

Rigid Tube Bender Correction

***Error in example**

Bend Adjustment Chart

Model No.	Tube (O.D.)	Bend Radius	Bend	
			45°	90°
310/316M*	5/8" / 16 mm	2 1/4" / 56 mm	3/32" / 2.4 mm	15/16" / 24 mm
312	3/4"	2 7/8"	1/8"	1 1/4"
310M	10 mm	42 mm	2 mm	18 mm
312M	12 mm	42 mm	2 mm	18 mm
314M	14 mm	56 mm	2.5 mm	24 mm
315M	15 mm	56 mm	2.5 mm	24 mm
318M	18 mm	72 mm	3 mm	31 mm
403	3/16"	5/8"	1/32"	1/4"
404	1/4"	5/8"	1/32"	1/4"
405/408M*	5/16" / 8 mm	15/16" / 24 mm	1/32" / 1 mm	13/32" / 10 mm
406	3/8"	15/16"	1/32"	13/32"
408	1/2"	1 1/2"	1/16"	5/8"
406M	6 mm	16 mm	0.5 mm	6.5 mm
410M	10 mm	24 mm	1 mm	10.5 mm
412M	12 mm	38 mm	1.5 mm	16.5 mm

* This product is dual purpose, being both inch and metric.

NOTE! Bend Adjustment (Gain) factors are calculated theoretical values. Different types of tubing materials and wall thicknesses may require more or less adjustment.

EXAMPLE:

FOR MODEL 403

406 = 3/8"

TUBE SIZE

3/8"

BEND RADIUS

~~3/16"~~ **15/16"**

Adjustment for 90° bend = $\frac{1}{4}" \times 1$

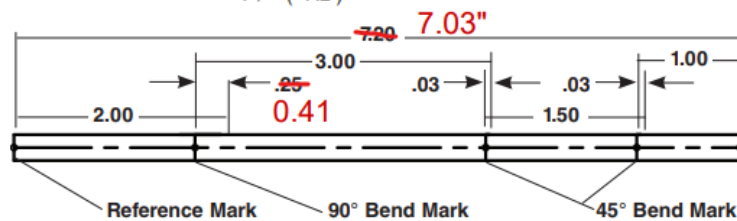
13/32" " for 3/8 90el

Adjustment for 45° bend = $\frac{1}{8}" \times 2$
(Values Found In Adjustment Chart)

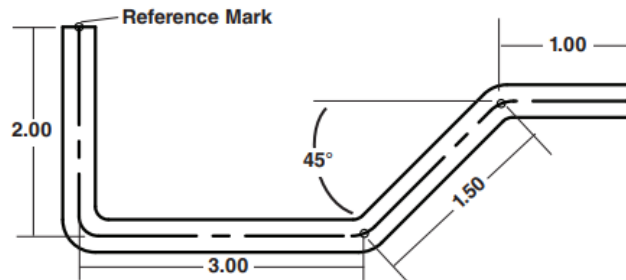
1/32" for 3/8 45el

ACTUAL TUBE = Sum of Centerline Dimensions - Adjustments for Bends

LENGTH REQUIRED = $2.00 + 3.00 + 1.50 + 1.00 - \frac{1}{4}" (.25) - \frac{1}{32}" (.03) - \frac{1}{32}" (.03) = 7 \frac{3}{16}" (\sim 7.2")$



A – Unbent Tube with Markings



B – Bent Tube with Markings