



# DMI International



BENDING PIPES, BREAKING EXPECTATIONS

PRODUCT CATALOG



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**DMI INTERNATIONAL, INC.** ("DMI International") is a world-class company dedicated to manufacturing, marketing, and supplying both construction and maintenance equipment to the pipeline industry.

The equipment we offer is designed, engineered and manufactured in our very own state-of-the-art facility. We employ a full staff of Engineers, Technicians, Service Personnel and Sales Specialists. When you buy or lease from DMI International, you are assured of competent, around-the-clock service and support.

We have earned a reputation in the industry for quality and reliability. Whether you need equipment in order to maintain or service a refinery or build a large diameter cross-country pipeline, DMI International is here to supply the equipment you need, fusing it with world class service.

DMI International also employs a full-time staff of Sales Technicians who travel the world helping our many customers. DMI International maintains our corporate headquarters in Tulsa, Oklahoma and has field offices located in Center, Texas; Conroe, Texas; Alice, Texas; Midland, Texas; and Mill Hall, Pennsylvania. We also have facilities in the Middle East, South America and Canada.

Contact us if we can help you with your pipeline needs.

Any questions, inquiries and comments may be directed to:

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# DMI | TOUGH

BENDING PIPES, BREAKING EXPECTATIONS

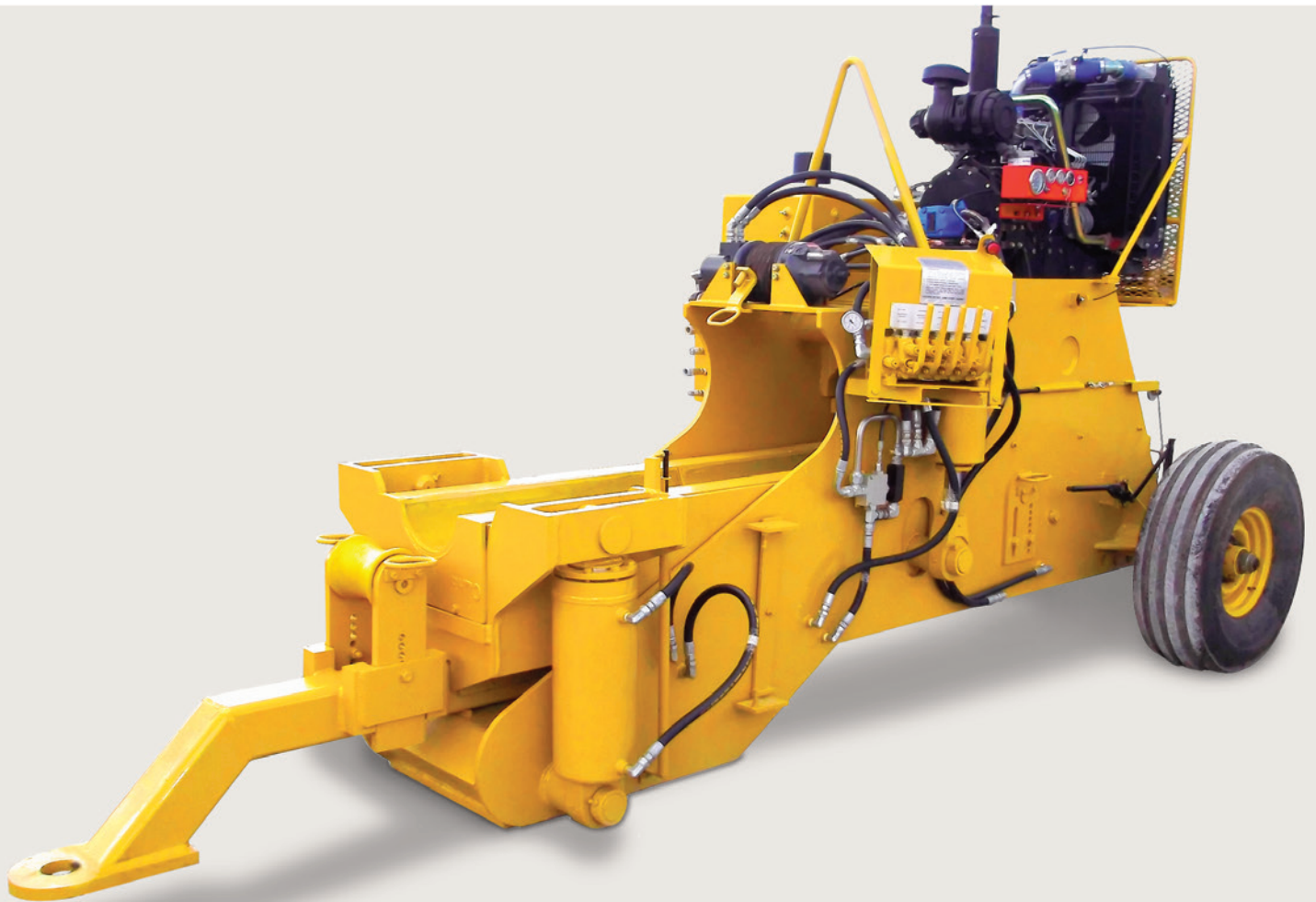




BENDERS

# PIPE BENDING MACHINE

## OPEN FACE 6" - 20"



### Design Features

- Three-Stage Pump option available
- T1 Steel body construction for long life and extra strength
- Calibrated Indicator Rod for precise repeatable pipe bends
- Single operator control station for all functions
- PTFE sealing system in all cylinders
- Designed to bend all grades of API-5L pipe within its range
- Easily towed on the right of way by a suitable tractor
- Towing eye can be raised and lowered by actuating the Stiffback controls



## HYDRAULICS

	BORE (IN)	STROKE (IN)	ROD (IN)
InBoard Cylinder	7	6	2.25
OutBoard Cylinder	8	14	6
Pin Up Cylinder	5	23	2.25
Clamp Cylinder			
Pump Type	Vane, Fix Volume		
Pump Flow	46 gpm		
Valve Type	Manual, 3 or 5 Section		
Filtration	3 Micron, Pressure Line		
Hydraulic System Max Operating Pressure	3000 psig		
Hydraulic Reservoir	50 gal	187.5 L	

## PIPE BENDING CAPACITY

	Dia (in)
Minimum	6.625
Maximum	20

## SPECIFICATIONS

Length	17'-5"	5,309 mm
Width	8'-0"	2,438 mm
Height	7'-7"	2,311 mm
Weight (lbs/kg)	12,700 lbs	5,760 kg
Pneumatic Tire Size	11.0 x 16	

## ENGINES

Perkins Diesel	67	hp
Operating Speed	2200	rpm
Fuel Tank	15	gal

## COMPRESSOR

Manufacturer	Quincy QR-325
Drive Type	Hydraulic Motor
Pressure	210 psig
Flow	17.4 acfm @ 175 psig

## WINCH

Manufacturer	Ramsey
Drive Type	Hydraulic Motor
Pulling Force	10,000 lbf
Cable Diameter	.4375"
Free Wheeling Drum	

## OPTIONS AVAILABLE

- Hydraulic driven air compressors
- Hydraulic mandrel controls with five-section valve & 3/4" access connections
- Tires or Tracks
- Cold weather operating kit (-40°) available

### Disclaimer:

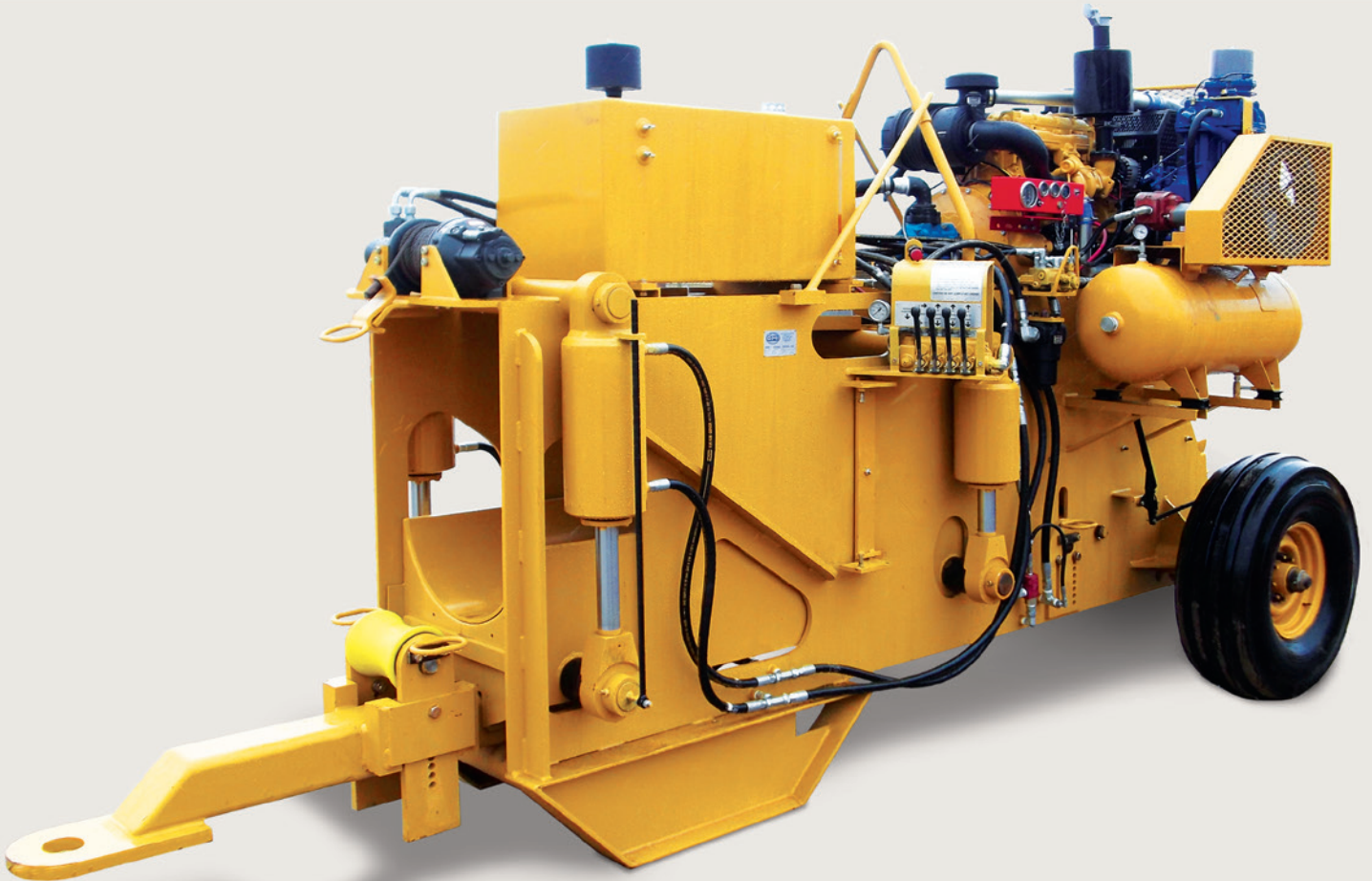
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# PIPE BENDING MACHINE

## STANDARD 6" - 20"



### Design Features

- Two-Stage Pump option available
- T1 Steel body construction for long life and extra strength
- Calibrated Indicator Rod for precise repeatable pipe bends
- Single operator control station for all functions
- PTFE sealing system in all cylinders
- Designed to bend all grades of API-5L pipe within its range
- Easily towed on the right of way by a suitable tractor
- Towing eye can be raised and lowered by actuating the Stiffback controls
- Extended to incorporate ease of loading and unloading pipe
- Featuring "Peak-A-Boo" hole for visual inspection of pipe



## HYDRAULICS

	BORE (IN)	STROKE (IN)	ROD (IN)
InBoard Cylinder	7	6	2.25
OutBoard Cylinder	7	14	6
Pin Up Cylinder	4	23	2.25
Clamp Cylinder			
Pump Type	Vane, Fix Volume		
Pump Flow	24 gpm		
Valve Type	Manual, 4 Section		
Filtration	3 Micron, Pressure Line		
Hydraulic System Max Operating Pressure	3000 psig		
Hydraulic Reservoir	50 gal	187.5 L	

## PIPE BENDING CAPACITY

	Dia (in)
Minimum	6.625
Maximum	20

## SPECIFICATIONS

Length	15'-6"	4,724 mm
Width	6'-9"	2,057 mm
Height	8'-2"	2,489 mm
Weight (lbs/kg)	11,500 lbs	5,227 kg
Pneumatic Tire Size	11.0 x 16	
Track Size	10 Ton	

## ENGINES

Perkins Diesel	99	hp
Operating Speed	2200	rpm
Fuel Tank	15	gal

## COMPRESSOR

Manufacturer	Quincy QR-325
Drive Type	Hydraulic Motor
Pressure	210 psig
Flow	17.4 acfm @ 175 psig

## WINCH

Manufacturer	Ramsey
Drive Type	Hydraulic Motor
Pulling Force	10,000 lbf
Cable Diameter	.4375"
Free Wheeling Drum	

## OPTIONS AVAILABLE

- Caterpillar C4.4 Diesel Engine
- Hydraulic driven air compressors
- Tires or Tracks
- Cold weather operating kit (-40°) available

