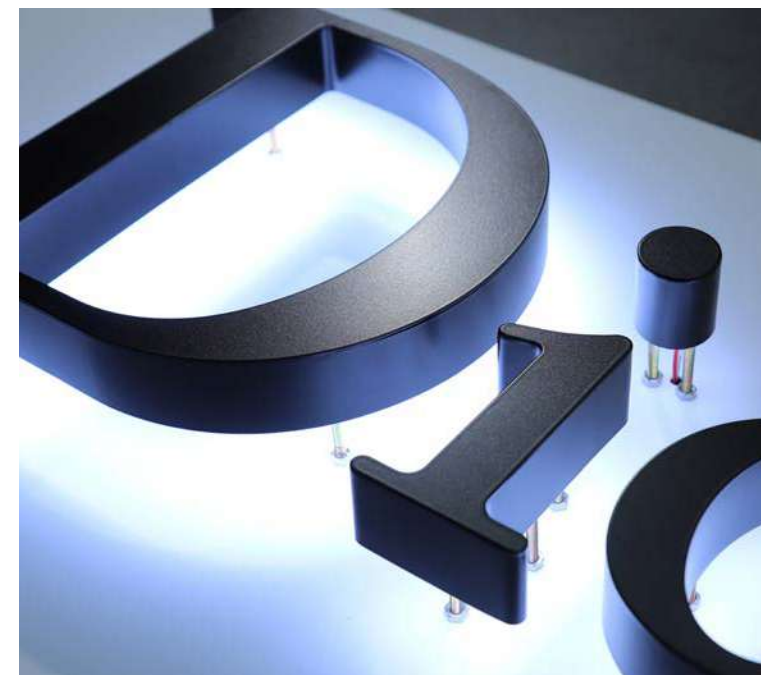
ChannelTrimmer is lightning fast, compact and easy to use. This trim cap processing solution processes most conventional trim cap materials with speed and accuracy that will dramatically increase efficiency and output. One ChannelTrimmer is capable of producing enough finished trim cap to support as many as six channel letter bending machines. Just imagine, this one, simple, easy to use machine can produce trim cap for as many as 600 letters per day!

ChannelBender Series



ChannelStitcher™

ChannelStitcher provides the strongest, fastest, most cost-effective method for fastening channel letter backs to the flange of your front-lit letters. Bring the speed, strength and economic efficiency of an automatic fastening system to your channel letter assembly operations and achieve substantial, immediate reductions in labor and material costs with the addition of a ChannelStitcher from SDS Automation. ChannelStitcher can work with both aluminum and ACM backing materials.



Trimless® LetterForm®

Our proprietary Trimless channel letter coil has numerous advantages that give your sign shop the edge over the competition. Trimless LetterForm letters provide a clean, high-quality, contemporary appearance and they deliver higher profit margins than traditional types of channel letters. LetterForm capabilities certainly command taking a closer look.



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ChannelBender® EX

The most capable entry-level bender on the market

- Accuracy and performance with an affordable price
- Full bending, notching and langing capability
- Material thickness from 0.8mm - 1.6mm
- Material height from 25.4mm - 152.4mm



ChannelBender EX is a full featured entry-level channel letter machine that delivers an outstanding combination of value and performance. The EX model is SDS Automation's lowest cost, complete solution for manufacturing both front-lit and halo-lit channel letters from all commonly used material heights and thicknesses. Versatile and reliable, the **ChannelBender EX** can flange, notch and form channel letters from aluminum coil measuring 0.8mm to 1.6mm in thickness and 25.4mm to 152.4mm in height. All cutting, notching and flanging is done with powerful, reliable hydraulics.

Although the EX model is the **ChannelBender Series'** most affordable letter bending machine, it still manages to outperform all of it's competitors in speed, accuracy and reduction of waste. This machine is the perfect choice if you're looking to bring channel letter fabrication in-house for the first time or if you simply need to move beyond hand-forming.

The price of a fully equipped **ChannelBender EX** includes on-site set-up, installation, and training at your facility. There is no optional equipment and there are no hidden fees. By the conclusion of your comprehensive training, you will know how to competently operate and maintain your new ChannelBender series machine.

