ERCOLINA®

Beware of imitations

Innovative Ercolina Technology

- Tables for choosing formers and counterformers for bending machines without mandrel
- Tabelle di guida per la scelta delle matrici e contromatrici per macchine curvatubi senz'anima
- Tabellen für die Auswahl der Biegesegmente und Gleitschuhe für Biegemaschinen ohne Dorn
- Tableaux pour choisir matrices et contre-matrices pour cintreuses sans mandrin
- Cuadros para elegir matrices y contramatrices por curvadoras sin nùcleo

RINA QUACER CISQ ISO 9001

NUOVA CML S.r.l.

CONVERSION TABLE

TABLE IN MILLIMETRES CONVERTED TO DECIMAL INCHES

MM	DECIMAL INCH	MM	DECIMAL INCH	MM	DECIMAL INCH	MM	DECIMAL INCH
1	0.03937	29	1.14173	58	2.28346	86	3.38583
2	0.07874	30	1.18110	59	2.32283	87	3.42520
3	0.11811	31	1.22047	60	2.36220	88	3.46457
4	0.15748	32	1.25984	61	2.40157	89	3.50394
5	0.19685	33	1.29921	62	2.44094	90	3.54331
6	0.23622	34	1.33858	63	2.48031	91	3.58268
7	0.27559	35	1.37795	64	2.51969	92	3.62205
8	0.31496	36	1.41732	65	2.55906	93	3.66142
9	0.35433	37	1.45669	66	2.59843	94	3.70079
10	0.39370	38	1.49606	67	2.63780	95	3.74016
11	0.47244	39	1.53543	68	2.67717	96	3.77953
12	0.47244	40	1.57480	69	2.71654	97	3.81890
13	0.51181	42	1.61417	70	2.75591	98	3.85827
14	0.55118	43	1.69291	71	2.79520	99	3.89764
15	0.59055	44	1.73228	72	2.83465	100	3.937
16	0.62992	45	1.77165	73	2.87402	105	4.133
17	0.66929	46	1.81102	74	2.91339	112	4.409
18	0.70866	47	1.85039	75	2.95276	120	4.724
19	0.74803	48	1.88976	76	2.99213	130	5.118
20	0.78740	49	1.92913	77	3.03150	145	5.708
21	0.82677	50	1.96850	78	3.07087	150	5.906
22	0.86614	51	2.00787	79	3.11024	170	6.692
23	0.90551	52	2.04724	80	3.14961	175	6.889
24	0.94488	53	2.08661	81	3.18898	190	7.480
25	0.98425	54	2.12598	82	3.22835	225	8.858
26	1.02362	55	2.16535	83	3.26772	250	9.842
27	1.06299	56	2.20472	84	3.30709	275	10.827
28	1.10236	57	2.24409	85	3.34646	300	11.811

TABLE OF FRACTIONS OF AN INCH AND DECIMAL MILLIMETRES

FRACTION	DECIMAL INCH	MM	FRACTION	DECIMAL INCH	MM
1/64	0.0156	0.3969	33/64	0.5156	13.0969
1/32	0.0312	0.7938	17/32	0.5312	13.4938
3/64	0.0469	1.1906	35/64	0.5469	13.8906
3/16	0.0625	1.5875	9/16	0.5625	14.2875
5/64	0.0781	1.9844	37/64	0.5781	14.6844
3/32	0.938	2.3812	19/32	0.5938	15.0812
7/64	0.1094	2.7781	39/64	0.6094	15.4781
1/8	0.1250	3.1750	5/8	0.6250	15.8750
9/64	0.1406	3.5719	41/64	0.6409	16.2719
5/32	0.1562	3.9688	21/32	0.6562	16.6688
11/64	0.1719	4.3656	43/64	0.6719	17.0656
3/16	0.1875	4.7625	11/16	0.6875	17.4625
13/64	0.2031	5.1594	45/64	0.7031	17.8594
7/32	0.2188	5.5562	23/32	0.7188	18.2562
15/64	0.2344	5.9531	47/64	0.7344	18.6531
1/4	0.2500	6.3500	3/4	0.7500	19.0500
17/64	0.2656	6.7469	49/64	0.7656	19.4469
9/32	0.2812	7.1438	25/32	0.7812	19.8438
19/64	0.2969	7.5406	51/64	0.7969	20.2406
5/16	0.3125	7.9375	13/16	0.8125	20.6375
21/64	0.3281	8.3344	53/64	0.8281	21.0344
11/32	0.3438	8.7312	27/32	0.8438	21.4312
23/64	0.3594	9.1281	55/64	0.8594	21.8281
3/8	0.3750	9.5250	7/8	0.8750	22.2250
25/64	0.3906	9.9219	57/64	0.8906	22.6219
13/32	0.4062	10.3188	29/32	0.9062	23.0188
27/64	0.4219	10.7156	59/64	0.9219	23.4156
7/16	0.4375	11.1125	15/16	0.9375	23.8125
29/64	0.4531	11.5094	61/64	0.9531	24.2094
15/32	0.4688	11.9062	31/32	0.9688	24.6062
31/64	0.4844	12.3031	63/64	0.9844	25.0031
1/2	0.5000	12.7000	1	1.0000	25.4000

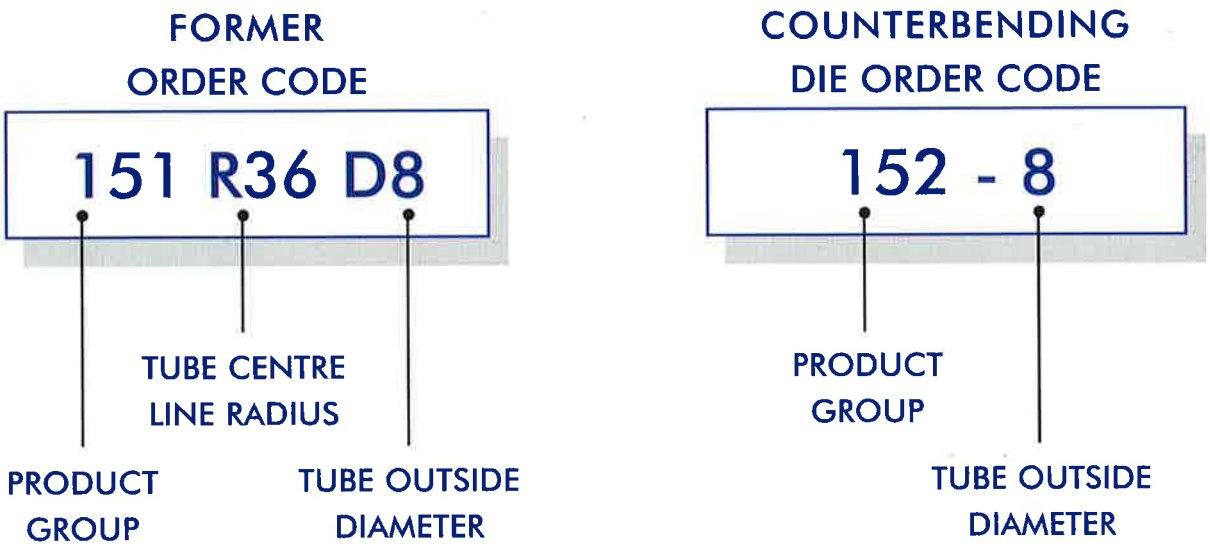
HOW TO READ THE TABLES

TUBE Ø THE OUTSIDE DIAMETER OF THE TUBE

BENDING RADIUS. CENTRE LINE BENDING RADIUS

MIN. THICKNESS. MINIMUM WALL THICKNESS OF THE TUBE NECESSARY TO OBTAIN THE SPECIFIED BENDING RADIUS
N.B.: LARGER THICKNESSES CAN BE USED UP TO THE MACHINE'S MAXIMUM FORCE (protected by overload device)

