

TABLE - 1

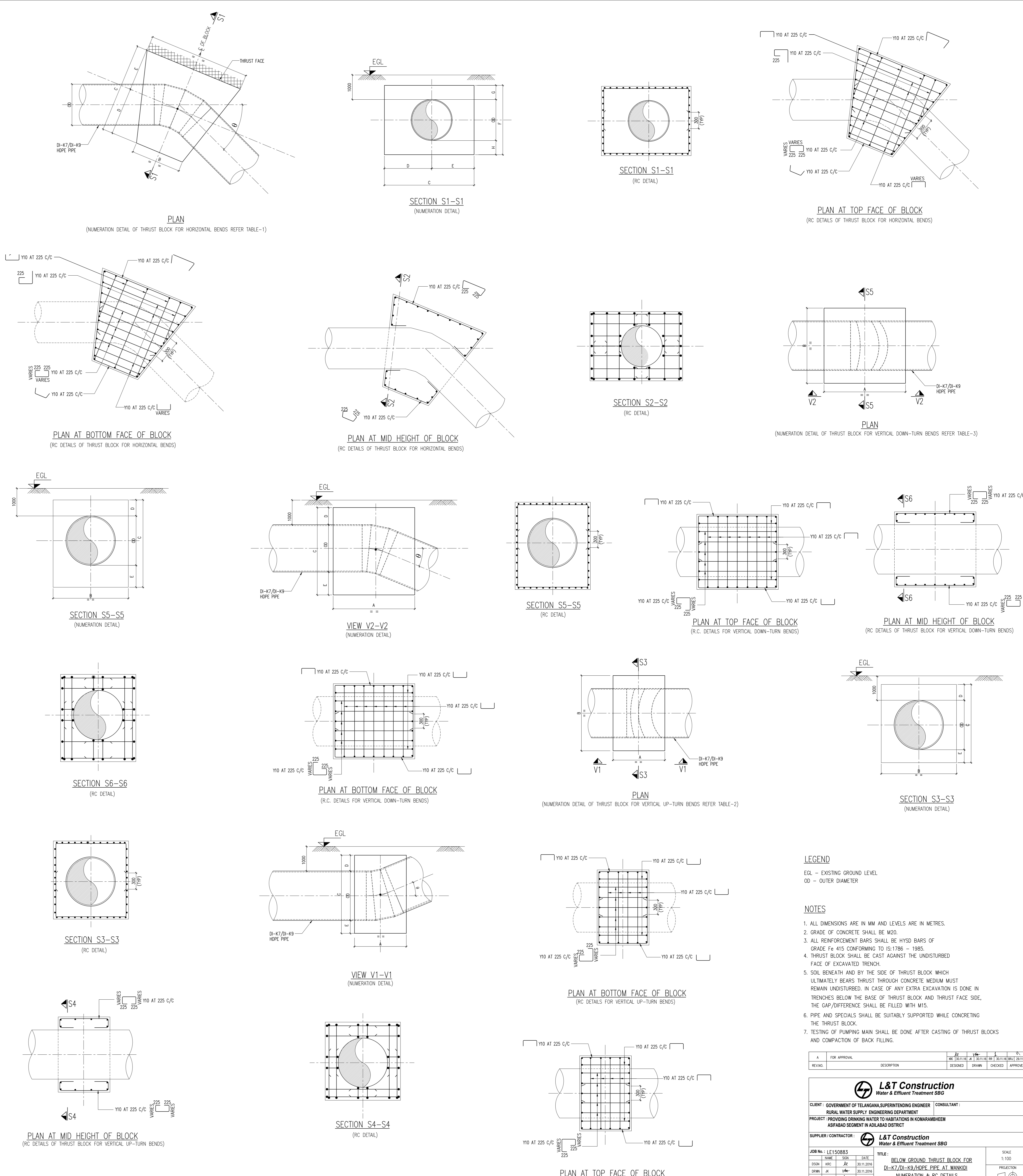
Horizontal bend for DI-K9 pipe										
Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	H (mm)		
150	170	11.25	300	150	1000	556	444	470	150	150
		22.5	550	250	1000	563	437	470	150	150
		45	1000	500	1000	556	444	520	175	175
		90	1700	550	1000	585	415	570	200	200
200	222	11.25	500	200	1000	571	429	522	150	150
		22.5	1000	400	1000	571	429	522	150	150
		45	1700	500	1000	591	409	572	175	175
		90	2150	600	1500	891	609	822	300	300
250	274	11.25	550	250	1000	563	437	574	150	150
		22.5	1050	550	1000	552	448	574	150	150
		45	1750	900	1400	775	625	624	175	175
		90	2150	1000	2500	1402	1098	874	300	300
300	326	11.25	825	400	1000	558	442	626	150	150
		22.5	1450	675	1400	785	615	676	175	175
		45	2350	700	1750	1033	717	776	225	225
		90	3450	750	2050	1245	805	976	325	325

TABLE - 2

Vertical upturn bend for DI-K9 pipe							
Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	E (mm)		
150	170	11.25	1000	500	470	150	150
		22.5	1000	500	470	150	150
		45	1000	500	470	150	150
		11.25	1000	550	522	150	150
200	222	22.5	1000	550	522	150	150
		45	1000	550	522	150	150
		11.25	1000	600	574	150	150
		22.5	1000	600	574	150	150
250	274	45	1000	600	574	150	150
		11.25	1000	650	626	150	150
		22.5	1000	650	626	150	150
		45	1200	775	626	150	150
300	326	11.25	1000	400	363	150	150
		22.5	1000	400	363	150	150
		45	1000	400	363	150	150
		11.25	1000	400	375	150	150
63	63	22.5	1000	400	363	150	150
		45	1000	400	363	150	150
		11.25	1000	400	375	150	150
		22.5	1000	400	375	150	150
75	75	22.5	1000	400	375	150	150
		45	1000	400	375	150	150
		11.25	1000	400	375	150	150
		22.5	1000	400	390	150	150
90	90	22.5	1000	400	390	150	150
		45	1000	400	390	150	150
		11.25	1000	400	390	150	150
		22.5	1000	400	390	150	150

