

Mandrel Bend Tooling Chart

Precision tube bending in Stainless Steel, Inconel, Titanium and Aluminium.

Clamp Length

The minimum clamp length increases with the diameter and these are detailed in the far left columns. Longer clamp and tail lengths can be requested up to a maximum of 10 inches/250mm.

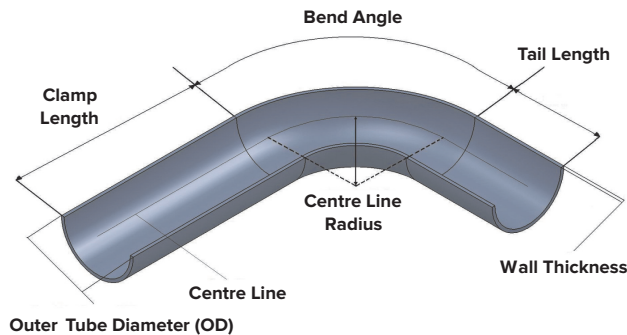
Diameter and CLR

Our bend tooling allows us to bend the Outer Diameters (OD) in the left hand column with the Centre Line Radius (CLR) along the top row.

Material

We bend stainless steel (304, 316 and 321), inconel, aluminium and titanium. We make our own 321 stainless, inconel and titanium tube so can bend all diameters on the tooling chart. Some aluminium and 304 stainless ODs are not available.

Clamp	O/D		CLR	mm	28.6	38.1	41.3	44.5	46.6	47.6	49.8	50.8	51.4	54.0	55.8	56.6	57.2	58.6	60.3	61.4	63.5	65.5	66.7	69.9	76.2	81.0	82.6	86.4	88.9	95.3	100.0	101.6	105.0	108.0	114.3	127.0	133.4	139.7	146.0	150.0	152.4	200.0								
mm	mm	imp		imp	1 1/8	1 1/2	1 5/8	1 3/4		1 7/8		2		2 1/8	2 1/5		2 1/4	2 3/8		2 1/2		2 5/8	2 3/4		3	3 1/4		3 1/2	3 3/4		4		4 1/4	4 1/2	5	5 1/4	5 1/2	5 3/4		6										
100	25.4	1			140			130				180					180																180																	
100	28.5	1 1/8										180																																						
100	31.8	1 1/4										140																																						
100	34.9	1 3/8										180																																						
125	38.1	1 1/2				135		180									145												160						180				180							180				
125	41.3	1 5/8					140										160												180																	140				
125	44.5	1 3/4						150									180												180																		180			
130	46.6								140								180																																	
125	47.6	1 7/8								130							150																														180			
165	49.8										130																																							
165	50.8	2										130																																			180			
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165	52.4																																														180			
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175	57.2	2 1/4															140																																	
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175	73.0	2 7/8																																																
200	76.2	3																																																
200	79.4	3 1/8																																																
200	82.6	3 1/4																																																
200	86.4																																																	
200	88.9	3 1/2																																																



To request quotes for bends in Stainless 304 & 321, Inconel, Titanium & Aluminium use our online bend calculator at www.goodfabs.com

Please contact us if you need tooling not on this chart.

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Download this chart at: www.goodfabs.com

This angle is the maximum possible with this tool.