BENDING MACHINES SPB 6-20 STANDARD
CE Approved
For bending pipe from 6” through 20”

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

**AVAILABLE ENGINES**

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

*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

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

### Auxiliary Quick Disconnect

<table>
<thead>
<tr>
<th>Size</th>
<th>Maximum Flow</th>
<th>Adj. Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/2”</td>
<td>24 U.S. gal/min / 90 liters/min</td>
<td>2,844 p.s.i. / 200 bar</td>
</tr>
<tr>
<td>3/8”</td>
<td>12.6 U.S. gal/min / 48 liters/min</td>
<td>2,844 p.s.i. / 200 bar</td>
</tr>
</tbody>
</table>

### BENDING DATA (U.S.)

<table>
<thead>
<tr>
<th>Pipe O.D.</th>
<th>Maximum Wall Thickness By Grade (Inch)</th>
<th>Recommended Bend</th>
</tr>
</thead>
<tbody>
<tr>
<td>inch</td>
<td>X52</td>
<td>X60</td>
</tr>
<tr>
<td>6</td>
<td>2-3/4</td>
<td>2-3/16</td>
</tr>
<tr>
<td>8</td>
<td>2-3/16</td>
<td>2-3/16</td>
</tr>
<tr>
<td>10</td>
<td>2-3/16</td>
<td>1-5/16</td>
</tr>
<tr>
<td>12</td>
<td>2-1/16</td>
<td>1-1/4</td>
</tr>
<tr>
<td>14</td>
<td>1-3/4</td>
<td>1-1/32</td>
</tr>
<tr>
<td>16</td>
<td>1-3/16</td>
<td>13/16</td>
</tr>
<tr>
<td>18</td>
<td>1-1/32</td>
<td>5/8</td>
</tr>
<tr>
<td>20</td>
<td>11/16</td>
<td>7/16</td>
</tr>
</tbody>
</table>

### BENDING DATA (METRIC)

<table>
<thead>
<tr>
<th>Pipe O.D.</th>
<th>Maximum Wall Thickness By Grade (mm)</th>
<th>Recommended Bend</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm/in</td>
<td>X52</td>
<td>X60</td>
</tr>
<tr>
<td>6 / 168</td>
<td>55.8</td>
<td>55.8</td>
</tr>
<tr>
<td>8 / 219</td>
<td>55.8</td>
<td>55.8</td>
</tr>
<tr>
<td>10 / 273</td>
<td>55.8</td>
<td>33.8</td>
</tr>
<tr>
<td>12 / 324</td>
<td>52.8</td>
<td>31.43</td>
</tr>
<tr>
<td>14 / 355.6</td>
<td>44</td>
<td>26.21</td>
</tr>
<tr>
<td>16 / 406.4</td>
<td>34.9</td>
<td>20.9</td>
</tr>
<tr>
<td>18 / 457.2</td>
<td>26.21</td>
<td>15.69</td>
</tr>
<tr>
<td>20 / 508</td>
<td>17.46</td>
<td>11.34</td>
</tr>
</tbody>
</table>

### 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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SUPERIOR MANUFACTURING
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