

Rotary Draw Pipe Tooling

Minimum Achievable Radii with Standard Tooling

Pipe	.035	.049	.065	.083	.109	.120	.160	.180	.157	.177
1/4"	1.4	1.4	1	1	1	1	1	1	1	1
3/8"	2.2	2.2	1.4	1.4	1.4	1.4	1.4	1.4	1.4	1.4
1/2"	2.6	2.6	2.2	1.8	1.8	1.8	1.8	1.8	1.8	1.8
3/4"	3.2	3.2	3.2	2.6	2.6	2.2	2.2	2.2	2.2	2.2
1"	4.4	4.4	4.4	3.2	2.2	2.6	2.6	2.6	2.6	2.6
1-1/4"		5.9	5.1	3.9	3.9	3.5	3.5	3.5	3.5	3.5
1-1/2"		7.5	6.7	5.9	3.9	3.9	3.9	3.9		
2"			7.5	5.9	5.1	5.1	5.1			
2-1/2"				11.8	11.8	11.8	9.8	9.8		

Reference catalog for individual machine capacities

Pipe size	Outside Diameter	Wall Thickness Sch. / Inches	Minimum CLR Inches / Millimeter	Drive Diameter	Center Former Part#	Counterbend Die Part#
1/4"	.540	40 / .088	1.4 / 36	40mm	153R036P0250	155P0250
3/8"	.675	40 / .091	1.4 / 36	40mm	153R036P0375	155P0375
3/8"	.675	10 / .065	2.2 / 56	40mm	153R056P0375	155P0375
1/2"	.840	40 / .109	1.8 / 46	40mm	153R046P0500	155P0500
1/2"	.840	10 / .083	2.2 / 56	40mm	153R056P0500	155P0500
1/2"	.840	5 / .065	2.6 / 67	40mm	153R067P0500	155P0500
3/4"	1.050	40 / .113	2.2 / 56	40mm	153R056P0750	155P0750
3/4"	1.050	10 / .083	2.6 / 67	40mm	153R067P0750	155P0750
3/4"	1.050	5 / .065	3.2 / 82	40mm	153R082P0750	155P0750
1"	1.315	40 / .133	2.6 / 67	40mm	153R067P1000	155P1000
1"	1.315	10 / .109	3.2 / 82	40mm	153R082P1000	155P1000
1"	1.315	5 / .065	4.4 / 112	40mm	153R112P1000	155P1000
1-1/4"	1.660	40 / .140	3.5 / 90	50mm	153R090P1250	155P1250
1-1/4"	1.660	40 / .140	3.9 / 100	50mm	153R100P1250	155P1250
1-1/4"	1.660	10 / .109	5.1 / 130	50mm	153R130P1250	155P1250
1-1/4"	1.660	5 / .065	5.9 / 150	50mm	153R150P1250	155P1250
1-1/4"	1.660	5 / .065	7.5 / 190	50mm	153R190P1250	155P1250
1-1/2"	1.900	40 / .145	3.9 / 100	50mm	153R100P1500	155P1500
1-1/2"	1.900	40 / .145	5.1 / 130	50mm	153R130P1500	155P1500
1-1/2"	1.900	40 / .145	5.9 / 150	50mm	153R150P1500	155P1500

1-1/2"	1.900	10 / .109	6.7 / 170	50mm	153R170P1500	155P1500
1-1/2"	1.900	5 / .065	7.5 / 190	50mm	153R190P1500	155P1500
2"	2.375	40 / .154	5.1 / 130	50mm	153R130P2000	155P2000
2"	2.375	10 / .109	5.9 / 150	50mm	153R150P2000	155P2000
2"	2.375	5 / .065	7.5 / 190	50mm	153R190P2000	155P2000
2"	2.375	5 / .065	8.9 / 225	50mm	157R225P2000	155P2000
2"	2.375	5 / .065	10.2 / 260	50mm	157R260P2000	155P2000
2"	2.375	5 / .065	11.8 / 300	50mm	157R300P2000	155P2000
2"	2.375	5 / .065	10.2 / 260	80mm	157R260P2000-80	155P2000
2"	2.375	5 / .065	11.8 / 300	80mm	157R300P2000-80	155P2000
2-1/2"	2.875	40 / .203	9.8 / 250	50mm	157R250P2500*	155P2500*
2-1/2"	2.875	10 / .120	10.2 / 260	50mm	157R260P2500*	155P2500*
2-1/2"	2.875	5 / .083	11.8 / 300	50mm	157R300P2500*	155P2500*
2-1/2"	2.875	40 / .203	10.2 / 260	80mm	157R260P2500-80	155P2500
2-1/2"	2.875	40 / .203	11.8 / 300	80mm	157R300P2500-80	155P2500
2-1/2"	2.875	40 / .203	13.8 / 350	80mm	157R350P2500-80	155P2500
3"	3.500	40 / .216	11.8 / 300	80mm	157R300P3000-80	155P3000
3"	3.500	40 / .216	11.8 / 300	110mm	157R300P300-110	155P3000
3	3.500	40 / .216	13.8 / 350	80mm	157R350P3000-80	155P3000
4	4.500	40 / .237	13.8 / 350	110mm	157R350P400-110	152BP4000

80mm and 110mm drive diameters available for TB100 / TB130 / TB180

*Counterbending die support 050E required when bending radii 225mm and larger.
All standard Ercolina counterbending dies are provided in bronze.