TECHNICAL SPECIFICATIONS		
POWER	Machine	220VAC, 15A, 50/60Hz, 1P
	Hydraulic pump	220VAC, 6.4/3.7A (max/typ)
DIMENSIONS (W x D x H)	Machine	1,960 mm x 1,010 mm x 1,500 mm
	Coil Stand	760 mm x 760 mm x 1,450 mm
FEATURES	Hydraulic flange notcher	30°, 60°, 100°, 130°
	Flange depth	12.7 mm
	Continuous batch processing	Yes
BENDING	Smallest radius that can be bent a full 180°	8 mm
MATERIAL COIL SPECIFICATIONS	Outside diameter of coil	660 mm
	Thickness	0.8 mm - 1.6 mm
	Height	25.4 mm - 152.4 mm

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ChannelBender® SXP

The most advanced channel letter bender ever built

- Adjustable height 3mm and 6.35mm hole punching
- Material heights from 25mm to 203.8mm
- Forms face-lit, halo-lit and LetterForm Trimless letters
- Bend aluminum, stainless, and mild steel
- 0.8mm - 1.6mm aluminum and 20 gauge stainless or mild steel
- Letters as small as 76.2mm in height and serifs as small as 4.76mm



*Patent Pending



The **ChannelBender SXP** is the flagship letter bending machine in SDS KOREA's ChannelBender Series and the ultimate, state-of-the-art channel letter system for traditional and advanced channel letter forming. The SXP is undeniably the most advanced, most efficient, most productive channel letter machine available to the sign making industry. This machine can form traditional face-lit or halo-lit channel letters of nearly any height and anywhere from 25mm to 203.8mm deep. The SXP can also process specialty materials like our Trimless LetterForm, LiquiForm, polished stainless, polished brass and even mild steel. Just imagine having the capability to automatically form letters as small as 76.2mm as well as serifs as small as 4.76mm. Electronically height-adjustable hole punching is one of the many ground-breaking features available only on ChannelBender SXP. Our exclusive, patented hydraulic hole punching unit eliminates manual drilling of 6.35mm drain holes and 3mm pilot holes for rivets or screws. Holes can be positioned anywhere in the return or the flange and it can even punch multiple holes both horizontally and vertically. Our software can recognize hole positions in the dxf file used to cut the back panel of the letter and the SXP will automatically create a corresponding rivet hole in the flange. Automating this tedious, manual task saves time and greatly increases accuracy and efficiency. No other machine in the industry comes close.

The **ChannelBender SXP** also has the ability to broach return material when forming Trimless, halo-lit or fabricated letters in materials like Trimless LetterForm, stainless steel, mild steel, polished brass and even copper. The broaching feature is a patented process that scores a shallow groove vertically across the interior surface of the return at the exact location of sharp, angled bends. Broaching forms a shallow groove or relief cut which results in crisp, sharp, precise bends and allows for the forming of intricate shapes, like serifs as small as 4.76mm, which were previously impossible to automate.

The price of a fully equipped **ChannelBender SXP** includes set-up, installation, and on-site training at your facility. There is no optional equipment and there are no hidden fees. By the conclusion of your comprehensive training, you will know how to competently operate and maintain your new ChannelBender series machine.

*Some limitations may apply

TECHNICAL SPECIFICATIONS		
POWER	System	220VAC, 15A, 50/60Hz, 1P
	Oil pump	220VAC, 6.4/3.7A (max/typ)
DIMENSIONS (W x D x H)	System	2,370 mm x 1,110 mm x 1,500 mm
	Coil cassette	760 mm x 760 mm x 1,450 mm
FEATURES	Vertical broaching of angles	100°
	Maximum flange thickness	Up to .063" (1.6 mm)
	Hydraulic flange notcher	30°, 60°, 100°, 130°
	Flange depth	Adjustable - 6.35 mm, 9.5 mm, 12.7 mm
	Cut-off tool for batch processing	Yes
	Hydraulic punching unit (inline)	6.35 mm weep holes, 3 mm screw/rivet holes
BENDING	Maximum angle	120° (coil)
	Smallest radius that can be bent a full 180°	5 mm
	Shortest distance from end to a sharp bend	40 mm
	Shortest distance from start to a sharp bend	6 mm
MATERIAL COIL SPECIFICATIONS	Outside diameter	660 mm
	Thickness	0.66 mm - 1.6 mm
	Height	25 mm - 203.8 mm
LETTERFORM SPECIFICATIONS	Thickness	1.0 mm
	Height	37, 60 and 100 mm
	Length	7 m stick or 30 m coil

