KAAST

PBH

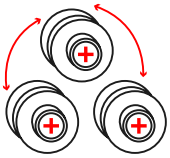
50 | 65 | 80

Angle and Ring Roller, Circular Profile Bending Machine

The PBH features a **3 roll drive** with the top roll fixed and hydraulically adjustable bottom rolls for precise forming. It can be fitted with custom rolls for bending other profiles. Suitable for **St. 37 material**.

STANDARD CONFIGURATION

- 2-Axes Digital Readout (DRO)
- Modular Hardened Bending Rolls
- Mobile Control Panel
- Mechanical Guide Rollers
- Tool Kit



OPTIONAL CONFIGURATION

- Special Dies
- Oil/Air Cooling
- Hydraulic Guide Rollers

PBH		50	65	80
		2" Shaft Ø	2.4" Shaft Ø	3.1" Shaft Ø
Upper Roll Shaft Diameter	mm	Ø50 (2")	Ø60 (2.4")	Ø80 (3.1")
Lower Roll Shaft Diameter	mm	Ø50 (2")	Ø50 (2")	Ø70 (2.75")
Upper Roll Diameter	mm	Ø152 (6")	Ø180 (7")	Ø245 (9.6")
Side Rolls Diameter	mm	Ø162 (6.3")	Ø180 (7")	Ø245 (9.6")
Main Drive Motor	kW	1.5 (2 Hp)	3 (4 Hp)	4 (5 Hp)
Bending Speed	m/min	4.5 (180"/min)	5 (200"/min)	6 (235"/min)
Dimensions (L/W/H)	mm	1000x750x1600 (39x30x63")	1200x850x1200 (47x33x47")	1500x975x1645 (59x38x65")
Weight	kg	510 (1,100 lbs)	1000 (2,200 lbs)	1700 (3,700 lbs)
Item No.		9312001	9312003	9312004
Item No. (NC Control)		9322001	9322003	9322004

