



**Transfluid Mandrel Bending  
Machine  
Model "2060K"**

<b>DB 2060K</b>	<b>Mandrel bending machine</b>	<b>\$48,412.00 Plus Options</b>
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**Capacity:**

- Mild steel tubing from 1/4" – 3", maximum wall thickness 0.109"
- Stainless steel tubing from 1/4" – 3", maximum wall thickness 0.065"
- Mild steel pipe SCH 80 from 1/8" – 2"
- Mild steel square tubing from 1/4" – 2", maximum wall thickness 0.138"
- Rectangular tubing easy way up to 1" x 2 1/2" x 0.137"
- Rectangular tubing hard way up to 2 1/2" x 1" x 0.137"
- Solid bar up to 1 3/4"
- Maximum moment of resistance 1.04 in<sup>3</sup> (17 cm<sup>3</sup>)
- Bending angle up to 180°
- Bending time 90°: 8 seconds

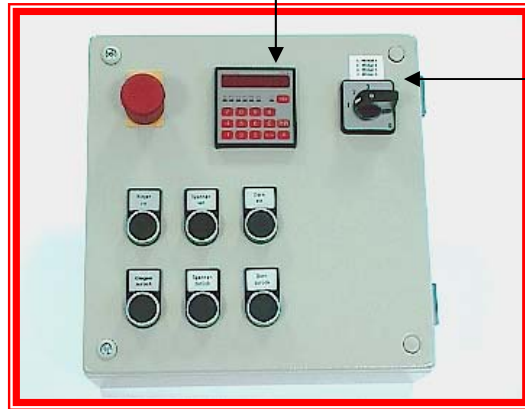
**Machine Equipment/Basic Accessories:**

- Load length 10' (**Extensions available**)
- Max Centerline radius 6" (**Ext. Avail**)
- Min centerline radius 1.5XD
- Bending height 41"
- Hydraulic powered bend head
- Length of pressure die to center of bending Shaft 13"
- Clockwise bending direction standard (CCW Option)
- Removable shaft for small diameter bend radius
- Hydraulic opening/closing of pressure die
- Rockwell 56 hardened bend tools with nylon pressure die
- Hydraulic tube clamping
- Standard hydraulic cylinder
- Hydraulic components Mannesmann Rexroth
- Machine mobile, on wheels
- Wipe Die Holder for all sizes
- Manual Mandrel Lube
- Programmable Mandrel Withdraw

**Machine Data:**

- Nominal pressure 3600 psi (250 bar)
- Operating pressure 2900 psi (200 bar)
- Digital bend angle readout via encoder
- Power requirements: 220 or 440 volt (Please specify when ordering.)
- Length 138" / 11'6"
- Width 36"
- Height 51"
- Weight approx. 2200 lbs.
- Color RAL 3000 red, 7037 grey

Data Input Key Pad



Bend Angle Selection Switch

DB 2060K-8W-D

8W-D Control

8 Angle digital control

Included

**Control:**

- Quick selection of 8 preset bend angles with angle selection switch
- Entry of preset angles via digital keyboard
- Manual mode utilizes each function button. (Optional Item AA01)
- Input of bend angle in 0.1° increments
- Digital display of actual or nominal bend angle

Mandrel Extractor

8-WD Digital Control

VWE Plane of Bend Option

1" plate steel box  
frame construction



Quick Change Tooling

## Optional & Standard Equipment DB 2060/76K



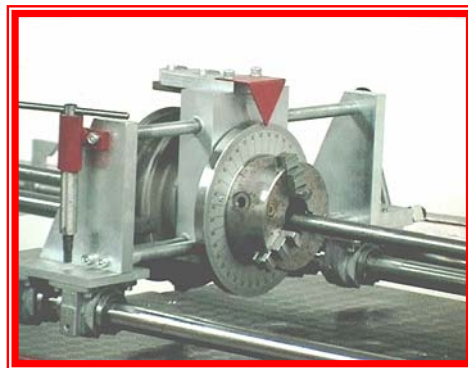
**SPS control panel**

<b>SPS Control</b>	<b>Optional PLC Control with storage function</b>	<b>\$6,100.00</b>
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- PLC control 500parts / 20 bends per part
- Automatic sequencing of bending angle and position
- Part Counter
- Digital lighted display
- Simple data entry

<b>AA 001</b>	<b>Automatic Operation Sequence</b>	<b>Included when ordering SPS control</b>
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- Manual or semi automatic sequence of operation selected by keyed switch.
- Manual operation initiated by push button on control. Each function; clamping, mandrel position, ending and return initiated by pressing respective button (for proto type and sample production)
- Semi automatic mode initiated by push button on control and cycles as follows: clamp & pressure die closes, bending head rotates to programmed angle, mandrel retracts, clamp opens, bending head and mandrel returns to start position.



