



A Division of Kiffer Industries, Inc.

HYDRAULIC RAM BENDER SPECIFICATIONS

Effective 01/30/2017

MODEL	BT-1000 – \$9,790.00	BT-2000 – \$10,290.00	BT-3000 – \$10,790.00
HP / Voltage	2-HP Single-Phase 220V	3-HP 3-Phase 208/240/480V	5-HP 3-Phase 208/240/480V
	<i>OPTIONAL: 110 Volts (add \$250)</i>		<i>OPTIONAL: 575 Volts (add \$290)</i>
Power / Pressure	12.0 Tons @ 1,925 PSI	14.5 Tons @ 2,300 PSI	15.5 Tons @ 2,500 PSI
Hyd. Reservoir Size	5 Gallon	5 Gallon	15 Gallon
Pump Type / GPM	Gear / 1.65 GPM	Gear / 2.0 GPM	VANE / 3.0 GPM
Forward Ram Speed	28 IPM	35 IPM (inches p/minute)	55 IPM
Reverse Ram Speed	38 IPM	45 IPM (inches p/minute)	75 IPM
Maximum Stroke	12" (305mm)	12" (305mm)	12" (305mm)

Machine Features All units have Operator Control-Box mounted on swing-arm which can be moved a full 180° for either right-hand or left-hand operation. For larger jobs, the available Foot-Control (optional) allows for hands free machine control. All units capable of Ram, Rotary-Style, and Press-Brake type bending. Basic tool storage built into lower table. See your representative for more information on available tooling to bend Tube, Pipe, & Solids, as well as other options.

All power units feature built-in Pressure-Gage (w/Shut-Off Valve) and include an automotive type (spin-on) Return-Line Oil-Filter. All units have Control-Box E-Stop, On/Off Disconnect Switch & built-in Overload Protection.

All benders feature Spring-Loaded "Quick-Adjusting" Stop-Nuts; providing operator with the ability to make fast and easy stroke adjustments; controlling distances for both forward and reverse travel. For added protection, all units have two (2) additional "safety" limit-switches, limiting any over-travel in both forward & reverse directions.

"RAM-Style" Bending Capacity

Solid Bar (Round)	1.500 OD x 6.0 CLR	1.625 OD x 6.0 CLR	1.750 OD x 8.25 CLR
Solid Bar (Flat)	.250 x 6 .375 x 6 .500 x 5.0	.250 x 6 *(using 2" V-Die) .375 x 6 *(using 3" V-Die) .560 x 5.0 *(using 6.5" Cast V-Die)	.250 x 6 .375 x 6 .625 x 5.0
Pipe	IPS 2" SCH 40 x 9.5 CLR	IPS 2" SCH 80 x 9.5 CLR	IPS 2" SCH 80 x 9.5 CLR

"ROTATING-Style" Bending Capacity

Tubing (Round)	1.750 OD x .120 wall x 6.0 CLR	2.00 OD x .120 wall x 6.0 CLR	2.00 OD x .120 wall x 6.0 CLR
Tubing (Square)	1.750 Sq. x .120 wall x 6.0 IR	2.00 Sq. x .120 wall x 6.0 IR	2.00 Sq. x .120 wall x 6.0 IR
Pipe	IPS 1-1/2" SCH 40 x 6.0 CLR	IPS 1-1/2" SCH 40 x 6.0 CLR	IPS 1-1/2" SCH 40 x 6.0 CLR

Dimensions	Work Surface	32" Wide x 22" Deep x 38" Table Height (without optional casters)	
	Overall Machine Size	32" Wide x 48" Deep x 56" High (Over top of Control Box)	
	Work Area – Minimum	6' ft. Wide x 8' ft. Deep	
Approx. Weight	1,000 lbs.	1,000 lbs.	1,100 lbs.

