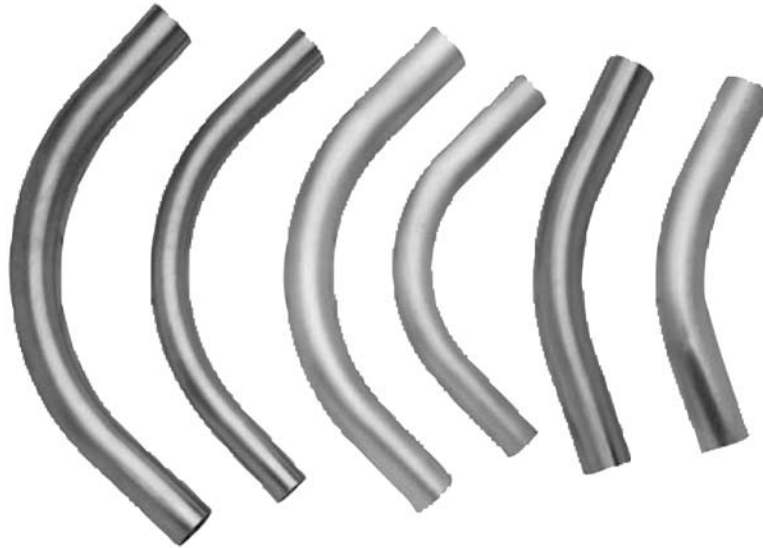


Tube & Pipe Bending



Aluminum • Carbon Steel • Stainless • Galvanized

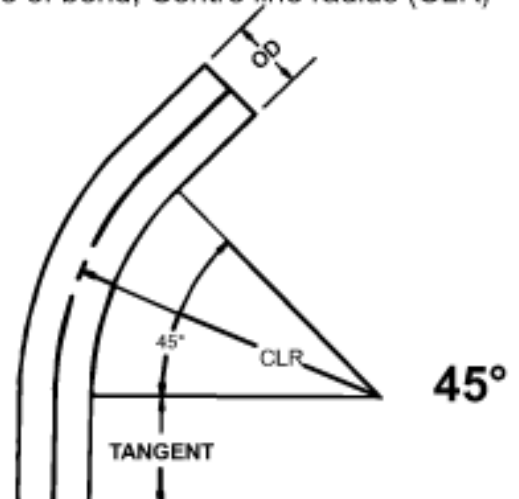
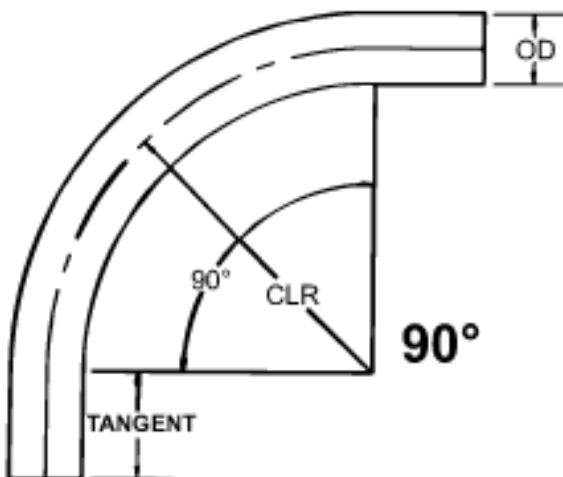
Long & short radius elbows and bends for pneumatic conveying and vacuum conveying systems. Internal mandrel bending equipment provides top quality bends from 1" up to 6" O.D. (outside diameter) covering all standard tube & pipe sizes. Selected materials specific to the conveying industry provide consistent, uniform and durable bends. 90°, 60°, 45°, 30°, 22° elbows are manufactured for immediate delivery. Custom offsets and custom bending is available.

BENDING MATERIAL SPECIFICATIONS			
	Aluminium	Stainless	Carbon
Tubing	6063-T1	304/304L/316	ERW-FC
	Extruded	A554/A778/A249	A513
Pipe	6063-T1	304/304L/316	Black
	Extruded	A312	A53/A312

Wall thickness*: 16 gauge (.065"), 14 gauge (.083"), 11 gauge (.120"/.125"), Schedules 10, 40, 80
*all specifications are for reference only!

ORDER BENDS BY:

Outside Diameter (OD), Wall thickness, Material, Degree of bend, Centre line radius (CLR)



Bending Information

TUBE BENDING CAPABILITIES

OD (inches)	CENTER LINE RADIUS (CLR) (inches)	GAUGE	WALL THICKNESS (inches)
1-1/2	5-3/4, 7, 10, 11-3/4, 18, 24, 30, 36, 48	11, 16	.120, .065
1-3/4	10-1/4, 11-3/4, 18, 24, 30, 36, 48	16	.065
2	7, 10-1/4, 11-3/4, 18, 24, 30, 36, 48	11, 16	.120, .065
2-1/8	5, 10-1/4, 24, 36	16	.065
2-3/16	10-1/4, 18, 24, 36, 48	16	.065
2-1/4	11-3/4, 18, 24, 36, 48	16	.065
2-1/2	6, 10-1/4, 11-3/4, 15-1/2, 18, 24, 30, 36, 48	16, 11	.065, .120
2-3/4	11-3/4, 18, 24, 30, 36, 48	11	.120
3	7-1/2, 18, 24, 30, 36, 48	16	.065
3	8-13/16, 11-3/4, 15-1/2, 18, 24, 30, 36, 48	11	.065, .120
3-1/4	18, 24, 30, 36, 48	11	.120
3-1/2	11-3/4**, 15-1/2, 18, 24, 30, 36, 48	11	.120
4	10, 30, 48	16	.065, .120
4	13-5/8, 15-1/2, 18, 24, 30, 36, 48	11	.120
4-1/4	18, 24, 30, 36, 48	11	.120
4-1/2	18, 24, 30, 36, 48	11	.120
5	30, 36, 48	11	.120
6	36, 48	11	.120

**11 gauge only

PIPE BENDING CAPABILITIES

NOMINAL PIPE SIZE	O.D.	CENTER LINE RADIUS (CLR) (inches)	SCHEDULE	WALL THICKNESS (inches)
1	1.315	4-1/8, 5	40	0.133
1-1/4	1.660	6-1/2, 24	40	0.14
1-1/2	1.900	5-3/4, 7-5/16, 10-1/4, 18, 24, 30, 48	40	0.145
2	2.375	6-7/8*, 7-13/16*, 10-1/4, 11-3/4, 15-1/2, 18, 24, 30, 36, 48	10, 40, 80	.109, .154, .218
2-1/2	2.875	7-3/8*, 9-7/8*, 11-3/4, 15-1/2, 18, 24, 30, 36, 48	10, 40, 80	.120, .203, .276
3	3.500	8-13/16, 11-3/4, 15-1/2, 18, 24, 30, 36, 48	10, 40, 80	.120, .216, .300
3-1/2	4.000	10-1/2*, 12*, 13-5/8, 15-1/2, 18, 24, 30, 36, 48	10, 40, 80	.120, .226, .318
4	4.500	12*, 15-1/2*, 18, 24, 30, 36, 48	10, 40, 80	.120, .237, .337
5	5.563	20*, 30, 36, 48	10, 40, 80	.134, .258, .375
6	6.625	24*, 30*, 36^, 48	10, 40, 80	.134, .280, .432

^ONLY ALUM IN SCH 10

*ONLY SCHEDULE 40 & UP