



**Malvern Tubular  
Components Ltd**

A subsidiary of Tricorn Group plc

# Bend Tooling List

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Imperial /Metric	Tube Diameter (inch/mm)	Centre Line Radius (inch/mm)	Clamp - (mm) Straight distance between bends	Tube Wall (swg/mm)	Machine
Imp	0.187	0.562	23	20.18.16	DB19
Imp	0.25	0.50	16	27.22.20	DB19
Imp	0.25	0.75	19	27.22.20	DB19
Imp	0.25	0.75	19	27.22.20	DB19
Imp	0.25	0.875	40	27.22.20	DB19
Imp	0.25	1.00	19	27.22.20	DB19
Imp	0.25	1.25	19	27.22.20	DB19
Imp	0.25	1.375	19	27.22.20	DB19
Imp	0.25	15	19	27.22.20	DB19
Imp	0.312	1.093	22	22.20.18	DB19
Imp	0.312	17	25	22.20.18	DB19
Imp	0.312	20	27	22.20.18	DB19
Imp	0.375	0.687	19	22.20.18.16	DB19
Imp	0.375	0.687	25	22.20.18.16	DB19
Imp	0.375	1.312	29	22.20.18.16	DB19
Imp	0.375	1.875	29	22.20.18.16	DB19
Imp	0.375	25	40	22.20.18.16	DB19
Imp	0.5	1.00	38	22.20.18.16	DB19
Imp	0.5	1.125	22	22.20.18.16	DB19
Imp	0.5	1.75	38	22.20.18.16	DB19
Imp	0.5	20	22	22.20.18.16	DB19
Imp	0.5	37	30	22.20.18.16	DB19
Imp	0.625	0.625	35	14	DB19
Imp	0.75	2.25	57	20.18.16.13	DB19
Imp	0.75	2.25	70	22.20.18.16	DB76
Imp	0.75	2.625	57	22.20.18.16	DB76
Imp	0.75	30	42	20.18.16.13	DB19
Imp	0.75	30	47	22.20.18.16	DB76
Imp	1.0	1.50	67	20.18.16	DB76
Imp	1.0	1.625	46	20.18.16	DB76
Imp	1.0	2.00	76	20.18.16	DB76
Imp	1.0	3.25	87	20.18.16	DB76
Imp	1.0	4.00	127	20.18.16	DB76
Imp	1.04	1.875	90	3/4 n.b.	DB76
Imp	1.125	1.75	60	18.16	DB76
Imp	1.125	2.00	60	18.16	DB76
Imp	1.25	1.75	57	18.16	DB76
Imp	1.25	2.00	70	18.16	DB76
Imp	1.25	2.25	70	18.16	DB76
Imp	1.25	4.00	150	18.16	DB76
Imp	1.375	2.16	105	16	DB76
Imp	1.375	2.875	105	16	DB76
Imp	1.5	1.50	108	22.20.18.16.14.12	DB76
Imp	1.5	2.00	69/80	22.20.18.16.14.12	DB76
Imp	1.5	2.25	115	22.20.18.16.14.12	DB76
Imp	1.5	60	85	22.20.18.16.14.12	DB76
Imp	1.5	2.50	85	22.20.18.16.14.12	DB76
Imp	1.5	3.00	85	22.20.18.16.14.12	DB76
Imp	1.5	4.75	115	22.20.18.16.14.12	DB76
Imp	1.5	58.5	125	22.20.18.16.14.12	DB76
Imp	1.5	100	107	22.20.18.16.14.12	DB76
Imp	1.625	2.25	75	16	DB76
Imp	1.75	2.05	90	18.16.14. 1.5mm	DB76
Imp	1.75	3.50	85	18.16.14. 1.5mm	DB76

