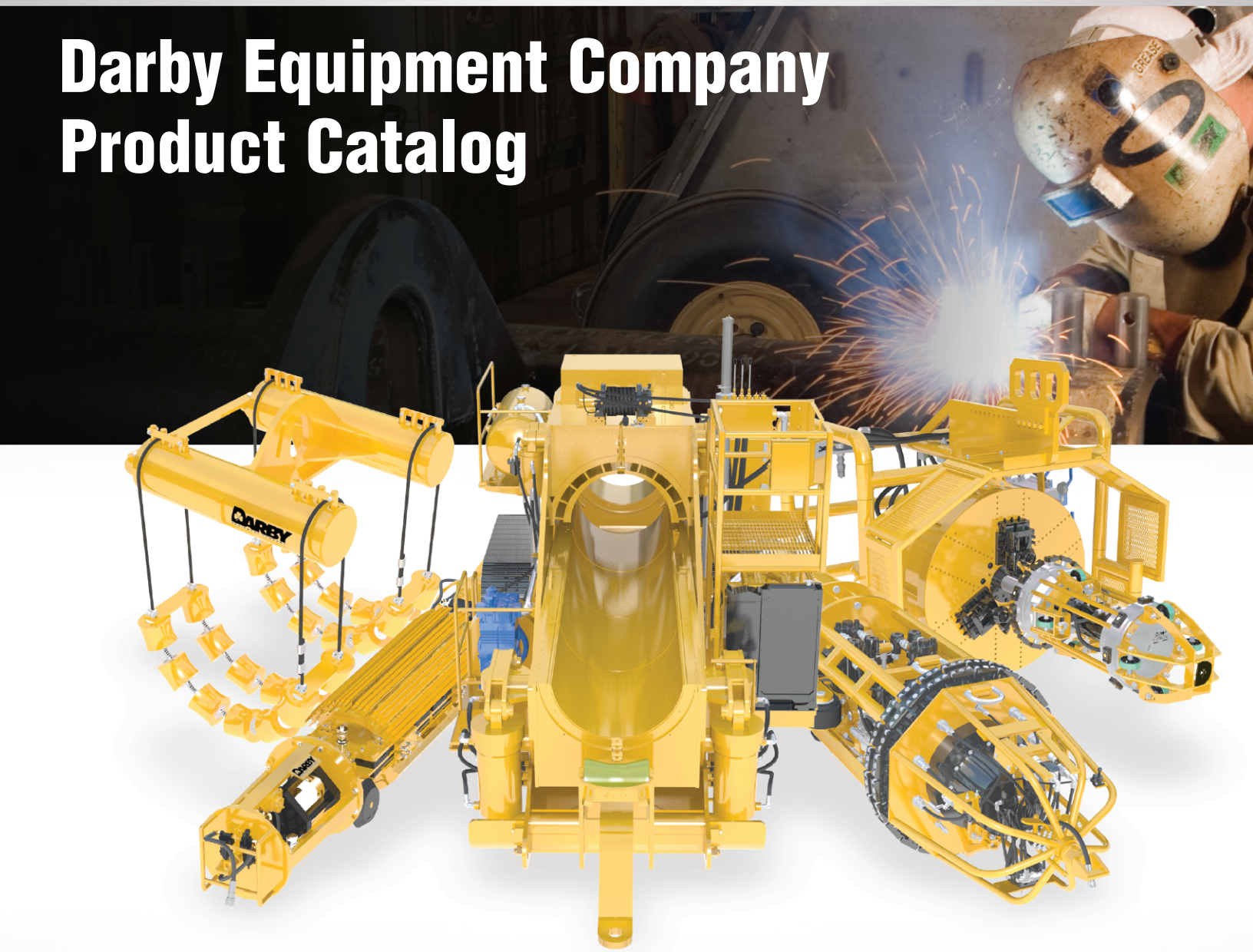
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Darby Equipment Company Product Catalog



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Pipe Bending Machines • Pipe Bending Mandrels • Line-Up Clamps • Roller Cradles
Pipe Facing Machines • Pipeline Supplies

Darby 6–20" Pipe Bending Package

Darby 6-20" Pipe Bending Machine (HPB6-20)



Features/Advantages:

- The HPB6-20 has a 17 gal (64 L) fuel tank and 35 gal (132.5 L) hydraulic tank with 29 GPM (110 LPM) fill capacity. The large hydraulic tank helps keep the oil cooler, extending the life of the hydraulic system.
- Parker four-section hydraulic control valve provides bending and winch operation. Hydraulic mandrel operation is a standard feature on all Darby bending machines.
- Machine side plates are reinforced with stiffeners for optimal frame life. Side plates are 5/8" (15.9 mm) T1 steel and die nest plates are 1" (25.4 mm) T1 steel. All welds are preheated, heat controlled and made “in position.”
- Frame cross tubes supporting the hydraulic cylinders have 3/8" (9.5 mm) wall thickness.
- Parker Seal Lok™ hydraulic system prevents leaks and has a working pressure rating of 3,000 psi (206.8 bar).
- Murphy control panel includes electric start, throttle control, oil pressure, tachometer and hour meter.
- Hydraulic cylinders can be disassembled without cutting for ease of repair.
- Pinup is fully reinforced to prevent spreading.
- 325 Quincy air compressor is hydraulically driven by its own circuit.
- 10-micron hydraulic return linekeeps oil clean to extend the life of the system.
- Oil cooler in compressor drive circuit keeps the circuit cooled. It continuously circulates, even when the compressor is not running. This extends the life of the hydraulic system.

Performance:

- Maximum bending force at front of stiffback is 207,000 lbs (93,893 kg).
- Air compressor provides 240 psi (16.5 bar) mandrel operation.
- With engine running at 2,350 rpm, hydraulic vane pump produces 29 GPM (110 LPM) @ operating pressure.

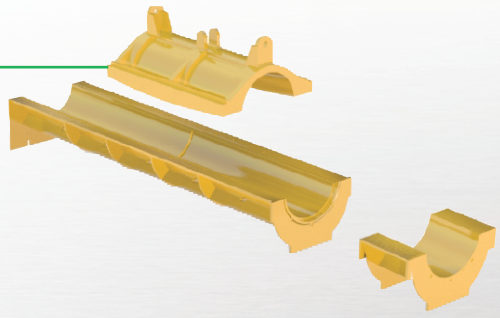
Options:

- Dual tires for added stability
- Tracks for reduced ground pressure
- Air-cooled Deutz Diesel Engine

Technical Specifications:

Length	13'6" (4,114.8 mm)
Width	6'8" (2,032 mm)
Height	8'6" (2,590.8 mm)
Weight	11,120 lbs (5043.9 kg) w/o bending set
Engine	CAT C4.4 Turbo Diesel, 80 hp @2400 rpm
Winch	WARN 12,000 lb hydraulic planetary winch
Air Compressor	Quincy 325 LVD Air Compressor w/ hydraulic drive & 30 gal (113.6 L) reservoir
Cylinders	Two 7" (178 mm) outboard cylinders w/ 11" (279.4 mm) stroke Two 7" (178 mm) inboard cylinders w/ 6" (152.4 mm) stroke One 4" (101.6 mm) pin-up cylinder w/ 22-3/4" (577.9 mm) stroke
Hydraulic Pump	Denison Dual Pump
Oil Cooler	American Industrial

Darby Bending Sets

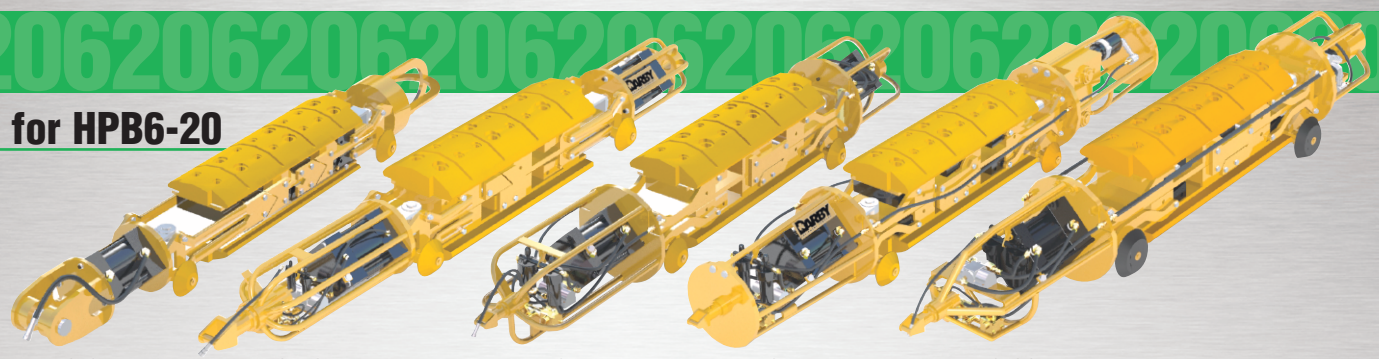


Darby bending machines require a bending set and/or bending die (bare or lined) for each diameter of pipe being bent. All bending sets are manufactured to conform to API-5L pipe sizes.

