

## 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
Max Pipe Diameter (in)		Ø 5/8"		1"		1.5"		2"		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		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 ( ° )	.1		.1		.1		.1		.1			
	Bending ( ° )	.1		.1		.1		.1		.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	130S2
SPECIFICATION													
Max Pipe Diameter (in)		3.150"				3.50"			4.00"		5.118"		
Max Wall Thickness (in)		.118"				.118"			.157"		.200"		
*Range of Center Line Radius (in)		9.800"				9.800"			14.00"		19.600"		
Max radius difference per		3.5"				3.5"			100		150		
Max Bending Angle		190				190			190		190		
*Max over mandrel length (in.)		118"				98"			142"		177"		
Operating Speed	Feeding (in/sec)	25"				24"		31"		24"		24"	
	Rotating ( ° /sec)	240				180			240		160		
	Bending ( ° /sec)	80				60			30		25		
Repeatability Accuracy	Feeding (in)	.004"				.004"			.004"		.004"		
	Rotating ( ° )	.1				.1			.1		.1		
	Bending ( ° )	.1				.1			.1		.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 75"		
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