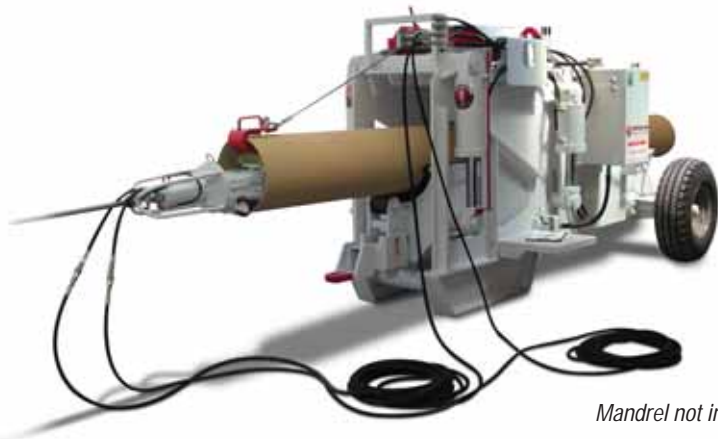


# BENDING MACHINES SPB 6-20 STANDARD

CE Approved

For bending pipe from 6" through 20"



Mandrel not included

## AVAILABLE ENGINES

ENGINE	CATERPILLAR	PERKINS *	DEUTZ
Net flywheel power (DIN 6271)	47 HP	37 HP	41 HP
Model	C2.2	104.19 Silent-Pack	F3L 1011F
Governed speed	2,600 rpm	2,500 rpm	2,500 rpm
Number of cylinders	4	4	4
Displacement	2.2 Liters	1.99 Liters	1.366 Liters
Bore x stroke	84 X 100 mm	84 x 90 mm	91 x 105 mm
Sound proofing type	yes	yes	yes

\* Default engine

## SHIPPING WEIGHT AND DIMENSIONS

Shipping Length	161.4" (4,100 mm)
Shipping Width	81.9" (2,080 mm)
Shipping Height	74.8" (1,900 mm)
Shipping Net Weight (Complete)	11,250 lb / 5,100 Kg
Operating Weight	11,250 lb / 5,100 kg
Tires Pneumatic Tires Tubeless	115/80-15.3
Hydraulic System Max. Operating Pressure	2,900 p.s.i. / 200 bar
Extra hydraulic control valves	2

## SPD 6-20 Standard Pipe Bending Machine

SPB 6-20 standard is our classic machine, resulting from over 35 years of experience. The demand for this small pipe bender is due to its simplicity and its strong structure.

The frame is made of high quality steel, and the parts mostly subject to stresses have been ribbed and boxed to ensure maximum resistance, though keeping the machine weight as light as possible.

The hydraulic system has 5 spools; the fourth and fifth spool may be used to control the hydraulic mandrel, if fitted. The separate

valves enable the operator to set the mandrel pressure independently from the machine.

The hydraulic cylinders are sized in such a way that they can operate with pressures exceeding 200 bar.

The diesel engine is in a fully insulated and hinged compartment, which swings open and enables the operator to gain access to the engine for maintenance purposes. The SPB 6-20 Standard is installed on rubber wheels, which make its travel easy on any job site, although it is undoubtedly the best solution, especially in small- and medium-sized projects.

## SPECIFICATIONS



### HYDRAULIC SYSTEM

Type	Gear
Maximum oil flow	12.6 U.S. gal/min / 48 lt/min
Pressure	2,900 p.s.i. / 200 bar



### CONTROLS

Type	Danfoss 5 valves proportional operated
Control	Manual



### ELECTRIC SYSTEM

Voltage	12 V
Batteries in series, maintenance free	1
Total rating	100 Amp/hr
Alternator	30 Amperes
Starter	4 kW



### WINCH

Type	Hydraulic drive
Motor	Orbital type
Line-pull	6,615 lb / 3,000 daN
Cable diameter	1/2" / 12 mm
Working pressure	1,990 p.s.i. / 140 bar
Speed at first layer	12.1 ft/min / 3.7 mt/min



