SUPERIOR MANUFACTURING

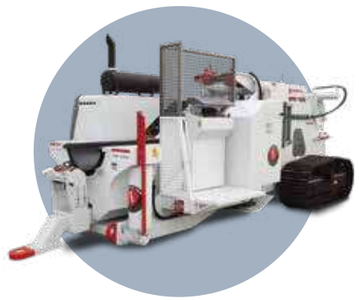
PIPE BENDERS

SPB 16-30

MAX PRESSURE
4,060 psi

WEIGHT
39,683 lb

HORSEPOWER
99.5 HP



The SPB 16-30

The SPB 16-30 is installed on tilting idle tracks. Its dimensions and low profile make its travel easy on any job site, thus being the best solution, especially on small and medium-sized projects where 30" pipes are used. The SPB benders also feature oversized cylinders for better control of the bending process.

PIPE BENDERS
SPB 16-30

Specifications

Engine

Model	Caterpillar C-4.4 ACERT
Net flywheel power (DIN 6271)	99.5 HP
Governed speed	2,000 rpm
Displacement	4.01 L
Number of cylinders	4
Sound proofing type	Yes

Hydraulic Pump

Type	Variable axial piston pump, with pressure and flow control
Maximum flow rate	40 gpm (150 L/min)
Maximum constant pressure	4,061 p.s.i. (280 bar)
Maximum peak pressure	5,046 p.s.i. (350 bar)

Control Valve

Brand	Rexroth
Type	Load-sensing with proportional control (LUDV)
Spools	N.5

Hydraulic Winch

Type	Hydraulic winch
Maximum pull at first layer	9,700 lb (4,400 kg)
Hydraulic motor	Orbital DANFOSS
Frame	Aluminum allow + ductile cast iron
Reduction gear	With worm screw, irreversible
Neutral	Manual
Maximum operating pressure	2,030 p.s.i. (140 bar)
Maximum feed flow rate	42 gpm (160 L/min)
Speed at first layer	16 ft/min (4,85 m/min)
Recommended cable diameter	1/2 inch (Ø 10 mm)
Wire rope type	6 strands with textile core
	R=2,160 N/mm2 min. breaking load guaranteed 30,000 kg

Hydraulic Oil Tank

Type	Metal work with filter
Capacity	50 US gal (190 L)
Cartridge type	Donaldson

Fuel Tank

Type	Metal work with filter
Capacity	52 US gal (200 L)

Spools

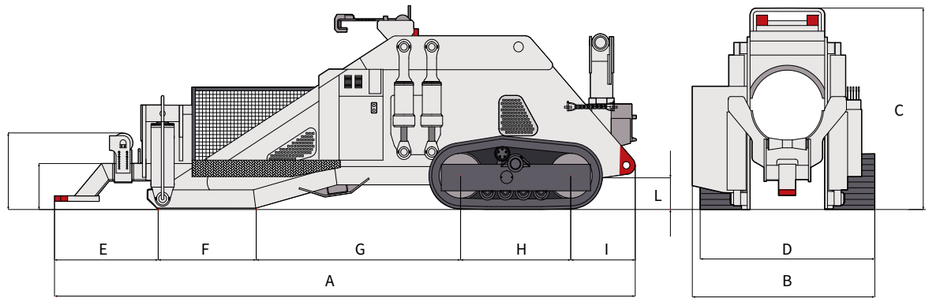
Spool 1: Out-board and in-board cylinders, clamps	
Maximum flow	39.6 gpm (150 L/min)
Pressure	4,351 p.s.i. (300 bar)
Spool 2: Wedge cylinder	
Maximum flow	40 gpm (150 L/min)
Pressure	2,175-4,351 p.s.i. (150-300² bar)
Spool 3: Winch	
Maximum flow	26 gpm (100 L/min)
Pressure	2,320 p.s.i. (160 bar)
Spool 4: Auxiliary control 1	
Maximum flow	26 gpm (100 L/min)
Pressure	2,320 p.s.i. (160² bar)
Spool 5: Auxiliary control 2	
Maximum flow	26 gpm (100 L/min)
Pressure	1,740 p.s.i. (120² bar)

Bending Data

Pipe Size	Maximum Wall Thickness By Grade (inches)							Recommended Bend		
	X52	*X56*	*X60*	*X65*	*X70*	*X80*	*X100*	*Degree per Arc Foot*	*Radius Feet*	*Max Degree Per 40 Feet*
22"	2	2	2	2	2	1-7/8	1-7/16	0.80	72	21.60
24"	2	2	2	1-15/16	1-3/4	1-1/2	1-1/8	0.75	76	20.30
26"	2	1-13/16	1-11/16	1-9/16	1-3/8	1-3/16	15/16	0.70	82	18.90
28"	1-5/8	1-1/2	1-3/8	1-1/4	1-1/8	1	3/4	0.65	88	17.60
30"	1-3/8	1-1/4	1-1/8	1-1/16	15/16	13/16	5/8	0.60	95	16.20
32"	1-3/16	1-1/16	1	15/16	13/16	11/16	9/16	0.58	98	15.60
34"	1	15/16	7/8	13/16	3/4	5/8	1/2	0.55	104	14.80
36"	7/8	13/16	3/4	11/16	5/8	9/16	7/16	0.50	115	13.50

