

Huth Ben Pearson Pipe Compression/ram-style benders vs. other types

	Compression-Ram Bender (Huth Ben Pearson)	Rotary Draw Bender	Mandrel
Speed	Fast, approx. 15 second cycle	20% longer cycle for model capable of handling 3" OD (TB80)	Typically faster.
Range	Up to 3 in. OD	Different models have different capacities	Broader tube size range
Bend Radius	3.5 in., 4 in. , 5 in.	Larger minimum radius (6 in. min on 3 inch OD)	Broader range, down to 1.5 X diameter
Tool Changeover time	Very quick, under 1 min.	Much Longer	Much longer
Cost	Low, typically \$10-15K US	Higher, 3" (TB80) approx. \$30K, 2 ½" (TB60) \$18K	Much higher cost, 8-10 times per OD capability
Tooling cost	\$600-\$1100 per OD	\$2-3+K per tool set	Much, much more expensive
Compression	Approx. 4.5% on 14 gage tubing, less on thicker wall	Approx. 2% on 14 gage tubing, less on thicker wall	None
End forming	Most models include end	Not included	Not included