Vietz®

Pipeline Equipment GmbH

PIPE BENDING MACHINES

VIETZ Pipe Bending Machines

VIETZ Pipe Bending Machines

Pipe bending machines are used on construction sites to bend pipes according to the pipeline route intended. Each change in 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 they are equipped with the latest technology. A robust steel girder 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 devices, usually sidebooms 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 temperatures, 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 sound-suppressing diesel engines in order to protect the person executing the bending process from excessive noise pollution. All relevant control elements are integrated in an operating panel, so that the person executing the bending process 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 devices.

In Germany, the first bending sequence on a site is usually made under the supervision of specialized authorities (TÜV or AMPA), whom the person in charge of the bending process has to give proof that he meets all practical requirements of the bending process. For bending pipes, there is a specific document available informing about the manufacturing of cold bent pipes.

VIETZ Pipe Bending Machines

According to this guideline, pipes are supposed to be bent max. 1,5° per bending stage and in conjunction with the pipe diameter. For example, a pipe DN 500 is bent by 1,5° at the respective position. After that, the pipe is shifted by 500 mm by means of the winch integrated in the bending machine. Then the second bending process is executed, also 1,5°. By this, you get a smaller or larger radius, depending on the pipe's dimension. A very important thing is that pipes must remain round after the bending process. The person executing the bending process must be an expert in his field – that's the key to successful pipe bending!

After the bending process, two calibration plates are pulled through the pipe. If these plates pass through the pipe without any difficulties, it can be assumed that the bending did not produce an out-of-round pipe.

Usually, hydraulic or pneumatic mandrels are used to support the bending process. If pneumatic mandrels are used, the bending machine must be equipped with an additional air compressor (to be ordered separately). Hydraulic mandrels can be connected directly to the bending machine, as they are supplied by the machine's hydraulic system and can be operated from the machine's control panel. Generally, two control valves for the mandrel are included, i.e. no additional assembly of the mandrel needs to be done.

At buyer's option, the bending set can be supplied in a coated, uncoated or PU-lined version. Provided the pipe bending machine is utilized in a professional fashion, we can guarantee that also when using uncoated bending sets no damages of the pipe insulation are produced.

All screwings and threads are metrical, i.e. spare parts 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.

Our bending machines are robust, provide long service life and are cost-efficient. We guarantee very short delivery times.

Options

- **Alternative engines**
  Optional engines available depending on the machine size
- **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.
- **BENDIT**
  Digital measuring instrument for automatic indication of the bending angle. Resolution: 0,1°.
- **Large diesel tank**

VIETZ Pipe Bending Machine EV 2-8

Outside pipe Ø		Max. wall thickness (API-5L)					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretical max. bending angle for 12 m pipe (*1) (*2)	theoretical max. bending angle for 18 m pipe
Inches	mm	X52	X60	X65	X70	X80				
2"	60	all	all	all	all	all	2,41	7,46°	248,8°	398,0°
4"	114	all	all	all	all	all	4,56	3,95°	131,6°	210,5°
6"	152	45	40	35	30	25	6,08	2,96°	98,7°	157,9°
8"	219	23	21	19	18	16	8,76	2,05°	68,5°	109,6°

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (plese refer to the table below)
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) The maximally 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.

	recomended not bandable ends	
	front [m]	rear [m]
EV 2-8	1	1

Note: The figures are recommended only and do not consitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine and the mandrel - The origin and the quality of the pipe - The type of pipe, spiral welded pipes accept only 75% of the recommended values - The type of bending set (lining, coating or uncoated)

VIETZ Pipe Bending Machine EV 2-8

For pipe diameter 2" - 8"

Item-No.: 40220A

Please include the following information when ordering the bending set:

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

VIETZ Pipe Bending Machine EV 6-24

Outside pipe Ø		Max. wall thickness (API-5L)					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretical max. bending angle for 12 m pipe (*1) (*2)	theoretical max. bending angle for 18 m pipe
Inches	mm	X52	X60	X65	X70	X80				
6	168	all	all	all	all	all	6,72	2,68	76,8	130,4
8	203	all	all	all	all	all	8,12	2,22	63,5	107,9
10	273	all	all	all	55,0	75,0	10,92	1,65	47,3	80,2
12	324	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 (plese refer to the table 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