EXAMPLE: A TUBE with **Ø 8mm**, WALL THICKNESS 1 mm, CAN BE BENT WITH FORMER **151R36D8** AND COUNTERBENDING DIE **152-8**



HOW TO USE THE TABLE

TUBE Ø	Bend Radius R10-R30	Min Wall Thickness	Bend Radius R36	Min Wall Thickness	Bend Radius R46	Min Wall Thickness
5	●	1,2 mm 1,5 mm	151R36D5	1 mm	156R46D5	1 mm
6	●	1,2 mm 1,5 mm	151R36D6	1 mm	156R46D6	1 mm
8	●	1,2 mm 1,5 mm	151R36D8	1 mm	156R46D8	1 mm
10	●	1,2 mm 1,5 mm	151R36D10	1 mm	156R46D10	1 mm
12	●	1,5 mm	151R36D12	1 mm	156R46D12	1 mm

COME LEGGERE LE TABELLE

Ø TUBO — IL DIAMETRO ESTERNO DEL TUBO

RAGG. DI CURV. — IL RAGGIO DI CURVATURA (centro tubo)

SPESS. MIN. — SPESSORE MINIMO DEL TUBO NECESSARIO PER OTTENERE IL RAGGIO DI CURVATURA INDICATO.

NOTA: SPESSORI PIÙ ALTI POSSONO ESSERE USATI FINO ALLA MASSIMA CAPACITÀ DI FORZA DELLA MACCHINA (protetto dal dispositivo di sovraccarico).

ESEMPIO: UN TUBO **Ø 8 mm**, SPESSORE **1 mm**, PUÒ ESSERE CURVATO CON LA MATRICE **151R36D8** E CONTROMATRICE **152-8**

MATRICE
CODICE ORDINATIVO

151 R36 D8

RAGGIO CENTRO TUBO

GRUPPO PRODOTTO

DIAMETRO ESTERNO TUBO

ESEMPIO DI COME USARE LA TABELLA

Ø TUBO	Ragg. di Curv. R10-R30	Spess. Min.	Ragg. di Curv. R36	Spess. Min.	Ragg. di Curv. R46	Spess. Min.
5	●	1,2 mm 1,5 mm	151R36D5	1 mm	156R46D5	1 mm
6	●	1,2 mm 1,5 mm	151R36D6	1 mm	156R46D6	1 mm
8	●	1,2 mm 1,5 mm	151R36D8	1 mm	156R46D8	1 mm
10	●	1,2 mm 1,5 mm	151R36D10	1 mm	156R46D10	1 mm
12	●	1,5 mm	151R36D12	1 mm	156R46D12	1 mm

CONTROMATRICE
CODICE ORDINATIVO

152 - 8

GRUPPO PRODOTTO

DIAMETRO ESTERNO TUBO

WIE SIE DIE TABELLE LESEN

Ø ROHR — DER AUSSENDURCHMESSER DES ROHRS

BIEGERADIUS — RADIUS DER BIEGUNG (Rohrmitte)

MINDESTRADIUS — ZUM ERZIELEN DES ANGEGEBENEN BIEGERADIUS NOTWENDIGE WANDSTÄRKE DES ROHRS.

MERKE: GRÖSSERE WANDSTÄRKEN KÖNNEN BIS ZUR HÖCHSTLEISTUNG DER MASCHINE (geschützt durch die Überlastvorrichtung) VERWENDET WERDEN.

BEISPIEL: ROHR **Ø 8 mm**, MINDEST WANDSTÄRKE **1 mm**, KANN MIT DEM BIEGESEGMENT **151R36D8** UND DEM GLEITSCHUH **152-8** GEBOGEN WERDEN.

BESTELLNUMMER
BIEGESEGMENT

151 R36 D8

RADIUS ROHRMITTE

Art. Nr.

AUSSENROHRDURCH-MESSER ROHR

BEISPIEL DER VERWENDUNG DER TABELLE

Ø ROHR	Biegeradius R10-R30	Min. Wandstärke	Biegeradius R36	Min. Wandstärke	Biegeradius R46	Min. Wandstärke
5	●	1,2 mm 1,5 mm	151R36D5	1 mm	156R46D5	1 mm
6	●	1,2 mm 1,5 mm	151R36D6	1 mm	156R46D6	1 mm
8	●	1,2 mm 1,5 mm	151R36D8	1 mm	156R46D8	1 mm
10	●	1,2 mm 1,5 mm	151R36D10	1 mm	156R46D10	1 mm
12	●	1,5 mm	151R36D12	1 mm	156R46D12	1 mm

BESTELLNUMMER
GLEITSCHUH

152 - 8

Art. Nr.

AUSSENROHRDURCH-MESSER ROHR

COMMENT LIRE LES TABLEAUX

Ø TUBE LE DIAMETRE EXTERIEUR DU TUBE

RAYON DE CINTR. CENTRE LINE BENDING RADIUS

EPAISS. MIN. LE RAYON DE CINTRAGE A L'AXE DU TUBE EPAISSEUR MINIMUM DU TUBE NECESSAIRE POUR OBTENIR LE RAYON DE CINTRAGE INDIQUE.

NOTE: DES EPAISSEURS SUPERIEURES PEUVENT ETRE EMPLOYEES DANS LA LIMITE DE LA CAPACITE MAXIMUM DE LA MACHINE (protégée par le dispositif de surcharge).

FORME
CODE DE COMMANDE

151 R36 D8

RAYON A L'AXE

GROUPE PRODUIT

DIAMETRE EXTERIEUR

EXEMPLE : UN TUBE DE **Ø 8 mm**, EPAISSEUR **1mm**, PEUT ETRE CINTRE AVEC LA FORME **151R36D8** ET CONTRE-FORME **152-8**

EXEMPLE D'EMPLOI DU TABLEAU

Ø TUBO	Ragg. di Curv. R10-R30	Spess. Min.	Ragg. di Curv. R36	Spess. Min.	Ragg. di Curv. R46	Spess. Min.
5	●	1,2 mm 1,5 mm	151R36D5	1 mm	156R46D5	1 mm
6	●	1,2 mm 1,5 mm	151R36D6	1 mm	156R46D6	1 mm
8	●	1,2 mm 1,5 mm	151R36D8	1 mm	156R46D8	1 mm
10	●	1,2 mm 1,5 mm	151R36D10	1 mm	156R46D10	1 mm
12	●	1,5 mm	151R36D12	1 mm	156R46D12	1 mm

CONTREFORME
CODE DE COMMANDE

152 - 8

GROUPE PRODUIT

DIAMETRE EXTERIEUR

COMO LEER LAS TABLAS

Ø TUBO EL DIÁMETRO EXTERIOR DEL TUBO

RADIO DE CURV. RADIO DE CURVATURA (AL CENTRO DEL TUBO)

ESPES. MIN. ESPESOR MÍNIMO DEL TUBO NECESARIO PARA OBTENER EL RADIO DE CURVATURA INDICADO.

