

DESIGN CRITERIA for Induction bending										
Pipe		Radius		Wall	"A1"	"A2"	"B1"	"B2"	"C1"	"C2"
OD nominal	OD mm	OD	(mm)	WT (mm)	Front Clamp (mm)	(mm)	(mm)	(mm)	(mm)	(mm)
½"	21,3	3	65	> 2	140	205	150	280	600	665
¾"	26,7	2,4	65	> 2	140	205	150	280	600	665
1"	33,4	2	67	> 2,5	140	205	150	284	600	667
1 1/4"	42,4	2	85	> 3	140	225	150	320	600	685
1 ½"	48,3	2	96	> 3	140	236	150	342	600	696
2"	60,3	2	121	> 3,5	140	261	150	392	600	721
3"	88,9	2	178	> 5	260	438	300	656	600	778
4"	114,3	2	229	> 6	260	489	300	758	600	829
5"	141,3	2	282	7 to 22	260	542	300	864	600	882
5"	141,3	2	282	> 22	460	742	460	1024	1150	1432
6"	168,3	2	337	8 to 22	260	597	300	974	600	937
6"	168,3	2	337	> 22	460	797	460	1134	1150	1487
8"	219,1	2	438	11 to 80	460	900	460	1340	1150	1590
8»	219,1	3	657	11 to 100	460	1120	460	1770	1150	1810
10"	273,1	2,5	680	15 to 75	460	1140	460	1820	1150	1830
10»	273,1	3	819	11 to 100	460	1280	460	2100	1150	1970
12"	323,8	2,5	810	11 to 70	460	1270	460	2080	1150	1960
12»	323,8	3	970	11 to 100	460	1430	460	2400	1150	2120
14»	355,6	2,5	890	17 to 60	460	1350	460	2240	1150	2040
14"	355,6	3	1067	13 to 100	460	1527	460	2594	1150	2220
16"	406,4	3	1219	15 to 39	460	1679	460	2898	1150	2370
16"	406,4	3	1219	40 to 100	460	1680	460	2900	1150	2370
18»	457,2	3	1372	15 to 50	460	1830	460	3200	1150	2520
18"	457,2	5	2286	50 to 70	460	2750	460	5030	1150	3440

Values in grey areas are meant for pipes with extra thick wall.

We will, if necessary, attach (weld) extra pipe length needed for the bending operation.