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PRICE SCHEDULE

Effective 01/30/2017

OPTIONAL Equipment & Accessories for **BENTEC** Hydraulic Ram Benders

PART NO		PRICE
1040	BAR FORMING "GROUP" (includes: 1024, 1025, 1026, 1037, 1045, 1046) <i>Buying the complete 1040 Bar "Group" saves over 20%</i>	1,390.00
1024	Steel Die Holder – Mounts directly to ram and holds most press-brake type tooling	390.00
1025	Universal Die Holder 3"Ø – Mounts in table & holds most press-brake type tooling	375.00
1026	Large Cast V-Die – Mounts directly to Ram for bending heavy flat work 6-1/2" V x 5" Tall	390.00
1037	Large Cast 88° V-Form Punch 3"Ø – Mounts directly in table for bending for heavy flat work	360.00
1045	V-Form Die - 2" V-Opening x 6" tall * OPTIONAL 1045-B has larger 3" V-Opening *Add \$50.00	175.00
1046	V-Form Punch - 1-1/4" wide (nominal) x 6" tall (can be used with either 1045 / 1045-B)	130.00
1041	PIPE BENDING "GROUP" (includes: 1027, 1028, 1029, 1030, 1031, 1032, 1033, 1036) <i>Buying the complete 1041 Pipe "Group" saves over 15%</i>	990.00
1027	Pipe Support Blocks (Pair) – 4-Way Pipe Blocks slip over Pins (Item 1036)	190.00
1028	Pipe Shoe Holder – Mounts to front of Ram. Used to hold all pipe bending shoes	90.00
1029	Bending Shoe for 3/4" Pipe *(Can also be used to bend 1/2" pipe)	70.00
1030	Bending Shoe for 1" Pipe	90.00
1031	Bending Shoe for 1-1/4" Pipe	140.00
1032	Bending Shoe for 1-1/2" Pipe	160.00
1033	Bending Shoe for 2" Pipe	210.00
1036	Solid Steel Pins (Pair) - 1-1/2"Ø Pins mount directly into table (various locations)	250.00
	SOLID STEEL PINS – Pins mounted into Table *(1-1/2"Ø & 2"Ø Pins are Nickel Plated) PINS can be used for various bending applications including: locating or anchoring tooling & mounting of bend fixtures.	
1034	3" Ø Single Pin This alloy steel pin gets mounted into main 3" dia. hole at front of table (center).	280.00
1035	2" Ø Pin Set These alloy steel pins gets mounted in 2" holes along front of table.	320.00
1036	1-1/2" Ø Pin Set These alloy steel pins gets mounted in 1-1/2" holes (various locations).	250.00
1047	CASTER SET – HEAVY DUTY (2 Rigid Casters & 2 Swivel w/Locks rated @ 600 lbs. ea.) Allows machine to be easily moved, and great where forklift accessibility is limited. Casters ship un-mounted w/hardware. (NOTE: Raises table height by Approx. 5½" inches)	160.00
1049	TWIN FOOT CONTROL – Guarded Allows operator to run machine from any location around machine, leaving both hands free to hold part while bending, or unloading part while returning ram back to home position.	280.00
1050	HYDRAULIC SPLIT-DIE *OPTION *(Available only on Model BT-3000) This option allows operator to Release & Lock "Split-Type" Dies Hydraulically . Recommended for higher volume bending with any standard or special "Split-Type" Tooling. Typically used with Square & Rectangular Tube Bending Dies, as well as odd shaped extrusions and other parts.	2,490.00
TBG-100	90° BENDING ATTACHMENT KIT - Used with ALL "Rotating-Style" Die Sets. Option allows bender to perform "Rotating-Style" (non-mandrel) bending of most Round, Square, and Rectangular Tubing, as also sch40 Pipe (some sch10 & sch80) on your Ram Bender . (Call for details)	490.00

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“Rotating-Style” ROUND TUBE Bending Die-Sets

*All Die-Sets used with **TBG-100** (90° Bending Attachment Kit)

