



# **SPECIALISED FORCE**

**HYDRAULIC TOOLS &  
SPECIALISED ELECTRICAL EQUIPMENT**



# **Pipe, Tube & Conduit Benders**

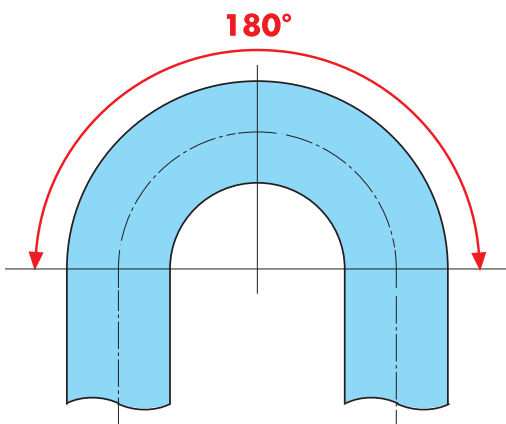
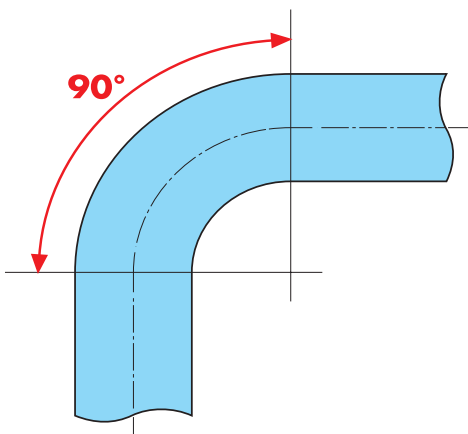
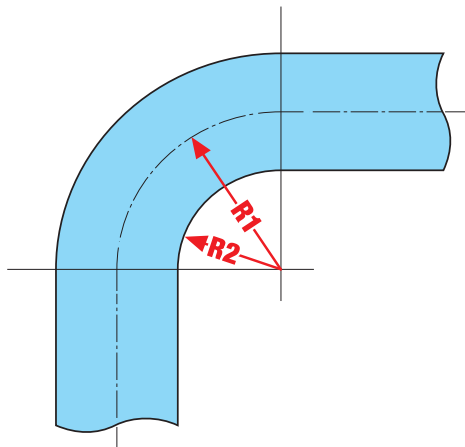


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USEFUL INFORMATION

PIPE, TUBE & CONDUIT BENDER

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R1 -Centre Line Radius

R2 -Root Radius

1. It is necessary to know the type of material of the pipe to bend, the outside diameter (mm/gas/inch(imperial)), the pipe wall-thickness (mm) and the required bending radius.

2. The bending radius (not to confuse with the bending angle) is the distance between the hypothetical centre of the circle and the centre of the bent pipe. When speaking of radius 3D or 4D we mean that the bending radius is 3 or 4 times the outside diameter of the pipe (example: diam.40 mm, radius 3D = 40 x 3 = 120mm). Bear in mind that the bigger the bending radius, the better the result on the bent pipe will be.

3. The bending angle, expressed in degrees, determines the width of the bend.

4. You can bend without using the mandrel system when you do not have particular exigencies or when you must bend thick pipes and/or with bending radii 3D/4D or bigger ones. On the contrary you must bend with mandrel system everytime you have particular exigencies or when you must bend thin pipes and/or with smaller bending radii 2D/2,5D.

**All CBC Bending Formers 3D & 4D are measured CLR (Centre Line Radius).**

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CBC	UNI 80 **	Electro-hydraulic	Bending Machine	400	x	x		24
CBC	UNI 90 **	Electro-hydraulic	Bending Machine	400	x	x		25
IZUMI	PB-10N	Hydraulic	Bending Machine	N/A			x	32
IZUMI	PB-15N	Hydraulic	Bending Machine	N/A			x	32
BENDITNOW	BE32AUS	Manual	Bending Machine	N/A			x	33
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**UNI 22**

**Ratchet operated bending machine**

UNI 22 is a compact ratchet operated bender copper, aluminium, steel and stainless steel tube. The optimal and constant bending radii will not deform the bent tube.

**General features**

- Aluminium body
- Hardened steel gears on ball bearings.
- Maximum bending angle: 180°.
- Dimensions: length 250mm, width 90mm, height 160mm (without stand).
- Weight: 8kg (without stand).

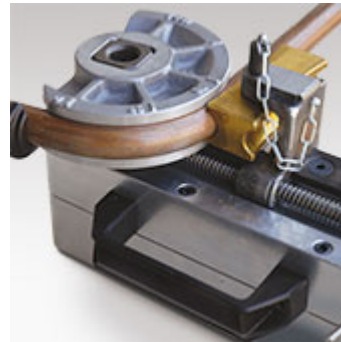


PIPE, TUBE & CONDUIT BENDER

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It is supplied with a bench fixing bracket.



Easy carrying handle.



Anti-rotation and return device of the wind lever.

STANDARD VERSIONS	CODE
UNI 22 hand pipe bender (basic tool)	9230000.1

TYPE OF TUBE	Max dia x min. thickness
Hard and softcopper tube, annealed brass tube	28 x 1,5 mm
Aluminium tube	32 x standard
304/316 stainless steel tube	28 x 1,5 mm
Seamless tube	25* x 3 mm
Gas pipes	3/4"* standard

(\* Use the universal roller instead of counterformer



**UNI 22 ACCESSORIES**



Aluminium standard formers with cast iron hook with bending radius 3 times tube diameter from Ø 6 up to 28.8 mm.



1. Bronze twin grooved guide (counter former) for tube from 6 up to 25mm.
2. Cast iron single grooved guide (counter former) for tube up to 1" 1/8 [28.58] .
3. Universal roller to be used with thick pipes (3mm thickness) thicker then 25mm code: 595156

**FORMERS AND GUIDES**

MILLIMETER-SIZED ALUMINIUM FORMERS		
CODE	DIA	R
140116,1	6	30
140117,1	8	30
140091,1	10	30
140092,1	12	36
140095,1	16	48
140098,1	20	60
140099,1	22	66
140107,1	25	71

IMPERIAL SIZED ALUMINUM FORMERS		
CODE	DIA	R
140128,1	1/4 [6.35]	30
140129,1	5/16 [7.94]	30
140121,1	3/8 [9.52]	30
140122,1	1/2 [12.70]	36
140123,1	5/8 [15.88]	48
140124,1	3/4 [19.05]	54
140125,1	7/8 [22.22]	66
140126,1	1" [25.40]	71
140127,1	1" 1/8 [28.58]	84

MILLIMETER-SIZED ALUMINUM FORMERS (special ones for radius 4D)		
CODE	DIA	R
140151,1	12	48
140148,1	16	64
140146,1	22	88

GAS INCH-SIZED CAST IRON FORMERS		
CODE	DIA	R
220350	1/4 NB	48
220351	3/8 NB	53.5
220352	1/2 NB	55.5
220353	3/4 NB	71

STAINLESS STEEL RINGS FOR GAS INCH-SIZED CAST IRON FORMERS	
CODE	DIA
519032	1/4 NB
519021	3/8 NB
519022	1/2 NB
519023	3/4 NB

MILLIMETER-SIZED COUNTERFORMERS	
CODE	DIA
224014	6-8
420013	10-12
420014	14-16
420010	18-22
420009	12-15
420008	17-20
220372	25

IMPERIAL SIZED COUNTERFORMERS	
CODE	DIA
224018	1/4-5/16
224017	1/4-3/8
420006	1/2-5/8
420007	3/4-7/8
220389	1
220365	1 1/8



## UNI 42

### Ratchet operated bending machine

UNI 42 manual, an accurate and powerful pipe and tube bending machine able to bend large pipes' and delicate tube with optimum and constant bending radii and without any deformation.

#### General features

- Aluminium body
- Tempered steel gears on ball bearings
- Maximum bending angle 180°
- Dimensions: length 400mm - width 200mm height 250 mm (without stand)
- Weight 18kg (without stand)
- Refer to pages 27-31 for suitable tooling & accessories.



Manual UNI 42, standard version, with folding stand for a better work and an easy transport.

Tubular, folding tripod stand is supplied as standard with each bender.



Driving lever return gear.

STANDARD VERSION	CODE
UNI 42 with folding stand.	9200005.1

TYPE OF PIPE	Bending capacity	
	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	42	1,5
Steel conduit for electrical installations	40	1,5
Stainless steel 304/316 tube	30	2
Hydraulic steel tubes ST. 35,4	42	3
Furniture tubes	42	3
FE boiler pipes	42	3
Aluminium tube	42	3
Gas pipes	1"1/4	Standard
Double coated aluminium pipe	50	Standard
Standard bending radii	3D and 4D	



## Mini Ring Rolling Machine

### Hand and digital Mini Ring Roller Machine

The mini ring rolling machine is suitable for ring rolling sections, flat bars, and metal pipes with ring rolling angle from 0° to 360°. The warping of the material is carried out by the operating arm (for the hand mini ring roller) and by a geared motor (for the digital mini ring roller). By the use of optional accessories it is possible to bend metal pipes from 0° to 180°.

#### General features

- Aluminium/steel body.
- Maximum ring rolling angle 360°.
- Single phase motor 230V/50hz (digital mini ring roller).
- mm-sized dimensions and weights  
Hand Operated 160mm H x 14kg  
Digital Electric 310mm H x 23kg



3 universal rollers (included in the standard equipment).



Round/RHS rollers (optional items, 3 pieces for each size) made to order

STANDARD VERSION	CODE
Hand Ring Roller equipped with: ratchet handle, work bench fixing bracket and 3 universal rollers	9230400
230v/50Hz digital Ring Rolling Machine equipped with: 3 universal rollers, work bench fixing bracket, foot pedal set, adjustment rod	9230600

Ring Rolling Capacity		
TYPE OF PIPE	Ring Rolling	
	Ø mm	mm
Raw/annealed copper and annealed brass pipes	22	3
304/316 stainless steel tube	16	2
ST 35,4 bonderised steel pipes	22	3

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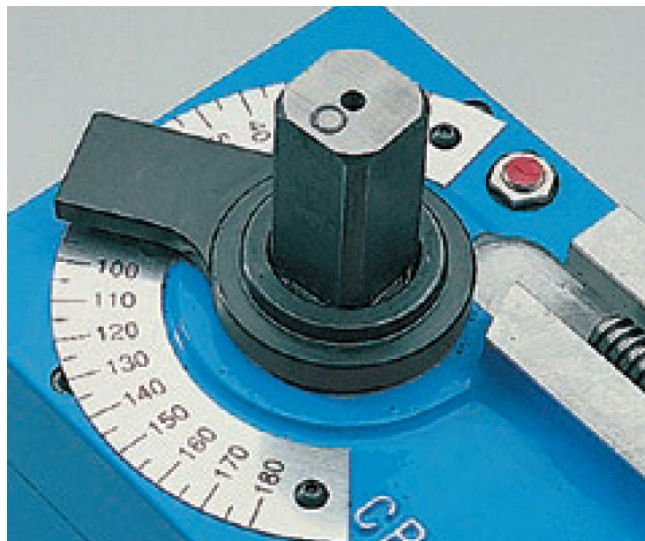
## UNI 42

### Electric bending machine

UNI 42, electric, an accurate and powerful bending machine able to bend large diameters as well as thin and delicate tube with optimum and constant bending radii and without any pipe deformation.