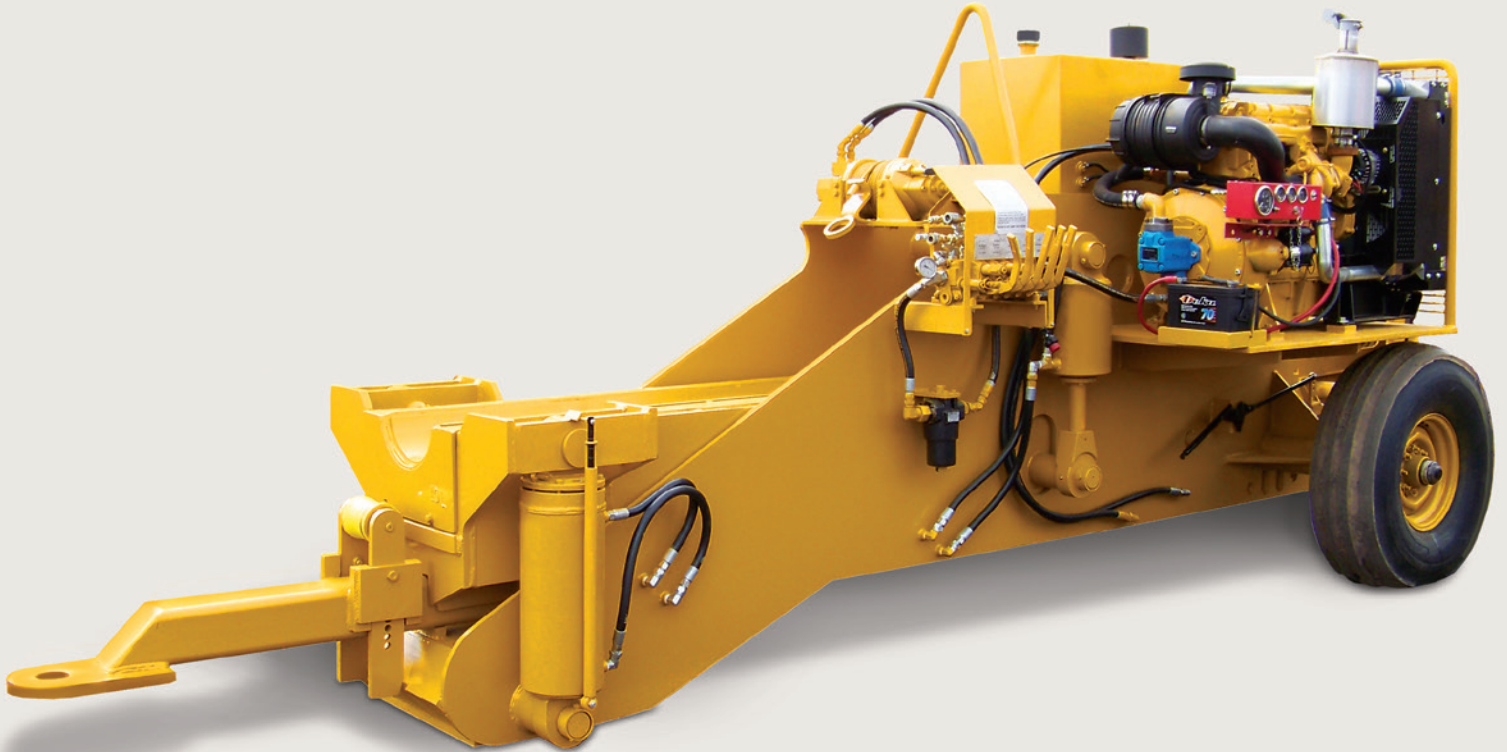
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# PIPE BENDING MACHINE

## SUPER 6" - 20"



### Design Features

- Two-Stage Pump option available
- T1 Steel body construction for long life and extra strength
- Calibrated Indicator Rod for precise repeatable pipe bends
- Single operator control station for all functions
- PTFE sealing system in all cylinders
- Designed to bend all grades of API-5L pipe within its range
- Easily towed on the right of way by a suitable tractor
- Towing eye can be raised and lowered by actuating the Stiffback controls





## HYDRAULICS

	BORE (IN)	STROKE (IN)	ROD (IN)
InBoard Cylinder	8	6	2.25
OutBoard Cylinder	8	14	6
Pin Up Cylinder	5	23	2.25
Clamp Cylinder			
Pump Type	Vane, Fix Volume		
Pump Flow	33 gpm		
Valve Type	Manual, 3 or 5 Section		
Filtration	3 Micron, Pressure Line		
Hydraulic System Max Operating Pressure	3000 psig		
Hydraulic Reservoir	50 gal	187.5 L	

## PIPE BENDING CAPACITY

	Dia (in)
Minimum	6.625
Maximum	20

## SPECIFICATIONS

Length (with wheels)	18'-9"	5,715 mm
Width	7'-7"	2,311 mm
Height	7'-8"	2,337 mm
Weight with Tires (lbs/kg)	14,160 lbs	6,436 kg
Pneumatic Tire Size	11.0 x 16	
Weight with Tracks (lbs/kg)	15,860 lbs	7,194 kg
Track Size	10 Ton	

## ENGINES

Perkins Diesel	109	hp
Operating Speed	2200	rpm
Fuel Tank	15	gal

## COMPRESSOR

Manufacturer	Quincy QR-325
Drive Type	Hydraulic Motor
Pressure	210 pisp
Flow	17.4 acfm @ 175 psig

## WINCH

Manufacturer	Ramsey
Drive Type	Hydraulic Motor
Pulling Force	10,000 lbf
Cable Diameter	.4375"
Free Wheeling Drum	

## OPTIONS AVAILABLE

- Caterpillar C4.4 Diesel Engine
- Hydraulic-driven air compressors
- Hydraulic mandrel controls with five-section valve & 3/4" access connections
- Tires or Tracks
- Cold weather operating kit (-40°) available

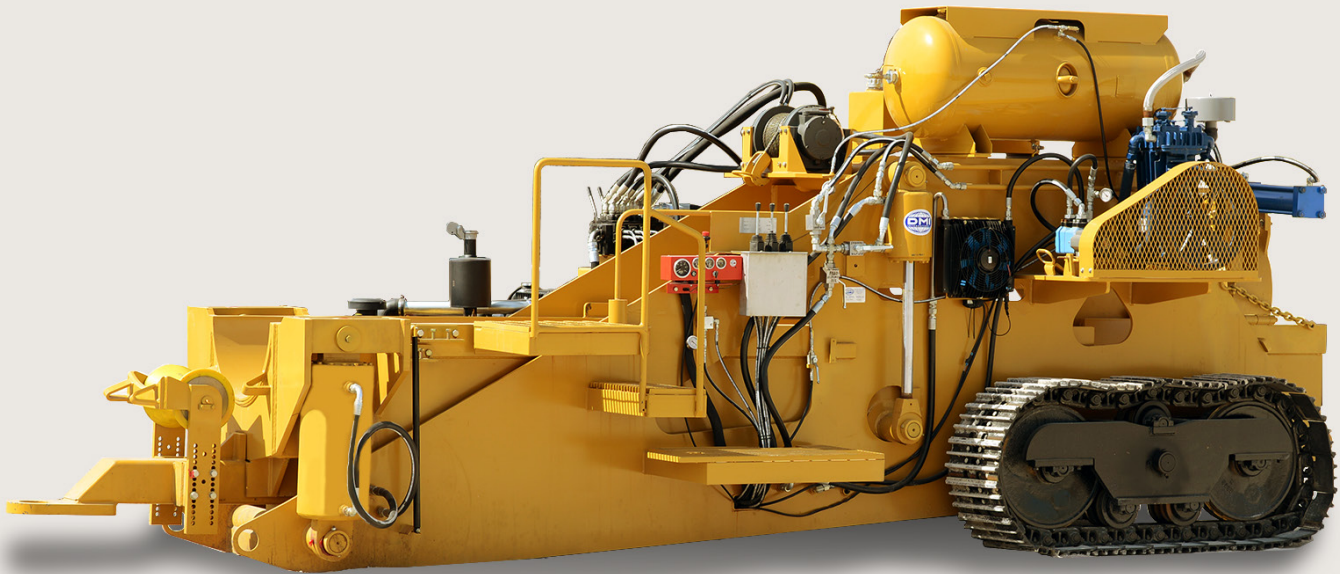
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# PIPE BENDING MACHINE

## SUPER 16" - 30"



### Design Features

- Two-Stage Pump option available
- T1 Steel body construction for long life and extra strength
- Calibrated Indicator Rod for precise repeatable pipe bends
- Single operator control station for all functions
- PTFE sealing system in all cylinders
- Designed to bend all grades of API-5L pipe within its range
- Easily towed on the right of way by a suitable tractor
- Towing eye can be raised and lowered by actuating the Stiffback controls
- Hydraulic remote controls valve system
- Operating warning light
- Safety steps provide access pipe from operator stand
- Control valve sections sized for precise flow and metering
- Loading isolation valves



## HYDRAULICS

	BORE (IN)	STROKE (IN)	ROD (IN)
InBoard Cylinder	8	5	2.25
OutBoard Cylinder	11	18	8
Pin Up Cylinder	6	23	4
Clamp Cylinder			
Pump Type	Vane, Fix Volume		
Pump Flow	48 gpm		
Valve Type	3 or 5 Section		
Filtration	3 Micron, Pressure Line		
Hydraulic System Max Operating Pressure	3000 psig		
Hydraulic Reservoir	85 gal	318.8 L	

## PIPE BENDING CAPACITY

	Dia (in)
Minimum	16
Maximum	30

## SPECIFICATIONS

Length	23'-8"	7,214 mm
Width	8'-6"	2,591 mm
Height	9'-0"	2,743 mm
Weight (lbs/kg)	29,500 lbs	13,409 kg
Track Size	15 Ton	

## ENGINES

Perkins Diesel	109	hp
Operating Speed	2200	rpm
Fuel Tank	25	gal

## COMPRESSOR

Manufacturer	Quincy QR-370
Drive Type	Hydraulic Motor
Pressure	210 pisp
Flow	49.3 acfm @ 175 psig

## WINCH

Manufacturer	Ramsey
Drive Type	Hydraulic Motor
Pulling Force	20,000 lbf
Cable Diameter	.5625"
Free Wheeling Drum	

## OPTIONS AVAILABLE

- Caterpillar C4.4 Diesel Engine
- Hydraulic-driven air compressors
- Hydraulic mandrel controls with five-section valve & 3/4" access connections
- Easy conversion to alternate pipe sizes within the machine range
- Cold weather operating kit (-40°) available

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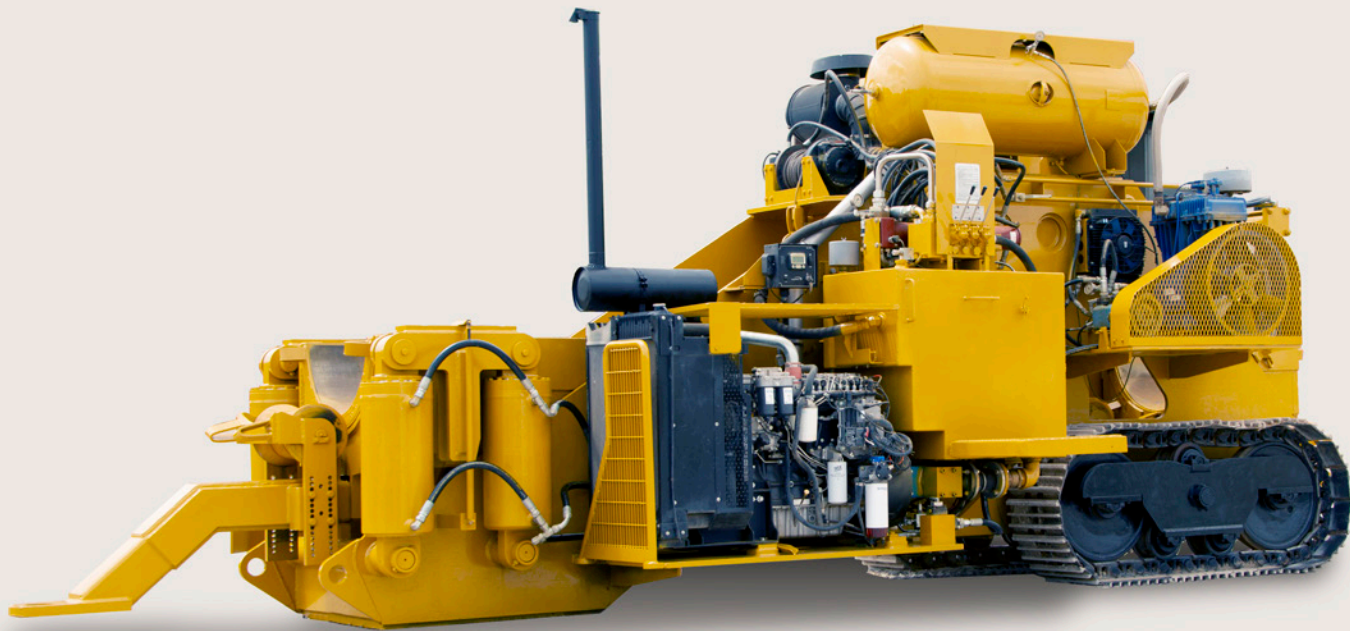
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# PIPE BENDING MACHINE

