

# CuNi CLASS 200 MANDREL TOOLING SETS

MATERIAL	WALL	CLR	ITEM CODE	DESCRIPTION	FITS MODEL
1" Pipe		4"	AK30DP1000	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR100R100P1000	Center Former	
			A224P1000	Clamp Die	
			A244R100P1000	Wiper Die	
			A201P1000	Pressure Die - Polymer	
1" Pipe Sch. 5	.070		AXKITCUNIP1000070	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1" Pipe			EB068P1000	Spring Collet Tailstock	EB65
1" Pipe			EB76P1000	Segmented Collet	EB76
1" Pipe			GB90COP1000	Segmented Collet	TB80 Mandrel
1-1/4" Pipe		5"	AK30DP1250	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR133R127P1250	Center Former	
			A2212P1250	Clamp Die	
			A2412R127P1250	Wiper Die	
			A201P2P1250-18	Pressure Die - Polymer	
1-1/4" Pipe Sch. 5	.072		AXKITCUNIP1250072	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1-1/4" Pipe			EB068P1250	Spring Collet Tailstock	EB65
1-1/4" Pipe			EB76P1250	Segmented Collet	EB76
1-1/4" Pipe			GB90COP1250	Segmented Collet	TB80 Mandrel
1-1/2" Pipe		6"	AK30DP1500	Tool Set (Includes 4 items:)	030 Mandrel, TB80 Mandrel, EB65, EB76
			AR178R152P1500	Center Former	
			A2212P1500	Clamp Die	
			A2412R152P1500	Wiper Die	
			A201P1500-18	Pressure Die - Polymer	
1-1/2" Pipe Sch. 5	.072		AXKITCUNIP1500072	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
1-1/2" Pipe			EB068P1500	Spring Collet Tailstock	EB65
1-1/2" Pipe			EB76P1500	Segmented Collet	EB76
1-1/2" Pipe			GB90COP1500	Segmented Collet	TB80 Mandrel
2" Pipe		7.125"	AK30DP2000	Tool Set (Includes 4 items:)	TB80 Mandrel, EB76
			AR200R180P2000	Center Former	
			A2214P2000	Clamp Die	
			A2414R180P2000	Wiper Die	
			A201P4P2000-18	Pressure Die - Polymer	
2" Pipe Sch. 5	.083		AXKITCUNIP2000083	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
2" Pipe			EB76P2000	Segmented Collet	EB76
2" Pipe			GB90COP2000	Segmented Collet	TB80 Mandrel
2-1/2" Pipe		8.625"	AK30DP2500	Tool Set (Includes 4 items:)	TB80 Mandrel, EB76
			EBDR219P2500	Center Former	
			A2216P2500	Clamp Die	
			A24/1/6R219P2500	Wiper Die	
			A201P6P2500-18	Pressure Die - Polymer	
2-1/2" Pipe Sch. 5	.083		AXKITCUNIP2500083	Mandrel Flexible <b>STEEL CHROME</b> with Sphere	
2-1/2" Pipe			EB76P2500	Segmented Collet	EB76
2-1/2" Pipe			GB90COP2500	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

## CuNi Size Chart

IPS	OD	90/10 70/30	70/30			
		CL 200 Wall	CL 700 Wall	CL 1650 Wall	CL 3300 Wall	CL 6000 Wall
1"	1.315	0.065	0.095	0.095	0.180	0.300
1-1/4"	1.660	0.072	0.095	0.120	0.220	0.380
1-1/2"	1.900	0.072	0.109	0.134	0.250	0.425
2"	2.375	0.083	0.120	0.165	0.340	0.520
2-1/2"	2.875	0.083	0.134	0.203	0.380	

