

# STANDARD TUBE MANDREL TOOLING SETS

MATERIAL	WALL	CLR	ITEM CODE	DESCRIPTION	FITS MODEL
1" Tube		2"	AK20DT1000	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR53R051T1000	Center Former	
			A223T1000	Clamp Die	
			A243R051T1000	Wiper Die	
			A204T1000	Pressure Die	
1" Tube 16 Ga.	.065		AXKITST1000065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1" Tube 14 Ga.	.083		AXKITST1000083		
1" Tube 11 Ga.	.120		AXKITST1000120		
1" Tube 16 Ga.	.065		AXKITBT1000065	Mandrel Flexible <b>BRONZE</b> with Sphere	
1" Tube 14 Ga.	.083		AXKITBT1000083		
1" Tube 11 Ga.	.120		AXKITBT1000120		
1" Tube			EB068T1000	Spring Collet Tailstock	
1" Tube			EB76T1000	Segmented Collet	EB76
1" Tube			GB90COT1000	Segmented Collet	TB80 Mandrel
1-1/4" Tube		2.5"	AK20DT1250	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR67R064T1250	Center Former	
			A224T1250	Clamp Die	
			A244R064T1250	Wiper Die	
			A204T1250	Pressure Die	
1-1/4" Tube 16 Ga.	.065		AXKITST1250065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1-1/4" Tube 14 Ga.	.083		AXKITST1250083		
1-1/4" Tube 11 Ga.	.120		AXKITST1250120		
1-1/4" Tube 16 Ga.	.065		AXKITBT1250065	Mandrel Flexible <b>BRONZE</b> with Sphere	
1-1/4" Tube 14 Ga.	.083		AXKITBT1250083		
1-1/4" Tube 11 Ga.	.120		AXKITBT1250120		
1-1/4" Tube			EB068T1250	Spring Collet Tailstock	
1-1/4" Tube			EB76T1250	Segmented Collet	EB76
1-1/4" Tube			GB90COT1250	Segmented Collet	TB80 Mandrel
1-1/2" Tube		3"	AK20DT1500	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR84R076T1500	Center Former	
			A2211T1500	Clamp Die	
			A2411R076T1500	Wiper Die	
			A2011T1500	Pressure Die	
1-1/2" Tube 16 Ga.	.065		AXKITST1500065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1-1/2" Tube 14 Ga.	.083		AXKITST1500083		
1-1/2" Tube 11 Ga.	.120		AXKITST1500120		
1-1/2" Tube 16 Ga.	.065		AXKITBT1500065	Mandrel Flexible <b>BRONZE</b> with Sphere	
1-1/2" Tube 14 Ga.	.083		AXKITBT1500083		
1-1/2" Tube 11 Ga.	.120		AXKITBT1500120		
1-1/2" Tube			EB068T1500	Spring Collet Tailstock	
1-1/2" Tube			EB76T1500	Segmented Collet	EB76
1-1/2" Tube			GB90COT1500	Segmented Collet	TB80 Mandrel
1-5/8" Tube		3.25"	AK20DT1625	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR84R082T1625	Center Former	
			A2212T1625	Clamp Die	
			A2412R082T1625	Wiper Die	
			A2012T1625	Pressure Die	
1-5/8" Tube 16 Ga.	.065		AXKITST1625065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1-5/8" Tube 14 Ga.	.083		AXKITST1625083		
1-5/8" Tube 11 Ga.	.120		AXKITST1625120		
1-5/8" Tube 16 Ga.	.065		AXKITBT1625065	Mandrel Flexible <b>BRONZE</b> with Sphere	
1-5/8" Tube 14 Ga.	.083		AXKITBT1625083		
1-5/8" Tube 11 Ga.	.120		AXKITBT1625120		
1-5/8" Tube			EB068T1625	Spring Collet Tailstock	
1-5/8" Tube			EB76T1625	Segmented Collet	EB76
1-5/8" Tube			GB90COT1625	Segmented Collet	TB80 Mandrel

## Decoding Bend Terms

CLR – Centerline radius. Distance from the center of forming die to centerline of material

DOB – Degree of bend. Number of degrees required in a bend  
Sch. – Schedule, or wall thickness of pipe

Ga. – Gauge, or wall thickness of tube  
O.D. – Outside diameter  
I.D. – Inside diameter