## SUPER ELITE 22" - 36"



### Design Features

- Two-Stage Pump option available
- T1 Steel Body Construction for long life and extra strength
- Calibrated Indicator Rod for precise repeatable pipe bends
- Single operator control station for all functions
- PTFE sealing system in all cylinders
- Designed to bend all grades of API-5L pipe within its range
- Easily towed on the right of way by a suitable tractor
- Towing eye can be raised and lowered by actuating the Stiffback controls
- Large extra capacity filter
- Control valve sections sized for precise flow and metering
- Best in Class cycle time



## HYDRAULICS

	BORE (IN)	STROKE (IN)	ROD (IN)
InBoard Cylinder	7	5	2.25
OutBoard Cylinder	11	18	8
Pin Up Cylinder	6	23	4
Clamp Cylinder			
Pump Type	Vane, Fix Volume		
Pump Flow	105 gpm		
Valve Type	Manual, 3 or 5 Section		
Filtration	3 Micron, Pressure Line		
Hydraulic System Max Operating Pressure	3000 psig		
Hydraulic Reservoir	125 gal	469 L	

## PIPE BENDING CAPACITY

	Dia (in)
Minimum	22
Maximum	36

## SPECIFICATIONS

Length	25'-0"	7,620 mm
Width	8'-8"	2,642 mm
Height	9'-11"	3,023 mm
Weight (lbs/kg)	57,000 lbs	25,455 kg
Track Size	15 Ton	

## ENGINES

Perkins Diesel	202	hp
Operating Speed	2200	rpm
Fuel Tank	25	gal

## COMPRESSOR

Manufacturer	Quincy QR-390
Drive Type	Hydraulic Motor
Pressure	210 psig
Flow	67.0 acfm @ 175 psig

## WINCH

Manufacturer	Ramsey
Drive Type	Hydraulic Motor
Pulling Force	20,000 lbf
Cable Diameter	.5625"
Free Wheeling Drum	

## OPTIONS AVAILABLE

- Caterpillar C6.6 Diesel Engine
- Hydraulic-driven air compressors
- Cold weather operating kit (-40°) available
- Telemetric performance monitoring

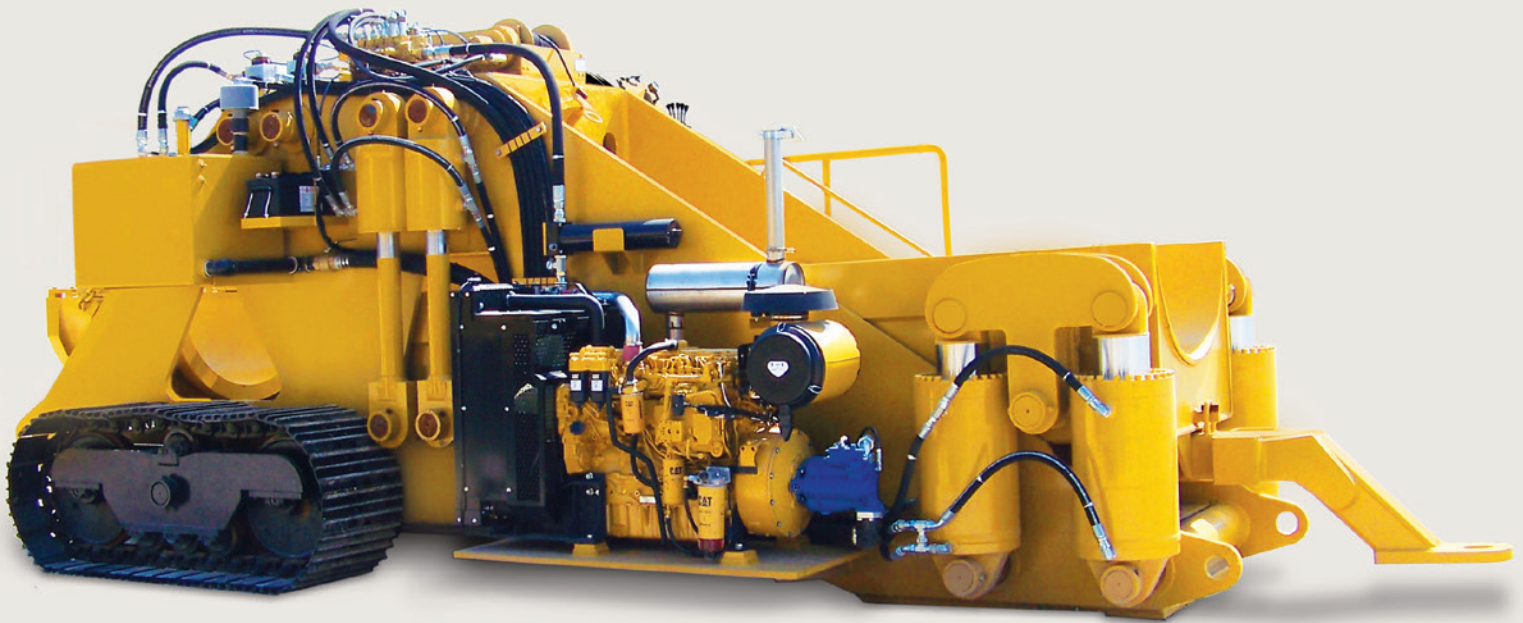
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# PIPE BENDING MACHINE

## **SUPER 32" - 42"**



### **Design Features**

- Two-Stage Pump option available
- T1 Steel body construction for long life and extra strength
- Calibrated Indicator Rod for precise repeatable pipe bends
- Single operator control station for all functions
- PTFE sealing system in all cylinders
- Designed to bend all grades of API-5L pipe within its range
- Easily towed on the right of way by a suitable tractor
- Towing eye can be raised and lowered by actuating the Stiffback controls
- Hydraulic remote controls valve system





## HYDRAULICS

	BORE (IN)	STROKE (IN)	ROD (IN)
InBoard Cylinder	10	5	3.5
OutBoard Cylinder	14	18	8
Pin Up Cylinder	6	23	4
Clamp Cylinder			
Pump Type	Pressure Compensated Piston Pump		
Pump Flow	70 gpm		
Valve Type	3 or 5 Section		
Filtration	3 Micron, Pressure Line		
Hydraulic System Max Operating Pressure	3000 psig		
Hydraulic Reservoir	90 gal		337.5 L

## PIPE BENDING CAPACITY

	Dia (in)
Minimum	32
Maximum	42

## SPECIFICATIONS

Length	26'-0"	7,925 mm
Width	9'-10"	2,997 mm
Height	10'-3"	3,124 mm
Weight (lbs/kg)	78,000 lbs	35,455 kg
Track Size	30 Ton	

## ENGINES

Cat C6.6 Diesel	173	hp
Operating Speed	2200	rpm
Fuel Tank	25	gal

## COMPRESSOR (optional)

Manufacturer	Quincy QR-390, Stand Alone
Drive Type	Deutz Engine
Pressure	210 psig
Flow	67.0 acfm @ 175 psig

## WINCH

Manufacturer	DP
Drive Type	Hydraulic Motor
Pulling Force	20,000 lbf
Cable Diameter	.5625"
Free Wheeling Drum	

## OPTIONS AVAILABLE

- Stand alone air compressor
- Hydraulic mandrel controls with five-section valve & 3/4" access connections
- Cold weather operating kit (-40°) available

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# PIPE BENDING MACHINE

## SUPER 36" - 48"



### Design Features

- Two-Stage Pump option available
- T1 Steel body construction for long life and extra strength
- Calibrated Indicator Rod for precise repeatable pipe bends
- Single operator control station for all functions
- PTFE sealing system in all cylinders
- Designed to bend all grades of API-5L pipe within its range
- Easily towed on the right of way by a suitable tractor
- Towing eye can be raised and lowered by actuating the Stiffback controls
- Hydraulic remote controls valve system



## HYDRAULICS

	BORE (IN)	STROKE (IN)	ROD (IN)
InBoard Cylinder	10	5	4.5
OutBoard Cylinder	14	18	9
Pin Up Cylinder	6	23	4
Clamp Cylinder			
Pump Type	Fix Volume		
Pump Flow	110 gpm		
Valve Type	3 or 5 Section		
Filtration	3 Micron, Pressure Line		
Hydraulic System Max Operating Pressure	2500 psig		
Hydraulic Reservoir	290 gal		

## PIPE BENDING CAPACITY

	Dia (in)
Minimum	36
Maximum	48

## SPECIFICATIONS

Length	32'-6"	9,906 mm
Width	12'-6" *	3,810 mm
Height	11'-2"	3,404 mm
Weight (lbs/kg)	120,750 lbs	54,886 kg
Track Size	50 Ton	

## ENGINES

Cat C7 Diesel	250	hp
Operating Speed	2200	rpm
Fuel Tank	80	gal

\* Actual width may vary

## COMPRESSOR (optional)

Manufacturer	Quincy QR-390, Stand Alone
Drive Type	Deutz Engine
Pressure	210 psig
Flow	67.0 acfm @ 175 psig

## WINCH

Manufacturer	Ramsey
Drive Type	Hydraulic Motor
Pulling Force	20,000 lbf
Cable Diameter	.5625"
Free Wheeling Drum	

## OPTIONS AVAILABLE

- Stand alone air compressor
- Hydraulic mandrel controls with five-section valve & 3/4" access connections
- Cold weather operating kit (-40°) available

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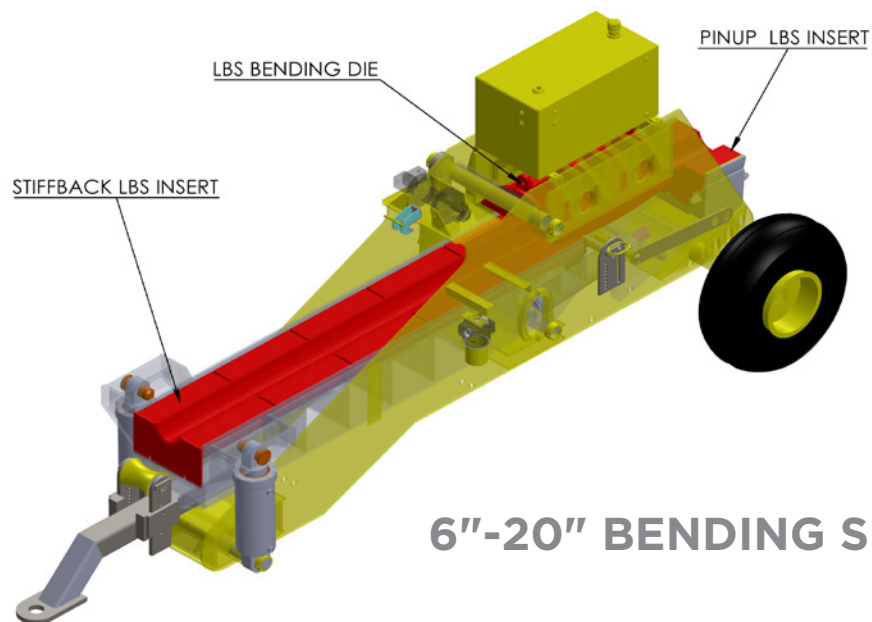
DETERMINATION, MOTIVATION AND INTEGRITY





# BENDING SETS & MANDRELS

# LINED BENDING SETS



**6"-20" BENDING SET**

## SPECIFICATIONS FOR STANDARD 6" - 20" BENDING SETS

		LENGTH		WIDTH		HEIGHT	
		in	mm	in	mm	in	mm
<b>Standard 6 - 20</b>	Stiffback	85.5	2172	21.25	540	10	254
	Pin Up	13.25	337	21.25	540	10	254
	Die	41	1041	24	610	16	406

## STANDARD 6" - 20"

SIZE	WEIGHT	
	lb	kg
6"	1240	563
8"	1280	581
10"	1200	544
12"	1200	544
14"	1440	653
16"	1280	581
18"	1550	703
20"	1175	533

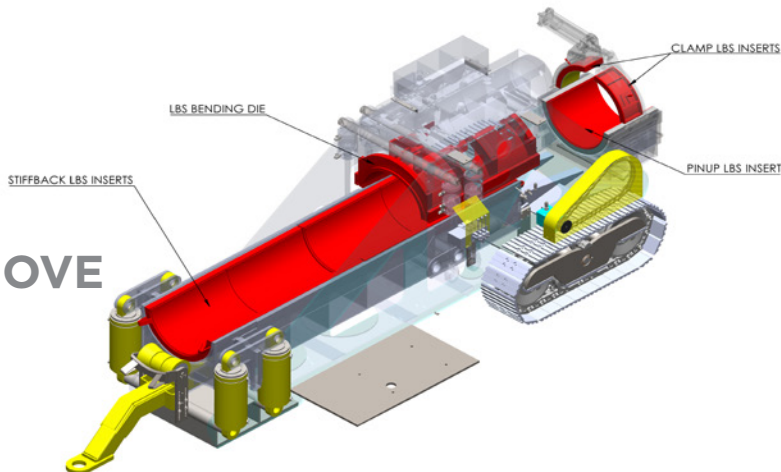
## SPECIFICATIONS FOR SUPER 6" - 20" BENDING SETS

		LENGTH		WIDTH		HEIGHT	
		in	mm	in	mm	in	mm
<b>Super 6 - 20</b>	Stiffback	120.5	3061	21.25	540	10	254
	Pin Up	13.25	337	21.25	540	10	254
	Die	41	1041	24	610	16	406

## SUPER 6" - 20"

SIZE	WEIGHT	
	lb	kg
6"	1300	590
8"	1380	626
10"	1460	662
12"	1460	662
14"	1550	703
16"	1620	735
18"	1840	835
20"	1220	553

Dimensions shown for bending sets are shipping dimensions.



