



# Tooling for Round Tube

Tube Size	Outside Diameter	Wall Thickness	Minimum CLR Inches / Millimeter		Drive Diameter	Center Former Part#	Counterbend Die Part#	
1/4"	.250	.035	1.4	36	↑	153R036T0250	154T0250	
3/8"	.375	.035	1.4	36		153R036T0375	154T0375	
1/2"	.500	.035	1.4	36		153R036T0500	154T0500	
5/8"	.625	.083	1.4	36	↓	153R036T0625	154T0625	
		.035	1.8	46		153R046T0625		
3/4"	.750	.083	1.8	46		153R046T0750	154T0750	
		.065	2.2	56		153R056T0750		
		.035	2.6	67		153R067T0750		
7/8"	.875	.083	1.8	46		153R046T0875	154T0875	
		.065	2.2	56		153R056T0875		
1"	1.000	.035	2.6	67		40mm	153R067T0875	154T1000
		.083	2.2	56		153R056T1000		
		.065	2.6	67		153R067T1000		
1 1/8"	1.125	.035	3.2	82	153R082T1000	154T1125		
		.095	2.2	56	156R056T1125			
		.083	2.6	67	153R067T1125			
1 1/4"	1.250	.035	3.2	82	153R082T1125	154T1250		
		.095	2.6	67	153R067T1250			
		.083	3.2	82	153R082T1250			
1 3/8"	1.375	.035	4.4	112	153R112T1250	154T1375		
		.083	3.2	82	153R082T1375			
		.035	4.4	112	153R112T1375			
1 1/2"	1.500	.109	3.5	90	50mm	153R090T1500	154T1500	
		.083	3.9	100	50mm	153R100T1500		
		.083	4.4	112	40mm	156R112T1500		
1 1/2"	1.500	.065	5.1	130	↑	153R130T1500	154T1500	
		.049	5.9	150		153R150T1500		
		.035	6.7	170		156R170T1500		
		.035	7.5	190		153R190T1500		
1 5/8"	1.625	.109	3.5	90		50mm	153R090T1625	154T1625
		.083	3.9	100			153R100T1625	
		.065	5.1	130			153R130T1625	
		.049	5.9	150			153R150T1625	
		.035	6.7	170			156R170T1625	
1 3/4"	1.750	.035	7.5	190		153R190T1625	154T1750	
		.109	3.9	100	153R100T1750			
		.095	5.1	130	153R130T1750			
		.095	5.9	150	↓	153R150T1750		

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# Tooling for Round Tube

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Tube Size	Outside Diameter	Wall Thickness	Minimum CLR Inches / Millimeter		Drive Diameter	Center Former Part#	Counterbend Die Part#
1¾"	1.750	.065	6.7	170	↑ 50mm ↓	153R170T1750	154T1750
		.035	7.5	190		156R190T1750	
1⅞"	1.875	.109	3.9	100		153R100T1875	154T1875
		.095	5.1	130		153R130T1875	
		.083	5.9	150		156R150T1875	
		.065	6.7	170		153R170T1875	
		.035	7.5	190		153R190T1875	
2"	2.000	.109	4.7	120		153R120T2000	154T2000
		.109	5.1	130		156R130T2000	
		.095	5.9	150		153R150T2000	
		.083	6.7	170		156R170T2000	
		.065	7.5	190		153R190T2000	
2⅛"	2.125	.134	4.7	120		153R120T2125	154T2125
		.109	5.1	130		153R130T2125	
		.083	5.9	150		153R150T2125	
		.083	6.7	170		156R170T2125	
		.065	7.5	190		153R190T2125	
2¼"	2.250	.109	5.1	130		153R130T2250	154T2250
		.095	5.9	150		153R150T2250	
		.083	6.7	170		156R170T2250	
		.083	7.5	190	153R190T2250		
2⅜"	2.375	.109	5.1	130	153R130T2375	154T2375	
		.095	5.9	150	153R150T2375		
		.083	6.7	170	156R170T2375		
		.083	7.5	190	153R190T2375		
2½"	2.500	.083	8.9	225	157R225T2500*	154T2500	
		.083	9.8	250	157R250T2500*		
		.065	10.2	260	157R260T2500*		
		.065	11.8	300	157R300T2500*		
		.156	9.8	250	157R250T3000*		
3"	3.000	.156	10.2	260	157R260T3000*	154T3000	
		.120	11.8	300	157R300T3000*		
		.156	10.2	260	157R260T3000-80		
3"	3.000	.216	11.8	300	157R300T3000-80	154T3000	
		.216	11.8	300	157R300T3250-80		
3¼"	3.250	.216	11.8	300	80mm	157R300T3250-80	152BT3250
3½"	3.500	.216	11.8	300	↓ 110mm	157R300P3000-80	155P3000
			13.8	350		157R350P3000-80	
4"	4.000	.216	13.8	350	110mm	157R350T400-110	152BT4000

