

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

T: 01590 286080  
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## 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	20	20	180
6	8	38	180
6	12	12	180
6	15	12*	160
6.35	12	12	180
6.35	20	12	180
6.35	38	12	180
6.35	45	12	180
6.35	136	12	180
8	16	16	180
8	24	16	180
9.53	15	25	170
9.53	25	15* & 25*	180
9.53	30	15*	180
9.53	45	30*	180
9.53	48	18*	180
9.53	60	25*	180
10	15	20*	180
10	20	20*	180
10	25	20*	180
10	76	20*	180
11.11	29	40	180
12	24	24	180
12.7	19	32*	180
12.7	25	25* & 20*	90
12.7	38	15* & 25*	180
12.7	40	15* & 25*	180
12.7	51	25*	180
12.7	60	20*	180
12.7	64	18* & 30*	180
14.3	30	15* & 40*	180
14.3	43.5	30*	180
14.3	45	30*	180
14.3	71	40*	180
14.3	72	40*	180
14.7	30	40*	180
14.7	45	30*	180
14.7	72	40*	180
15.22	46	50*	180
15.22	77	25*	180
15.88	25	50	180
15.88	29	40*	180
15.88	38.1	45*	180
15.88	48	51	180
15.88	51	37*	180
15.88	76	32*	180

This tooling list is regularly updated. Please contact us if you require tooling that is not shown on this list.

The information listed should be used as a guide for design

purposes. If you are unsure if the tooling will meet your requirements please contact us to discuss your design.

#### Clamp Lengths

\* Removable clamp insert  
(Clamp length can be modified on tool.  
Chargeable if required).

S Serrated clamp.

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15.88	80	40*	180
15.88	102	45*	180
16	32	40*	180
16	50	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	51	50*	180
19.1	28	18 -S*	180
19.1	28	51	100
19.1	32	30*	180
19.1	38	40* & 51*	180
19.1	48	38*	180
19.1	51	51*	180
19.1	57	28* & 38*	180
19.1	64	28* & 49*	180
19.1	76	25* & 48*	180
19.1	89	48*	180
19.1	95	50*	180
19.1	102	50*	180
20	25	60	160
20	34	60	180
20	75	40* & 60*	180
20	100	60*	180
21.25	87	40*	180
21.3	29	40*	180
21.3	40	40*	180
21.3	70	35	180
21.3	102	40*	180
21.65	102	40*	180
22	30	60	180
22	36	50*	180
22	40	50*	180
22	60	60	180
22.2	40	20-S*/40*/50*	180
22.2	51	50*	180
22.2	64	55*	180
22.2	75	50*	180
22.2	102	40* & 65*	180
23.37	64	50*	180
25	38	26-S* 60*	180
25	50	60*	180
25.4	38	26-S* & 40* & 60*	180
25.4	51	45* & 64*	180
25.4	64	60*	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
25.4	76	60*	180
25.4	89	60*	180
25.4	102	60*	180
25.4	114	60*	180
25.4	127	50*	180
25.4	152	60*	180
25.81	127	80*	180
26.7	38	76	160
26.7	51	76*	180
26.7	100	50*	180
26.7	120	40*	180
26.7	130	50*	180
28	75	70*	180
28	117	70*	180
28	150	90*	180
28.6	45	30* & 60*	180
28.6	102	80*	180
30	75	75*	180
30	165	90	120
30	355	90	120
30.6	152	75*	180
31.8	51	50-S* & 80*	160
31.8	64	64* & 80*	180
31.8	76	80*	180
31.8	102	80*	180
31.8	114	80*	180
31.8	127	80*	180
31.8	152	80*	180
33.4	50	100*	180
33.4	64	100*	180
33.4	76	100* & 152	180
33.4	102	100* & 110	180
33.4	150	60*	180
34.9	70	60*	180
34.9	76	115	180
34.9	102	152	180
34.9	127	152	180
34.9	152	152	180
38.1	51	115* & 60-S*	170
38.1	57	85* & 100*	175
38.1	76	100*	180
38.1	89	100*	180
38.1	102	75* & 100*	180
38.1	114	100*	180
38.1	127	50* & 100*	180
38.1	152	100*	180
38.1	203	203	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
40	100	70-S* & 100*	180
40	152	152	180
41.3	76	152	180
41.3	89	152	180
41.3	102	120	180
41.3	127	152	180
41.3	152	152	180
42.2	50	60-S	135
42.2	63	110	135
42.2	76	125*	180
42.2	100	125*	180
42.2	152	152	180
44.5	76	152	180
44.5	102	152	180
44.5	127	152	180
44.5	152	152	180
48.3	76	152	180
48.3	102	100 & 152*	180
48.3	125	152	160
48.3	152	152	180
50.8	76	115* & 152*	180
50.8	85	152	180
50.8	102	125*	180
50.8	127	152	180
50.8	152	152	180
50.8	203	152	180
50.8	610	152	135
51	76	152*	180
51	102	152*	180
57.2	152	152	175
57.2	200	152	180
60.3	120	152*	180
60.3	152	152	180
60.3	200	63 - S* & 150*	180
60.3	254	180	180
63.5	95	152*	180
63.5	121	152* & 190*	180
63.5	127	152* & 190*	180
63.5	152	152*	180
63.5	190	152*	180
73	230	220	180
76.2	114	230*	180
76.2	152	120-S* & 190*	180
76.2	152	230	180
76.2	190	190*	180
76.2	360	152	180
76.2	500	235	140

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76.2	600	230	180
76.2	900	230	180
80	500	240	140
84	168	250	180
88.9	115	150-S*	180
88.9	230	265	180
88.9	395	265	180
88.9	600	270	145
88.9	900	265	180
101.6	101.6	280*	180
101.6	152	280*	180
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
101.6	900	305	180
104	300	300	180
114.3	114	210* & 320*	180
114.3	305	345	180
114.3	500	340	145
114.3	600	340	180
114.3	900	345	180
127	600	380	180
127	900	380	180
129	375	300	180
129	750	380	120
129	500	380	100
129	900	380	120
154	500	300	120
154	800	300	120

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