## 16"-30" AND ABOVE BENDING SET

### SPECIFICATIONS FOR SUPER 16" - 30" BENDING SETS

		LENGTH		WIDTH		HEIGHT		CUBE		WEIGHT	
		in	mm	in	mm	in	mm	ft	m	lb	kg
<b>Super 16 - 30</b>	Stiffback	87	2210	30.25	768	14.375	365	140	4	5,260	2,391
	Pin Up	37.4	953	30.25	768	14.375	365				
	Die	70	1778	38	965	27	686				
	Clamps	19.5	495	15	381	10.25	260				

### SPECIFICATIONS FOR SUPER 22" - 36" BENDING SETS

		LENGTH		WIDTH		HEIGHT		CUBE		WEIGHT	
		in	mm	in	mm	in	mm	ft	m	lb	kg
<b>Super 22 - 36</b>	Stiffback	88	2235	36.25	921	17.625	448	160	4.6	6,300	2,864
	Pin Up	37.5	953	36.25	921	17.625	448				
	Die	70	1778	41	1041	28	711				
	Clamps	23.5	597	15	381	10	254				

### SPECIFICATIONS FOR SUPER 32" - 42" BENDING SETS

		LENGTH		WIDTH		HEIGHT		CUBE		WEIGHT	
		in	mm	in	mm	in	mm	ft	m	lb	kg
<b>Super 32 - 42</b>	Stiffback	97	2464	47.25	1200	21.75	553	180	5.1	8,360	3,800
	Pin Up	52	1321	47.25	1200	21.75	553				
	Die	76	1930	48	1219	28	711				
	Clamps	28	711	20	508	10	254				

### SPECIFICATIONS FOR SUPER 36" - 48" BENDING SETS

		LENGTH		WIDTH		HEIGHT		CUBE		WEIGHT	
		in	mm	in	mm	in	mm	ft	m	lb	kg
<b>Super 36 - 48</b>	Stiffback	98	2489	52.25	1327	24.625	626	250	7.1	13,830	6,286
	Pin Up	58	1473	52.25	1327	24.625	626				
	Die	83	2108	52	1321	30.5	775				
	Clamps	33.625	854	16.75	426	14.125	359				

# DMI Hydraulic Pipe Bending Machines 6" - 48" Pipe Bending Data

## Pipe Bending Diameters 6" - 20"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
20/508	0.805	0.694	0.639	0.592	0.515	0.411	0.90	69	27.00
18/457	1.007	0.867	0.798	0.738	0.643	0.511	1.10	52	33.00
16/406	1.299	1.116	1.026	0.949	0.825	0.654	1.50	38	45.00
14/356	1.735	1.492	1.371	1.268	1.101	0.870	1.70	34	51.00
12.75/324	2.106	1.822	1.678	1.553	1.349	1.065	2.30	25	69.00
10.75/273	-	2.479	2.231	2.175	1.921	1.538	2.80	20	84.00
8.625/219	-	-	-	-	2.549	2.224	3.80	15	114.00
6.625/168	-	-	-	-	-	-	4.50	13	135.00

## Pipe Bending Diameters Open Face 6" - 20"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
20/508	1.297	1.116	1.026	0.950	0.826	0.656	0.90	69	27.00
18/457	1.631	1.401	1.288	1.191	1.035	0.819	1.10	52	33.00
16/406	1.735	1.811	1.664	1.538	1.335	1.055	1.50	38	45.00
14/356	2.104	2.390	2.207	2.048	1.784	1.410	1.70	34	51.00
12.75/324	-	-	-	-	2.415	1.724	2.30	25	69.00
10.75/273	-	-	-	-	-	2.373	2.80	20	84.00
8.625/219	-	-	-	-	-	-	3.80	15	114.00
6.625/168	-	-	-	-	-	-	4.50	13	135.00

## Pipe Bending Diameters 16" - 30"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
30/762	1.637	1.410	1.297	1.201	1.046	0.831	0.60	96	16.20
28/711	1.900	1.634	1.502	1.390	1.210	0.960	0.65	88	17.60
26/660	2.231	1.917	1.762	1.630	1.417	1.122	0.70	82	18.90
24/610	-	2.282	2.096	1.938	1.683	1.331	0.75	76	20.30
22/559	-	-	-	2.342	2.034	1.606	0.80	72	21.60
20/508	-	-	-	-	2.500	1.976	0.90	64	24.40
18/457	-	-	-	-	-	2.478	1.10	52	27.00
16/406	-	-	-	-	-	-	1.51	38	32.40





## Pipe Bending Diameters 22" - 36"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
36/914	1.179	1.020	0.937	0.869	0.758	0.604	0.50	115	13.95
34/864	1.329	1.150	1.055	0.978	0.853	0.679	0.55	104	15.43
32/813	1.511	1.300	1.990	1.110	0.967	0.769	0.58	98	16.37
30/762	1.735	1.495	1.374	1.272	1.108	0.880	0.60	95	16.89
28/711	-	1.732	1.592	1.473	1.281	1.017	0.65	88	18.23
26/660	-	-	1.868	1.728	1.501	1.189	0.70	82	19.56
24/610	-	-	-	-	1.785	1.411	0.75	76	21.11
22/559	-	-	-	-	-	1.703	0.80	72	22.28

## Pipe Bending Diameters 32" - 42"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
42/1067	1.804	1.555	1.432	1.327	1.157	0.921	0.50	115	12.46
40/1016	-	1.724	1.587	1.469	1.280	1.018	0.50	115	12.46
38/965	-	1.922	1.768	1.637	4.426	1.133	0.50	115	12.46
36/914	-	-	1.984	1.836	1.598	1.268	0.50	115	12.46
34/864	-	-	-	-	1.804	1.430	0.50	115	12.46
32/813	-	-	-	-	-	1.626	0.50	115	12.46

## Pipe Bending Diameters 36" - 48"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
48/1219	-	-	-	1.813	1.580	1.256	0.50	115	12.46
46/1168	-	-	-	1.983	1.727	1.372	0.50	115	12.46
44/1118	-	-	-	-	1.897	1.506	0.50	115	12.46
42/1067	-	-	-	-	-	1.660	0.50	115	12.46
40/1016	-	-	-	-	-	1.840	0.50	115	12.46
38/965	-	-	-	-	-	-	0.50	115	12.46
36/914	-	-	-	-	-	-	0.50	115	12.46

# DMI Hydraulic Pipe Bending Machines 6" - 48" Pipe Bending Data

## Pipe Bending Diameters Super 6" - 20"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
20.866/530	1.139	0.9881	0.902	0.8356	0.728	0.578	.83	69	24.90
20/508	1.248	1.074	0.987	0.914	0.796	0.632	.83	69	24.90
18/457	1.568	1.348	1.238	1.145	0.996	0.789	1.10	52	33.00
16/406	2.023	1.741	1.600	1.479	1.284	1.015	1.51	38	45.30
14/356	-	2.303	2.126	1.971	1.715	1.356	1.70	34	51.00
12.75/324	-	-	-	2.371	2.083	1.659	2.30	25	69.00
10.75/273	-	-	-	-	-	2.299	2.86	20	85.80
8.625/219	-	-	-	-	-	-	3.82	15	114.60
6.625/168	-	-	-	-	-	-	4.41	13	132.20

## Pipe Bending Diameters Super 16" - 30"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
30/762	1.792	1.543	1.419	1.314	1.144	0.908	0.60	96	16.71
28/711	2.08	1.789	1.645	1.522	1.324	1.050	0.65	88	18.23
26/660	-	2.101	1.93	1.785	1.551	1.228	0.70	82	19.56
24/610	-	-	2.297	2.124	1.844	1.458	0.75	76	21.11
22/559	-	-	-	-	2.228	1.759	0.80	72	22.28
20/508	-	-	-	-	-	2.165	0.90	64	25.07
18/457	-	-	-	-	-	-	1.10	52	30.85
16/406	-	-	-	-	-	-	1.51	38	42.22

## Pipe Bending Diameters Super 22" - 36"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
36/914.4	2.363	2.033	1.869	1.73	1.506	1.195	0.50	115	13.95
34/864	-	2.299	2.113	1.955	1.700	1.348	0.55	104	15.43
32/813	-	2.623	2.41	2.228	1.936	1.533	0.58	98	16.37
30/762	-	-	-	2.563	2.226	1.760	0.60	95	16.89
28/711	-	-	-	-	2.586	2.042	0.65	88	18.23
26/660	-	-	-	-	-	2.399	0.70	82	19.56
24/610	-	-	-	-	-	-			
22/559	-	-	-	-	-	-			



## Pipe Bending Diameters Super 32" - 42"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
42/1066.8	2.991	2.572	2.365	2.188	1.904	1.51	0.50	115	12.46
40/1016	-	-	-	2.430	2.112	1.674	0.50	115	12.46
38/965	-	-	-	-	2.358	1.866	0.50	115	12.46
36/914	-	-	-	-	-	2.095	0.50	115	12.46
34/864	-	-	-	-	-	-	0.50	115	12.46
32/813	-	-	-	-	-	-	0.50	115	12.46

## Pipe Bending Diameters Super 36" - 48"

NOMINAL PIPE O.D.	MAXIMUM WALL THICKNESS BY GRADE						RECOMMENDED BEND		
IN/MM	X52	X60	X65	X70	X80	X100	DEGREE PER ARC FOOT	RADIUS FEET	MAXIMUM 40 FOOT JOINT
48/1219.2	-	-	-	2.766	2.405	1.907	0.50	115	12.46
46/1168	-	-	-	3.032	2.635	2.087	0.50	115	12.46
44/1118	-	-	-	-	2.900	2.294	0.50	115	12.46
42/1067	-	-	-	-	3.207	2.535	0.50	115	12.46
40/1016	-	-	-	-	-	2.816	0.50	115	12.46
38/965	-	-	-	-	-	3.149	0.50	115	12.46
36/914	-	-	-	-	-	-	0.50	115	12.46

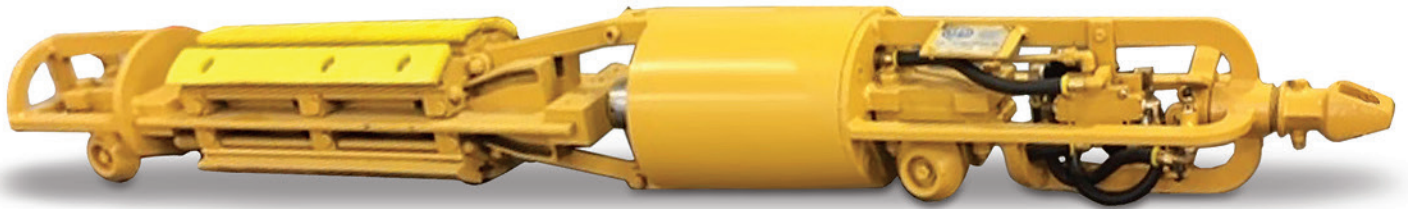
- A cell marked with a (-) represents the ability to bend up to 2.00" thick. For wall thickness greater than that, contact DMI.
- Figures above represent empirical data and are recommendation only. They do not constitute a warranty.
- All bends are based on the use of DMI mandrels and approved Die Sets.
- For heavy wall pipe special Die Sets may be required.
- Figures shown above are provided as "Average" and will vary depending on the following:
  - Actual wall thickness of the pipe.
  - Actual Yield Stress of the pipe.
  - Skill of the Operators handling the Bending Machine and Mandrel.
  - Origin and Quality of the pipe.
  - Type of Die and Bending Set being used.
- Normal unbend tangent for PBM 6-20 is 5'
- Normal unbend tangent for PBM 16-30 is 6'
- Normal unbend tangent for PBM 22-36 is 6'
- Normal unbend tangent for PBM 32-42 is 7'
- Normal unbend tangent for PBM 48-60 is:
  - 11' for Stiffback end with pipe support
  - 13' for Stiffback end with NO pipe support
  - 8' for Pinup end with pipe support
  - 9' for Pinup end with NO pipe support

### Disclaimer:

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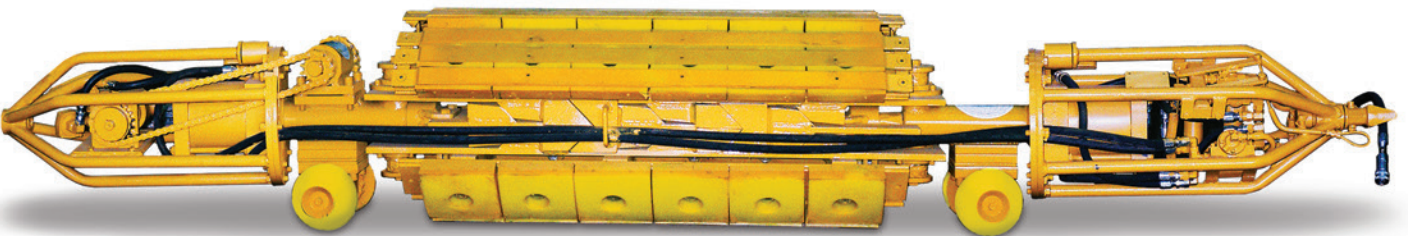
# PNEUMATIC WEDGE MANDREL



6" and 8"



