Accessory for ROLLER'S Arco 50, ROLLER'S Arco, ROLLER'S Arco 22 V and ROLLER'S Arcus:

- *Form and pressure stable, high sliding bending formers and back formers up to 180° made from high strength, glass fibre reinforced polyamide or aluminium or bending formers up to 90° (Art. No. 581480, 581490, 581500, 581510, 581520, 581530, 581540) for ROLLER'S Arco 50 die-cast and back formers made from high strength, high sliding, glass fibre reinforced polyamide.*
- *For material-compatible bending without cracking and creasing.*
- *Angle scale on every bending former for dimensionally accurate bending.*

Bending and back formers for pipes Ø mm/inch O.D.	**R mm**	**X mm 90°**	**X mm 45°**	**Material bending former**	**Arcus**								**Arco**								**Arco 22 V**								**Arco 50**								**Art.-Nr.**	**€**
					Cu	Cu-U	St 10312	St 10305-U	St 10305	St 10255	St 50086	V	Cu	Cu 12735	Cu-U	St 10312	St 10305-U	St 10305	St 10255	St 50086	V	Cu	Cu 12735	Cu-U	St 10312	St 10305-U	St 10305	St 10255	St 50086	V	Cu	Cu 12735	Cu-U	St 10312	St 1127	St 10305-U	St 10305	St 10255	St 50086	V		
10	40	45	20	P	●				●				●					●				●					●				▲						▲				581400	**180,61**
12	45	49	22	P	●		●		●				●			●		●				●			●		●				▲			▲			▲				581410	**135,98**
14, 10 U, ¼" (DN 6)	50	53	23	P	●	●			●			●	●		●			●	●		●	●		●			●	●		●	▲		▲				▲	▲		▲	581420	**131,83**
15, 12 U	55	56	25	P	●		●	●	●				●			●	●	●				●			●	●	●				▲			▲		▲	▲				581430	**147,40**
16, 12 U	60	62	28	P	●	●			●		●	●	●		●			●		●	●	●		●			●		●	●	▲		▲				▲		▲	▲	581440	**148,43**
17, 15 U	56	60	27	P				●				●					●				●					●				●					▲						581110	**181,65**
18, 14 U, 15 U, ⅜" (DN10)	70	75	33	P	●	●	●		●			●	●		●	●		●	●		●	●		●	●		●	●		●	▲		▲	▲			▲	▲		▲	581450	**149,47**
20, 16 U, 18 U	75	80	36	P	●	●		●			●	●	●		●				●	●	●	●		●				●	●	●	▲		▲			▲			▲	▲	581080	**237,70**
21.3, ½" (s = 1.6/2.0/2.6)	103	110	50	S																														■			■				581480	**536,65**
22, 18 U, ½" (DN 15)	77	81	36	A	●	●			●				●		●	●		●	●			●		●	●		●	●			▲		▲	▲			▲	▲			581460	**177,50**
22, 18 U, ½" (DN 15)	88	91	41	P									●		●	●		●				●		●	●		●				▲		▲	▲			▲				581470	**260,54**
24, 22 U	75	85	38	P									●				●					●				●					▲				▲						581130	**288,56**
25	98	103	46	P								●	●					●		●	●	●					●		●	●	▲						▲		▲	▲	581180	**317,63**
26	98	108	49	P								●						●			●						●			●							▲			▲	581270	**438,04**
26.9, ¾" (s = 1.6/2.0/2.6)	102	108	49	S																														■			■				581490	**598,93**
28[1]	102[3]	108	49	P									●									●									▲										581070	**278,18**
28, ¾" (DN 20)[2]	102	110	50	A									●			●		●	●			●			●		●	●			▲			▲			▲	▲			581260	**428,69**
28, ¾" (DN 20)[2]	114	120	54	A									●			●		●	●			●			●		●	●			▲			▲			▲	▲			581310	**371,60**
30, 28 U	98	105	47	P									●				●					●				●					▲					▲					581150	**349,81**
32	98	110	50	P								●									●									●										▲	581280	**339,43**
32	114	121	54	A									●						●	●										●	▲								▲	▲	581320	**438,04**
1" (DN 25)	100	105	47	S																																	■				581520	**498,24**
33.7, 1" (s = 1.6/2.0/2.6)	100	105	47	S																														■			■				581520	**498,24**
35	100	105	47	S																											■			■			■				581500	**498,24**
35	140	150	68	A									●																		▲			▲							581350	**585,43**
40	140	148	67	A																	●									●										▲	581330	**589,58**
42	140	155	70	S																											■			■			■				581510	**532,49**
1¼" (DN 32)	140	150	68	S																																	■				581530	**517,96**
42.4, 1¼" (s = 2.0/2.6)	140	150	68	S																																	■				581530	**517,96**
50	135	143	64	S																																				■	581540	**699,61**
⅜" (9.5mm)	43	48	22	P	●								●	●								●	●								▲	▲									581200	**228,36**
½" (12.7mm)	52	60	27	P	●								●	●								●	●								▲	▲									581210	**217,98**
⅝" (15.9mm)	63	70	32	P	●								●	●								●	●								▲	▲									581220	**244,97**
¾" (19.1mm)	75	82	37	P	●								●	●								●	●								▲	▲									581230	**291,68**
⅞" (22.2mm)	98	107	48	P	●								●	●								●	●								▲	▲									581240	**341,50**
1" (25.4mm)	101	112	50	A									●									●									▲										581360 R	**445,30**
1" (25.4mm)	101	112	50	P									●									●									▲										581370	**338,39**
1⅛" (28.6mm)	102	110	44	A									●	●								●	●								▲	▲									581260	**428,69**
1⅛" (28.6mm)	115	117	53	A									●									●									▲										581380	**371,60**
1¼" (31.8mm)	114	123	55	A									●																		▲	▲									581320	**438,04**
1¼" (31.8mm)	133	145	65	A									●																		▲										581390	**618,65**
1⅜" (34.9mm)	100	105	47	S																												■									581500	**498,24**
1⅜" (34.9mm)	140	150	68	A									●	●																	▲	▲									581350	**585,43**
1⅝" (41.3mm)	140	155	70	S																											■	■									581510	**532,49**

