

# GK MACHINE, INC.

*Combining Technology & Tradition Since 1976*

**PO Box 427**

**Donald Oregon 97020**

**503-678-5525**

**[www.GKMachine.com](http://www.GKMachine.com)**



**GK MACHINE, INC. DONALD, OREGON**

**503-678-5525**

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# Kinetic K5000 XMC

## Machining, Plasma & Flame Cutting

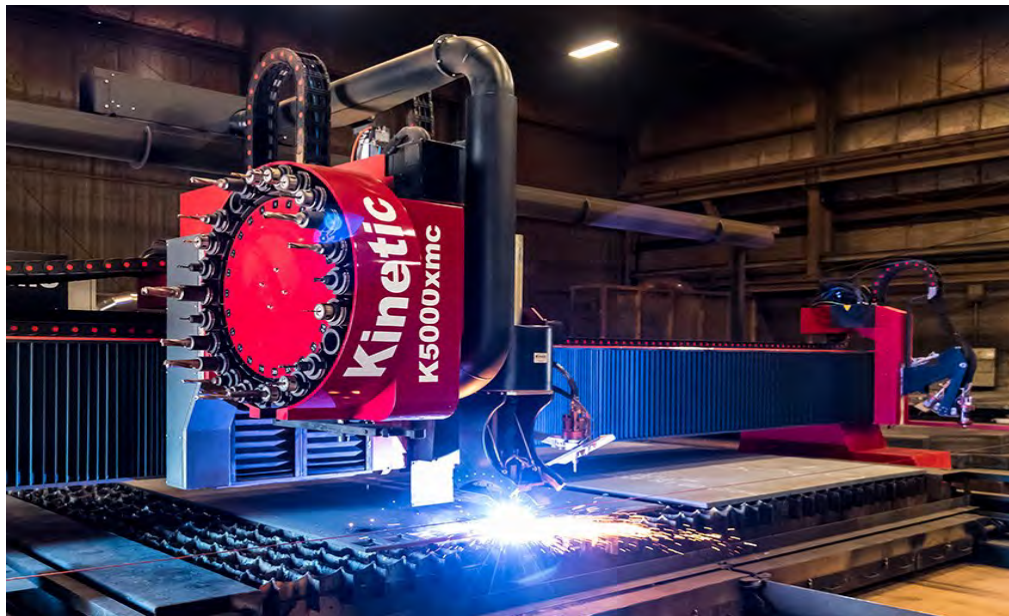


### Plasma Tolerance

For parts 36" x 36" or smaller. For larger parts, add 0.002"/foot.

THICKNESS	TOLERANCE (In Inches)
Gauge	0.017
0.188	0.019
0.250	0.021
0.313	0.023
0.375	0.038
0.500	0.047
0.625	0.056
0.750	0.064
1.000	0.082
1.250	0.099
1.500	0.169
1.750	0.195
2.000	0.222
2.250	0.248
2.500	0.274
2.750	0.300
3.000	0.326

*Width 10' Length 40', 24 automatic tool changer  
Combination Plasma/Flame bevel, Marking Systems,  
Flame cutting and multiple torch stations*

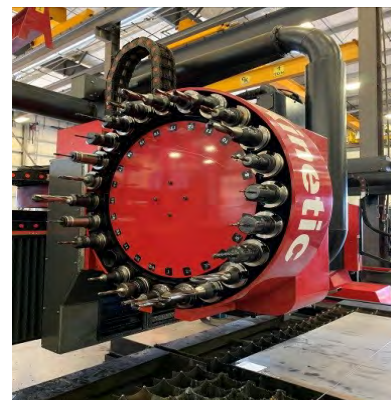


### Flame Tolerance

Parts 36" x 36" or smaller. Large parts, add 0.002"/foot.

THICKNESS	TOLERANCE (IN INCHES)
$\leq 3.0"$	1/8
$> 3.0"$	1/4

Notes/Tips: Bevels can be on top and bottom of parts, 10-8" x 40'-8" smaller than sheet size, long, straight sections burn more accurate than rounds or radiused parts. Slots and tables are not advised on plasma, unable to flame cut stainless steel material.



### Capabilities

DRILLING	COUNTERBORING
MILLING	PLASMA CUTTING
TAPPING	FLAME CUTTING
MARKING	BEVEL CUTTING
AUTOMATIC TOOL CHANGING	

### Additional Information

Max drilled hole (current tooling on hand)	1.25"
Max drilled hole (check tooling avail. 1st)	4.0"
Max tapped hole	1.25"
Max plasma thickness	3.0"
Max flame thickness	8.0"
Max bevel angle	45°
Max bevel "length"	3.0"
Max plate thickness with 45° bevel	2.0"
Tolerance on bevel cuts	+/- 1/8"
Min OD of a features' profile	.125
Max weight for skeleton 10ft wide or less	10 ton
Max weight for skeleton over 10 ft wide	30 ton

