

PIPE BENDING MACHINES



Your global partner for pipeline equipment!

vietz®

Pipe Bending Machines

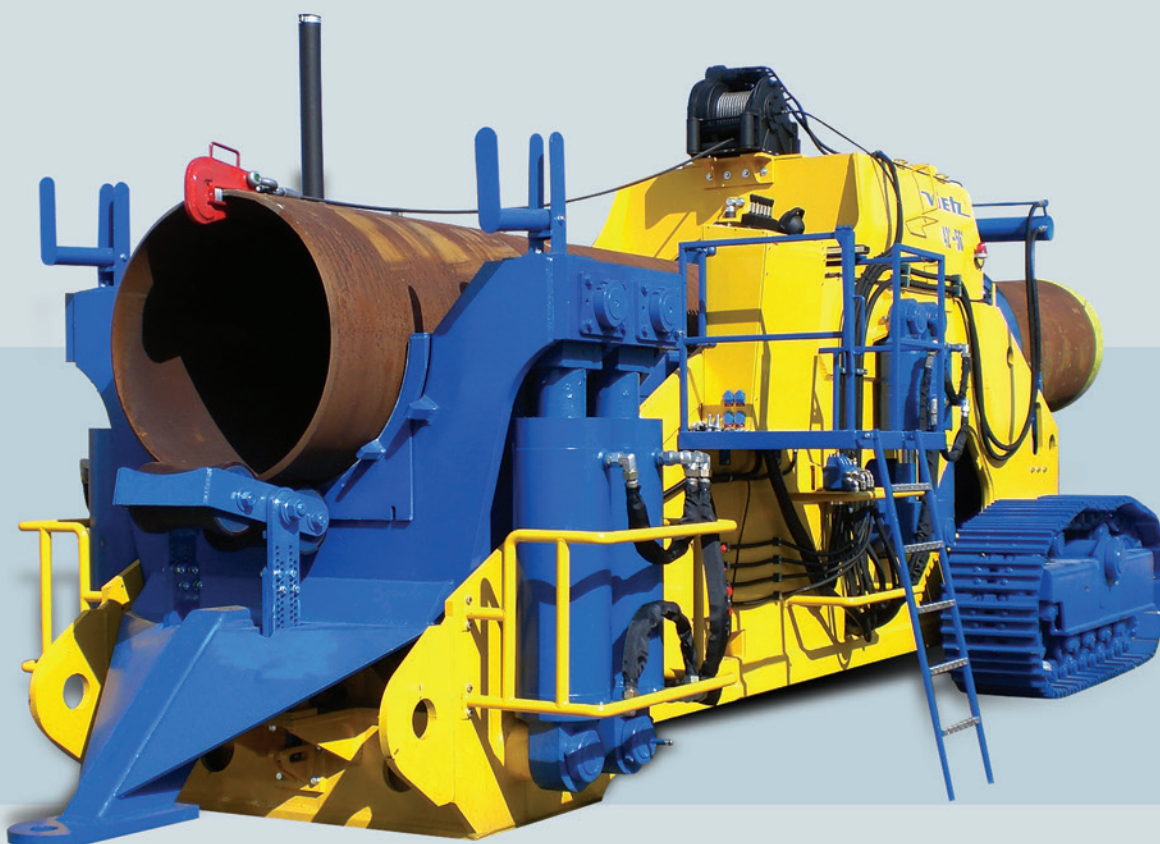
Pipe Bending Machines are used on construction sites to bend pipes according to the pipeline route intended. Each change on the direction of the pipeline must be individually dealt with by bending a pipe by a certain radius.

The development of new steels with ever increasing quality and the use of pipes with particularly thick walls requires continuous adaptation of machine components. That is why pipe bending machines by VIETZ are made of top-quality components only and are equipped with the latest technology. A robust steel frame construction, an exactly controllable hydraulic system and a diesel engine of sufficient power are crucial prerequisites for being able to professionally bend pipes on the site. When developing and designing our pipe bending machines, we can fall back on decades of experience in pipeline construction. On construction sites the machines are moved on wheels or tracks, depending on their size. To pull those heavy machines, usually side-booms are used.

The components of the machines have been selected under the premise that VIETZ pipe bending machines can be used in all regions of the world. For construction sites in regions characterized by very cold or very hot temperature, respectively, we offer special accessories so that pipes can be bent optimally even under extreme conditions.

As for the motor to be integrated in the pipe bending machines, our customers may choose from a range of manufacturers. However, we recommend diesel engines with noise-reduced design in order to protect the person executing the bending process from excessive noise. All relevant control elements are integrated in an operating panel, so that the operator is able to control all functions of the pipe bending machine from a single position.

The person executing the bending process must have sufficient experience in pipe bending to work adequately with our machines.



Pipe Bending Machines

General rule for field cold pipe-bending (onshore) is to make bending steps in the same distance as the outer diameter of the pipe and with bending angles between 1.0 and 2.0 degrees – depending on outer diameter, pipe material, wall thickness and coating.

In this way the total allowed bending angle in one length of pipe varies depending on the outer diameter, resulting in a bend radius of approx. 40 times the outer diameter (40D).

