

# DURMA

## Profile Rolls





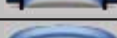













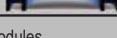
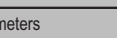



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# HYDRAULIC PROFILE ROLLS

Profile Type		PBH 360		PBH 300		PBH 240		PBH 180		Notes	
		Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.		
1	Solid - Square		10" x 10"	104"	6" x 6"	85"	4-3/8" x 4-3/8"	62"	3-1/2" x 3-1/2"	45"	○
2	Flat-Along Edge		12" x 3-1/2"	80"	10" x 2-1/2"	80"	7" x 1 1/2"	47"	6" x 1"	39"	○
3	Solid - Rectangle		25" x 4"	80"	20" x 3"	80"	14" x 2"	38"	10" x 2"	40"	○
4	T Section Leg-Down		8" x 1"	52"	8" x 1"	72"	6" x 3/4"	87"	6" x 5/8"	58"	○
5	T Section Leg-Out		8" x 1"	52"	8" x 1"	72"	6" x 3/4"	94"	6" x 5/8"	56"	○
6	T Section Leg-In		8" x 1"	60"	8" x 1"	105"	6" x 3/4"	115"	6" x 5/8"	67"	○
7	Angle Leg-Out		8" x 8" x 1-1/4"	64"	8" x 8" x 1-1/8"	90"	6" x 6" x 3/4" (1")	63" (105")	6" x 6" x 5/8"	85"	○
8	Angle Leg-In		8" x 8" x 1-1/4"	70"	8" x 8" x 1"	110"	6" x 6" x 3/4" (1")	70" (135")	5" x 5" x 3/4"	85"	○
9	Tubing - Square		16" x 16" x 5/8"	∞	8" x 8" x 3/8"	∞	6" x 6" x 3/8"	∞	5" x 5" x 5/16"	∞	○●
10	Tubing - Rectangle		18" x 8" x 3/8"	∞	8" x 6" x 3/8"	∞	8" x 3" x 5/16"	∞	7" x 2-3/4" x 5/16"	∞	○●
11	Solid - Round		10-1/2"	80"	7"	85"	5"	50"	4"	39"	○●
12	Schedule 40 Pipe		20" SCH 40	598"	12" SCH 40	160"	8" SCH 40	102"	6" SCH 40	70"	●
13	C Section Leg-Out		MC18 x 58#	62"	MC18 x 58#	44"	C15 x 50#	58"	C12 x 30#	48"	○●
14	C Section Leg-In		MC18 x 58#	62"	MC18 x 58#	44"	C15 x 50#	64"	C12 x 30#	52"	○●
15	I Section Leg-In/Out		W36 x 210#	198"	W21 x 93#	86"	W14 x 38#	62"	W12 x 35#	46"	○●
16	I Section Leg-In/Out		W31 x 241#	198"	W12 x 65#	82"	W12 x 50#	62"	W8 x 31#	45"	○●
17	I Section Leg-In/Out		W30 x 211#	145"	W4	36"	W10 x 45#	62"	W6 x 25#	30"	○●
18	C Section Leg-Up		MC18 x 58#	690"	MC12 x 50#	365"	C8 x 18.75#	420"	C7 x 12.25#	345"	▲X
19	I Section Leg-Up/Down		W24 x 118#	1810"	W12 x 35#	512"	W8 x 21#	205"	W6 x 16#	124"	▲X
20	I Section Leg-Up/Down		W16 x 100#	1290"	W10 x 39#	410"	W6 x 25"	152"	W5 x 19#	98"	▲X
21	I Section Leg-Up/Down		W14 x 176#	1100"	W4	84"	W4	82"	W3	42"	▲X
Section Modules		80-290 In <sup>3</sup>		24-45 In <sup>3</sup>		11-20 In <sup>3</sup>		6-10 In <sup>3</sup>			
Shaft Diameters		Ø 14.2", 14.2", 14.2"		Ø 11", 11", 11.8"		Ø 8.7", 8.7", 9.5"		Ø 6.3", 6.3", 7.1"			
Roll Diameters		Ø 32"		Ø 29"		Ø 22"		Ø 18"			
Motor Power		95 HP		85 HP		40 HP		25 HP			
Turning Speed		0-23 Feet/Min.		0-23 Feet/Min.		0-23 Feet/Min.		0-23 Feet/Min.			
Dimensions		225" L x 200" W x 130" H		126" L x 165" W x 100" H		91" L x 78" W x 126" H		95" L x 79" W x 63" H			
Weight		104,000 Lbs.		52,800 Lbs.		35,200 Lbs.		22,000 Lbs.			