### TIRES

Type	Tubeless
Size	115/80 - 15.3
Gauge	1,750 mm
Parking brake	Drum type



### CAPACITIES

Fuel tank	60 liters / 16 U.S. gal
Hydraulic system	120 liters / 32 U.S. gal

# BENDING MACHINES SPB 6-20 STANDARD

## SPECIFICATIONS

Cylinder	Two Out-Board	Two In-Board	One Pin-Up
Bore	7.8" / 200 mm	7" / 180 mm	5.1" / 130 mm
Stroke	12.4" / 315 mm	6" / 150 mm	29.5" / 750 mm
Max. Push	332,275 lb / 150,720 kg	228,439 lb / 103,620 kg	70,194 lb / 31,840 kg

Auxiliary Quick Disconnect	Size	Maximum Flow	Adj. Pressure
Aux-1	1/2"	24 U.S. gal/min / 90 liters/min	2,844 p.s.i. / 200 bar
Aux-2	3/8"	12.6 U.S. gal/min / 48 liters/min	2,844 p.s.i. / 200 bar

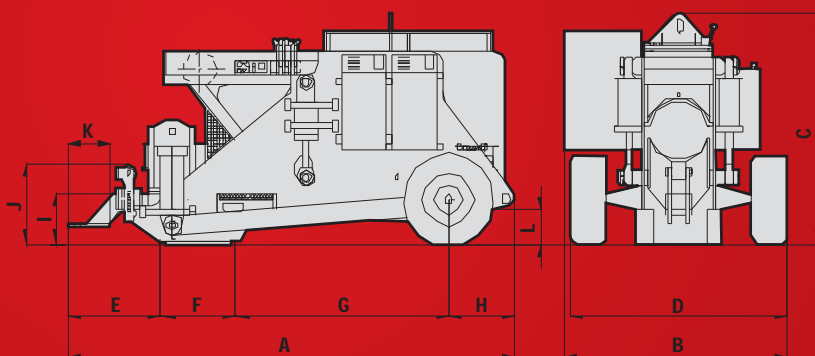
## BENDING DATA (U.S.)

Pipe O.D. inch	Maximum Wall Thickness By Grade (Inch)				Recommended Bend		
	X52	X60	X65	X70	Degree per Arc Foot	Radius Feet	Max Degree Per 40 Feet
6	2-3/4	2-3/16	1-5/16	1-5/16	4.41	13	132.30
8	2-3/16	2-3/16	1-5/16	1-9/32	3.82	15	114.60
10	2-3/16	1-5/16	1-9/32	1-1/4	2.86	20	85.80
12	2-1/16	1-1/4	1-3/32	1-3/32	2.30	25	69.00
14	1-3/4	1-1/32	31/32	7/8	1.70	34	51.00
16	1-3/16	13/16	3/4	11/16	1.51	38	45.30
18	1-1/32	5/8	9/16	17/32	1.10	52	33.00
20	11/16	7/16	9/32	11/32	0.83	69	24.90

## BENDING DATA (METRIC)

Pipe O.D. mm/in	Maximum Wall Thickness By Grade (mm)				Recommended Bend		
	X52	X60	X65	X70	Ratio Radius: O.D.	Radius Meter	Max Degree Per 12 Meters
6 / 168	55.8	55.8	33.8	33.8	23.6	3.96	132.30
8 / 219	55.8	55.8	33.8	33	20.9	4.57	114.60
10 / 273	55.8	33.8	33	31.43	22.3	6.10	85.80
12 / 324	52.8	31.43	27.94	27.94	23.5	7.62	69.00
14 / 355.6	44	26.21	24.45	22.68	29.1	10.36	51.00
16 / 406.4	34.9	20.9	19.22	17.46	28.5	11.58	45.30
18 / 457.2	26.21	15.69	13.97	13.10	34.7	15.85	33.00
20 / 508	17.46	11.34	10.48	8.71	41.4	21.03	24.90

## DIMENSIONS



A	4.1 m / 13.5'
B	3.03 m / 6.8'
C	1.9 m / 6.25'
D	2.05 m / 6.7'
E	87 cm / 2.85'
F	68 cm / 2.25'
G	1.94 m / 6.4'
H	61 cm / 2'
I	45.5 cm / 1.5'
J	71.5 cm / 2.4'
K	40 cm / 1.3'
L	30 cm / 1'



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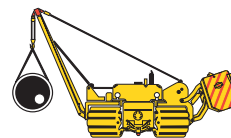
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