



A Division of Kiffer Industries, Inc.

HYDRAULIC ROTARY DRAW TYPE BENDERS - MODELS [BT-210](#) -&- [BT-220](#) \$31,900

Effective 01/30/2017

PROGRAMMABLE CONTROLLER

Standard workstation/display allows storage of up to 400 part programs with up to 8 bends per part. Simple operating instructions help you run and program your bender for precise, accurate and repeatable bend angles from 5° to 193° degrees. All Rotary Benders come standard with Hydraulic Part Clamping as well as the following features:

| | |
|--------------------------------------|--|
| Minimum/Maximum bend | 5°/190° |
| Rotation direction | Counterclockwise |
| Clamping (part) | Hydraulic |
| Clamping (pressure die) | Manual toggle (optional hydraulic) |
| Dimensions (without extension table) | 56"H x 48"W x 64"L |
| Shipping weight (approximate) | 1,700 lbs / 770 kg |
| Power Unit | 5-hp 3-ph 208/240/480 Volts (<i>575 optional</i>) 10-gallon hydraulic reservoir with in-line filter 2,500 psi working pressure (under full load) |
| 3-ph electrical service requirements | 15 Amps at 208 / 14 Amps at 240 / 7 Amps at 480 |

MODEL

Bend Speed (90°)
Bending Torque (at 2,500 psi)

BT-210

3 - 4 seconds
42,000 in/lbs

BT-220

5 - 6 seconds
75,000 in/lbs

BENDING CAPACITY – Over Mandrel

| | | |
|---------------|------------------------------|----------------------------|
| Round Tubing | 1.5"∅ x .109 wall x 5.0" CLR | 2"∅ x .120 wall x 5.0" CLR |
| Pipe – SCH 40 | 1" (1.315"∅) x 5" CLR | 1-1/2" (1.900"∅) x 5" CLR |

BENDING CAPACITY – Non-Mandrel

| | | |
|-----------------------------|-----------------------------|---------------------------|
| Round Tubing | 1.5"∅ x .109" wall x 7" CLR | 2"∅ x .187" wall x 6" CLR |
| Square Tubing | 1.25"□ x .109" wall x 6" IR | 2"□ x .156" wall x 5" IR |
| Rectangular Tube – Easy Way | 1.25" x 1" x .125" wall | 2" x 1.5" x .187" wall |
| Rectangular Tube – Hard Way | 1.25" x 1" x .109" wall | 2" x 1.5" x .156" wall |
| Steel Pipe – SCH 40 | 1" (1.315"∅) x 7" CLR | 2" (2.375"∅) x 6" CLR |
| Steel Pipe – SCH 80 | 1" (1.315"∅) x 5.5" CLR | 1.5" (1.900"∅) x 5.5" CLR |
| Solid Round Bar | 1.125"∅ x 6" CLR | 1.5"∅ x 5" CLR |
| Solid Square Bar | .750"□ x 6" IR | 1.25"□ x 5" IR |

OPTIONS – Please call for pricing quotation

Mandrel Extractor Package / Pedestal Control Display / Hyd. Pressure-Die Advance (replaces manual Toggle) Pressure-Die Roller Carriage (with or without Hydraulic Boost) / Hydraulic Split-Die Clamping / Complete Bending Dies Mandrel Rods w/Quick-Disconnect Couplings / Ethernet Card / Extension Tables for use with longer tube/pipe lengths.

