Bending

Standard single-pass tubular elements may be bent in an infinite variety of configurations. Utilizing the most up-to-date computer numerical control (CNC) bending equipment and techniques, INDEECO is able to produce an element to fit virtually any application.

Bends that are less than 2" center-to-center are normally repressed on unfinned elements to recompact the magnesium oxide insulation, eliminating hairline cracks that may develop during bending.

Figures A through T show some of the configurations frequently specified. For configurations not shown, submit a drawing or sketch of your requirements. Any of these are available either finned or unfinned.

Table V

Sheath Diameter (Inches)	Sheath Materials	Minimum Bending(1) (Inches)		Center-To-Center Dimensions (Inches) Available For Repressing Dies For 180° Bends
		Inside Radius	Center-To-Center Dimensions	
.312	Copper & Incoloy 800 304 SS	3/8 1/4	7/8 1	5/8, 11/16, 3/4, 1, 1-1/2, 2, 2-3/8, 2-1/2
.475 Unfinned	Copper, Steel & Incoloy 800 304 & 316 SS Inconel 600 & Monel 400	1/2 1/4 3/8	1-1/4 1 1-1/2	1, 1-1/16, 1-1/8, 1-1/4, 1-3/8, 1-1/2, 1-5/8, 1-3/4, 1-7/8, 2, 2-1/4, 2-1/2
.475 Finned	Steel 304 SS Monel 400		2 2 2	Not repressed. Bending dies are available in 1/8 increments from 2 through 3-1/2.

(1) Contact factory for requirements below minimum bending dimensions shown.

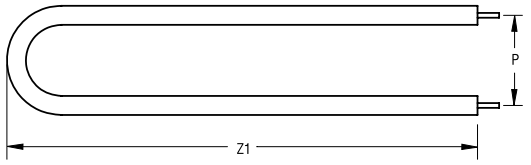


Figure A

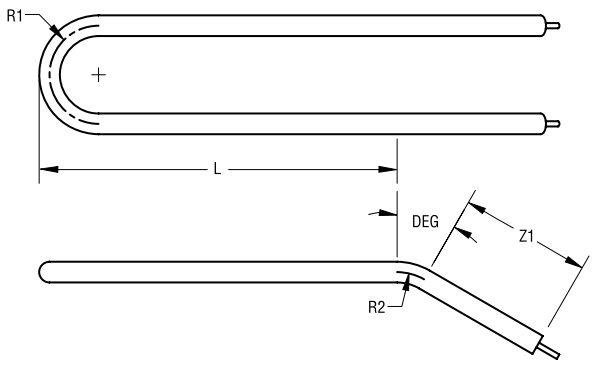
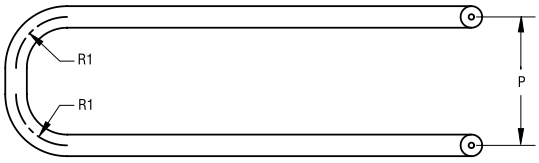