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



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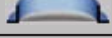


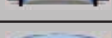
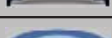
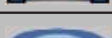







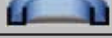

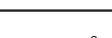
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**PBH 180, 240, 300, 360**

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# HYDRAULIC PROFILE ROLLS

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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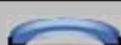

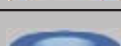
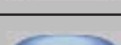




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**DURMA PBH 125**

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# PROFILE ROLLS

Profile Type			PBH 45		PBM 50		PBM 30		Notes		
			Dimensions	Min. Internal Diameter	Dimensions	Min. Internal Diameter	Dimensions	Min. Internal Diameter			
1	Solid - Square		1-3/8" x 1-3/8"	20"	1-3/8" x 1-3/8"	49"	1-1/4" x 1-1/4"	26"	○		
					3/4"	16"					
2	Flat-Along Edge		2" x 3/4"	18"	2 1/2" x 3/8"	32"	2" x 3/8"	20"	○		
					2" x 1/2"	32"					
3	Solid - Rectangle		2" x 3/4"	18"	3" x 3/4"	30"	3" x 3/8"	14"	○		
4	Angle Leg-Out		2" x 2" x 1/4"	25"	2" x 2" x 3/16"	38"	1-1/2" x 1-1/2" 3/16"	16"	○		
5	Angle Leg-In		2" x 2" x 1/4"	30"	2" x 2" x 3/16"	40"	1-1/2" x 1-1/2" 3/16"	16"	○X		
6	T Section Leg-Down		2" x 2" x 1/4"	24"	2-3/8" x 2-3/8" x 1/4"	30"	1-1/2" x 1-1/2" x 1/4"	25"	○		
7	T Section Leg-Out		2" x 2" x 1/4"	24"	2" x 2" x 3/16"	28"	2" x 2" x 1/4"	24"	○		
8	T Section Leg-In		2" x 2" x 1/4"	24"	2" x 2" x 3/16"	38"	2" x 2" x 1/4"	36"	○		
9	Tubing - Square		1-3/4" x 1-3/4" x 10 Ga.	∞	2" x 2" x 0.120"	∞	1-1/2" x 1-1/2" x 0.120"	∞	○●		
10	Tubing - Rectangle		2" x 1-3/16" x 12 Ga.	∞	2" x 1-1/2" x 0.120"	∞	2" x 1" x 0.120"	∞	○●		
11	Solid - Round		1-3/8"	20"	Ø1-3/8"	32"	Ø1-1/8"	24"	○●		
12	Schedule 40 Pipe		1-1/2" SCH 40	20"	1" SCH 40	13"	1" SCH 40	18"	●		
					2" SCH 40	40"	1-1/2" SCH 40	26"		1-1/2" SCH 40	36"
					2" SCH 40	48"	2" SCH 40	48"		2" SCH 40	48"
13	Tubing - Round		Ø1.18" x 0.079"	18"	Ø1.18" x 0.079"	20"	Ø3/4" x 0.06"	∞	●		
					Ø2-1/2" x 0.120"	40"	Ø2-3/4" x 0.120"	48"		Ø2-3/8" x 1/16"	∞
14	C Section Leg-Out		2" x 2" x 1/4"	24"	2-3/8" x 1-1/16" x 1/4"	24"	2"	20"	○●		
15	C Section Leg-In		2" x 2" x 1/4"	29"	2-3/8" x 1-1/16" x 1/4"	32"	2"	32"	○●		

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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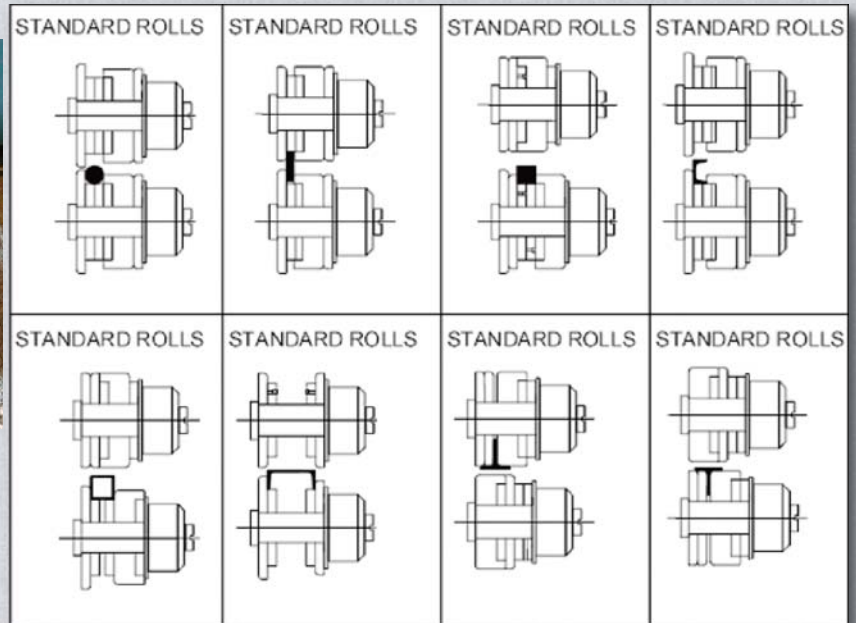
**PBH 45, PBM 30, PBM 50**

