

- 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 10305-U	St 10305	St 10255	St 50086	V							
10	40	45	20	P	•								•									•									•							581400	209,00							
12	45	49	22	P	•								•									•									•								581410	158,00						
14, 10 U, ¼" (DN 6)	50	53	23	P	•	•							•									•									•									581420	153,00					
15, 12 U	55	56	25	P	•	•	•						•									•									•										581430	171,00				
16, 12 U	60	62	28	P	•	•							•									•									•											581440	172,00			
17, 15 U	56	60	27	P	•								•									•									•											581110	210,00			
18, 14 U, 15 U, ⅜" (DN10)	70	75	33	P	•	•							•									•									•											581450	173,00			
20, 16 U, 18 U	75	80	36	P	•	•							•									•									•											581080	275,00			
21.3, ½" (s = 1.6/2.0/2.6)	103	110	50	S																																						581480	620,00			
22, 18 U, ½" (DN 15)	77	81	36	A	•	•							•									•									•												581460	206,00		
22, 18 U, ½" (DN 15)	88	91	41	P									•									•									•												581470	301,00		
24, 22 U	75	85	38	P									•									•									•												581130	334,00		
25	98	103	46	P									•									•									•												581180	367,00		
26	98	108	49	P									•									•									•												581270	510,00		
26.9, ¾" (s = 1.6/2.0/2.6)	102	108	49	S																																							581490	700,00		
28 ¹⁾	102 ³⁾	108	49	P									•									•									•													581070	322,00	
28, ¾" (DN 20) ²⁾	102	110	50	A									•									•									•												581260	496,00		
28, ¾" (DN 20) ²⁾	114	120	54	A									•									•									•												581310	430,00		
30, 28 U	98	105	47	P									•									•									•													581150	405,00	
32	98	110	50	P									•									•									•													581280	393,00	
32	114	121	54	A									•									•									•												581320	510,00		
1" (DN 25)	100	105	47	S																																								581520	580,00	
33.7, 1" (s = 1.6/2.0/2.6)	100	105	47	S																																								581520	580,00	
35	100	105	47	S																																								581500	580,00	
35	140	150	68	A									•									•									•													581350	680,00	
40	140	148	67	A									•									•									•													581330	690,00	
42	140	155	70	S																																								581510	620,00	
1¼" (DN 32)	140	150	68	S																																								581530	600,00	
42.4, 1¼" (s = 2.0/2.6)	140	150	68	S																																								581530	600,00	
50	135	143	64	S																																								581540	810,00	
⅜" (9.5mm)	43	48	22	P	•								•									•									•														581200	264,00
½" (12.7mm)	52	60	27	P	•								•									•									•														581210	252,00
⅝" (15.9mm)	63	70	32	P	•								•									•									•														581220	283,00
¾" (19.1mm)	75	82	37	P	•								•									•									•														581230	337,00
⅞" (22.2mm)	98	107	48	P	•								•									•									•														581240	395,00
1" (25.4mm)	101	112	50	A									•									•									•														581360 R	520,00
1" (25.4mm)	101	112	50	P									•									•									•														581370	391,00
1¼" (28.6mm)	102	110	44	A									•									•									•														581260	496,00
1½" (28.6mm)	115	117	53	A									•									•									•														581380	430,00
1¼" (31.8mm)	114	123	55	A									•									•									•														581320	510,00
1¼" (31.8mm)	133	145	65	A									•									•									•														581390	720,00
1¾" (34.9mm)	100	105	47	S																																								581500	580,00	
1¾" (34.9mm)	140	150	68	A									•									•									•														581350	680,00
1¾" (41.3mm)	140	155	70	S																																								581510	620,00	

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.

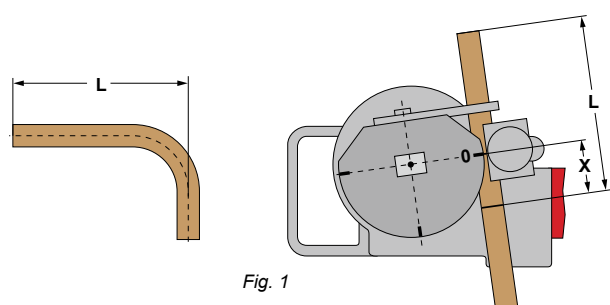


Fig. 1

- 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