**Chuck Clamp VWE H-2060K**

<b>VWE 2060-30</b>	<b>Plane of bend device</b>	<b>\$3,985.00</b>
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- Supports tube, maintains position, and indicates plane with 4 adjustable stops
- Manual clamping via 3 jaw chuck
- For manual positioning of tubes up to 3"
- Includes length stop device with scale and 4 adjustable stops
- Gauges from 10' down to 15" from front tangent of bend die

**DR 001**

**Programmable mandrel withdrawal during bending**

**included**

- Improves bend quality by reducing distortion caused by mandrel
- Retracts mandrel prior to completion of bend
- Variable adjustment form 0-20°
- Automatic mandrel return



**DSA-H**

**Manual Mandrel lubrication**

**included**

- Hand pump Lubricator mounted near operator control
- Attaches to mandrel rod via quick disconnect



**Sample Tooling Prices (other OD and CLR sizes available):**

Tooling for 1.75" Ø x .065 wall 1.5 X D 2.625" CLR	\$ 3,229.00
Tooling for 2" Ø x .065 wall 1.5 X D 3" CLR	\$ 3,460.00
Tooling for 2-1/4" Ø x .065 wall 1.5 X D 3.5" CLR	\$ 3,612.00
Tooling for 2-1/2" Ø x .065 wall 1.5 X D 3.75" CLR	\$ 3,948.00
Tooling for 3" Ø x .065 wall 1.5 X D 4.5" CLR	\$ 4,655.00

Mandrel lubrication Part # 0-AF-99 <b>1qt</b>	\$ 14.99 /each
Mandrel lubrication Part # 0-AF-100 <b>5 Gallons</b>	\$ 232.00

All tools are made with 1.6xD clamp lengths (serrated) which will result in marking of the material in clamping area. All other tools made with 2.5xD clamp lengths (straight) unless specified otherwise.

Mandrels can be produced in Chrome or Ampco Bronze for no additional charge. Please specify material type and finish required for your application.

Initial machine & tool orders include mandrel rods.

**Note:** Tool prices are subject to change based on application, please consult Van Sant Enterprises, Inc. about your specific requirements.

**Terms & Conditions:**

**Payment Terms:** 30% Down, 70% Prior to Ship

**Delivery:** Normally in stock, otherwise 8-10 weeks from receipt of deposit and sales order confirmation, pending swift US Customs clearance. The proposed shipment date is an estimate and could be affected by circumstances beyond the control of Van Sant Enterprises, Inc.. Under no circumstances shall Van Sant Enterprises, Inc. have any liability whatsoever for the loss of use or any direct or consequential damages resulting from delay.

**Freight:** FOB Kingston NH

**Twelve-month warranty on parts.** Manufacturer warrants the products to be free from defects in material and workmanship for twelve months from the date of shipment to the original purchaser only. The credit for replacement parts under warranty is subject to inspection of the defective part after the customer returns it. All consumables and parts subject to normal wear are not covered under this warranty. All warranty defects must be documented and sent to our technical department indicating the nature of the fault and all other related information required to rectify problem.

**NOTE:** All tooling is considered wear items which not covered under machine warranty.

**Sample Tubes:** Customer must supply sample material required for final adjustment of machine and tooling, quantities to be determined. Freight charges are the responsibility of customer.

**Training & Setup: Additional**

Machine must be placed in position and main power connected prior to setup and training at customer site. Customer will be billed \$65/hour for travel plus related expenses (may include hotel, airfare, rental car, etc.). On site labor will be billed at \$95/hour; overtime rates apply.

**Taxes:**

Prices do not include taxes. If any sales, use or similar tax is payable to Van Sant Enterprises, Inc. in connection with any transaction or part thereof between the Purchaser and Van Sant Enterprises, Inc. with respect to goods delivered, the Purchaser will, upon demand, pay to Van Sant Enterprises, Inc. the amount of any such tax unless the Purchaser provides Seller with a valid tax exemption certificate.

Please be advised this quote is valid 60 days from above date.

We thank you for this opportunity to offer our equipment and look forward to serving you in the future.

Sincerely,

Van Sant Enterprises, Inc.  
1-877-VAN-SANT  
alan@vansantent.com