Pipe Size	Maximum Wall Thickness By Grade (mm)							Recommended Bend		
	X52	*X56*	*X60*	*X65*	*X70*	*X80*	*X100*	*Degree per Arc Foot*	*Radius Meter*	*Max Degree Per 12 Meters*
22" (558.8)	50.80	50.80	50.80	50.80	50.80	47.63	36.52	39.3	21.95	21.60
24" (609.6)	50.80	50.80	50.80	49.22	44.45	38.10	28.58	38.0	23.16	20.30
26" (660.4)	50.80	46.04	42.87	39.69	34.93	30.17	23.82	37.9	24.99	18.90
28" (711.2)	41.28	38.10	34.93	31.75	28.58	25.40	19.05	37.7	26.82	17.60
30" (762)	34.93	31.75	28.58	26.99	23.82	20.64	15.88	38.0	28.96	16.20
32" (812.8)	30.17	26.99	25.40	23.82	20.64	17.47	14.29	36.7	29.87	15.60
34" (863.6)	25.40	23.82	22.23	20.64	19.05	15.88	12.70	36.7	31.70	14.80
36" (914.4)	22.23	20.64	19.05	17.47	15.88	14.29	11.12	38.3	35.05	13.50

Dimensions



A	26.25' (8 m)
B	8.2' (2.5 m)
C	9.4' (2.86 m)
D	8.1' (2.48 m)
E	5.7' (1.73 m)
F	2.8' (86.5 cm)
G	9.8' (2.99 m)
H	4.6' (1.4 m)
I	3.4' (1.04 m)
J	2.3' (70 cm)
K	3.6' (1.1 m)
L	1.7' (51 cm)

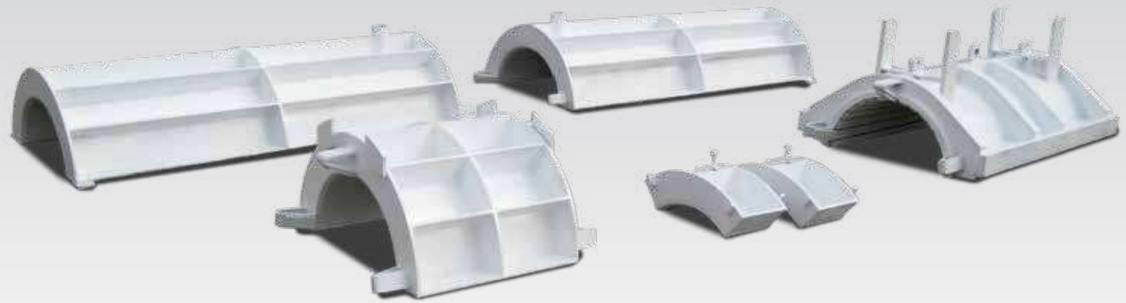
Accessories

Mandrels

Model	Pipe Size	Dimensions (L X W X H)	Weight
SWH 10	10"	73 x 8 x 8" (1,850 x 203 x 203 mm)	374 lb (170 kg)
SWH 12-14	12-14"	81 x 12 x 12" (2,050 x 305 x 305 mm)	440 lb (200 kg)
SWH 16-18	16-18"	86.5 x 16 x 16" (2,200 x 407 x 407 mm)	924 lb (420 kg)
SWH 20-22	20-22"	95.5 x 20 x 20" (2,430 x 508 x 508 mm)	1,452 lb (660 kg)
SWH 24-26	24-26"	107.5 x 22 x 22" (2,730 x 559 x 559 mm)	1,760 lb (800 kg)
SWH 28	28"	107.5 x 24 x 24" (2,730 x 610 x 610 mm)	2,904 lb (1,320 kg)
SWH 30-32	30-32"	123.5 x 28 x 28" (3,140 x 711 x 711 mm)	3,795 lb (1,725 kg)
SWH 34-36	34-36"	123.5 x 31 x 31" (3,140 x 787 x 787 mm)	3,927 lb (1,785 kg)
SWH 36-38	36-38"	115 x 33 x 33" (2,920 x 838 x 838 mm)	5,390 lb (2,450 kg)
SWH 40-42	40-42"	115 x 37 x 37" (2,920 x 940 x 940 mm)	5,522 lb (2,510 kg)
SWH 42-44	42-44"	158 x 39 x 39" (4,013 x 990 x 990 mm)	8,020 lb (3,638 kg)
SWH 46-48	46-48"	158 x 43 x 43" (4,013 x 1,092 x 1,092 mm)	9,504 lb (4,320 kg)
SWH 48-50	48-50"	158 x 45 x 45" (4,013 x 1,143 x 1,143 mm)	11,030 lb (5,003 kg)
SWH 52-54	52-54"	158 x 49 x 49" (4,013 x 1,245 x 1,245 mm)	11,946 lb (5,430 kg)
SWH 56-58	56-58"	158 x 50 x 50" (4,013 x 1,270 x 1,270 mm)	13,112 lb (5,960 kg)
SWH 60-62	60-62"	158 x 54 x 54" (4,013 x 1,372 x 1,372 mm)	13,640 lb (6,200 kg)
SWH 64-66	64-66"	158 x 58 x 58" (4,013 x 1,473 x 1,473 mm)	14,828 lb (6,740 kg)

