

Proline BM16-30 Series 3 Bending Capabilities

PIPE DIAMETER Inches / mm	MAXIMUM WALL THICKNESS BY GRADE (mm)				
	X52	X60	X65	X70	X80
16 / 406.4	105.76	91.84	81.74	73.99	62.61
18 / 457.2	63.73	58.32	53.73	49.83	43.57
20 / 508.0	46.59	43.12	40.08	37.46	33.12
22 / 558.8	36.41	33.87	31.62	29.65	26.37
24 / 609.6	29.56	27.57	25.8	24.24	21.63
26 / 660.4	24.61	22.99	21.55	20.27	18.13
28 / 711.2	20.88	19.53	18.32	17.25	15.45
30 / 762.0	17.98	16.83	15.8	14.89	13.35

PIPE DIAMETER Inches / mm	DEGREE PER ARC 30.5cm IN DIE	RECOMMENDED BEND BASED ON BENDING AT 1.5° PER PIPE DIAMETER		MAXIMUM BEND	
		BEND RADIUS (M)	DEGREES IN 12M JOINT	BEND RADIUS (M)	DEGREES IN 12M JOINT
16 / 406.4	2.14	15.53	23.6	14.38	25.4
18 / 457.2	1.96	17.47	20.9	15.22	24
20 / 508.0	1.7	19.41	18.9	15.55	23.5
22 / 558.8	1.56	21.35	17.1	16.76	21.8
24 / 609.6	1.42	23.29	15.7	18.29	20
26 / 660.4	1.31	25.23	14.5	19.81	18.5
28 / 711.2	1.22	27.17	13.5	20.27	18.1
30 / 762.0	1.12	29.11	12.6	20.42	17.9

Pipe ends not bendable, based on stiff back and pin-up fully loaded with pipe.

Stiff-back end 3.4M

Pin-up end 2.09M

(BENDING PIPE WITH STIFFBACK AND PINUP NOT FULLY LOADED WITH PIPE MAY CAUSE THE PIPE TO RUPTURE/BUCKLE)

The above figures are recommended only and do not constitute a warranty. They are based on the use of Proline Bending Mandrels and Proline Bending Die Sets, they may vary due to:

- v The wall thickness of the pipe.
- v The actual yield point of the pipe, not the nominal.
- v The skill of the Bending Machine and Bending Mandrel operators.
- v The type and quality of the pipe. (spiral seam pipe will normally accept 75% of the bend)