

PIPE & TUBE BENDING DIMENSIONS

| TUBE SIZE (IN) | PIPE SIZE (IN) | OUTSIDE DIAMETER (IN) | COMMON CENTERLINE RADII (CLR) (IN) | STANDARD TANGENT (ST) (IN) |
|----------------|----------------|-----------------------|---|----------------------------|
| 1 | | 1 | 3, 4, 6, 12 | 4 |
| | 1 | 1.15 | 3, 5 | 4 |
| 1 1/4 | | 1.25 | 3, 7.25 | 4 |
| | 1 1/4 | 1.66 | 3.5, 4, 6.25 | 4 |
| 1 1/2 | | 1.5 | 2.5, 6, 7.5, 9, 12, 15, 18, 24, 30, 36 | 4 |
| 1 3/4 | | 1.75 | 2.5, 8, 9, 12, 15, 24, 30, 36, 48 | 4 |
| | 1 1/2 | 1.9 | 5, 6, 7.5, 9, 10, 12, 18, 24, 30, 36, 48 | 4 |
| 2 | | 2 | 2.5, 3, 3.5, 4, 5, 6, 8, 8.5, 9, 10, 12, 15, 18, 24, 30, 36, 48 | 4 |
| 2 1/8 | | 2.125 | 3, 5, 12, 24, 30, 36 | 4 1/4 |
| 2 1/4 | | 2.25 | 3, 9, 12, 15, 17, 24, 30, 36 | 4 1/2 |
| | 2 | 2.375 | 6, 7.5, 10, 12, 15, 17, 24, 30, 36, 48 | 4 |
| 2 1/2 | | 2.5 | 4, 6, 9, 12, 15, 17, 24, 30, 36, 48 | 5 |
| 2 3/4 | | 2.75 | 2.75, 4, 17, 30, 36, 48 | 5 1/2 |
| | 2 1/2 | 2.875 | 12, 12.5, 15, 17, 24, 30, 36, 60 | 5 |
| 3 | | 3 | 4, 4.5, 7.5, 9, 10, 12, 15, 18, 24, 30, 36, 48, 60 | 6 |
| 3 1/4 | | 3.25 | 17, 30, 36 | 6 1/2 |
| 3 1/2 | 3 | 3.5 | 3.5, 4.5, 6, 8.75, 12, 15, 16, 18, 24, 30, 36, 48 | 7 (6-PIPE) |
| 3 3/4 | | 3.75 | 17, 24, 32, 36 | 7 1/2 |
| 4 | 3 1/2 | 4 | 4, 5, 6, 7.75, 10, 12, 16, 18, 20, 24, 30, 32, 36, 48, 60 | 8 (7-PIPE) |
| 4 1/4 | | 4.25 | 16, 30, 36, 48, 60 | 8 1/2 |
| 4 1/2 | 4 | 4.5 | 6, 9, 12, 16, 18, 20, 24, 30, 32, 36, 48, 60 | 9 (8-PIPE) |
| 4 3/4 | | 4.75 | 36 | 9 1/2 |
| 5 | | 5 | 5.5, 7.5, 12.5, 17, 22, 24, 30, 36, 42, 48, 60 | 10 |
| | 5 | 5.563 | 15, 20, 24, 30, 36, 42, 48, 60, 72 | 10 |
| 5 1/2 | | 5.5 | 30, 36 | 11 |
| 6 | | 6 | 9, 15, 18, 24, 30, 36, 42, 48, 60, 72 | 12 |
| | 6 | 6.625 | 18, 24, 30, 36, 42, 48, 60, 72 | 12 |
| 8 | | 8 | 12, 20, 32, 48, 60, 72 | 16 |
| | 8 | 8.625 | 24, 32, 40, 42, 48, 60, 72 | 16 |
| | 10 | 10.75 | 40, 48, 50 | 20 |

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