#### General features

- Aluminium body
- Asynchronous motor, 230V/50Hz, 2800 RPM, 0.56 kW power
- Low tension electronic schedule (24V)
- Bending angle regulation
- Electrobrake
- Automatic return to stop
- Dimensions: length 520 mm, width 170mm, height 350mm (without stand)
- Weight 35kg.
- Refer to pages 27-31 for suitable tooling & accessories.



UNI 42 electric, with positioning ring to obtain the desired bending angle.



UNI 42 A, version with moving plane of bend and universal base (optional)

STANDARD VERSION	CODE
Electric UNI 42 A 230V-50Hz with quick guide positioning device without stand.	9200150.5

#### Bending capacity

TYPE OF PIPE	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	42	1,5
Steel conduit for electrical installations	40	1,5
304/316 stainless steel tube	30	2
Hydraulic steel tubes ST. 35,4	42	3
Furniture tubes	42	2
FE boiler pipes	42	3
Aluminium tube	42	3
Gas pipes	1"1/4	Standard
Double coated aluminium pipe	50	Standard
Standard bending radii	3D and 4D	

**UNI 42**

**Digital electric bending machine**

UNI 42, electric, an accurate and powerful bending machine able to bend large diameters as well as thin and delicate tube with optimum and constant bending radii and without any pipe deformation.

**General features**

- Aluminium body
- Asynchronous motor, 230V/50Hz, 2800 RPM, 0.56 kW power
- Digital touchscreen control panel with multi-language microprocessor for programming the angle of bend. Capable of storing 9 bending programmes with 9 bends per program.
- Low tension electronic schedule (24V)
- Electrobrake
- Automatic return to stop
- Dimensions: length 520 mm, width 170mm, height 350mm (without stand)
- Weight 35kg.
- Refer to pages 27-31 for suitable tooling & accessories.



UNI 42 A, version with moving plane of bend and universal base (optional)

STANDARD VERSION	CODE
Electric digital UNI 42 A 230V-50Hz with quick guide positioning device without stand.	9200121.5

Bending capacity		
TYPE OF PIPE	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	42	1,5
Steel conduit for electrical installations	40	1,5
304/316 stainless steel tube	30	2
Hydraulic steel tubes ST. 35,4	42	3
Furniture tubes	42	2
FE boiler pipes	42	3
Aluminium tube	42	3
Gas pipes	1"1/4	Standard
Double coated aluminium pipe	50	Standard
Standard bending radii	3D and 4D	

**PIPE, TUBE & CONDUIT BENDER**

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## UNI 60 A

### Electric bending machine

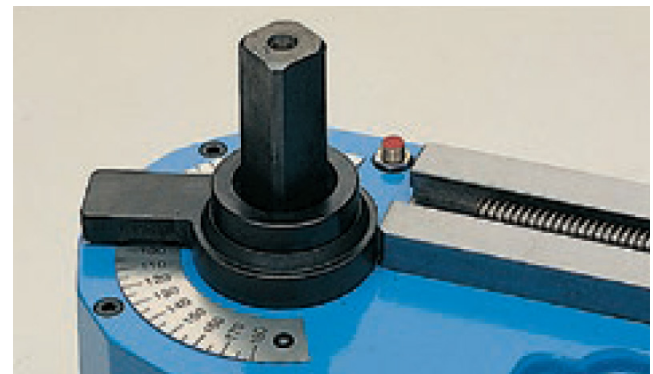
UNI 60 A, electric, an accurate and powerful bending machine able to bend large diameters as well as thin and delicate tube with optimum and constant bending radii and without any pipe deformation.

#### General features

- Aluminium body
- Asynchronous motor, 230V/50Hz, 2800 RPM, 0.97 kW power
- Low tension electronic schedule (24V)
- Bending angle regulation
- Electrobrake
- Automatic return to stop
- Dimensions: length 520mm, width 210mm, height 410mm (without stand)
- Weight 60kg.
- Refer to pages 27-31 for suitable tooling & accessories.



Electric UNI 60 A, version with moving plane of bend and universal base.



Electric UNI 60 A with positioning ring to obtain the desired bending angle.

STANDARD VERSION	CODE
Electric UNI 60 A 230V-50Hz with quick guide positioning device without stand.	9200350.5

Bending capacity		
TYPE OF PIPE	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	54	4
Steel conduit for electrical installations	50	2
304/316 stainless steel tube	35	3
Hydraulic steel tubes ST. 35,4	54	4
Furniture tubes	54	3
FE boiler pipes	54	4
Aluminium tube	54	5
Gas pipes	1"1/2	Standard
Double coated aluminium pipe	63	Standard
Standard bending radii	3D and 4D	





**UNI 60 A**

**Digital electric bending machine**

UNI 60 A digital, an accurate and powerful bending machine able to bend large diameters as well as thin and delicate tube with optimum and constant bending radii and without any pipe deformation.

**General features**

- Aluminium body
- Asynchronous motor, 230V/50Hz, 2800 RPM, 0.97 kW power
- Digital touchscreen control panel with multi-language microprocessor for programming the angle of bend. Capable of storing 9 bending programmes with 9 bends per program.
- Low tension electronic schedule (24V)
- Bending angle regulation
- Electrobrake
- Automatic return to stop
- Dimensions: length 520mm, width 210mm, height 410mm (without stand)
- Weight 60kg.
- Refer to pages 27-31 for suitable tooling & accessories.



UNI 60 digital, version complete with moving plane of bend and universal base. (optional)

STANDARD VERSION	CODE
Electric digital UNI 60 A 230V-50Hz with quick guide positioning device without stand.	9200345.5

Bending capacity		
TYPE OF PIPE	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	54	4
Steel conduit for electrical installations	50	2
304/316 stainless steel tube	35	3
Hydraulic steel tubes ST. 35,4	54	4
Furniture tubes	54	3
FE boiler pipes	54	4
Aluminium tube	54	5
Gas pipes	1"1/2	Standard
Double coated aluminium pipe	63	Standard
Standard bending radii	3D and 4D	

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**UNI 60 AI**

**Electric digital single phase pipe bending machine for delicate and thin pipes**

Digital UNI 60 AI with interchangeable outlet shaft, a powerful and precise pipe bending machine to bend delicate and thin pipes. It is suitable for bending tube with very tight radii.

**General features**

- Aluminium body
- Asynchronous motor, 230V/50Hz, 2800 RPM, 0.97 kW power
- Maximum bending angle 180°
- Digital touchscreen electronic unit with multilingual microprocessor for programming, controlling and recovering the bending angle. It is capable of storing 50 bending programmes with the possibility to select 9 sequential bending angles for every program.
- Low tension printed-circuit board (24V)
- Electrobrake
- Bending angle regulation
- Automatic return at the end of stroke
- Dimensions: length 580mm, width 210mm, height 410mm (without stand)
- Weight: 60kg
- Refer to pages 27-31 for suitable tooling & accessories.



Digital UNI 60 AI, version with moving plane of bend and universal base. (optional)



D. 32 (square) provided outlet shaft.



Provided reduced shaft to use with special formers and guides for bending radii which are less than 30 mm.

STANDARD VERSION	CODE
Electric digital UNI 60 AI 230V-50Hz with 2 interchangeable shafts with quick guide positioner device, guide's support reduction for reduced shaft, without stand.	9200325.5

**Bending capacity**

TYPE OF PIPE	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	54	2
Steel conduit for electrical installations	50	1.5
304/316 stainless steel tube	35	3
Hydraulic steel tubes ST. 35,4	48	4
Furniture tubes	48	3
FE boiler pipes	48	3
Aluminium tube	54	3
Gas pipes	1"1/2	Standard
Double coated aluminium pipe	63	Standard
Standard bending radii	3D and 4D	

\*To bend pipes whose thickness is equal to/over 2.5mm use the twin roller set and not the guide.

PIPE, TUBE & CONDUIT BENDER

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**UNI 63**

**Digital electric 3-phase bending machine**

Digital, electric, 3-phase bending machine to bend any kind of pipe, diameter and thickness. It has been conceived to realise and satisfy the various demands of operators in the plumbing field, nautical, hydraulics, industry and installations in general.

**General features**

- Cast iron body based on structural steelwork
- Asynchronous motor, 400V/50Hz, 2800 RPM, 1.12 kW power
- Digital touchscreen electronic unit with multilanguage microprocessor for programming, controlling and recovering the bending angle. It is capable of storing 50 bending programmes with the possibility to select 9 sequential bending angles for each program.
- Maximum bending angle 180°
- Low tension printed circuit board (24v.)
- Bending angle regulation
- Electro-brake
- Supplied with 1 interchangeable outlet shaft d.32 (code 544455); one reduced shaft (code 544454) optional.
- Weight & dimensions: only machine 120kg.
- Length: 740mm, width: 900mm, height: 1000mm
- Refer to pages 27-31 for suitable tooling & accessories.



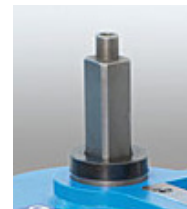
**PIPE, TUBE & CONDUIT BENDER**



UNI 63, version complete with moving arm.



Reduced shaft for bending with radii less than 30 mm.



Shaft d.32 (square) for bending with standard radii

STANDARD VERSION	CODE
UNI 63 digital electric 3-phase bending machine 400v/50hz with quick guide positioner device, foot-pedal and stand	9200503

Bending capacity		
TYPE OF PIPE	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	54	2
Steel conduit for electrical installations	50	1,5
304/316 stainless steel tube	35	3
Hydraulic steel tubes ST. 35,4	48	4
Furniture tubes	48	3
FE boiler pipes	48	3
Aluminium tube	54	3
Gas pipes	1'1/2	Standard
Double coated aluminium pipe	63	Standard
Standard bending radii	3D and 4D	

\*To bend pipes whose thickness is equal to/over 2.5mm use the twin roller set and not the guide.