Actual bending steps and angles used on a project depend on several factors, including – but not limited to - material, thickness and diameter of the pipe, type and thickness of coating as well as project specifications.

For movement of the pipe from one bending position to the next, a hydraulic winch is integrated into the pipe bending machine's design.

A very important thing is that pipes must remain round during the bending. Usually, hydraulic or pneumatic mandrels are used to support the process. If pneumatic mandrels are used, the bending machine must be equipped with (the optional) air compressor (to be ordered (as extra feature)). Hydraulic mandrels can be connected directly to the bending machine's hydraulic system by provided couplings, and be operated from the machine's control panel. We integrate the control valves for operation of the hydraulic mandrel in our pipe bending machines.

At buyer's option, the bending set can be supplied in a coated, uncoated or PU-lined version to allow our customers to adjust the machine to the coating material used for their pipes.

All screwing's and threads are metrical, i.e. spare part supply is ensured all over the world (except for the USA). This is a real advantage compared to bending machines that have a Whitworth thread.

Options

Engines option

Deliverable with diesel engines from various manufacturers to meet customer's fleet policy as well as local exhaust emission standards.

ARCTIC Kit

For use in climatic zones characterized by very low temperatures. Comprises an additional preheating unit. More information on request.

TROPIC Kit

For use in climatic zones characterized by very high temperatures (up to 55°C), dusty air or very high humidity (up to 90%). Comprises an additional oil-cooling system and air-cleaning filter. More information on request.

COMPRESSOR Kit

Necessary when using pneumatic mandrels.

Large diesel tank



Pipe Bending Machine EV 2 – 8

Outside pipe Ø		Max. wall thickness (mm)					Technological values			
inches	mm	API-5L					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretically achievable angle for 12 m pipe (*1)(*2)	theoretically achievable angle for 18 m pipe
		X52	X60	X65	X70	X80				
2	60,3	all	all	all	all	all	2,41	7,46	248,8	398,0
4	114,3	all	all	all	all	all	4,57	3,94	131,2	210,0
6	168,3	45	40	35	30	25	6,73	2,67	89,1	142,6
8	219,1	23	21	19	18	16	8,76	2,05	68,5	109,5

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (please refer to the values below)

Specifications subject to change.

12 m ~ 10 m max. effective bending range 33,33 bending steps for 12 m. pipe

18 m ~ 16 m max. effective bending range 53,33 bending steps for 18 m. pipe

(*2) Max. recommended bending angle is only for pipe with wall thickness according to API-5L

the bending angles for pipe with wall thickness outside of API-5L can differ greatly.

	recommended not bendable ends	
	front [m]	rear [m]
EV 2-8"	1	1

Note: Data in the chart are recommendations and do not define warranted values. Please note that for spiral-weld pipes the recommended maximum bending angles have to be reduced by 25%.

Actual bending result depends on several factors: material, wall thickness and quality of the pipe – Welding type of pipe – Skill of the operator of the pipe bending machine – Type of bending set (coated, uncoated or lined) – Thickness and type of coating.

VIETZ Pipe Bending Machine EV 2 – 8 For pipe diameter 2" – 8"

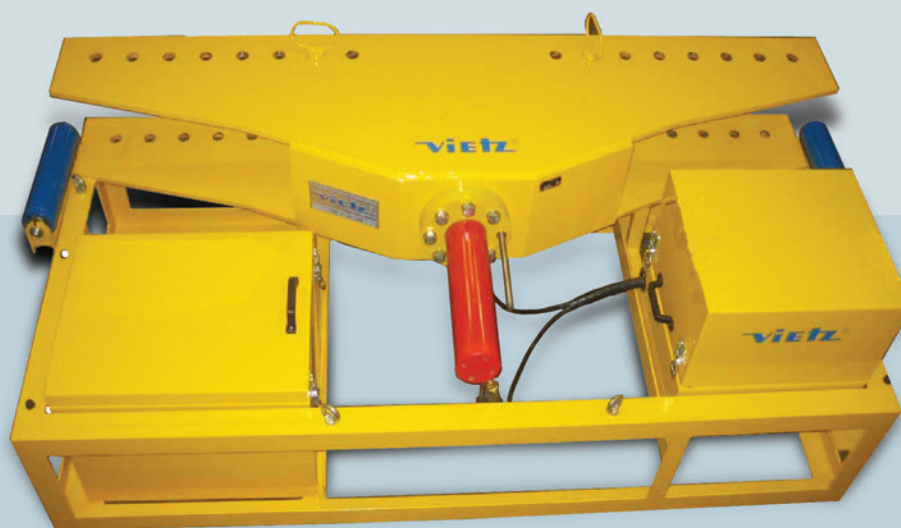
with petrol engine
with electric engine

Item no.: 40211
Item no.: 40214



Please include the following information when ordering the bending set:

- outside pipe diameter
- wall thickness
- type and thickness of coating



Pipe Bending Machine EV 6 – 24

Outside pipe Ø		Max. wall thickness (mm)					Technological values			
inches	mm	API-5L					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretically achievable angle for 12 m pipe (*1)(*2)	theoretically achievable angle for 18 m pipe
		X52	X60	X65	X70	X80				
6	168,3	all	all	all	all	all	6,73	2,67	76,6	130,1
8	219,3	all	all	all	all	all	8,77	2,05	58,8	99,9
10	273,1	all	all	all	85,0	75,0	10,92	1,65	47,2	80,2
12	323,9	all	all	all	72,0	60,0	12,96	1,39	39,8	67,6
14	356	all	all	68,0	60,8	50,0	14,22	1,27	36,3	61,6
16	406	all	48,0	44,0	41,0	37,0	16,26	1,11	31,7	53,9
18	457	42,0	38,0	35,0	33,0	29,1	18,29	0,98	28,2	47,9
20	508	35,0	31,0	29,0	27,5	25,9	20,32	0,89	25,4	43,1
22	559	30,0	27,0	26,0	24,3	22,7	22,35	0,81	23,1	39,2
24	610	26,0	24,0	23,0	20,9	20,3	24,38	0,74	21,2	35,9

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (please refer to the values below)

12 m ~ 8,6 m max. effective bending range 28,67 bending steps for 12 m. pipe

18 m ~ 14,6 m max. effective bending range 48,67 bending steps for 18 m. pipe

Specifications subject to change.

(*2) Max. recommended bending angle is only for pipe with wall thickness according to API-5L

the bending angles for pipe with wall thickness outside of API-5L can differ greatly.

	recommended not bendable ends	
	front [m]	rear [m]
EV 6-24"	2	1,4

Note: Data in the chart are recommendations and do not define warranted values. They are based upon using a Vietz Mandrel with the pipe bending machine. – Please note that for spiral-weld pipes the recommended maximum bending angles have to be reduced by 25%. Actual bending result depends on several factors: material, wall thickness and quality of the pipe - Welding type of pipe – Skill of the operator of the pipe bending machine – Type of bending set (coated, uncoated or lined) – Thickness and type of coating.

VIETZ Pipe Bending Machine EV 6 – 24

For pipes diameter 6" – 24"

mounted on wheels

mounted on heavy duty crawler undercarriage

Item no.: 40230A

Item no.: 40230C



Please include the following information when ordering the bending set:

- outside pipe diameter
- wall thickness
- type and thickness of coating



Pipe Bending Machine EV 16 – 30

Outside pipe Ø		Max. wall thickness (mm)					Technological values			
inches	mm	API-5L					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretically achievable angle for 12 m pipe (*1)(*2)	theoretically achievable angle for 18 m pipe
		X52	X60	X65	X70	X80				
16	406,4	all	all	all	all	all	16,26	1,11	30,3	52,4
18	457,2	all	all	all	all	all	18,29	0,98	26,9	46,6
20	508,0	all	all	all	all	all	20,32	0,89	24,2	41,9
22	558,8	all	all	all	93,2	76,5	22,35	0,81	22,0	38,1
24	609,6	83,4	75,1	68,8	65,4	56,2	24,38	0,74	20,2	34,9
26	660,4	62,5	57,2	52,4	50,2	44,9	26,42	0,68	18,6	32,3
28	711,2	50,4	46,8	42,4	41,0	36,1	28,45	0,63	17,3	29,9
30	762,0	41,1	38,0	35,0	34,2	30,2	30,48	0,59	16,1	28,0

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (please refer to the values below)

Specifications subject to change.

12 m ~ 8,2 m max. effective bending range 27,3 bending steps for 12 m. pipe

18 m ~ 14,2 m max. effective bending range 47,3 bending steps for 18 m. pipe

(*2) Max. recommended bending angle is only for pipe with wall thickness according to API-5L
the bending angles for pipe with wall thickness outside of API-5L can differ greatly.

	recommended not bendable ends	
	front [m]	rear [m]
EV 16-30"	2,4	1,4

Note: Data in the chart are recommendations and do not define warranted values. They are based upon using a Vietz Mandrel with the pipe bending machine. – Please note that for spiral-weld pipes the recommended maximum bending angles have to be reduced by 25%. Actual bending result depends on several factors: material, wall thickness and quality of the pipe - Welding type of pipe – Skill of the operator of the pipe bending machine – Type of bending set (coated, uncoated or lined) – Thickness and type of coating.

VIETZ Pipe Bending Machine EV 16 – 30 For pipes diameter 16" – 30"

with Deutz engine

Item no.: 40442



Please include the following information when ordering the bending set:

- outside pipe diameter
- wall thickness
- type and thickness of coating



Pipe Bending Machine EV 22 – 36

Outside pipe Ø		Max. wall thickness (mm)					Technological values			
inches	mm	API-5L					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretically achievable angle for 12 m pipe (*1)(*2)	theoretically achievable angle for 18 m pipe
		X52	X60	X65	X70	X80				
22	559	161,4	141,2	122,7	101,4	79,4	22,36	0,81	20,1	36,2
24	610	119,9	90,4	79,6	71,2	59,3	24,40	0,74	18,4	33,2
26	660	83,8	68,4	61,6	55,9	47,5	26,40	0,68	17,0	30,7
28	711	66,2	55,3	50,3	46,0	39,7	28,44	0,63	15,8	28,5
30	762	54,7	46,3	42,3	38,9	33,6	30,48	0,59	14,8	26,6
32	813	46,6	39,6	36,4	33,5	29,1	32,52	0,55	13,8	24,9
34	864	40,3	34,5	31,7	29,3	25,5	34,56	0,52	13,0	23,4
36	914	35,3	30,9	28,0	25,7	22,3	36,56	0,49	12,3	22,2

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (please refer to the values below)

12 m ~ 7,5 m max. effective bending range 25 bending steps for 12 m. pipe

18 m ~ 13,5 m max. effective bending range 45 bending steps for 18 m. pipe

Specifications subject to change.

