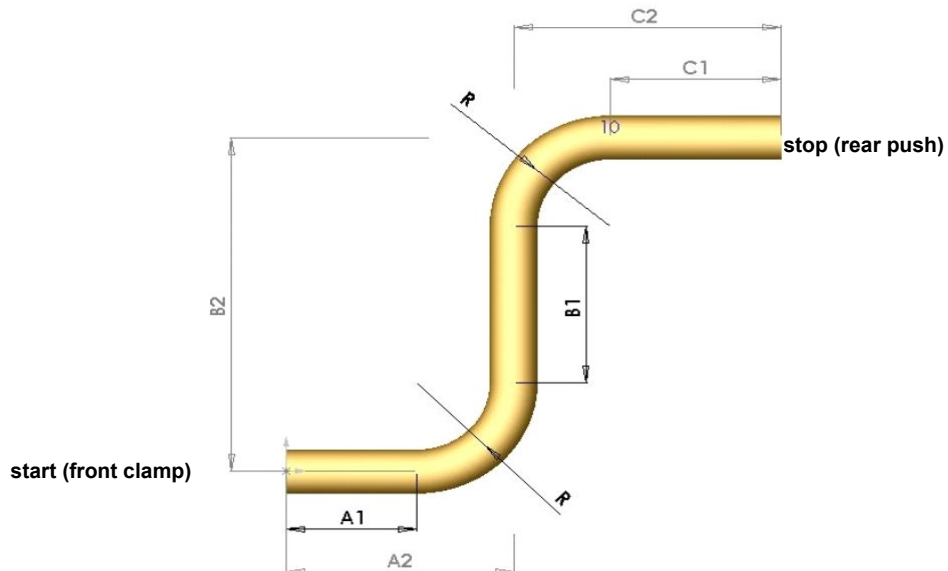


| DESIGN CRITERIA for Induction bending on: | | | | | | Stainless Steel | | | | |
|---|-------|---------|------|------------|------------------------|-----------------|--------------------------|------|----------------------|------|
| Pipe | | Radius | | Wall | "A1" | "A2" | "B1" | "B2" | "C1" | "C2" |
| nominal | (mm) | Minimum | | WT (mm) | Front Clamp (mm) | (mm) | between bends (mm) | (mm) | Rear push (mm) | (mm) |
| | | x OD | (mm) | | | | | | | |
| ½" | 21,3 | 3,2 | 67 | > 3 | 140 | 207 | 150 | 274 | 450 | 517 |
| ¾" | 26,7 | 2,6 | 67 | > 3 | 140 | 207 | 150 | 274 | 450 | 517 |
| 1" | 33,4 | 2 | 67 | > 4 | 140 | 207 | 150 | 274 | 450 | 517 |
| 1 ¼" | 42,2 | 2 | 84 | > 4 | 140 | 224 | 150 | 309 | 450 | 534 |
| 1 ½" | 48,3 | 2 | 97 | > 4 | 140 | 237 | 150 | 333 | 450 | 547 |
| 2" | 60,3 | 2 | 121 | > 4,5 | 140 | 261 | 150 | 381 | 450 | 571 |
| 2 ½" | 73,0 | 2 | 146 | > 5 | 140 | 286 | 150 | 432 | 450 | 596 |
| 3" | 88,9 | 2 | 178 | > 5,5 | 260 | 438 | 180 | 616 | 450 | 628 |
| 4" | 114,3 | 2 | 229 | > 6 | 260 | 489 | 180 | 717 | 450 | 679 |
| 5" | 141,3 | 3 | 424 | 7 to 35 | 260 | 684 | 260 | 1108 | 600 | 1024 |
| 5" | 141,3 | 2 | 283 | 15 to 35 | 460 | 743 | 460 | 1025 | 1150 | 1433 |
| 6" | 168,3 | 3 | 505 | 11 to 40 | 260 | 765 | 300 | 1270 | 1150 | 1655 |
| 6" | 168,3 | 2 | 337 | 18 to 40 | 460 | 797 | 460 | 1133 | 1150 | 1487 |
| 8" | 219,1 | 3 | 657 | 11 to 50 | 460 | 1117 | 460 | 1775 | 1150 | 1807 |
| 8" | 219,1 | 2 | 438 | 20 to 50 | 460 | 898 | 460 | 1336 | 1150 | 1588 |
| 10" | 273,0 | 3 | 819 | 15 to 50 | 460 | 1279 | 460 | 2098 | 1150 | 1969 |
| 10" | 273,0 | 2 | 546 | 20 to 50 | 460 | 1006 | 460 | 1552 | 1150 | 1696 |
| 12" | 323,8 | 2 | 648 | 18 to 50 | 460 | 1108 | 460 | 1755 | 1150 | 1798 |
| 12" | 323,8 | 3 | 971 | 15 to 50 | 460 | 1431 | 460 | 2403 | 1150 | 2121 |
| 14" | 355,6 | 2 | 711 | 21 to 45 | 460 | 1171 | 460 | 1882 | 1150 | 1861 |
| 14" | 355,6 | 3 | 1067 | 18 to 45 | 460 | 1527 | 460 | 2594 | 1150 | 2217 |
| 16" | 406,4 | 2 | 813 | 20 to 40 | 460 | 1273 | 460 | 2086 | 1150 | 1963 |
| 16" | 406,4 | 3,0 | 1219 | 18 to 40 | 460 | 1679 | 460 | 2898 | 1150 | 2369 |
| 18" | 457 | 2 | 914 | 25 to 40 | 460 | 1374 | 460 | 2288 | 1150 | 2064 |
| 18" | 457 | 3,0 | 1371 | 18 to 40 | 460 | 1831 | 460 | 3202 | 1150 | 2521 |
| 20" | 508 | 3 | 1524 | 20 to 25 | 460 | 1984 | 460 | 3508 | 1150 | 2674 |
| 20" | 508 | 4,5 | 2286 | 35 | 460 | 2746 | 460 | 5032 | 1150 | 3436 |