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## UNI 60 COMBICAL

### Electric pipe bending and ring rolling machine

The UNI 60 COMBI-CAL is a ring rolling machine which allows to bend pipes, structural sections, and plates (it is equipped with three universal rollers to bend structural sections, and plates). In the pipe bending mode it is equipped to bend metal pipes with a bending angle from 0° to 180°; the machine is designed to bend without mandrel.

#### General features

- Cast iron body on steel base
- Asynchronous motor, 230V/50Hz, 2800 RPM, 1.5 kW power
- Maximum bending angle: 180°
- Digital control panel with multilingual microprocessor for programming, controlling and recovering the bending angle. It is capable of storing 50 bending programmes and each of them can store 9 sequential bending angles (in the pipe bending version)
- Low tension (24V) printed circuit board
- Bending angle setting
- Electrobrake
- Dimensions: length 780mm, width 430mm, height 1000mm
- Weight: 170kg.
- Refer to pages 27-31 for suitable tooling & accessories.

Ring rolling capacity		
TYPE OF PIPE	Ø mm	mm
Gas pipes	1" 1/2	3,2
Square tube (RHS)	40 x 40	2
Rectangular pipe	50 x 25	2,5
Solid bar	20	-
Square structural section	20	-
Rectangular structural section	50 x 8	-
"L" shaped structural section	40 x 40	3
"T" shaped structural section	40 x 40	5
"U" shaped structural section	30 x 15	4

Special diameters and bending radii on request

Bending capacity		
TYPE OF PIPE	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	54	2
Steel conduit for electrical installations	50	1.5
Stainless steel 304/316 tube	35	3
Hydraulic steel tubes ST. 35,4	48	4
Furniture tubes	48	3
FE boiler pipes	48	3
Aluminium tube	54	3
Gas pipes	1" 1/2	Standard
Double coated aluminium pipe	63	Standard
Standard bending radii	3D and 4D	

STANDARD VERSION	CODE
UNI 60 COMBI-CAL 230V/50Hz with one square interchangeable shaft of diam. 32, quick guide positioner, 2 ring rolling shafts of diameter 40, 3 universal rollers, 2 lateral supports, foot pedal switch and base.	9200445



UNI 60 COMBI-CAL in the standard version



The square interchangeable shaft of diam. 32 is included in the standard equipment.



The quick-guide positioner of the guide support is included in the standard equipment.

PIPE, TUBE & CONDUIT BENDER

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**UNI 70 C**

**Digital electric 3-phase bending machine**

UNI 70/C digital, a powerful and precise pipe bender for bending large diameter pipes, delicate and thin tube; the optimal and constant bending radii does not deform the curved pipe in any way: ideal for the various needs of operators in the hydraulic, nautical, hydraulics, industrial, and general plant sectors.

**General features**

- Spheroidal cast iron body on steel base.
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 3.1 kW power
- Digital touchscreen electronic unit with multi-language display to program and control the required bend angles. Memorises up to 70 bending programmes with the possibility to store up to 6 bending angles in sequence in each program.
- Automatic return to original starting point.
- Low tension electronic panel (24V).
- 180° maximum bending angle.
- Equipped with quick counterformer support position device and 2 interchangeable outlet shafts.
- Dimensions: length 810mm, width 400mm, height 1100mm
- Weight 210kg.
- Refer to pages 27-31 for suitable tooling & accessories.



Digital UNI 70/C, version with moving plane of bend (optional).



The 2 interchangeable outlet shafts of the standard equipment.



Digital UNI 70/C with a simple control panel.



**PIPE, TUBE & CONDUIT BENDER**

STANDARD VERSION	CODE
Electric digital UNI 70/C 400V/50Hz supplied with 1 quick guide positioner and 2 interchangeable outlet shafts in the standard equipment. UNI 70/C electrical digital 400V/50Hz	9200600.2

TYPE OF PIPE	Bending capacity	
	WITHOUT MANDREL	
	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	60	4
Steel conduit for electrical installations	60	2
304/316 stainless steel tube	60	3
Hydraulic steel tubes ST. 35,4	60	4
Furniture tubes	60	3
FE boiler pipes	60	4
Aluminium tube	60	8
Gas pipes UNI 5745	2"	Standard
Square tube (RHS)	50 x 50	4
Standard bending radii	3D and 4D	

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**UNI 76**

**Universal electric bending machine**

The UNI 76 is an accurate and powerful bending machine to bend pipes with large diameters. The optimal and constant bending radii do not deform the bent pipes: it is the ideal machine to satisfy every user's demands in the plumbing, nautical, hydraulic, industrial and plant engineering sector.

**General features**

- Spheroidal cast ironed body on steel base.
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 4 kW power
- Digital touchscreen electronic control board with multi-language microprocessor and display to set and control the required bend and recovery angle. It can store up to 50 bending programmes. Each program can memorise up to 9 bending angles in sequence.
- Automatic return to stroke end.
- Switch panel low tension (24V).
- 180° Maximum allowed bending angle.
- Dimensions: length 1000mm, width 710mm, height 1100mm
- Weight: 430kg
- Refer to pages 27-31 for suitable tooling & accessories.



With two additional interchangeable shafts in the standard equipment.



Special formers diameter 2"1/2Gas - 3" OD.



Counterformer diameter 2"1/2 gas - 3" OD.



Guide for twin-rollers (it is supplied without rollers)



Counterform support reduction

STANDARD VERSION	CODE
Digital electric UNI 76 400V/50Hz supplied with quick guide positioner and 3 interchangeable outlet shafts, reinforcing tie-rod and guide support reduction	9200676.2

Bending capacity		
TYPE OF PIPE	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	76	8
Steel conduit for electrical installations	78	6
304/316 stainless steel tube	76	4
Hydraulic steel tubes ST. 35,4	76	6
Furniture tubes	76	6
FE boiler pipes	76	6
Aluminium tube	76	8
Gas pipes	3"	Standard
Square pipe (RHS)	60 x 60	3
Standard bending radii	3D and 4D	



**UNI 89**

**Universal electric bending machine**

The UNI 89 is an accurate and powerful bending machine able to bend large diameters pipes. The optimal and constant bending radii does not deform bent pipes: it is the ideal machine to satisfy every user's demand in the plumbing, boating, hydraulics, industry and plants installation in general, above all in the ornamental field.

**General features**

- Spheroidal cast ironed body on steel base
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 4.8 kW power
- Digital touchscreen electronic unit with multi-language display for the programming and control of required bending angle. Memory up to 50 bending programmes with the possibility to make for each program up to 9 bending angles in sequence.
- Automatic return at stroke end
- Switch panel low tension (24V)
- 180° maximum bending angle
- Sizes: length 1200mm, width 650mm, height 1200mm.
- Weight: 650kg.
- Refer to pages 27-31 for suitable tooling & accessories.



**PIPE, TUBE & CONDUIT BENDER**



With two additional interchangeable shafts in the standard equipment.



Special formers diameter 2"1/2 Gas - 3" OD.



Counterformer diameter 2"1/2 gas - 3" OD.



Reinforcement tie-rod supplied with machine



Guide for twin-rollers (it is supplied without rollers)



Counterform support reduction

STANDARD VERSION	CODE
Digital electric UNI 89 400V/50Hz supplied with quick guide positioner and 3 interchangeable outlet shafts, reinforcing tie-rod and guide support reduction	9200750.1

Bending capacity		
TYPE OF PIPE	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	90	10
Steel conduit for electrical installations	91	8
304/316 stainless steel tube	89	6
Hydraulic steel tubes ST. 35,4	89	8
Furniture tubes	89	10
FE boiler pipes	89	8
Aluminium tube	89	10
Gas pipes	3"	Standard
Square pipe (RHS)	70 x 70	5
Standard bending radii	3D and 4D	

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**UNI 120**

**Digital electric 3-phase bending machine**

The UNI 120 is an accurate and powerful bending machine to bend large diameter pipes. The optimal bending radii does not deform the bent pipes. It is the ideal machine to satisfy the demand of every user in the nautical, hydraulic, industrial, oil-hydraulic and plant-engineering sectors.

**General features**

- Spheroidal graphite iron body on steel base;
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 7.8 kW power with inverter
- Digital touchscreen electronic unit with multilingual microprocessor for setting, controlling and springing-back the bending angle. It is possible to store 50 bending programmes and up to 9 sequential bending angles for each program;
- Maximum allowed bending angle 180° + spring-back;
- Console with 24V low tension control board;
- Bending angle adjustment;
- Electrobrake;
- Weight: 1750kg;
- Dimensions: length 1500mm, width 900mm, height 1200mm.
- Contact the SF representative for suitable tooling.



PIPE AND TUBE BENDER

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OPTIONAL ACCESSORIES	CODE
2-metre long moving plane of bend (useful 1.7 metres)	0001330-2
3-metre long moving plane of bend (useful 2.7 metres)	0001330-3
4-metre long moving plane of bend (useful 3.7 metres)	0001330-4
5-metre long moving plane of bend (useful 4.7 metres)	0001330-5
6-metre long moving plane of bend (useful 5.7 metres)	0001330-6

STANDARD VERSION	CODE
UNI 120 three-phase, digital, 400V/50Hz, 2 speeds, with quick guide positioner, console, 3 interchangeable shafts, tie rod, guide support, reduction, and base.	9200780.1

Bending capacity		
TYPE OF PIPE	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	139,7	8
Steel conduit for electrical installations	129	8
304/308/316 stainless steel tube	114,3	6
ST. 35.4 bonderised steel pipes for oil-hydraulic plants	114,3	8
Furniture tubes	114,3	10
FE boiler pipes	114,3	8
Aluminium tube	139,7	9
gas pipes	4"	8
Square tube (RHS)	90 x 90	10
Standard bending radii	3/4	times Ø

**UNI 63 MANDREL BENDER**

**Digital electric 3-phase bending machine**

Digital, electric, 3-phase bending machine, quick, powerful and precise. It is the suitable machine to bend thin and delicate pipes with optimal and constant bending radii, with no deformation on bent pipes.