### Machining Tolerance & Capacity

#### Feature location:

DISTANCE BETWEEN FEATURES	TOLERANCE (IN INCHES)
$\leq 36"$	0.006 "
$> 36"$	0.006" + 0.002"/foot

#### Feature size:

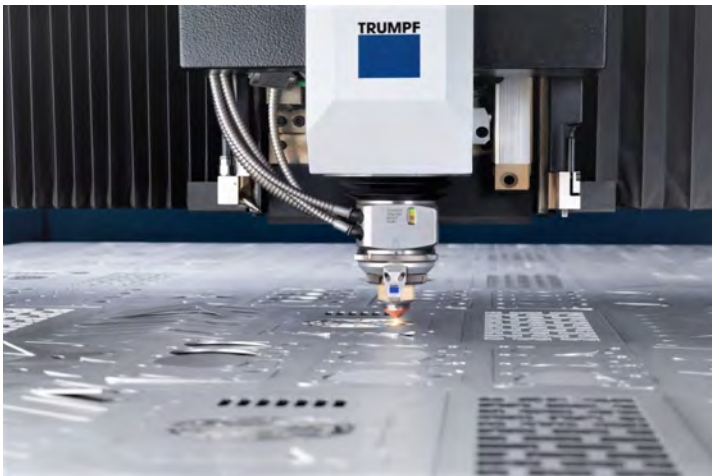
Drilling	+/- 0.010"
Milling	+/- 0.010"

#### Tap sizes:

$< 1/2"$ plate	1/4 min tap size
$< 3/4"$ plate	5/16 min tap size

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# Trumpf Trulaser 5030 Fiber Laser



The Trulaser 5030 fiber is a 12KW solid-state laser designed for precision and efficiency.

- Material Versatility: cuts mild steel, stainless steel, aluminum, copper, brass, titanium, and nickel.
- Maximum Part Size: This machine handles sheet sizes up to 60" x 120" maximum weight of 4,000 lbs. per pallet.
- Handles complex contours with ease
- Cooling feature allows for innovative shapes and reliable cuts on thicker sheets of metal.
- It achieves high processing speeds with reproducible part quality.
- Fiber functions provide smooth edges and intricate contour cutting quality.

## Facts:

- 1) 1.5" Maximum aluminum thickness
- 2) 2.0" Maximum steel and stainless steel thickness
- 3) 5/8" Maximum for copper and brass
- 4) 1/2" Maximum for brass
- 5) Cuts mild steel, stainless steel, aluminum, copper, brass, titanium, and nickel

Cutting table size is 60" x 120", maximum weight of 4,000 lbs. per pallet

## Laser Tolerance

The chart below is for carbon steel plate

Thickness	Tolerance (In Inches)
Up to .039"	+/- .0047"
Over .039" to .118"	+/- .0059"
Over .118" to .236"	+/- .0078"
Over .236" to .984"	+/- .0098"
Over .984" to 1.96"	+/- .0196"

The Trumpf 5030 Trulaser Fiber Laser with high speed CNC laser capabilities. Solid-state 12kW laser ensures our ability to achieve excellent feeds rates and cutting speeds.



# Laser Trumpf Trumatic 3050



## Facts:

- 1) .50" Max aluminum thickness
- 2) .63" Max stainless thickness
- 3) 125-250 RMS surface finish @ cut
- 4) 60" x 120" cutting table size, parts
- 5) Cannot last cut copper, brass or plastic

Thickness	Min Size Hole
Gauge	.85-.9x material thickness
.188-.500	= material thickness
.625-1.00	1.5x material thickness*

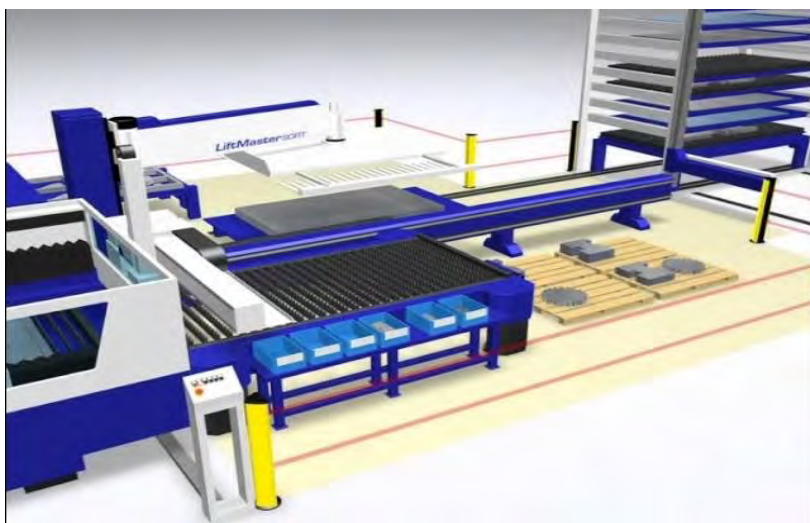


**Laser Kerf Angle:** .5-1° dependent upon material, consumables and wattage. Tolerance table includes kerf allowance.

## Laser Tolerance

For parts 36" x 36" or smaller. For larger parts, add 0.002"/foot. Chart below is for carbon and stainless steel.

Thickness	Tolerance (In Inches)
<b>GAUGE</b>	0.010
0.188	0.012
0.250	0.013
0.313	0.014
0.375	0.015
0.500	0.015
0.625	0.016
0.750	0.028
1.000	0.031



## **Trumpf Liftmaster** (automatic loading & unloading)

The Liftmaster is a fast, compact loading and unloading unit. It's well suited to flat sheet processing and can handle lights out processing to increase efficiency and production times.

## **Trumpf TruStore** (material storage tower)

The TruStore is fully automatic storage tower and pallet picker that can hold various flat sheets up to 245 tons. Sheets are ready for processing and production, reducing loading times.