10" - 12"



12" - 20"

## Pneumatic Wedge Mandrels

- Helps reduce buckling and out of round in the bend
- Adjustable for any wall thickness within specified mandrel range
- Pneumatic wedge mandrels are available in pipe sizes from 24" - 60" diameter
- For efficient operation the compressed air pressure should be 180 - 200 PSI (12.4 - 13.8 Bar)
- Maximum safe working pressure is 225 PSI (15.5 Bar)
- One man operated for expansion and contracting
- Powered travel available for 12" - 20" and up



## PNEUMATIC WEDGE MANDREL

MODEL	PIPE SIZE		LENGTH		WIDTH		HEIGHT		VOLUME		WEIGHT	
	in	mm	in	mm	in	mm	in	mm	cu-ft	cu-m	lbs	kg
<b>PWM 6</b>	6	152	61	1549	6	152	6	152	1.3	0.04	150	68
<b>PWM 8</b>	8	203	71	1803	8.5	216	8.5	216	3.0	0.08	200	91
<b>PWM 10-12</b>	10-12	254-305	88	2235	11.5	292	11.5	292	6.7	0.19	564	256
<b>PWM 12-14</b>	12-14	305-356	108	2743	11	279	11	279	7.6	0.21	680	309
<b>PWM 16</b>	16	406	108	2743	14	356	14	356	12.3	0.35	754	343
<b>PWM 18-20</b>	18-20	457-508	108	2743	18	457	18	457	20.3	0.57	820	373
<b>PWM 20-22</b>	20-22	508-559	124	3150	18	457	18	457	23.3	0.66	950	432
<b>PWM 24-26</b>	24-26	610-660	140	3556	20	508	20	508	32.4	0.92	2310	1050
<b>PWM 28-30</b>	28-30	711-762	140	3556	26	660	26	660	54.8	1.55	2700	1227
<b>PWM 30-32</b>	30-32	762-813	140	3556	27	686	27	686	59.1	1.67	3200	1455
<b>PWM 34-36</b>	34-36	864-914	125	3175	31	787	31	787	69.5	1.97	4500	2045
<b>PWM 36-38</b>	36-38	914-965	160	4064	32	813	32	813	95	2.68	5650	2568
<b>PWM 40-42</b>	40-42	1016-1067	160	4064	38	965	38	965	134	3.79	6350	2886
<b>PWM 42-44</b>	42-44	1067-1118	160	4064	38	965	38	965	134	3.79	6350	2886
<b>PWM 46-48</b>	46-48	1168-1219	150	3810	43	1092	43	1092	161	4.54	7000	3182
<b>PWM 52</b>	52	1321	186	4724	45	1143	47	1194	228	6.45	10000	4545
<b>PWM 56</b>	56	1422	186	4724	46	1168	50	1270	248	7.01	12000	5455
<b>PWM 60</b>	60	1524	186	4724	50	1270	54	1372	291	8.23	15000	6818

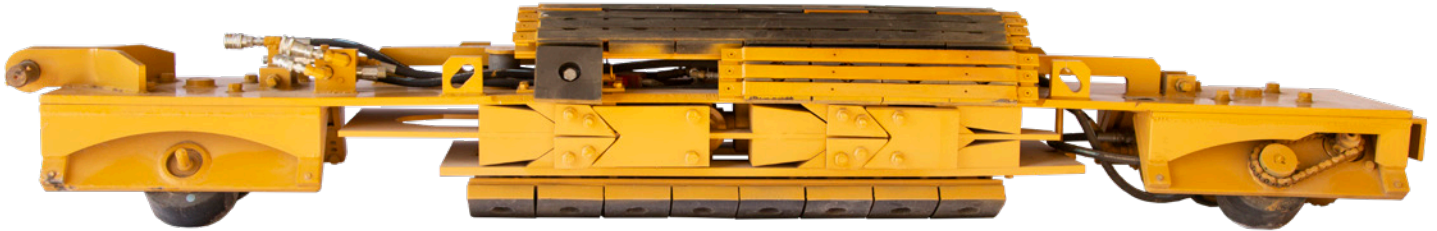
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# HYDRAULIC WEDGE MANDREL

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## Hydraulic Wedge Mandrels

The DMI Wedge Mandrel is used specifically to meet bending requirements of X65 and higher grade pipes. Operator controls all functions of the mandrel.

- Helps reduce buckling and out of round in the bend
- Power is provided by the bending machine hydraulic system or by an auxiliary power unit
- Models cover pipe sizes 24" - 60"

**PIPE RANGES**    24" - 30"   |   30" - 36"   |   36" - 42"   |   40"- 48"   |   52" - 60"

- Fast approach and powerful locking action is provided by double angle hardened steel wedges
- Auxiliary hydraulic power units and conversion kits (within mandrel's range) available at additional cost
- Non-Powered available 6" - 20"
- Powered available 12" - 60"

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### HYDRAULIC WEDGE MANDREL

MODEL	PIPE SIZE		LENGTH		WIDTH		HEIGHT		VOLUME		WEIGHT	
	in	mm	in	mm	in	mm	in	mm	cu-ft	cu-m	lbs	kg
<b>HWM 10</b>	10	254	90	2286	9.5	241	8.5	216	4.2	0.12	405	184
<b>HWM 12</b>	12	305	84	2134	9.5	241	10.5	267	4.8	0.14	437	199
<b>HWM 14</b>	14	356	84	2134	11	279	11	279	5.9	0.17	475	216
<b>HWM 16</b>	16	406	84	2134	11	279	13	330	7.0	0.20	750	341
<b>HWM 18</b>	18	457	92	2337	15	381	15	381	12.0	0.34	1025	466
<b>HWM 20</b>	20	508	92	2337	16	406	17	432	14.5	0.41	1250	568
<b>HWM 12-16</b>	12-16	305-406	84	2134	11	279	13	330	7.0	0.20	750	341

### MULTIPLE SIZE HYDRAULIC WEDGE MANDREL

MODEL	PIPE SIZE		LENGTH		WIDTH		HEIGHT		VOLUME		WEIGHT	
	in	mm	in	mm	in	mm	in	mm	cu-ft	cu-m	lbs	kg
<b>MHWM 24-26</b>	24-26	610-660	128	3251	22	559	21.5	546	35.0	0.99	2400	1091
<b>MHWM 28-30</b>	28-30	711-762	128	3251	25.5	648	24.5	622	46.3	1.31	2600	1182
<b>MHWM 30-32</b>	30-32	762-813	121	3073	31	787	30	762	65.1	1.84	2800	1273
<b>MHWM 34-36</b>	34-36	864-914	121	3073	29	737	30	762	60.9	1.73	3000	1364
<b>MHWM 36-38</b>	36-38	914-965	121	3073	29	737	30	762	60.9	1.73	4500	2045
<b>MHWM 38-40</b>	38-40	965-1016	128	3251	33	838	31.5	800	77.0	2.18	5750	2614
<b>MHWM 40-42</b>	40-42	1016-1067	121	3073	34	864	33	838	78.6	2.22	6000	2727
<b>MHWM 46-48</b>	46-48	1168-1219	128	3251	40	1016	38.5	978	114.1	3.23	7500	3409
<b>MHWM 52-54</b>	52-54	1321-1372	144	3658	54.5	1384	43	1092	195.3	5.53	13000	5909
<b>MHWM 56</b>	56	1422	144	3658	56.5	1435	47	1194	221.3	6.27	14500	6591
<b>MHWM 58-60</b>	58-60	1473-1524	144	3658	58.5	1486	49	1245	238.9	6.76	16750	7614





# DMI | SERVICE

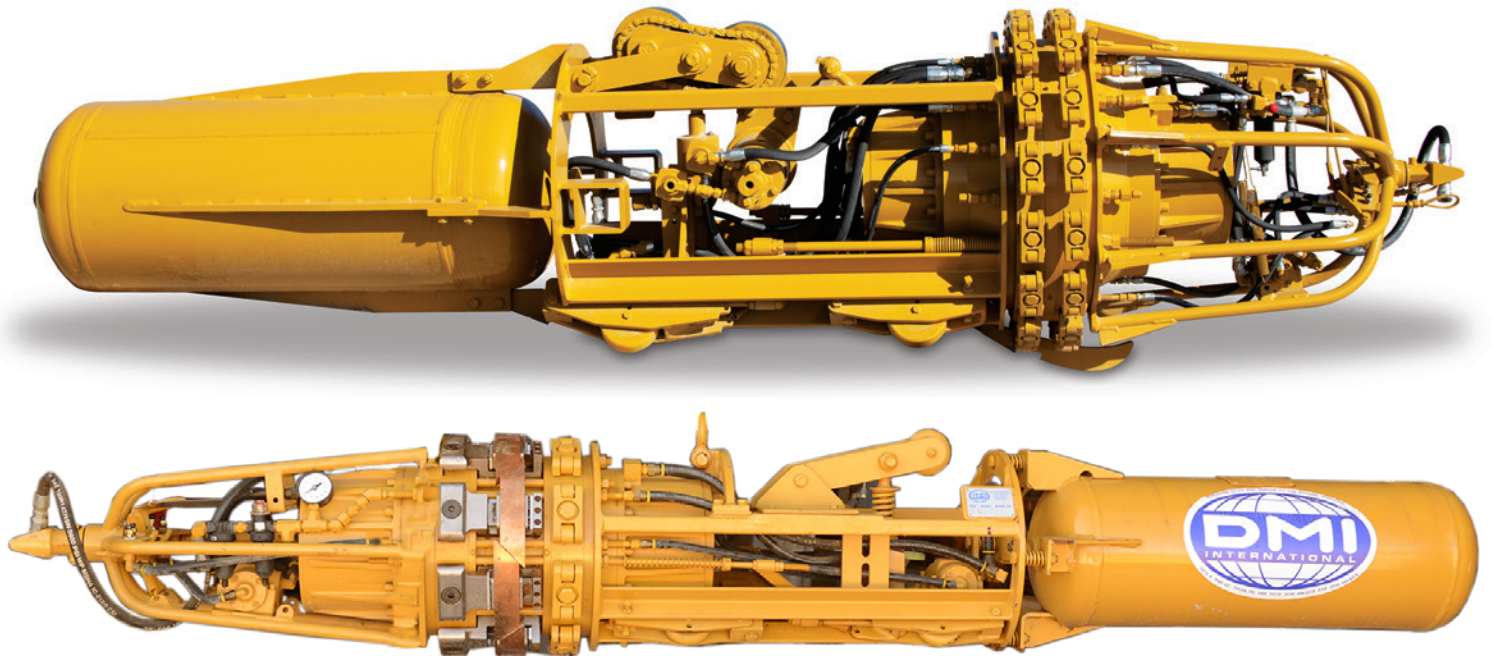
SERVICE AND SUPPORT YOU CAN COUNT ON





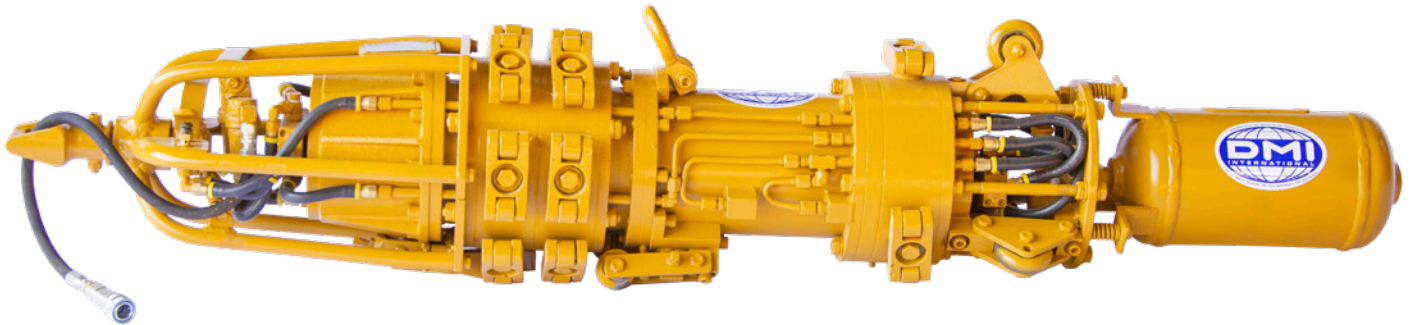
CLAMPS & CRADLES

# CLAMPS



## **Pneumatic Clamp and Pneumatic Clamp with Copper Backup Shoes**

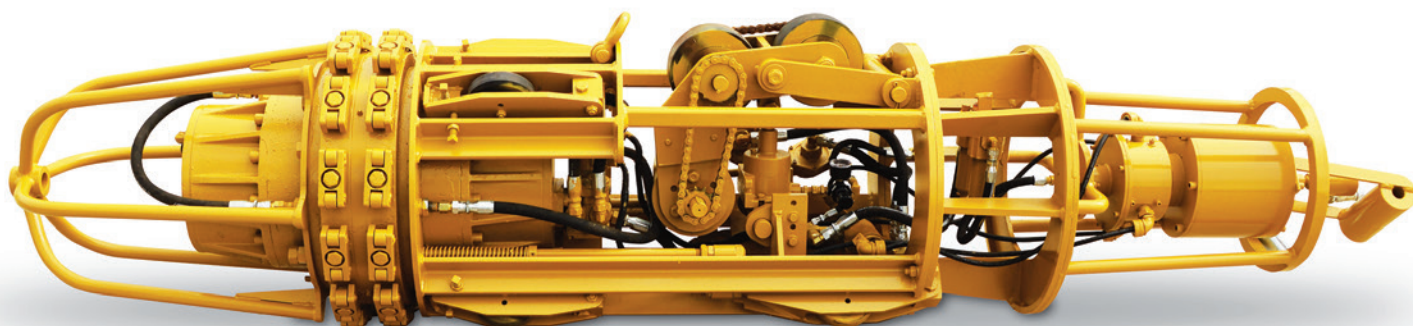
- Standard sizes 6"-60", available upon request
- Clamps 12"-60" will cover two pipe sizes by use of conversion kits
- Adjustable for various wall thickness within clamp's range
- Powered travel drive available on models 12"-60"
- For efficient operation the compressed air pressure should be 180-200 PSI. (12.4-13.8 Bar)
- Maximum safe working pressure is 225 PSI (15.5 Bar)