NOTA: LOS ESPESORES MAYORES PUEDEN SER UTILIZADOS HASTA LA MÁXIMA CAPACIDAD DE FUERZA DE LA MÁQUINA (protegido por el dispositivo de sobrecarga).

MATRIZ
CÓDIGO PARA ORDENAR

151 R36 D8

RADIO CENTRO TUBO

GRUPO PRODUCTO

DIAMETRO EXTERNO DEL TUBO

EJEMPLO: un tubo de **Ø 8 mm** ESPESOR: **1 mm** PUEDE SER PLEGADO CON LA MATRIZ **151R36D8** Y CONTRAMATRIZ **152-8**.

EJEMPLO DE CÓMO USAR LA TABLA

Ø TUBO	Radio de Curv. R10-R30	Espes. Mín.	Radio de Curv. R36	Espes. Mín.	Radio de Curv. R46	Espes. Mín.
5	●	1,2 mm 1,5 mm	151R36D5	1 mm	156R46D5	1 mm
6	●	1,2 mm 1,5 mm	151R36D6	1 mm	156R46D6	1 mm
8	●	1,2 mm 1,5 mm	151R36D8	1 mm	156R46D8	1 mm
10	●	1,2 mm 1,5 mm	151R36D10	1 mm	156R46D10	1 mm
12	●	1,5 mm	151R36D12	1 mm	156R46D12	1 mm

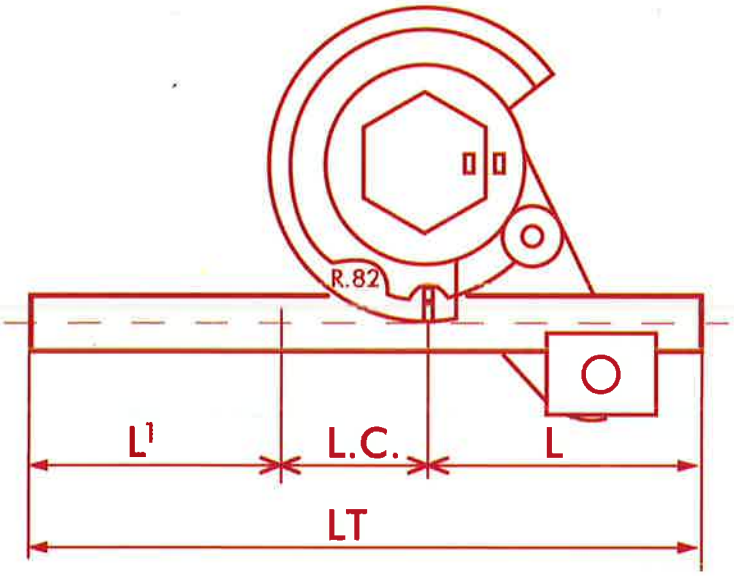
CONTRAMATRIZ
CÓDIGO PARA ORDENAR

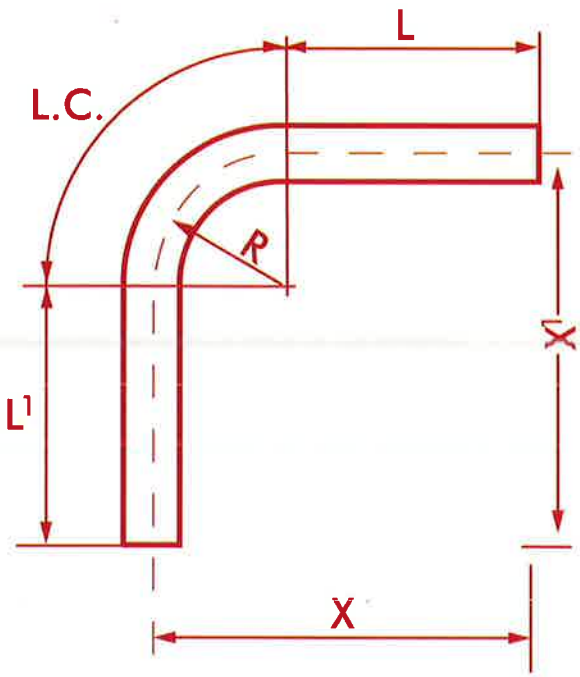
152 - 8

GRUPO PRODUCTO

DIAMETRO EXTERNO DEL TUBO

BENDING TO SIZE WITH THE PATENTED ERCOLINA® SYSTEM





$L.C. = \frac{2\ \pi\ x\ R}{360} .X° = L.C. =$ length of bend

R = former radius
X° = Bending angle in degrees
L.1 = X1 - R
L = X - R
The total bend length will be:

L.T. = L.C + L.1 + L

TYPICAL EXAMPLE OF A 90° BEND

R = 82
X = 200
X1 = 200
L = 118
L1 = 118
$L.C. = \frac{3,14 x 82}{2} = 128,8$

L.T. = 128,8 + 118 + 118 = 364,8

N.B.: - If distance "x" is not exact after making the bend, this may be due to the different technical characteristics of the tube and/or material elasticity, otherwise the tube may have been badly positioned at the entry to bending: in these cases distance L.C. has to be corrected.

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NOTE

TABELLA N° 1 DI RICERCA PER CODICI MATRICI E CONTROMATRICI

PER MACCHINE: MEDI BENDER® MB42 — SUPER BENDER® 060A — SUPER BENDER® SB48 — TOP BENDER® 050 — TOP BENDER® TB60-V2T — MEGABENDER VS76

Ø TUBO	Ragg. di Curv. R10-R30	Spess. Min.	Ragg. di Curv. R36	Spess. Min.	Ragg. di Curv. R46	Spess. Min.	Ragg. di Curv. R56	Spess. Min.	Ragg. di Curv. R67	Spess. Min.	Ragg. di Curv. R82	Spess Min.
5	●	1,2 mm 1,5 mm	151R36D5	1 mm	156R46D5	1 mm	156R56D5	1 mm	156R67D5	1 mm	156R82D5	1 mm
6	●	1,2 mm 1,5 mm	151R36D6	1 mm	156R46D6	1 mm	156R56D6	1 mm	156R67D6	1 mm	156R82D6	1 mm
8	●	1,2 mm 1,5 mm	151R36D8	1 mm	156R46D8	1 mm	156R56D8	1 mm	156R67D8	1 mm	156R82D8	1 mm
10	●	1,2 mm 1,5 mm	151R36D10	1 mm	156R46D10	1 mm	156R56D10	1 mm	156R67D10	1 mm	156R82D10	1 mm
12	●	1,5 mm	151R36D12	1 mm	156R46D12	1 mm	156R56D12	1 mm	156R67D12	1 mm	156R82D12	1 mm
13	●	1,5 mm	151R36D13	1 mm	156R46D13	1 mm	156R56D13	1 mm	156R67D13	1 mm	156R82D13	1 mm
14	●	2 mm	151R36D14	1,5 mm	151R46D14	1 mm	156R56D14	1 mm	156R67D14	1 mm	156R82D14	1 mm
15	●	2 mm	151R36D15	1,5 mm	151R46D15	1 mm	156R56D15	1 mm	156R67D15	1 mm	156R82D15	1 mm
16			151R36D16	1,5 mm	151R46D16	1 mm	156R56D16	1 mm	156R67D16	1 mm	156R82D16	1 mm
18			151R36D18	1,5 mm	151R46D18	1,5 mm	151R56D18	1 mm	151R67D18	1 mm	156R82D18	1 mm
19			151R36D19	2,5 mm	151R46D19	2 mm	151R56D19	1,5 mm	151R67D19	1 mm	156R82D19	1 mm
20					151R46D20	2 mm	151R56D20	1,5 mm	151R67D20	1 mm	156R82D20	1 mm
22					151R46D22	2 mm	151R56D22	1,5 mm	151R67D22	1 mm	156R82D22	1 mm
24							151R56D24	2 mm	151R67D24	1,5 mm	151R82D24	1 mm
25							151R56D25	2 mm	151R67D25	1,5 mm	151R82D25	1 mm
26							151R56D26	2 mm	151R67D26	1,5 mm	151R82D26	1 mm
28							151R56D28	2,5 mm	151R67D28	2 mm	151R82D28	1 mm
30									151R67D30	2,5 mm	151R82D30	2 mm
32									151R67D32	2,5 mm	151R82D32	2 mm
35											151R82D35	2 mm
38												
40												
42												
45												
48												
50												
55												
60												
64												
67												
70												
76												