ChannelBender® R/T

Highly specialized automated letter bending technology for sign makers

- Material heights from 25mm up to 127mm
- Dedicated to fabricated, reverse or Trimless® LetterForm® letters
- 0.66mm to 1.6mm aluminum and 20 gauge stainless steel
- Also bends mirror finish stainless steel, polished brass and copper without leaving any mechanical bending marks
- Letters as small as 76.2mm in height and serifs as small as 4.76mm



The **ChannelBender® Series**, manufactured by SDS KOREA is a line of automated channel letter fabrication machines known as the fastest, most reliable and precise technology available to sign makers. Rigorous testing shows ChannelBenders can complete the process of bending returns 15% to 30% faster than the nearest competitive machines, and cut hand finishing time by an additional 30% or more. Customer feedback indicates it is typical to achieve return on investment between 12 and 18 months.

The **ChannelBender R/T** produces non-flanged letters. Its unique broaching feature produces crisper, sharper bends, allowing the machine to bend intricate shapes previously thought impossible to automate. In addition to aluminum, brass, and stainless material, the ChannelBender R/T can process LetterForm®, our proprietary aluminum return material, for the production of Trimless® channel letters.

The price of a fully equipped **ChannelBender R/T** includes set-up, installation, and on-site training at your facility. There is no optional equipment and there are no hidden fees. By the conclusion of your comprehensive training, you will know how to competently operate and maintain your new ChannelBender series machine.

SDS KOREA is an automated metal bending expert and the inventor and original holder of fifteen patents for this type of technology. Over 3,000 machines have been sold worldwide. Our 30 years of experience manufacturing and servicing these systems, combined with our dedicated team of technicians, create the very best service and support infrastructure in the industry.

TECHNICAL SPECIFICATIONS		
POWER	System	220VAC, 15A, 50/60Hz, 1P
DIMENSIONS (W x D x H)	System	2,180 mm x 900 mm x 1,650 mm
	Coil cassette	760 mm x 760 mm x 1,450 mm
FEATURES	Broaching of angles	Adjustable depth relief cut
	Batch processing	Yes
BENDING	Maximum angle	120° (coil)
	Smallest radius that can be bent a full 180°	5 mm
	Shortest distance from end to a sharp bend	6 mm
	Shortest distance from start to a sharp bend	6 mm
MATERIAL COIL SPECIFICATIONS	Outside diameter	660 mm
	Thickness	0.66 mm - 1.6 mm
	Height	25 mm - 127 mm
LETTERFORM SPECIFICATIONS	Thickness	1.0 mm
	Height	37, 60 and 100 mm
	Length	3 m stick or 27 m coil

ChannelBender® XD

Extra duty for bending up to 2mm aluminum

- Material heights from 38mm to 216mm
- Adjustable broaching mechanism
- Bend aluminum, stainless, and mild steel
- 0.8mm - 2.0mm aluminum and 20 gauge stainless or mild steel
- Letters as small as 76.2mm in height and serifs as small as 4.76mm (19mm with 2.0mm)



The ChannelBender® Series, manufactured by SDS KOREA is a line of automated channel letter fabrication machines known as the fastest, most reliable and precise technology available to sign makers. Rigorous testing shows ChannelBenders can complete the process of bending returns 15% to 30% faster than the nearest competitive machines, and cut hand finishing time by an additional 30% or more. Customer feedback indicates it is typical to achieve return on investment between 12 and 18 months.

The ChannelBender XD is the most powerful channel letter machine available, making the processing of 2.0mm aluminum returns quick and painless. If a large part of your business comes from the fabrication of traditional or reverse channel letters, the ChannelBender XD is a must have. Why build letters the hard way when the XD can automate the process quickly and precisely.

The price of a fully equipped ChannelBender XD includes set-up, installation, and on-site training at your facility. There is no optional equipment and there are no hidden fees. By the conclusion of your comprehensive training, you will know how to competently operate and maintain your new ChannelBender series machine.

SDS KOREA is an automated metal bending expert and the inventor and original holder of fifteen patents for this type of technology. Over 3,000 machines have been sold worldwide. Our 30 years of experience manufacturing and servicing these systems, combined with our dedicated team of technicians, create the very best service and support infrastructure in the industry.