(*2) The maximally 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.

	recomended not bandable ends	
	front [m]	rear [m]
EV 6-24	2	1,4

Note: The figures are recommended only and do not consitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine and the mandrel - The origin and the quality of the pipe - The type of pipe, spiral welded pipes accept only 75% of the recommended values - The type of bending set (lining, coating or uncoated)

VIETZ Pipe Bending Machine EV 6-24

For pipe diameter 6″ - 24″

Item-No.: 40230

Please include the following information when ordering the bending set:

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

VIETZ Pipe Bending Machine EV 16-30

Outside pipe Ø		Max. wall thickness (API-5L)					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretical max. bending angle for 12 m pipe (*1) (*2)	theoretical max. bending angle for 18 m pipe
Inches	mm	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 (plese refer to the table below)
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) The maximally 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.

	recomended not bandable ends	
	front [m]	rear [m]
EV 16-30	2,4	1,4

Note: The figures are recommended only and do not consitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine and the mandrel - The origin and the quality of the pipe - The type of pipe, spiral welded pipes accept only 75% of the recommended values - The type of bending set (lining, coating or uncoated)

VIETZ Pipe Bending Machine EV 16-30

For pipe diameter 16" - 30"

Item-No.: 40442

Please include the following information when ordering the bending set:

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

VIETZ Pipe Bending Machine EV 22-36

Outside pipe Ø		Max. wall thickness (API-5L)					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretical max. bending angle for 12 m pipe (*1) (*2)	theoretical max. bending angle for 18 m pipe
Inches	mm	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 (plese refer to the table 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

(*2) The maximally 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.

	recomended not bandable ends	
	front [m]	rear [m]
EV 22-36	2,5	2

Note: The figures are recommended only and do not consitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine and the mandrel - The origin and the quality of the pipe - The type of pipe, spiral welded pipes accept only 75% of the recommended values - The type of bending set (lining, coating or uncoated)

VIETZ Pipe Bending Machine EV 22-36

For pipe diameter 22" - 36"

Item-No.: 40443N

Please include the following information when ordering the bending set:

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

VIETZ Pipe Bending Machine EV 30-42

Outside pipe Ø		Max. wall thickness (API-5L)					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretical max. bending angle for 12 m pipe (*1) (*2)	theoretical max. bending angle for 18 m pipe
Inches	mm	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 (plese refer to the table below)
12 m ~ 7 m max. effective bending range — 23,3 bending steps for 12 m. pipe
18 m ~ 13 m max. effective bending range — 43,33 bending steps for 18 m. pipe

(*2) The maximally 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.

	recomended not bandable ends	
	front [m]	rear [m]
EV 30-42	3	2

Note: The figures are recommended only and do not consitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine and the mandrel - The origin and the quality of the pipe - The type of pipe, spiral welded pipes accept only 75% of the recommended values - The type of bending set (lining, coating or uncoated)

VIETZ Pipe Bending Machine EV 30-42

For pipe diameter 30" - 42"

Item-No.: 40444A

Please include the following information when ordering the bending set:

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

VIETZ Pipe Bending Machine EV 36-48

Outside pipe Ø		Max. wall thickness (API-5L)					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretical max. bending angle for 12 m pipe (*1) (*2)	theoretical max. bending angle for 18 m pipe
Inches	mm	X52	X60	X65	X70	X80				
36	914	86,11	72,51	66,13	60,67	52,23	36,56	0,49	11,5	21,3
38	965	74,74	64,25	58	53,36	46,11	38,60	0,47	10,9	20,2
40	1016	65,83	56,13	51,47	47,43	41,12	40,64	0,44	10,3	19,2
42	1067	57,64	50,18	46,09	42,54	36,98	42,68	0,42	9,8	18,3
44	1118	52,68	45,22	41,59	38,45	33,47	44,72	0,40	9,4	17,4
46	1168	47,69	41,03	37,76	34,96	30,48	46,72	0,39	9,0	16,7
48	1219	43,44	37,44	34,51	31,96	30,91	48,76	0,37	8,6	16,0