# BLM Tube Laser LT8.20



**The BLM Tube Laser** is fully automated for 3D tube processing. It cuts a variety of tube shapes: round, square, rectangular, oval tubes, I-beams, and custom extrusions. Processes a wide range of materials, including steel, stainless steel, aluminum, brass, and copper. Drill and tap device offers friction or classic drilling and roll tapping. It allows threaded holes from 3/16" to 3/8" to be added to the workpiece.

Loading (front/rear)	Bundle, stepper & single bar
Minimum loading length	8'
Single bar load front	Rear bundle 27'- unloading 15'
Bar load capacity	11000 lbs.
Unloader	15' - 21' - 27'
Three programmable positions	Rear conveyor belt, motorized front and rear collection table
Installed power (kVA)	63 Fiber
Standard loading	21' and unloading 15'



## Simple Assembly Aids



## Simple Connections



## Extended Connections



## Bend Connections



## Tube-blank Connections



# Trumpf TruBend 7036 (40 T)



**Bend minimum guidelines chart is for steel (A36) up to a 90° single bend ONLY.**

*See below for other bends or alternate materials. Standard radius is equal to material thickness.*

MATERIAL THICKNESS	8X THK	STANDARD DIE WIDTH	MINIMUM ENTITY TO BEND	MINIMUM FLANGE LENGTH	LONGEST BEND	MAX DEGREE	K FACTOR MS / SS
(.048)18 ga	0.38	0.384" (10MM)	0.281	0.317	40	35	0.208 / 0.065
(.060)16 ga	0.48	0.384" (10MM)	0.281	0.317	40	35	0.524 / 0.283
(.075)14 ga	0.60	0.472" (12MM)	0.332	0.361	40	35	0.496 / 0.225
(.105)12 ga	0.84	0.630" (16MM)	0.406	0.440	40	35	0.481 / 0.350
(.120)11 ga	0.96	0.630" (16MM)	0.406	0.440	30	35	0.507 / 0.380
(.135)10 ga	1.08	0.630" (16MM)	0.406	0.440	22	35	0.522 / 0.355
.188 Plate	1.50	1.181" (30MM)	0.850	0.875	19	35	0.410 / 0.326
.250 Plate	2.00	1.969" (50MM)	1.250	1.375	20	35	0.333 / 0.342
.313 Plate	2.50	1.969" (50MM)	1.250	1.375	12	35	0.374 / 0.328
.375 Plate	3.00	2.756" (70MM)	1.690	1.875	16.5	55	0.346 / 0.3145

5052 AL K Factors	
Thickness	K-Factor
0.0478	0.1350
0.0630	0.5000
0.0800	0.4100
0.1000	0.4850
0.1250	0.5000
0.1880	0.4150
0.2500	0.3450
0.3130	0.3280
0.3750	0.3135

86° (90°) Dies Available	
Size	Length
0.3149" (8mm)	40"
0.472" (12mm)	40"
0.630" (16mm)	40"
1.575" (40mm)	40"

Radius punches available	
Size	Length
0.040 R (1mm)	40"
0.160 R (4mm)	40"
0.375 R	40"
0.500 R	40"
0.750 R	40"
1.000 R	40"



**Notes:** Dies bed is 40" and 36.7" between columns, Maximum interior box ID = 2.625", Maximum flange at upright is 16".

**Stepping Down Dies:** No step-down die size for 10 gauge below 16mm, when forming aluminum plate do not step down die size due to cracking risks.

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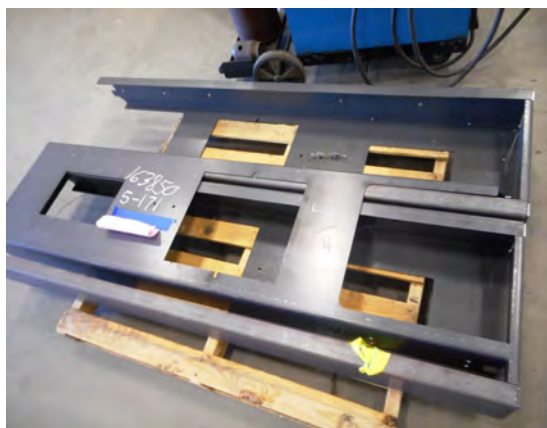


# Trumpf TruBend 5320 (360 T)

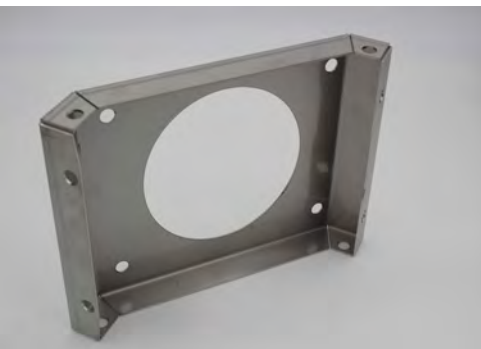


Bend table minimum guidelines chart is for steel (A36) up to a 90° single bend ONLY.  
See below for other bends or alternate materials. Standard radius is equal to material thickness.

