

Unit A, Scotswood Park,
Gordleton Industrial Park
Hannah Way, Pennington,
Lymington, Hampshire SO41 8JD

T: 01590 286080
E: info@tubecraft.co.uk
W: tubecraft.co.uk

MANDREL BENDING TOOLING LIST

TUBE DIAMETER (mm)	CENTRE LINE RADIUS (mm)	CLAMP LENGTH (mm) Minimum Straight Distance Between Bends	MAX DEGREE OF BEND Degree Of Bend
3.18	15	10*	180
4.76	25	20	180
6	12	12	170
6	12	12	180
6	15	12	170
6	15	12*	160
6	25	38	180
6.35	8	38	180
6.35	12	12	170
6.35	12	12	180
6.35	14	12	180
6.35	16	12	170
6.35	16	12	170
6.35	20	12	170
6.35	20	12	180
6.35	38	12	180
6.35	45	12	180
6.35	136	12	180
8	16	16	170
8	16	16	180
8	20	16	180
8	22	45	180
8	24	16	170
8	24	16	180
8	28	16	180
9.53	12.7	20	180
9.53	15	25	170
9.53	17	50	180
9.53	25	45	180
9.53	25	15	170
9.53	25	15* & 25*	180
9.53	28	15	180
9.53	30	15	180
9.53	30	15*	180
9.53	32	36	180
9.53	38	45	180
9.53	38	15	180
9.53	45	30	180
9.53	45	30*	180
9.53	48	18*	180
9.53	48	15	180
9.53	51	45	180
9.53	57	26	180
9.53	60	25*	180
9.53	64	45	180
9.53	76	45	180
10	12	30	180

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Clamp Lengths

* Removable clamp insert
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S Serrated clamp.

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10	12.7	64	180
10	15	20	170
10	15	20*	170
10	16.5	20	180
10	19	13	180
10	19	20*	180
10	20	14-S* & 20*	170
10	20	14-S* & 20*	180
10	25	20	170
10	25	20*	180
10	30	32	180
10	30	38	180
10	38	32	180
10	76	20*	180
11.11	15	40	170
11.11	29	40	180
12	24	24	170
12	24	24	180
12	38	112	180
12	38	36	180
12	38	24	180
12	50	24	180
12.7	19	51	180
12.7	19	25	170
12.7	19	32*	180
12.7	25	45	180
12.7	25	25* & 20*	90
12.7	29	38	180
12.7	30.7	25	180
12.7	32	38	180
12.7	35.3	25	180
12.7	38	25	180
12.7	38	44	180
12.7	38	15* & 25*	180
12.7	51	45 & 115	180
12.7	51	25*	180
12.7	57	58	180
12.7	60	20*	180
12.7	64	45	180
12.7	64	18* & 30*	180
12.7	64	25	180
12.7	76	44	180
13.7	41	38	180
14.3	30	38	180
14.3	30	15* & 40*	180
14.3	43.5	30*	180
14.3	45	30	180

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14.3	45	45	180
14.3	45	30*	180
14.3	71	24 & 40*	180
14.3	72	40*	180
14.3	72	30	180
14.7	45	30*	180
14.7	72	40*	180
15.22	46	50*	180
15.22	77	25*	180
15.88	17	36	180
15.88	19	80	180
15.88	25	45	180
15.88	25	50*	180
15.88	29	51	180
15.88	29	40*	180
15.88	32	45*	180
15.88	38.1	51	180
15.88	38.1	45*	180
15.88	44	51	180
15.88	51	51	180
15.88	51	37*	180
15.88	64	51	180
15.88	76	48*	180
15.88	76	32*	180
15.88	76	51	180
15.88	100	45*	180
16	32	40*	180
16	35	51	180
16	50	40*	180
16	68	40*	180
16	80	40*	180
17.28	87	50*	180
17.53	51	50*	180
17.53	87	50*	180
18	23	50*	180
18	23	50*	180
18	51	50*	180
19.1	19.1	60	90
19.1	22	81	180
19.1	25	35	180
19.1	28	18-S*	110
19.1	28	51	180
19.1	28	51	100
19.1	32	51	180
19.1	32	30*	180
19.1	38	51	180
19.1	38	40* & 51*	180

