

Heavy Duty Pipe/Tube Bending Machine



(SINGLE AXIS)

Applications of Pipe Bending Machines

- Building construction (Windows, Trusses, Interior decoration)
- Furnitures (Beds, Hospital equipments, Wheel chairs)
- Automotive (Exhaust, Seat frames, Stabilizers)
- Gymnasium Equipments- Baby Strollers
- Chemical Plant- Petrochemical Plants
- Stores display equipments
- Cycle, Motorcycle frames
- Electrical appliances
- Refrigeration pipes
- Irrigation systems
- Boiler tubes
- Material handling equipments

Sequence of Bending

- Insert tube over mandrel
- Grip end of tube with clamping die
- Close pressure die
- Select bending angle
- Initiate bending electrically through PLC
- Release both clamping and pressure die
- Remove bent portion out of roller die
- Proceed with next bend

MODEL NO.		PHDPB 32	PHDPB 45	PHDPB 65	PHDPB 100	PHDPB 150
Max. Capacity (Dia. X Thickness)	mm	Max. 32 X 2.0 Min. 6.00	Max. 45 X 3.0 Min. 12.00	Max. 65 X 6.0 Min. 20.00	Max. 114 X 7.0 Min. 25.00	Max. 168.3 X 7 Min. 50.00
Bend Radius CLR*	mm	Max. 120 Min. 20.0	Max. 150 Min. 25.0	Max. 350 Min. 30.0	Max. 350 Min. 40.0	Max. 450 Min. 75
Min. Bend Radius (In terms of D*)		1.5 D	1.5 D	1.5 D	1.5 D	1.5 D (upto 100mm dia pipe) 2.5 D (above 100mm dia pipe)
Standard Length over Mandrel Extra Length (available on request)	Mtrs.	2.01	2.01	2.01	4.01	4.01
Bend Angle Range	Deg	5-180	5-180	5-180	5-180	5-180
Bending Direction	PCB Cards & Boards	Clockwise	Clockwise	Clockwise	Clockwise	Clockwise
Bending Speed	Deg/Sec.	60	50	40	30	15
Indicative Production Rate (Approx.)	90 Deg Bends/Hr	150	150	125	100	30
Bend Angle Accuracy	Deg	± 0.25	± 0.25	± 0.25	± 0.25	± 0.25
Motor Capacity	HP	5	7.5	10	20	30
Weight (Appox.)	Tonnes	1	1.4	2	4	8

*D - Pipe Outside Diameter | *CLR - Centre Line Radius