



## Pipe Bending Machine



Ajashy Pipe Bending Machine is designed to bend a wide range of routine pipes, pipes with high wall thickness and high yield strength, efficiently at higher bending pace.

Fitted with 68 HP higher capacity engine and 110+43LPM superior hydraulic system, backed with robust high tensile steel main frame structure design Ajashy PBM produces enormous bending force which makes the complete bending system packed with remarkable bending capabilities resulting in effortless bending from 6 inches to 24 inches.

Ergonomically designed "No Step" operator station decreases operator fatigue drastically, making it easy for the operator to inspect the bending process and finish off jobs faster with high concentration.

### Salient Features

- Wider range of bending from 6 inches to 24 inches
- Higher capacity 68 HP Engine and 110+ 43 LPM Hydraulic Pump
- Calibrated bending indicator rod
- Pre-fitted QRC mounted circuit for Hydraulic Mandrels
- Provision of retrofitment Air Compressor
- "See It - Do It" window for operator
- All operation controls at single operator station

### Optionals

- Hydraulic Mandrels suitable for various pipe sizes
- Coated and Bare Die Sets
- Air Compressor to power Pneumatic Mandrels

## Specifications

### Operating Range

Pipe Diameter	6" - 24"	
Pipe Thickness	Bending Chart to be followed	
<b>Engine</b>	<b>Domestic</b>	<b>International</b>
Make	TMTL	Yanmar
Model	621 ES FF A	4TNV98-NSA
Power	68 hp	69 hp
Rated RPM	1800	2500
Engine Type	Water cooled, Diesel Engine	Water cooled, Diesel Engine
No. of Cylinders	03	04
Oil Sump Capacity	7.5 L	10.5 L
Recommended Oil	C4 15W40	SAE 10W30

### Hydraulics

Control Valve	Wolvoil ( Italy ) , 4 Section
Pump Type	Tandem Vane Pump
Maximum Pressure	220 Bar
Operating Flow	65 LPM
Hydraulic Tank Capacity	165 L
Recommended Oil	ISO 46
Mandrel Connections Size	1/2" BSP

### Winch

Pulling Force	6 Ton
Wire Rope	IWRC, Normal Lay, Ø 16 mm, 25 m

### Electrical

Voltage	12 V
Battery	100 Ah
Alternator	12 V
Starter	12 V

### Tyres

Nos. of Tyres	2
Size	11.00- 16/ 12 PR

### Structure

Operating Dimensions	5030 x 2160 x 2900 mm
Shipping Dimensions	4850 x 2160 x 2400 mm
Weight	7455 kg

## Bending Chart

Pipe Data		Pipe Steel Grade And Maximum Wall Thickness					Bending Radius (40 x D)			
Outside Diameter		X52 (API 5L)	X60 (API 5L)	X65 (API 5L)	X70 (API 5L)	X80 (API 5L)	Bending radius (40 x D)	Recommended Bending angle on 30 cm Bending Step	Theoretical Maximal Bending Angle for 12 m pipe (*1) (*2)	Theoretical Maximal Bending Angle for 18 m pipe
Inch	mm	mm	mm	mm	mm	mm	m			
6	168.3	all	all	all	all	all	6.73	2.67	76.6	76.6
8	219.3	all	all	all	all	all	8.77	2.05	58.8	76.6
10	273	all	all	all	85.0	75.0	10.92	0.97	47.2	76.6
12	323.9	all	all	all	72.0	60.0	12.96	1.39	39.8	67.6
14	355.6	all	all	68.0	60.8	50.0	14.22	1.27	36.3	61.6
16	406.4	all	48.0	44.0	41.0	37.0	16.26	1.11	31.7	53.9
18	457.2	42.0	38.0	35.0	33.0	29.1	18.29	0.98	28.2	47.9
20	508.0	35.0	31.0	29.0	27.5	25.9	20.32	0.89	25.4	43.1
22	558.8	30.0	27.0	26.0	24.3	22.7	22.35	0.81	23.1	39.2
24	609.6	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 table below.

12 m	8.6 m maximal effective bending range	29 bending steps for 12 m pipe
18 m	14.6 m maximal effective bending range	49 bending steps for 12 m pipe

(\*2) The maximal recommended bending angle is only for pipe with wall thickness according to API 5L. | The bending angle for pipe with wall thickness outside of API 5L can differ greatly.

Recommended not bendable lengths on pipe ends: Front: 2 m and Rear: 1.4 m

Bending values are reduced to 75% as mentioned in case of Spiral Welded Pipes.

Note: The values mentioned are for recommendation only, depend on multiple factors and are not warranted.

### Warranty

All products are guaranteed against defects due to faulty workmanship or materials for twelve months from the date of purchase. This guarantee is limited to the repair or replacement of any parts found to be defective, and no other liability—expressed, implied, or contingent—is assumed.

### Disclaimer

These specifications are general guidelines for product selection and can be changed for your specific requirement. Specifications are provided for convenience of reference only and may vary upon manufacturing of individual product.



## Ajashy Engineering Sales Private Limited

1505-1506, Tower 4, 15th Floor, DLF Corporate Greens,

Southern Peripheral Road, Sector-74 A, Gurugram, Haryana, India - 122004

Fixed Lines: 0124-5181505/06 | +91-9311666631 Email: info@ajashy.com Web: www.ajashy.com

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