151 MATRICI STANDARD IN ACCIAIO — **156** MATRICI SEMI STANDARD IN ACCIAIO

TABELLA N° 2 DI RICERCA PER CODICI MATRICI E CONTROMATRICI ACCIAIO

PER MACCHINE: MEGA BENDER MB42 · SUPER BENDER 060A · SUPER BENDER SB48 · TOP BENDER 050 · TOP BENDER TB60-V2T · MEGABENDER VS76

PER LE MATRICI SPECIALI DEL

∅ TUBO	Ragg. di Curv. R10-R30	Spess. Min.	Ragg. di Curv. R36	Spess. Min.	Ragg. di Curv. R46	Spess. Min.	Ragg. di Curv. R56	Spess. Min.	Ragg. di Curv. R67	Spess. Min.	Ragg. di Curv. R82	Spess. Min.	Ragg. di R90
5	●	1,2 mm 1,5 mm	151R36D5	1 mm	156R46D5	1 mm	156R56D5	1 mm	156R67D5	1 mm	156R82D5	1 mm	156R90D
6	●	1,2 mm 1,5 mm	151R36D6	1 mm	156R46D6	1 mm	156R56D6	1 mm	156R67D6	1 mm	156R82D6	1 mm	156R90D
8	●	1,2 mm 1,5 mm	151R36D8	1 mm	156R46D8	1 mm	156R56D8	1 mm	156R67D8	1 mm	156R82D8	1 mm	156R90D
10	●	1,2 mm 1,5 mm	151R36D10	1 mm	156R46D10	1 mm	156R56D10	1 mm	156R67D10	1 mm	156R82D10	1 mm	156R90D
12	●	1,5 mm	151R36D12	1 mm	156R46D12	1 mm	156R56D12	1 mm	156R67D12	1 mm	156R82D12	1 mm	156R90D
13	●	1,5 mm	151R36D13	1 mm	156R46D13	1 mm	156R56D13	1 mm	156R67D13	1 mm	156R82D13	1 mm	156R90D
14	●	2 mm	151R36D14	1,5 mm	151R46D14	1 mm	156R56D14	1 mm	156R67D14	1 mm	156R82D14	1 mm	156R90D
15			151R36D15	1,5 mm	151R46D15	1 mm	156R56D15	1 mm	156R67D15	1 mm	156R82D15	1 mm	156R90D
16			151R36D16	1,5 mm	151R46D16	1 mm	156R56D16	1 mm	156R67D16	1 mm	156R82D16	1 mm	156R90D
18			151R36D18	1,5 mm	151R46D18	1,5 mm	151R56D18	1 mm	151R67D18	1 mm	156R82D18	1 mm	156R90D
19			151R36D19	2,5 mm	151R46D19	2 mm	151R56D19	1,5 mm	151R67D19	1 mm	156R82D19	1 mm	156R90D
20					151R46D20	2 mm	151R56D20	1,5 mm	151R67D20	1 mm	156R82D20	1 mm	156R90D
22					151R46D22	2 mm	151R56D22	1,5 mm	151R67D22	1,2 mm	156R82D22	1 mm	156R90D
24											151R82D24	2 mm	156R90D
25											151R82D25	2 mm	151R90D
26											151R82D26	2 mm	156R90D
28											151R82D28	3 mm	156R90D
30													156R90D
32													156R90D
35													
38													
40													
42													
45													
48													
50													
55													
60													
64													
67													
70													
76													

151 MATRICI STANDARD IN ACCIAIO **156** MATRICI SEMI STANDARD IN ACCIAIO **157** MA

'ENIBILI	
)N)MATRICE	CON RULLO
R240	R300
R240	R300
R260	R300
R315	R380

SI RACCOMANDA DI USARE IL RULLO ART. 0501 INVECE DELLA CONTROMATRICE PER TUTTI I TUBI DI SPESSORE SUPERIORE A 4 mm

I RAGGI INDICATI SONO A CENTRO CURVA

Spess. Min.	Ragg. di Curv. R250	Spess. Min.	Ragg. di Curv. R260	Spess. Min.	Ragg. di Curv. R300	Spess. Min.	Ragg. di Curv. R301-380	∅ TUBO	CONTROMATRICI OTTONE	CONTROMATRICI PLASTICA
1 mm	157NR250D5	1 mm	157NR260D5	1 mm	157OR300D5	1 mm	●	5	152-5	—
1 mm	157NR250D6	1 mm	157NR260D6	1 mm	157OR300D6	1 mm	●	6	152-6	—
1 mm	157NR250D8	1 mm	157NR260D8	1 mm	157OR300D8	1 mm	●	8	152-8	—
1 mm	157NR250D10	1 mm	157NR260D10	1 mm	157OR300D10	1 mm	●	10	152-10	—
1 mm	157NR250D12	1 mm	157NR260D12	1 mm	157OR300D12	1 mm	●	12	152-12	152P-12
1 mm	157NR250D13	1 mm	157NR260D13	1 mm	157OR300D13	1 mm	●	13	152-13	152P-13
1 mm	157NR250D14	1 mm	157NR260D14	1 mm	157OR300D14	1 mm	●	14	152-14	152P-14
1 mm	157NR250D15	1 mm	157NR260D15	1 mm	157OR300D15	1 mm	●	15	152-15	152P-15
1 mm	157NR250D16	1 mm	157NR260D16	1 mm	157OR300D16	1 mm	●	16	152-16	152P-16
1 mm	157NR250D18	1 mm	157NR260D18	1 mm	157OR300D18	1 mm	●	18	152-18	152P-18
1 mm	157NR250D19	1 mm	157NR260D19	1 mm	157OR300D19	1 mm	●	19	152-19	152P-19
1 mm	157NR250D20	1 mm	157NR260D20	1 mm	157OR300D20	1 mm	●	20	152-20	152P-20
1 mm	157NR250D22	1 mm	157NR260D22	1 mm	157OR300D22	1 mm	●	22	152-22	152P-22
1 mm	157NR250D24	1 mm	157NR260D24	1 mm	157OR300D24	1 mm	●	24	152-24	—
1 mm	157NR250D25	1 mm	157NR260D25	1 mm	157OR300D25	1 mm	●	25	152-25	—
1 mm	157NR250D26	1 mm	157NR260D26	1 mm	157OR300D26	1 mm	●	26	152-26	—
1 mm	157NR250D28	1 mm	157NR260D28	1 mm	157OR300D28	1 mm	●	28	152-28	—
1 mm	157NR250D30	1 mm	157NR260D30	1 mm	157OR300D30	1 mm	●	30	152-30	—
1 mm	157NR250D32	1 mm	157NR260D32	1 mm	157OR300D32	1 mm	●	32	152-32	—
1 mm	157NR250D35	1 mm	157NR260D35	1 mm	157OR300D35	1 mm	●	35	152-35	—
1 mm	157NR250D38	1 mm	157NR260D38	1 mm	157OR300D38	1 mm	●	38	152-38	—
1 mm	157NR250D40	1 mm	157NR260D40	1 mm	157OR300D40	1 mm	●	40	152-40	—
1 mm	157NR250D42	1 mm	157NR260D42	1 mm	157OR300D42	1 mm	●	42	152-42	—
1 mm	157NR250D45	1,2 mm	157NR260D45	1 mm	157OR300D45	1 mm	●	45	152-45	—
1,2 mm	157NR250D48	1,2 mm	157NR260D48	1 mm	157OR300D48	1 mm	●	48	152-48	—
1,5 mm	157NR250D50	1,5 mm	157NR260D50	1 mm	157OR300D50	1 mm	●	50	152-50	—
1,5 mm	157NR250D55	1,5 mm	157NR260D55	1,2 mm	157OR300D55	1 mm	●	55	152-55	—
2 mm	157NR250D60	2 mm	157NR260D60	1,5 mm	157OR300D60	1,2 mm	●	60	152-60	—
2,5 mm	157QR250D64	2,5 mm	157QR260D64	2 mm	157RR300D64	2 mm	●	64	152-64	—
3 mm	157QR250D67	2,5 mm	157QR260D67	2,5 mm	157RR300D67	2 mm	●	67	152-67	—
3,5 mm	157QR250D70	3 mm	157QR260D70	3 mm	157RR300D70	2,5 mm	●	70	152-70	—
	157QR250D76	4 mm	157QR260D76	3 mm	157RR300D76	2,5 mm	●	76	152-76	—

