

## YLM CNC Bending Machine Specifications

MODEL NO.		Electric Servo Bending													
		16S1	16S2 16S3	25S1	25S2 25S3	38S1	38S2	38S3	50S1	50S2	50S3	65S1	65S2 65S3	65MS	
SPECIFICATION															
Max Pipe Diameter (in)		Ø 5/8"		Ø 1"		Ø 1.5"			Ø 2"			Ø 2.60"			
Max Wall Thickness (in)		.048"		.060"		.078"			.098"			.120"			
*Range of Center Line Radius (in)		2-3/4"		4"		7"			8.6"			9.8"			
Max radius difference per level (in)		\	1-3/8"	\	1.560"		\	2.00"		\	3.150"		\	3.150"	
Max Bending Angle □ ° □		190		190		190			190			190			
*Max over mandrel length (in.)		55"		70"		78"			98"			98"			
Operating Speed	Feeding (in/sec)	50"		50"		48"			48"			34"			
	Rotating ( ° /sec)	360		360		360			270			240			
	Bending ( ° /sec)	200		180		180			110			90			
Repeatability Accuracy	Feeding (in)	± .004"		± .004"		± .004"			± .004"			± .004"			
	Rotating ( ° )	±0.1		±0.1		±0.1			±0.1			±0.1			
	Bending ( ° )	±0.1		±0.1		±0.1			±0.1			±0.1			
Hydraulic Motor □ Hp)		5		5		7.5			10			10			
Total Power Hp	Standard	9.75		11		18			27			30		35	
	Push Roll	9.75		12.75		21			28			34		38	
POB Carriage Boost		\		\		\			\			38		42	
Max Hydraulic Pressure (psi)		2030		2030		2030			2030			2030			
Oil Tank Capacity (gal.)		16		26		40			58			60			
Cooler (gal/min)		26		26		26			26			26			
Dimensions L x W x H		9 ft x 32 x 57		12 ft x 44" x 59"		13 ft x 44" x 60"			17 ft x 48" x 61"			17 ft x 48" x 61"			
Working Height		44"		44"		47"			46"			45"			
Machine Weight (lbs)		2900	3100	3100	3300		3750	4200		5700	6400		6200	7060	7100
<b>**Torque (lb/ft)</b>		<b>6,865</b>													

\*Length may be extended

\*\*Torque not including additional force generated from POB carriage boost

MODEL NO.		Electric Servo Bending							Hydraulic Bending			
		80S1	80S2	80MS	80MS-BS	90S1	90S2	90MS	90MS-BS	100S1	100S2	130S1
SPECIFICATION		Ø 3.150"				Ø 3.50"				Ø 4.00"		Ø 5.118
Max Pipe Diameter (in)		.118"				.118"				.157"		.200"
Max Wall Thickness (in)		9.800"				9.800"				14.00"		19.600"
*Range of Center Line Radius (in)		3.5"				3.5"				100		
Max radius difference per level (in)		190				190				190		190
Max Bending Angle □ ° □		118"				98"				142"		177"
*Max over mandrel length (in.)		Feeding (in/sec)		25"		24"		31"		24"		24"
Operating Speed	Rotating ( ° /sec)	240		180		240		160				
	Bending ( ° /sec)	80		60		30		25				
	Feeding (in)	± .004"		± .004"		± .004"		± .004"				
Repeatability Accuracy	Rotating ( ° )	±0.1		±0.1		±0.1		±0.1		±0.1		
	Bending ( ° )	±0.1		±0.1		±0.1		±0.1		±0.1		
	Hydraulic Motor □ Hp)	15		33.5		30		50				
Total Power Hp	Standard	41	45	59	47	50	64	45	60			
	Push Roll	44	48	59	49	53	64	52	70			
POB Carriage Boost		64	70		52	55						
Max Hydraulic Pressure (psi)		2030				2030				2030		2030
Oil Tank Capacity (gal.)		110				110				185		210
Cooler (gal/min)		52				52				52		52
Dimensions L x W x H		21 ft x 80" x 61"				21 ft x 80" x 61"				20' x 75" x 67"		28 ft x 83" x
Working Height		46"				46"				47"		47"
Machine Weight (lbs)		14,300		16,540		15,450		17,650		21,000		26,460
<b>**Torque (lb/ft)</b>		<b>10,117</b>				<b>13,278</b>				<b>31,100</b>		<b>52,027</b>

\*Length may be extended

\*\*Torque not including additional force generated from POB carriage boost

**Technical Data Subject to Change without Notice**

**Date □ 2004-07-19**



130S2

"

'

150

< 75"