Bending sets for the HPB6-20 Bending Machine consist of the following:

- Bending sets for 6" (152.4 mm) through 18" (457.2 mm) pipe include a bending die, a stiff-back insert and a pin-up insert.
- Bending sets for 20" (508 mm) pipe include a bending die plus two stiff-back liners and a pin-up liner.

Mandrels for HPB6-20



HWM6-8 PWM10-12 PWM14-16 PWM16 PWM18-20

Features / Advantages

- Darby Mandrels are adjustable for any wall thickness within specified mandrel range and most have the capability to cover two pipe sizes using a conversion kit.
- Darby uses high-strength alloys in construction.
- Long wedges reduce the need for shimming.
- Slide locks pull the belly of the mandrels up to eliminate drag in the pipe.
- Mandrels are equipped with filters, lubricators, regulators & valves that are all rated to 250 psi (17.24 bar).
- Tapered wheels greatly reduce rolling.
- Powerful oversized cylinders provide maximum force.
- Mandrels are operated remotely by reach rod.

Technical Specifications:

See pages 11–12 for all mandrel technical specifications.

Darby AccuBend Electronic Bend Indicator

All Darby bending packages can include the AccuBend electronic indicator, an advanced and user friendly bend measurement system designed for operational ease, speed and safety.

Advantages

- Eliminates need for operator to climb on the pipe.
- Provides reliable accuracy from continuous readout of the bend progress to 1/10 degree.
- Facilitates workflow by eliminating need to stop for bend measurements.

How it works:

The AccuBend measurement system consists of two transmitters and one receiver. The receiver is mounted at the operator's stand. Once the transmitters are set on the pipe, the angle of the bend is continuously displayed. In the normal operating mode, the receiver computes the net bend in the pipe regardless of the bending machine angle.

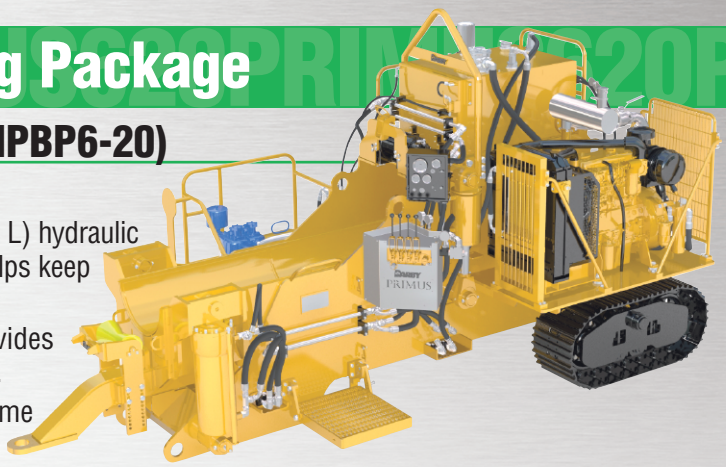


Standard Features:

- Works on any size pipe
- Accuracy to 1/10 degree
- Continuous digital readout
- Operational ease saves time and increases workflow
- Automatic shutoff preserves battery life
- Relative angle easily set by flipping switch on receiver
- Serialized radio frequency prevents interference from other units in proximity
- Strong magnetic base secures transmitters to pipe
- Comes in self-containing, protective hard case

Darby 6–20" Primus Pipe Bending Package

Darby 6-20" Primus Pipe Bending Machine (HPBP6-20)



Features/Advantages:

- The HPBP6-20 has a 31.5 gal (119 L) fuel tank and a 91 gal (344 L) hydraulic tank with 82 gal (310 L) fill capacity. The large hydraulic tank helps keep the oil cooler, extending the life of the hydraulic system.
- Commercial Intertech four-section hydraulic control valve provides bending operations and optional hydraulic mandrel operation.
- Machine sideplates are reinforced with stiffeners for optimal frame life. Side plates are 3/4" (19.1 mm) T1 steel. All welds are preheated, heat controlled and made “in position.”
- Frame cross tubes supporting the hydraulic cylinders have 3/8" (9.5 mm) wall thickness.
- Parker Seal Lok™ hydraulic system prevents leaks and has a working pressure rating of 3,000 psi (206.8 bar).
- Murphy control panel includes electric start, throttle control, oil pressure, tachometer and hour meter.
- Hydraulic cylinders can be disassembled without cutting for ease of repair.
- Pinup is fully reinforced to prevent spreading.
- 325 Quincy air compressor is hydraulically driven by its own circuit.
- 10-micron hydraulic pressure and return line filtration keeps oil clean to extend the life of the system.
- Oil cooler in compressor drive circuit keeps the circuit cooled. It continuously circulates, even when the compressor is not running. This extends the life of the hydraulic system.
- Inner pipe roller provides smooth pipe translation.
- Darby-designed tracks utilize Berco components.

Performance:

- Maximum bending force at front of stiffback is 301,600 lbs (136,803 kg).
- Air compressor provides 240 psi (16.6 bar) for mandrel operation.
- With engine running at 2,200 rpm, the hydraulic vane pump produces 46 GPM (174 LPM) at operating pressure.

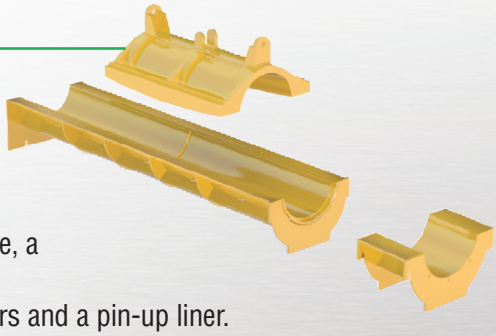
Options:

- Air-cooled Deutz Diesel Engine
- Poly tracks

Technical Specifications:

Length	16' 7" (5,054 mm)
Width	7' 4" (2,235 mm)
Height	7' 8" (2,336 mm)
Weight	20,020 lb (9,081 kg) w/o bending set
Engine	CAT C4.4 Turbo Diesel, 109 hp @2,200 rpm
Winch	WARN 12,000 lb hydraulic planetary winch
Air Compressor	Quincy 325 LVD Air Compressor w/ hydraulic drive & 30 gal (113.6 L) reservoir
Cylinders	Two 8" (203.6 mm) outboard cylinders w/ 18" (457.2 mm) stroke Two 7" (177.8 mm) inboard cylinders w/ 6" (152.4 mm) stroke One 5" (127 mm) pin-up cylinder w/ 24" (609.6 mm) stroke
Hydraulic Pump	Denison Dual Pump
Oil Cooler	American Industrial

Darby Bending Sets

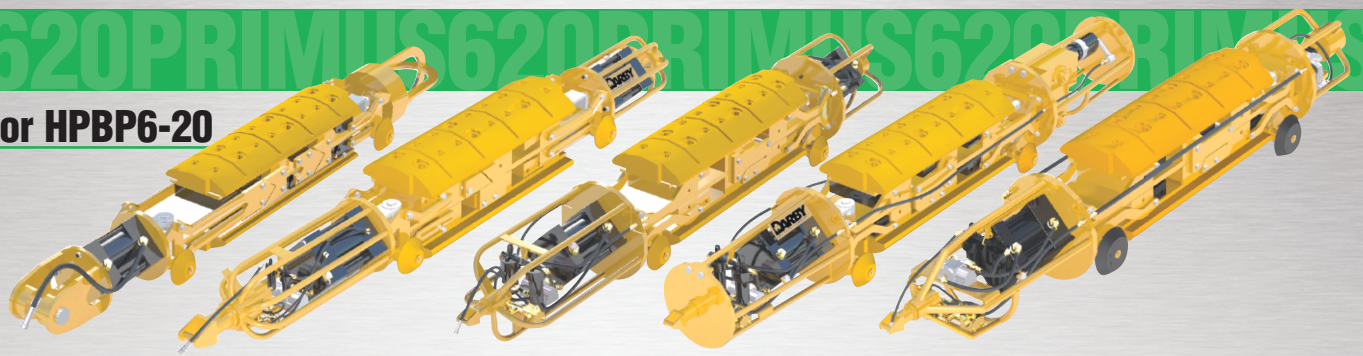


Darby bending machines require a bending set and/or bending die (bare or lined) for each diameter of pipe being bent. All bending sets are manufactured to conform to API-5 L pipe sizes.