(*1) Average values, which consider connections for the free pipe ends, which will not be bent (plese refer to the table below)
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) The maximally 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.

	recomended not bandable ends	
	front [m]	rear [m]
EV 36-48	3	2

Note: The figures are recommended only and do not consitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine and the mandrel - The origin and the quality of the pipe - The type of pipe, spiral welded pipes accept only 75% of the recommended values - The type of bending set (lining, coating or uncoated)

VIETZ Pipe Bending Machine EV 36-48

For pipe diameter 36"-48"

Item-No.: 40445

Please include the following information when ordering the bending set:

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

VIETZ Pipe Bending Machine EV 42-56

Outside pipe Ø		Max. wall thickness (API-5L)					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretical max. bending angle for 12 m pipe (*1) (*2)	theoretical max. bending angle for 18 m pipe
Inches	mm	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 (plese refer to the table below)
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) The maximally 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.

	recomended not bandable ends	
	front [m]	rear [m]
EV 36-48	3,5	2,2

Note: The figures are recommended only and do not consitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine and the mandrel - The origin and the quality of the pipe - The type of pipe, spiral welded pipes accept only 75% of the recommended values - The type of bending set (lining, coating or uncoated)

VIETZ Pipe Bending Machine EV 42-56

For pipe diameter 42" - 56"

Art.-Nr.: 40447

Please include the following information when ordering the bending set:

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

VIETZ Pipe Bending Machine EV 48-64

Outside pipe Ø		Max. wall thickness (API-5L)					Bending radius [m] (40 x D)	Recommended bending angle on 30 cm bending step	theoretical max. bending angle for 12 m pipe (*1) (*2)	theoretical max. bending angle for 18 m pipe
Inches	mm	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 (plese refer to the table below)
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) The maximally 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.

	recomended not bandable ends	
	front [m]	rear [m]
EV 36-48	3,5	2,5

Note: The figures are recommended only and do not consitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine and the mandrel - The origin and the quality of the pipe - The type of pipe, spiral welded pipes accept only 75% of the recommended values - The type of bending set (lining, coating or uncoated)

VIETZ Pipe Bending Machine EV 48-64

For pipe diameter 48" - 64"

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

	BM 2-8"	BM 6-24"	BM 16-30"	BM 22-36"
ENGINE				
Type	Briggs + Straton or E-Motor	DEUTZ D 2011 L04 i	Perkins 1104D-44TA	Perkins 1104D-E44 TA
Fuel	petrol or 380 VAC	diesel	diesel	diesel
No. of cylinders	1	4	4	4
Configuration	single	inline four	inline four	inline four
Displacement	190 ccm	3620 ccm	4400 ccm	4400 ccm
Cooling	air	air	liquid	liquid
Horse power	3 kW (4,5 HP)	43 kW (58 HP)	75 kW (100 HP)	96,5 kW (130 HP)
Engine speed (1/min)	3000	2200	2200	2200
Airfilter	dry	dry	dry	dry
Tank volume	1,5 l	90 l	220 l	250 l
Emission class	-	TIER 3, COM 3, EPA 3	TIER 3, COM 3, EPA 3	TIER 3, COM 3, EPA 3
HYDRAULIC SYSTEM				
Type of pump	gear	axial piston	axial piston	axial piston
No. of pumps	single	single	single	single
Operating pressure	100 bar @ 3000 rpm	230 bar @ 2200 rpm	230 bar/2200 rpm	230 bar @ 2200 rpm
Flow	20 l	132 l @ 2200 rpm	220 l @ 2200 rpm	220 l @ 2200 rpm
Tank volume	20 l	170 l	400 l	520 l
MEASUREMENTS AND WEIGHT				
Weight	1.000 kg	9000 kg	17.500 kg	22.500 kg
Height (w winch / w/o winch)	1000 mm	2335 mm	2250 / 2160 mm	2680 / 2660 mm
Length	2900 mm	4675 mm	6500 mm	7210 mm
Width (total / transport)	1200 mm	2315 mm	2960 / 2570 mm	3010 / 2670 mm
COMPRESSOR (option)				
Type				Atlas Copco LT15-20
Hydraulic drive				Parker F12-40
Operating pressure air				max 20 bar / 290psi
Airflow				15,1l/s @ 1500 1/min
Air reservoir capacity				2 x 150l

