

Proline BM20-36 Series 3 Bending Capabilities

PIPE DIAMETER Inches / mm	MAXIMUM WALL THICKNESS BY GRADE (mm)				
	X52	X60	X65	X70	X80
20 / 508.0	98.4	88.44	80.39	73.81	63.61
22 / 558.8	69.93	64.23	59.34	55.17	48.41
24 / 609.6	54.42	50.38	46.86	43.8	38.76
26 / 660.4	44.24	41.14	38.39	35.99	32
28 / 711.2	36.98	34.47	32.24	30.28	27.01
30 / 762.0	31.51	29.42	27.56	25.92	23.16
32 / 812.8	27.26	25.48	23.89	22.49	20.13
34 / 863.6	23.85	22.32	20.94	19.72	17.67
36 / 914.4	21.08	19.73	18.53	17.46	15.66

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
20 / 508.0	1.56	19.41	19	15.55	23.7
22 / 558.8	1.56	21.35	17.2	16.76	21.9
24 / 609.6	1.42	23.29	15.8	18.29	20.1
26 / 660.4	1.31	25.23	14.6	19.81	18.6
28 / 711.2	1.22	27.17	13.5	20.27	18.1
30 / 762.0	1.12	29.11	12.6	20.42	18
32 / 812.8	1.04	31.05	11.8	21.83	16.9
34 / 863.6	1.01	32.99	11.2	23.56	15.6
36 / 914.4	0.96	34.93	10.5	24.95	14.7

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

Stiff-back end 3.40M

Pin-up end 2.18M

(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)