PBH			50		65		80	
No	Profile Type	Unit	Dimensions	Min Bend Dia	Dimensions	Min Bend Dia	Dimensions	Min Bend Dia
1		mm	35x35 (1.4x1.4") 15x15 (0.6x0.6")	Ø600 (24") Ø300 (12")	32x32 (1.25x1.25") 12x12 (0.5x0.5")	Ø400 (16") Ø250 (10")	45x45 (1.75x1.75") 15x15 (0.6x0.6")	Ø500 (20") Ø380 (15")
2		mm	60x10 (2.4x0.4") 20x10 (0.75 x0.4")	Ø600 (24") Ø300 (12")	60x10 (2.4x0.4") 20x5 (0.75x0.2")	Ø500 (20") Ø250 (10")	80x20 (3.1x0.75") 30x10 (1.2x0.4")	Ø800 (31.5") Ø300 (12")
3		mm	80x15 (3.1x0.6") 50x10 (2x0.4")	Ø600 (24") Ø300 (12")	80x20 (3.1x0.75") 50x5 (2x0.2")	Ø500 (20") Ø250 (10")	125x25 (5x1") 60x5 (2.4x0.2")	Ø600 (24") Ø300 (12")
4		mm	UPN 80 (3.1") UPN 30 (1.2")	Ø800 (32") Ø400 (16")	UPN 80 (3.1") UPN 30 (1.2")	Ø600 (24") Ø250 (10")	UPN 120 (4.75") UPN 100 (4")	Ø900 (35.5") Ø800 (32")
5		mm	UPN 80 (3.1") UPN 30 (1.2")	Ø1200 (47") Ø600 (24")	UPN 65 (2.5") UPN 30 (1.2")	Ø600 (24") Ø250 (10")	UPN 120 (4.75") UPN 100 (4")	Ø1000 (40") Ø800 (32")
6		mm	60x7 (2.4x0.27") 30x4 (1.2x0.15")	Ø700 (27.5") Ø400 (16")	60x7 (2.4x0.27") 20x3 (0.75x0.12")	Ø500 (20") Ø250 (10")	80x9 (3.1x0.35") 30x4 (1.2x0.15")	Ø800 (32") Ø280 (11")
7		mm	60x7 (2.4x0.27") 30x4 (1.2x0.15")	Ø600 (24") Ø400 (16")	60x7 (2.4x0.27") 20x3 (0.75x0.12")	Ø500 (20") Ø250 (10")	80x9 (3.1x0.35") 25x3.5 (1x0.14")	Ø800 (32") Ø450 (18")
8		mm	60x7 (2.4x0.27") 30x4 (1.2x0.15")	Ø700 (27.5") Ø400 (16")	50x6 (2x0.25") 20x3 (0.75x0.12")	Ø500 (20") Ø250 (10")	70x8 (2.75x0.3") 25x3.5 (1x0.14")	Ø800 (32") Ø280 (11")
Special Design Bending Rolls								
9		mm	50x3 (2x0.12") 20x2 (0.75x0.08")	Ø1600 (63") Ø400 (16")	45x3 (1.75x0.12") 20x2 (0.75x0.08")	Ø600 (24") Ø300 (12")	70x3 (2.75x0.1") 25x2 (1x0.08")	Ø1300 (51") Ø350 (14")
10		mm	70x30x3 (2.75x1.2x0.12") 30x15x2 (1.2x0.6x0.08")	Ø1500 (60") Ø400 (16")	50x25x3 (2x1x0.12") 20x15x2 (0.75x0.6x0.08")	Ø450 (18") Ø250 (10")	80x25x3 (3.1x1x0.1") 25x15x2 (1x1x0.08")	Ø800 (32") Ø350 (14")
11		mm	Ø35 (1.4") Ø20 (0.75")	Ø600 (24") Ø300 (12")	Ø35 (1.4") Ø10 (0.4")	Ø350 (14") Ø250 (10")	Ø50 (2") Ø15 (0.6")	Ø500 (20") Ø380 (14")
12		mm	Ø70x2 (2.75x0.08") Ø25x1.5 (1x0.06")	Ø1200 (48") Ø400 (16")	Ø60x2 (2.4x0.08") Ø15x1.5 (0.6x0.06")	Ø600 (24") Ø200 (8")	Ø100x2.5 (4x0.1") Ø15x1 (0.6x0.04")	Ø1200 (48") Ø380 (14")
13		mm	Ø51x2.9 (2x0.11") Ø12.7x2.3 (0.5x0.09")	Ø1000 (40") Ø300 (12")	Ø51x3.9 (2x0.15") Ø12.7x2.77 (0.5x0.1")	Ø400 (16") Ø200 (8")	Ø76x5.5 (3x0.22") Ø12.7x2.77 (0.5x0.1")	Ø800 (32") Ø380 (14")
14		mm	50x50x6 (2x2x0.25") 30x30x3 (1.2x1.2x0.12")	Ø600 (24") Ø400 (16")	60x60x6 (2.4x2.4x0.24") 30x30x4 (1.2x1.2x0.12)	Ø650 (26") Ø350 (14")	80x80x8 (3x3x0.3") 30x30x3 (1.2x1.2x0.12")	Ø800 (32") Ø400 (16")
15		mm	50x50x6 (2x2x0.25") 30x30x3 (1.2x1.2x0.12")	Ø900 (36") Ø600 (24")	50x50x5 (2x2x0.2") 30x30x4 (1.2x1.2x0.12")	Ø550 (22") Ø350 (14")	70x70x7 (2.75x2.75x0.27") 30x30x3 (1.2x1.2x0.12")	Ø700 (28") Ø450 (18")
16		mm	–		IPN 80 (3.1")	Ø600 (24")	IPN 120 (4.75") IPN 80 (3.1")	Ø600 (24") Ø400 (16")

*The above specifications are subject to change without prior notice. No liability for printing mistakes. Machine may be shown with optional equipment.