Delivery: Normal availability is from 6 to 8 weeks (depending on options) subject to confirmation at time of order. Pricing is in U.S. Dollars and does not include tax or freight. Freight is F.O.B. Cleveland, OH 44135

Warranty: One Year – Limited

Kiffer Industries, Inc. reserves the right to make specification and/or equipment changes without prior notice

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PRICE SCHEDULE

Effective 01/30/2017

OPTIONAL Equipment for Hydraulic Rotary Benders

| PART NO | | PRICE |
|---------|--|----------|
| R221 | MANDREL EXTRACTOR PACKAGE WITH PEDESTAL CONTROL Hydraulic mandrel puller mounts on back of machine or, an extension table; allows bending of tube or pipe over a mandrel; 4" stroke cylinder is standard; and allows bending up to 30" from end of part. Package includes pedestal control. (<i>Extension Tables allow bending from 30" up to 174" from end of part</i>) | 3,800.00 |
| R222 | 12' MANDREL EXTENSION TABLE- Adds extra length and capacity to your bender Used when mandrel bending more than 30" from end of part; other sizes available. | 3,500.00 |
| R223 | MANDREL ROD – Short | 190.00 |
| R224 | MANDREL ROD – Long (used with extension table) Both come standard with quick-disconnect couplings unless otherwise specified. Please indicate individual thread requirements. | 290.00 |
| R225 | HYDRAULIC SPLIT DIE RELEASE May be used with most split type square and rectangular tube dies, to both lock and release the die hydraulically. Used for quick and easy part removal; also highly recommended when bending with tools used for odd shaped extrusions. | 2,500.00 |
| R226 | HYDRAULIC PRESSURE DIE CLAMP Replaces manual toggle lever with hydraulic cylinder; similar to hyd. part clamp. | 1,900.00 |
| R227a | PRESSURE DIE ROLLER CARRIAGE w/Hyd. Boost (Includes option R226) | 6,900.00 |
| R227b | PRESSURE DIE ROLLER CARRIAGE w/o Boost (Includes option R226) NOTE: Both R227a & R227b include Option R226 – Hydraulic Pressure-Die Advance Roller Carriage is recommended and desirable for numerous applications including: a) Customer has existing tooling from other machines using roller carriage. b) When part has minimum material back past tangent of bend c) When minimum wall thinning is required and/or desired *** Both R227a & R227b include Option R226 – Hydraulic Pressure-Die Advance | 5,900.00 |
| R229 | WEARPLATE – Backs up Pressure-Die / Follow-Bar Used as replacement or spare on standard machine. One face has a low friction material applied to facilitate sliding motion of pressure die. | 390.00 |
| R231 | PEDESTAL CONTROL Control box is mounted to a movable pedestal; allowing machine to be operated from any position. | 750.00 |
| OPT-1 | PROGRAMMING UPGRADES / DRIVE SHAFT ALTERATIONS / SPECIAL TOOL MOUNTS Ask about programming upgrades and machine alterations to allow use of special or existing tooling. | |

Special configurations and other options are available. Please contact our BENTEC application engineers to build a machine that fits your application. **BENTEC** will be happy to discuss any bending job and keep all details confidential.



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ROTARY BENDER TOOLING

Effective 01/30/2017

CALL FACTORY (216)-267-1818 FOR TOOL PRICING

ROUND TUBE & PIPE

All **TUBE** and all **PIPE** Bending Die Sets are custom made per order. *BENTEC* will also make non-standard tooling upon request. Please see examples below and ask about any sizes not listed. * * * Bend Die Part Numbers are designated in the following manner:

TUBE DIE Part No. # ROT 1.250 T – 4

PIPE DIE Part No. # ROT 1-1/4 P – 5.5

ROT (Machine Type) / Size of **Tube** (Decimal) or **Pipe** (Fractional) / **T** (Tube) or **P** (Pipe) / CLR

SQUARE & RECTANGULAR TUBE

All **SQUARE** and **RECTANGULAR** TUBE Bending Die Sets are custom made per order. *BENTEC* will also make non-standard tooling upon request. Please note that bending dies for square and rectangular tube call out the “Inside Radius” (IR) because die comes in contact with tube on inside face. See examples below and ask about sizes not listed.

* * * Bend Die Part Numbers are designated in the following manner:

SQUARE TUBE DIE Part No. # ROT 1.500 SQ – 5

RECTANGULAR TUBE DIE Part No. # ROT 1.250 RECT – 4.5

ROT (Machine Type) / Size of Tube (Decimal) or SQ (Square) / Inside Radius (IR)