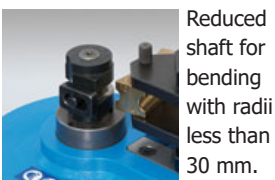
**General features**

- Cast iron body based on structural steelwork
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 1.12 kW power
- Digital touchscreen electronic unit with multilanguage microprocessor for programming, controlling and recovering the bending angle. it is capable of storing 50 bending programmes with the possibility to select 9 sequential bending angles for each program.
- Maximum bending angle 180°
- Low tension printed circuit board (24v.)
- bending angle regulation
- Electro-brake
- Supplied with 1 interchangeable outlet shaft d.32 (code 544455); one reduced shaft (code 544454) optional.
- Weight & dimensions: only machine 120kg.
- Length (without mandrel): 740mm, width: 900mm, height: 1000mm
- Refer to pages 26 for example mandrel bending tooling & accessories.

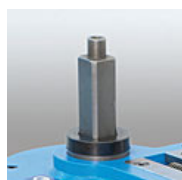
STANDARD VERSION	CODE
UNI 63 digital electric 3phase bending machine 400v/50hz with two interchangeable outlet shafts, quick guide positioner device, guide's support reduction for reduced shaft, foot-pedal and base with mandrel kit 1mt long (usefull length 0,55mt) complete with locking pipe device, mandrel's extraction device, bending plan regulator, shoulders, base fo r slider, wiper-die supports and mandrel rod d.20.	9210341

ACCESSORIES	CODE
With mandrel arm kit 2mt (usefull length 1,55 mt)	9210342
With mandrel arm kit 3mt (usefull length 2,55 mt)	9210343
With mandrel arm kit 4mt (usefull length 3,55 mt)	9210344

Bending capacity		
TYPE OF PIPE	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	35	3
Steel conduit for electrical installations	-	-
Stainless steel 304/316 tube	30	2
Hydraulic steel tubes ST. 35,4	-	-
Furniture tubes	35	2
FE boiler pipes	-	-
Aluminium tube	-	-
Gas pipes	1"	Standard
Double coated aluminium pipe	-	-
Minimum radi	2D	
Special tooling & bending radius available on request.		



Reduced shaft for bending with radii less than 30 mm.



Shaft d.32 (square) for bending with standard radii





**UNI 70/C MANDREL BENDER**

**Digital electric 3-phase bending machine**

The digital UNI 70/C is an accurate and powerful bending machine to bend pipes with large diameters as well as thin and delicate tubes with optimal and constant bending radii and without any pipe deformation. It is suitable to satisfy the bending requirements of the user operating in the plumbing, nautical, hydraulic, industrial, and plant engineering sector.

**General features**

- Spheroidal graphite iron body on metal steelwork base
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 2.2 kW power
- Digital touchscreen electronic unit with multi-language microprocessor and display for programming and controlling the required bending angle. It is possible to store up to 50 bending programmes with the possibility to store up to 9 sequential bending angles for each programme.
- Automatic return at the end of stroke
- Low tension control panel (24V)
- maximum bending angle: 180°
- It is equipped with 1 quick guide positioning device and 2 interchangeable outlet shafts
- Dimensions: length 810mm, width 400mm, height 1100mm.
- Weight: 210kg.
- Length (without mandrel): 740mm, width: 900mm, height: 1000mm
- Refer to pages 26 for example mandrel bending tooling & accessories.
- Special tooling & bending radius available upon request.

STANDARD VERSION	CODE
Digital electric UNI 70/C 400V/50Hz with quick guide positioner and 2 interchangeable outlet shafts, equipped with a 2-metre-long mandrel arm with locking jaw, mandrel extraction device, plane regulator, shoulders, slider base, and wiper-die support. Mandrel rod diameter: 20.	9210002

ACCESSORIES	CODE
With mandrel arm kit 3mt (usefull length 2,55 mt)	9210003
With mandrel arm kit 4mt (usefull length 3,55 mt)	9210004
With mandrel arm kit 5mt (usefull length 4,55 mt)	9210005
With mandrel arm kit 6mt (usefull length 5,55 mt)	9210006

Bending capacity		
TYPE OF PIPE	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	50	4
Steel conduit for electrical installations	-	8
Stainless steel 304/316 tube	50,8	3
Hydraulic steel tubes ST. 35,4	-	4
Furniture tubes	50	3
FE boiler pipes	50	4
Aluminium tube	50	8
Gas pipes	-	Standard
Square tube (RHS)	40 x 40	4
Minimum radii	2D	



Mechanical spindle for the bending plane regulation.



The 2 interchangeable outlet shafts of the standard equipment.



PIPE, TUBE & CONDUIT BENDER

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**UNI 70 HC-OS MANDREL BENDER**

**Electro-hydraulic bending machine for bending with and without mandrel system**

The UNI70/HC-OS with kit moving arm, is an accurate and powerful bending machine able to bend large diameters pipes as well as thin and delicate ones. The optimal and constant bending radii do not deform bent pipes: it is the ideal machine to satisfy every user's exigency in the plumbing, nautical, hydraulic, industry and plants' installation in general, above all in the ornamental field.

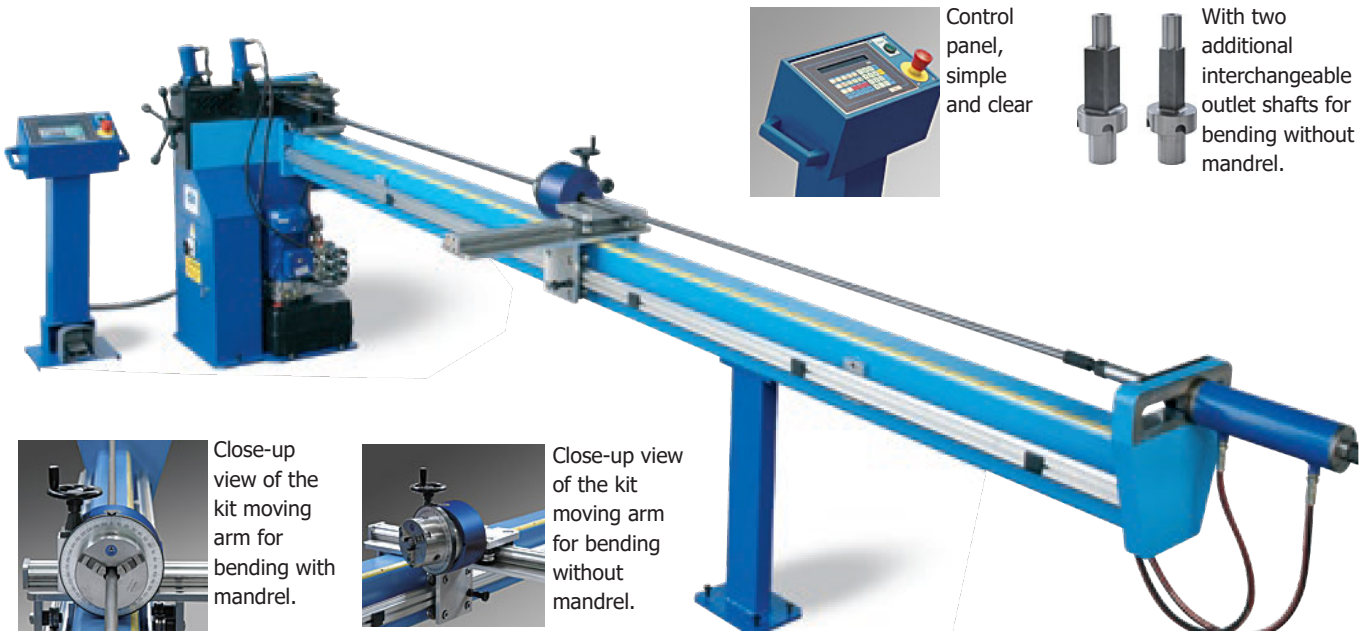
**General features**

- Spheroidal cast ironed body on metal steelwork base.
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 3.1 kW power
- Digital electronic control board with microprocessor and display to set and control the required bend and recovery angle. It can store up to 50 bending programmes . Each program can memorize up to 9 bending angles in sequence.
- Computerised hydraulic system for the closing and opening of locking and bending tools.
- The mandrel's extraction can be set up for a high definition of the bend.
- Dimensions: (only machine) length 830mm, width 630mm, height 1270mm
- Weight: 400kg.
- Refer to page 23 for suitable tooling & accessories.

STANDARD VERSION	CODE
Electrohydraulic UNI 70/HC-OS 400V/50Hz supplied with the controls for hydraulic clamping devices and for the computerized bending, the 2 metre long moving arm kit for bending with and without mandrel system, mandrel extraction oil hydraulic drive, plane regulator, notches, slider base, wiper-die support and mandrel rod diameter: 20.	9210202

ACCESSORIES	CODE
With mandrel arm kit 3mt (usefull length 2,55 mt)	9210203
With mandrel arm kit 4mt (usefull length 3,55 mt)	9210204
With mandrel arm kit 5mt (usefull length 4,55 mt)	9210205
With mandrel arm kit 6mt (usefull length 5,55 mt)	9210206

TYPE OF PIPE	Bending capacity			
	WITH MANDREL		WITHOUT MANDREL	
	Ø mm	mm	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	50	3	60	4
Steel conduit for electrical installations	50	2	60	2
Stainless steel 304/316 pipes	50,8	1,5	60	3
Hydraulic steel tubes ST. 35,4	50	3	60	4
Furniture tubes	50	2	60	3
FE boiler pipes	50	2	60	4
Aluminium tube	50	4	60	8
Gas pipes	48	3	60	standard
Square tube (RHS)	40 x 40	3	50 x 50	4
Minimum radii	2D		3D and 4D	



Control panel, simple and clear

With two additional interchangeable outlet shafts for bending without mandrel.

Close-up view of the kit moving arm for bending with mandrel.

Close-up view of the kit moving arm for bending without mandrel.



**70/HC MANDREL BENDER**

**Electro-hydraulic bending machine for bending with mandrel system**

UNI 70/HC, an accurate and powerful tube, pipe and profile bending machine able to bend large diameters as well as thin and delicate tubes with optimal and constant bending radii and without any tubes deformation: suitable to satisfy every requirement of people operating in the plumbing, nautical, hydraulic, industrial, implantation field and most of all ornamental.

**General features**

- More than the UNI70/C with manual mandrel this machine includes the following features:
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 3.1 kW power
- Microprocessor controlled software able to store up to 50 bending angles along with different recovery angles.
- Possibility to program 50 different sequences with 9 max. bends each in an automatic working cycle.
- Automatic hydraulic system for the closure and opening of the bending accessories.
- Programmable extraction of the mandrel to accomplish a very high quality bend.
- Nominal capacity of 2" (50.8 x 2mm.) Stainless steel.
- Mechanical chuck to position the tube with length and plane stops.
- Refer to page 23 for suitable tooling & accessories.