TECHNICAL SPECIFICATIONS		
POWER	System	220VAC, 15A, 50/60Hz, 1P
	Oil Pump	220VAC, 6.4/3.7A (max/typ)
DIMENSIONS (W x D x H - monitor excluded)	System	2,370 mm x 1,110 mm x 1,500 mm
	Coil Cassette	760 mm x 760 mm x 1,070 mm
FEATURES	Vertical broaching of angles	100° (adjustable depth)
	Maximum flange thickness	Up to 2.0 mm
	Hydraulic flange notcher	30°, 60°, 100°, 130°
	Flange depth	Adjustable - 9.5 mm, 12.7 mm
	Cut-off tool for batch processing	Yes
BENDING	Maximum Angle	120° (coil)
	Smallest radius that can be bent a full 180°	38 mm with 2 mm coil
	Shortest distance from end to a sharp bend	40 mm
	Shortest distance from start to a sharp bend	25.4 mm
MATERIAL COIL SPECIFICATIONS	Outside Diameter	660 mm
	Thickness	0.8 mm - 2.0 mm
	Height	38 mm - 216 mm

ChannelSander®

Sand your letters before you bend them!

- Brush and vacuum system removes dust
- Uses standard ScotchBrite pads
- Variable speed
- Works with mill finish or painted letter coil
- Compatible with most bending machines
- Fast ROI
- Slashes labor costs



SDS KOREA is leading the way again, with its new ChannelSander which automatically preps coil by sanding it prior to being formed into channel letters. The ChannelSander can be set to sand one or both sides and will work with painted or mill finish material.

The **ChannelSander** is designed with one purpose in mind: to make your signmaking operation more efficient. This means hours of tedious, painstaking labor sanding your letters *after* they are formed are now effectively reduced to almost zero by doing it *before* they are formed. A moderately busy sign shop can expect a 100% return on investment in about 3 months and even less for a high-volume sign building operation. Just the reduction in production time would make a ChannelSander worth the investment. The higher level of quality and consistency is an added bonus.

ChannelSander will automate your channel letter preparation process, making your shop considerably more efficient while reducing your labor costs and improving quality and consistency.



Just a few of the benefits of automation!

TECHNICAL SPECIFICATIONS		
POWER	System	220VAC, 15A, 50/60Hz, 1P
DIMENSIONS (W x D x H - monitor excluded)	ChannelSander	760 mm x 540 mm x 1,530 mm
	Coil Cassette (not included)	760 mm x 760 mm x 1,070 mm
FEATURES	Integrated vacuum	Removes dust before bending
	Setup	Sand one or both sides
	Materials	Painted or mill finish
MATERIAL COIL SPECIFICATIONS	Outside Diameter	660mm
	Thickness	0.8 mm - 2.0 mm
	Height	35 mm - 254 mm



ChannelTrimmerTM

Reliable automated trim cap processing

- Automatically notches for all outside corners
- Marks inside corners with 2 small dimples
- Inkjet printer to label each piece
- Lengths and distances are measured with exacting precision
- Produces enough trim cap for 400 - 600 letters per day



ChannelTrimmer is an automated trim cap processing solution that will automatically notch outside corners, mark inside corners and measure all distances with remarkable accuracy. Lightning fast, compact and easy to use, this trim cap processing solution processes most conventional trim cap materials with speed and accuracy that will dramatically increase efficiency and output. One ChannelTrimmer is capable of producing enough finished trim cap to support as many as six channel letter bending machines. Just imagine, this one, simple, easy to use machine can produce trim cap for as many as 400-600 letters per day! ChannelTrimmer will automatically notch all outside corners using an automatic notching system that is equipped with eight different angle notching tools. Each tool is different angle – from 45° to 120° which allows your trim cap team to create sharp, crisp corners that add a clean, high-quality appearance and dimension to your front-lit channel letters and signs. Inside corners are marked with 2 faint dimples that disappear once the trim cap is formed to the inside angle. When used alongside one of our ChannelBender® series channel letter bending machines, ChannelTrimmer will dramatically lower production costs and increase profitability by delivering significant improvements to your output and efficiency. Not to worry if you don't own a ChannelBender brand bending machine. ChannelTrimmer can be used alongside any channel letter bending machine.

ChannelTrimmer pricing includes on-site set-up, installation, and training at your facility. There is no optional equipment and there are no hidden fees. By the conclusion of your comprehensive training, your team will know how to competently operate and maintain your new ChannelBender series machine.