Bending sets for the HPBP6-20 Bending Machine consist of the following:

- Bending sets for 6" (152.4 mm) through 18" (457.2 mm) pipe include a bending die, a stiff-back insert and a pin-up insert.
- Bending sets for 20" (508 mm) pipe include a bending die plus three stiff-back liners and a pin-up liner.

Mandrels for HPBP6-20



HWM6-8 PWM10-12 PWM14-16 PWM16 PWM18-20

Features / Advantages

- Darby Mandrels are adjustable for any wall thickness within specified mandrel range and most have the capability to cover two pipe sizes using a conversion kit.
- Darby uses high-strength alloys in construction.
- Long wedges reduce the need for shimming.
- Slide locks pull the belly of the mandrels up to eliminate drag in the pipe.
- Mandrels are equipped with filters, lubricators, regulators & valves that are all rated to 250 psi (17.24 bar).
- Tapered wheels greatly reduce rolling.
- Powerful oversized cylinders provide maximum force.
- Mandrels are operated remotely by reach rod.

Technical Specifications:

See pages 11–12 for all mandrel technical specifications.

Darby AccuBend Electronic Bend Indicator



All Darby bending packages can include the AccuBend electronic indicator, an advanced and user friendly bend measurement system designed for operational ease, speed and safety.

Advantages

- Eliminates need for operator to climb on the pipe.
- Provides reliable accuracy from continuous readout of the bend progress to 1/10 degree.
- Facilitates workflow by eliminating need to stop for bend measurements.

How it works:

The AccuBend measurement system consists of two transmitters and one receiver. The receiver is mounted at the operator's stand. Once the transmitters are set on the pipe, the angle of the bend is continuously displayed. In the normal operating mode, the receiver computes the net bend in the pipe regardless of the bending machine angle.

Standard Features:

- Works on any size pipe
- Accuracy to 1/10 degree
- Continuous digital readout
- Operational ease saves time and increases workflow
- Automatic shutoff preserves battery life
- Relative angle easily set by flipping switch on receiver
- Serialized radio frequency prevents interference from other units in proximity
- Strong magnetic base secures transmitters to pipe
- Comes in self-containing, protective hard case

Darby 16–30" Pipe Bending Package

Darby 16-30" Pipe Bending Machine (HPB16-30)



Features/Advantages:

- The HPB16-30 has a 34 gal (128.7 L) fuel tank and a 100 gal (378.54 L) hydraulic tank with 80 gal (303 L) fill capacity. The large hydraulic tank helps keep the oil cooler, extending the life of the hydraulic system.
- Hydro Control five-section hydraulic control valve provides bending and winch operation. Hydraulic mandrel operation is a standard feature on all Darby bending machines.
- Machine side plates are reinforced with stiffeners for optimal frame life. Side plates are 3/4" (19.1 mm) T1 steel and die nest plates are 1-1/2" T1 steel. All welds are preheated, heat controlled and made "in position."
- Parker Seal Lok™ hydraulic system prevents leaks and has a working pressure rating of 3,000 psi (206.8 bar).
- Murphy control panel includes electric start, throttle control, oil pressure, tachometer and hour meter.
- Hydraulic cylinders can be disassembled without cutting for ease of repair.
- Frame cross tubes supporting the hydraulic cylinders have 3/8" (.375 mm) wall thickness.
- Pinup is fully reinforced to prevent spreading.
- 370 Quincy air compresor is hydraulically driven by its own circuit.
- 10-micron hydraulic pressure and return line filtration keeps oil clean to extend the life of the system.
- Oil cooler in compressor drive circuit keeps the circuit cooled. It continuously circulates, even when the compressor is not running. This extends the life of the hydraulic system.

Performance:

- Maximum bending force at front of stiffback is 381,700 lbs (173,139 kg).
- Air compressor provides 240 psi (16.5 bar) for mandrel operation.
- With engine running at 2,200 rpm, hydraulic vane pump produces 41 GPM (155 LPM) @ operating pressure.
- 15 ton CAT style triple grouser tracks.

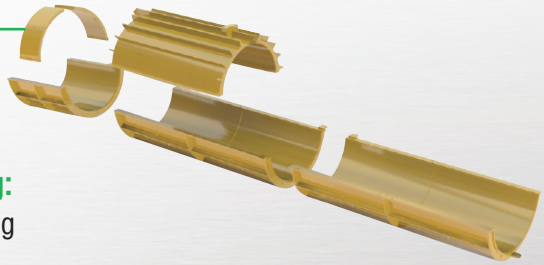
Options:

- Air-cooled Deutz Diesel Engine

Technical Specifications:

Length	22'6" (6,858 mm)
Width	8'6" (2,590.8 mm)
Height	8'6" (2,590.8 mm)
Weight	35,000 lbs (15,876 kg) w/o bending set
Engine	CAT C4.4 Turbo Diesel, 109 hp @ 2,200 rpm
Winch	Ramsey 15,000 lb (6,804 kg) hydraulic planetary winch
Air Compressor	Quincy 370 LVD Air Compressor w/ hydraulic drive and 120 gal (454.3 L) reservoir
Cylinders	Two 9" (228.6 mm) outboard cylinders w/ 19" (482.6 mm) stroke Two 7" (177.8 mm) inboard cylinders w/ 6" (152.4 mm) stroke One 6" (152.4 mm) pin-up cylinder w/ 22-15/16" (559.7 mm) stroke
Hydraulic Pump	Denison vane pump w/ Parker piston pump
Oil Cooler	American Industrial

Darby Bending Sets



Darby bending machines require a bending set and/or bending die (bare or lined) for each diameter of pipe being bent. All bending sets are manufactured to conform to API-5L pipe sizes.

Bending sets for the HPB16-30 Bending Machine consist of the following:

- Bending sets for 16" (406.4 mm) through 28" (711.2 mm) pipe include a bending die, two stiff-back inserts, a pin-up insert and two clamp pieces.
- Bending sets for 30" (762 mm) pipe include a bending die plus four stiff-back liners, a pin-up liner and two clamp liners.

Mandrels for HPB16-30



PWM16 Long | PWM18-20 | PWM16-22 | PWM24-32 | PWMSA24-32*

*Self-aligning mandrel

Features / Advantages

- Darby Mandrels are adjustable for any wall thickness within specified mandrel range and most have the capability to cover two pipe sizes using a conversion kit.
- Darby uses high-strength alloys in construction.
- Long wedges reduce the need for shimming.
- Slide locks pull the belly of the mandrels up to eliminate drag in the pipe.
- Mandrels are equipped with filters, lubricators, regulators & valves that are all rated to 250 psi (17.24 bar).
- Tapered wheels greatly reduce rolling.
- Powerful oversized cylinders provide maximum force.
- Mandrels are operated remotely by reach rod.

Technical Specifications:

See pages 11–12 for all mandrel technical specifications.

Darby AccuBend Electronic Bend Indicator



All Darby bending packages can include the AccuBend electronic indicator, an advanced and user friendly bend measurement system designed for operational ease, speed and safety.

Advantages

- Eliminates need for operator to climb on the pipe.
- Provides reliable accuracy from continuous readout of the bend progress to 1/10 degree.
- Facilitates workflow by eliminating need to stop for bend measurements.

How it works:

The AccuBend measurement system consists of two transmitters and one receiver. The receiver is mounted at the operator's stand. Once the transmitters are set on the pipe, the angle of the bend is continuously displayed. In the normal operating mode, the receiver computes the net bend in the pipe regardless of the bending machine angle.