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# HYDRAULIC PROFILE ROLLS

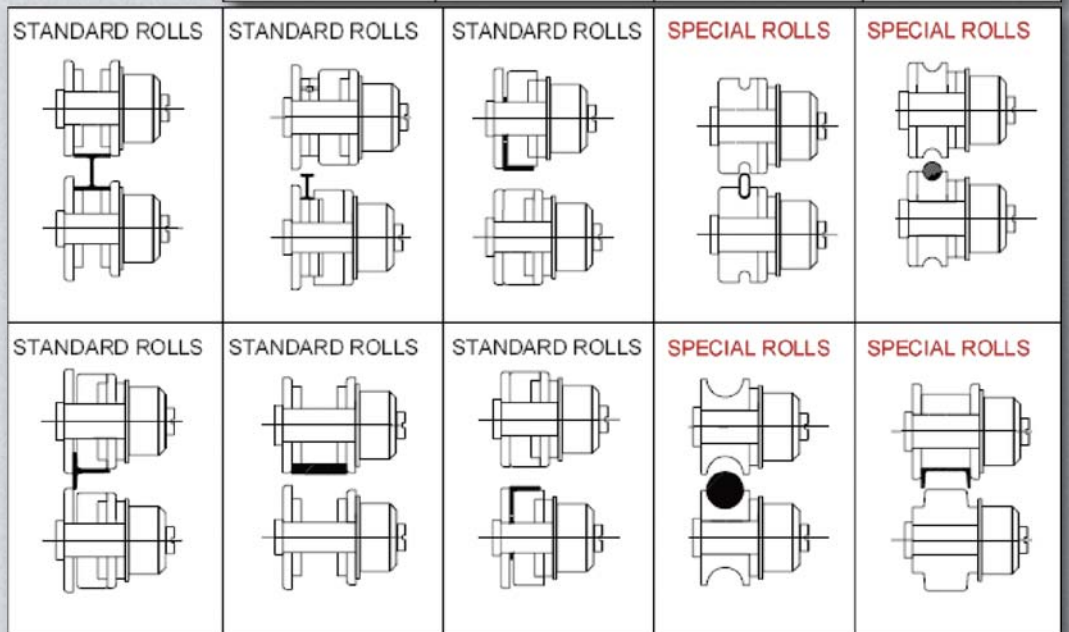


## Standard Universal Rolls / Tooling



for Models:

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



Many More **Special Rolls** Are Available

# HYDRAULIC PROFILE ROLLS

## PBH 360, PBH 300, PBH 240, PBH 180

### STANDARD SPECIFICATIONS:

- 1 set of standard universal hardened and ground rolls (special steel)
- On the PBH 180 & 240: Bottom and top rolls have two separate planetary gear boxes and are hydramotor driven
- On the PBH 300 & 360: All rolls have separate planetary gear boxes and are hydramotor driven
- Hydraulic control of lateral guide rolls in 3 axes (Thrust → / Translation ↑ / Radial ↻) – 6 axes total
- Adjustable turning speed
- Portable control panel with programmable DROs
- 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 are available off-the-shelf from your local supplier)
- Compliant with CE norms regulations

### OPTIONS:

- Special rolls for pipe and profiles
- Rolls and tooling for hardway beam/channel bending
- Digital readout for side supports
- NC control system – with or without axis
- CNC control system
- Remote (wired or wireless)
- Anti-deformation apparatus for U-I-H bending
- Spiral bending apparatus
- Custom machines available



# HYDRAULIC PROFILE ROLLS



## PBH 125

### Shaft Diameters:

Top .....5.5"

Planetary (2) .....4.7"

Roll Diameters .....15"

Motor Power .....20 HP

Turning Speed .....0 - 29 FPM

Dimensions .....73" L x 61" W x 66" H

Weight .....10,120 lbs.