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19.1	45	51	180
19.1	48	38*	180
19.1	51	105	180
19.1	51	51	180
19.1	51	51*	180
19.1	57	28* & 38*	180
19.1	64	150	180
19.1	64	28* & 49*	180
19.1	76	51	180
19.1	76	100	180
19.1	76	25* & 48*	180
19.1	89	150	180
19.1	89	48*	180
19.1	95	50*	180
19.1	102	150	180
19.1	102	50*	180
19.1	114	155	180
19.1	127	150	180
20	25	60	160
20	30	40	180
20	34	60	180
20	75	40* & 60*	180
20	95	60*	180
20	100	155	180
21.25	87	40*	180
21.3	29	40*	180
21.3	40	40*	180
21.3	60	40*	180
21.3	60	50 & 150	180
21.3	70	35*	180
21.3	102	35*	180
21.3	102	40*	180
21.3	108	45* & 150*	180
21.65	102	40*	180
22	22	65	180
22	30	60	180
22	36	50*	180
22	40	50*	180
22	60	60	180
22.2	29	60	180
22.2	40	20-S* & 40*	180
22.2	44	58	180
22.2	51	45	180
22.2	51	110	180
22.2	51	50*	180
22.2	64	55*	180
22.2	70	35	180

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TUBE DIAMETER (mm)	CENTRE LINE RADIUS (mm)	CLAMP LENGTH (mm) Minimum Straight Distance Between Bends	MAX DEGREE OF BEND Degree Of Bend
22.2	75	50*	180
22.2	76	152	180
22.2	102	152	180
22.2	102	40* & 65*	180
22.2	152	152	180
22.97	112	40*	180
23.37	64	50*	180
25	38	60*	180
25	50	60	180
25	50	60*	180
25.4	25.4	60	90
25.4	38	26-S* & 40* & 60*	180
25.4	51	75/125/150	180
25.4	51	45* & 64*	180
25.4	64	60*	180
25.4	64	90* & 133*	180
25.4	76	120	180
25.4	76	60*	180
25.4	89	60*	180
25.4	89	152	180
25.4	95	152	180
25.4	102	152	180
25.4	102	60*	180
25.4	114	152	180
25.4	114	60*	180
25.4	127	152	180
25.4	127	32* & 50*	180
25.4	140	152	180
25.4	152	60*	180
25.4	152	152	180
25.4	165	152	180
25.4	200	152	180
25.81	127	50*	180
26.7	38	76	160
26.7	51	100	180
26.7	51	76	180
26.7	64	115	180
26.7	76	48	180
26.7	76	152	180
26.7	89	120	180
26.7	100	50*	180
26.7	102	152	180
26.7	120	25* & 50*	180
26.7	127	152	180
26.7	130	50*	180
26.7	152	152	180
28	75	70*	180

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28	117	70*	180
28	150	90*	180
28.6	45	30-S* & 60*	180
28.6	51	152	180
28.6	64	80	180
28.6	64	152	180
28.6	75	80*	180
28.6	76	125	180
28.6	89	152	180
28.6	102	56* & 158*	180
28.6	102	80*	180
28.6	127	152	180
28.6	152	152	180
30	75	75*	180
30	89	100	180
30	165	90	120
30	355	90	120
30.6	152	75*	180
31.75	51	152	160
31.75	51	50-S* & 80*	180
31.75	64	65* & 152*	175
31.75	64	55* & 64* & 80*	180
31.75	76	80*	180
31.75	76	65* & 147*	180
31.75	89	80*	180
31.75	89	152	180
31.75	102	80*	180
31.75	102	152	180
31.75	114	80*	180
31.75	114	152	180
31.75	127	80*	180
31.75	127	127	180
31.75	152	80*	180
31.75	152	152	180
31.75	218	89	150
33.4	44	100	180
33.4	50	100	180
33.4	51	110	180
33.4	57	152	180
33.4	64	125	180
33.4	64	100*	180
33.4	76	152	180
33.4	76	100*	180
33.4	89	122	180
33.4	95	60* & 100*	180
33.4	102	110	180
33.4	102	100*	180