Imp	1.75	4.375	125	18.16.14. 1.5mm	DB76
Imp	1.875	71	100	16	DB76
Imp	1.875	88.5	100	16	DB76
Imp	1.9	9.50	150	1.1/2.n.b	DB76
Imp	2.0	2.25	150	20.18.16.14	DB76
Imp	2.0	2.844	120	20.18.16.14	DB76
Imp	2.0	3.00	130	20.18.16.14	DB76
Imp	2.0	4.00	125	20.18.16.14	DB76
Imp	2.0	5.00	125	20.18.16.14	DB76
Imp	2.0	6.00	150	20.18.16.14	DB76
Imp	2.0	85	125	20.18.16.14	DB76
Imp	2.125	3.187	110	16	DB76
Imp	2.25	2.25	165	22. 2.9mm.2mm	CL400
Imp	2.25	2.75	180	22. 2.9mm.2mm	db76
Imp	2.25	3.375	110	18.16.14	DB76
Imp	2.25	3.375	180	22. 2.9mm.2mm	CL400
Imp	2.25	4.625	140	18.16.14	DB76
Imp	2.375	7.00	180	16, 2.77mm	DB76
Imp	2.5	2.50	110	24.20.18.16.14	DB76/CL400
Imp	2.5	3.75	120	24.20.18.16.14	DB76
Imp	2.5	4.50	115	24.20.18.16.14	DB76
Imp	2.5	5.00	120	24.20.18.16.14	DB76
Imp	2.5	140	190	24.20.18.16.14	DB76
Imp	2.75	2.75	180	22.16.14 1.4mm	CL400
Imp	2.75	4.125	180	22.16.14 1.4mm	DB76/CL400
Imp	3.0	3.00	230	16	PB120
Imp	3.0	3.75	220	16	db76
Imp	3.0	4.50	160	16.14.13.10 1.5mm	DB76
Imp	3.0	5.50	180	16.14.13.10 1.5mm	DB76
Imp	3.0	6.00	175	16.14.13.10 1.5mm	DB76
Imp	3.0	6.00	230	22	CL400
Imp	3.0	6.875	220	22	CL400
Imp	3.5	3.500	200	16	db120
Imp	3.5	4.50	200	16.10 1.5mm	DB120/PB120
Imp	3.5	7.75	270	16.10 1.5mm	DB120/PB120
Imp	4.0	4.00	255	16.14.10	DB120
Imp	4.0	6.00	310	16.14.10	db120
Imp	4.0	10.00	305	16.14.10	DB/PB120
Imp	4.0	125	305	16.14.10	DB120
Imp	4.0	150	203	16.14.10	DB120
Imp	4.0	200	305	16.14.10	DB120
Imp	4.5	6.75	343	23.20.18.16	cl400
Imp	4.5	9.00	343	23.20.18.16	cl400
Metric	6	15.5	21	1mm	DB19
Metric	6	17	21	1mm	DB19
Metric	6	33	20	1mm	DB19
Metric	8	12	25	0.9mm.0.7mm	DB19
Metric	8	31.75	24	0.9mm.0.7mm	DB19
Metric	10	17	30	0.9mm.1mm	DB19
Metric	10	25	40	0.9mm.1mm	DB19
Metric	12	25	30	1mm.1.5mm	DB19
Metric	14	30	23	2mm	DB19
Metric	15	30	40	2mm	DB19
Metric	16	30	35	1mm.1.5mm	DB19
Metric	20	40	40	2mm	DB76
Metric	20	100	40	2mm	DB76
Metric	22	35	40	1mm.2mm.16	DB76
Metric	25	50	50	2mm	DB76
Metric	28	44	80	2mm	DB76
Metric	35	52.5	85	1.5mm.2mm	DB76
Metric	48.5	65	200	5mm	DB76
Metric	70	4.125	175	1.4mm	DB76
Metric	70	140	90	1.5mm	DB76
Metric	128 (5")	190.5	380	16. 1.5mm	DB/PB120,CL400
Metric	128 (5")	254	320	16. 1.5mm	DB/PB120,CL400

This Tooling List is produced as a design aid for customers wishing to specify bend radii for multi-bend components using our CNC Tube Bending equipment. The list is constantly being updated and sizes that are required but not shown must be referred to the Sales Dept. The column marked 'clamp' represents the minimum straight distance between bends that must be observed to eliminate welded joints.

Please visit our website at: [www.mtc.uk.com](http://www.mtc.uk.com)