Standard Features:

- Works on any size pipe
- Accuracy to 1/10 degree
- Continuous digital readout
- Operational ease saves time and increases workflow
- Automatic shutoff preserves battery life
- Relative angle easily set by flipping switch on receiver
- Serialized radio frequency prevents interference from other units in proximity
- Strong magnetic base secures transmitters to pipe
- Comes in self-containing, protective hard case

Darby 22–36" Pipe Bending Package

Darby 22-36" Pipe Bending Machine (HPB22-36)



Features/Advantages:

- The HPB22-36 has a 35 gal (144 L) fuel tank and a 120 gal (454 L) hydraulic tank with 100 gal (379 L) fill capacity. The large hydraulic tank helps keep the oil cooler, extending the life of the hydraulic system.
- Hydro Control five-section hydraulic control valve provides bending and winch operation. Hydraulic mandrel operation is a standard feature on all Darby bending machines.
- Machine side plates are reinforced with stiffeners for optimal frame life. Side plates are 1" (25.4 mm) T1 steel and die nest plates are 1-1/2" (38.1 mm) T1 steel. All welds are preheated, heat controlled and made “in position.”
- Frame cross tubes supporting the hydraulic cylinders have 3/8" (9.5 mm) wall thickness.
- Parker Seal-Lok™ hydraulic system prevents leaks and has a working pressure rating of 3,000 psi (206.8 bar).
- Murphy control panel includes electric start, throttle control, oil pressure, tachometer and hour meter.
- Hydraulic cylinders can be disassembled without cutting for ease of repair.
- Pinup is fully reinforced to prevent spreading.
- 390 Quincy Air compressor is hydraulically driven by its own circuit.
- 10-micron hydraulic pressure and return line filtration keeps oil clean to extend the life of the system.
- Oil cooler in compressor drive circuit keeps the circuit cooled. It continuously circulates, even when the compressor is not running. This extends the life of the hydraulic system.

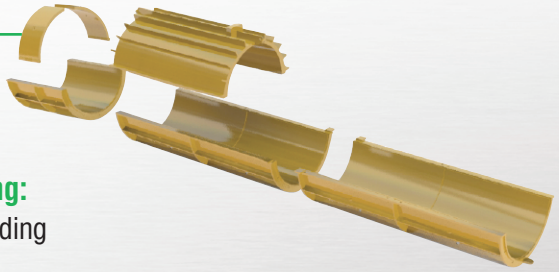
Performance:

- Maximum bending force at front of stiffback is 763,000 lbs (346,090 kg).
- Air compressor provides 240 psi (16.5 bar) continuous pressure for mandrel operation.
- With engine running at 2,200 rpm, hydraulic vane pump produces 74 GPM (280 LPM) @ operating pressure.
- 15 ton CAT style triple grouser tracks

Technical Specifications:

Length	24'6" (7,467 mm)
Width	9'1" (2,768.6 mm)
Height	9'3" (2,819.4 mm)
Weight	47,600 lbs (21,591 kg) w/o bending set
Engine	CAT C6.6 Turbo Diesel, 173 hp @ 2,200 rpm
Winch	Ramsey 20,000 lb (9,071 kg) Powermaster® hydraulic planetary winch
Air Compressor	Quincy 390 LVD air compressor w/ hydraulic drive and 120 gal (454.3 L) reservoir
Cylinders	Four 9" (228.6 mm) outboard cylinders w/ 19" (482.60 mm) stroke Four 7" (177.8 mm) inboard cylinders w/ 6" (152.4 mm) stroke One 7" (177.8 mm) pin-up cylinder w/ 23" (584 mm) stroke
Hydraulic Pump	Denison vane pump w/ Parker piston pump
Oil Cooler	American Industrial

Darby Bending Sets



Darby bending machines require a bending set and/or bending die (bare or lined) for each diameter of pipe being bent. All bending sets are manufactured to conform to API-5L pipe sizes.

Bending sets for the HPB22-36 Bending Machine consist of the following:

- Bending sets for 22” (558.8 mm) through 34” (863.6 mm) pipe include a bending die, two stiff-back inserts, a pin-up insert and two clamp pieces.
- Bending sets for 36” (914.4 mm) pipe include a bending die plus four stiff-back liners, a pin-up liner and two clamp liners.

Mandrels for HPB22-36



PWM16-22 PWM24-32 PWMSA24-32* PWM34-42 PWMSA34-42*

*Self-aligning mandrels

Features / Advantages

- Darby Mandrels are adjustable for any wall thickness within specified mandrel range and most have the capability to cover two pipe sizes using a conversion kit.
- Darby uses high-strength alloys in construction.
- Long wedges reduce the need for shimming.
- Slide locks pull the belly of the mandrels up to eliminate drag in the pipe.
- Mandrels are equipped with filters, lubricators, regulators & valves that are all rated to 250 psi (17.24 bar).
- Tapered wheels greatly reduce rolling.
- Powerful oversized cylinders provide maximum force.
- Mandrels are operated remotely by reach rod.

Technical Specifications:

See pages 11–12 for all mandrel technical specifications.

Darby AccuBend Electronic Bend Indicator



All Darby bending packages can include the AccuBend electronic indicator, an advanced and user friendly bend measurement system designed for operational ease, speed and safety.

Advantages

- Eliminates need for operator to climb on the pipe.
- Provides reliable accuracy from continuous readout of the bend progress to 1/10 degree.
- Facilitates workflow by eliminating need to stop for bend measurements.

How it works:

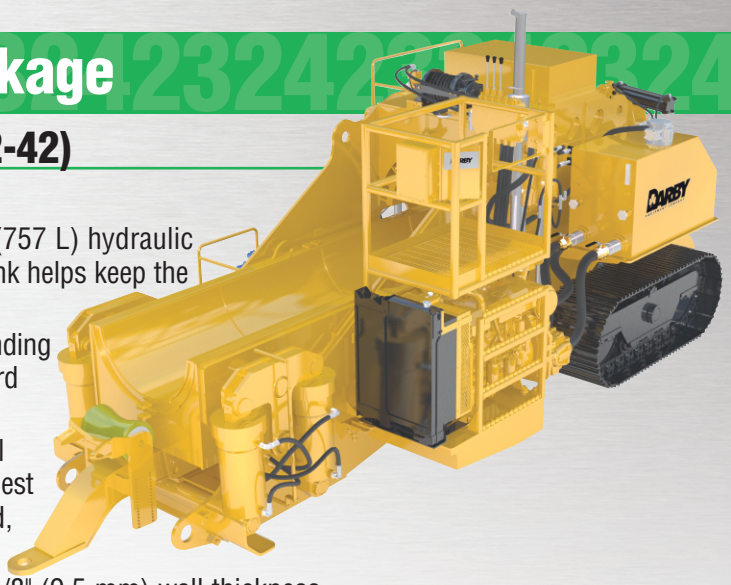
The AccuBend measurement system consists of two transmitters and one receiver. The receiver is mounted at the operator's stand. Once the transmitters are set on the pipe, the angle of the bend is continuously displayed. In the normal operating mode, the receiver computes the net bend in the pipe regardless of the bending machine angle.

Standard Features:

- Works on any size pipe
- Accuracy to 1/10 degree
- Continuous digital readout
- Operational ease saves time and increases workflow
- Automatic shutoff preserves battery life
- Relative angle easily set by flipping switch on receiver
- Serialized radio frequency prevents interference from other units in proximity
- Strong magnetic base secures transmitters to pipe
- Comes in self-containing, protective hard case

Darby 32–42" Pipe Bending Package

Darby 32-42" Pipe Bending Machine (HPB32-42)



Features/Advantages:

- The HPB32-42 has a 75 gal (284 L) fuel tank and a 200 gal (757 L) hydraulic tank with 160 gal (606 L) fill capacity. The large hydraulic tank helps keep the oil cooler, extending the life of the hydraulic system.
- Hydro Control five-section hydraulic control valve provides bending and winch operation. Hydraulic mandrel operation is a standard feature on all Darby bending machines.
- Machine side plates are reinforced with stiffeners for optimal frame life. Side plates are 1-1/4" (31.8 mm)T1 steel and die nest plates are 1-1/2" (38.1 mm) T1 steel. All welds are preheated, heat controlled and made “in position.”
- Frame cross tubes supporting the hydraulic cylinders have 3/8" (9.5 mm) wall thickness.
- Parker Seal Lok™ hydraulic system prevents leaks and has a working pressure rating of 3,000 psi (206.8 bar).
- Murphy control panel includes electric start, throttle control, oil pressure, tachometer and hour meter.
- Hydraulic cylinders can be disassembled without cutting for ease of repair.
- Pinup is fully reinforced to prevent spreading.
- 390 Quincy Air compressor is hydraulically driven by its own circuit.
- 10-micron hydraulic pressure and return line filtration keeps oil clean to extend the life of the system.
- Oil cooler in compressor drive circuit keeps the circuit cooled. It continuously circulates, even when the compressor is not running. This extends the life of the hydraulic system.
- Heavy duty 3-roller tracks for improved performance and lower ground track.