### STANDARD SPECIFICATIONS:

- 1 set of universal standard hardened and ground rolls (special steel)
- All three rolls (shafts) are hydramotor driven through planetary gear box
- Hydraulic control of lateral guide rolls in 3 axes (Thrust → / Translation ↑ / Radial ↻)
- Side supports will accommodate leg-in/leg-out angle iron
- 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 pipe, profiles, bar/angles, etc.
- Rolls and tooling for hardway beam/channel bending
- Adjustable turning speed
- Digital readout for side supports
- NC control system – with or without axis
- CNC control system
- Remote (wired or wireless)
- Special apparatus to prevent deformation on U-I-H bending
- Spiral bending apparatus



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# HYDRAULIC PROFILE ROLLS



Shown with  
Options

## PBH 100

### Shaft Diameters:

Top .....4.33" (110mm)

Planetary (2) .....3.94" (100mm)

Roll Diameters .....12.4"

Motor Power .....15 HP

Turning Speed .....0 - 26 FPM

Dimensions .....69" L x 53" W x 65" H

Weight .....7392 lbs.

### STANDARD SPECIFICATIONS:

- 1 set of standard universal hardened and ground rolls (special steel)
- All three rolls (shafts) are hydramotor driven through planetary gear box
- 3-axis hardened side supports (lateral guide rolls) with hydraulic forward-backward movement (Thrust →) and mechanical up-down and right-left 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
- Adjustable turning speed
- Hydraulic control of lateral guide rolls in additional 2 axes (Translation ↕ / Radial ↻)
- Digital readout for side supports
- NC control system – with or without axis
- CNC control system
- Remote (wired or wireless)
- Special apparatus to prevent deformation on U-I-H bending
- Spiral bending apparatus



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# HYDRAULIC PROFILE ROLLS



## PBH 80

### Shaft Diameters:

Top .....3.349" (85mm)

Planetary (2).....3.152" (80mm)

Roll Diameters .....9.7"

Motor Power .....10 HP

Turning Speed .....0 - 23 FPM

Dimensions .....62" L x 47" W x 56" H

Weight .....5170 lbs.

### STANDARD SPECIFICATIONS:

- 1 set of standard universal hardened and ground rolls (special steel)
- All three rolls (shafts) are hydramotor driven through planetary 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
- Adjustable turning speed
- NC control system – with or without axis
- CNC control system
- Remote (wired or wireless)
- Tie Bar for rolls
- Spiral bending apparatus



# 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



JORGENSEN MACHINE TOOLS

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**DURMA PBH 60**

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# PROFILE ROLLS

## PBH 45 Hydraulic Profile Rolls

Shaft Diameters .....	1.8"
Roll Diameters.....	6.4"
Motor Power .....	2 + 2 HP
Turning Speed .....	0 - 13 FPM
Dimensions .....	39"L x 28"W x 54"H
Weight .....	1320 lbs.

### STANDARD SPECIFICATIONS:

- Steel construction
- Standard universal rolls
- Hardened rolls
- Three roll driven
- Mechanical lateral guide rolls
- Digital read out for both lower rolls
- Horizontal and vertical operation
- Portable control panel
- Compliant with CE norms regulations

### OPTIONS:

- Special rolls for tubes, profiles, cap rail, etc.
- Special support rolls for angle iron leg/in
- NC Control System
- CNC Control System
- Remote (wired or wireless)



**PBH 45**

## PBM 50 Mechanical Profile Rolls

Shaft Diameters .....	2"
Roll Diameters .....	6.1"
Motor Power .....	2 HP
Turning Speed .....	0 - 12 FPM
Dimensions .....	37" L x 29" W x 56" H
Weight .....	957 lbs.

## PBM 30 Mechanical Profile Rolls

Shaft Diameters .....	1.2"
Roll Diameters .....	5"
Motor Power .....	0.75 - 1 HP
Turning Speed .....	0-12 FPM
Dimensions.....	32" L x 28" W x 47" H
Weight .....	471 lbs.

### PBM 30 & 50 STANDARD SPECIFICATIONS:

- Standard universal rolls
- Hardened rolls
- Mechanical lateral guide rolls
- Horizontal and vertical operation
- Foot pedal with safety device
- Compliant with CE norms regulations

### PBM 30 & 50 OPTIONS:

- Special rolls for tubes, profiles, cap rail, etc.
- Special support rolls for angles
- Special bar twist device
- Digital read out
- Remote (wired or wireless)
- Double speed motor – 6-12 FPM (PBM 30 only)



**PBM 50**



**PBM 30**



**Horizontal Operation**