



Tooling for Round Tube

Tube Size	Outside Diameter	Wall Thickness	Minimum CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
1/4"	.250	.035	1.4	40mm	153R036T0250	154T0250
3/8"	.375	.035	1.4		153R036T0375	154T0375
1/2"	.500	.035	1.4		153R036T0500	154T0500
5/8"	.625	.083	1.4		153R036T0625	154T0625
		.035	1.8		153R046T0625	
3/4"	.750	.083	1.8		153R046T0750	154T0750
		.065	2.2		153R056T0750	
		.035	2.6		153R067T0750 ● ●	
7/8"	.875	.083	1.8		153R046T0875	154T0875
		.065	2.2		153R056T0875 ●	
		.035	2.6		153R067T0875 ●	
1"	1.000	.083	2.2		153R056T1000	154T1000
		.065	2.6		153R067T1000 ●	
		.035	3.2		153R082T1000 ●	
1 1/8"	1.125	.095	2.2		156R056T1125	154T1125
		.083	2.6		153R067T1125	
		.035	3.2	153R082T1125		
1 1/4"	1.250	.095	2.6	153R067T1250	154T1250	
		.083	3.2	153R082T1250 ●		
		.035	4.4	153R112T1250 ●		
1 3/8"	1.375	.083	3.2	153R082T1375	154T1375	
		.035	4.4	153R112T1375		
1 1/2"	1.500	.109	3.5	153R090T1500	154T1500	
		.083	3.9	153R100T1500 ●		
		.083	4.4	156R112T1500		
1 1/2"	1.500	.065	5.1	153R130T1500	154T1500	
		.049	5.9	153R150T1500 ●		
		.035	6.7	156R170T1500		
		.035	7.5	153R190T1500		
1 5/8"	1.625	.109	3.5	153R090T1625	154T1625	
		.083	3.9	153R100T1625		
		.065	5.1	153R130T1625		
		.049	5.9	153R150T1625		
		.035	6.7	153R170T1625		
		.035	7.5	153R190T1625		
1 3/4"	1.750	.109	3.9	153R100T1750	154T1750	
		.095	5.1	153R130T1750		
		.095	5.9	153R150T1750		
		.065	6.7	153R170T1750 ●		
		.035	7.5	153R190T1750		

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Tube Size	Outside Diameter	Wall Thickness	Minimum CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
1 7/8"	1.875	.109	3.9	50mm	153R100T1875	154T1875
		.095	5.1		153R130T1875	
		.083	5.9		156R150T1875	
		.065	6.7		153R170T1875	
		.035	7.5		153R190T1875	
2"	2.000	.109	4.7		153R120T2000	154T2000
		.109	5.1		156R130T2000	
		.095	5.9		153R150T2000 ●	
		.083	6.7		156R170T2000	
		.065	7.5		153R190T2000 ●	
2 1/8"	2.125	.134	4.7		153R120T2125	154T2125
		.109	5.1		153R130T2125	
		.083	5.9		153R150T2125	
		.083	6.7		156R170T2125	
		.065	7.5		153R190T2125	
2 1/4"	2.250	.109	5.1		153R130T2250	154T2250
		.095	5.9		153R150T2250	
		.083	6.7		156R170T2250	
		.083	7.5		153R190T2250	
2 3/8"	2.375	.109	5.1		153R130T2375	154T2375
		.095	5.9	153R150T2375		
		.083	6.7	156R170T2375		
		.083	7.5	153R190T2375		
2 1/2"	2.500	.187	8.9	157R225T2500*	154T2500	
		.156	9.8	157R250T2500*		
		.120	10.2	157R260T2500*		
		.065	11.8	157R300T2500*		
3"	3.000	.187	9.8	157R250T3000*	154T3000	
		.156	10.2	157R260T3000*		
		.120	11.8	157R300T3000*		
3"	3.000	.216	10.2	157R260T3000-80	154T3000	
		.156	11.8	157R300T3000-80		
3 1/4"	3.250	.216	11.8	80mm	157R300T3250-80	152BT3250
3 1/2"	3.500	.216	11.8	157R300P3000-80	155P3000	
		.216	13.8	157R350P3000-80		
4"	4.000	.216	13.8	110mm	157R350T4000-11	155BT4000

● Included in standard small radius
Tube Tooling Kits (pg. 17)

● Included in standard large radius
Tube Tooling Kits (pg. 17)

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.