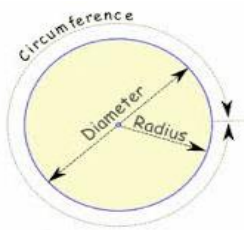




## MERS Bending dies / Bockningsmatriser

CM 4130 MERS note	Tube diameter / Rördiameter	Bending radius / Bockningsradie	Docol R8 MERS note
	50,8 mm	2"	6" 152,4 mm
	44,45 mm	1-3/4"	6" 152,4 mm .065 OK seam on side
	42 mm	42 mm	6" 152,4 mm
.065 OK, .058 Not ok	41,27 mm	1-5/8"	6" 152,4 mm .065 OK, .058 Not ok
.065 OK, .058 Not ok	38,1 mm	1-1/2"	6" 152,4 mm .058 OK
	38,1 mm	1-1/2"	5" 127 mm .065 OK, .058 Not ok
	34,92 mm	1-3/8"	5" 127 mm .058 OK
	31,75 mm	1-1/4"	5" 127 mm
	31,75 mm	1-1/4"	4" 101,6 mm .058 OK, .049 Not ok
	30,16 mm	1-3/16"	6-1/2" 165,1 mm
.065 OK, .058 Not ok	28,57 mm	1-1/8"	4" 101,6 mm .065 OK, .058 Not ok
	25,4 mm	1"	4" 101,6 mm
.058 OK but little flat	25,4 mm	1"	3" 76,2 mm .058 OK but little flat
	22,22 mm	7/8"	3" 76,2 mm .058 OK seam on side
	19,05 mm	3/4"	5" 127 mm
.049 Not ok	19,05 mm	3/4"	2" 50,8 mm .049 OK seam on side
	15,88 mm	5/8"	2" 50,8 mm .035 OK
	12,7 mm	1/2"	1-1/4" 31,75 mm



### Calculation. Good to know

To know the length of the bend:  
 $\text{Radius} + \text{Radius} \times 3,14 / 360 \times \text{your degrees on the tube.}$

Exampel.

90 degree bend with a 6" (152,4mm) Radius

$152,4 + 152,4 \times 3,14 / 360 \times 90 = 239,27\text{mm}$  is the bend in the center of the tube

The easy way is to use this formula.

$\text{Radius} \times \text{Degrees} \times 0,4431 = \text{Lenght on the bend in the center of the tube.}$

$6 \times 90 \times 0,4431 = 239,27\text{mm.}$