STANDARD VERSION	CODE
Electrohydraulic UNI 70/HC 400V/50Hz supplied with the controls for hydraulic clamping devices and for the computerised bending, the 2 metre long moving arm kit, mandrel extraction oil hydraulic drive, plane regulator, notches, slider base, wiper-die support and mandrel rod diameter: 20.	9210102

ACCESSORIES	CODE
With mandrel arm kit 3mt (usefull length 2,55 mt)	9210103
With mandrel arm kit 4mt (usefull length 3,55 mt)	9210104
With mandrel arm kit 5mt (usefull length 4,55 mt)	9210105
With mandrel arm kit 6mt (usefull length 5,55 mt)	9210106

Bending capacity		
TYPE OF PIPE	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	50	3
Steel conduit for electrical installations	50	2
Stainless steel 304/316 tube	50,8	1,5
Hydraulic steel tubes ST. 35,4	50	3
Furniture tubes	50	2
FE boiler pipes	50	2
Aluminium tube	50	4
Gas pipes	48	3
Square tube (RHS)	40 x 40	3
Minimum radii	2D	



PIPE, TUBE & CONDUIT BENDER

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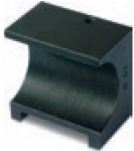


**UNI 70/HC**

**Accessories for bending with mandrel**



Steel former for pipes from diam.10mm to diam.50,8mm and corresponding inch sizes.



Square steel jaw (one per size).



Couple of rollers (one per size) – It must be used instead of the slider guide when pipes have a wall-thickness over 2,5mm and no particular aesthetical exigency is required.



Slider (one x size according to diameter and bending radius) for thin and delicate pipes it avoids marks on the external pipe's surface. It is used instead of the guide for twin-rollers.



Wiper-die (one per size according to diameter and bending radius). To bend with mandrel finished delicate and thin-wall tubes; it avoids wrinkles inside the pipe and can be used together with the slider or with the couple of rolls.



Mandrel support rod.



Fixed mandrel (one per size) for radii equal and/or superior than 2,5D and with pipe's wall-thickness over 2mm. On the mandrel there is a longitudinal groove made appositely to put in the eventual pipe's bead.



Articulated mandrel (one per size) for radii inferior to 2.5D and pipe's wall-thickness less than 2mm.



Mandrel with balls (one per size) for radii inferior than 2.5D and with pipe's wall-thickness less than 2mm. Ideal for very thin wall pipes and with bending radii 2D.



## UNI 80 MANDREL BENDER

### Electro-hydraulic bending machine for bending with mandrel system

The UNI80 is an accurate and powerful bending machine able to bend large diameters pipes as well as thin and delicate ones. The optimal and constant bending radii do not deform bent pipes: it is the ideal machine to satisfy every user's demand in the plumbing, nautical, hydraulic, industry and plants' installation in general, above all in the ornamental field.

#### General features

- Spheroidal cast ironed body on metal steelwork base.
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 3 kW power with inverter
- Digital electronic control board with microprocessor and display to set and control the required bend and recovery angle. It can store up to 50 bending programmes . Each program can memorise up to 9 bending angles in sequence.
- Automatic return to stroke end.
- Switch panel low tension (24V).
- 180° at Maximum allowed bending angle.
- Computerised hydraulic system per the closing and opening of locking and bending tools.
- The mandrel's extraction can be set up for a high definition of the bend.
- Dimensions: (only machine) length 830mm, width 630mm, height 1270mm
- Weight: 600 kg.
- Refer to pages 26 for example mandrel bending tooling & accessories.

STANDARD VERSION	CODE
Electro-hydraulic digital UNI 80, 400V/50Hz with automatic hydraulic device for closing and opening of locking devices and bending tools, with a 3-metre-long mandrel arm kit with hydraulic device for mandrel extraction, plane regulator, notches, mandrel rod diam. 20mm.	9210403

ACCESSORIES	CODE
With mandrel arm kit 2mt (usefull length 155 mt)	9210402
With mandrel arm kit 4mt (usefull length 3,55 mt)	9210404
With mandrel arm kit 5mt (usefull length 4,55 mt)	9210405
With mandrel arm kit 6mt (usefull length 5,55 mt)	9210406

Bending capacity		
TYPE OF PIPE	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	76	1,5
Steel conduit for electrical installations	76	2
Stainless steel 304/316 tube	63,5	1,5
Hydraulic steel tubes ST. 35,4	76	3
Furniture tubes	76	2
FE boiler pipes	76	2
Aluminium tube	76	4
Gas pipes	2" 1/2	3
Square tube (RHS)	60 x 60	3
Minimum radii	2D	



Control panel, simple and clear



Mechanical spindle for the bending plan regulation.

PIPE, TUBE & CONDUIT BENDER

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**UNI 90 MANDREL BENDER**

**Electro-hydraulic bending machine for bending with mandrel system**

The UNI90 is an accurate and powerful bending machine able to bend large diameters pipes as well as thin and delicate ones. The optimal and constant bending radii do not deform bent pipes: it is the ideal machine to satisfy every user's demand in the plumbing, nautical, hydraulic, industry and plants' installation in general, above all in the ornamental field.

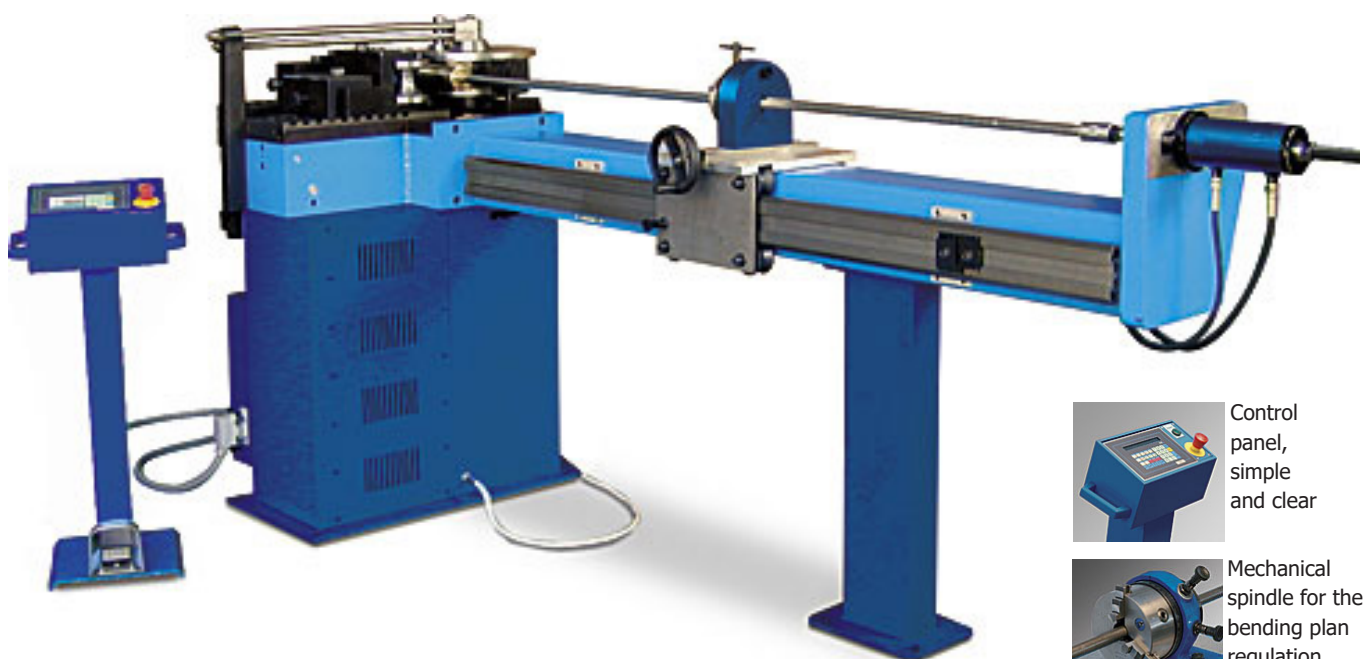
**General features**

- Spheroidal cast ironed body on metal steelwork base.
- Asynchronous motor, 400V/50Hz, 2800 RPM, self-braking motor, 2 speeds, 4 kW power with inverter
- Digital electronic control board with microprocessor and display to set and control the required bend and recovery angle. It can store up to 50 bending programmes Each program can memorize up to 9 bending angles in sequence.
- Automatic return to stroke end.
- Switch panel low tension (24V.).
- 180° at Maximum allowed bending angle.
- Computerized hydraulic system per the closing and opening of locking and bending tools.
- The mandrel's extraction can be set up for a high definition of the bend.
- Dimensions: (only machine) length 110mm, width 700mm, height 1310mm
- Weight: 970 kg.
- Refer to pages 26 for example mandrel bending tooling & accessories.

STANDARD VERSION	CODE
Electro-hydraulic digital UNI 80, 400V/50Hz with automatic hydraulic device for closing and opening of locking devices and bending tools, with a 3-metre-long mandrel arm kit with hydraulic device for mandrel extraction, plane regulator, notches, mandrel rod diam. 20mm.	9210403

ACCESSORIES	CODE
With mandrel arm kit 2mt (usefull length 155 mt)	9210502
With mandrel arm kit 4mt (usefull length 3,55 mt)	9210504
With mandrel arm kit 5mt (usefull length 4,55 mt)	9210505
With mandrel arm kit 6mt (usefull length 5,55 mt)	9210506

Bending capacity		
TYPE OF PIPE	Ø mm	mm
Hard and soft copper pipes, annealed brass pipes	90	1,5
Steel conduit for electrical installations	90	2
Stainless steel 304/316 tube	80	1,5
Hydraulic steel tubes ST. 35,4	90	3
Furniture tubes	90	2
FE boiler pipes	90	2
Aluminium tube	90	4
Gas pipes UNI 5745	3"	3
Square tube (RHS)	70 x 70	3
Minimum radii	2D	



Control panel, simple and clear



Mechanical spindle for the bending plan regulation.

PIPE, TUBE & CONDUIT BENDER

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## EXAMPLE ACCESSORIES FOR BENDING WITH MANDREL

PIPE, TUBE & CONDUIT BENDER



Steel former for pipes from diam.10mm to diam.76mm and corresponding inch sizes.



Steel locking jaw (one per size).



