Pipe Benders

Manual Hydraulic

	2013 hand-hydraulic, tip-up wing head	3013 hand-hydraulic, tip-up wing head	4013 hand-hydraulic tip-up wing head
Hydraulic pressure pump	80 kN (8.000 kg)	130 kN (13.000 kg)	200 kN (20.000 kg)
Motorcapacity			
Weight including standard accessaries and standard formers (kg)	82	182	465
Deimensions of container (cm)	82 × 34 × 48	118 × 43 × 50	178 × 78 × 67
Standard formers for 90° bends (")	3/8 1/2 3/4 1 1 1/4 1 1/2 2	3/8 1/2 3/4 1 1 1/4 1 1/2 2 2 1/2 3	3/8 1/2 3/4 1 1 1/4 1 1/2 2 2 1/2 3 4
external diameter (mm)	17.2 21.3 26.9 33.7 42.4 48.3 60.3	17.2 21.3 26.9 33.7 42.4 48.3 60.3 76.1 88.9	17.2 21.3 26.9 33.7 42.4 48.3 60.3 76.1 88.9 114.3
Wall thickness DIN 2440 (mm) (150 medium, ISO R65)	2.35 2.65 2.65 3.25 3.25 3.25 3.65	2.35 2.65 2.65 3.25 3.25 3.25 3.65 3.65 4.05	2.35 2.65 2.65 3.25 3.25 3.25 3.65 3.65 4.05 4.50
Wall thickness DIN 2441 (mm) (150 heavy, ISO R65)	2.9 3.25 3.25 4.05 4.05 4.05 4.50	2.9 3.25 3.25 4.05 4.05 4.05 4.50 4.50 4.85	2..9 3.25 3.25 4.05 4.05 4.05 4.50 4.50 4.85 5.40
Bending radii (mm)	45 50 65 100 130 150 200	45 50 65 100 130 150 200 320 380	45 50 65 100 130 150 200 320 380 600
Standard accessories	7 formers, 2 bending blocks with dowel pins, 1 straightener, 1 U clamp	9 formers, 2 bending blocks with dowel pins, 1 straightener, 1 U clamp and 1 extention ram	10 formers, 4 hoekmallen, 1 straightener, 2 pins for pipe extrusion 4" and 2 extention ram
Optional formers for 180° in gas and steam tubes (inch and mm)	3/8 1/2 3/4 1 1 1/4 1 1/2 2 17.2 21.3 26.9 33.7 42.4 48.3 60.3	3/8 1/2 3/4 1 1 1/4 1 1/2 2 17.2 21.3 26.9 33.7 42.4 48.3 60.3	3/8 1/2 3/4 1 1 1/4 1 1/2 2 17.2 21.3 26.9 33.7 42.4 48.3 60.3
Bending radii (mm)	130 130 130 130 130 140 190	130 130 130 130 130 140 190	130 130 130 130 130 140 190
Optional attachment for hairpin bends up to 180°	Can be used	Can be used	
Optional formers for 90° bends (mm)	25/21 30/26 32/28 38/33 44.5/40 48.3/43.1 51/46	25/21 30/26 32/28 38/33 44.5/40 48.3/43.1	25/21 30/26 32/28 38/33 44.5/40 48.3/43.1
Bending radii (mm)	115 140 140 170 190 220 220	115 140 140 170 190 220 51/46 57/51.5 60.3/54.5 63.5/57.5 70/64 76/70 220 250 270 270 315 420	115 140 140 170 190 220 51/46 57/51.5 60.3/54.5 63.5/57.5 70/64 76/70 220 250 270 270 315 420
	P21 P25 P31 P38 P46 P52	P21 P25 P31 P38 P46 P52 P65	P21 P25 P31 P38 P46 P52 P65
Optional formers for 90° bends (")	3/8 1/2 3/4 1 1 1/4 1 1/2	3/8 1/2 3/4 1 1 1/4 1 1/2 2	3/8 1/2 3/4 1 1 1/4 1 1/2 2
Bending radii (mm)	110 110 137 140 170 220	110 110 137 140 170 220 270	110 110 137 140 170 220 270
Optional formers for 90° bends (")	1/2 3/4 1 1 1/4	1/2 3/4 1 1 1/4	1/2 3/4 1 1 1/4
External diam./wall thickness (mm)	21.3×1.75 / 26.9×1.75 / 33.7×2 / 42.5×2.00	21.3×1.75 / 26.9×1.75 / 33.7×2 / 42.4×2.00	21.3×1.75 26.9×1.75 33.7×2.00 42.4×2.00
Bending radii (mm)	110 137 190 220	110 137 190 220	110 137 190 220
Extra bending jig curve upto 180° internal diameter (mm)	120 140 160 180 200 220 240 260	120 140 160 180 200 220 240 260	120 140 160 180 200 220 240 260
Optional attachment for bends up to 180°	Can be used	Can be used	Can be used
Stroke adjustment	Can be used	Can be used	

Standard

Delivery in container

Accessories

90° Formers

polyethene covered tubes
Special 90° formers for 3/8 -2" (radii 110-270 mm) tubes.

construction tubes
Special 90° formers for 1/2-11/4" (21.3×1.75 - 42.5×2 mm) tubes.

Boilertubes
Special 90° formers for 25/21 - 76/70 mm boilertubes.

Special attachment for hairpin bends in gas and steam tubes
Not for Mark 1013, 1023 and 1323.