MATERIAL THICKNESS	8X THK	STANDARD DIE WIDTH	MINIMUM ENTITY TO BEND	MINIMUM LANGE LENGTH	LONGEST BEND	MAX DEGREE	K FACTOR MS / SS
(.048)18 ga	0.38	0.384" (10MM)	0.281	0.317	159"	35 OR HEM	0.208 / 0.065
(.060)16 ga	0.48	0.384" (10MM)	0.281	0.317	159"	35 OR HEM	0.524 / 0.283
(.075)14 ga	0.60	0.472" (12MM)	0.332	0.361	159"	35 OR HEM	0.496 / 0.225
(.105)12 ga	0.84	0.630" (16MM)	0.406	0.440	159"	35 OR HEM	0.481 / 0.350
(.120)11 ga	0.96	0.630" (16MM)	0.406	0.440	159"	35 OR HEM	0.507 / 0.380
(.135)10 ga	1.08	0.630" (16MM)	0.406	0.440	159"	35 OR HEM	0.522 / 0.355
.188 Plate	1.50	1.181" (30MM)	1.17	1.173	172"	35	0.419 / 0.328
.250 Plate	2.00	1.969" (50MM)	1.25	1.375	172"	35	0.333 / 0.342
.313 Plate	2.50	1.969" (50MM)	1.25	1.375	159"	35	0.374 / 0.328
.375 Plate	3.00	2.756" (70MM)	1.69	1.875	159"	55	0.346 / 0.3145
.500 Plate	4.00	3.937" (100MM)	2.25	2.500	90"	55	0.344 / 0.300
.625 Plate	5.00	5.906" (150MM)	3.25	3.750	112"	85	0.240 / 0.286
.750 Plate	6.00	5.906" (150MM)	3.25	3.750	112"	85	0.384 / 0.265
1.00 Plate	8.00	5.906" (150MM)	3.50	4.00	80"	85	0.439 / 0.235



5052 AL K factors	
Thickness	K factor
0.0478	0.135
0.063	0.500
0.080	0.410
0.100	0.485
0.125	0.500
0.188	0.415
0.250	0.345
0.313	0.328
0.375	0.3135



86° (90°) dies available	
Size	Length
0.3149" (8mm)	42"
0.472" (12mm)	42"
5/8" (16mm)	42"
1.5" (40mm)	159"

Radius punches available	
Size	Length
0.04 R (1mm)	159.00
0.16 R (4mm)	159.00
0.375 R	78.75
0.500 R	98.50
0.750 R	78.75
1.000 R	98.50
1.500 R	78.75

**Notes:** Hem up to 10 gauge sheet at 159.5" long. Die bed is 174" and 145" between the uprights. Maximum flange at upright 16". 40mm bottoms are for making 90° max bend parts. If acute bends needed, must step down to 30mm bottom. Cross brake is 2° minimum. Max distance from center of die to rear-most brake stop position is 33.875

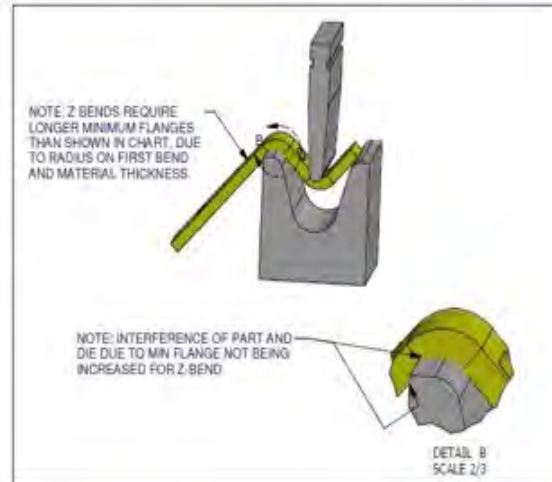
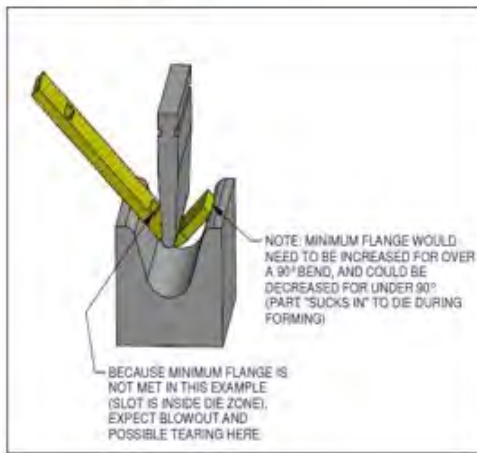
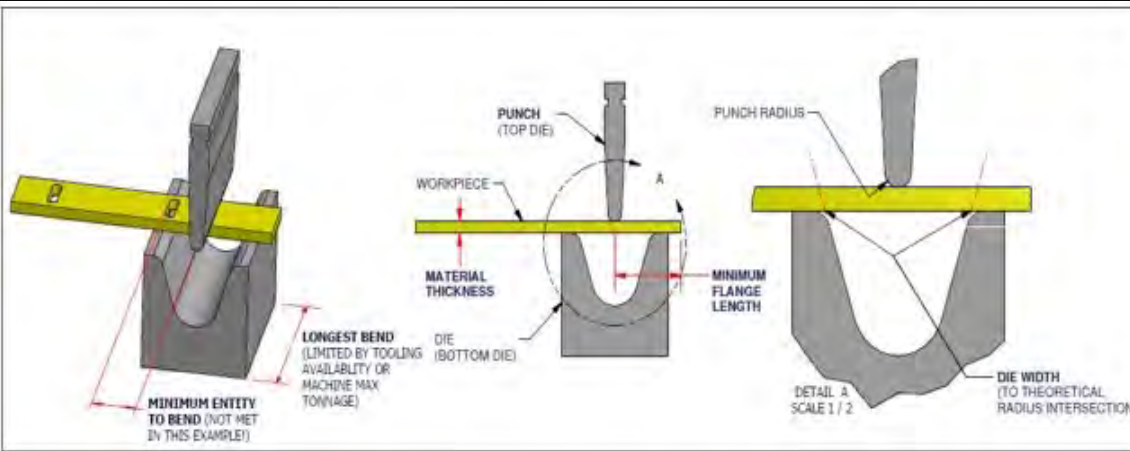
**Stepping Dow Dies:** no step down die size for 10 ga. Below 16mm. When forming aluminum plate do not step down die size due to cracking risks.