## **Self-Centering Internal Pneumatic Lineup Clamp**

- Automatic centering mechanism helps reduce Hi-Lo
- Adjustable for various wall thickness within clamp's range
- Spring mounted reserve air tank provides sufficient air pressure for lining up incoming pipe joint
- For efficient operation the compressed air pressure should be 180 - 200 PSI (12.4 - 13.8 Bar)
- Maximum safe working pressure is 225 PSI (15.5 Bar)
- Pneumatic automatic centering clamps available in sizes 6" - 14"
- Optional copper back-up shoes





### Internal Pneumatic Double Joint Clamp

- Designed specifically for use with a Double Joint Rack
- Available in sizes 16" to 60" and adjustable for various wall thickness within clamp's range
- Copper back-up shoes help prevent burn through
- For efficient operation the compressed air pressure should be 180-200 PSI. (12.4-13.8 Bar)
- Maximum safe working pressure is 225 PSI (15.5 Bar)
- Easy removal and installation of copper back-up shoes

#### NON POWERED CLAMP, PULL TYPE

MODEL	PIPE SIZE		LENGTH		WIDTH		HEIGHT		VOLUME		WEIGHT	
	inch	mm	inch	mm	inch	mm	inch	mm	cu-ft	cu-m	lbs	kg
IPLC 6	6	152	38	965	5.5	140	6.5	165	0.8	0.02	98	45
IPLC 8	8	203	50	1270	7.5	191	7.5	191	1.6	0.05	130	59
IPLC 10 2-section	10	254	58	1473	12	305	12	305	4.8	0.14	178	81
IPLC 10 3-section	10	254	58	1473	12	305	12	305	4.8	0.14	212	96
IPLC 12 2-section	12-14	324-356	60	1524	10.75	273	10.75	273	4.0	0.11	204	93
IPLC 12 3-section	12-14	324-356	60	1524	10.75	273	10.75	273	4.0	0.11	257	117
IPLC 14-16	14-16	356-406	67	1702	13	330	13.5	343	6.8	0.19	225	102
IPLC 18-20	18-20	457-508	96	2438	16.5	419	18.5	470	17.0	0.48	418	190

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# CLAMPS

POWERED CLAMP, LINE TRAVEL													
MODEL	PIPE SIZE		LENGTH		WIDTH		HEIGHT		VOLUME		WEIGHT		CFM
	in	mm	in	mm	in	mm	in	mm	cu-ft	cu-m	lbs	kg	
<b>IPLC 10</b>	10	254	62	1575	10	254	11.5	292	4.1	0.12	300	136	25
<b>IPLC 12-14</b>	12-14	305	109	2769	10.75	273	10.75	273	7.3	0.21	294	133	25
<b>IPLC 14-16</b>	14-16	356-406	112.5	2858	15	381	15	381	14.6	0.41	550	240	25
<b>IPLC 16-18</b>	16-18	406-457	91	2311	13	330	13	330	8.9	0.32	500	227	25
<b>IPLC 20-22</b>	20-22	508-559	102	2591	18	457	18	457	19.1	0.69	770	349	40
<b>IPLC 24-26</b>	24-26	610-660	111	2819	21	533	21	533	28.3	1.05	1010	458	40
<b>IPLC 28-30</b>	28-30	711-762	115	2870	28	711	28	711	52.2	1.45	1290	585	40
<b>IPLC 30-32</b>	30-32	762-813	115	2870	28	711	28	711	52.2	1.73	1400	635	40
<b>IPLC 34-36</b>	34-36	864-914	122	3099	34	864	35.5	902	85.2	2.41	1700	773	90
<b>IPLC 36-38</b>	36-38	914-965	128	3251	36	914	37.5	953	100.0	2.83	1750	795	90
<b>IPLC 40-42</b>	40-42	1016-1067	141	3581	38	965	38	965	117.8	3.94	3100	1406	90
<b>IPLC 46-48</b>	46-48	1168-1219	145	3683	45	1143	46.5	1181	175.6	4.97	3140	1427	90
<b>IPLC 52-54</b>	52-54	1321-1372	188	4775	52	1321	53.5	1359	302.7	8.57	4950	2250	90
<b>IPLC 56</b>	56	1422	188	4775	54	1372	55.5	1410	326.1	9.23	5400	2455	90
<b>IPLC 60</b>	60	1524	191	4851	58	1473	60	1524	384.7	10.89	6000	2727	90

## Standard Features

- 40' reach rod (125 lbs)
- 125' air hose (25 lbs)
- Standard Steel Pipe Compatibility (24"-up)

## Additional Cost Features

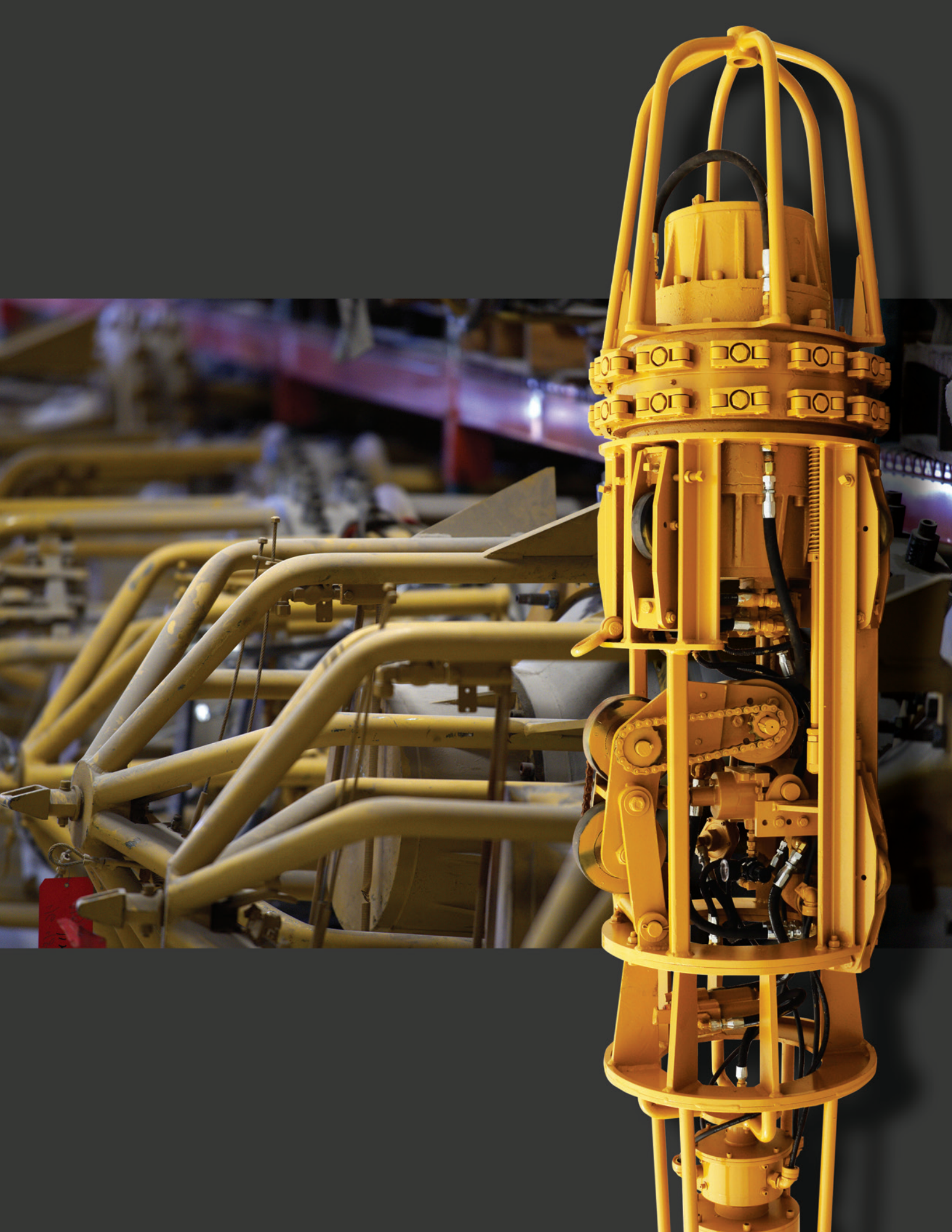
- Dual side drive, capability of 35 degree grade
- Stainless steel pipe compatibility
- Storage skid
- Additional reach rod
- Emergency braking system

### Disclaimer:

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# ROLLER CRADLES

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## Design Features

- Various cradle assemblies for pipe sizes 6" (152MM) through 60" (1524MM) welded seam hang-up
- Slings for pipe sizes 2" (51MM) through 24" (610MM)
- Designed load capacity ensures safe handling of heavy wall pipe
- Multiple urethane rollers spaced to support the pipe evenly
- The wire rope assembly meets ANSI B-30-9 sling requirements, OSHA 1910.184 sling requirements and OSHA 1926.251 material handling requirements
- **Replacement urethane cradle rollers available**



CRADLES			
SIZE	NUMBER OF ROLLERS PER ROLLER STRAND (2 ROLLER STRANDS)	MAXIMUM RECOMMENDED WORKING LOAD	
IN		LB	KG
6"-12"	10	15,600	7,076
12"-24"	14	28,662	13,001
24"-36"	12	56,500	25,628
36"-48"	16	69,390	31,475
48"-60"	18	105,380	47,800



Note: Single cradle has 1 cable strand looped over the head iron  
Dual cradle has 2 cable strands looped over the head iron

CRADLES									
SIZE		LENGTH		WIDTH		HEIGHT		WEIGHT	
IN	MM	IN	MM	IN	MM	IN	MM	LB	KG
6"-12"	152-305	42"	1067	22"	559	30"	762	750	340
12"-24"	305-610	42"	1067	36"	914	36"	914	800	363
24"-36"	610-914	56"	1422	60"	1524	36"	914	2892	1312
36"-48"	914-1219	56"	1422	72"	1829	42"	1067	3794	1721
48"-60"	1219-1524	56"	1422	84"	2134	48"	1219	7240	3284

NOTE: Dimensions are with units collapsed for shipping. A safety factor of 5:1 is used to determine working loads. Capacities should be recalculated if local laws or regulations require a different safety factor.

**CAUTION:** Care must be taken to be sure the recommended working load is not exceeded in use.  
Custom sizes available upon request.

SLINGS					
SIZE	NUMBER OF ROLLERS PER SLING	WEIGHT		MAXIMUM RECOMMENDED WORKING LOAD	
IN		LB	KG	LB	KG
2"-8"	3	36	16	15,600	7,075
8"-12"	5	56	25	15,600	7,075
12"-24"	7	76	34	15,600	7,075