Figure B



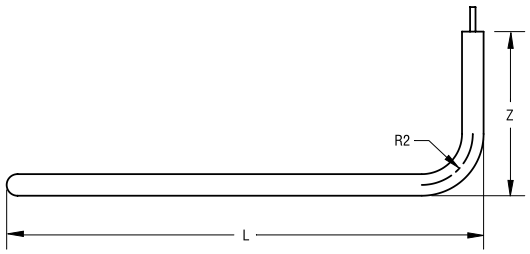


Figure C

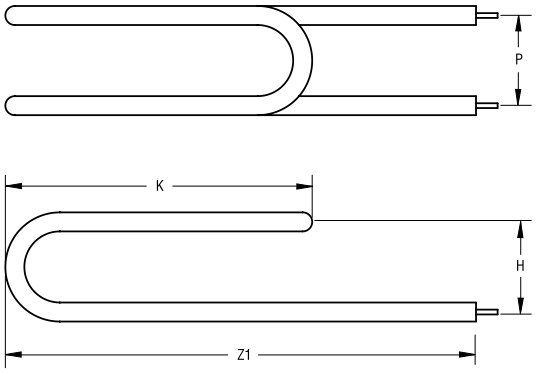


Figure D

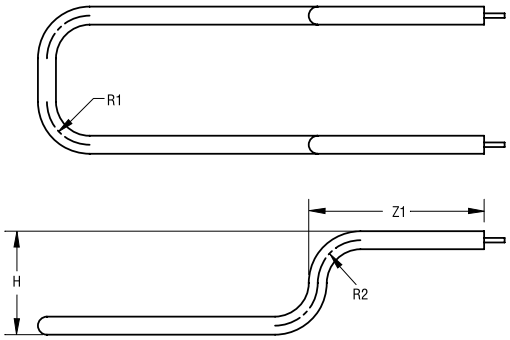


Figure G

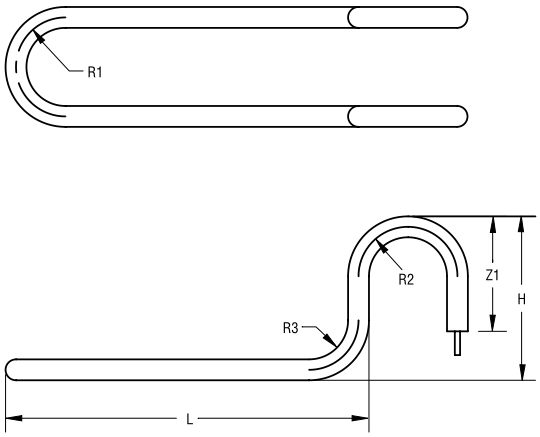


Figure E

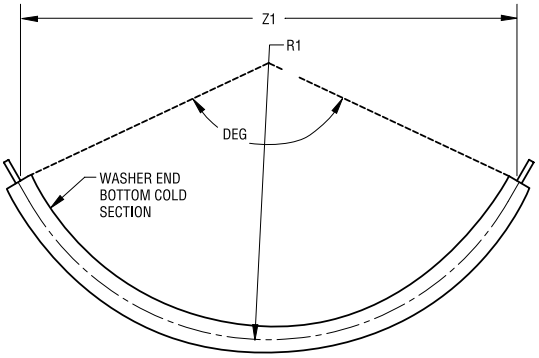


Figure H

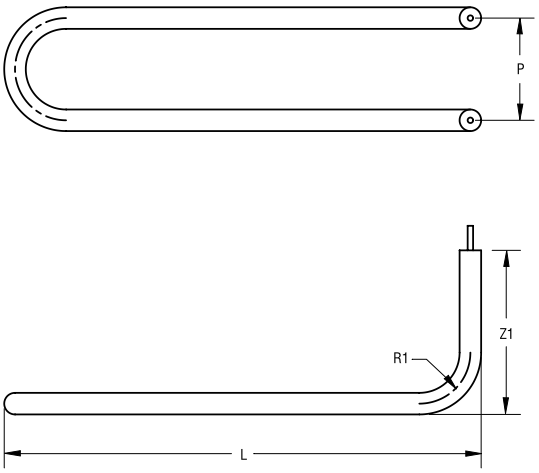


Figure F