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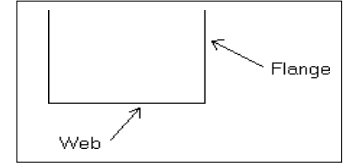
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# Trumpf TruBend 7036 / 5320



All dimensions measured to inside of bends

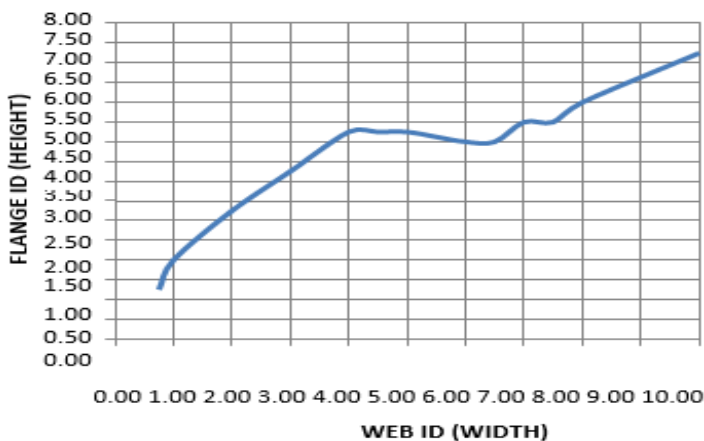


Maximum Flange Lengths

(typical for all material thicknesses)

Web	Max Flange
0.75	1.25
1.0	2.00
2.0	3.25
3.0	4.25
4.0	5.25
4.5	5.25
5.0	5.25
5.5	5.13
6.0	5.00
6.5	5.00
7.0	5.50
7.5	5.50
8.0	6.00
10.0	7.25
12.0	9.25
15.0	12.2
18.0	15.2
21.0	18.2
24.0	21.2
30.0	27.2
36.0	33.2

## MAX FLANGE HEIGHT FOR <10" WEB



### Forming Tolerance

Thickness	+/-
18 ga - 10ga	1/32
3/16 - 1/2	1/16
5/8 +	3/32

Angular = +/- 1 deg.

### Chart Modifiers

Material	Multiplier
A572 GR50	0.9
A514 GRB	0.6
316SS	0.9

\*Consider increasing the flange length to allow stepping up to the next die size, vs limiting max bend length.

\*Multiply tolerance by 2 when forming textured plate (diamond, rigidized, etc.)

## MAX FLANGE HEIGHT FOR >10" WEB

FLANGE = WEB 2.8

TOOL HEIGHT W/EXT. is 15 3/4

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# Trumpf 260-T Punch



## Capabilities

Tonnage	27 T
Max. Hits per Minute	500 HPM
Min. Width	22 5/8
Max Width	100" (w/o Reposition)
Max Thickness	10 Gauge
Min. Edge to Punch Center Line	4 1/16
Tool Stations	25
Min. Center to Center with Dimple	1.5"

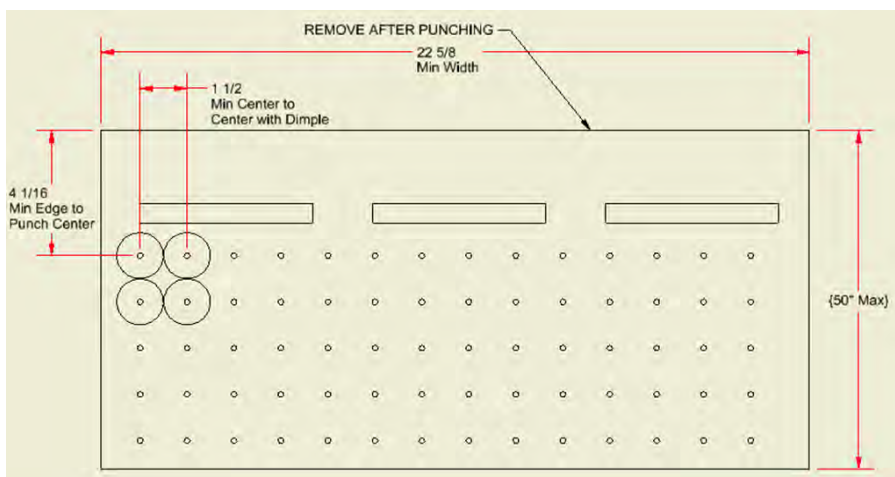
- 1) Punch up to 0.25", preferred max. thickness is 10 gauge
- 2) Minimum distance to center of punched "dimple" can be from a 90° (10 gauge max for dimples).

## Available Punch Shapes

Circle	.039" -2."
Oval	.142" - 1.00"; L 0.203" - 2.00"
Square	0.2" x 0.2"
Rectangle	0.125" x 0.5" - 1" x 2.5"
Dimple	1.5"



Many intermediate sizes and other shapes are available. Star, Hexagon, Obround, Special, etc. Check with Sales staff for availability.



