



- A = TANGENT
- B = CENTER TO TANGENT DIMENSIONS
- C = CHORD
- D = CIRCLE
- ⊗ = CENTER OF THE BEND

NOTES:

1. MIN. ELBOW ANGLE 10°
2. STD = SCH. 40 WALL
3. DIMENSION "D" = CIRCLE AT ϕ
 $D = \theta^\circ \times R \times 0.01745$

BEND CHECKING:

FINAL DIMENSION CHECKING OF A BEND IS ACCOMPLISHED BY EXTENDING THE CENTERLINE OF EACH TANGENT WITH A STRAIGHT EDGES OR STRINGS UNTIL THEY CROSS. THIS DETERMINES THE "CENTER OF THE BEND" AND IS DETERMINED BY POINT . FROM THIS POINT, EACH APPROPRIATE CENTER TO END OF BEND IS MEASURED AND MARKED. THESE LENGTHS ARE IDENTIFIED AS (A) AND (B). THE CHORD (C) IS CALCULATED FROM THE TWO CENTER TO END DIMENSIONS AND THE ANGLE OF BEND AND IS MEASURED TO CONFIRM THAT THE BEND COMPLIES WITH CUSTOMER REQUIREMENTS.

NOTE: Dimensions in inches, weight in lbs, varying slightly with production models. Request certified drawings of particular models or applications for exact dimensions.

* Optional Equipment - Stainless Alloy

LINE SIZE	R	A (MIN.)	θ (ANGLE)	B	C	D
6 ⁵ / ₈	6'-0	22 TO 24	10°	6 ⁵ / ₁₆	1'-0 ⁹ / ₁₆	1'-0 ⁹ / ₁₆
			15°	9 ¹ / ₂	1'-6 ¹³ / ₁₆	1'-6 ²⁷ / ₃₂
			30°	1'-7 ⁵ / ₁₆	3'-1 ¹ / ₄	3'-1 ¹¹ / ₁₆
			45°	2'-5 ¹³ / ₁₆	4'-8 ¹ / ₈	4'-8 ⁹ / ₁₆
			60°	3'-5 ⁹ / ₁₆	6'-0	8'-3 ¹³ / ₃₂
			90°	6'-0	8'-5 ¹³ / ₁₆	9'-5 ¹ / ₈
8 ⁵ / ₈	8'-0	24	10°	8 ³ / ₈	1'-4 ³ / ₄	1'-4 ³ / ₄
			15°	1'-0 ⁵ / ₈	2'-1 ¹ / ₁₆	2'-1 ¹ / ₈
			30°	2'-1 ³ / ₄	4'-1 ¹¹ / ₁₆	4'-2 ⁹ / ₃₂
			45°	3'-3 ³ / ₄	6'-1 ¹ / ₂	6'-3 ¹³ / ₃₂
			60°	4'-7 ⁷ / ₁₆	8'-0	8'-4 ¹⁷ / ₃₂
			90°	8'-0	11'-3 ¹³ / ₁₆	12'-6 ³ / ₄
10 ³ / ₄	10'-0	24 TO 30	10°	10 ¹ / ₂	1'-8 ¹⁵ / ₁₆	1'-8 ¹⁵ / ₁₆
			15°	1'-3 ¹³ / ₁₆	2'-7 ⁵ / ₁₆	2'-7 ⁷ / ₁₆
			30°	2'-8 ¹ / ₁₆	5'-2 ¹ / ₈	5'-2 ²⁷ / ₃₂
			45°	4'-1 ¹¹ / ₁₆	7'-7 ⁷ / ₈	7'-10 ¹ / ₄
			60°	5'-9 ⁵ / ₁₆	10'-0	10'-5 ²¹ / ₃₂
			90°	10'-0	14'-1 ¹¹ / ₁₆	15'-8 ¹ / ₂
12 ³ / ₄	12'-0	36	10°	1'-0 ⁵ / ₈	2'-1 ¹ / ₈	2'-1 ⁵ / ₃₂
			15°	1'-6 ¹³ / ₁₆	3'-1 ⁹ / ₁₆	3'-1 ¹¹ / ₁₆
			30°	3'-2 ⁹ / ₁₆	6'-2 ⁹ / ₁₆	6'-3 ¹³ / ₃₂
			45°	4'-11 ⁵ / ₈	9'-2 ³ / ₁₆	9'-5 ³ / ₃₂
			60°	6'-11 ¹ / ₈	12'-0	12'-6 ¹³ / ₁₆
			90°	12'-0	16'-11 ⁵ / ₈	18'-10 ³ / ₁₆
14	12'-0	36	10°	1'-0 ⁵ / ₈	2'-1 ¹ / ₈	2'-1 ⁵ / ₃₂
			15°	1'-6 ¹³ / ₁₆	3'-1 ⁹ / ₁₆	3'-1 ¹¹ / ₁₆
			30°	3'-2 ⁹ / ₁₆	6'-2 ⁹ / ₁₆	6'-3 ¹³ / ₃₂
			45°	4'-11 ⁵ / ₈	9'-2 ³ / ₁₆	9'-5 ³ / ₃₂
			60°	6'-11 ¹ / ₈	12'-0	12'-6 ¹³ / ₁₆
			90°	12'-0	16'-11 ⁵ / ₈	18'-10 ³ / ₁₆