

## The performance parameters of the PBM series vertical hydraulic pipe cold bender

pipe-bending machine type	PBM0620	PBM1630	PBM2236	PBM3242	PBM3248	PBM4860
bending pipe diameter scope	Φ168-Φ508mm	Φ406-Φ762mm	Φ559-Φ914mm	Φ711-Φ1067mm	Φ711-Φ1219mm	Φ1219-Φ1524mm
apply to bending style	Applicable to screwed pipe, straight-side slot tube, seamless tube and boring inner or outer erosion resistant coating steel tube's embowing system, not spoiling steel tube erosion resistant coating.					
environment or operating temperature	-20°C - +50°C relative humidity : ≤ 85%					
engine power	46KW	75KW	125KW	132KW	160KW	160KW
hydraulic system pressure	16MPa	16MPa	16MPa	16MPa	16MPa	21MPa
master hydraulic cylinder	2pieces 220× 350	2pieces 280×500	4pieces 320× 500	4pieces 360×500	4pieces 450×560	6pieces 360×560

hydraulic cylinder	2pieces 180× 200	2pieces 200× 200	4pieces 220× 200	4pieces 250× 200	4pieces 280× 200	4pieces 280× 200
hydraulic winch pull	1.5t	2.5t	7t	7t	8t	12t
track	Assembled track is parseal lubrication and avoding attendance type, it is true of working at frigid climate particularly, after deposing for a long time, it can be used immediately, dispense with excess service.					
complete machine size(mm) (length* width* height)	4450×2180×2175	6600×2650×2700	8400×3000×2800	8850×3180×3000	9800×3335×3235	main machine size: 9875× 3190×3500 4300× 2280×2760
complete machine total weight	about 8t	about 20t	about 42t	about 50t	about 68t	about 93t
Each bending set pipe is made of pipe bending mandrel and the out bending set (it includes the up set, the front clamp, the front bending set and the down bending set) which cooperated each other. A diameter of this pipe matches a kind of front bending set and the out one.						

**PBM0620 type vertical hydraulic pipe cold bender**

Pipe external diameter (mm)	Maximum bending thickness(mm)					Suggesting bending specifications		
	X52 L360	X60 L415	X65 L465	X70 L485	X80 L555	max bending angle in one step	max bending angles (every 12m)	Shift distance every time
168	59	40	37	35		4.0	108	300-400mm
219	57	38	36	34		3.4	93	
273	55	37	35	33		3.0	81	
324	53	35	30	29		2.4	65	
356	45	30	27	24		1.74	47	
406	36	26	22	19		1.52	41	
457	28	21	17	14		1.0	29	
508	20	17	13	10		0.7	20	

Note: The max bending angles apply for longitudinal-seam steel pipe, suggesting bending specification's 75% are for screw-thread pipes; the efficient bending length is 8m.

**PBM1630 type vertical hydraulic pipe cold bender**

Pipe external diameter (mm)	Maximum bending thickness(mm)					Suggesting bending specifications		
	X52 L360	X60 L415	X65 L465	X70 L485	X80 L555	max bending angle in one step	max bending angles (every 12m)	distance every time
406	57	45	40	36		1.51	40.8	No bigger than 300mm
457	47	38	33	30		1.1	29.7	
508	43	33	31	30		0.9	24.4	
559	38	31	30	26		0.8	20.6	
610	33	26	25	23		0.75	20.3	
660	27	25	22	19		0.7	18.9	
711	22	19	17	15		0.65	17.6	
762	20	17	15	14		0.6	16.2	

Note: The max bending angles apply for longitudinal-seam steel pipe, suggesting bending specification's 75% are for screw-thread pipes; the efficient bending length is 8m.

**PBM2236 type vertical hydraulic pipe cold bender**

Pipe external diameter (mm)	Maximum bending thickness(mm)					Suggesting bending specifications		
	X52 L360	X60 L415	X65 L465	X70 L485	X80 L555	max bending angle in one step	max bending angles (every 12m)	Shift distance every time
559	58	51	48	43		0.9	23.4	No bigger than 300mm
610	54	48	44	40		0.8	20.8	
660	49	43	41	38		0.7	18.2	
711	43	39	37	35		0.65	16.9	
762	40	37	34	32		0.6	16.2	
813	37	35	32	29		0.6	16.2	
864	35	33	29	28		0.6	16.2	
914	32	30	27	25		0.5	13	

Note: The max bending angles apply for longitudinal-seam steel pipe, suggesting bending specification's 75% are for screw-thread pipes; the efficient bending length is 8m.

PBM3242 type vertical hydraulic pipe cold bender								
Pipe external diameter(mm)	Maximum bending thickness(mm)					Suggesting bending specifications		
	X52 L360	X60 L415	X65 L465	X70 L485	X80 L555	max bending angle in one step	max bending angles (every 12m)	Shift distance every time
813	45	39	38	34		0.58	15.6	No bigger than 350mm
864	44	37	36	33		0.55	14.8	
914	42	34	34	31		0.5	13.5	
965	39	32	31	29		0.5	12.75	
1016	36	30	28	27		0.5	12.75	
1067	35	28	26	25		0.5	12.5	

Note: The max bending angles apply for longitudinal-seam steel pipe, suggesting bending specification's 75% are for screw-thread pipes; the efficient bending length is 8m.

PBM3248 type vertical hydraulic pipe cold bender								
Pipe external diameter (mm)	Maximum bending thickness(mm)					Suggesting bending specifications		
	X52 L360	X60 L415	X65 L465	X70 L485	X80 L555	max bending angle in one step	max bending angles (every 12m)	Shift distance every time
813	86	74	66	60	52	0.50	15.00	No bigger than 300mm
864	75	67	63	54	46	0.50	13.40	
914	74	65	62	53	45	0.50	12.75	
965	72	65	61	52	44	0.50	12.75	
1016	69	63	59	50	42	0.50	12.75	
1067	66	61	57	48	40	0.50	12.75	
1118	63	59	55	46	38	0.50	10.50	
1168	61	57	53	44	36	0.50	10.50	
1219	58	54	50	41	33	0.50	10.50	

Note: The max bending angles apply for longitudinal-seam steel pipe, suggesting bending specification's 75% are for screw-thread pipes; the efficient bending length is 8m.

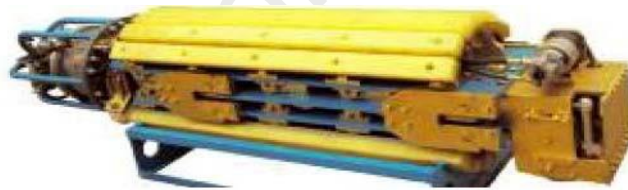
PBM4860 type vertical hydraulic pipe cold bender								
Pipe external diameter (mm)	Maximum bending thickness(mm)					Suggesting bending specifications		
	X52 L360	X60 L415	X65 L465	X70 L485	X80 L555	max bending angle in one step	max bending angles (every 12m)	Shift distance every time
1219	48	48	48	48	38	0.50	10.50	300-400mm
1270	48	48	48	44	35	0.50	10.50	
1321	48	48	48	41	32	0.50	10.50	
1372	48	48	48	38	30	0.50	10.50	
1422	48	48	44	35	27	0.50	10.50	
1473	46	44	40	36	25			
1526	45	43	38	35	25			

Note: The max bending angles apply for longitudinal-seam steel pipe, suggesting bending specification's 75% are for screw-thread pipes; the efficient bending length is 8m.

## PBM Vertical



Hydraulic Cold Bending Machine



Pneumatic Mandrel



Hydraulic Mandrel