TABLE - 3

Vertical downturn bend for DI-K9 pipe							
Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	E (mm)		
150	170	11.25	1000	500	470	150	150
		22.5	1000	500	470	150	150
		45	1000	500	470	150	150
		11.25	1000	550	522	150	150
200	222	22.5	1000	550	522	150	150
		45	1000	550	522	150	150
		11.25	1000	600	574	150	150
		22.5	1000	600	574	150	150
250	274	45	1000	600	574	150	150
		11.25	1000	650	626	150	150
		22.5	1000	650	626	150	150
		45	1200	775	626	150	150
300	326	11.25	1000	400	363	150	150
		22.5	1000	400	363	150	150
		45	1000	400	363	150	150
		11.25	1000	400	375	150	150
63	63	22.5	1000	400	363	150	150
		45	1000	400	363	150	150
		11.25	1000	400	375	150	150
		22.5	1000	400	375	150	150
75	75	22.5	1000	400	375	150	150
		45	1000	400	375	150	150
		11.25	1000	400	375	150	150
		22.5	1000	400	390	150	150
90	90	22.5	1000	400	390	150	150
		45	1000	400	390	150	150
		11.25	1000	400	390	150	150
		22.5	1000	400	390	150	150



Horizontal bend for HDPE pipe-8kg/cm2

Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	H (mm)		
63	63	11.25	300	175	1000	544	456	363	150	150
		22.5	500	350	1000	529	471	363	150	150
		45	700	450	1000	536	464	363	150	150
		90	1000	600	1000	542	458	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	1400	700	1050	583	467	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	1200	600	1100	611	489	390	150	150

Horizontal bend for HDPE pipe-8kg/cm2

Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	H (mm)		
63	63	11.25	300	175	1000	544	456	363	150	150
		22.5	500	350	1000	529	471	363	150	150
		45	600	325	1000	550	450	363	150	150
		90	700	325	1000	561	439	363	150	150
75	75	11.25	300	175	1000	544	456	375	150	150
		22.5	500	350	1000	529	471	375	150	150
		45	750	425	1000	546	454	375	150	150
		90	1200	650	1000	550	450	375	150	150
90	90	11.25	300	175	1000	544	456	390	150	150
		22.5	400	225	1000	547	453	390	150	150
		45	400	200	1000	556	444	390	150	150
		90	500	250	1000	556	444	390	150	150
110	110	11.25	300	200	1000	533	467	410	150	150
		22.5	400	225	1000	547	453	410	150	150
		45	500	200	1000	571	429	410	150	150
		90	800	250	1000	587	413	410	150	150

Horizontal bend for HDPE pipe-10kg/cm2

Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	H (mm)		
63	63	11.25	300	175	1000	544	456	363	150	150
		22.5	400	225	1000	547	453	363	150	150
		45	500	275	1000	548	452	363	150	150
		90	700	300	1000	567	433	363	150	150
75	75	11.25	300	175	1000	544	456	375	150	150
		22.5	550	325	1000	543	457	375	150	150
		45	600	325	1000	550	450	375	150	150
		90	1200	600	1000	556	444	375	150	150
90	90	11.25	300	150	1000	524	476	390	150	150
		22.5	300	175	1000	544	456	390	150	150
		45	300	150	1000	556	444	390	150	150
		90	450	200	1000	564	436	390	150	150
110	110	11.25	250	150	1000	542	458	410	150	150
		22.5	300	150	1000	556	444	410	150	150
		45	500	200	1000	571	429	410	150	150
		90	625	250	1000	571	429	410	150	150

Horizontal bend for HDPE pipe-10kg/cm2

Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	H (mm)		
63	63	11.25	300	175	1000	544	456	363	150	150
		22.5	400	225	1000	547	453	363	150	150
		45	500	275	1000	548	452	363	150	150
		90	700	300	1000	567	433	363	150	150
75	75	11.25	300	175	1000	544	456	375	150	150
		22.5	550	325	1000	543	457	375	150	150
		45	600	325	1000	550	450	375	150	150
		90	1200	600	1000	556	444	375	150	150
90	90	11.25	300	150	1000	524	476	390	150	150
		22.5	300	175	1000	544	456	390	150	150
		45	300	150	1000	556	444	390	150	150
		90	450	200	1000	564	436	390	150	150
110	110	11.25	250	150	1000	542	458	410	150	150
		22.5	300	150	1000	556	444	410	150	150
		45	500	200	1000	571	429	410	150	150
		90	625	250	1000	571	429	410	150	150

Horizontal bend for HDPE pipe-10kg/cm2

Pipe dia (mm)	Pipe OD (mm)	Angle (degrees)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	H (mm)		
63	63	11.25	300	175	1000	544	456	363	150	150
		22.5	400	225	1000	547	453	363	150	150
		45	500	275	1000	548	452	363	150	150
		90	700	300	1000	567	433	363	150	150
75	75	11.25	300	175	1000	544	456	375	150	150
		22.5	550	325	1000	543	457	375	150	150
		45	600	325	1000	550	450	375	150	150
		90	1200	600	1000	556	444	375	150	150
90	90	11.25	300	150	1000	524	476	390	150	150
		22.5	300	175	1000	544	456	390	150	150
		45	300	150	1000	556	444	390	150	150</