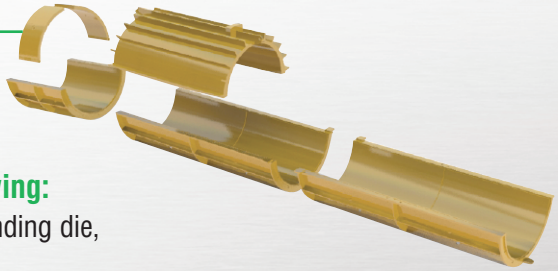
Performance:

- Maximum bending force at front of stiffback is 1,140,400 lbs (517,276 kg).
- Air compressor provides 240 psi (16.5 bar) continuous pressure for mandrel performance.
- With engine running at 2,200 rpm, hydraulic vane pump produces 145 GPM (549 LPM) @ operating pressure.

Technical Specifications:

Length	26'8" (8,128 mm)
Width	10'2" (3,098.8 mm)
Height	11'5" (3,479.8 mm)
Weight	82,500 lbs (37,421 kg) w/o bending set
Engine	CAT C6.6 Turbo Diesel, 202 hp at 2,200 rpm
Winch	Ramsey 20,000 lb (9,071 kg) Powermaster® hydraulic planetary winch
Air Compressor	Quincy 390 LVD air compressor w/ hydraulic drive and 120 gal (454.3 L) reservoir
Cylinders	Four 11" (279 mm) outboard cylinders w/ 18.5" (469.9 mm) stroke Four 8" (203 mm) inboard cylinders w/ 6" (152.4 mm) stroke One 7" (177.8 mm) pin-up cylinder w/ 42" (1,066.8 mm) stroke
Hydraulic Pump	Three Parker piston pumps
Oil Cooler	American Industrial

Darby Bending Sets

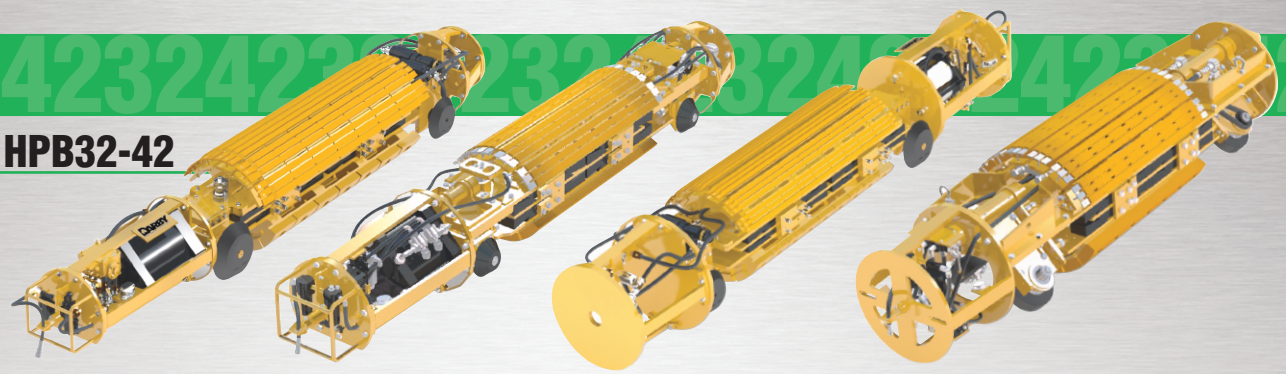


Darby bending machines require a bending set and/or bending die (bare or lined) for each diameter of pipe being bent. All bending sets are manufactured to conform to API-5L pipe sizes.

Bending sets for the HPB32-42 Bending Machine consist of the following:

- Bending sets for 32" (812.8 mm) through 40" (1,016 mm) pipe include a bending die, two stiff-back inserts, a pin-up insert and two clamp pieces.
- Bending sets for 42" (1,066.8 mm) pipe include a bending die plus four stiff-back liners, a pin-up liner and two clamp liners.

Mandrels for HPB32-42



PWM24-32 | PWMSA24-32* | PWM34-42 | PWMSA34-42*

*Self-aligning mandrels

Features / Advantages

- Darby Mandrels are adjustable for any wall thickness within specified mandrel range and most have the capability to cover two pipe sizes using a conversion kit.
- Darby uses high-strength alloys in construction.
- Long wedges reduce the need for shimming.
- Slide locks pull the belly of the mandrels up to eliminate drag in the pipe.
- Mandrels are equipped with filters, lubricators, regulators & valves that are all rated to 250 psi (17.24 bar).
- Tapered wheels greatly reduce rolling.
- Powerful oversized cylinders provide maximum force.
- Mandrels are operated remotely by reach rod.

Technical Specifications:

See pages 11–12 for all mandrel technical specifications.

Darby AccuBend Electronic Bend Indicator



All Darby bending packages can include the AccuBend electronic indicator, an advanced and user friendly bend measurement system designed for operational ease, speed and safety.

Advantages

- Eliminates need for operator to climb on the pipe.
- Provides reliable accuracy from continuous readout of the bend progress to 1/10 degree.
- Facilitates workflow by eliminating need to stop for bend measurements.

How it works:

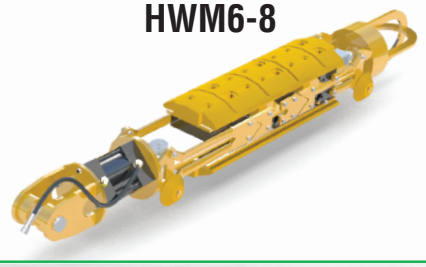
The AccuBend measurement system consists of two transmitters and one receiver. The receiver is mounted at the operator's stand. Once the transmitters are set on the pipe, the angle of the bend is continuously displayed. In the normal operating mode, the receiver computes the net bend in the pipe regardless of the bending machine angle.

Standard Features:

- Works on any size pipe
- Accuracy to 1/10 degree
- Continuous digital readout
- Operational ease saves time and increases workflow
- Automatic shutoff preserves battery life
- Relative angle easily set by flipping switch on receiver
- Serialized radio frequency prevents interference from other units in proximity
- Strong magnetic base secures transmitters to pipe
- Comes in self-containing, protective hard case

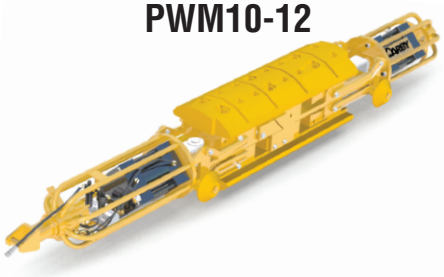
Darby Pipe Bending Mandrels – Technical Specifications

HWM6-8



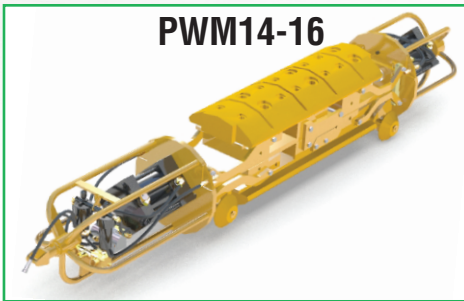
Length	62" (1,549 mm)
Width	7" (175 mm)
Height	8" (203 mm)
Weight	185 lbs (84 kg)
Air Motor	Non-powered
Cylinder	3" (79.4 mm)
Working Hydraulic Pressure	300-500 psi (20.68-34.47 bar)
Pipe Size Range	6"-8" (152-203 mm)
Wall Thickness Range	.156"-.500" (4-12.7 mm)