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# DMI DEPENDABLE

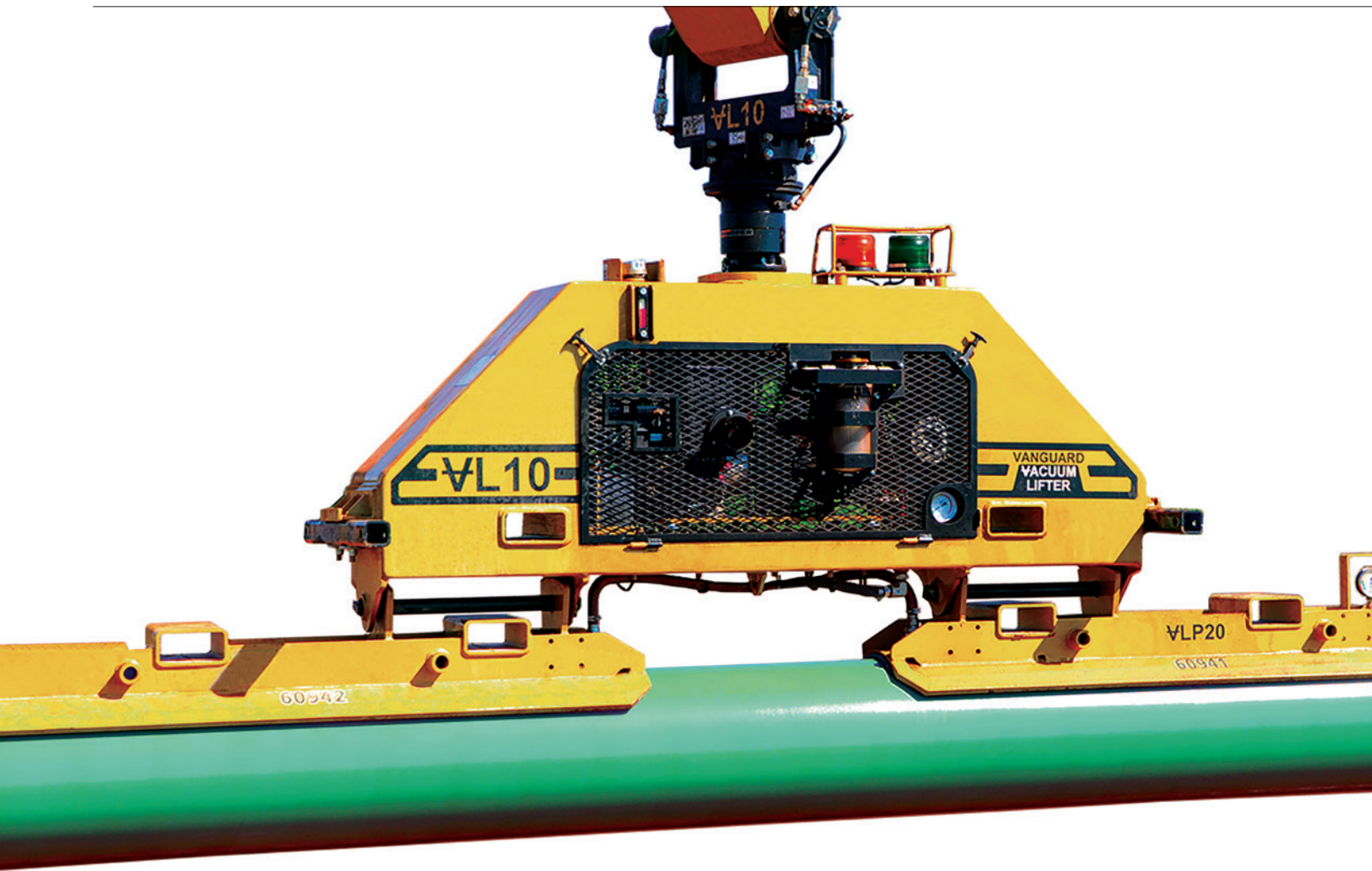
WHEN IT MATTERS





SUPPORTING EQUIPMENT

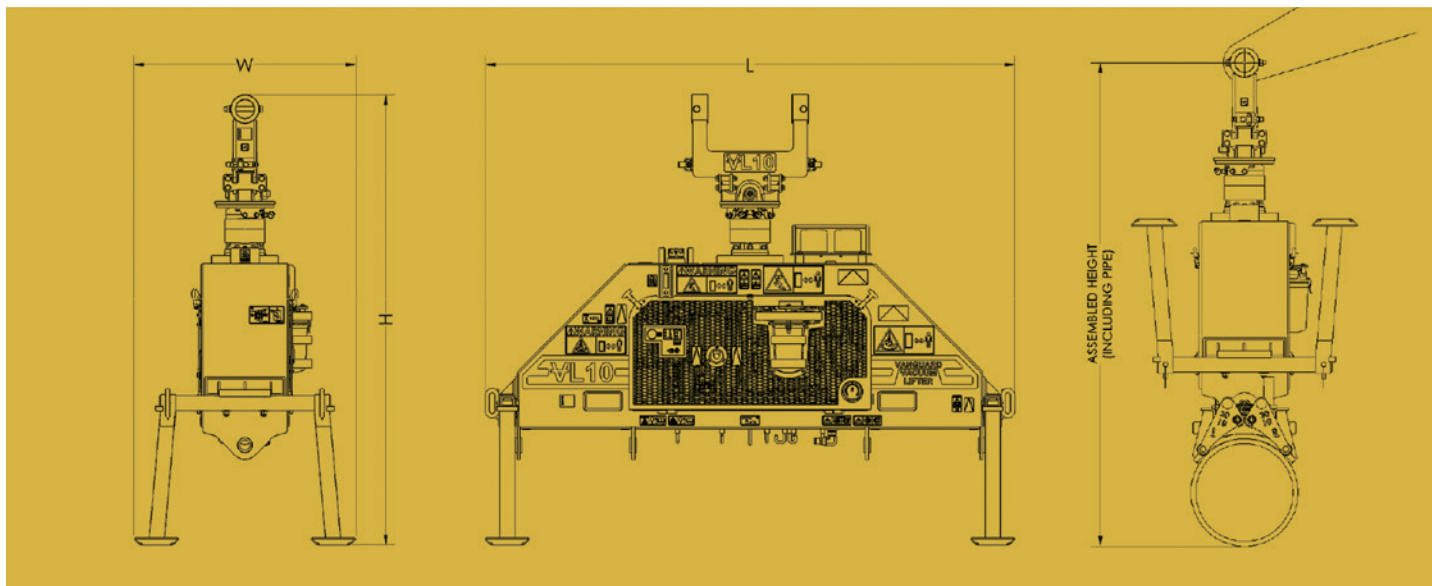
# VACUUM LIFTERS



## Design Features

- Built to the highest safety standards: meets or exceeds ASME B30.20 and ASME BTH-1 specifications. Designed to Design Category “B” and Service Class “2” with substantially higher number of cycles: between 100,000 and 500,000 for greatly improved safety and reliability over majority of similar units, which are typically Service Class “O” designed for 0 to 20,000 cycles.
- Extensive Vacuum Lifter and Pad Attachment testing, exceeding US required standards ensures safe load holding capability.
- Large, intuitive Operators Panel with complete lockout function for safe storage and prevents unauthorized start up during maintenance.
- Integrated, foldable tank stand legs allow stowing the unit with pads attached, without the need of carrying an additional large and heavy support frame. Simple operation requires pulling out pins and flipping legs up out of the way.
- Integrated foldable pad stand legs and forklift sockets allow for easy storage and moving pad attachments without destroying the seal. Pads are stored seal down to extend seal life due to minimizing UV exposure.
- Eco oil drain hoses for all components, and diesel fuel tank drain speed up maintenance and keep machine and environment clean.





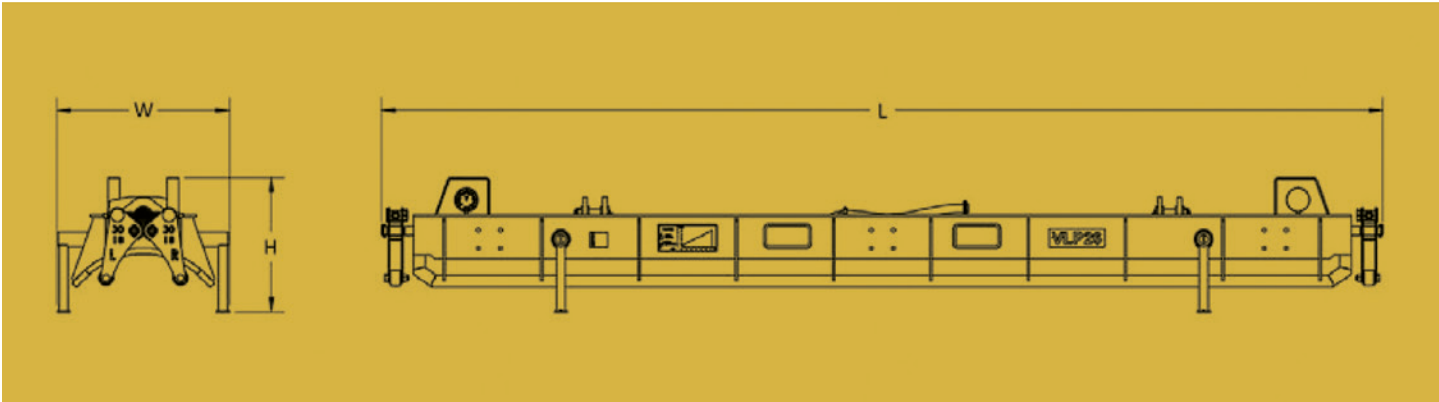
## VACUUM LIFTERS

MODEL	VL10	VL12	VL16
<b>Lifting Capacity</b>	10 tonnes 22,000 lb	12 tonnes 26,500 lb	16 tonnes 32,275 lb
<b>Working Dimensions (L/W/H)</b>	112/47/94 inches 2.8/1.1/2.3 m	112/47/91 inches 2.8/1.1/2.3 m	112/47/92 inches 2.8/1.1/2.3 m
<b>Operating Weight</b>	1365 kg 3010 lb	1375 kg 3025 lb	1395 kg 3070 lb



# VACUUM LIFTERS

## LIFTING PADS VLP4 - VLP20

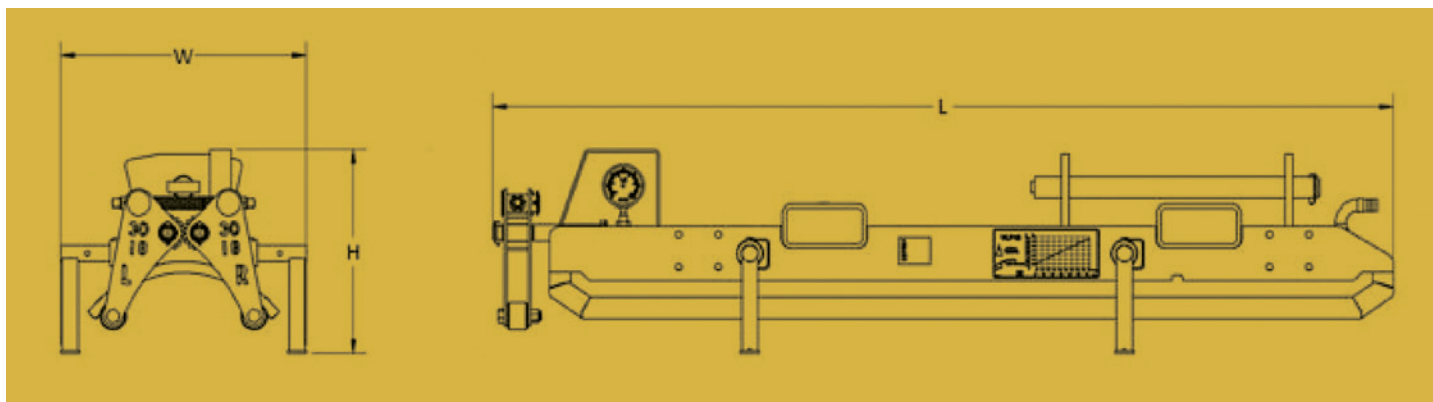


VACUUM LIFTERS VLP4 - VLP20						
MODEL	DIMENSIONS (L/W/H) 2 PADS REQUIRED		TOTAL OPERATING WEIGHT		ASSEMBLED HEIGHT (INCLUDING PIPE)	
	in	m	lb	kg	in	m
VLP4	79.4 / 16.5 / 16.4	2.02 / 0.42 / 0.42	550	250	85	2.17
VLP6	79.4 / 16.5 / 16.4	2.02 / 0.42 / 0.42	550	250	87	2.20
VLP8	79.4 / 16.5 / 16.4	2.02 / 0.42 / 0.42	570	258	89	2.25
VLP10	79.4 / 16.5 / 16.4	2.02 / 0.42 / 0.42	600	272	91	2.30
VLP12	79.9 / 18.6 / 17.3	2.03 / 0.47 / 0.44	690	312	92	2.33
VLP14	79.9 / 18.6 / 17.3	2.03 / 0.47 / 0.44	710	322	93	2.37
VLP16	85.9 / 18.6 / 17.2	2.18 / 0.47 / 0.44	750	340	95	2.42
VLP18	85.4 / 23.3 / 18.7	2.17 / 0.59 / 0.47	860	390	97	2.46
VLP20	85.4 / 23.3 / 18.6	2.17 / 0.59 / 0.47	870	394	99	2.51





## LIFTING PADS VLP22 - VLP48



### VACUUM LIFTERS VLP22 - VLP48

MODEL	DIMENSIONS (L/W/H) 1 PAD REQUIRED		TOTAL OPERATING WEIGHT		ASSEMBLED HEIGHT (INCLUDING PIPE)	
	in	m	lb	kg	in	m
<b>VLP22</b>	169.8 / 29.3 / 22.5	4.31 / 0.74 / 0.57	1085	492	99	2.52
<b>VLP24</b>	169.8 / 29.3 / 22.5	4.31 / 0.74 / 0.57	1135	525	101	2.58
<b>VLP26</b>	169.8 / 29.3 / 22.4	4.31 / 0.74 / 0.57	1160	526	103	2.63
<b>VLP28</b>	169.8 / 35.5 / 24.8	4.31 / 0.90 / 0.63	1215	551	105	2.68
<b>VLP30</b>	169.8 / 35.5 / 24.8	4.31 / 0.90 / 0.63	1260	572	107	2.73
<b>VLP32</b>	181.5 / 35.5 / 24.6	4.31 / 0.90 / 0.63	1480	671	109	2.78
<b>VLP34</b>	181.5 / 35.5 / 24.5	4.61 / 0.90 / 0.62	1490	676	111	2.83
<b>VLP36</b>	181.5 / 35.5 / 24.4	4.61 / 0.90 / 0.62	1500	680	113	2.88
<b>VLP42</b>	228.5 / 45.0 / 25.3	5.80 / 1.14 / 0.64	2100	950	119	3.03
<b>VLP48</b>	228.5 / 45.0 / 24.9	5.80 / 1.14 / 0.63	2230	1012	125	3.18

