

ROUND TUBING MANDREL BENDING

ROUND PRESS BENDING

US Common (SAE) & Metric - Metric measurements indicated in red

Outside Diameter (O.D.)	Center Line Radius	Minimum Distance Between Bend	Grip Blocks				Capabilities		Outside Diameter (O.D.)	Center Line Radius	Capabilities			
							Maximum Expansion Length	Maximum Reduction Length			Maximum Expansion Length	Maximum Reduction Length		
1.00/25.40	1.50/38.10 2.00/50.80 3.00/76.20	4.00/101.60 4.00/101.60	4.00/101.60 3.00/76.20 4.00/101.60					1.50/38.10 3.00/76.20 1.50/38.10	3.00/76.20 3.00/76.20 3.00/76.20	0.44/11.18 0.55/13.97	4.63/116.84 1.00/25.40			
1.06/26.92	2.50/63.50 3.00/76.20	2.75/69.85 2.75/69.85	2.75/69.85 2.75/69.85							0.63/16.00	1.24/31.50 2.00/50.80			
1.25/31.75	1.50/38.10 2.00/50.80 3.00/76.20 5.62/142.75	2.75/69.85 2.75/69.85 2.00/50.80 2.00/50.80	2.75/69.85 2.75/69.85 2.00/50.80 2.00/50.80	3.00/76.20 3.00/76.20				2.25/57.15 2.25/57.15 2.25/57.15 2.25/57.15	3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	0.75/19.05	1.50/38.10 2.00/50.80			
1.37/34.80	2.00/50.80	4.00/101.60	4.00/101.60					2.25/57.15	3.00/76.20	1.00/25.40	2.00/50.80 8.00/203.20			
1.50/38.10	1.75/44.45 2.50/63.50 7.00/177.80	2.50/63.50 3.50/88.90 4.50/114.30	2.50/63.50 3.50/88.90 4.50/114.30					2.25/57.15 2.25/57.15 2.25/57.15	3.00/76.20 3.00/76.20 3.00/76.20	1.06/26.92	3.00/76.20			
1.62/41.15	2.50/63.50 4.00/101.60	2.50/63.50 2.00/50.80	2.50/63.50 2.50/63.50					3.25/82.55 3.25/82.55	3.00/76.20 3.00/76.20	1.37/34.80	3.00/76.20 4.00/101.60 5.00/127.80 8.00/203.20			
1.75/44.45	2.50/63.50 4.00/101.60 6.00/152.40	2.00/50.80 2.50/63.50 2.50/63.50	2.00/50.80 4.00/101.60 2.50/63.50	2.50/63.50 4.00/101.60	4.00/101.60			3.25/82.55 3.25/82.55 3.25/82.55	3.00/76.20 3.00/76.20 3.00/76.20	1.50/38.10	4.00/101.60 6.00/152.40 10.00/254.00			
1.87/47.50	2.50/63.50 3.50/88.90 4.00/101.60	3.00/76.20 3.00/76.20 4.00/101.60	3.00/76.20 3.00/76.20 4.00/101.60	4.00/101.60				3.00/76.20 3.00/76.20 3.00/76.20	3.00/76.20 3.00/76.20 3.00/76.20	1.62/41.15	2.50/63.50 4.00/101.60 6.00/152.40 8.00/203.20			
2.00/50.80	2.50/63.50 3.00/76.20 3.50/88.90 4.00/101.60 5.00/127.80 7.00/177.80	2.00/50.80 2.00/50.80 2.00/50.80 2.00/50.80 2.00/50.80	2.00/50.80 2.00/50.80 2.00/50.80 2.00/50.80 2.00/50.80	3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	5.50/139.70 5.50/139.70 4.00/101.60 4.00/101.60			3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55	3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	1.75/44.45	5.00/127.80 18.00/457.20			
2.12/53.85	3.00/76.20 4.00/101.60	2.62/66.55 4.00/101.60	2.62/66.55					3.25/82.55 3.25/82.55	3.00/76.20 3.00/76.20	1.87/47.50	3.00/76.20 5.00/127.80			
2.25/57.15	2.50/63.50 3.00/76.20 4.00/101.60 5.00/127.80 6.00/152.40	4.00/101.60 3.00/76.20 2.00/50.80 2.00/50.80 5.25/133.35	4.00/101.60 3.00/76.20 2.00/50.80 2.00/50.80 5.25/133.35	5.00/127.80 4.00/101.60 3.00/76.20 4.00/101.60 5.00/127.80	6.00/152.40 4.00/101.60 3.00/76.20 4.00/101.60 5.00/127.80			3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55	3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	2.00/50.80	2.25/57.15 2.50/63.50 3.00/76.20 4.00/101.60 5.00/127.80 8.00/203.20			
2.50/63.50	3.00/76.20 4.00/101.60 5.00/127.80 6.00/152.40 8.00/203.20 10.00/254.00	4.00/101.60 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	4.00/101.60 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	5.00/127.80 4.00/101.60 4.00/101.60 4.00/101.60 5.00/127.80 5.00/127.80	5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80			3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55	3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	2.25/57.15	4.00/101.60 5.00/127.80 6.00/152.40 7.50/190.50 8.00/203.20			
2.75/69.85	4.00/101.60 5.00/127.80 6.00/152.40 8.00/203.20	4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60	4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60	5.00/127.80 5.00/127.80 5.00/127.80 6.00/152.40	6.00/152.40 6.00/152.40 6.00/152.40 6.00/152.40			3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55	5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80	2.50/63.50	5.00/127.80 6.00/152.40 7.00/177.80 8.00/203.20			