MEDI BENDER® MB42

SUPER BENDER® 060A - SB48

TOP BENDER® 050 - TOP BENDER® TB60V2T

MEGABENDER VS76

ALCHE CASO DIPENDENDO DAL MATERIALE, ARE IL RIVENDITORE AUTORIZZATO. NCML

N.B.CONTROMATRICI PER RAME CRUDO: PER CURVARE QUESTO MATERIALE DI PARTICOLARE DIFFICOLTÀ, SONO NECESSARIE LE CONTROMATRICI SPECIALI IN OTTONE Art. 152/1 DA 5 mm A 54 mm

ACCIAIO ST37 O SIMILI

MISURE IN: mm

NOTA: RAGGI MASSIMI

CC

SUPER BENDER® 060/A - SB48
TOP BENDER® 050
MEDI BENDER® MB42
MEGABENDER VS76/ TOP BENDER® TB60

PER LE MATRICI SPECIALI DELLA MEDI BENDER® MB42/MB42P CONSULTARE IL CATALOGO A PAG. 30

Ragg. di Curv. R90	Spess. Min.	Ragg. di Curv. R100	Spess. Min.	Ragg. di Curv. R112	Spess. Min.	Raggio di Curv. R130	Spess. Min.	Ragg. di Curv. R150	Spess. Min.	Ragg. di Curv. R170	Spess. Min.	Ragg. di Curv. R190	Spess. Min.	Ragg. di R22
156R90D5	1 mm	156R100D5	1 mm	156R112D5	1 mm	156R130D5	1 mm	156R150D5	1 mm	156R170D5	1 mm	156R190D5	1 mm	157MR2
156R90D6	1 mm	156R100D6	1 mm	156R112D6	1 mm	156R130D6	1 mm	156R150D6	1 mm	156R170D6	1 mm	156R190D6	1 mm	157MR2
156R90D8	1 mm	156R100D8	1 mm	156R112D8	1 mm	156R130D8	1 mm	156R150D8	1 mm	156R170D8	1 mm	156R190D8	1 mm	157MR2
156R90D10	1 mm	156R100D10	1 mm	156R112D10	1 mm	156R130D10	1 mm	156R150D10	1 mm	156R170D10	1 mm	156R190D10	1 mm	157MR2
156R90D12	1 mm	156R100D12	1 mm	156R112D12	1 mm	156R130D12	1 mm	156R150D12	1 mm	156R170D12	1 mm	156R190D12	1 mm	157MR2
156R90D13	1 mm	156R100D13	1 mm	156R112D13	1 mm	156R130D13	1 mm	156R150D13	1 mm	156R170D13	1 mm	156R190D13	1 mm	157MR2
156R90D14	1 mm	156R100D14	1 mm	156R112D14	1 mm	156R130D14	1 mm	156R150D14	1 mm	156R170D14	1 mm	156R190D14	1 mm	157MR2
156R90D15	1 mm	156R100D15	1 mm	156R112D15	1 mm	156R130D15	1 mm	156R150D15	1 mm	156R170D15	1 mm	156R190D15	1 mm	157MR2
156R90D16	1 mm	156R100D16	1 mm	156R112D16	1 mm	156R130D16	1 mm	156R150D16	1 mm	156R170D16	1 mm	156R190D16	1 mm	157MR2
156R90D18	1 mm	156R100D18	1 mm	156R112D18	1 mm	156R130D18	1 mm	156R150D18	1 mm	156R170D18	1 mm	156R190D18	1 mm	157MR2
156R90D19	1 mm	156R100D19	1 mm	156R112D19	1 mm	156R130D19	1 mm	156R150D19	1 mm	156R170D19	1 mm	156R190D19	1 mm	157MR2
156R90D20	1 mm	156R100D20	1 mm	156R112D20	1 mm	156R130D20	1 mm	156R150D20	1 mm	156R170D20	1 mm	156R190D20	1 mm	157MR2
156R90D22	1 mm	156R100D22	1 mm	156R112D22	1 mm	156R130D22	1 mm	156R150D22	1 mm	156R170D22	1 mm	156R190D22	1 mm	157MR2
156R90D24	1 mm	156R100D24	1 mm	156R112D24	1 mm	156R130D24	1 mm	156R150D24	1 mm	156R170D24	1 mm	156R190D24	1 mm	157MR2
151R90D25	1 mm	156R100D25	1 mm	156R112D25	1 mm	156R130D25	1 mm	156R150D25	1 mm	156R170D25	1 mm	156R190D25	1 mm	157MR2
156R90D26	1 mm	156R100D26	1 mm	156R112D26	1 mm	156R130D26	1 mm	156R150D26	1 mm	156R170D26	1 mm	156R190D26	1 mm	157MR2
156R90D28	1 mm	151R100D28	1 mm	151R112D28	1 mm	156R130D28	1 mm	156R150D28	1 mm	156R170D28	1 mm	156R190D28	1 mm	157MR2
156R90D30	2 mm	151R100D30	2 mm	151R112D30	1 mm	156R130D30	1 mm	156R150D30	1 mm	156R170D30	1 mm	156R190D30	1 mm	157MR2
156R90D32	2 mm	156R100D32	2 mm	151R112D32	1 mm	156R130D32	1 mm	156R150D32	1 mm	156R170D32	1 mm	156R190D32	1 mm	157MR2
151R90D35	2 mm	156R100D35	2 mm	151R112D35	1 mm	156R130D35	1 mm	156R150D35	1 mm	156R170D35	1 mm	156R190D35	1 mm	157MR2
151R90D38	2,5 mm	151R100D38	2 mm	151R112D38	2 mm	151R130D38	1,5 mm	151R150D38	1,2 mm	151R170D38	1,2 mm	151R190D38	1 mm	157MR2
151R90D40	3 mm	151R100D40	2 mm	151R112D40	2 mm	151R130D40	1,5 mm	151R150D40	1,2 mm	151R170D40	1,2 mm	151R190D40	1 mm	157MR2
151R90D42	3 mm	151R100D42	2 mm	151R112D42	3 mm	151R130D42	1,5 mm	151R150D42	1,2 mm	151R170D42	1,2 mm	151R190D42	1 mm	157MR2
		151R100D45	3 mm			151R130D45	2,5 mm	151R150D45	2,5 mm	151R170D45	1,5 mm	156R190D45	1,2 mm	157MR2
		151R100D48	3 mm			151R130D48	2,5 mm	151R150D48	2,5 mm	151R170D48	2,5 mm	151R190D48	1,5 mm	157MR2
						151R130D50	3 mm	151R150D50	2,5 mm	151R170D50	2,5 mm	151R190D50	1,5 mm	157MR2
						151R130D55	3 mm	151R150D55	2,5 mm	156R170D55	2,5 mm	151R190D55	1,5 mm	157MR2
						151R130D60	3 mm	151R150D60	2,5 mm	156R170D60	2,5 mm	151R190D60	2 mm	157MR2
										156R170D64	3 mm	157PR190D64	3 mm	157PR22
												157PR190D67	3,5 mm	157PR22
												157PR190D70	4mm	157PR22