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

N.B.: This table is for general information and guidelines. We can improve and optimize after request. We will, if necessary, attach (weld) extra pipe length needed for the bending operation.



| DESIGN CRITERIA for Induction bending on: | | | | | | | Carbon Steel | | | |
|---|-------|---------|------|------------|------------------------|------|--------------------------|------|----------------------|------|
| Pipe | | Radius | | Wall | "A1" | "A2" | "B1" | "B2" | "C1" | "C2" |
| OD nominal | (mm) | Minimum | | WT (mm) | Front Clamp (mm) | (mm) | between bends (mm) | (mm) | Rear push (mm) | (mm) |
| | | x OD | (mm) | | | | | | | |
| ½" | 21,3 | 3,2 | 67 | > 3 | 140 | 207 | 150 | 274 | 450 | 517 |
| ¾" | 26,7 | 2,6 | 67 | > 3 | 140 | 207 | 150 | 274 | 450 | 517 |
| 1" | 33,4 | 2 | 67 | > 3,5 | 140 | 207 | 150 | 274 | 450 | 517 |
| 1 ¼" | 42,2 | 2 | 84 | > 4 | 140 | 224 | 150 | 309 | 450 | 534 |
| 1 ½" | 48,3 | 2 | 97 | > 4 | 140 | 237 | 150 | 333 | 450 | 547 |
| 2" | 60,3 | 2 | 121 | > 4,5 | 140 | 261 | 150 | 381 | 450 | 571 |
| 2 ½" | 73,0 | 2 | 146 | > 5 | 140 | 286 | 150 | 432 | 450 | 596 |
| 3" | 88,9 | 2 | 178 | > 5,5 | 260 | 438 | 180 | 616 | 450 | 628 |
| 4" | 114,3 | 2 | 229 | > 6 | 260 | 489 | 180 | 717 | 450 | 679 |
| 5" | 141,3 | 3 | 424 | 7 to 35 | 260 | 684 | 260 | 1108 | 600 | 1024 |
| 5" | 141,3 | 2 | 283 | 15 to 35 | 460 | 743 | 460 | 1025 | 1150 | 1433 |
| 6" | 168,3 | 2 | 337 | 11 to 40 | 260 | 597 | 300 | 933 | 1150 | 1487 |
| 6" | 168,3 | 2 | 337 | 18 to 40 | 460 | 797 | 460 | 1133 | 1150 | 1487 |
| 8" | 219,1 | 2 | 438 | 11 to 50 | 460 | 898 | 460 | 1336 | 1150 | 1588 |
| 8" | 219,1 | 3 | 657 | 20 to 50 | 460 | 1117 | 460 | 1775 | 1150 | 1807 |
| 10" | 273,0 | 2 | 546 | 15 to 50 | 460 | 1006 | 460 | 1552 | 1150 | 1696 |
| 10" | 273,0 | 3 | 819 | 20 to 50 | 460 | 1279 | 460 | 2098 | 1150 | 1969 |
| 12" | 323,8 | 2 | 648 | 18 to 50 | 460 | 1108 | 460 | 1755 | 1150 | 1798 |
| 12" | 323,8 | 3 | 971 | 15 to 50 | 460 | 1431 | 460 | 2403 | 1150 | 2121 |
| 14" | 355,6 | 2 | 711 | 21 to 45 | 460 | 1171 | 460 | 1882 | 1150 | 1861 |
| 14" | 355,6 | 3 | 1067 | 18 to 45 | 460 | 1527 | 460 | 2594 | 1150 | 2217 |
| 16" | 406,4 | 1,7 | 691 | 20 to 40 | 460 | 1151 | 460 | 1842 | 1150 | 1841 |
| 16" | 406 | 3 | 1219 | 18 to 40 | 460 | 1679 | 460 | 2898 | 1150 | 2369 |
| 18" | 457 | 2 | 914 | 25 to 40 | 460 | 1374 | 460 | 2288 | 1150 | 2064 |
| 18" | 457 | 3 | 1371 | 18 to 40 | 460 | 1831 | 460 | 3202 | 1150 | 2521 |
| 20" | 508 | 3 | 1524 | 20 to 25 | 460 | 1984 | 460 | 3508 | 1150 | 2674 |
| 20" | 508 | 4,5 | 2286 | 35 | 460 | 2746 | 460 | 5032 | 1150 | 3436 |

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

N.B.: This table is for general information and guidelines. We can improve and optimize after request. We will, if necessary, attach (weld) extra pipe length needed for the bending operation.