Couple of rollers (one per size) – It must be used instead of the slider guide when pipes have a wall-thickness over 2,5mm and no particular aesthetical exigency is required.



Universal support for fixed slider guide (cod. 0001078).



Slider guide (one per size depending on diameter) for thin and delicate pipes. It avoids external marks on pipe's surface. It is to be used instead of the rollers.



Universal support for mobile slider guide with automatic return (cod.0001079).



Mobile slider guide (one per size according to diameter and bending radius) for very thin wall and delicate pipes. It avoids external marks on pipe's surface. It can be used instead of the fixed slider guide.



Wiper-die (one per size according to diameter and bending radius) for thin-wall and delicate pipes, it avoids wrinkles inside the pipe and it is used in combination with the slider guide.



Mandrel arm rod.



Fixed mandrel (one per size) for radii equal and/or superior than 2,5D and with pipe's wall-thickness over 2mm. On the mandrel there is a longitudinal groove made appositely to put in the eventual pipe's bead.



Articulated mandrel (one per size) for radii inferior to 2.5D and pipe's wall-thickness less than 2mm.



Mandrel with balls (one per size) for radii inferior than 2.5D and with pipe's wall-thickness less than 2mm. Ideal for very thin wall pipes and with bending radii 2D.

Contact an SF-friendly representative for more details on tooling and accessories.

Please specify:

- bend radius,
- tube material,
- tube size,
- inside diameter,
- outside diameter,
- wall thickness,
- length of the tube.

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**UNI42-UNI60-UNI60AI-UNI60COMBI-UNI63-UNI70C-UNI76-UNI89**

**Accessories for bending without mandrel**



Folding stand.  
For UNI 42 (code 000592.1).  
For UNI 60 (code 000593.1).



Universal base, essential for bending with the swinging arm for UNI 42 and UNI 60 (code 000970.1).



Aluminum or spheroidal cast iron form with a ring for bending with standard radii of 3 or 4 times the tube diameter. See FORMS AND COUNTERFORMS tables.



The counter former is used to bend thin tubes with forms A-B-C-E-L-H. See FORMS AND COUNTERFORMS tables.



The single roller is used for bending thick tubes with forms C-E-L-H of the diameter 1 1/4 gas and corresponding in mm only for UNI 42. See FORMS AND COUNTERFORMS tables.



The counterform for the roller pair is used to bend tubes with a thickness greater than 2.5 mm (it is used with 2 rollers depending on the diameter of the tube to be bent); the use of this equipment prevents external flattening of the tube. It is used with forms C-E-L-H.

A - Applies to the single-phase digital UNI 42 electric pipe bender (max 1" gas and corresponding in mm) (code 000844).

B - Applies to the single-phase digital UNI 60 electric pipe bender (code 000969).

C - Applies to the three-phase UNI 70/C pipe bender (code 000799) and the UNI 76 pipe bender up to a diameter of 2" gas and corresponding in mm.

D - Applies to the UNI 76 pipe bender for diameters greater than 2" gas and corresponding in mm (code 0001101).



Roller pair (one for each size), applied to the counterform for the roller pair. See FORMS AND COUNTERFORMS tables.



Reinforcement rod for C-E-L type form, used when bending stainless steel tubing with a diameter greater than 33 mm and corresponding in inches, or when bending other types of tubing with a diameter greater than 42 mm and corresponding in inches.

A - Applies to the single-phase digital UNI 60 electric pipe bender (code 000744).

B - Applies to the three-phase digital UNI 70/C pipe bender (code 000745).



Only for UNI 70/C. Reduction counterform support. It applies to the counterform support of the quick approach device and is exclusively used for bending tube without a mandrel, ranging from Ø 6 to Ø 25 and corresponding in inches (code 000776).



Angle of plane attachment swingarm complete with floor regulator.

Bender model	code	length	usefull length
UNI42	000825	1 m.	0,70 m.
	000826	2 m.	1,70 m.
	000933	3 m.	2,70 m.
	000916	4 m.	3,70 m.
UNI60 UNI60AI	000841	1 m.	0,70 m.
	000842	2 m.	1,70 m.
	000937	3 m.	2,70 m.
	000938	4 m.	3,70 m.
	000986	5 m.	4,70 m.
	0001177	6 m.	5,70 m.
UNI60 COMBI	0001245/1	1 m.	0,70 m.
	0001245/2	2 m.	1,70 m.
	0001245/3	3 m.	2,70 m.
	0001245/4	4 m.	3,70 m.
	0001245/5	5 m.	4,70 m.
	0001245/6	6 m.	5,70 m.
UNI63	0001242/1	1 m.	0,70 m.
	0001242/2	2 m.	1,70 m.
	0001242/3	3 m.	2,70 m.
	0001242/4	4 m.	3,70 m.
	0001242/5	5 m.	4,70 m.
	0001242/6	6 m.	5,70 m.
UNI70C	000815	2 m.	1,70 m.
	000819	3 m.	2,70 m.
	000847	4 m.	3,70 m.
	000838	5 m.	4,70 m.
UNI76	0001083	6 m.	5,70 m.
	0001160	2 m.	1,70 m.
	0001161	3 m.	2,70 m.
	0001162	4 m.	3,70 m.
	0001163	5 m.	4,70 m.
	0001164	6 m.	5,70 m.
UNI89	0001215	2 m.	1,70 m.
	0001216	3 m.	2,70 m.
	0001217	4 m.	3,70 m.
	0001218	5 m.	4,70 m.
	0001246	6 m.	5,70 m.

**UNI 60 COMBI-COMBICAL - Accessories for rolling.**



Three universal rollers for rolling profiles and flat surfaces (a single universal roller is shown in the photo).



Three rollers for bending round tubes based on the diameter of the tube to be bent (metric/gas inches/actual inches) (a single roller is shown in the photo).

Sinistro/Left  
Izquierdo  
Cod. 0001208



Destro/Right  
Derecho  
Cod. 0001205

A right-side support and a left-side support are used for adjusting the height of the tube to be rolled.



**FORMERS AND COUNTERFORMERS**

**MILLIMETER SIZED FORMERS TYPE "C"**

Spheroidal graphite iron formers with ring to use without mandrel TYPE C for bending hard brass, steel, stainless steel, bonderized, titanium tubes etc. To use with guides or rollers according to the tube wall-thickness from diam. 6 to diam. 60.

PIPE, TUBE & CONDUIT BENDER

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UNI							code	
	Ømm	R	mm. min.	mm. max.	mm. min.	mm. min.		
42-60-70/C-76-89	6	30	1	2	•	2,5	•	000636
	8	30	1	2	•	2,5	•	000637
	10	30	1	2	•	2,5	•	000526
		40	1	2	•	2,5	•	000426
	12	36	1	2	•	2,5	•	000309
		48	1	2	•	2,5	•	000310
	14	42	1	2	•	2,5	•	000311
		56	1	2	•	2,5	•	000312
	15	45	1	2	•	2,5	•	000307
		60	1	2	•	2,5	•	000308
	16	48	1	2	•	2,5	•	000305
		64	1	2	•	2,5	•	000306
	17	51	1	2	•	2,5	•	000313
		68	1	2	•	2,5	•	000314
	18	54	1	2	•	2,5	•	000303
		72	1	2	•	2,5	•	000304
	19	57	1	2	•	2,5	•	000326
		76	1	2	•	2,5	•	000327
	20	60	1	2	•	2,5	•	000281
		80	1	2	•	2,5	•	000286
22	66	1	2	•	2,5	•	000282	
	88	1	2	•	2,5	•	000182	
24	72	1	2	•	2,5	•	000301	
	96	1	2	•	2,5	•	000302	
25	75	1	2	•	2,5	•	000283	
	100	1	2	•	2,5	•	000284	
26	78	1	2	•	2,5	•	000299	
	104	1	2	•	2,5	•	000300	
28	84	1	2	•	2,5	•	000297	
	112	1	2	•	2,5	•	000298	
30	90	1	2	•	2,5	•	000147	
	120	1	2	•	2,5	•	000148	
32	96	1	2,5	•	2,5	•	000287	
	128	1	2,5	•	2,5	•	000289	
34	102	1	2,5	•	2,5	•	000290	
	136	1	2,5	•	2,5	•	000291	
35	105	1	2,5	•	2,5	•	000145	
	140	1	2,5	•	2,5	•	000146	
37	111	1	2,5	•	2,5	•	000292	
	148	1	2,5	•	2,5	•	000293	
38	114	1	2,5	•	2,5	•	000143	
	152	1	2,5	•	2,5	•	000144	
40	120	1	2,5	•	2,5	•	000294	
	160	1	2,5	•	2,5	•	000295	
42	162	1	2,5	•	2,5	•	000141	
	216	1	2,5	•	2,5	•	000142	



UNI							code	
	Ømm	R	mm. min.	mm. max.	mm. min.	mm. min.		
60	45	135	1	2,5	•	2,5	•	000750
		180	1	2,5	•	2,5	•	000414
	50	150	1	2,5	•	2,5	•	000751
200		1	2,5	•	2,5	•	000285	
54	162	1	2,5	•	2,5	•	000752	
	216	1	2,5	•	2,5	•	000629	
70/C-76-89	45	135	1	2,5	•	2,5	•	000750.60-70
		180	1	2,5	•	2,5	•	000414.60-70
	50	150	1	2,5	•	2,5	•	000751.60-70
		200	1	2,5	•	2,5	•	000285.60-70
	54	162	1	2,5	•	2,5	•	000752.60-70
		216	1	2,5	•	2,5	•	000629.60-70
	45	135	1	2,5	•	2,5	•	000750.70
		180	1	2,5	•	2,5	•	000414.70
	50	150	1	2,5	•	2,5	•	000751.70
		200	1	2,5	•	2,5	•	000285.70
54	162	1	2,5	•	2,5	•	000752.70	
	216	1	2,5	•	2,5	•	000629.70	
60	180	1	2,5	•	2,5	•	000753.70	
	240	1	2,5	•	2,5	•	000296.70	
76-89	63	180	1	2,5	•	2,5	•	0001097
		240	1	2,5	•	2,5	•	0001098
	65	228	1	2,5	•	2,5	•	0001099
		228	1	2,5	•	2,5	•	0001100
	75	228	1	2,5	•	2,5	•	0001103
75	292	1	2,5	•	2,5	•	0001128	
89	80	355	1	2,5	•	2,5	•	0001221
	85	355	1	2,5	•	2,5	•	0001222
	90	355	1	2,5	•	2,5	•	0001223



**FORMERS AND COUNTERFORMERS**


**INCH SIZED FORMERS TYPE "E"**

Spheroidal graphite iron formers with ring to use without mandrel TYPE E for bending hard brass, steel, stainless steel, bonderized, titanium tubes etc. To use with guides or rollers according to the tube wall thickness from Ø 1/4" to Ø 2" 3/8.