157 MATRICI SPECIALI A RICHIESTA IN ACCIAIO ● A RICHIESTA

I RAGGI INDICATI GARANTISCONO UN'OTTIMA QUALITÀ DI CURVA. I RAGGI LEGGERMENTE INFERIORI POTREBBERO ESSERE POSSIBILI - CO

NOX, RAME CRUDO E SIMILI

MISURE IN: mm

:DI BENDER® MB42/MB42P CONSULTARE IL CATALOGO A PAG. 30

NOTA: RAGGI MASSIMI OTTENIBILI

	CON CONTROMATRICE	CON RULLO
SUPER BENDER® 060/A - SB48	= R240	R300
TOP BENDER® 050	= R240	R300
MEDI BENDER® MB42	= R260	R300
MEGABENDER VS76/ TOP BENDER® TB60	= R315	R380

Spess. Min.	Ragg. di Curv. R100	Spess. Min.	Ragg. di Curv. R112	Spess. Min.	Raggio di Curv. R130	Spess. Min.	Ragg. di Curv. R150	Spess. Min.	Ragg. di Curv. R170	Spess. Min.	Ragg. di Curv. R190	Spess. Min.	Ragg. di Curv. R225	Spess. Min.
1 mm	156R100D5	1 mm	156R112D5	1 mm	156R130D5	1 mm	156R150D5	1 mm	156R170D5	1 mm	156R190D5	1 mm	157MR225D5	1 mm
1 mm	156R100D6	1 mm	156R112D6	1 mm	156R130D6	1 mm	156R150D6	1 mm	156R170D6	1 mm	156R190D6	1 mm	157MR225D6	1 mm
1 mm	156R100D8	1 mm	156R112D8	1 mm	156R130D8	1 mm	156R150D8	1 mm	156R170D8	1 mm	156R190D8	1 mm	157MR225D8	1 mm
1 mm	156R100D10	1 mm	156R112D10	1 mm	156R130D10	1 mm	156R150D10	1 mm	156R170D10	1 mm	156R190D10	1 mm	157MR225D10	1 mm
1 mm	156R100D12	1 mm	156R112D12	1 mm	156R130D12	1 mm	156R150D12	1 mm	156R170D12	1 mm	156R190D12	1 mm	157MR225D12	1 mm
1 mm	156R100D13	1 mm	156R112D13	1 mm	156R130D13	1 mm	156R150D13	1 mm	156R170D13	1 mm	156R190D13	1 mm	157MR225D13	1 mm
1 mm	156R100D14	1 mm	156R112D14	1 mm	156R130D14	1 mm	156R150D14	1 mm	156R170D14	1 mm	156R190D14	1 mm	157MR225D14	1 mm
1 mm	156R100D15	1 mm	156R112D15	1 mm	156R130D15	1 mm	156R150D15	1 mm	156R170D15	1 mm	156R190D15	1 mm	157MR225D15	1 mm
1 mm	156R100D16	1 mm	156R112D16	1 mm	156R130D16	1 mm	156R150D16	1 mm	156R170D16	1 mm	156R190D16	1 mm	157MR225D16	1 mm
1 mm	156R100D18	1 mm	156R112D18	1 mm	156R130D18	1 mm	156R150D18	1 mm	156R170D18	1 mm	156R190D18	1 mm	157MR225D18	1 mm
1 mm	156R100D19	1 mm	156R112D19	1 mm	156R130D19	1 mm	156R150D19	1 mm	156R170D19	1 mm	156R190D19	1 mm	157MR225D19	1 mm
1 mm	156R100D20	1 mm	156R112D20	1 mm	156R130D20	1 mm	156R150D20	1 mm	156R170D20	1 mm	156R190D20	1 mm	157MR225D20	1 mm
1 mm	156R100D22	1 mm	156R112D22	1 mm	156R130D22	1 mm	156R150D22	1 mm	156R170D22	1 mm	156R190D22	1 mm	157MR225D22	1 mm
1,5 mm	156R100D24	1 mm	156R112D24	1 mm	156R130D24	1 mm	156R150D24	1 mm	156R170D24	1 mm	156R190D24	1 mm	157MR225D24	1 mm
1,5 mm	156R100D25	1 mm	156R112D25	1 mm	156R130D25	1 mm	156R150D25	1 mm	156R170D25	1 mm	156R190D25	1 mm	157MR225D25	1 mm
1,5 mm	156R100D26	1 mm	156R112D26	1 mm	156R130D26	1 mm	156R150D26	1 mm	156R170D26	1 mm	156R190D26	1 mm	157MR225D26	1 mm
2,5 mm	151R100D28	2 mm	151R112D28	1 mm	156R130D28	1 mm	156R150D28	1 mm	156R170D28	1 mm	156R190D28	1 mm	157MR225D28	1 mm
2,5 mm	151R100D30	2 mm	151R112D30	2 mm	156R130D30	1 mm	156R150D30	1 mm	156R170D30	1 mm	156R190D30	1 mm	157MR225D30	1 mm
2,5 mm	156R100D32	2 mm	151R112D32	2 mm	156R130D32	1 mm	156R150D32	1 mm	156R170D32	1 mm	156R190D32	1 mm	157MR225D32	1 mm
	156R100D35	3 mm	151R112D35	2,5 mm	156R130D35	1 mm	156R150D35	1 mm	156R170D35	1 mm	156R190D35	1 mm	157MR225D35	1 mm
			151R112D38	2,5 mm	151R130D38	2 mm	151R150D38	1,5 mm	151R170D38	1,5 mm	151R190D38	1,2 mm	157MR225D38	1 mm
			151R112D40	3 mm	151R130D40	2 mm	151R150D40	2 mm	151R170D40	1,5 mm	151R190D40	1,2 mm	157MR225D40	1 mm
			151R112D42	3 mm	151R130D42	2 mm	151R150D42	2 mm	151R170D42	1,5 mm	151R190D42	1,2 mm	157MR225D42	1 mm
					151R130D45	2,5 mm	156R150D45	2,5 mm	151R170D45	2,5 mm	156R190D45	2 mm	157MR225D45	1,5 mm
					151R130D48	3 mm	151R150D48	3 mm	151R170D48	2,5 mm	151R190D48	2 mm	157MR225D48	2 mm
							151R150D50	3 mm	156R170D50	3 mm	151R190D50	2,5 mm	157MR225D50	2 mm
									156R170D55	3 mm	151R190D55	2,5 mm	157MR225D55	2,5 mm
									156R170D60	3 mm	151R190D60	2,5 mm	157MR225D60	2,5 mm
											157PR190D64	3,5 mm	157PR225D64	3,0 mm