Technical specifications of VIETZ Pipe Bending Machines

	BM 30-42"	BM 36-48"	BM 42-56"	BM 48-64"	
	Perkins 1106D-E66TA	Perkins 1106D-E66TA	DEUTZ TCD 2013 L06 2V	Caterpillar. C9 DITA	DEUTZ TCD 2013 L06 4V
	diesel	diesel	diesel	diesel	diesel
	6	6	6	6	6
	inline six	inline six	inline six	inline six	inline six
	6600 ccm	6600 ccm	7100 ccm	8800 ccm	7100 ccm
	liquid	liquid	liquid	liquid	liquid
	168 kW (225 HP)	168 kW (225 HP)	197 kW (268HP)	224 kW (300 HP)	243 kW (326HP)
	2200	2200	2200	2200	2100
	dry	dry	dry	dry	dry
	250 l	250 l	400 l	500 l	500 l
	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	axial piston	axial piston	axial piston	
	single	single	tandem	tandem	
	230 bar @ 2100 rpm	230 bar @ 2100 rpm	240 bar @ 2200 rpm	240 bar @ 2200 rpm	
	323 l @ 2100 rpm	323 l @ 2100 rpm	386 l @ 2200 rpm	386 l @ 2200 rpm	
	815 l	815 l	815 l	815 l	
	47000 kg	59000 kg	70000 kg	77000 kg	
	3280 / 2980 mm	3520 / 3220 mm	4020 / 3455 mm	4243 / 3735 mm	
	8690 mm	8860 mm	9655 mm	9760 mm	
	3470 / 2955 mm	3680 / 2955 mm	4090 / 3595 mm	4800 / 3850 mm	
	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	
	max 20 bar / 290psig	max 20 bar / 290psig	max 20 bar / 290psig	max 20 bar / 290psig	
	15,1l/s @ 1500 1/min	15,1l/s @ 1500 1/min	15,1l/s @ 1500 1/min	15,1l/s @ 1500 1/min	
	2 x 150l	2 x 150l	2 x 150l	2 x 150l	

Specifications subject to change. Errors and omissions excepted.

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 250-l compressed-air tank completely assembled including hose connections. All VIETZ Pipe Bending Machines come standard with a hydraulic connection for the air compressor, so retrofitting of the machines is no problem.

Item-No.: 40695

VIETZ BENDIT

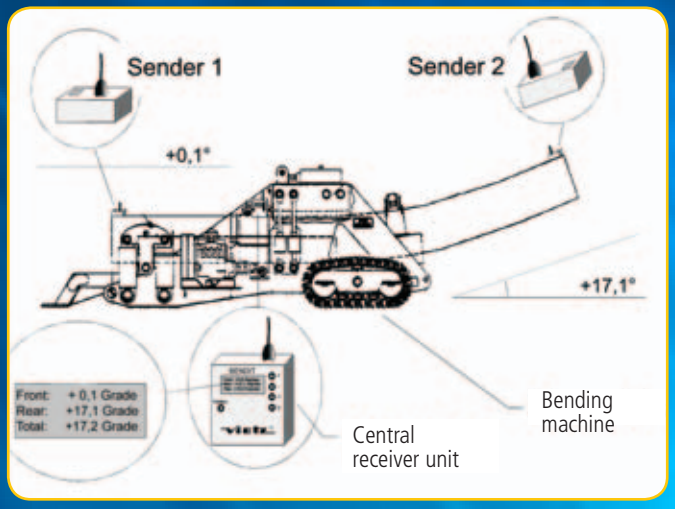
Digital measuring instrument to automatically indicate the bending angle. All VIETZ Pipe Bending Machines can be retrofitted with this device.

- measures and displays the bending angle of two pipe ends
- displays the total angle
- reading accuracy 0,1°
- robust and water-tight version according to IP 67, DIN 40050
- high signal-to-noise ratio due to temperature-compensated and proven sensors

Mode of operation

Each of the two sensors is mounted on a magnetic baseplate so that they can be placed on each of the pipe's ends. They transmit their position values to the central receiver unit, which then computes the absolute angle. The central receiver unit is mounted directly to the bending machine's control panel, allowing the person executing the bending process direct access to all relevant information displayed at any time.