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# DAVI 4 MCA 3022 Roller



## ROLLER CAPABILITIES:

MAX ROLL WIDTH (FT)	10'
MAX ROLL THICKNESS (IN)	3/8"
MAX PREBENDING THICKNESS (IN)	1/4"
TOP ROLL DIAMETER (IN)	8.5"
BOTTOM CLAMPING ROLL DIAMETER (IN)	8"
Maximum Dia.	N/A
Minimum Dia.	10"
Minimum Width	30"
ELECTRIC POWER (HP)	12



POSSIBLE SHAPDES:	Pipes/Tubes, Cones, Ovals
TYPICAL SIZES:	10: - 10* Diameter
TOLERANCE	1/16"

- 1) The capacities are based on mild steel with max 65,000 psi, ultimate tensile strength and 40,000 psi yield strength.
- 2) No extra material required for lead in, lead out, "flats" on end.
- 3) Narrower plates will damage rollers due to "bridging" effect.



## MISC. Rollers

### ROLLER CAPABILITIES:

MAX Roll Width (FT)	*6'
MAX Roll Thickness (IN)	*TBD
Maximum Diameter	N/A
Minimum Diameter	*4"
Minimum Width	0"

**Notes:** The small rollers will leave a flat spots on the lead in edge, and the lead out edge.. If part required no flat spots, add material to both ends to be trimmed after roller.

- 1) Material under 48" wide requires 2.25" on both ends. All other sizes require 7" extra material on both ends.
- 2) Width, thickness, and diameter capabilities will vary greatly. Consult Sales for tight diameter parts

### Small

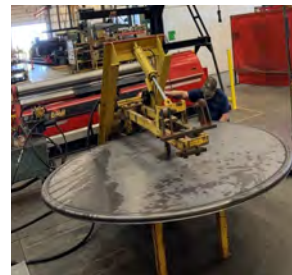
#### Lip Roller:

- ◆ 16" - 64" DIA MAX
- ◆ 18 GA - 10 GA
- ◆ 3/4" - 1" LIP



### Large Lip Roller:

- ◆ 64" - 108" DIA MAX
- ◆ 3/16" - 1/4" THICK
- ◆ 1" - 2" LIP



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# Machining Centers



**DMG MORI NT5400/1800SY PRODUCTION MILLING MACHINE**  
5 axis mill-turn with lower turret  
X: 40.9"/1,040mm Y: 10"/255mm Z: 76.4"/1,940mm



**DMG MORI DURA VERTICAL 5100 PRODUCTION MILLING MACHINE**  
3 Axis vertical  
X: 17.7"/450mm Y: 3.94"/100mm Z: 51.2"/1,301mm



**DMG MORI NHX6300 PRODUCTION MILLING MACHINE**  
4 axis horizontal machining center  
X: 41.3"/1,050mm Y: 35.4"/900 mm Z: 40.6"/1,030mm



**DMG MORI NLX 2500/700SY PRODUCTION MILL TURN**  
4 axis machining center and 48" bar feeder  
X: 10.2"/260mm Y: 31.3"/795mm Z: 28.6"/728mm



**DMG MORI CTX BETA 1250TC MILL TURN**  
5 axis and 60" bar feeder  
X: 17.7"/450mm Y: 3.94"/100mm Z: 51.2"/1,301mm



Machining Capabilities			Max travel			Through spindle		Raw material		Barfeed / max L <sup>1</sup>	Removable side
			X	Y	Z	Main	Sub	Max L	Max D		
M1001	Mill, 3 ax.	OKK 40	36.0	25.0	12.0						Yes
M1003	Lathe, 2 ax.	Takasawa TC4	15.9		37.5	3.25		48.0	24.0		
M1004	Turn/mill, 5 ax.	CTX 1250TC	17.7	7.8	51.2	3.00	2.00	47.0	15.4	Yes / 60"	
M1005	Mill, 4 ax.	NHX6300	41.3	35.4	40.6			51.1	41.3		
M1006	Turn/mill, 4 ax.	NLX2500	10.2	3.9	31.3	3.00	1.9 <sup>5</sup>	28.6	3.00	Yes / 48"	
M1007	Mill, 3 ax.	DV 5100	41.5	20.9	20.1						Yes
M1008	Turn/mill, 5 ax.	NT5400	40.9	10.0	76.4	4.20	4.20	75.6	36.2		
M1009	Mill, 3 ax.	SMV1370	53.0	27.0	24.0						Yes
Manual lathe						4.00		120.0	36.0		
Simplon Mill			48.0	16.0	16.0						
Manual mill			37.0	27.0	24.0						
Turret drill			20.0	12.5	24.0						