<u>TUBE OD</u>	<u>CLR</u>	<u>PART NO</u>	<u>IN STOCK</u>	<u>PRICE</u>
.50	2.5	RAM .5T - 2.5	<input checked="" type="checkbox"/>	340.00
.50	3	RAM .5T - 3		375.00
.625	2.5	RAM .625T - 2.5		340.00
.625	3	RAM .625T - 3		375.00
.75	2.5	RAM .5T - 2.5		340.00
.75	3	RAM .75T - 3	<input checked="" type="checkbox"/>	375.00
.75	3.5	RAM .75T - 3.5		395.00
.875	3.5	RAM .875T - 3.5		425.00
.875	4.5	RAM .875T - 4.5		450.00
1.00	3	RAM 1T - 3	<input checked="" type="checkbox"/>	450.00
1.00	4	RAM 1T - 4	<input checked="" type="checkbox"/>	460.00
1.00	5	RAM 1T - 5		CALL
1.125	4	RAM 1.125T - 4		470.00
1.25	4	RAM 1.25T - 4	<input checked="" type="checkbox"/>	500.00
1.25	5	RAM 1.25T - 5	<input checked="" type="checkbox"/>	520.00
1.25	6	RAM 1.25T - 6		540.00
1.375	5	RAM 1.375T - 5		525.00
1.375	6	RAM 1.375T - 6		550.00
1.50	5	RAM 1.5T - 5	<input checked="" type="checkbox"/>	540.00
1.50	6	RAM 1.5T - 6	<input checked="" type="checkbox"/>	570.00
1.625	6	RAM 1.625T - 6		590.00
1.75	6	RAM 1.75T - 6	<input checked="" type="checkbox"/>	625.00
2.00	6	RAM 2T - 6		695.00
2.00	6.5	RAM 2T - 6.5		785.00

TBG100 90° BENDING ATTACHMENT KIT 490.00

Only one kit required to operate any “Rotating-Style” Tube or Pipe Bending Die-Set

Refer to Bending CHART for best combination of size, wall thickness, and radius.

Upon Request: **BENTEC** will gladly quote any bending dies that are not listed. Please specify material sizes and type.

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4905 Rocky River Drive, Cleveland Ohio 44135 ■ (216) 267-1818 ■ Fax: (216) 267-1850 ■ E-Mail: bentec@kiffer.com



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“Rotating-Style” PIPE Bending Die-Sets

*All Die-Sets used with **TBG-100** (90° Bending Attachment Kit)

PIPE SIZE (NOMINAL)	ACTUAL OD	CLR	PART NO	IN STOCK	PRICE
3/8	.675	3	RAM 3/8P - 3	<input checked="" type="checkbox"/>	375.00
1/2	.840	3	RAM 1/2P - 3	<input checked="" type="checkbox"/>	380.00
1/2	.840	4	RAM 1/2P - 4		390.00
3/4	1.05	3.5	RAM 3/4P - 3.5		460.00
3/4	1.05	4	RAM 3/4P - 4	<input checked="" type="checkbox"/>	470.00
3/4	1.05	4.5	RAM 3/4P - 4.5		480.00
1	1.315	4	RAM 1P - 4		520.00
1	1.315	4.5	RAM 1P - 4.5		530.00
1	1.315	5	RAM 1P - 5	<input checked="" type="checkbox"/>	540.00
1	1.315	6	RAM 1P - 6		550.00
1-1/4	1.66	5	RAM 1-1/4P - 5		640.00
1-1/4	1.66	6	RAM 1-1/4P - 6	<input checked="" type="checkbox"/>	660.00
1-1/2	1.90	5	RAM 1-1/2P - 5		670.00
1-1/2	1.90	6	RAM 1-1/2P - 6	<input checked="" type="checkbox"/>	690.00
* 2	2.38	6.5	RAM 2 P – 6.5		<i>*(Aluminum Pipe ONLY)</i> 875.00

TBG100 90° BENDING ATTACHMENT KIT 490.00
Only one kit required to operate any “Rotating-Style” Pipe or Tube Bending Die-Set

NOTE: All Rotating-Style Pipe Bending Die-Sets listed are designed to bend SCH 40 pipe. Some die-sets, depending on CLR (centerline radius) of tool, may also be used with sch10 and sch80 pipe. Please call the factory for particulars. Remember that in general, larger radius tools will produce bends with less distortion.

Refer to Bending CHART for best combination of size, wall thickness, and radius.

Upon Request: BENTEC will gladly quote any bending dies that are not listed. Please specify material sizes and type.

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