



A DIVISION OF KIFFER INDUSTRIES
Last revised: 09/20/2013

ROUND TUBE BENDING CHART
(CHART BELOW BASED ON BENDING LOW CARBON STEEL TUBE)

TUBE O.D.	CENTERLINE RADIUS								
	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0	6.5
.500	STD	.035	.035	.035	.035	.035	.035	.035	.035
	.035								
.625	.049	.049	.049	.049	.049	.049	.049	.049	.049
.750	M	STD	.049	.049	.049	.049	.049	.049	.049
	.028	.049							
.875	M	.065	.065	.065	.065	.065	.065	.065	.065
1.000	M	STD	.065	STD	.065	.065	.065	.065	.065
	.049	.083		.065					
1.125	M	.095	.083	.065	.065	.065	.065	.065	.065
1.250	M	M	.125	STD	.083	STD	.065	.065	.065
	.065	.065		.095		.065			
1.375		M	M	.125	.095	.083	.083	.065	.065
1.500			M	M	.109	STD	.095	STD	.083
			.083	.065		.095		.083	
1.625				M	M	.109	.095	.095	.083
1.750					M	M	.095	STD	.095
					.083	.083		.095	
1.875						M	M	.120	.120
2.000						M	M	.120	.120

- STD** STANDARD TOOLING - NORMALLY IN STOCK
- .000** VALUE IN BOX INDICATES MINIMUM WALL THICKNESS REQUIRED TO MAKE WRINKLE FREE BENDS
NOTE: THINNER WALL TUBES OFTEN REQUIRE THE USE OF AN INTERNAL MANDREL
- M** THIS SYMBOL INDICATES "INTERNAL" MANDREL IS REQUIRED. MANDREL BENDS SHOULD BE PERFORMED ON **BENTEC**'S ROTARY DRAW BENDER WITH MANDRELOPTIONAL PACKAGE.
PLEASE CALL BENTEC FACTORY AT **216-267-1818** TO DISCUSS YOUR BEND APPLICATION.

PIPE CHART FOR NON-MANDREL BENDING

(CHART BASED ON BENDING SCH40 STEEL PIPE & RIGID CONDUIT)

PIPE SIZE	ACTUAL PIPE O.D.	CENTERLINE RADIUS							
		3	3.5	4	4.5	5	5.5	6	6.5
3/8	.675	STD	OPT	OPT	OPT	OPT	OPT	OPT	OPT
1/2	.840	STD	OPT	OPT	OPT	OPT	OPT	OPT	OPT
3/4	1.050	OPT	OPT	STD	OPT	OPT	OPT	OPT	OPT
1	1.315			OPT	OPT	STD	OPT	OPT	OPT
1 1/4	1.660					OPT	OPT	STD	OPT
1 1/2	1.900					OPT	OPT	STD	OPT