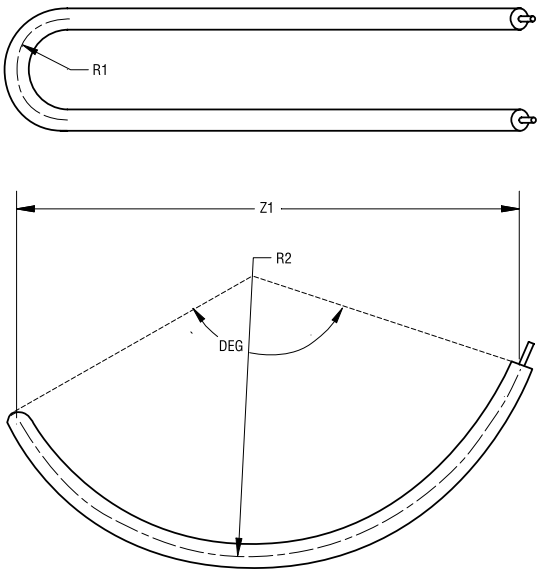


Figure I

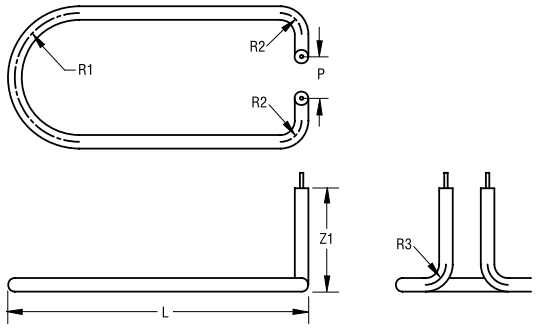


Figure J

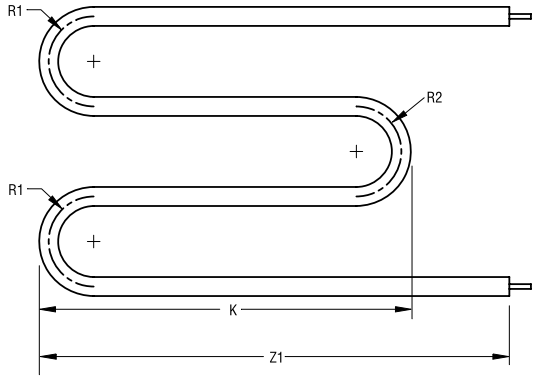


Figure K

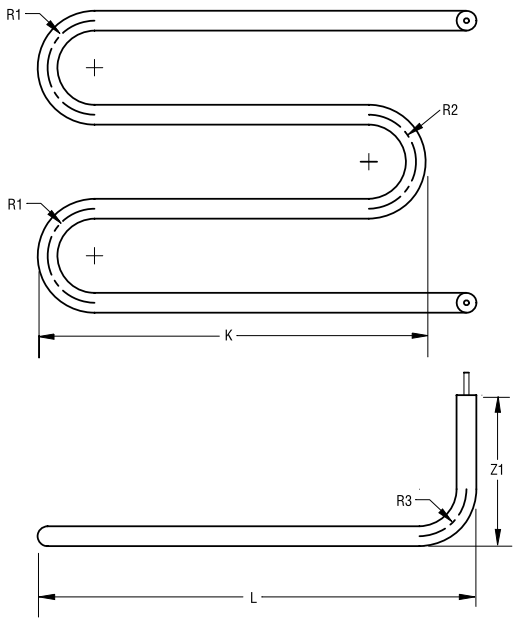


Figure L

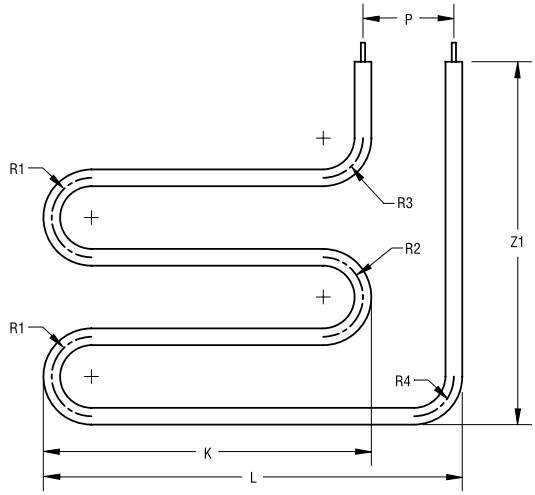


Figure M

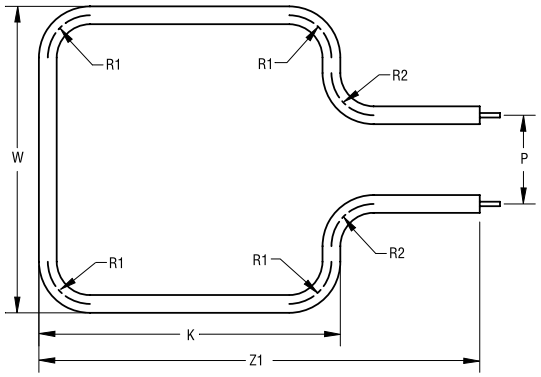


Figure N

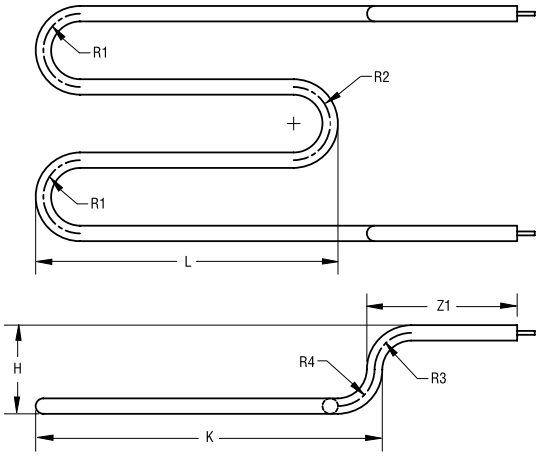


