

# HYDRAULIC PROFILE ROLLS



## PBH 60

### Shaft Diameters:

Top .....2.364" (60mm)

Planetary (2).....2.364" (60mm)

Roll Diameters.....7"

Motor Power .....3 + 2 HP

Turning Speed.....0 - 17 FPM

Dimensions .....46" L x 39" W x 46" H

Weight .....2627 lbs.

### STANDARD SPECIFICATIONS:

- 1 set of standard universal hardened and ground rolls (special steel)
- All three rolls (shafts) are driven through precision gear box
- 3-axis hardened side supports (lateral guide rolls) with mechanical forward-backward (Thrust➡), up-down (Translation⬆) and right-left (Radial↻) movement
- Side supports will accommodate leg-in/leg-out angle iron bending

- Portable control panel with programmable DROs
- Vertical or horizontal operation
- Body constructed of stress-relieved steel
- Hydraulic/electrical overload protection
- Bottom roll shafts hydraulically adjusted
- World standard electrical/hydraulic components (parts stocked by us or available off-the-shelf from your local supplier)
- Compliant with CE norms regulations

### OPTIONS:

- Special rolls for tubes, profiles, etc.
- Rolls and tooling for hardway beam/channel bending
- Fully hydraulic side supports (per axis)
- Digital readout for side supports
- NC control system – with or without axis
- CNC control system
- Remote (wired or wireless)
- Adjustable turning speed
- Tie Bar for rolls
- Spiral bending apparatus



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**DURMA PBH 60**




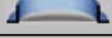


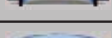
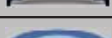
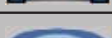