#### Disclaimer:

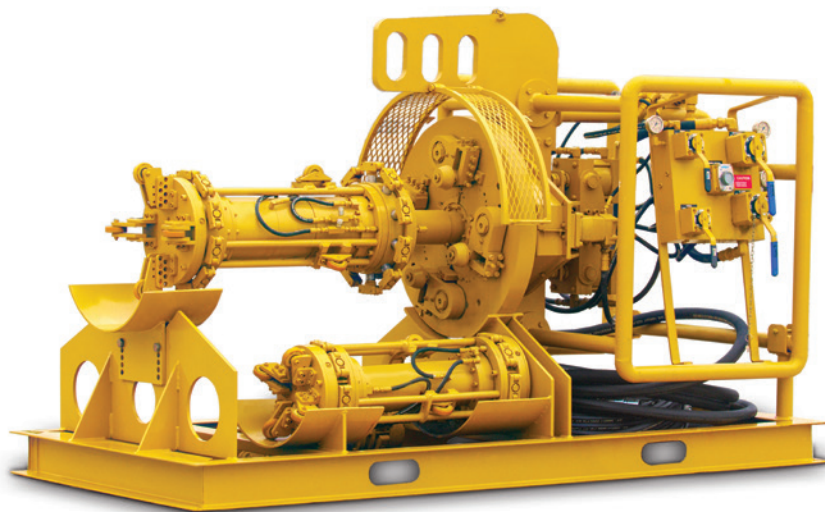
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# HYDRAULIC PIPE FACING MACHINE

## Design Features

- Available in sizes 8"- 60"
- This unit requires a hydraulic power source
- Transition tapers or counterbores for joining pipes of different wall thickness
- Mitered bevels up to 2-1/2" where mitered pipe is required
- Provides a bevel for pipeline tie-ins, on and offshore, that will maximize quality and minimize repairs of field welding. A combination of hydraulic and mechanical components produce a bevel within our + or - .016" (0.406MM) tolerance
- Pipe end prep station for double jointing yards
- Radial arm tool holder or dovetail type tool holder

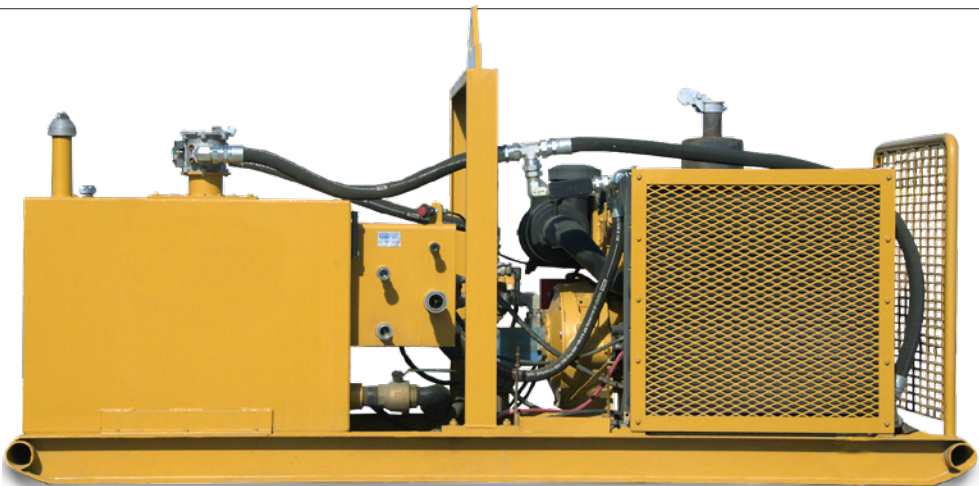


MODEL	LENGTH		WIDTH		HEIGHT		CUBE		WEIGHT	
	in	mm	in	mm	in	mm	ft	m	lb	kg
8 - 14	65	1651	34	863	37	939	47	1.34	1300	590
16 - 22	81	2057	40	1016	43	1092	81	2.28	1850	839
24 - 32	100	2540	41	1041	52	1320	123	3.49	3200	1451
34 - 38	103	2616	44	1117	58	1473	152	4.31	3800	1723
40 - 48	129	3276	54	1371	77	1955	310	8.79	6500	2948
50 - 60	140	3556	68	1727	87	2209	479	13.57	8800	3991

# POWER UNITS

## Design Features

- Available in diesel or electric drive, each unit is self contained and includes everything necessary to power the Pipe Facing Machine
- Diesel Units come equipped with an electric start, water cooled, diesel engine
- Electric Units contain a heavy-duty industrial motor, disconnect switch with thermal protection, and an On/Off switch for operation. Electric Units are available in a variety of voltages and may be ordered as 50 Hz or 60 Hz
- All units come equipped with a dual-action hydraulic oil pump and a heavy-duty oil filter



# SIDE BOOM PIPE LAYERS

## Design Features

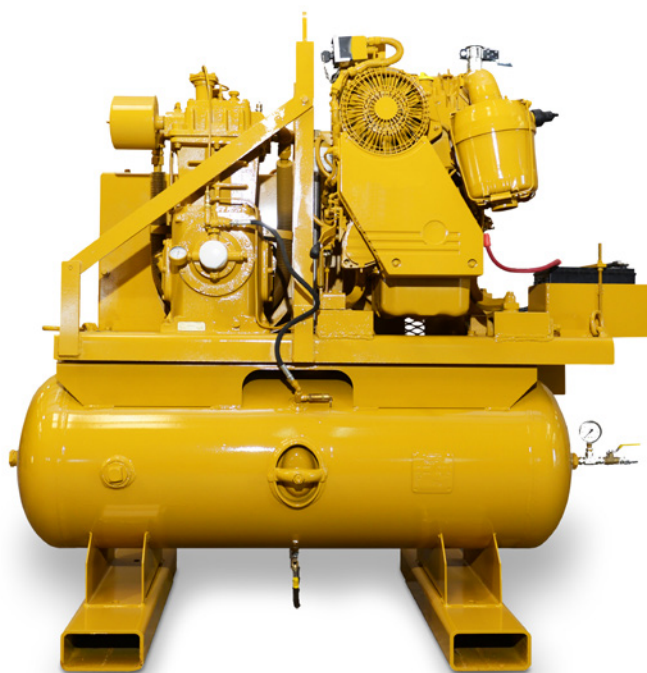
- Folding boom for ease of transportation
- Controls are easy to operate and require minimal operator training
- Hydraulic boom stop automatically prevents system over travel and damage to boom
- Sideboom features quick release hinge pins for easy boom removal and maintenance
- Hydraulically operated, four-bar linkage counterweight system for maximum stability and lifting capability
- Optional 2-speed load winch
- Optional Boom Lengths
- Various models available for sale or lease



# AIR COMPRESSORS

## Design Features

- Designed to complement DMI pneumatic equipment
  - foot-mounted, complete, ready to operate
- Working range is up to 225 psi (15.3 atm)
- Minimum range compressed air supply is 180-200 psi (12.2-13.6 atm)
- 25CFM - Model #325
- 40CFM - Model #340 73"x 36"x 69" (1880 mm x 940 mm x 1803 mm) 2,075 lbs. (941 kg) (30 HP Duetz, 2 Cylinder motor)
- 90CFM - Model #390 76"x 48"x 78" (1778 mm x 1219 mm x 1981 mm) 2,650 lbs. (1202 kg) (46 HP Duetz, 3 Cylinder motor)
- Specified power units include:
  - HTD - Diesel engine with electric start
  - HTE - Electric motor, at customer's required voltage



## AVAILABLE OPTIONS:

- Air tank certified to special (non-U.S.) standards
- Centerlift hook
- Pipe bending machine mounting bracket
- Roll-over cage



## MANUAL INTERNAL LINEUP CLAMP



- Toggle action puts maximum power on pipe
- "Gap" is unobstructed for fuller stringer bead
- Heavy duty jack box puts more power on the pipe with less operator effort
- Each clamp machined for specific wall thickness and pipe O.D.
- Available with copper back-up ring
- Standard 6" to 60"

## HYDRAULIC INTERNAL LINEUP CLAMP



- Easy to operate
- Requires no outside power unit
- Precision manufactured, field proven
- Each clamp machined for specific wall thickness and pipe O.D.
- Heavy duty all steel construction
- Standard 16" to 60"
- Available through 100"

## MANUAL, RATCHET & HYDRAULIC EXTERNAL LINEUP CLAMPS STANDARD & NO-TACK

### Manual

- Precision Acme threads ensure strength and ease of operation.
- Standard 1" ratchet handle fits all sizes
- Available in sizes 2" through 60"
- Mechanism is enclosed to eliminate dirt and mud
- Will not back off while weld is being made
- No-Tack type has arched cross-beams to permit continuous welding without removing the clamp
- Heavy duty all steel construction



### Ratchet

- Heavy duty all steel construction.
- Standard 1" ratchet handle fits all sizes
- Precision Acme threads ensure strength and ease of operation
- Clamp sizes 2" through 60"
- Mechanism is enclosed to eliminate dirt and mud
- Will not back off while weld is being made
- No-Tack type has arched cross-beams to permit continuous welding without removing the clamp



### Hydraulic

- Accurately aligns in minutes
- Hinged to open wide for easy mounting, use, or removal
- Circle secured by single master pin
- Bridging allows full 360° welding without removing clamp
- Available in sizes from 16" to 60"
- Heavy duty all steel construction
- Precision manufactured, field proven





## GPB HEAD IRON

- Alloy steel for greater strength with less weight
- Reinforced lifting bail and end iron hooks for increased durability
- Painted with stainless steel data plate
- Lowering-in belt not included
- Belts used around the world in sizes for 2 hook to 11 hook



## GPM LOWERING-IN BELT

- Heavy duty nylon webbing for durability and strength
- Alloy steel end irons for greater strength with less weight
- Web coated with heavy duty vinyl coating
- Head iron not included as pictured
- Lowering in belt and head iron sold separately
- Belts used around the world, in all types of climates, in sizes up to 60" diameter pipe
- Custom belts available for additional pipe diameters



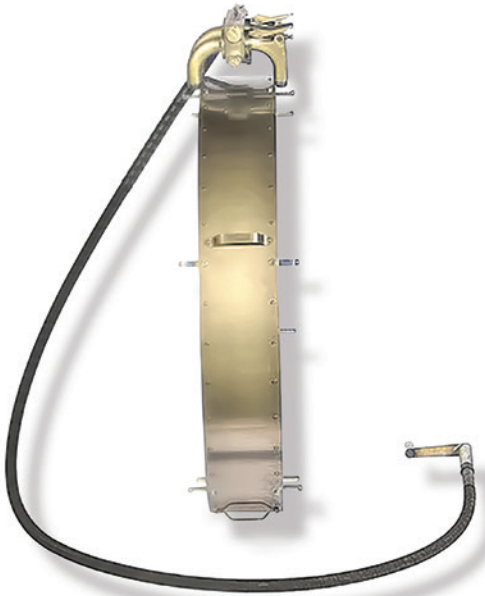
## GPC BLP LINED STEEL CHOKER BELT

- Accurately aligns in minutes
- Hinged to open wide for easy mounting, use, or removal
- Circle secured by single master pin
- Bridging allows full 360 degrees welding without removing clamp
- Available in sizes from 16" to 60"
- Heavy duty all steel construction precision manufactured, field proven



## STAINLESS BEVELING BANDS

- Made from durable stainless steel for long life
- Ease of operation and removal
- Sizes from 6" to 60" in 2" intervals
- Adaptable to any beveling requirement
- Smoothly, accurately cuts and bevels
- Minimum clearance needed in bell holes
- Out of round pipe attachments unnecessary
- Mounts easily anywhere on the pipe

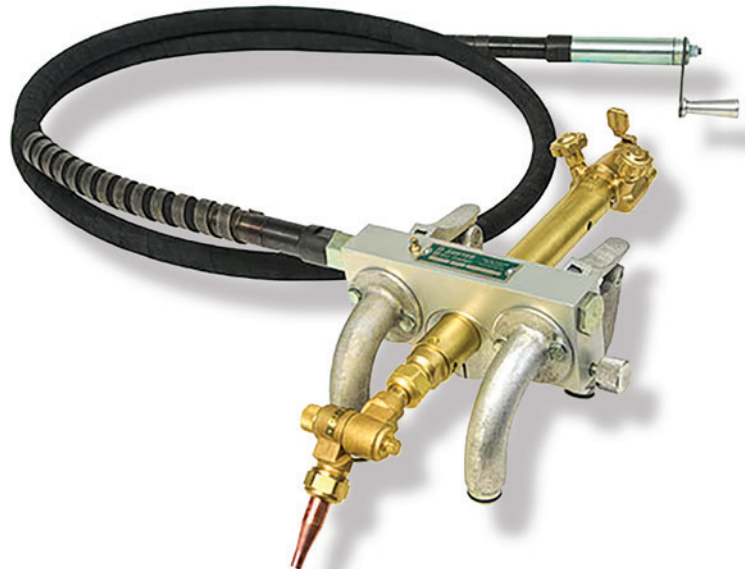


## BAND-TYPE CRAWLER

- One man can set up and cut pipes as large as 48"
- Ease of setup when cutting horizontal or vertical pipes due to lightweight design
- Quick installation latching mechanism
- Fits all band sizes
- 60% faster than hand cutting and grinding

*Not Included:*

- Machine cutting torch, torch angle head adapter





# DMI WORKMANSHIP

QUALITY IS FOUND IN THE DETAILS





DRIVEN

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