TECHNICAL SPECIFICATIONS		
POWER	System	220VAC, 15A, 50/60Hz, 1P
DIMENSIONS (W x D x H)	System	1,600 mm x 680 mm x 1,360 mm
	Coil Cassette	Industry standard coil
FEATURES	V-Cut (Pneumatic Punch)	45°, 60°, 70°, 80°, 90°, 100°, 110°, 120° on flange
	Cut-Off Tool For Batch Processing	Yes
BENDING	Maximum Angle	Manual bending at marked bend points
MATERIAL COIL SPECIFICATIONS	Outside Diameter	Industry standard coil
	Thickness	1.0 mm
	Height	25 mm, 38 mm, 50.8 mm

ChannelStitcher™

Fast, secure channel letter fastening

- Works with both aluminum sheet and aluminum composite materials (ACM)
- No size limitation on flange tab.
- Compatible with thicker aluminum like 1.6mm and 2.0mm
- Strong, fast, reliable, and economical fastening



ChannelStitcher is the strongest, fastest, most inexpensive method available for fastening channel letter backs to the flange of your face-lit letters. This machine quickly and securely staples aluminum and /or ACM (aluminum composite material) used to create the back panels of your face-lit letters. This rapid-fire fastening solution creates its own industrial-strength staple from a coil of galvanized or stainless-steel wire. This mechanical fastener delivers strength and structural stability that is superior to any other commonly used fastening method. Bring the speed, strength and economic efficiency of an automatic fastening system to your channel letter assembly operations and achieve substantial, immediate reductions in labor and material costs with the addition of a ChannelStitcher, only from SDS KOREA.

Compared to Clinching:

Clinching does not work with aluminum composite material (ACM) and requires 9.5mm minimum tab size which prevents fastening along many radius bends. Clinching also produces notoriously weak connections in aluminum, especially when thickness ex-ceeds 1mm. ChannelStitcher does not have any of these limitations.

Compared to Riveting:

Rivets are many times more expensive than staples. A 4.5kg spool of stitcher wire will produce about 30,000 staples, making staples a fraction of a penny each (approximately 1/5 of a cent each), unlike rivets which are several cents each.

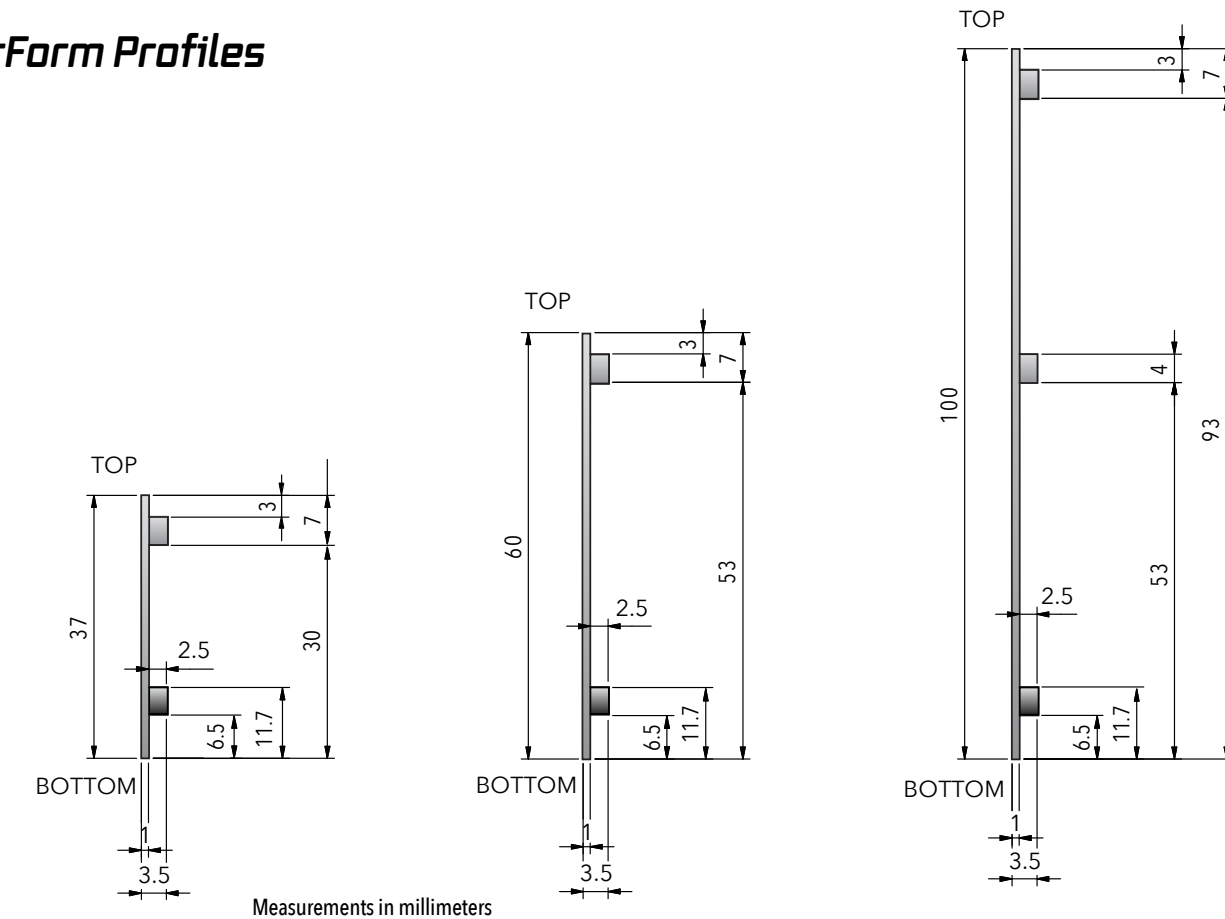
Compared to Gluing:

Adhesives are expensive as are the mixing tips for the glue cartridges. Stitching produces no fumes, requires no cleaning and is dramatically less expensive than adhesive.

TECHNICAL SPECIFICATIONS		
POWER	System	110/115 VAC, ½ HP, 20 AMP
DIMENSIONS (W x D x H)	Floor space	610 mm x 1,040 mm x 1,830 mm
FEATURES	660mm throat	Accommodates stitching up to 1,320 mm letters
	Clearance	35 mm between clincher and head
	Work height	1,180 mm - top of post
	Wire	18 gauge - stainless or galvanized
SPEED	Up to	310 stitches per minute
MATERIAL	10# Coil	30,000 staples
	50# Coil	150,000 staples
AVAILABLE OPTIONS	Sign stitcher table	Adjustable height, air operated

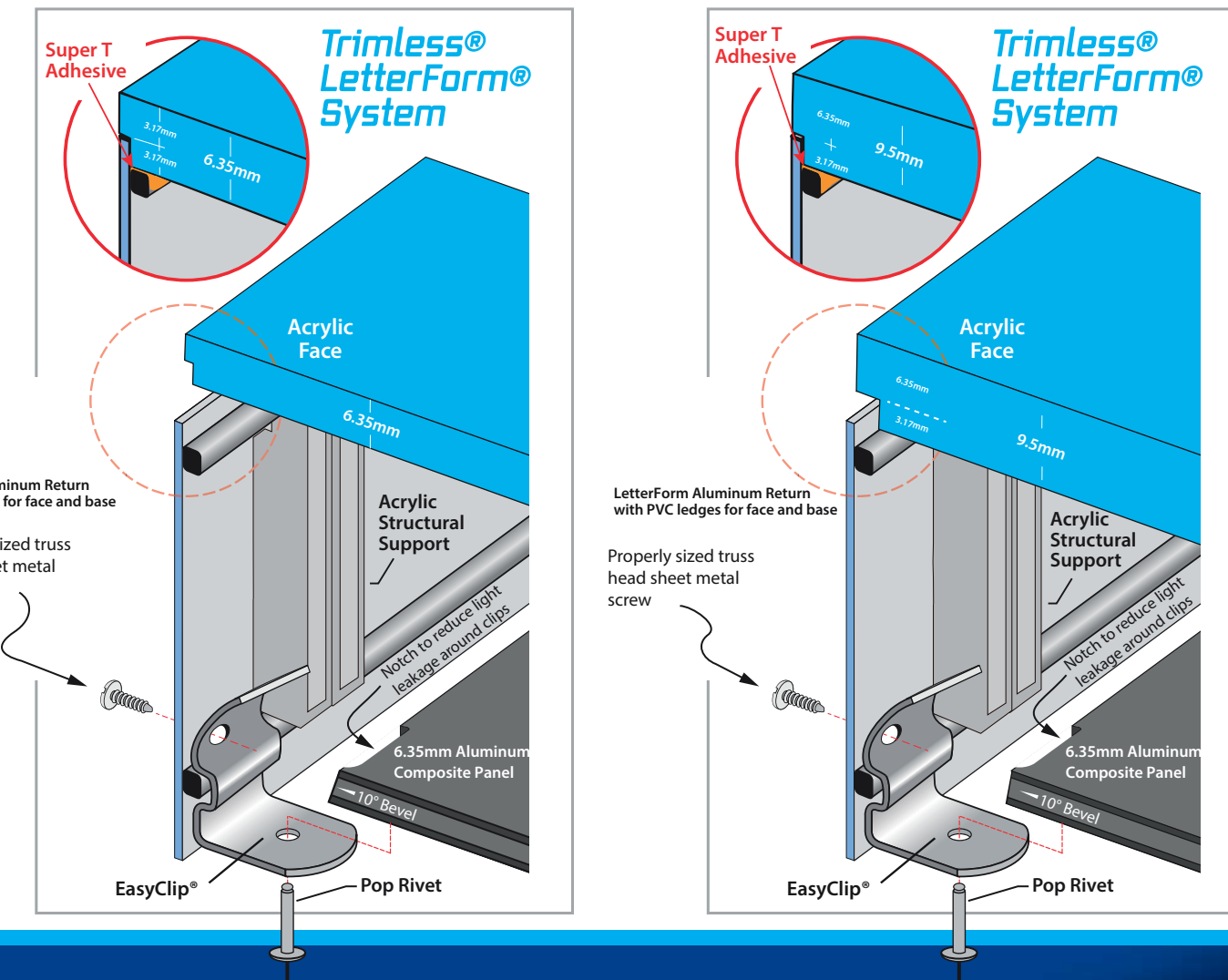
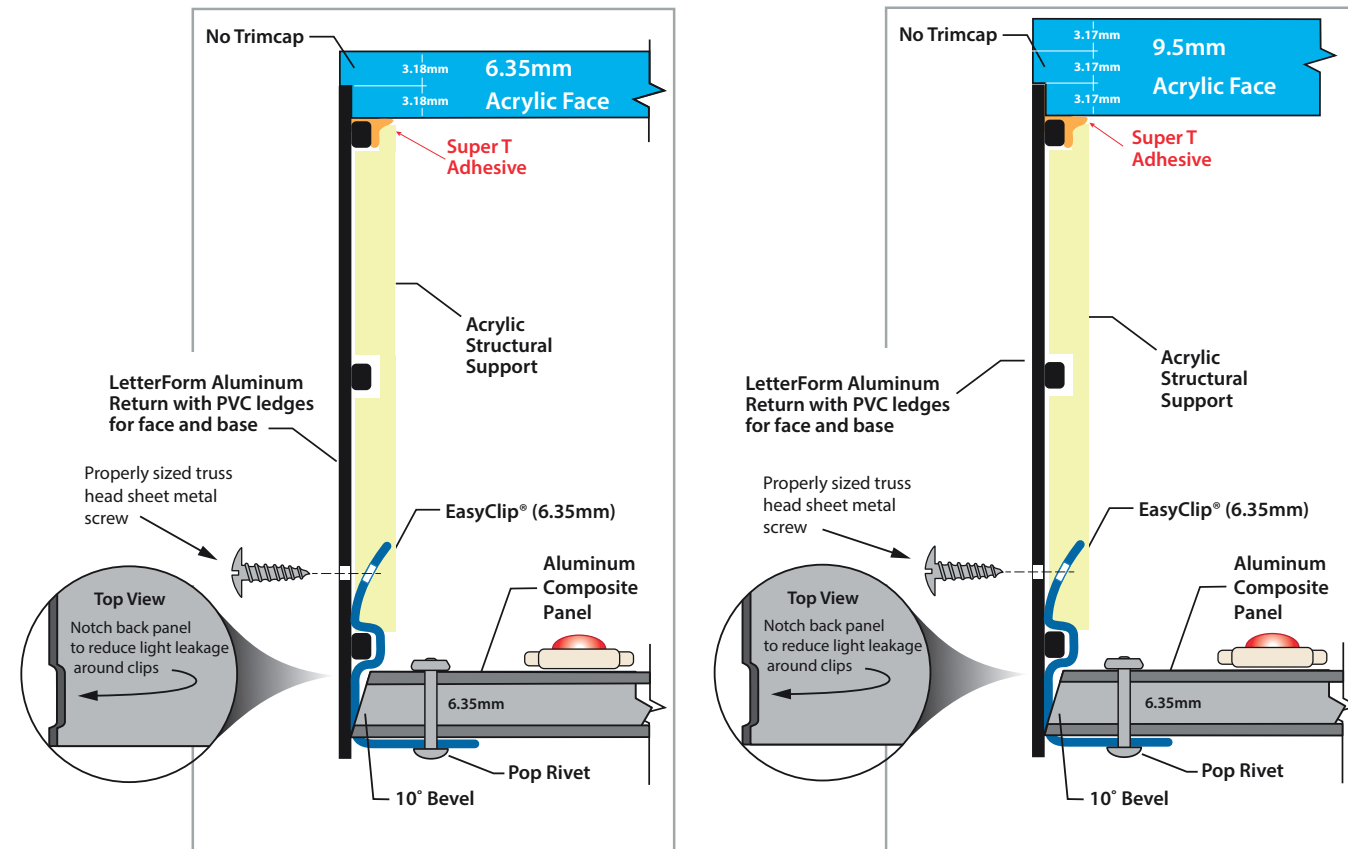
LetterForm Illustrations