Line-up Clamps

Model	Pipe Size	Dimensions (L X W X H)	Weight
SLC 8	8"	59.5 x 7.5 x 9" (1,510 x 190 x 229 mm)	253 lb (115 kg)
SLC 10	10"	64 x 10 x 11.5" (1,625 x 254 x 292 mm)	286 lb (130 kg)
SLC 12-14	12-14"	90.5 x 12 x 13.5" (2,300 x 305 x 343 mm)	319 lb (145 kg)
SLC 16-18	16-18"	95.5 x 16 x 17.5" (2,430 x 406 x 445 mm)	418 lb (190 kg)
SLC 20-22	20-22"	105 x 18.5 x 20" (2,680 x 469 x 508 mm)	693 lb (315 kg)
SLC 24-26	24-26"	113.5 x 26 x 27.5" (2,880 x 660 x 698 mm)	935 lb (425 kg)
SLC 28	28"	113.5 x 28 x 29.5" (2,8800 x 710 x 749 mm)	1,122 lb (510 kg)
SLC 30-32	30-32"	124.5 x 30 x 31.5" (3,160 x 762 x 800 mm)	1,148 lb (522 kg)
SLC 34-36	34-36"	134 x 36 x 37.5" (3,400 x 910 x 952 mm)	2,640 lb (1,200 kg)
SLC 40-42	40-42"	140 x 40 x 41.5" (3,550 x 1,016 x 1,054 mm)	3,080 lb (1,400 kg)
SLC 46-48	46-48"	151 x 45 x 46.5" (3,850 x 1,143 x 1,181 mm)	4,290 lb (1,950 kg)
SLC 50-52	50-52"	157 x 50 x 51.5" (4,000 x 1,270 x 1,308 mm)	4,620 lb (2,100 kg)
SLC 54-56	54-56"	157 x 54 x 55.5" (4,000 x 1,372 x 1,410 mm)	4,950 lb (2,250 kg)
SLC 56-60	56-60"	181 x 58 x 59.5" (4,600 x 1,473 x 1,511 mm)	5,170 lb (2,350 kg)
SLC 60-64	60-64"	181 x 62 x 63.5" (4,600 x 1,575 x 1,613 mm)	5,720 lb (2,600 kg)



Bending Sets

Bending sets are available bare or with linings to accommodate special conditions and non-standard pipe or coating. Standard bending sets will accommodate pipe manufactured to API-5L. The largest pipe size in a given pipe bending machine range requires a bending die only.

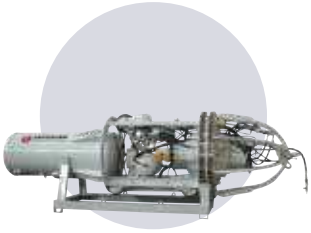
For SPB 6-20	For SPB 16-30	For SPB 22-36	For SPB 32-42	For SPB 36-48	For SPB 48-60
LBS 6/20	LBS 16/30	LBS 22/36	LBS 32/42	LBS 36/48	LBS 48/60
LBS 8/20	LBS 18/30	LBS 24/36	LBS 34/42	LBS 38/48	LBS 50/60
LBS 10/20	LBS 20/30	LBS 26/36	LBS 36/42	LBS 40/48	LBS 52/60
LBS 12/20	LBS 22/30	LBS 28/36	LBS 38/42	LBS 42/48	LBS 54/60
LBS 14/20	LBS 24/30	LBS 30/36	LBS 40/42	LBS 44/48	LBS 56/60
LBS 16/20	LBS 26/30	LBS 32/36	LBS 42/42	LBS 46/48	LBS 58/60
LBS 18/20	LBS 28/30	LBS 34/36	-	LBS 48/48	LBS 60/60
LBS 20/20	LBS 30/30	LBS 36/36	-	-	-

The first number indicates the pipe size while the second number indicates the maximum range of the bending machine where it fits. For example: an LBS 16/20 would accommodate a 16” pipe on an SPB 6-20 bender. An LBS 16/30 would also accommodate a 16” pipe but on an SPB 16-30 bender. All models are also available as bare bending sets.

Padding Machines

Pipelayers

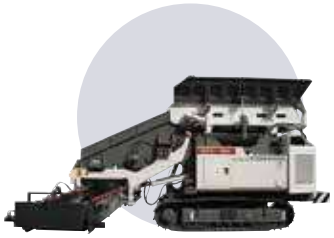
Pipe Benders



Pipeline Accessories

Crawler Carriers

Hydraulic Kits



Top-Loading Padders

Vacuum Lifts

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