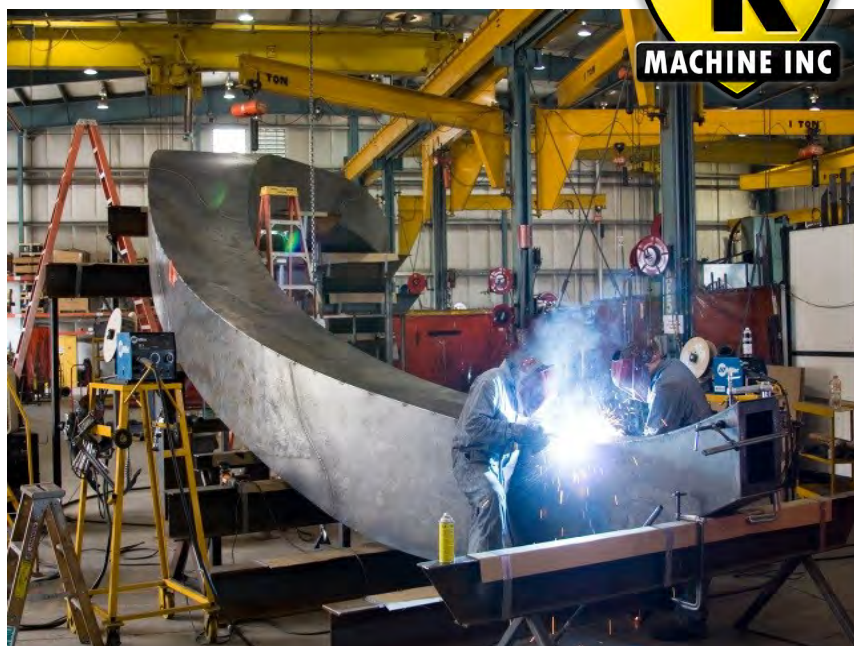
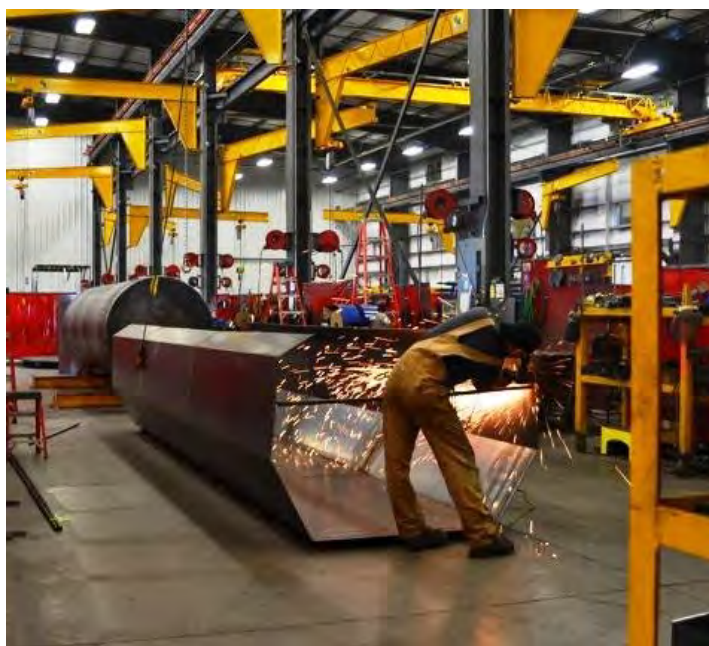
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# Welding & Fabrication



- UL142 Above Ground Fuel Tank Certified
- Aluminum Certified Structural Welders
- Welding in all positions
- (30) Dual Feed MIG Welders
- (5) Dual Feed TIG Welders
- Tank Roller and Auto Welder
- Dual Feed Track Welders
- All Grades of Finish Work

- (25) JIB Cranes
- (5) Milwaukee Bridge (5 TON)
- (2) Milwaukee Bridge (10 TON)
- (1) Milwaukee Bridge (20 TON)

## Specialize in various alloys and materials

- Stainless - Aluminum - Thin gage - Brass - Hardox  
- T1 Hardened plate - Mild steel - Structural steel

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# Finishing—Sand-blast, Powder Coat & Paint



## Standard Colors

### Powder Coat: *\* Additional Colors Available*

Color	Name	Stock Code
Black	Gloss SRSF 10108	POWD100
Blue	Powder Blue Streak	POWD113
Gray	SNO-CAT	POWD118
Green	John Deere	POWD125
Green	Reiter	POWD136
Orange	New Orange #10091336	POWD102
Red	International	POWD154
White	Gloss PFW51059	POWD104
Yellow	GK / Cat Yellow	POWD120

### Liquid: *\* Additional Colors Available*

Color	Name	Stock Code
Black	Imron High Gloss 1640	DUPO803
Blue	Global	DUPO843
Gray	42P-3714 Imron Volve-GM	DUPO500
Green	John Deere Imron	DUPO828
Orange	GK	DUPO101
Red	International	DUPO848
White	Imron Urethane Bright	DUPO804
Yellow	GK / Tracker Urethane	DUPO300

### Booth sizes:

	L	W	H	DW	DH
Blast	70'	20'	17'	20'	16'
Chemical wash	14'	9'	7'	9'	7'
Powder	35'	14'	16'	14'	16'
Liquid	70'	20'	17'	20'	16'



**Notes:** Due to baking requirements, maximum material thickness for powder coat is 2". Material over 1" thick would be better for liquid paint. Over door is 12' wide, powder coating is limited by width of over door.

