

TABLE 1

Horizontal bend for BWSG pipe										
Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)
700	830	11.25	1000	500	1300	722	578	1130	150	150
		22.5	1800	800	1300	735	567	1230	200	200
		45	3000	1000	2900	1692	1208	1230	200	200
		90	4500	1900	3750	2129	1621	1430	300	300
Horizontal bend for DI-K7 pipe										
150	170	11.25	250	125	1000	556	444	470	150	150
		22.5	500	250	1000	556	444	470	150	150
		45	725	350	800	447	353	520	175	175
		90	1250	625	1200	667	533	520	175	175
200	222	11.25	250	125	1000	556	444	522	150	150
		22.5	450	200	1000	564	436	522	150	150
		45	850	325	1100	632	468	522	150	150
		90	1225	550	1350	761	589	672	225	225
250	274	11.25	325	150	1250	702	548	574	150	150
		22.5	625	300	1250	698	552	574	150	150
		45	1200	550	1300	730	570	574	150	150
		90	1750	700	1250	714	536	774	250	250
350	378	11.25	700	350	1000	556	444	678	150	150
		22.5	1250	500	1700	971	729	678	150	150
		45	2150	600	1700	1010	690	778	200	200
		90	3350	1500	2650	1493	1157	828	225	225
Horizontal bend for DI-K9 pipe										
150	170	11.25	700	250	1000	579	421	728	175	175
		22.5	1250	500	1250	714	536	778	200	200
		45	2300	750	1750	1023	727	778	200	200
		90	3400	1200	2050	1188	862	978	300	300
Horizontal bend for HDPE pipe-6kg/cm <sup>2</sup>										
63	63	11.25	300	200	1000	533	467	363	150	150
		22.5	600	400	1000	533	467	363	150	150
		45	700	450	1000	536	464	363	150	150
		90	1400	850	1000	541	459	363	150	150
75	75	11.25	300	200	1000	533	467	375	150	150
		22.5	500	350	1000	529	471	375	150	150
		45	750	425	1000	546	454	375	150	150
		90	1700	800	1150	644	506	375	150	150
90	90	11.25	300	200	1000	533	467	390	150	150
		22.5	500	350	1000	529	471	390	150	150
		45	800	500	1000	538	462	390	150	150
		90	1600	800	1150	639	511	390	150	150
110	110	11.25	300	200	1000	533	467	410	150	150
		22.5	500	350	1000	529	471	410	150	150
		45	700	350	1000	529	471	410	150	150
		90	1300	700	1000	550	450	410	150	150
125	125	11.25	400	300	1000	524	476	425	150	150
		22.5	700	350	1200	667	533	425	150	150
		45	700	350	1150	639	511	425	150	150
		90	1600	800	1150	639	511	425	150	150
140	140	11.25	400	300	1000	524	476	440	150	150
		22.5	700	350	1200	667	533	440	150	150
		45	700	350	1150	639	511	440	150	150
		90	1600	800	1150	639	511	440	150	150
Horizontal bend for HDPE pipe-8kg/cm <sup>2</sup>										
63	63	11.25	300	200	1000	533	467	363	150	150
		22.5	600	400	1000	533	467	363	150	150
		45	700	450	1000	536	464	363	150	150
		90	1400	800	1000	536	464	363	150	150
75	75	11.25	300	200	1000	533	467	375	150	150
		22.5	500	350	1000	529	471	375	150	150
		45	750	425	1000	546	454	375	150	150
		90	1600	800	1150	639	511	375	150	150
90	90	11.25	300	200	1000	533	467	390	150	150
		22.5	500	350	1000	529	471	390	150	150
		45	700	350	1000	529	471	390	150	150
		90	1300	700	1000	550	450	390	150	150
110	110	11.25	300	200	1000	533	467	410	150	150
		22.5	500	350	1000	529	471	410	150	150
		45	700	350	1100	611	489	410	150	150
		90	1450	800	1000	548	452	410	150	150
125	125	11.25	300	200	1000	533	467	425	150	150
		22.5	600	300	1100	611	489	425	150	150
		45	650	325	1000	556	444	425	150	150
		90	1400	700	1000	556	444	425	150	150
140	140	11.25	300	200	1000	533	467	440	150	150
		22.5	600	400	1000	533	467	440	150	150
		45	650	300	1000	561	439	440	150	150
		90	1000	500	1000	556	444	440	150	150
Horizontal bend for HDPE pipe-10kg/cm <sup>2</sup>										
140	140	11.25	300	200	1000	533	467	440	150	150
		22.5	650	400	1000	540	460	440	150	150
		45	500	250	1000	556	444	440	150	150
		90	950	450	1000	560	440	440	150	150

