

THERE ARE LIMITATIONS ON SOME DIES REGARDING BEND ANGLES , WALL THICKNESS & MATERIAL

ROUND TUBE												MIN. CLAMP DIMENSION
OUTSIDE DIAMETER		CENTRE LINE RADIUS (mm)										
MM	INCHES											
6.35	1/4"	14*										
8	5/16"	18*										
9.5	3/8"	20*	24*									
12.7	1/2"	20*	35*									
16	5/8"	26	40	45*								
19.1	3/4"	29	31	76*	90*							80
22.2	7/8"	30	41	50	55	115*						100
25.4	1"	38	50	76*	115*							120 /65
31.8	1 1/4"	57	80	148*								140
38.1	1 1/2"	72	76	94	140	190*						160/120
44.5	1 3/4"	80	165*									160
50.8	2"	102	110	76								230/120
63.5	2 1/2"	114										250



NOMINAL BORE PIPE													MIN. CLAMP DIMENSION
DIAMETER			CENTRE LINE RADIUS (mm)										
MM	INCHES	OD											
10	3/8"	17.15	35*	59*									
15	1/2"	21.3	41.5*										
20	3/4"	26.7	51*	80*	90*	106*						140	
25	1"	33.4	52	85*	115*							110	
32	1 1/4"	42.2	76	90	115*	140*						140	
40	1 1/2"	48.3	76	165*								150	
50	2"	60.3	190									250	

SQUARE TUBE												MIN. CLAMP DIMENSION
OUTSIDE DIAMETER		CENTRE LINE RADIUS (mm)										
MM	INCHES											
19.1	3/4"	57										120
25.4	1"	76										120
50.8	2"	125	165									120

COLLAPSE BEND ONLY

RECTANGLE TUBE												MIN. CLAMP DIMENSION
OUTSIDE DIAMETER		CENTRE LINE RADIUS (mm)										
MM	INCHES											
50.8 x 25.4	2" x 1"	152										160

FLAT SIDED OVAL												MIN. CLAMP DIMENSION
OUTSIDE DIAMETER		CENTRE LINE RADIUS (mm)										
MM	INCHES											
31.8x15.9	1 1/4"x5/8"	40										

* NON MANDREL
 ROLLING OF ROUND TUBE LISTED, DOWN TO 10 TIMES TUBE DIAMETER AS A MINIMUM CENTRE RADIUS