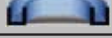

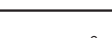
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| Profile Type    |                       | PBH 125                                                                             |                        | PBH 100               |                        | PBH 80                    |                         | PBH 60     |                                                                                        | Notes |    |
|-----------------|-----------------------|-------------------------------------------------------------------------------------|------------------------|-----------------------|------------------------|---------------------------|-------------------------|------------|----------------------------------------------------------------------------------------|-------|----|
|                 |                       | Dimensions                                                                          | Min. Internal Diameter | Dimensions            | Min. Internal Diameter | Dimensions                | Min. Internal Diameter  | Dimensions | Min. Internal Diameter                                                                 |       |    |
| 1               | Solid - Square        |    | 3" x 3"                | 36"                   | 2-1/4" x 2-1/4"        | 24"                       | 2" x 2"                 | 24"        | 1-1/2" x 1-1/2"                                                                        | 20"   | ○  |
| 2               | Flat-Along Edge       |    | 5" x 1"                | 40"                   | 4" x 1"                | 32"                       | 3-1/8" x 3/4"           | 32"        | 2-3/4" x 3/8"                                                                          | 24"   | ○  |
| 3               | Solid - Rectangle     |    | 10" x 1-1/4"           | 52"                   | 7" x 1-3/8"            | 26"                       | 5" x 1"                 | 26"        | 3-1/2" x 1"                                                                            | 20"   | ○  |
| 4               | Angle Leg-Out         |    | 5" x 1/2"              | 42"                   | 4" x 1/2"              | 42"                       | 3" x 3/8"               | 37"        | 2-1/2" x 3/16"                                                                         | 32"   | ○  |
| 5               | Angle Leg-In          |    | 5" x 1/2"              | 48"                   | 4" x 1/2"              | 42"                       | 3" x 3/8"               | 37"        | 2-1/2" x 3/16"                                                                         | 28"   | ○  |
| 6               | T Section Leg-Down    |    | 5" x 1/2"              | 60"                   | 4" x 1/2"              | 65"                       | 3" x 3/8"               | 40"        | 2-1/2" x 3/16"                                                                         | 36"   | ○  |
| 7               | T Section Leg-Out     |    | 5" x 5" x 1/2"         | 48"                   | 4" x 4" x 1/2"         | 45"                       | 3" x 3" x 3/8"          | 36"        | 2-1/2" x 2-1/2" x 1/4"                                                                 | 24"   | ○  |
| 8               | T Section Leg-In      |    | 4" x 4-1/2"            | 52"                   | 4" x 4" x 3/8"         | 52"                       | 3" x 3" x 3/8"          | 44"        | 2-1/2" x 2-1/2" x 1/4"                                                                 | 32"   | ○  |
| 9               | Tubing - Square       |    | 4" x 4" x 1/4"         | ∞                     | 3" x 3" x 1/4"         | ∞                         | 2-3/4" x 2-3/4" x 5/32" | ∞          | 2" x 2" x 0.120"                                                                       | ∞     | ○● |
| 10              | Tubing - Rectangle    |   | 5-1/2" x 2" x 3/16"    | ∞                     | 4" x 2-1/4" x 5/32"    | ∞                         | 3" x 1-1/2" x 5/32"     | ∞          | 2-1/2" x 1-1/2" x 1/8"                                                                 | ∞     | ○● |
| 11              | Solid - Round         |  | Ø3-1/4"                | 42"                   | Ø2-3/4"                | 32"                       | Ø2"                     | 24"        | Ø1-1/2"                                                                                | 20"   | ○● |
| 12              | Schedule 40 Pipe      |  | 5" SCH 40              | 68"                   | 4" SCH 40              | 48"                       | 3" SCH 40               | 40"        | 2" SCH 40                                                                              | 24"   | ●  |
| 13              | Tubing - Round        |  | Ø5-1/2" x 0.129"       | 59"                   | Ø4-3/4" x 0.099"       | 55"                       | Ø4" x 0.099"            | 51"        | Ø2.36" x 0.080"                                                                        | 24"   | ●  |
| 14              | C Section Leg-Out     |  | C8 x 22#               | 48"                   | C7 x 14#               | 40"                       | C6 x 13#                | 28"        | C5 x 9#                                                                                | 28"   | ○● |
| 15              | C Section Leg-In      |  | C8 x 22#               | 48"                   | C7 x 14#               | 40"                       | C6 x 13#                | 36"        | C5 x 9#                                                                                | 32"   | ○● |
| 16              | I Section Leg-In/Out  |  | W8 x 21#               | 44"                   | S7 x 203               | 42"                       | S6 x 17#                | 28"        | 2-1/4"                                                                                 | 28"   | ●  |
| 17              | I Section Leg-In/Out  |  | W6 x 20#               | 44"                   | W6 x 16#               | 36"                       | W4 x 13#                | 55"        | Note: Machine will roll 3" x 3" x 1/4" angle with larger rolls to a greater dimension. |       | ●  |
| 18              | C Section Leg-Up      |  | W5 x 19#               | 36"                   | W3                     | 24"                       | 3" x 1-3/4"             | 158"       |                                                                                        |       | ▲○ |
| 19              | I Section Leg-Up/Down |  | C5 x 9#                | 320"                  | C5 x 6#                | 210"                      |                         |            |                                                                                        |       | ▲○ |
| Section Modules |                       | 3 - 5 In <sup>3</sup>                                                               |                        | 2 - 4 In <sup>3</sup> |                        | 1.3 - 1.9 In <sup>3</sup> |                         |            |                                                                                        |       |    |

Capacity based on mild steel | ∞ Can be changed according to deformation | ○ Standard Rolls | ● Special Rolls | X Special Support Rolls | ▲ Special Tools