LetterForm Profiles

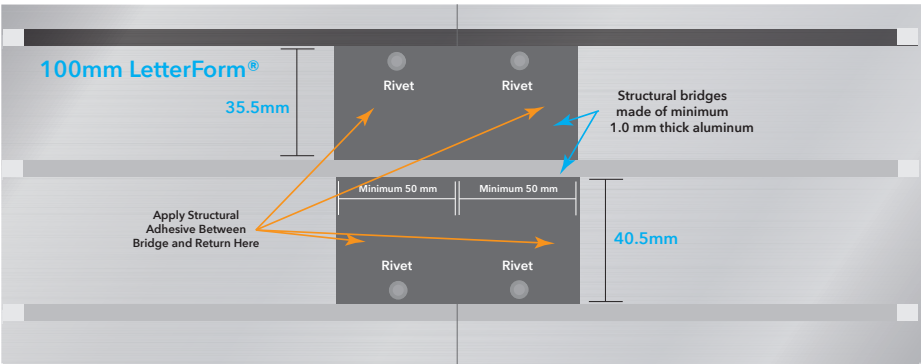
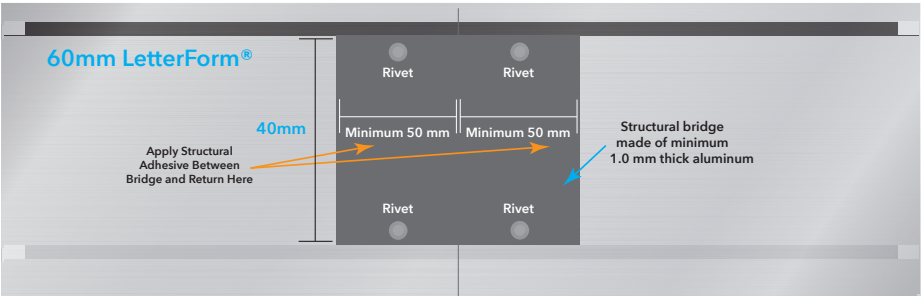
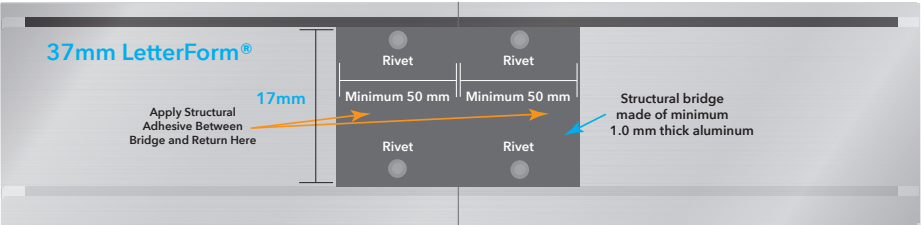


ChannelBender Series

Trimless® LetterForm® System



ChannelBender Series



Notes



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