(*2) Max. recommended bending angle is only for pipe with wall thickness according to API-5L
the bending angles for pipe with wall thickness outside of API-5L can differ greatly.

	recommended not bendable ends	
	front [m]	rear [m]
EV 22-36"	2,5	2

Note: Data in the chart are recommendations and do not define warranted values. They are based upon using a Vietz Mandrel with the pipe bending machine. – Please note that for spiral-weld pipes the recommended maximum bending angles have to be reduced by 25%. Actual bending result depends on several factors: material, wall thickness and quality of the pipe - Welding type of pipe – Skill of the operator of the pipe bending machine – Type of bending set (coated, uncoated or lined) – Thickness and type of coating.

VIETZ Pipe Bending Machine EV 22 – 36 For pipes diameter 22" – 36"

with Deutz engine

Item no.: 40443AD



Please include the following information when ordering the bending set:

- outside pipe diameter
- wall thickness
- type and thickness of coating



Pipe Bending Machine EV 30 – 42

Outside pipe Ø		Max. wall thickness (mm)					Technological values			
inches	mm	API-5L					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretically achievable angle for 12 m pipe (*1)(*2)	theoretically achievable angle for 18 m pipe
		X52	X60	X65	X70	X80				
30	762	98,6	81,2	73,3	66,7	56,7	30,48	0,59	13,8	25,6
32	813	81,0	67,8	61,6	56,4	48,3	32,51	0,55	12,9	24,0
34	864	68,7	58,0	52,9	48,5	41,8	34,54	0,52	12,2	22,6
36	914	59,3	50,4	46,1	42,4	36,6	36,58	0,49	11,5	21,3
38	965	52,0	44,4	40,7	37,5	32,4	38,61	0,47	10,9	20,2
40	1016	46,1	39,4	36,2	33,4	29,0	40,64	0,44	10,3	19,2
42	1067	41,3	35,4	32,5	30,0	26,1	42,67	0,42	9,8	18,3

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (please refer to the values below)

Specifications subject to change.

12 m ~ 7 m max. effective bending range 23,33 bending steps for 12 m. pipe

18 m ~ 13 m max. effective bending range 43,33 bending steps for 18 m. pipe

(*2) Max. recommended bending angle is only for pipe with wall thickness according to API-5L
the bending angles for pipe with wall thickness outside of API-5L can differ greatly.

	recommended not bendable ends	
	front [m]	rear [m]
EV 30-42"	3	2

Note: Data in the chart are recommendations and do not define warranted values. They are based upon using a Vietz Mandrel with the pipe bending machine. – Please note that for spiral-weld pipes the recommended maximum bending angles have to be reduced by 25%. Actual bending result depends on several factors: material, wall thickness and quality of the pipe - Welding type of pipe – Skill of the operator of the pipe bending machine – Type of bending set (coated, uncoated or lined) – Thickness and type of coating.

VIETZ Pipe Bending Machine EV 30 – 42 For pipes diameter 30" – 42"

with Deutz engine

Item no.: 40444AD



Please include the following information when ordering the bending set:

- outside pipe diameter
- wall thickness
- type and thickness of coating



Pipe Bending Machine EV 36 – 48

Outside pipe Ø		Max. wall thickness (mm)						Technological values			
inches	mm	API-5L						Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretically achievable angle for 12 m pipe (*1)(*2)	theoretically achievable angle for 18 m pipe
		X42	X52	X60	X65	X70	X80				
36	914	112	86,11	72,51	66,13	60,67	52,23	36,56	0,49	11,5	21,3
38	965	92	74,74	64,25	58	53,36	46,11	38,60	0,47	10,9	20,2
40	1016	78	65,83	56,13	51,47	47,43	41,12	40,64	0,44	10,3	19,2
42	1067	69	57,64	50,18	46,09	41,8	36,98	42,68	0,42	9,8	18,3
44	1118	60	52,68	45,22	41,59	37,5	33,47	44,72	0,40	9,4	17,4
46	1168	54	47,69	41,03	37,76	33,8	29,5	46,72	0,39	9,0	16,7
48	1219	49	43,44	37,44	34,51	31,1	27,5	48,76	0,37	8,6	16,0

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (please refer to the values below)

Specifications subject to change.