PWM10-12



Length	87" (2,210 mm)
Width	10" (279 mm)
Height	12" (305 mm)
Weight	475 lbs (216 kg)
Air Motor	Non Powered
Cylinder	5" (127 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	10" - 12" (254 - 305 mm)
Wall Thickness Range	.188"-.500" (4.8 - 12.7 mm) 10" .188"-.625"(4.8 - 15.9 mm) 12"

PWM14-16



Length	87" (2,197 mm)
Width	11" (279 mm)
Height	16" (406 mm)
Weight	610 lbs (277 kg)
Air Motor	Non Powered
Cylinder	6" (152 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	14" - 16" (356 - 406.4 mm)
Wall Thickness Range	.188"-.500" (4.8 - 12.7 mm) 14" .188" - .625"(4.8 - 15.9 mm) 16"

PWM16



Length	99" (2,515 mm)
Width	12" (305 mm)
Height	16" (406 mm)
Weight	720 lbs (327 kg)
Air Motor	1.3 hp - Ingersoll Rand
Cylinder	6" (152 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	16" (406 mm)
Wall Thickness Range	.188"-.500" (4.8 - 12.7 mm)

PWM18-20



Length	99" (2,515 mm)
Width	14" (356 mm)
Height	20" (432 mm)
Weight	850 lbs (386 kg)
Air Motor	.9 hp - Cooper
Cylinder	8" (203 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	18" - 20" (406 mm)
Wall Thickness Range	.188"-.500" (4.8 - 12.7 mm)

PWM16-22



Length	126" (3,200 mm)
Width	18" (457 mm)
Height	22" (432 mm)
Weight	1,700 lbs (771 kg)
Air Motor	1.3 hp - Ingersoll Rand
Cylinder	8" (203 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	16"-22" (406 - 559 mm)
Wall Thickness Range	.188"-.750" (4.8 - 19 mm)

PWM16 Long



Length	107" (2,718 mm)
Width	12" (305 mm)
Height	16" (406 mm)
Weight	930 lbs (421 kg)
Air Motor	.9 hp - Cooper
Cylinder	6" (152 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	16" (406 mm)
Wall Thickness Range	.188"-.500" (4.8 - 12.7 mm)

PWM18-20 Long



Length	127" (2,718 mm)
Width	18" (356 mm)
Height	20" (432 mm)
Weight	1,060 lbs (481 kg)
Air Motor	.9 hp - Cooper
Cylinder	8" (203 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	18"-20" (457 - 508 mm)
Wall Thickness Range	.188"-.500" (4.8 - 12.7 mm)

PWM24-32



Length	133" (3,378 mm)
Width	25" (635 mm)
Height	32" (813 mm)
Weight	3,650 lbs (1656 kg)
Air Motor	Two 1.3 hp - Ingersoll Rand
Cylinder	14" (356 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	24" - 32" (610 - 813 mm)
Wall Thickness Range	.188"-.750" (4.8 - 19 mm)

PWMSA24-32*



Length	137" (3,480 mm)
Width	29" (737 mm)
Height	29" (737 mm)
Weight	4,000 lbs. (1,814 kg)
Air Motor	Two 1.3 hp - Ingersoll Rand
Cylinder	12" (305 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	24"- 32" (610 mm - 813 mm)
Wall Thickness Range	.188"-.750" (4.8 - 19 mm)

PWM34-42



Length	160" (4,064 mm)
Width	36" (914 mm)
Height	42" (1,067 mm)
Weight	7,060 lbs (3,202 kg)
Air Motor	Two 3.0 hp - Ingersoll Rand
Cylinder	16" (406 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	34" - 42" (864 - 1,067 mm)
Wall Thickness Range	.188"-.750" (4.8 - 19 mm)

PWMSA34-42*



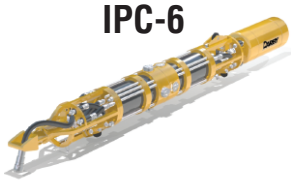
Length	131" (3,327 mm)
Width	37" (950 mm)
Height	38" (965 mm)
Weight	5,930 lbs (2,686 kg)
Air Motor	Two 3.0 hp - Ingersoll Rand
Cylinder	14" (356 mm)
Working Air Pressure	200-225 psi (13.8-15.5 bar)
Pipe Size Range	34"-42" (864 -1,067 mm)
Wall Thickness Range	.188"-.750" (4.8 - 19 mm)

*Self-aligning mandrels

Darby Line-Up Clamps – Technical Specifications

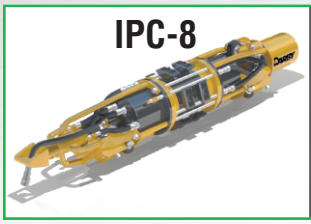
Unless otherwise noted Darby internal pneumatic clamps are adaptive to two pipe sizes through the use of conversion kits. All clamp models feature fully hardened dowel pins, electro static plated air tubes to reduce corrosion, best quality high pressure quick exhausts and optimum strength frame construction. Powered models have a 25-degree climbing capability and all models employ grade 8 bolts along with high quality seals and u-cups.

IPC-6



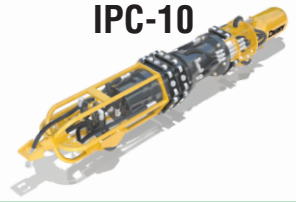
Pipe Size Range	6" pipe; 6-5/8" (168.3 mm) OD	**Working Air Pressure**	200-225 psi (13.8-15.5 bar)
Wall Thickness Range	.125-.500 (3.18-12.7 mm)	**Air Motor**	Non-powered
Standard Length	53" (1,346 mm)	**Air Tank**	.6 gal (2.27 L)
Width	6" (152 mm)	**Clamping Shoes**	8 total/4 on each section
Height	6" (152 mm)	**Cylinder**	3.5" (89 mm)
Weight	60 lbs (27 kg)	**Climbing Capability**	N/A

IPC-8



Pipe Size Range	8" pipe; 8-5/8" (168.3 mm) OD	**Working Air Pressure**	200-225 psi (13.8-15.5 bar)
Wall Thickness Range	.125-.500 (3.18-12.7 mm)	**Air Motor**	Non-powered
Standard Length	48" (1,219 mm)	**Air Tank**	.6 gal (2.27 L)
Width	8" (203 mm)	**Clamping Shoes**	10 total/5 on each section
Height	8" (203 mm)	**Cylinder**	3.5" (89 mm)
Weight	125 lbs (56.7 kg)	**Climbing Capability**	N/A

IPC-10



Pipe Size Range	10" pipe; 10-3/4" (273 mm) OD	**Working Air Pressure**	200-225 psi (13.8-15.5 bar)
Wall Thickness Range	.125-.500 (3.18-12.7 mm)	**Air Motor**	Non-powered
Standard Length	68" (1,727.2 mm)	**Air Tank**	.6 gal (2.27 L)
Width	10" (254 mm)	**Clamping Shoes**	15 total/6 on each section & the joint
Height	10" (254 mm)	**Cylinder**	3.5" (89 mm)
Weight	235 lbs (106.6kg)	**Climbing Capability**	N/A

IPC12-14



Pipe Size Range	12" pipe; 12-3/4-14" (323-356 mm)	**Working Air Pressure**	200-225 psi (13.8-15.5 bar)
Wall Thickness Range	.125-.5 (3.18-12.7 mm) .125-.75" (3.18-19.05 mm)	**Air Motor**	Non-powered
		Air Tank	2 gal (7.57 L)
Standard Length	65" (1,651 mm)	**Clamping Shoes**	15 total/6 on each section & the joint
Width	11" (279 mm)	**Cylinder**	6" (152 mm)
Height	11" (279 mm)	**Climbing Capability**	N/A
Weight	270 lbs (123 kg)		

IPC16-18



Pipe Size Range	16-18" (406-457 mm)	**Working Air Pressure**	200-225 psi (13.8-15.5 bar)
Wall Thickness Range	.125-.5 (3.18-12.7 mm) .125-.75" (3.18-19.05 mm)	**Air Motor**	.9 hp Cleco
		Air Tank	10 gal (37.85 L) with 3 gal (11.35 L) reserve
Standard Length	100" (2,540 mm)		
Width	14" (356 mm)	**Clamping Shoes**	16 total/8 on each section
Height	14" (356 mm)	**Cylinder**	8" (203 mm)
Weight	545 lbs (247 kg)	**Climbing Capability**	25 degree incline