3.00/76.20	3.50/88.50 4.00/101.60 4.50/114.30 5.00/127.80 6.00/152.40 8.00/203.20 10.00/254.00 12.00/304.80	4.00/101.60 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	4.00/101.60 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	6.00/152.40 4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60	5.00/127.80 4.00/101.60 4.55/115.57 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80	6.00/152.40 5.00/127.80 6.00/152.40 6.00/152.40 6.00/152.40 6.00/152.40 6.00/152.40 6.00/152.40	7.00/177.80 7.00/177.80 7.00/177.80 7.00/177.80 7.00/177.80 7.00/177.80 7.00/177.80 7.00/177.80	3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20 3.00/76.20	2.75/69.85	5.50/139.70 8.00/203.20	3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55 3.25/82.55			
3.50/88.50	4.25/107.95 5.00/127.80 6.00/152.40 7.00/177.80 8.00/203.20 10.00/254.00 12.00/304.80	5.00/127.80 5.00/127.80 5.00/127.80 4.00/101.60 5.00/127.80 5.00/127.80 7.00/177.80	5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80	7.00/177.80 7.00/177.80 7.00/177.80 5.00/127.80 7.00/177.80 7.00/177.80 7.00/177.80	8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20	8.00/203.20		4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60 4.00/101.60	5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80	3.00/76.20	6.50/165.10 8.00/203.20	7.00/177.80 7.00/177.80		
4.00/101.60	4.00/101.60 4.50/115.57 5.00/127.80 6.00/152.40 7.00/177.80 8.00/203.20 10.00/254.00 11.00/279.40 14.00/355.50 21.00/533.40	3.00/76.20 5.00/127.80 4.00/101.60 4.00/101.60 5.00/127.80 5.00/127.80 5.00/127.80 8.00/203.20 10.00/254.00 10.00/254.00	4.00/101.60 5.00/127.80 4.00/101.60 4.00/101.60 5.00/127.80 5.00/127.80 5.00/127.80 8.00/203.20 10.00/254.00 10.00/254.00	6.00/152.40 6.00/152.40 5.00/127.80 5.00/127.80 6.00/152.40 6.00/152.40 6.00/152.40 8.00/203.20 10.00/254.00 12.00/304.80	8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20 8.00/203.20	7.00/177.80 8.00/203.20		5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80	5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80	4.00/101.60 4.00/101.60				
4.50/114.30	6.00/152.40 9.00/228.60	8.00/203.20 9.00/228.60	8.00/203.20 9.00/228.60					5.00/127.80 5.00/127.80	4.00/101.60 4.00/101.60	1.50 x 3.00 38.10 x 76.20	3.00 76.20			
5.00/127.80	5.50/139.70 6.00/152.40 7.00/177.80 8.00/203.20 10.00/254.00 11.00/279.40	4.00/101.60 5.50/139.70 6.00/152.40 5.00/127.80 6.00/152.40 18.00/457.20	4.00/101.60 5.50/139.70 6.00/152.40 5.00/127.80 6.00/152.40 18.00/457.20	8.00/203.20 6.00/152.40 9.00/228.60 9.00/228.60 9.00/228.60 9.00/228.60	10.00/254.00 10.00/254.00 10.00/254.00 10.00/254.00 10.00/254.00 10.00/254.00	10.00/254.00		5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80	5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80 5.00/127.80	2.00 x 2.00 50.80 x 50.80	3.00 76.20	5.00 127.80	6.25 158.75	15.00 381.00
5.50/139.70	8.00/203.20 10.00/254.00	7.00/177.80 7.00/177.80	7.00/177.80 7.00/177.80	10.00/254.00 10.00/254.00	12.00/304.80 12.00/304.80			4.00/101.60 4.00/101.60	3.00/76.20 3.00/76.20	2.50 x 2.50 63.50 x 63.50	3.75 95.25	8.00 203.20	14.00 355.60	
6.00/152.40	7.00/177.80 8.00/203.20 10.00/254.00	4.00/101.60 6.00/152.40 6.00/152.40	4.00/101.60 6.00/152.40 6.00/152.40	7.00/177.80 10.00/254.00 10.00/254.00	10.00/254.00			4.00/101.60 4.00/101.60 4.00/101.60	3.00/76.20 3.00/76.20 3.00/76.20	3.00 x 3.00 76.20 x 76.20	5.00 127.80	6.25 158.75		
7.00/177.80	8.75/222.25 10.00/254.00	6.00/152.40 9.50/241.30	6.00/152.40 9.50/241.30	10.00/254.00 10.00/254.00	11.00/279.40			4.00/101.60 4.00/101.60	3.00/76.20	4.00 x 4.00 101.60 x 101.60	6.00 152.40	9.50 241.30	12.00 304.80	18.00 457.20
8.00/203.20	14.00/355.60	6.00/152.40	6.00/152.40	7.00/177.80	12.00/304.80			5.00/127.80		5.00 x 5.00 127.00 x 127.00	6.25 158.75			

SQUARE/RECTANGULAR MANDREL BENDING

Outside Diameter (O.D.)	Inside Radius			
1.50 x 3.00 38.10 x 76.20	3.00 76.20			
2.00 x 2.00 50.80 x 50.80	3.00 76.20	5.00 127.00	6.25 158.75	15.00 381.00
2.00 x 8.00 50.80 x 203.20	7.25 184.15			
2.50 x 2.50 63.50 x 63.50	3.75 95.25	8.00 203.20	14.00 355.60	
3.00 x 3.00 76.20 x 76.20	5.00 127.00	6.25 158.75		
3.50 x 3.50 88.90 x 88.90	6.25 158.75	9.00 228.60		
4.00 x 4.00 101.60 x 101.60	6.00 152.40	9.50 241.30	12.00 304.80	18.00 457.20