Pipe Benders

Electric Hydraulic

	2313 electro-hydraulic, tip-up wing head	3313 electro-hydraulic tip-up wing head	4313 electro-hydraulic tip-up wing head
Hydraulic pressure pump	80 kN (8.000 kg)	130 kN (13.000 kg)	200 kN (20.000 kg)
Motorcapacity	1,5 kW 3~ 400V / 1,4 kW 1~ 230V	1,5 kW 3~ 400V / 1,4 kW 1~ 230V	1,5 kW 3~ 400V / 1,4 kW 1~ 230V
Weight including standard accessaries and standard formers (kg)	100	208	475
Deimensions of container (cm)	82 × 39 × 60	118 × 47 × 60	178 × 78 × 67
Standard formers for 90° bends (")	3/8 1/2 3/4 1 1 1/4 1 1/2 2	3/8 1/2 3/4 1 1 1/4 1 1/2 2 2 1/2 3	3/8 1/2 3/4 1 1 1/4 1 1/2 2 2 1/2 3 4
external diameter (mm)	17.2 21.3 26.9 33.7 42.4 48.3 60.3	17.2 21.3 26.9 33.7 42.4 48.3 60.3 76.1 88.9	17.2 21.3 26.9 33.7 42.4 48.3 60.3 76.1 88.9 114.3
Wall thickness DIN 2440 (mm)	2.35 2.65 2.65 3.25 3.25 3.25 3.65	2.35 2.65 2.65 3.25 3.25 3.25 3.65 3.65 4.05	2.35 2.65 2.65 3.25 3.25 3.25 3.65 3.65 4.05 4.50
(150 medium, ISO R65)			
Wall thickness DIN 2441 (mm)	2.9 3.25 3.25 4.05 4.05 4.05 4.50	2.9 3.25 3.25 4.05 4.05 4.05 4.50 4.50 4.85	2.9 3.25 3.25 4.05 4.05 4.05 4.50 4.50 4.85 5.40
(150 heavy, ISO R65)			
Bending radii (mm)	45 50 65 100 130 150 200	45 50 65 100 130 150 200 320 380	45 50 65 100 130 150 200 320 380 600
Standard accessories	7 formers, 2 bending blocks with dowel pins, 1 straightener, 1 U clamp	9 formers, 2 bending blocks with dowel pins, 1 straightener, 1 U clamp and 1 extention ram	10 formers, 4 bending blocks with dowel pins, 1 straightener and 2 extention ram
Optional formers for 180°	3/8 1/2 3/4 1 1 1/4 1 1/2 2	3/8 1/2 3/4 1 1 1/4 1 1/2 2	3/8 1/2 3/4 1 1 1/4 1 1/2 2
in gas and steam tubes (inch and mm)	17.2 21.3 26.9 33.7 42.4 48.3 60.3	17.2 21.3 26.9 33.7 42.4 48.3 60.3	17.2 21.3 26.9 33.7 42.4 48.3 60.3
Bending radii (mm)	130 130 130 130 130 140 190	130 130 130 130 130 140 190	130 130 130 130 130 140 190
Optional attachment for hairpin bends up to 180°	Can be used	Can be used	Can be used
Optional formers for 90° bends (mm)	25/21 30/26 32/28 38/33 44.5/40 48.3/43.1 51/46	25/21 30/26 32/28 38/33 44.5/40 48.3/43.1 51/46	25/21 30/26 32/28 38/33 44.5/40 48.3/43.1
Bending radii (mm)	115 140 140 170 190 220 220	115 140 140 170 190 220 220	115 140 140 170 190 220
			51/46 57/51.5 60.3/54.5 63.5/57.5 70/64 76/70
			220 250 270 270 315 420
	P21 P25 P31 P38 P46 P52	P21 P25 P31 P38 P46 P52 P65	P21 P25 P31 P38 P46 P52 P65
Optional formers for 90° bends (")	3/8 1/2 3/4 1 1 1/4 1 1/2	3/8 1/2 3/4 1 1 1/4 1 1/2 2	3/8 1/2 3/4 1 1 1/4 1 1/2 2
Bending radii (mm)	110 110 137 140 170 220 mm	110 110 137 140 170 220 270	110 110 137 140 170 220 270
Optional formers for 90° bends (")	1/2 3/4 1 1 1/4	1/2 3/4 1 1 1/4	1/2 3/4 1 1 1/4
External diam./wall thickness (mm)	21.3×1.75 26.9×1.75 33.7×2.00 42.5×2.00	21.3×1.75 26.9×1.75 33.7×2.00 42.5×2.00	21.3×1.75 26.9×1.75 33.7×2.00 42.4×2
Bending radii (mm)	110 137 190 220	110 137 190 220	110 137 190 220
Extra bending jig curve upto 180° internal diameter (mm)	120 140 160 180 200 220 240 260	120 140 160 180 200 220 240 260	120 140 160 180 200 220 240 260
Optional attachment for bends up to 180°	Can be used	Can be used	Can be used
Stroke adjustment	Can be used	Can be used	Can be used

Accessories

180° formers for gas and steam tubes

Additional 180° formers for 3/8 - 2" (17.2 - 60.3 mm) tubes.

Electro-hydraulic tube benders with stroke ajustment

For serial bend production.

Pivot stand

Detachable stand with pivot head at working level.

Special attachment for 180° bends in flat bars

Not for Mark 1013, 1023 en 1323.