IPC20-22



Pipe Size Range	20-22" (508-559 mm)	**Working Air Pressure**	200-225 psi (13.8-15.5 bar)
Wall Thickness Range	.125-.5 (3.18-12.7 mm) .125-.75" (3.18-19.05 mm)	**Air Motor**	.9 hp Cleco
		Air Tank	10 gal (37.85 L) with 3 gal (11.35 L) reserve
Standard Length	114" (2,896 mm)		
Width	18" (457 mm)	**Clamping Shoes**	20 total/10 on each section
Height	18" (457 mm)	**Cylinder**	8" (203 mm)
Weight	810 lbs (367 kg)	**Climbing Capability**	25 degree incline

IPC24-26



Pipe Size Range	24-26" (610-660 mm)
Wall Thickness Range	.125-.5 (3.18-12.7 mm) .125-.75" (3.18-19.05 mm)
Standard Length	121" (3,073 mm)
Width	21" (533 mm)
Height	21" (533 mm)
Weight	1,035 lbs (470 kg)

Working Air Pressure	200-225 psi (13.8-15.5 bar)
Air Motor	1.9 hp Cleco
Air Tank	30 gal (113.56 L) with 3 gal (11.35 L) reserve
Clamping Shoes	24 total/12 on each section
Cylinder	10" (254 mm)
Climbing Capability	25 degree incline

IPC28-30



Pipe Size Range	28-30" (711-762 mm)
Wall Thickness Range	.125-.5 (3.18-12.7 mm) .125-.75" (3.18-19.05 mm)
Standard Length	125" (3,175 mm)
Width	25" (635 mm)
Height	25" (635 mm)
Weight	1,260 lbs (572 kg)

Working Air Pressure	200-225 psi (13.8-15.5 bar)
Air Motor	1.9 hp Cleco
Air Tank	30 gal (113.56 L) with 3 gal (11.35 L) reserve
Clamping Shoes	32 total/16 on each section
Cylinder	10" (254 mm)
Climbing Capability	25 degree incline

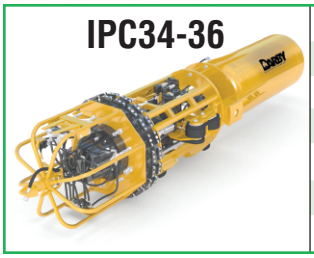
IPC30-32



Pipe Size Range	30-32" (762-813 mm)
Wall Thickness Range	.125-.5 (3.18-12.7 mm) .125-.75" (3.18-19.05 mm)
Standard Length	125" (3,175 mm)
Width	27" (686 mm)
Height	27" (686 mm)
Weight	1,340 lbs (609 kg)

Working Air Pressure	200-225 psi (13.8-15.5 bar)
Air Motor	1.9 hp Cleco
Air Tank	30gal (113.56 L) with 3gal (11.35 L) reserve
Clamping Shoes	32 total/16 on each section
Cylinder	10" (254 mm)
Climbing Capability	25 degree incline

IPC34-36



Pipe Size Range	34-36" (864-914 mm)
Wall Thickness Range	.375-.75 (9.5-19.05 mm)
Standard Length	145" (3,686 mm)
Width	31" (787 mm)
Height	31" (787 mm)
Weight	2,715 lbs (1,232 kg)

Working Air Pressure	200-225 psi (13.8-15.5 bar)
Air Motor	Two 2.7 hp drive motors
Air Tank	80 gal (302.83 L) with 1.6 gal (11.35 L) reserve
Clamping Shoes	36 total/18 on each section
Cylinder	12" (305 mm)
Climbing Capability	25 degree incline

IPC36-38



Pipe Size Range	36-38" (914-965 mm)
Wall Thickness Range	.375-.75 (9.5-19.05 mm)
Standard Length	144" (3,658 mm)
Width	32" (813 mm)
Height	32" (813 mm)
Weight	3,435 lbs (1,558 kg)

Working Air Pressure	200-225 psi (13.8-15.5 bar)
Air Motor	Two 2.7 hp drive motors
Air Tank	80gal (302.83 L) with 3 gal (11.35 L) reserve
Clamping Shoes	40 total/20 on each section
Cylinder	12" (305 mm)
Climbing Capability	25 degree incline

IPC40-42



Pipe Size Range	40-42" (1,016-1,067 mm)
Wall Thickness Range	.375-.75 (9.5-19.05 mm)
Standard Length	148" (3,759 mm)
Width	36" (914 mm)
Height	38" (965 mm)
Weight	3,650 lbs (1,656 kg)

Working Air Pressure	200-225 psi (13.8-15.5 bar)
Air Motor	Two 2.7 hp drive motors
Air Tank	80 gal (302.83 L) with 3 gal (11.35 L) reserve
Clamping Shoes	48 total/24 on each section
Cylinder	14" (305 mm)
Climbing Capability	25 degree incline

IPC46-48



Pipe Size Range	46-48" (1,167-1,219 mm)
Wall Thickness Range	.375-.75 (9.5-19.05 mm)
Standard Length	148" (3,759 mm)
Width	42" (1,067 mm)
Height	42" (1,067 mm)
Weight	3,700 lbs (1,656 kg)

Working Air Pressure	200-225 psi (13.8-15.5 bar)
Air Motor	Two 2.7 hp drive motors
Air Tank	80 gal (302.83 L) with 4.7 gal (17.8 L) reserve
Clamping Shoes	48 total/24 on each section
Cylinder	14" (305 mm)
Climbing Capability	25 degree incline

Darby Pipe Roller Cradles – Technical Specifications

- Darby cradles assemble quickly for transit and storage.
- The multiple urethane rollers are spaced evenly supporting the pipe and preventing ovality, or "egging."
- All Darby cradles use springs between rollers, allowing optimum alignment of the rollers to various load requirements resulting in prolonged cable life.
- Long-lasting rollers have either grease fittings or factory sealed ball bearings providing smooth rotation.
- Lifting eyes are made of reinforced T1 steel, and head irons are made of schedule 80 pipe.
- Springs and axles are zinc plated to prevent corrosion.
- Lifting lugs extend through the head iron and are welded on the top and bottom to secure maximum lifting capacity.
- Finite element analysis calculations are performed on all Darby cradle weldments to assure structural integrity.
- Swaged sleeves achieve maximum cable strength and meet all OSHA requirements.
- Darby cradles are CE compliant, and the wire assembly meets ANSI B-30-9 sling requirements, OSHA 1910.184 and OSHA 1926-251 material handling requirements.

PRC 02-08 	**Pipe Size Range**	2-8" (50.8-203.2 mm)
	Head Iron Design	Single
	Working Load	8,000 lbs (3637 kg)
	Rope Diameter	5/8" (15.9 mm)
	Number of Rollers	3
	Weight	45 lbs (20.5 kg)
PRC 6-12S 	**Pipe Size Range**	6-12" (152.4-304.8 mm)
	Head Iron Design	Single
	Working Load	12,000 lbs (5,455 kg)
	Rope Diameter	5/8" (15.9 mm)
	Number of Rollers	10
	Weight	225 lbs (102.3 kg)
PRC 12-24S 	**Pipe Size Range**	12-24" (304.8-609.6 mm)
	Head Iron Design	Single
	Working Load	13,331 lbs (6,047 kg)
	Rope Diameter	5/8" (15.9 mm)
	Number of Rollers	14
	Weight	437 lbs (198.2 kg)
PRC 24-36S 	**Pipe Size Range**	24-36" (609.6-914.4 mm)
	Head Iron Design	Single
	Working Load	28,250 lbs (12,814 kg)
	Rope Diameter	1" (25.4 mm)
	Number of Rollers	12
	Weight	1,446 lbs (655.9 kg)
PRC 36-48S 	**Pipe Size Range**	36-48" (914.4-1219.2 mm)
	Head Iron Design	Single
	Working Load	34,694.5 lbs (15,737 kg)
	Rope Diameter	1" (25.4 mm)
	Number of Rollers	16
	Weight	1,740 lbs (789.3 kg)

PRC 48-60S



Pipe Size Range	48-60" (1219.2-1,524 mm)
Head Iron Design	Single
Working Load	52,690 lbs (23,900 kg)
Rope Diameter	1-1/8" (28.6 mm)
Number of Rollers	18
Weight	1,898 lbs (860.9 kg)