UNI				mm.				code	
	Ø	Ømm	R	min.	max.	min.	mm.		
42-60-70/C-76-89	1/4	6,35	3D	1	2	•	2,5	•	000633
	5/16	7,94	3D	1	2	•	2,5	•	000634
	3/8	9,52	3D	1	2	•	2,5	•	000635
	1/2	12,70	3D	1	2	•	2,5	•	000332
	1/2	12,70	4D	1	2	•	2,5	•	000333
	5/8	15,88	3D	1	2	•	2,5	•	000334
	5/8	15,88	4D	1	2	•	2,5	•	000335
	3/4	19,05	3D	1	2	•	2,5	•	000552
	3/4	19,05	4D	1	2	•	2,5	•	000553
	7/8	22,22	3D	1	2	•	2,5	•	000554
	7/8	22,22	4D	1	2	•	2,5	•	000339
	1"	25,40	3D	1	2	•	2,5	•	000340
	1"	25,40	4D	1	2	•	2,5	•	000341
	1 1/8	28,58	3D	1	2	•	2,5	•	000342
	1 1/8	28,58	4D	1	2	•	2,5	•	000343
	1 1/4	31,75	3D	1	2,5	•	2,5	•	000344
	1 1/4	31,75	4D	1	2,5	•	2,5	•	000345
	1 3/8	34,92	3D	1	2,5	•	2,5	•	000346
	1 3/8	34,92	4D	1	2,5	•	2,5	•	000347
	60	1 1/2	38,10	3D	1	2,5	•	2,5	•
1 1/2		38,10	4D	1	2,5	•	2,5	•	000349
1 5/8		41,28	3D	1	2,5	•	2,5	•	000507
1 5/8		41,28	4D	1	2,5	•	2,5	•	000509
1 3/4		44,45	3D	1	2,5	•	2,5	•	000562
1 3/4		44,45	4D	1	2,5	•	2,5	•	000563
1 7/8		47,62	3D	1	2,5	•	2,5	•	000754
1 7/8		47,62	4D	1	2,5	•	2,5	•	000565
2"		50,80	3D	1	2,5	•	2,5	•	000755
2"		50,80	4D	1	2,5	•	2,5	•	000350
2 1/8		53,98	3D	1	2,5	•	2,5	•	000756
2 1/8		53,98	4D	1	2,5	•	2,5	•	000582
1 3/4		44,45	3D	1	2,5	•	2,5	•	000562.60-70
1 3/4		44,45	4D	1	2,5	•	2,5	•	000563.60-70
1 7/8		47,62	3D	1	2,5	•	2,5	•	000754.60-70
1 7/8		47,62	4D	1	2,5	•	2,5	•	000565.60-70
2"		50,80	3D	1	2,5	•	2,5	•	000755.60-70
2"		50,80	4D	1	2,5	•	2,5	•	000350.60-70
2 1/8		53,98	3D	1	2,5	•	2,5	•	000756.60-70
2 1/8		53,98	4D	1	2,5	•	2,5	•	000582.60-70
70/C-76-89	1 3/4	44,45	3D	1	2,5	•	2,5	•	000562.70
	1 3/4	44,45	4D	1	2,5	•	2,5	•	000563.70
	1 7/8	47,62	3D	1	2,5	•	2,5	•	000754.70
	1 7/8	47,62	4D	1	2,5	•	2,5	•	000565.70
	2"	50,80	3D	1	2,5	•	2,5	•	000755.70
	2"	50,80	4D	1	2,5	•	2,5	•	000350.70
	2 1/8	53,98	3D	1	2,5	•	2,5	•	000756.70
	2 1/8	53,98	4D	1	2,5	•	2,5	•	000582.70
	2 1/4	57,15	3D	1	2,5	•	2,5	•	000757.70
	2 1/4	57,15	4D	1	2,5	•	2,5	•	000351.70
76-89	2 3/8	60,32	3D	1	2,5	•	2,5	•	000758.70
	2 3/8	60,32	4D	1	2,5	•	2,5	•	000583.70
	2 1/2	63,5	180	1	2,5	•	2,5	•	0001104
	2 1/2	36,5	240	1	2,5	•	2,5	•	0001105
	2 5/8	66,7	228	1	2,5	•	2,5	•	0001106
	2 3/4	69,8	228	1	2,5	•	2,5	•	0001107
	2 7/8	73	228	1	2,5	•	2,5	•	0001108
	3"	76	228	1	2,5	•	2,5	•	0001102
	3 1/4	82,5	355	1	2,5	•	2,5	•	0001224
	3 1/2	88,9	355	1	2,5	•	2,5	•	0001225


**GAS INCH SIZED FORMERS TYPE "L"**

Spheroidal graphite iron formers with ring to use without mandrel TYPE L for bending gas tubes. To use with guides or rollers according to the tube wall thickness.

UNI				code
	Ø" GAS	EQUIVALENT (mm)	R (mm)	
42-60-70/C-76-89	1/4	13.72	47	000524
	3/8	17.2	53.5	000194
	1/2	21.3	59	000193
	3/4	26.9	78	000165
	1"	33.7	100	000171
	1 "1/4	42.40	127.20	000824
60	1" 1/4	42.40	150	000172
	1 "1/2	48.3	144.75	000793
60-70/C-76-89	1" 1/2	48.3	199.5	000331
	1" 1/2	48.3	144.75	000793.70
	1" 1/2	48.3	199.5	000331.70
	2"	60.3	180.9	000794.70
76-89	2"	60.3	238.5	000260.70
	2"	60.3	180.9	0001232
	2 "1/2	76.1	228	0001102
	2"1/2	76.1	292	0001109
	3"	88.9	270	0001229
3"	88.9	355	0001226	

**MILLIMETER SIZED FORMERS TYPE "H"**

Spheroidal graphite iron formers to use without mandrel TYPE H for bending steel, hydraulic stainless steel pipes (minimum thickness 3 mm) with tight radii (about 2D).

UNI				code
	Ømm max.	R min.	R max. (mm)	
42-60-70/C-76	20	30	43	H.30-43
	30	43.1	61	H.43-61
	38	61.1	76	H.61-76
	42	76.1	91	H.76-91
42-60-70/C-76	45	91.1	128	H.91-128
	60	101	115	H.101-115
	60	115.1	130	H.115-130
	60	130.1	150	H.130-150
70/C-76	60	150.1	170	H.150-170
	60	170.1	200	H.170-200
	60	200.1	240	H.200-240
	60	240.1	280	H.240-280

**PIPE, TUBE & CONDUIT BENDER**

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**FORMERS AND COUNTERFORMERS**

**MILLIMETER SIZED BRASS GUIDES**

ITEM	code
Ø 6 - 8	420060
Ø 10 - 12	420061
Ø 12 - 14	420062
Ø 15 - 17	420063
Ø 15 - 18	420064
Ø 16 - 18	420025
Ø 19 - 26	420065
Ø 20 - 24	420066
Ø 20 - 25	420026
Ø 20 - 26	420067
Ø 22 - 28	420027
Ø 30 - 32	420068
Ø 32 - 38	420028
Ø 32 - 40	420069
Ø 34 - 37	420070
Ø 42 for copper UNI 42	420073
Ø 42 for copper UNI 60 - 70/C	420074
Ø 42 for UNI 60 - 70/C	420075
Ø 45	420076
Ø 50	420077
Ø 54	420078
Ø 60	420079
Ø 63 (1)	420081
Ø 65	CF76BM65
Ø 70	CF76BM70
Ø 75	CF76BM75
Ø 80*	CF89BM80
Ø 85*	CF89BM85
Ø 90*	CF89BM90

**GAS INCH SIZED BRASS GUIDES**

ITEM	code
Ø 1/8 - 1/4	420130
Ø 3/8 - 1/2	420131
Ø 3/4 - 1"	420032
Ø 1"1/4	420132
Ø 1"1/4 only UNI 60 - 70/C	420133
Ø 1"1/2	420134
Ø 2"	420135
Ø 2"1/2*	CF76BG2.1/2-3W
Ø 3"*	CF89BG3

**MILLIMETER SIZED SPECIAL GUIDES FOR THE UNI 60 AI AND UNI 30 SPEED (WITH REDUCED SHAFT ONLY)**

ITEM	code
Ø 6-8	224014
Ø 10-12	420013
Ø 14-16	420014
Ø 18-22	420010
Ø 12-15	420009
Ø 17-20	420008

**INCH SIZED GUIDES FOR THE UNI 60 AI & UNI 30 SPEED (WITH REDUCED SHAFT ONLY)**

ITEM	code
Ø 1/4-5/16	224018
Ø 1/4-3/8	224017
Ø 1/2-5/8	420006

**INCH SIZED BRASS GUIDES**

ITEM	code
Ø 1/4 - 5/16	420103
Ø 3/8 - 1/2	420104
Ø 5/8 - 3/4	420105
Ø 7/8 - 1"	420030
Ø 1"1/4 - 1"1/2	420039
Ø 1"1/8 - 1"3/8	420031
Ø 1"5/8	420100
Ø 1"5/8 only UNI 60 - 70/C	420101
Ø 1"3/4	420102
Ø 1"3/4 only UNI 60 - 70/C	420106
Ø 1"7/8	420107
Ø 2"	420108
Ø 2"1/8	420109
Ø 2"1/4	420110
Ø 2"3/8	420111
Ø 2"1/2	420112
Ø 2"5/8*	CF76B2.5/8W
Ø 2"3/4*	CF76B2.3/4W
Ø 2"7/8*	CF76B2.7/8W
Ø 3"*	CF76BG2.1/2-3W
Ø 3"1/4*	CF89B3.1/4W
Ø 3"1/2*	CF89B3.1/2W

**MILLIMETER SIZED ROLLERS FOR UNI 42**

ITEM	code
universal UNI 42	595362
Ø 10	595363
Ø 12	595364
Ø 14	595365
Ø 15	595366
Ø 16	595367
Ø 17	595368
Ø 18	595369
Ø 19	595370
Ø 20	595371
Ø 22	595372
Ø 24	595373
Ø 25	595374
Ø 26	595375
Ø 28	595376
Ø 30	595377
Ø 32	595378
Ø 34	595379
Ø 35	595380
Ø 37	595381
Ø 38	595382
Ø 40	595383
Ø 42	595384