Bending to measure

If a bend is to be in a certain place on the pipe, a length correction must be made according to the pipe size. The correction dimension X specified in Fig. 1 must be considered for a 90° bend or a 45° bend. The nominal dimension L must be shortened by the value X here. If, e.g., the dimension L for pipe size 22 is 400 mm and a bend of 90° with a bending radius of 77 mm is to be made, the dimension line should be marked on the pipe at 319 mm. This mark must then be placed at the 0 mark on the bending former as shown in Fig. 1.

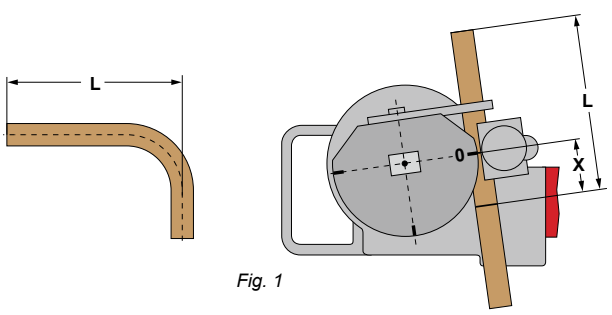

Fig. 1

R mm	*Bending radius mm at the neutral axis of the bend (DVGW GW 392)*
X mm	*correction dimension mm for a 90° bend or a 45° bend*
s mm	*Wall thickness*
[1]	*hard, semi-hard copper pipes, also thin-walled, EN 1057*
[2]	*hard copper pipes EN 1057*
[3]	*According to DVGW work sheet GW 392 for hard and semi-hard copper pipes Ø 28 mm minimum bending radius 114 mm necessary. Wall thickness ≥ 0.9 mm.*
▲	*Square driver 10 – 40, support 10 – 40 (Art. No. 582120) necessary.*
■	*Square driver 35 – 50, support 35 – 50 (Art. No. 582110) necessary.*
Cu:	*hard, semi-hard, soft copper tubes, also thin-walled, EN 1057*
Cu 12735:	*Copper pipes K65 for refrigeration and air-conditioning technology in accordance with EN 12735-1*
St 10312:	*Stainless steel pipes of the pressfitting systems EN 10312, series 2, EN 10088, EN 10217-7*
St 1127:	*Stainless steel pipes EN ISO 1127, EN 10217-7*
St 10305-U:	*Coated, soft carbon steel pipes of the pressfitting systems EN 10305-3*
St 10305:	*Soft precision steel pipes EN 10305-1, EN 10305-2, EN 10305-3, carbon steel pipes EN 10305-3*
St 10255:	*Steel pipes (threaded pipes) EN 10255*
St 50086:	*Electrical installation pipes EN 50086*
U:	*jacketed*
V:	*composite tubes of the pressfitting systems*
P:	*Glass fibre-reinforced bending former*
A:	*Aluminium bending former*
S:	*Spheroidal iron bending former*