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MATERIAL	WALL	CLR	ITEM CODE	DESCRIPTION	FITS MODEL	
1-3/4" Tube		3.5"	AK20DT1750	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76	
			AR100R089T1750	Center Former		
			A2212T1750	Clamp Die		
			A2412R089T1750	Wiper Die		
			A2012T1750	Pressure Die		
1-3/4" Tube 16 Ga.	.065		AXKITST1750065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere		
1-3/4" Tube 14 Ga.	.083		AXKITST1750083			
1-3/4" Tube 11 Ga.	.120		AXKITST1750120			
1-3/4" Tube 16 Ga.	.065		AXKITBT1750065			
1-3/4" Tube 14 Ga.	.083		AXKITBT1750083	Mandrel Flexible <b>BRONZE</b> with Sphere		
1-3/4" Tube 11 Ga.	.120		AXKITBT1750120			
1-3/4" Tube			EB068T1750	Spring Collet Tailstock		EB65
1-3/4" Tube			EB76T1750	Segmented Collet		EB76
1-3/4" Tube			GB90COT1750	Segmented Collet		TB80 Mandrel
2" Tube		4"	AK20DT2000	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76	
			AR110R102T2000	Center Former		
			A2213T2000	Clamp Die		
			A2413R102T2000	Wiper Die		
			A2013T2000	Pressure Die		
2" Tube 16 Ga.	.065		AXKITST2000065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere		
2" Tube 14 Ga.	.083		AXKITST2000083			
2" Tube 11 Ga.	.120		AXKITST2000120			
2" Tube 16 Ga.	.065		AXKITBT2000065			
2" Tube 14 Ga.	.083		AXKITBT2000083	Mandrel Flexible <b>BRONZE</b> with Sphere		
2" Tube 11 Ga.	.120		AXKITBT2000120			
2" Tube			EB068T2000	Spring Collet Tailstock		EB65
2" Tube			EB76T2000	Segmented Collet		EB76
2" Tube			GB90COT2000	Segmented Collet		TB80 Mandrel
2-1/4" Tube		4.5"	AK20DT2250	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76	
			AR121R114T2250	Center Former		
			A2214T2250	Clamp Die		
			A2414R114T2250	Wiper Die		
			A2014T2250	Pressure Die		
2-1/4" Tube 16 Ga.	.065		AXKITST2250065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere		
2-1/4" Tube 14 Ga.	.083		AXKITST2250083			
2-1/4" Tube 11 Ga.	.120		AXKITST2250120			
2-1/4" Tube 16 Ga.	.065		AXKITBT2250065			
2-1/4" Tube 14 Ga.	.083		AXKITBT2250083	Mandrel Flexible <b>BRONZE</b> with Sphere		
2-1/4" Tube 11 Ga.	.120		AXKITBT2250120			
2-1/4" Tube			EB068T2250	Spring Collet Tailstock		EB65
2-1/4" Tube			EB76T2250	Segmented Collet		EB76
2-1/4" Tube			GB90COT2250	Segmented Collet		TB80 Mandrel
2-1/2" Tube		5"	AK20DT2500	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76	
			AR133R127T2500	Center Former		
			A2215T2500	Clamp Die		
			A2415R127T2500	Wiper Die		
			A2015T2500-18	Pressure Die		
2-1/2" Tube 16 Ga.	.065		AXKITST2500065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere		
2-1/2" Tube 14 Ga.	.083		AXKITST2500083			
2-1/2" Tube 11 Ga.	.120		AXKITST2500120			
2-1/2" Tube 16 Ga.	.065		AXKITBT2500065			
2-1/2" Tube 14 Ga.	.083		AXKITBT2500083	Mandrel Flexible <b>BRONZE</b> with Sphere		
2-1/2" Tube 11 Ga.	.120		AXKITBT2500120			
2-1/2" Tube			EB068T2500	Spring Collet Tailstock		EB65
2-1/2" Tube			EB76T2500	Segmented Collet		EB76
2-1/2" Tube			GB90COT2500	Segmented Collet		TB80 Mandrel

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MATERIAL	WALL	CLR	ITEM CODE	DESCRIPTION	FITS MODEL
3" Tube		6"	AK20DT3000	Tool Set (Includes 4 items:)	TB80 Mandrel, EB76
			AR178R152T3000	Center Former	
			A2217T3000HR	Clamp Die	
			A2417R152T3000	Wiper Die	
			A2017T3000-18	Pressure Die	
3" Tube 16 Ga.	.065		AXKITST3000065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
3" Tube 14 Ga.	.083		AXKITST3000083		
3" Tube 11 Ga.	.120		AXKITST3000120		
3" Tube 16 Ga.	.065		AXKITBT3000065	Mandrel Flexible <b>BRONZE</b> with Sphere	
3" Tube 14 Ga.	.083		AXKITBT3000083		
3" Tube 11 Ga.	.120		AXKITBT3000120		
3" Tube			EB76T3000	Segmented Collet	EB76
3" Tube			GB90COT3000	Segmented Collet	TB80 Mandrel

# SQUARE TUBE MANDREL TOOLING SETS

MATERIAL	WALL	CLR	ITEM CODE	DESCRIPTION	FITS MODEL
1" Square Tube		3"	AK30DAT1000	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR84R076A1000	Center Former	
			A223A1000	Clamp Die	
			A243R076A1000	Wiper Die	
			A203A1000	Pressure Die - Steel	
1" Square Tube	.065		AXKITSA1000065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	EB65
1" Square Tube	.120		AXKITSA1000120	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1" Square Tube			EB068A1000	Spring Collet Tailstock	EB76
1" Square Tube			EB76A1000	Segmented Collet	TB80 Mandrel
1" Square Tube			GB90COA1000	Segmented Collet	
1-1/2" Square Tube		4.4"	AK30DAT1500	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR121R114A1500	Center Former	
			A2211A1500	Clamp Die	
			A2411R114A1500	Wiper Die	
			A2011A1500	Pressure Die - Steel	
1-1/2" Square Tube	.065		AXKITSA1500065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	EB65
1-1/2" Square Tube	.120		AXKITSA1500120	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1-1/2" Square Tube			EB068A1500	Spring Collet Tailstock	EB76
1-1/2" Square Tube			EB76A1500	Segmented Collet	TB80 Mandrel
1-1/2" Square Tube			GB90COA1500	Segmented Collet	
2" Square Tube		6"	AK30DAT2000	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR178R152A2000	Center Former	
			A2213A2000	Clamp Die	
			A2413R152A2000	Wiper Die	
			A2013A2000	Pressure Die - Steel	
2" Square Tube	.065		AXKITSA2000065	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	EB65
2" Square Tube	.120		AXKITSA2000120	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
2" Square Tube			EB068A2000	Spring Collet Tailstock	EB76
2" Square Tube			EB76A2000	Segmented Collet	TB80 Mandrel
2" Square Tube			GB90COA2000	Segmented Collet	

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