Proline BM30-42HD Bending Capabilities

PIPE DIAMETER Inches / mm	MAXIMUM WALL THICKNESS BY GRADE (mm)				
	X52	X60	X65	X70	X80
30 / 762.0	78.23	72.23	67.02	62.52	55.16
32 / 812.8	65.63	60.87	56.69	53.05	47.03
34 / 863.6	56.27	52.33	48.86	45.81	40.75
36 / 914.4	49	45.66	42.7	40.1	35.75
38 / 965.2	43.18	40.29	37.73	35.47	31.67
40 / 1016.0	38.42	35.89	33.63	31.64	28.3
42 / 1066.8	34.46	32.21	30.21	28.44	25.46

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
30 / 762.0	1.12	29.11	11.2	28.19	11.6
32 / 812.8	1.04	31.05	10.5	29.75	11
34 / 863.6	1.01	32.99	9.9	31.5	10.4
36 / 914.4	0.96	34.93	9.4	34.93	9.3
38 / 965.2	0.96	36.87	8.9	34.93	9.3
40 / 1016.0	0.96	38.81	8.4	34.93	9.3
42 / 1066.8	0.96	40.75	8	34.93	9.3

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

Stiff-back end 3.87M

Pin-up end 2.43M

(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:

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