:I SPECIALI A RICHIESTA ● A RICHIESTA

I RAGGI INDICATI GARANTISCONO UN'OTTIMA QUALITÀ DI CURVA. IN QUALCHE CASO DIPENDENDO DAL MATERIALE, RAGGI LEGGERMENTE INFERIORI POTREBBERO ESSERE POSSIBILI - CONTATTARE IL RIVENDITORE AUTORIZZATO. NCML

I RACCOMANDA DI USARE IL
ULLO ART. 050I INVECE DELLA
CONTROMATRICE CON TUTTI I TUBI
)I SPESSORE SUPERIORE A 4 mm

I RAGGI INDICATI SONO A CENTRO CURVA

Ragg. di Curv. R250	Spess. Min.	Ragg. di Curv. R260	Spess. Min.	Ragg. di Curv. R300	Spess. Min.	Ragg. di Curv. R301-380	∅ TUBO	CONTROMATRICI OTTONE	CONTROMATRICI PLASTICA
57NR250D5	1 mm	157NR260D5	1 mm	157OR300D5	1 mm	●	5	152-5	—
57NR250D6	1 mm	157NR260D6	1 mm	157OR300D6	1 mm	●	6	152-6	—
57NR250D8	1 mm	157NR260D8	1 mm	157OR300D8	1 mm	●	8	152-8	—
57NR250D10	1 mm	157NR260D10	1 mm	157OR300D10	1 mm	●	10	152-10	—
57NR250D12	1 mm	157NR260D12	1 mm	157OR300D12	1 mm	●	12	152-12	152P-12
57NR250D13	1 mm	157NR260D13	1 mm	157OR300D13	1 mm	●	13	152-13	152P-13
57NR250D14	1 mm	157NR260D14	1 mm	157OR300D14	1 mm	●	14	152-14	152P-14
57NR250D15	1 mm	157NR260D15	1 mm	157OR300D15	1 mm	●	15	152-15	152P-15
57NR250D16	1 mm	157NR260D16	1 mm	157OR300D16	1 mm	●	16	152-16	152P-16
57NR250D18	1 mm	157NR260D18	1 mm	157OR300D18	1 mm	●	18	152-18	152P-18
57NR250D19	1 mm	157NR260D19	1 mm	157OR300D19	1 mm	●	19	152-19	152P-19
57NR250D20	1 mm	157NR260D20	1 mm	157OR300D20	1 mm	●	20	152-20	152P-20
57NR250D22	1 mm	157NR260D22	1 mm	157OR300D22	1 mm	●	22	152-22	152P-22
57NR250D24	1 mm	157NR260D24	1 mm	157OR300D24	1 mm	●	24	152-24	—
57NR250D25	1 mm	157NR260D25	1 mm	157OR300D25	1 mm	●	25	152-25	—
57NR250D26	1 mm	157NR260D26	1 mm	157OR300D26	1 mm	●	26	152-26	—
57NR250D28	1 mm	157NR260D28	1 mm	157OR300D28	1 mm	●	28	152-28	—
57NR250D30	1 mm	157NR260D30	1 mm	157OR300D30	1 mm	●	30	152-30	—
57NR250D32	1 mm	157NR260D32	1 mm	157OR300D32	1 mm	●	32	152-32	—
57NR250D35	1 mm	157NR260D35	1 mm	157OR300D35	1 mm	●	35	152-35	—
57NR250D38	1 mm	157NR260D38	1 mm	157OR300D38	1 mm	●	38	152-38	—
57NR250D40	1 mm	157NR260D40	1 mm	157OR300D40	1 mm	●	40	152-40	—
57NR250D42	1 mm	157NR260D42	1 mm	157OR300D42	1 mm	●	42	152-42	—
57NR250D45	1,5 mm	157NR260D45	1 mm	157OR300D45	1 mm	●	45	152-45	—
57NR250D48	1,5 mm	157NR260D48	1,2 mm	157OR300D48	1 mm	●	48	152-48	—
57NR250D50	1,5 mm	157NR260D50	1,5 mm	157OR300D50	1,2 mm	●	50	152-50	—
57NR250D55	2,5 mm	157NR260D55	1,5 mm	157OR300D55	1,2 mm	●	55	152-55	—
57NR250D60	2,5 mm	157NR260D60	2 mm	157OR300D60	2 mm	●	60	152-60	—
57QR250D64	3 mm	157QR260D64	2,5 mm	157RR300D64	2 mm	●	64	152-64	—
57QR250D67	3 mm	157QR260D67	2,5 mm	157RR300D67	2 mm	●	67	152-67	—
		157QR260D70	3 mm	157RR300D70	2 mm	●	70	152-70	—
				157RR300D76	2 mm	●	76	152-76	—

MEDI BENDER® MB42

SUPER BENDER® 060A - SUPER BENDER® SB48

TOP BENDER® 050 - TOP BENDER® TB60

MEGABENDER VS76

N.B.CONTROMATRICI PER RAME CRUDO: PER CURVARE QUESTO MATERIALE DI PARTICOLARE DIFFICOLTÀ, SONO NECESSARIE LE CONTROMATRICI SPECIALI IN OTTONE Art. 152/1 DA 5 mm A 54 mm

TABELLA N° 3 DI RICERCA PER CODICI MATRICI E CONTROMATRICI

PER MACCHINE: MEDI BENDER® MB42 — SUPER BENDER® 060A — SUPER BENDER® SB48 — TOP BENDER® 050 — TOP BENDER® TB60-V2T — MEGABENDER VS76