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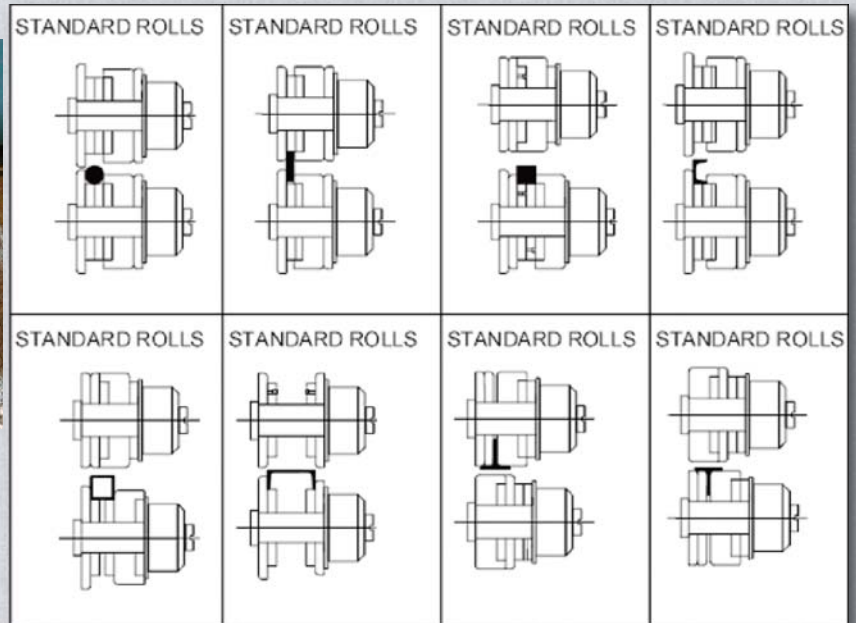
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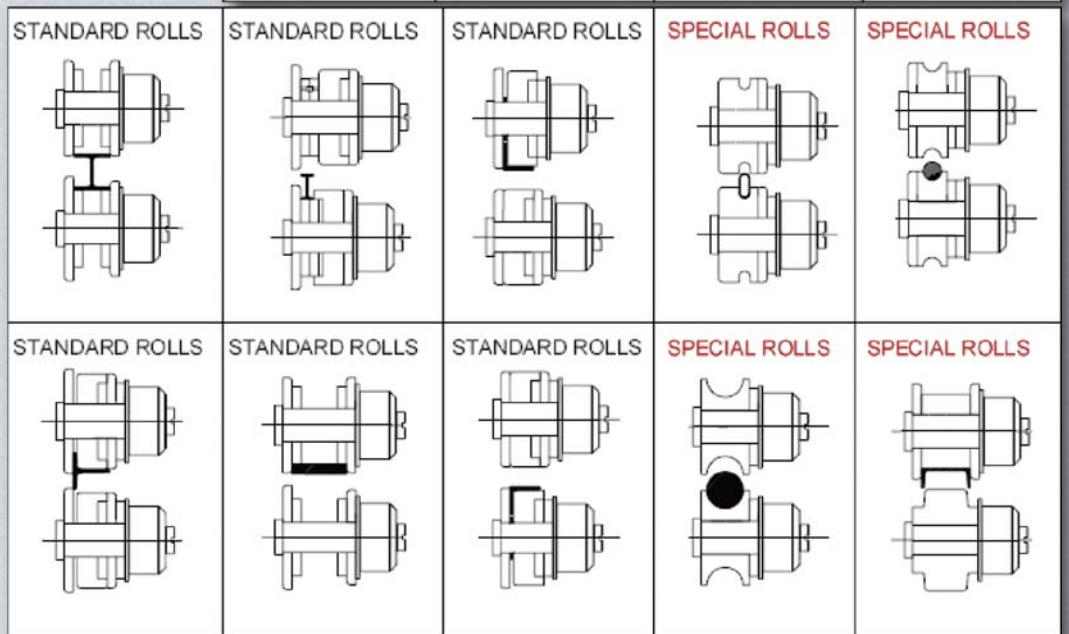


## Standard Universal Rolls / Tooling



for Models:

- PBH 60
- PBH 80
- PBH 100
- PBH 125
- PBH 180
- PBH 240
- PBH 300
- PBH 360



Many More **Special Rolls** Are Available



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