Item-No.: 40696



VIETZ Mandrels for Pipe Bending Machines

VIETZ Mandrels for Pipe Bending Machines

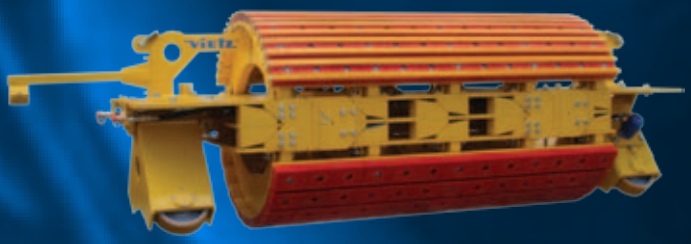
As the quality of the steel used to produce pipes has increased over the years, pipe walls have become thinner and thinner. Of course, this has an effect on bending pipes on construction sites. To prevent pipe buckling and out-of-round in the bend, a bending mandrel must be used. The mandrel is placed 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.

We offer two types of mandrels: pneumatic and hydraulic. The main difference between these two types of mandrels is that a hydraulic mandrel can be operated under much more pressure, i.e. an accurate bend of the pipe can be ensured regardless of the wall thickness.

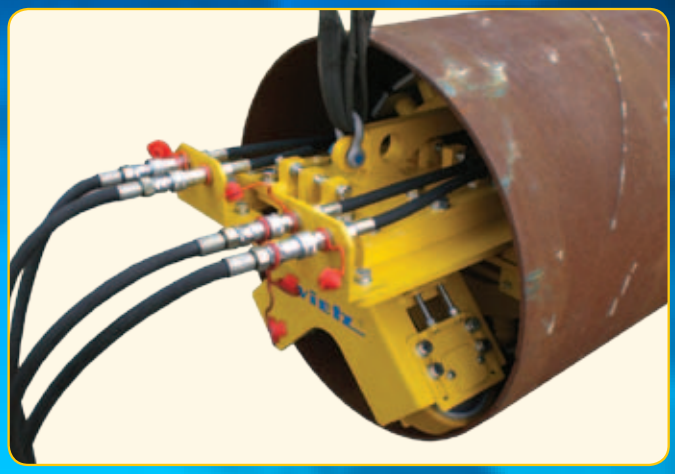
Hydraulic mandrels

Depending on its size, the hydraulic mandrel either is moved manually within the pipe using a reach rod, or it travels by means of a hydraulic motor. To operate the mandrel, the pull-type version requires two hydraulic hoses, whereas the self-propelled version requires four hydraulic hoses. The hydraulic mandrel is supplied directly over the bending machine's hydraulic system

Hydraulic mandrel 8"-10"



Hydraulic wedge-type mandrel 46"-48" (self-propelled)



VIETZ Mandrels for Pipe Bending Machines

Inches	For pipe Ø DN	Item-No.:
14 - 16	DN 350 - DN 400	40697
18 - 20	DN 450 - DN 500	40698
22 - 24	DN 550 - DN 600	40683
26 - 28	DN 650 - DN 700	40684
30 - 32	DN 750 - DN 800	40679
36 - 38	DN 900 - DN 950	40686
40 - 42	DN 1000 - DN 1050	40688
46 - 48	DN 1150 - DN 1200	40699
56 - 58	DN 1420 - DN 1450	40692
64 - 68	DN 1620 - DN 1727	40693

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

Other Products by Vietz

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

The hydraulic internal centring devices from Vietz are designed according to the same principle as the pneumatic ones. They can be operated with a hydraulic hand pump as well as with an electro-hydraulic power pack. We manufacture hydraulic internal centring devices from 6" - 64". Other sizes on request.

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. Another design feature of the pneumatic internal centring device is the copper backing for the MAG orbital welding process.

Arcotrac

Company Vietz has developed a totally new ARCOTRAC Series which has been specifically designed according to the requirements of large diameter pipeline construction. The advantage of the ARCOTRAC Series is the optimized utilization of a machinery concept with its unique focus on today's and future design features.

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03/2012 - Specifications subject to change. Errors and omissions excepted.