12 m ~ 7 m max. effective bending range 23,33 bending steps for 12 m. pipe

18 m ~ 13 m max. effective bending range 43,33 bending steps for 18 m. pipe

(*2) Max. recommended bending angle is only for pipe with wall thickness according to API-5L
the bending angles for pipe with wall thickness outside of API-5L can differ greatly.

	recommended not bendable ends	
	front [m]	rear [m]
EV 36-48"	3	2

Note: Data in the chart are recommendations and do not define warranted values. They are based upon using a Vietz Mandrel with the pipe bending machine. – Please note that for spiral-weld pipes the recommended maximum bending angles have to be reduced by 25%. Actual bending result depends on several factors: material, wall thickness and quality of the pipe - Welding type of pipe – Skill of the operator of the pipe bending machine – Type of bending set (coated, uncoated or lined) – Thickness and type of coating.

VIETZ Pipe Bending Machine EV 36 – 48 For pipes diameter 36" – 48"

with Deutz engine

Item no.: 40445AD



Please include the following information when ordering the bending set:

- outside pipe diameter
- wall thickness
- type and thickness of coating



Pipe Bending Machine EV 42 – 56

Outside pipe Ø		Max. wall thickness (mm)					Technological values			
inches	mm	API-5L					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretically achievable angle for 12 m pipe (*1)(*2)	theoretically achievable angle for 18 m pipe
		X52	X60	X65	X70	X80				
42	1067	107,7	89,21	80,76	73,64	62,78	42,68	0,42	8,9	17,3
44	1118	93,82	78,53	71,39	65,31	55,96	44,72	0,40	8,5	16,5
46	1168	83,02	69,97	63,8	58,51	50,31	46,72	0,39	8,1	15,8
48	1219	74,3	62,94	57,51	52,84	45,56	48,76	0,37	7,8	15,1
50	1270	67,09	57,04	52,22	48,04	41,51	50,80	0,35	7,4	14,5
52	1321	61,01	52,02	47,68	43,91	38,01	52,84	0,34	7,2	14,0
54	1372	55,81	47,69	43,76	40,34	34,96	54,88	0,33	6,9	13,4
56	1422	51,3	43,92	40,34	37,22	32,3	56,88	0,32	6,6	13,0

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (please refer to the values below)

Specifications subject to change.

12 m ~ 6,3 m max. effective bending range 21,00 bending steps for 12 m. pipe
18 m ~ 12,3 m max. effective bending range 41,00 bending steps for 18 m. pipe

(*2) Max. recommended bending angle is only for pipe with wall thickness according to API-5L
the bending angles for pipe with wall thickness outside of API-5L can differ greatly.

	recommended not bendable ends	
	front [m]	rear [m]
EV 42-56"	3,5	2,2

Note: Data in the chart are recommendations and do not define warranted values. They are based upon using a Vietz Mandrel with the pipe bending machine. – Please note that for spiral-weld pipes the recommended maximum bending angles have to be reduced by 25%. Actual bending result depends on several factors: material, wall thickness and quality of the pipe - Welding type of pipe – Skill of the operator of the pipe bending machine – Type of bending set (coated, uncoated or lined) – Thickness and type of coating.

VIETZ Pipe Bending Machine EV 42 – 56 For pipes diameter 42" – 56"

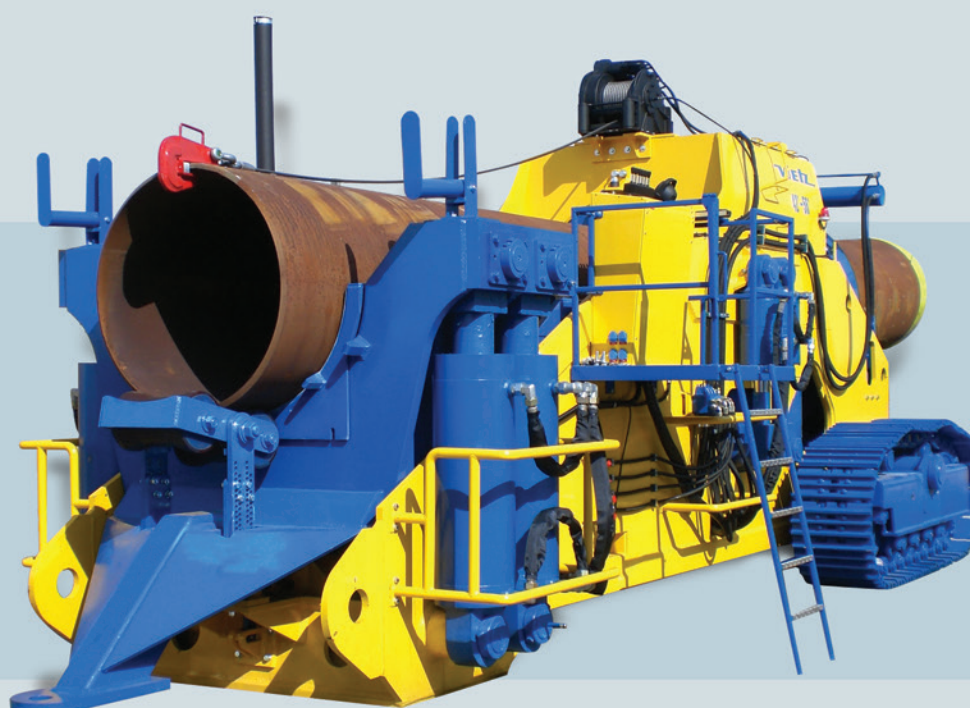
with Deutz engine

Item no.: 40481



Please include the following information when ordering the bending set:

- outside pipe diameter
- wall thickness
- type and thickness of coating



Pipe Bending Machine EV 48 – 64

Outside pipe Ø		Max. wall thickness (mm)					Technological values			
inches	mm	API-5L					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretically achievable angle for 12 m pipe (*1)(*2)	theoretically achievable angle for 18 m pipe
		X52	X60	X65	X70	X80				
48	1219	60	57	54	50	45	48,77	0,37	7,4	14,8
52	1321	53	50	47	45	40	52,83	0,34	6,8	13,6
56	1422	44	42	40,5	38	34	56,90	0,32	6,3	12,7
60	1524	38	36	34,5	33,5	30	60,96	0,30	5,9	11,8
64	1626	33	31	29,5	28,5	25	65,02	0,28	5,5	11,1

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (please refer to the values below)

Specifications subject to change.

12 m ~ 6 m max. effective bending range 20,00 bending steps for 12 m. pipe

18 m ~ 12 m max. effective bending range 40,00 bending steps for 18 m. pipe

(*2) Max. recommended bending angle is only for pipe with wall thickness according to API-5L
the bending angles for pipe with wall thickness outside of API-5L can differ greatly.

	recommended not bendable ends	
	front [m]	rear [m]
EV 48-64"	3,5	2,5

Note: Data in the chart are recommendations and do not define warranted values. They are based upon using a Vietz Mandrel with the pipe bending machine. – Please note that for spiral-weld pipes the recommended maximum bending angles have to be reduced by 25%. Actual bending result depends on several factors: material, wall thickness and quality of the pipe - Welding type of pipe – Skill of the operator of the pipe bending machine – Type of bending set (coated, uncoated or lined) – Thickness and type of coating.

VIETZ Pipe Bending Machine EV 22 – 36 For pipes diameter 22" – 36"

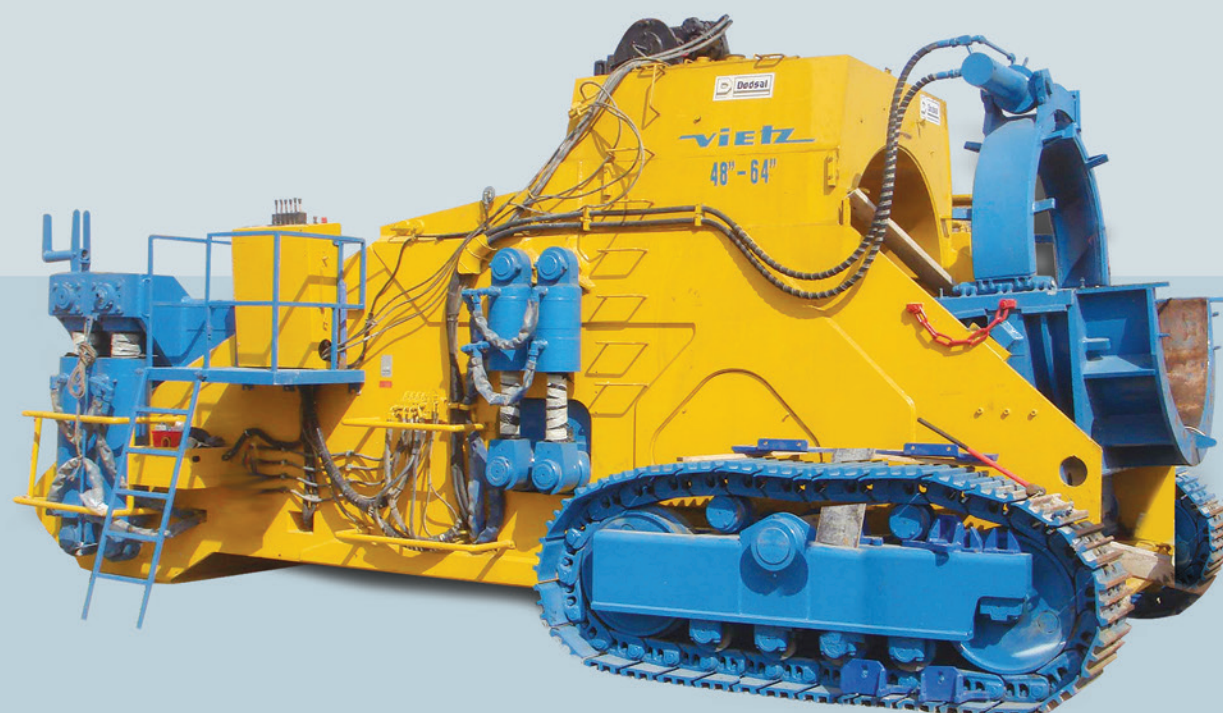
with Deutz engine

Item no.: 40447AD



Please include the following information when ordering the bending set:

- outside pipe diameter
- wall thickness
- type and thickness of coating



Technical Specifications of VIETZ Pipe Bending Machines

Technical changes reserved! Other make of engine on request possible – please ask us!