TABLE 2

Vertical upturn bend for BWSG pipe									
Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)
700	830	11.25	1000	500	1300	722	578	1130	150
		22.5	1000	500	1300	722	578	1130	150
		45	1000	500	1300	722	578	1130	150
Vertical upturn bend for DI-K7 pipe									
150	170	11.25	1000	500	470	150	150		
		22.5	1000	500	470	150	150		
		45	1000	500	470	150	150		
200	222	11.25	1000	550	522	150	150		
		22.5	1000	550	522	150	150		
		45	1000	550	522	150	150		
250	274	11.25	1000	600	574	150	150		
		22.5	1000	600	574	150	150		
		45	1000	600	574	150	150		
350	378	11.25	1000	700	678	150	150		
		22.5	1000	700	678	150	150		
		45	1150	750	678	150	150		
Vertical upturn bend for DI-K9 pipe									
11.25	1000	700	678	150	150				
		22.5	1000	700	678	150	150		
		45	1300	700	678	150	150		
Vertical upturn bend for HDPE pipe-6kg/cm <sup>2</sup>									
63	63	11.25	1000	400	363	150	150		
		22.5	1000	400	363	150	150		
		45	1000	400	363	150	150		
75	75	11.25	1000	400	375	150	150		
		22.5	1000	400	375	150	150		
		45	1000	400	375	150	150		
90	90	11.25	1000	400	375	150	150		
		22.5	1000	400	375	150	150		
		45	1000	400	375	150	150		
110	110	11.25	1000	450	410	150	150		
		22.5	1000	450	410	150	150		
		45	1000	450	410	150	150		
125	125	11.25	1000	450	425	150	150		
		22.5	1000	450	425	150	150		
		45	1000	450	425	150	150		
140	140	11.25	1000	450	440	150	150		
		22.5	1000	450	440	150	150		
		45	1000	450	440	150	150		
Vertical upturn bend for HDPE pipe-8kg/cm <sup>2</sup>									
63	63	11.25	1000	400	363	150	150		
		22.5	1000	400	363	150	150		
		45	1000	400	363	150	150		
75	75	11.25	1000	400	375	150	150		
		22.5	1000	400	375	150	150		
		45	1000	400	375	150	150		
90	90	11.25	1000	400	390	150	150		
		22.5	1000	400	390	150	150		
		45	1000	400	390	150	150		
110	110	11.25	1000	450	410	150	150		
		22.5	1000	450	410	150	150		
		45	1000	450	410	150	150		
125	125	11.25	1000	450	425	150	150		
		22.5	1000	450	425	150	150		
		45	1000	450	425	150	150		
140	140	11.25	1000	450	440	150	150		
		22.5	1000	450	440	150	150		
		45	1000	450	440	150	150		
Vertical upturn bend for HDPE pipe-10kg/cm <sup>2</sup>									
140	140	11.25	1000	450	425	150	150		
		22.5	1000	450	425	150	150		
		45	1000	450	425	150	150		

TABLE 3

Vertical downturn bend for BWSG pipe									
Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	H1 (mm)	H2 (mm)
700	830	11.25	1800	1150	1130	150	150		
		22.5	2350	1500	1280	225	225		
		45	3000	2250	1130	150	150		
Vertical downturn bend for DI-K7 pipe									
150	170	11.25	1000	500	470	150	150		
		22.5	1000	500	470	150	150		
		45	1000	500	470	150	150		