



Tooling for Pipe

Pipe Size	Outside Diameter	Wall Thickness Sch. / Inch	Min. CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
1/4"	.540	40 - .088	1.4		153R036P0250	155P0250
3/8"	.675	40 - .091	1.4		153R036P0375	155P0375
		10 - .065	2.2	153R056P0375		
1/2"	.840	40 - .109	1.8	40mm	153R046P0500 ●	155P0500
		10 - .083	2.2		153R056P0500	
		5 - .065	2.6		153R067P0500	
		5 - .065	4.4		156R112P0500	
3/4"	1.050	40 - .113	2.2	50mm	153R056P0750 ●	155P0750
		10 - .083	2.6		153R067P0750	
		5 - .065	3.2		153R082P0750	
		5 - .065	5.1		156R130P0750	
1"	1.315	40 - .133	2.6	40mm	153R067P1000 ●	155P1000
		10 - .109	3.2	40mm	153R082P1000	
		10 - .109	3.9	50mm	156R100P1000	
		5 - .065	4.4	40mm	153R112P1000	
		5 - .065	6.7	50mm	156R170P1000	
		5 - .065	6.7	110mm	157R170P1000-110	
1 1/4"	1.660	40 - .140	3.5	50mm	153R090P1250 ●	155P1250
		40 - .140	3.9		153R100P1250	
		10 - .109	5.1		153R130P1250	
		5 - .065	5.9		153R150P1250	
		5 - .065	7.5		153R190P1250	
		5 - .065	8.9		157R225P1250	
		5 - .065	8.9	110mm	157R225P1250-110	
1 1/2"	1.900	40 - .145	3.9	50mm	153R100P1500 ●	155P1500
		40 - .145	5.1		153R130P1500	
		40 - .145	5.9		153R150P1500	
		10 - .109	6.7		153R170P1500	
		5 - .065	7.5		153R190P1500	
		5 - .065	9.8		157R250P1500	
		5 - .065	9.8		110mm	

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Pipe Size	Outside Diameter	Wall Thickness Sch. / Inch	Min. CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
2"	2.375	40 - .154	5.1	50mm	153R130P2000	155P2000
		10 - .109	5.9		153R150P2000 ●	
		5 - .065	7.5		153R190P2000	
		5 - .065	8.9		157R225P2000	
		5 - .065	10.2	80mm	157R260P2000	
		5 - .065	10.2		157R260P2000-80	
		5 - .065	11.8		157R300P2000	
		5 - .065	11.8		157R300P2000-80	
		5 - .065	11.8		157R300P2000-110	
2½"	2.875	40 - .203	10.2	80mm	157R260P2500-80	155P2500
		40 - .203	11.8		157R300P2500-80	
		40 - .203	11.8	110mm	157R300P2500-110	
		10 - .120	13.8	80mm	157R350P2500-80	
		10 - .120	13.8	110mm	157R350P2500-110	
3"	3.500	40 - .216	11.8	80mm	157R300P3000-80	155P3000
		40 - .216	11.8	110mm	157R300P3000-110	
		40 - .216	13.8	80mm	157R350P3000-80	
		10 - .120	17.7	110mm	157R450P3000-110	
4"	4.500	40 - .237	13.8	110mm	157R350P400-110	152BP4000
		10 - .120	22.0	110mm	157R560P400-110**	
6"	6.625	40 - .280	23.2	130mm	157R590P6000-130	152BP6000
		10 - .134	31.5	130mm	157R800P6000-130**	



3D Tooling



5D Tooling



Included in standard Pipe Tooling Kits (pg. 16)

80mm drive diameter available for TB80 / TB100 / TB130

110mm drive diameter available for TB130 / TB180

130mm drive diameter available for TB180 only

Bending of non-ferrous material may require tooling modification.

*Select models require counterbending die support 050E when bending radii 225mm and larger.
Refer to machine manual for CLR capacities and drive.

All standard Ercolina® counterbending dies are provided in bronze.

**Center Former Part# 157R560P400-110 and 157R800P6000-130 require lead time