	PBM 2-8"		PBM 6-24"		PBM 16-30"
ENGINE					
Type	Briggs + Stratton	"Jet"-Motor	Deutz D 2011 L04 i		Deutz TCD 2012 L04 2V
Fuel	petrol	electric	diesel		diesel
No of cylinders	1 pcs	3 phase	4		4
Voltage		220/380V 50 Hz or 230/460V 60 Hz	inline four		inline four
Displacement	190 ccm		3620 ccm		4038 ccm
Cooling	air		air		liquid
Horse power	3 kW (4,5 HP)	2,24 kW (3,05 HP)	43 kW (58 HP)		83 kW (113 HP)
Engine speed	3000 rpm	2850 rpm	2200 rpm		2200 rpm
Airfilter	dry		dry		dry
Emission class			TIER 3, COM 3, EPA 3		TIER 3, COM 3, EPA 3
HYDRAULIC SYSTEM					
Type of pump	gear		axial piston open circuit pump		axial piston open circuit pump
No of pumps	single		single		single
Maximum pressure	700 bar / cylinder		310 bar		310 bar
Flow at rated speed	10 l/min		156 l/min		156 l/min
CAPACITIES					
Fuel tank	19 l		90 l		250 l
Hydraulik system	20 l		170 l		400 l
ELECTRIC SYSTEM					
Voltage			12 V		24 V
Batteries in series, maintenance free			1		2
Total rating			88 Amp/hr		176 Amp/hr
Alternator			60 A		80 A
Starter			2,3 kW		4 kW
WINCH					
Type			Hydraulic drive		Hydraulic drive
Maximum pulling force (bottom/top rope layer)			45 kN		80 / 50 kN
Maximum rope speed (bottom/top rope layer)			2,6/8,9 m/min		7/11 m/min
Rope diameter			10 mm		12 mm
Maximum oil pressure			150 bar		200 bar
TIRE / UNDERCARRIAGE					
Track chain type / type			Tire	B1	B 1
Track/Carrier rollers				4	4
Gauge				1.490 mm	1490 mm
Length of track on ground				1400 mm	1400 mm
Triple grouser shoes width				500 mm	500 mm
MEASUREMENTS AND WEIGHT					
Operating weight	1.150 kg		9.000 kg	10.500 kg	19.000 kg
Height	1000 mm		2335 mm	2335 mm	2.250 mm
Length	2900 mm		4675 mm	4960 mm	6300 mm
Width	1200 mm		2320 mm	2330 mm	3090 mm
Article no.	40211	40214	40230A	40230C	40442
COMPRESSOR (Option)					
Type			Atlas Copco LT15-20		Atlas Copco LT15-20
Hydraulic drive			Parker F12-40		Parker F12-40
Operating pressure air			max. 20 bar / 290 psi		max. 20 bar / 290 psi
Airflow			15,1l/s @1500 rpm		15,1l/s @ 1500 rpm
Air reservoir capacity			150 l		2 x 150 l

Technical Specifications of VIETZ Pipe Bending Machines

Technical changes reserved! Other make of engine on request possible – please ask us!

PBM 22-36"	PBM 30-42"	PBM 36-48"	PBM 42-56"	PBM 48-64"
Deutz TCD 2013 L04 2V	Deutz TCD 2013 L06 2V	Deutz TCD 2013 L06 2V	Deutz TCD 2013 L06 2V	Deutz TCD 7.8 L6
diesel	diesel	diesel	diesel	diesel
4	6	6	6	6
inline four	inline six	inline six	inline six	inline six
4764 ccm	7146 ccm	7146 ccm	7146 ccm	7800 ccm
liquid	liquid	liquid	liquid	liquid
104 kW (141 HP)	197 kW (268 HP)	197 kW (268 HP)	197 kW (268 HP)	250 kW (340 HP)
2200 rpm	2200 rpm	2200 rpm	2200 rpm	2200 rpm
dry	dry	dry	dry	dry
TIER 3, COM 3, EPA 3	TIER 3, COM 3, EPA 3	TIER 3, COM 3, EPA 3	TIER 3, COM 3, EPA 3	TIER 3, COM 3, EPA 3
axial piston open circuit pump	axial piston open circuit pump	axial piston open circuit pump	axial piston open circuit pump	axial piston open circuit pump
single	single	single	tandem	tandem
310 bar	350 bar	350 bar	290 bar	290 bar
245 l/min	309 l/min	309 l/min	245 l/min	245 l/min
250 l	320 l	380 l	400 l	420 l
450 l	800 l	800 l	800 l	800 l
24 V	24 V	24 V	24 V	24 V
2	2	2	2	2
176 Amp/hr	176 Amp/hr	176 Amp/hr	176 Amp/hr	176 Amp/hr
55 A	80 A	80 A	80 A	55 A
3 KW	4 KW	4 KW	4 KW	3 KW
Hydraulic drive	Hydraulic drive	Hydraulic drive	Hydraulic drive	Hydraulic drive
80 / 50 kN	80 / 50 kN	100 / 65 kN	150 / 107 kN	150/107 kN
7/11 m/min	7/11 m/min	8/9,5 m/min	5/7 m/min	5/7 m/min
12 mm	12 mm	16 mm	19 mm	19 mm
200 bar	200 bar	200 bar	175 bar	175 bar
B 2	D7E	D7E	B 8	B 8
3	5	5	4	4
1.365 mm	2.245 mm	2.245 mm	2.200 mm	2.200 mm
1.350 mm	2.150 mm	2.150 mm	2.100 mm	2.100 mm
500 mm	600 mm	600 mm	600 mm	600 mm
24.300 kg	49.000 kg	59.500 kg	73.000 kg	77.500 kg
2.540 mm	3.120 mm	3.520 mm	4.020 mm	4.240 mm
7.210 mm	8.680 mm	8.860 mm	9.650 mm	9.760 mm
3.230 mm	3.660 mm	3.880 mm	4.100 mm	4.350 mm
40443AD	40444AD	40445AD	40481	40447AD
Atlas Copco LT15-20	Atlas Copco LT15-20	Atlas Copco LT15-20	Atlas Copco LT15-20	Atlas Copco LT15-20
Parker F12-40	Parker F12-40	Parker F12-40	Parker F12-40	Parker F12-40
max. 20 bar / 290 psi	max. 20 bar / 290 psi	max. 20 bar / 290 psi	max. 20 bar / 290 psi	max. 20 bar / 290 psi
15,1 l/s @ 1500 rpm	15,1l/s @ 1500 rpm	15,1l/s @ 1500 rpm	15,1l/s @ 1500 rpm	15,1l/s @ 1500 rpm
2 x 150 l	2 x 150 l	2 x 150 l	2 x 150 l	2 x 150 l