Figure O

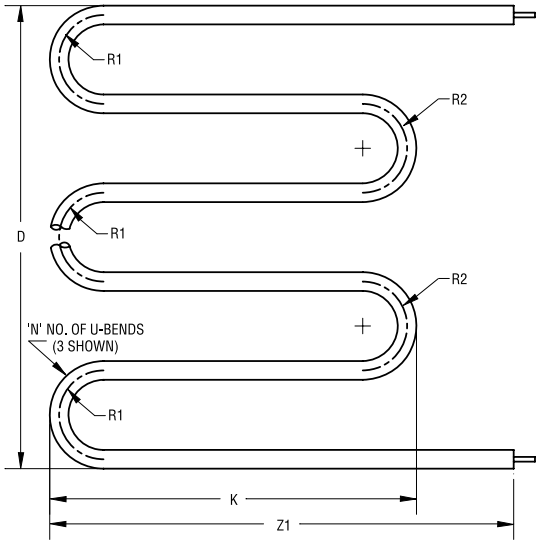


Figure P

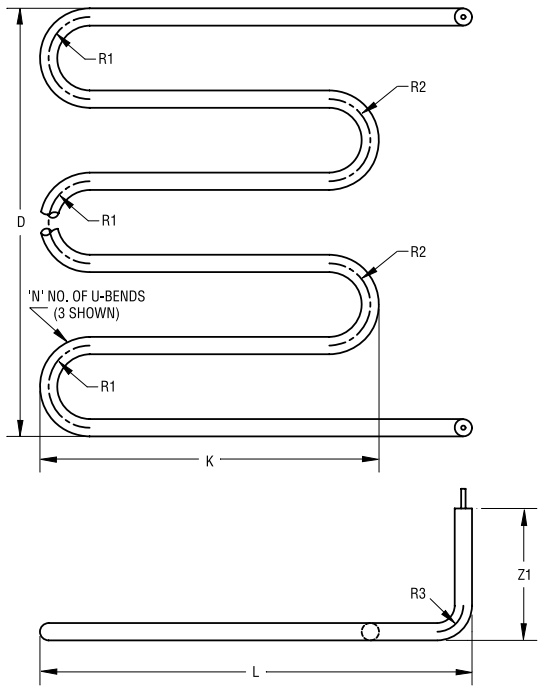


Figure Q

Note: Unheated section must not end in bend.

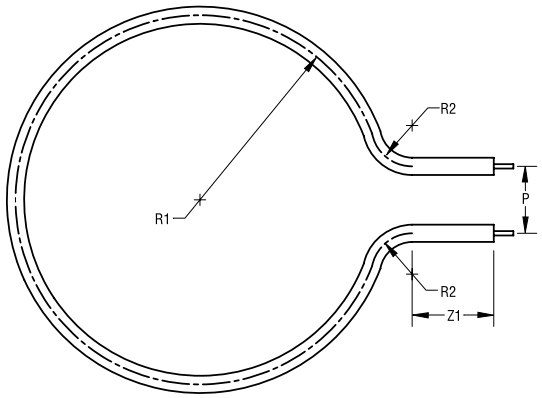


Figure R

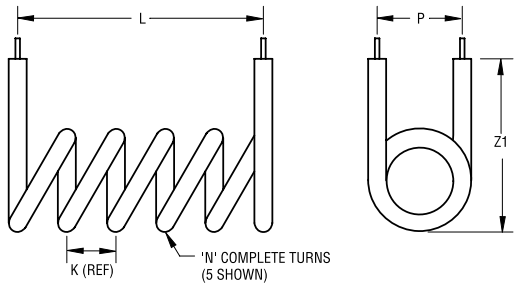


Figure S

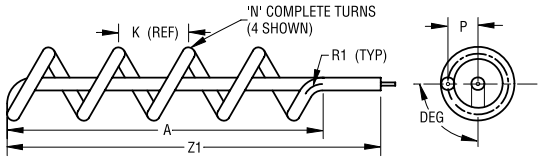


Figure T