PIPE, TUBE & CONDUIT BENDER

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**FORMERS AND COUNTERFORMERS**

**INCH SIZED ROLLERS FOR UNI 42**

ITEM	code
Ø 1/4"	595385
Ø 3/8"	595386
Ø 1/2"	595387
Ø 5/8"	595388
Ø 3/4"	595389
Ø 7/8"	595390
Ø 1"	595391
Ø 1 1/8"	595392
Ø 1 1/4"	595393
Ø 1 3/8"	595394
Ø 1 1/2"	595395
Ø 1 5/8"	595396

**GAS INCH SIZED ROLLERS FOR UNI 42**

ITEM	code
Ø 1/4"	595397
Ø 3/8"	595398
Ø 1/2"	595399
Ø 3/4"	595400
Ø 1"	595401
Ø 1 1/4"	595402

**INCH SIZED ROLLERS FOR THE UNI 60 - 70/C - 76 - 89**

ITEM	code
Ø 1/2"	595136
Ø 5/8"	595137
Ø 3/4"	595138
Ø 7/8"	595139
Ø 1"	595140
Ø 1 1/8"	595141
Ø 1 1/4"	595147
Ø 1 3/8"	595286
Ø 1 1/2"	595129
Ø 1 5/8"	595142
Ø 1 3/4"	595143
Ø 1 7/8"	595144
Ø 2"	595145
Ø 2 1/8"	595287
Ø 2 1/4"	595146
Ø 2 3/8"	595288
Ø 2 1/2"	595409
Ø 2 5/8"	595410
Ø 2 3/4"	595411
Ø 2 7/8"	595412
Ø 3"	595413
Ø 3 1/4"	595420
Ø 3 1/2"	595421

**MILLIMETER SIZED ROLLERS FOR UNI 60 - 70/C - 76 - 89**

ITEM	code
Universal UNI 60	595155
Ø 10	595113
Ø 12	595114
Ø 14	595115
Ø 15	595103
Ø 16	595116
Ø 17	595112
Ø 18	595102
Ø 19	595117
Ø 20	595089
Ø 22	595090
Ø 24	595118
Ø 25	595091
Ø 26	595119
Ø 28	595092
Ø 30	595093
Ø 32	595109
Ø 34	595111
Ø 35	595094
Ø 37	595120
Ø 38	595132
Ø 40	595110
Ø 42	595101
Ø 45	595271
Ø 50	595122
Ø 52	595272
Ø 54	595273
Ø 60	595257
Ø 63	595405
Ø 65	595406
Ø 70	595407
Ø 75	595408
Ø 80	595417
Ø 85	595418
Ø 90	595419

**GAS INCH SIZED ROLLERS FOR UNI 60 - 70/C - 76 - 89**

ITEM	code
Ø 1/4"	595134
Ø 3/8"	595104
Ø 1/2"	595105
Ø 3/4"	595106
Ø 1"	595238
Ø 1 1/4"	595108
Ø 1 1/2"	595284
Ø 2"	595285
Ø 2 1/2"	595413
Ø 3"	595422



## PB SERIES HYDRAULIC PIPE BENDERS (MADE IN JAPAN)



### FEATURES

The PB-10N & PB-15N Benders were designed to bend various sizes and various thickness of steel pipes without wrinkles. An aluminium alloy frame makes this bender lighter so that it can be easily carried to the job site.

Bending shoes are designed to bend gas pipe or steel electrical conduit - listed in the charts below. For use with any 700-bar hydraulic single-acting high-pressure pump (HAND, ELECTRIC, BATTERY OR AIR-HYDRAULIC)

**PLEASE NOTE: Hydraulic Pump & Bending shoes are sold separately - unless otherwise indicated**

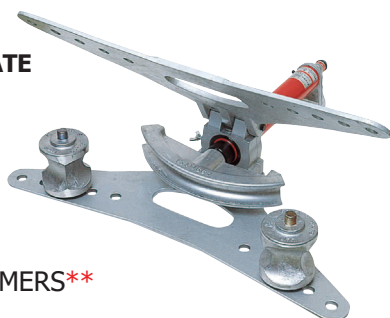
### SUITABLE CONDUIT & PIPE

Model No.	PB-10N	PB-15N
<b>Thin steel conduit</b>	16mm to 50mm	16mm to 63mm
<b>Gas Pipe</b>	SGP15 (1/2", 21.3mm) to SGP50 (2", 60.3mm) to 90° in one shot	SGP15 (1/2", 21.3mm) to SGP100 (4", 114.3mm)

### SPECIFICATIONS

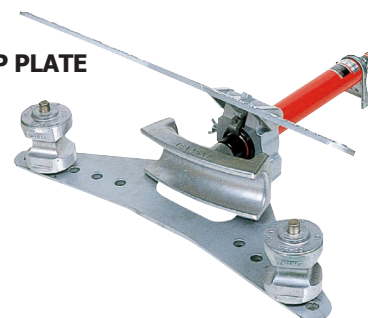
Model No.	PB-10N	PB-15N
<b>Capacity</b>	15-50mm (1/2 - 2") Nominal Bore Pipe	15-100mm (1/2 - 4") Nominal Bore Pipe
<b>Oil volume required</b>	400cc	595cc
<b>Output force</b>	108kN	162kN
<b>Ram stroke</b>	250mm	250mm
<b>Size</b>	780mm Wide	900mm Wide
<b>Weight</b>	18.6kg (W/O PIVOT SHOES and BENDER SHOE)	28.8kg (W/O PIVOT SHOES and BENDER SHOE)
<b>INCLUDES:</b>	Frame, Cylinder, Pivot shoes (2 pieces) and Angle gauge	Frame, Cylinder, Pivot shoes (2 pieces) and Angle gauge

HINGED TOP PLATE



**MODEL NO.**  
PB-10N  
PB-10N INC FORMERS\*\*

HINGED TOP PLATE



**MODEL NO.**  
PB-15N

### BENDING SHOES STEEL CONDUIT

Model No.	(mm) OD	Suits Model
<b>A15</b>	15.9	<b>PB10N/15N</b>
<b>B16</b>	21.0	<b>PB10N/15N</b>
<b>A25</b>	25.4	<b>PB10N/15N</b>
<b>A31</b>	31.8	<b>PB10N/15N</b>
<b>B36</b>	41.9	<b>PB10N/15N</b>
<b>A51</b>	50.8	<b>PB10N/15N</b>
<b>*A63</b>	63.5	<b>PB15N</b>

\* Segmented bending required to produce a 90° bend

### BENDING SHOES GAS PIPE

Model No.	(mm) OD	Suits Model
<b>**SGP-15 - 1/2" GAS</b>	21.3	<b>PB10N/15N</b>
<b>**SGP-20 - 3/4" GAS</b>	26.9	<b>PB10N/15N</b>
<b>**SGP-25 - 1" GAS</b>	33.7	<b>PB10N/15N</b>
<b>**SGP-32 - 1 1/4" GAS</b>	42.2	<b>PB10N/15N</b>
<b>**SGP-40 - 1 1/2" GAS</b>	48.3	<b>PB10N/15N</b>
<b>**SGP-50 - 2" GAS</b>	60.3	<b>PB10N/15N</b>
<b>*SGP-65 - 2 1/2" GAS</b>	76.3	<b>PB15N</b>
<b>*SGP-80 - 3" GAS</b>	89.1	<b>PB15N</b>
<b>*SGP-90 - 3 1/2" GAS</b>	101.6	<b>PB15N</b>
<b>*SGP-100 - 4" GAS</b>	114.3	<b>PB15N</b>

**MODEL No. BE32AUS MANUAL CONDUIT BENDER (MADE IN UK)**



**FEATURES**

The BE32AUS Conduit Machine will bend 16mm, 20mm, 25mm and 32mm galvanised and black enamel conduit. The formers are precision machined aluminium for improved accuracy and ease of use throughout the bend. The BE32AUS Conduit Machine is supplied with a quality pipe vice and carrying handle for ease of transportation also an extension lever is provided for extra leverage required for bending larger diameter conduit. When not in use the extension lever can be stored neatly on the side of the machine. The BE32 Conduit Machine is manufactured in the UK by the last British manufacturer of the Hilmor brand of pipe bending machines spares and accessories.



**SPECIFICATIONS**

<b>Capacity</b>	16mm, 20mm, 25mm, & 32mm OD Electrical Steel and PVC Conduit*
<b>Includes</b>	Vice 16/20/25/32mm Formers.
<b>Packed Weight</b>	34kg
<b>Packed Dimensions</b>	113 x 54 x 22cm (LxWxH)

Capacity –16-32mm Ø

\*Steel Electrical Conduit 2.0mm thick and under all PVC conduits

**DETAILS**

- Used in electrical installation
- Precision machined aluminium formers
- Bends 16mm, 20mm, 25mm and 32mm conduit with included formers
- Pipe vice and extension lever included



**SPARE PARTS**



Model No. BVICE2 2" / 50mm Pipe vice



Model No. BLP Bending lever pin BCP Centre pin



Model No. B32F 32mm Conduit former  
Model No. B25F 25mm Conduit former  
Model No. B20F 20mm Conduit former  
Model No. B16F 16mm Conduit former



Model No. BDP Repeat bend attachment (Supplied with bolts and pins (not shown))



Model No. BTS Tube stop and clip



Model No. BRC Retaining clips x5



Model No. BSPCA Safety Chain Assembly



Model No. BGR Grooved roller



Model No. BUNIBL Universal bending lever



Model No. BPVJ Pipe vice jaw set

**MODEL NO. SF16-32 METRIC THREADING KIT FOR ELECTRICAL STEEL CONDUIT**

Draper Ratchet Action Pipe Threading Kits

Metric conduit external end threading kit, often referred to as "Warragul Dies", these kits are suitable for threading electrical conduit pipes. Contains two piece tubular steel operating handle with rubber grip, compact ratchet head, cast iron and alloy steel dies.



Model No	Dies & Die Guides Included for Metric Threads (mm)	Threading Details	Kit Contents	Kit Dimensions LxWxH (mm)	Kit Weight (kg)
SF16-32	16, 20, 25 & 32	Metric Conduit @ 1.5mm Pitch	<ul style="list-style-type: none"> <li>• 1 x Carry Case</li> <li>• 1 x Ratchet</li> <li>• 4 x Cutting Dies</li> <li>• 4 x Die Guides</li> </ul>	370x135x85	6.7



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**PIPE, TUBE & CONDUIT BENDER**

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