

MANDREL BENDING TOOLING LIST

T: 01483 773208
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W: tubecraft.co.uk

| 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 |
| 6 | 12 | 12 | 180 |
| 6 | 15 | 12* | 160 |
| 6.35 | 12 | 12 | 180 |
| 6.35 | 20 | 12 | 180 |
| 8 | 16 | 16 | 180 |
| 8 | 24 | 16 | 180 |
| 9.53 | 25 | 15* & 25* | 180 |
| 9.53 | 30 | 15* | 180 |
| 9.53 | 48 | 18* | 180 |
| 9.53 | 60 | 25* | 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 |
| 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 |

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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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|--------------------|-------------------------|--|--------------------------------------|
| 18 | 23 | 50* | 180 |
| 19.1 | 28 | 18 -S* | 180 |
| 19.1 | 28 | 51 | 100 |
| 19.1 | 32 | 30* | 180 |
| 19.1 | 38 | 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 |
| 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 | 36 | 50* | 180 |
| 22 | 40 | 50* | 180 |
| 22.2 | 40 | 50* | 180 |
| 22.2 | 51 | 50* | 180 |
| 22.2 | 64 | 55* | 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 |
| 25.4 | 76 | 60* | 180 |
| 25.4 | 102 | 60* | 180 |
| 25.4 | 127 | 50* | 180 |
| 25.4 | 152 | 60* | 180 |
| 25.81 | 127 | 80* | 180 |
| 26.7 | 38 | 76 | 160 |
| 26.7 | 120 | 40* | 180 |
| 28 | 75 | 70* | 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 |

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|--------------------|-------------------------|--|--------------------------------------|
| 31.8 | 51 | 80* | 160 |
| 31.8 | 64 | 64* & 80* | 180 |
| 31.8 | 76 | 80* | 180 |
| 31.8 | 102 | 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 | 152 | 180 |
| 33.4 | 102 | 110 | 180 |
| 33.4 | 152 | 60* & 127* | 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 | 102 | 75* & 100* | 180 |
| 38.1 | 127 | 50* & 100* | 180 |
| 38.1 | 152 | 100* | 180 |
| 38.1 | 203 | 203 | 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 | 127 | 152 | 180 |
| 48.3 | 152 | 152 | 180 |
| 50.8 | 76 | 152* | 180 |
| 50.8 | 85 | 152 | 180 |
| 50.8 | 102 | 125* | 180 |
| 50.8 | 127 | 152 | 180 |
| 50.8 | 152 | 152 | 180 |

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|--------------------|-------------------------|--|--------------------------------------|
| 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 | 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 |
| 76.2 | 600 | 230 | 180 |
| 76.2 | 900 | 230 | 180 |
| 80 | 500 | 240 | 140 |
| 84 | 168 | 250 | 180 |
| 88.9 | 230 | 265 | 180 |
| 88.9 | 395 | 265 | 180 |
| 88.9 | 600 | 270 | 145 |
| 88.9 | 900 | 265 | 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 |
| 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 | 750 | 380 | 120 |
| 129 | 900 | 380 | 120 |

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