

- 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	X mm	Material bending former	Arcus				Arco				Arco 22V				Arco 50				Art.-Nr.	kr					
					Cu	St 10312	St 10305-U	St 10305	St 50086	V	Cu	Cu-U	St 10312	St 10305-U	St 10305	St 50086	V	Cu	Cu-U	St 1127			St 10305-U	St 10305	St 50086	V	
10	40	45	20	P	•																				581400	2 240,00	
12	45	49	22	P	•																					581410	1 690,00
14, 10 U, ¼" (DN 6)	50	53	23	P	•	•																				581420	1 630,00
15, 12 U	55	56	25	P	•	•	•																			581430	1 830,00
16, 12 U	60	62	28	P	•	•	•	•																		581440	1 840,00
17, 15 U	56	60	27	P	•																					581110	2 250,00
18, 14 U, 15 U, ⅜" (DN10)	70	75	33	P	•	•	•																			581450	1 850,00
20, 16 U, 18 U	75	80	36	P	•	•	•																			581080	2 940,00
21.3, ½" (s = 1.6/2.0/2.6)	103	110	50	S																						581480	6 640,00
22, 18 U, ½" (DN 15)	77	81	36	A	•	•																				581460	2 200,00
22, 18 U, ½" (DN 15)	88	91	41	P																						581470	3 220,00
24, 22 U	75	85	38	P																						581130	3 570,00
25	98	103	46	P																						581180	3 930,00
26	98	108	49	P																						581270	5 420,00
26.9, ¾" (s = 1.6/2.0/2.6)	102	108	49	S																						581490	7 410,00
28 ¹⁾	102 ³⁾	108	49	P																						581070	3 440,00
28, ¾" (DN 20) ²⁾	102	110	50	A																						581260	5 300,00
28, ¾" (DN 20) ²⁾	114	120	54	A																						581310	4 600,00
30, 28 U	98	105	47	P																						581150	4 330,00
32	98	110	50	P																						581280	4 200,00
32	114	121	54	A																						581320	5 420,00
1" (DN 25)	100	105	47	S																						581520	6 160,00
33.7, 1" (s = 1.6/2.0/2.6)	100	105	47	S																						581520	6 160,00
35	100	105	47	S																						581500	6 160,00
35	140	150	68	A																						581350	7 240,00
40	140	148	67	A																						581330	7 290,00
42	140	155	70	S																						581510	6 580,00
1¼" (DN 32)	140	150	68	S																						581530	6 400,00
42.4, 1¼" (s = 2.0/2.6)	140	150	68	S																						581530	6 400,00
50	135	143	64	S																						581540	8 650,00
⅜" (9.5 mm)	43	48	22	P	•																					581200	2 830,00
½" (12.7 mm)	52	60	27	P	•																					581210	2 700,00
⅝" (15.9 mm)	63	70	32	P	•																					581220	3 030,00
¾" (19.1 mm)	75	82	37	P	•																					581230	3 610,00
⅞" (22.2 mm)	98	107	48	P	•																					581240	4 220,00
1" (25.4 mm)	101	112	50	A																						581360 R	5 510,00
1" (25.4 mm)	101	112	50	P																						581370	4 190,00
1½" (28.6 mm)	102	110	44	A																						581260	5 300,00
1½" (28.6 mm)	115	117	53	A																						581380	4 600,00
1¼" (31.8 mm)	114	123	55	A																						581320	5 420,00
1¼" (31.8 mm)	133	145	65	A																						581390	7 650,00
1⅜" (34.9 mm)	100	105	47	S																						581500	6 160,00
1⅜" (34.9 mm)	140	150	68	A																						581350	7 240,00
1⅝" (41.3 mm)	140	155	70	S																						581510	6 580,00

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.

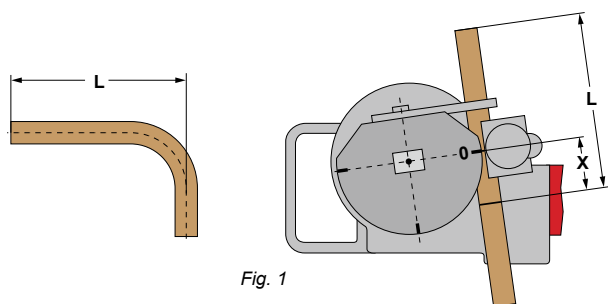


Fig. 1

- 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