PRC 6-12D



Pipe Size Range	6-12" (152.4-304.8 mm)
Head Iron Design	Double
Working Load	16,923 lbs (7,676 kg)
Rope Diameter	5/8" (15.9 mm)
Number of Rollers	20
Weight	515 lbs (234.1 kg)

PRC 12-24D



Pipe Size Range	12-24" (304.8-609.6 mm)
Head Iron Design	Double
Working Load	26,662 lbs (13,001 kg)
Rope Diameter	5/8" (15.9 mm)
Number of Rollers	28
Weight	870 lbs (395.5 kg)

PRC 24-36D



Pipe Size Range	24-36" (609.6-914.4 mm)
Head Iron Design	Double
Working Load	56,500 lbs (25,628 kg)
Rope Diameter	1" (25.4 mm)
Number of Rollers	24
Weight	2,990 lbs (1,359 kg)

PRC 36-48D



Pipe Size Range	36-48" (914.4-1219.2 mm)
Head Iron Design	Double
Working Load	69.389 lbs (31,471 kg)
Rope Diameter	1" (25.4 mm)
Number of Rollers	32
Weight	3,575 lbs (1,625 kg)

PRC 48-60D

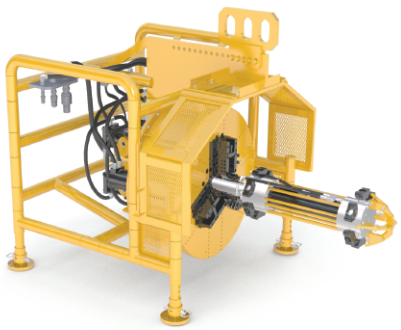


Pipe Size Range	48-60" (1219.2-1,524 mm)
Head Iron Design	Double
Working Load	105,380 lbs (47,800 kg)
Rope Diameter	1 1/8" (28.6 mm)
Number of Rollers	36
Weight	4,635 lbs (2,106 kg)

Darby Pipe Facing Machines – Technical Specifications

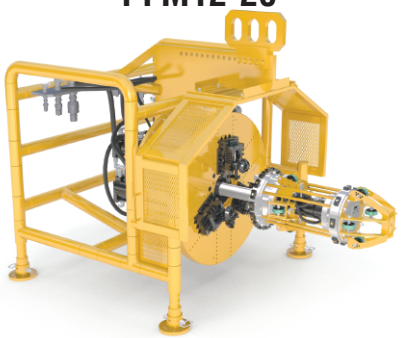
- Darby pipe facing machines come with interchangeable clamping sections. Each section can clamp up in no less than two pipe sizes.
- Tooling easily adapts to any bevel configuration including modified “J” bevel for automatic welding.
- Optional boring tool for Models PFM12-26 and PFM24-48 will counterbore all pipe in their size range to facilitate wall thickness changes.
- Fittings are Parker Seal-Lok.
- All models have variable hydraulic feed with fast feed option and feature counter clockwise rotation for better operator visibility and safety.
- All models have a dovetail design for smoother action and provide precise feed control for accurate depth of cut metering.

PFM8-14



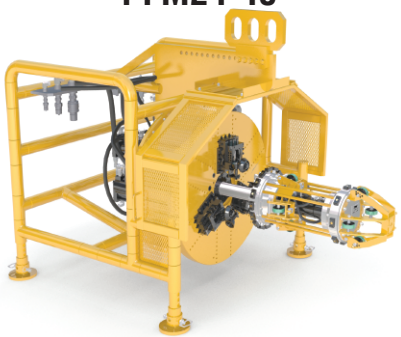
Length	For 8" (203.2 mm) and 10" (254 mm) pipe – 93" (2,375 mm) For 12" (304.8 mm) and 14" (355.6 mm) pipe – 93" (2,375 mm)
Width	For 8" (203.2 mm) and 10" (254 mm) pipe – 61" (1,562 mm) For 12" (304.8 mm) and 14" (355.6 mm) pipe – 61" (1,562 mm)
Height	Min. height - 60-7/16" (1,535.1 mm) Max. height - 75-7/16" (1,916 mm)
Weight	For 8" and 10" pipe - 3,250 lbs (1,477.3 kg) For 12" and 14" pipe - 3,300 lbs (1,522.3 kg)
Operating Pressure	Rotation: 2,000 psi (137.9 bar) @ 40 gpm max. Feed: 600 psi (41.4 bar) @ 2 gpm max. Clamp: 350 psi (24.1 bar)
Cutting Speed	226 surface feet @ 100 rpm on 8" (203.2 mm) pipe 281 surface feet @ 100 rpm on 10" (254 mm) pipe 334 surface feet @ 100 rpm on 12" (304.8 mm) pipe 367 surface feet @ 100 rpm on 14" (355.6 mm) pipe

PFM12-26



Length	110" (2,794 mm)
Width	54" (1,372 mm)
Height	66" (1,676 mm)
Weight	5,000 lbs (2,267 kg)
Operating Pressure	Rotation: 2,000 psi (137.9 bar) @ 40 gpm max. Feed: 600 psi (41.4 bar) @ 2 gpm max. Clamp: 350 psi (24.1 bar)
Cutting Speed	270 surface feet @ 100 rpm – min. 12" (304.8 mm) pipe 488 surface feet @ 100 rpm – min. 22" (558.8 mm) pipe

PFM24-48



Length	142" (3,607 mm)
Width	80" (2,032 mm)
Height	91" (2,311 mm)
Weight	9,000 lbs (4,082 kg)
Operating Pressure	Rotation: 2,000 psi (137.9 bar) @ 40 gpm max. Feed: 600 psi (41.4 bar) @ 2 gpm max. Clamp: 350 psi (24.1 bar)
Cutting Speed	250 surface feet @ 100 rpm – min. 24" (609.6 mm) pipe 377 surface feet @ 100 rpm – min. 36" (914.4 mm) pipe

Darby Hydraulic Power Unit

- Self-contained, skid-mounted unit with dual hydraulic pumps
- Pressure and return line filtration, hydraulic oil cooler and Parker Seal-Lok fittings
- Suction strainers in the hydraulic tank
- Murphy control panel with low oil pressure shutoff

Darby Power Unit



Length	92"(2,337 mm)
Width	75"(1,905 mm)
Height	66 (1676 mm)
Weight	5,000lbs (2,267 kg)
Operating Pressure	2,000psi (137.9 bar) and 1,000 psi (68.9 bar) (dual pump)
Engine	CAT C4.4 Turbo Diesel, 109 hp @ 2,200 rpm
Fuel Capacity	30 gal (151.4 L)
Hydraulic Oil	175 gal (662.4 L)

Darby Pipeline Supplies

GENERAL CLAMP AND TONG, LLC · SAWYER MFG COMPANY · SPY · MATHEY DEARMAN · Bishop Lifting Products, Inc. www.Lifting.com · HPB HEAMAN PIPE BENDING INC. · H&M

Beveling Machines:
Band Type Beveling Machines
Beveling Bands
Compact Cutting & Beveling Machines

External Line-Up Clamps:
Standard Line-Up Clamps
Ratchet Line-Up Clamps
Hydraulic Line-Up Clamps
Gripmaster Line-Up Clamps
Large Diameter Line-Up Clamps

Internal Line-Up Clamps:
Manual Line-Up Clamps
Hydraulic Line-Up Clamps
Screwjack Line-Up Clamps

Lifting & Lowering In Equipment:
Lowering In Belts & Head Irons 12-60
2- and 3-Ply Web Slings Without Metal Ends
2- and 3-Ply Web Slings With Metal Ends
Lined Steel Choker Belts
Round-Up Slings

Electronic Bend Indicator:
AccuBend

Auxiliary Equipment:
Pipe Tongs
Lifting Hooks & Coupon Cutters
Aluminum External Clamps
Manual Pipe Expanders
Hydraulic Dent Removers

Holiday Detectors:
Stick/Shoulder Type Detectors
Spring Electrodes
Jeepmeters

Bending Shoes:
Tractor Bending Shoes
Padded Tractor Shoes
Unpadded Tractor Shoes
Heaman Pipe Bending Sock

DARBY
EQUIPMENT COMPANY

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