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# Saw Cutting—Vertical Band Saw



## Capacities

Blade	1-1/2" x 20'0" x 050"
Motor	10 HP
Hydraulics	5 HP
Operations	Automatic
Bar-Feed	0-48" Storke Hydraulic (multiple index)
Table Lift	Table Lifts in Automatic

## Features:

- Swing-Away Control Console w/ 8" Touch Screen
- Variable Frequency Controller
- Computer Controlled Feed (CCF)
- Programmable Powered Tilt w/ Angle Readout
- Full Stroking Main & Feed Vise
- Electronic Controlled Traverse
- Adjustable Blade Speed w/Readout on Touch Screen
- Powered Adjustable Guide Arm
- Powered Blade Tension
- Cut Watcher System
- Material Jogging Feature
- Idle Base Rollers – 1 Each Side of Base
- Powered Chip Conveyor
- Built-In Coolant System w/ Wash-Down Hose
- 220V/3PH or 440V/3PH Electrical Motor Requirement

## Tolerances

Length:	+/- 1/16"
Angle:	+/- 1°

## Capacity

22" W x 30" H @ 90"
22" W x 20: H @ 45: (L)
22" W x 20" H @ 45" (R)
22" W x 13.5" H @ 60" (L)
22" W x 13" H @ 60" (R)

## Extra Features:

- 3rd Holding Vise on Feed
- Full stroking 2nd Main Vise
- Laser Light System
- Right to Left Feed Direction
- Spray Mist Lubrication



# Shearing



- ♦ 12' max width
- ♦ 1/2" max thickness

The sheet metal is positioned between two blades, with the lower blade stationary and the upper blade moving to slice through the metal.

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# Tube Bending



## Small Bend Radius Hyd Tubing Dies<sup>1</sup>

### Manual Powered Hyd Tube Bender

Tube OD	Size <sup>2</sup>	Bend Radius <sup>3</sup>	Min Length of Straight After Bend
5/16	5	11/16	1 1/4
1/2	8	1 1/4	1 5/16
5/8	10	1 1/2	1 1/2
3/4	12	1 3/4	1 11/16

## Large Bend Radius Dies<sup>1</sup>

### Manual Powered Hyd Tube Bender

Tube OD	Size <sup>2</sup>	Bend Radius <sup>3</sup>	Min Length of Straight After Bend
1/4	4	3/4	1 1/4
5/16	5	1	1 1/4
3/8	6	1 1/4	1 3/8
1/2	8	2	1 3/8
5/8	10	2 1/2	1 3/8
3/4	12	3	1 3/4

### Hydraulic Powered Hyd Tube Bender

5/8	10	1 1/2	1 5/8
3/4	12	1 3/4	1 1/2
7/8	14	2	1 3/4
1	16	3	2 1/2
1 1/4	20	3 3/4	3
1 1/2	24	5	3 1/8

Tube Benders	Manufacturer/Model No.
Manual (M)	Parker/412
Hydraulic (H)	JD2/MODEL 32
Hydraulic (H)	Parker/HB633

- JD2 Model 32 is the primary bender.
- Parker Benders are used for Hydraulic Hardlines only.

## JD2 MODEL 32\* Pipe & Tube Bender

### Hydraulic Powered

Nominal OD (Actual OD)	MAT	Bend Radius <sup>3</sup>	Min Length of Start	Min Length Between Bends After 90° Bend**	Min Length After Bend
3/4 (1.050)	PIPE	3	4 3/16	4 3/16	4 1/2
1 (1.000)	TUBE	3	4 3/16	4 3/16	4 1/2
1 (1.315)	PIPE	3 1/2	4 5/16	4 5/16	4 1/2
1 1/2 (1.900)	PIPE	5 1/2	4 7/16	4 7/16	5 5/8

## Stainless Steel Hydraulic Tube Bender Capacity<sup>4</sup>

Wall Thickness <sup>5</sup> (in)	Tube OD (in)			
	3/4 (12)	1 (16)	1 1/4 (20)	1 1/2 (24)
0.035	M/H <sup>6,7</sup>	H <sup>7</sup>	H <sup>7</sup>	H <sup>7</sup>
0.049	M/H <sup>7</sup>	H <sup>7</sup>	H <sup>7</sup>	H <sup>7</sup>
0.058	H	H <sup>7</sup>	H <sup>7</sup>	H <sup>7</sup>
0.065	H	H <sup>7</sup>	H <sup>7</sup>	H <sup>7</sup>
0.072	H	H	H <sup>7</sup>	H <sup>7</sup>
0.083	H	H	H <sup>7</sup>	H <sup>7</sup>
0.095	H	H	H	H <sup>7</sup>
0.109	H	H	H	H
0.120	H	H	H	H
0.134	H	H	H	H
0.156	H	H	H	H
0.188	H	H	H	H

- Dies are notated by size and bend radius (Ex: “#5 x 11/16”)
- Size represents the tube OD in sixteenths (Ex: Size 4 is 4/16” or 1/4” OD)
- Bend radius is the centerline radius of the tube
- The manual bender is able to bend 1/2” OD and lower stainless steel hydraulic tubing regardless of wall thickness.
- Tube wall thickness is a minimum of 7% of the OD to avoid kinking
- M and H represent Manual and Hydraulic tube benders respectively
- Tube flaring machine needs at least 2” of straight after bend

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- ◆ Hydraulic manifolds
- ◆ Tank accessories
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- ◆ Filters & tank accessories
- ◆ Farm and tractor parts



- ◆ Chemical sprayers
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GK Machine is locally owned and operated for close to 50 years in Donald, Oregon. GK is much more than just a farm store—we carry the brands you trust!

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Owner /Sales



**Connie Lindsay**  
Marketing



**Mike Mader**  
Manufacturing Sales

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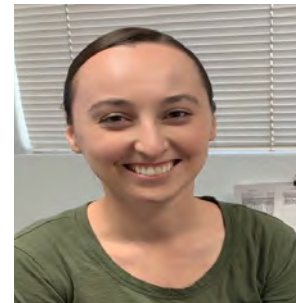
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