

MERS Bending dies, CBC

Updated: 22-05-17

Tools with out mandrel / Verktyg utan invändigt dorn.

Tube Diameter	Bending Radius		MERS note CM 4130	MERS note Docol R8	MERS note Other qualities
	mm	mm			
50mm	150			2,0mm OK. Thinner not tested	
45mm	180				
40mm	160			1,5mm OK. 1,0mm Fail	
35mm	140			1,5mm OK. 1,0mm 20degrees OK. 25degrees Fail.	
32mm	128				Stainless 2mm OK. Thinner not tested
30mm	120			1,5mm OK. 1,0mm OK with clamp.	
25mm	100	75		2,0mm OK R75. 1,0mm OK with clamp R100.	Stainless 2mm OK. Thinner not tested
20mm	60			1,0mm OK with clamp.	
2" (50,8mm)	200				
1-3/4" (44,45mm)	177,8			0.083" OK. Thinner not tested	
1-5/8" (41,27mm)	165,1			0.083" OK. Thinner not tested	
1-1/2" (38,1mm)	152,4	114,3	0.049" OK with R152,4. Thinner not tested	0.065" OK with R114,3. Thinner not tested	
1-3/8" (34,92mm)	139,7			0.049" OK with R139,7 Thinner not tested	
1-1/4" (31,75mm)	127	95,3	0.049" OK with R127. Thinner not tested	0.049" OK with R127. 0.049" Fail with R95,3	
1-1/8" (28,57mm)	114,3			0.065" OK. Thinner not tested	
1" (25,4mm)	101,8	76,2	0.058" OK with R76,2. Thinner not tested	0.049" OK with R76,2. Thinner not tested	
7/8" (22,22mm)	88,8	76,2		0.058" OK with R76,2. Thinner not tested	Stainless 22 x 2mm OK with R76,2. Thinner not tested
3/4" (19,05mm)	59,5	57,15	0.049" OK with R57,15	0.058" OK with R57,15. Thinner not tested	
5/8" (15,88mm)	47,6			0.058" OK with R47.6. Thinner not tested	
1/2" (12,7mm)	38,1				

Tools with mandrel / Verktyg med invändigt dorn.

Tube Dimension	Bending Radius		MERS note CM 4130	MERS note Docol R8	MERS note Other qualities
	mm	mm			
50 x 2mm	150			OK	
50 x 1,5mm	150			OK	

Radius is center of the tube.

Radius length (mm) = Radius (mm) x Angle (deg.) x 0,0174444 The actual radius also change according to the angle and quality of the tube to be exact.