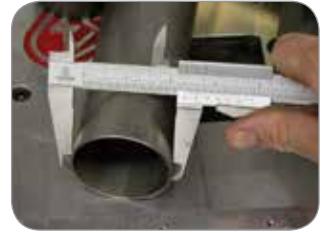
**80mm and 110mm drive diameters available for TB100 / TB130 / TB180**

\*Part# 050E required when bending radii 225mm and larger. (Not required for TB100/TB130/TB180.)



# Round Tube Information

## Minimum Achievable "Centerline Radius" with Standard Tooling



Tube dimensions are based on O.D. of material (2" tube measures 2.00" O.D.).

Tube Size	Wall Thickness							
	.035 20 Ga.	.049 18 Ga.	.065 16 Ga.	.083 14 Ga.	.095 13 Ga.	.109 12 Ga.	.120 11 Ga.	.134 10 Ga.
¼"	1.4	1.4	1.4	1.4	1.4	1.4	.78	.78
⅜"	1.4	1.4	.78	.78	.78	.78	.78	.78
½"	1.4	1.4	1	1	1	1	1	1
⅝"	1.8	1.8	1.8	1.4	1.4	1.4	1.4	1.4
¾"	2.6	2.6	2.6	1.8	1.8	1.8	1.8	1.8
⅞"	2.6	2.6	2.2	1.8	1.8	1.8	1.8	1.8
1"	3.2	3.2	2.6	2.2	2.2	2.2	2.2	2.2
1⅛"	3.2	3.2	3.2	2.6	2.2	2.2	2.2	2.2
1¼"	4.4	4.4	4.4	3.2	2.6	2.6	2.6	2.6
1⅜"	4.4	4.4	4.4	3.2	3.2	3.2	3.2	3.2
1½"	7.5	5.9	5.1	3.9	3.9	3.5	3.5	3.5
1⅝"	7.5	5.9	5.1	3.9	3.9	3.5	3.5	3.5
1¾"			6.7	6.7	5.1	3.9	3.9	3.9
1⅞"			7.5	5.9	5.1	3.9	3.9	3.9
2"			7.5	7.5	5.9	4.7	4.7	4.7
2⅛"			7.5	7.5	5.9	5.1	5.1	4.7
2¼"				7.5	5.9	5.1	5.1	5.1
2⅜"				7.5	5.9	5.1	5.1	5.1
2½"					11.8	10.2	9.8	
3"					11.8	10.2	9.8	

All standard Ercolina counterbending dies are provided in bronze.

\*Polished tooling for round tube recommended for materials with a polished finish such as stainless and aluminum.

Optional polymer counterbending dies available on request. Consult factory for more information.

## Steel & Polymer Tube Counterbending Dies

### STEEL

### POLYMER

Tube Size	Outside Diameter	Counterbend Die Part#
¾"	.750	154AT0750
⅞"	.875	154AT0875
1"	1.000	154AT1000
1¼"	1.250	154AT1250
1⅜"	1.375	154AT1375
1½"	1.500	154AT1500
1¾"	1.750	154AT1750
1⅞"	1.875	154AT1875
2"	2.000	154AT2000
2¼"	2.250	154AT2250
2½"	2.500	154AT2500

Tube Size	Outside Diameter	Counterbend Die Part#
¾"	.750	154NT0750
⅞"	.875	154NT0875
1"	1.000	154NT1000
1¼"	1.250	154NT1250
1⅜"	1.375	154NT1375
1½"	1.500	154NT1500
1¾"	1.750	154NT1750
1⅞"	1.875	154NT1875
2"	2.000	154NT2000

Consult factory for tooling sizes not shown.



### STEEL SUPPORT WITH REPLACEABLE POLYMER INSERT

### REPLACEABLE POLYMER INSERT

1½"	1.500	154ST1500
2"	2.000	154ST2000

1½"	1.500	154ST1500INS
2"	2.000	154ST2000INS

Polymer recommended for materials with a polished finish such as stainless and aluminum.