VIETZ

Pipe Bending Machines



Air-Compressor Kit for VIETZ Pipe Bending Machines

Using pneumatic mandrels requires that the pipe bending machine is equipped with an air compressor. The Compressor Kit comprises a hydraulic powered air compressor (ATLAS Copco or similar) plus 300 l compressed-air tank completely assembled including hose connections. All VIETZ Bending Machines as standard come with a hydraulic connection for the air compressor, so retrofitting of the machines is not a problem.



Mandrels for Pipe Bending Machines

VIETZ Mandrels for Pipe Bending Machines

As the quality of the steel used to produce pipes has increased over the years, pipe walls have to be adapted to this given fact. Of course, this has an effect on bending pipes on construction sites. To prevent pipe buckling and out-of-roundness in the bend, a bending mandrel must be used. The mandrel is placed inside the pipe at the position of bending. Then the mandrel is expanded. It thereby supports the pipe during the bending process by providing internal pressure.

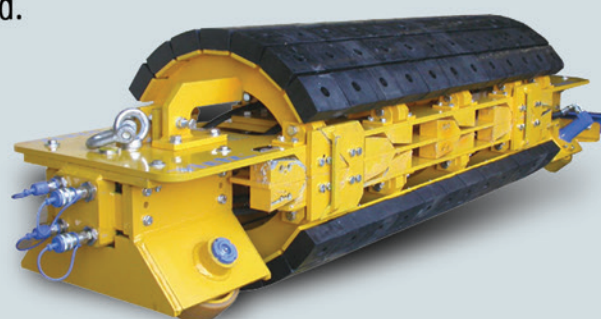
Hydraulic Mandrels

Depending on its size and weight, inside the pipe the mandrel either is moved manually using a reach rod or by a hydraulically driven motor. To operate the mandrel, the pull-type version requires two hydraulic hoses whereas the self-propelled one requires four. The hoses connect the mandrel to the hydraulic system of the bending machine. Vietz Pipe Bending Machines provide non-confusable couplings for the connection of those hoses

VIETZ Mandrels for Pipe Bending Machines

Inches	Item no.:
6" – 8"	40672
10" – 12"	40678H
14" – 16"	40697
18" – 20"	40698
22" – 24"	40683
26" – 28"	40684
30" – 32"	40679
36" – 38"	40686
40" – 42"	40688
46" – 48"	40699
52"	40691
56"	40692
64"	40693

One set of hoses for standard pipe length 12 m included.
Other lengths available on request.



A selection of further products made by VIETZ in Germany



ARCOTRAC

The ARCOTRAC series is specifically designed according to the requirements of large diameter pipeline construction. The advantage is the optimized utilization of a machinery concept with its unique focus on today's and future design features.



Vacuvietz

Our vacuum lifting technology is fully developed and represented on many construction sites all over the world. This modern pipe transporting unit is also operated by many pipe factories, saving time and staff. However – even more important – the risk of accidents by transporting pipes can be diminished to a minimum. The independent unit VACUVIETZ can be mounted on a crane, a pipe layer or a hydraulic excavator. Due to the changeable suction pads one VACUVIETZ unit handles the total range of all pipe diameters.



Line-up-Clamps

Pneumatic internal centring devices can be used in any terrain. The compressed-air drive ensures that the centring device moves in the pipe. Additionally fitted brakes prevent the centring device from moving through the pipe uncontrolled as a result of its own weight. Each line-up clamp can optionally be ordered equipped with a copper backing to assist in MAG orbital welding process.

Customer wishes can be included on request.



Headquarters VIETZ GmbH
Hannover

Fränkische Straße 30–32, 30455 Hannover

Tel. +49 (0) 511 94997-0

Fax +49 (0) 511 495116

info@vietz.de