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33.4	114	130	180
33.4	127	130	180
33.4	150	60*	180
33.4	152	60* & 127*	180
34.9	57	155	180
34.9	76	115	180
34.9	102	152	180
34.9	127	152	180
34.9	152	152	180
34.9	190	152	180
35	70	60*	180
35.8	269	152	180
38.1	51	115* & 60-S*	170
38.1	57	85* & 100*	175
38.1	64	155	160
38.1	76	152	160
38.1	76	100*	180
38.1	76	100*	180
38.1	89	100*	180
38.1	89	135	180
38.1	102	75* & 150*	180
38.1	102	75* & 100*	180
38.1	114	145	180
38.1	114	80*	180
38.1	127	150	180
38.1	127	50* & 100*	180
38.1	133	133	180
38.1	152	80*	180
38.1	152	152	180
38.1	178	178	180
38.1	203	203	180
40	100	70-S* & 100*	180
40	127	152	180
40	152	152	180
41.3	76	152	180
41.3	76	90*	180
41.3	89	152	180
41.3	102	120	180
41.3	127	152	180
41.3	152	152	180
42.4	50	60-S	180
42.4	63	85* & 110*	135
42.4	76	152	180
42.4	76	125*	180
42.4	89	130	180
42.4	100	125*	180
42.4	102	152	180

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42.4	114	152	180
42.4	127	152	180
42.4	150	125*	180
42.4	221	125*	180
44.45	90	40-S & 70*	180
44.45	130	40-S & 70*	180
44.5	76	152	180
44.5	76	152*	180
44.5	102	152	180
44.5	127	152	180
44.5	152	152	180
48.3	70	160	150
48.3	76	85-S* & 152*	180
48.3	76	152	180
48.3	102	100 & 152*	180
48.3	114	152	180
48.3	127	152	160
48.3	146	152	180
48.3	152	152	180
48.3	178	152	180
48.3	254	152	180
50	75	152	180
50.8	75	115 & 152*	180
50.8	85	152	180
50.8	102	150* & 200*	180
50.8	102	125*	180
50.8	127	152	180
50.8	152	100* & 152*	180
50.8	152	152	180
50.8	203	152	180
50.8	500	152	135
50.8	610	152	135
51	76	152*	180
51	102	152*	180
54	152	152*	180
57	112	152*	180
57.2	76	100	120
57.2	152	152	175
57.2	200	152	180
57.2	350	152	180
60.3	112	152	180
60.3	120	100-S* & 152*	180
60.3	152	152	180
60.3	175	175	180
60.3	200	63 - S* & 150*	180
60.3	200	150	180
60.3	254	180	180

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63.5	95	95-S* & 152*	180
63.5	102	165	180
63.5	121	152* & 190*	180
63.5	127	152* & 190*	180
63.5	140	152*	180
63.5	146	152*	180
63.5	152	152*	180
63.5	152	152	180
63.5	190	152*	180
63.5	250	125* & 190*	180
63.5	367	95-S*	180
63.5	500	152	135
73	230	220	180
76.2	114	210	180
76.2	114	90-S*	180
76.2	114	230*	145
76.2	152	190* & 120-S*	180
76.2	152	230	180
76.2	190	152	180
76.2	190	130* & 230*	180
76.2	190	190*	180
76.2	230	230	180
76.2	360	152* & 190*	180
76.2	360	152	180
76.2	500	235	140
76.2	600	230	180
76.2	750	230	110
76.2	900	230	180
80	500	240	140
84	168	250	180
88.9	115	150-S*	180
88.9	133.35	135	180
88.9	230	265	180
88.9	230	265	180
88.9	395	265	180
88.9	600	270	145
88.9	750	270	110
88.9	900	265	180
101.6	102	280*	100
101.6	152	280*	160
101.6	203	300*	180
101.6	305	200* & 300*	180
101.6	305	240	180
101.6	305	305	180
101.6	400	305	120
101.6	500	305	145
101.6	600	280	180

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101.6	750	305	110
101.6	900	305	180
104	300	300	180
104	500	300	90
104	750	300	90
108	216	325	180
114.3	114	210* & 320*	100
114.3	305	345	180
114.3	500	340	145
114.3	600	340	180
114.3	750	340	110
114.3	900	345	180
127	600	380	180
127	900	380	180
129	375	300	180
129	500	380	100
129	750	380	120
129	900	380	120
154	500	300	90
154	800	300	90
159	318	400	135
159	477	400	135

SQUARE / BOX SECTION TOOLING Section Size (mm)	Centre Line Radius (mm)	Clamp Length (mm)	Max D.O.B
25 x 25 BOX	87.5	60	180
50 x 25 BOX	265	150	180
50 x 50 BOX	100	150	180
60 x 30 BOX	129	150	180

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