∅ TUBO	Ragg. di Curv. R10- R30	Spess. Min.	Ragg. di Curv. R36	Spess. Min.	Ragg. di Curv. R46	Spess. Min.	Ragg. di Curv. R56	Spess. Min.	Ragg. di Curv. R67	Spess. Min.	Ragg. di Curv. R82	Spess. Min.
1/4"OD-6,30	●	1,2 mm	153R36D1/4"	1 mm	156R46D1/4" O.D.	1 mm	156R56D1/4" O.D.	1 mm	156R67D1/4" O.D.	1 mm	156R82D1/4" O.D.	1 mm
3/8"OD-9,52	●	1,5 mm	153R36D3/8"	1 mm	156R46D3/8" O.D.	1 mm	156R56D3/8" O.D.	1 mm	156R67D3/8" O.D.	1 mm	156R82D3/8" O.D.	1 mm
1/2"OD-12,70	●	1,5 mm	153R36D1/2"	1 mm	156R46D1/2" O.D.	1 mm	156R56D1/2" O.D.	1 mm	156R67D1/2" O.D.	1 mm	156R82D1/2" O.D.	1 mm
5/8"OD-15,88			153R36D5/8"	2 mm	153R46D5/8"	1 mm	156R56D5/8" O.D.	1 mm	156R67D5/8" O.D.	1 mm	156R82D5/8" O.D.	1 mm
3/4"OD-19,05					153R46D3/4"	2,5 mm	153R56D3/4"	1,5 mm	153R67D3/4"	1 mm	156R82D3/4" O.D.	1 mm
7/8"OD-22,22					153R46D7/8"	2 mm	153R56D7/8"	1,5 mm	153R67D7/8"	1 mm	156R82D7/8" O.D.	1 mm
1"OD-25,40							153R56D1"	2 mm	153R67D1"	1,5 mm	153R82D1"	1 mm
1 1/8"OD-28,58							153R56D1 1/8"	2,5 mm	153R67D1 1/8"	2 mm	153R82D1 1/8"	1 mm
1 1/4"OD-31,75									153R67D1 1/4"	2,5 mm	153R82D1 1/4"	2 mm
1 3/8"OD-34,92											153R82D1 3/8"	2 mm
1 1/2"OD-38,10												
1 5/8"OD-41,28												
1 3/4"OD-44,45												
1 7/8"OD-47,62												
2"OD-50,80												
2 1/8"OD-53,97												
2 1/4"OD-57,15												
2 3/8"OD-60,32												
3"OD-76												

NOTA IMPORTANTE: LE MISURE 2 1/2" O.D. (63,51mm), 2 5/8" O.D. (66,67mm), 2 3/4" O.D. (68,87mm) e 2 7/8" O.D. (73,1mm

153 MATRICI STANDARD IN ACCIAIO — **153/1** MATRICI STANDARD GAS IN ACCIAIO

∅ TUBO	Ragg. di Curv. R10-R30	Spess. Min.	Ragg. di Curv. R36	Spess. Min.	Ragg. di Curv. R46	Spess. Min.	Ragg. di Curv. R56	Spess. Min.	Ragg. di Curv. R67	Spess. Min.	Ragg. di Curv. R82	Spess. Min.
1/4"GAS-13,25	●	1,5 mm	153/1R36D1/4"	1 mm	156R46D1/4"G	1 mm	156R56D1/4"G	1 mm	156R67D1/4"G	1 mm	156R82D1/4"G	1 mm
3/8"GAS-17,2			153/1R36D3/8"	1,5 mm	156R46D3/8"G	1,5 mm	153/1R56D3/8"	1 mm	156R67D3/8"G	1 mm	156R82D3/8"G	1 mm
1/2"GAS-21,3					153/1R46D1/2"	2,5 mm	153/1R56D1/2"	2 mm	153/1R67D1/2"G	1 mm	156R82D1/2"G	1 mm
3/4"GAS-26,9							153/1R56D3/4"	2,5 mm	153/1R67D3/4"	2 mm	153/1R82D3/4"	1 mm
1"GAS-33,7									153/1R67D1"	2,5 mm	153/1R82D1"	2 mm
1 1/4"GAS-42,25												
1 1/2"GAS-48,25												
2"GAS-60,3												
2 1/2"P-73												
2 1/2"GAS-76												

TABELLA N° 4 DI RICERCA PER CODICI MATRICI E CONTROMATRICI ACCIA

PER MACCHINE: MEDI BENDER® MB42 — SUPER BENDER® 060A — SUPER BENDER® SB48 — TOP BENDER® 050 — TOP BENDER® TB60-V2T — MEGABENDER VS76

MI

PER LE MATRICI SPECIALI D

Ø TUBO	Ragg. di Curv. R10- R30	Spess. Min.	Ragg. di Curv. R36	Spess. Min.	Ragg. di Curv. R46	Spess. Min.	Ragg. di Curv. R56	Spess. Min.	Ragg. di Curv. R67	Spess. Min.	Ragg. di Curv. R82	Spess. Min.	Ragg. di R9
1/4"OD-6,30	●	1,2 mm	153R36D1/4"	1 mm	156R46D1/4" O.D.	1 mm	156R56D1/4" O.D.	1 mm	156R67D1/4" O.D.	1 mm	156R82D1/4" O.D.	1 mm	156R90D
3/8"OD-9,52	●	1,5 mm	153R36D3/8"	1 mm	156R46D3/8" O.D.	1 mm	156R56D3/8" O.D.	1 mm	156R67D3/8" O.D.	1 mm	156R82D3/8" O.D.	1 mm	156R90D
1/2"OD-12,70	●	1,5 mm	153R36D1/2"	1 mm	156R46D1/2" O.D.	1 mm	156R56D1/2" O.D.	1 mm	156R67D1/2" O.D.	1 mm	156R82D1/2" O.D.	1 mm	156R90D
5/8"OD-15,88			153R36D5/8"	2 mm	153R46D5/8"	1 mm	156R56D5/8" O.D.	1 mm	156R67D5/8" O.D.	1 mm	156R82D5/8" O.D.	1 mm	156R90D
3/4"OD-19,05					153R46D3/4"	2,5 mm	153R56D3/4"	1,5 mm	153R67D3/4"	1 mm	156R82D3/4" O.D.	1 mm	156R90D
7/8"OD-22,22					153R46D7/8"	2 mm	153R56D7/8"	1,5 mm	153R67D7/8"	1 mm	156R82D7/8" O.D.	1 mm	156R90D
1"OD-25,40											153R82D1"	2 mm	153R90D
1 1/8"OD-28,58													156R90D1
1 1/4"OD-31,75													156R90D1
1 3/8"OD-34,92													
1 1/2"OD-38,10													
1 5/8"OD-41,28													
1 3/4"OD-44,45													
1 7/8"OD-47,62													
2"OD-50,80													
2 1/8"OD-53,97													
2 3/8"OD-60,32													
3"OD-76													

NOTA IMPORTANTE: LE MISURE 2 1/2" O.D. (63,51mm), 2 5/8" O.D. (66,67mm), 2 3/4" O.D. (68,87mm) e 2 7/8" O.D. (73,1mm), SONO DI

153 MATRICI STANDARD IN ACCIAIO — **153/1** MATRICI STANDARD GAS IN ACCIAIO — **156**

Ø TUBO	Ragg. di Curv. R10-R30	Spess. Min.	Ragg. di Curv. R36	Spess. Min.	Ragg. di Curv. R46	Spess. Min.	Ragg. di Curv. R56	Spess. Min.	Ragg. di Curv. R67	Spess. Min.	Ragg. di Curv. R82	Spess. Min.	Ragg. di C R90
1/4"GAS-13,25	●	1,5 mm	153/1R36D1/4"	1 mm	156R46D1/4"G	1 mm	156R56D1/4"G	1 mm	156R67D1/4"G	1 mm	156R82D1/4"G	1 mm	156R90D1
3/8"GAS-17,2			153/1R36D3/8"	1,5 mm	156R46D3/8"G	1 mm	153/1R56D3/8"	1 mm	156R67D3/8"G	1 mm	156R82D3/8"G	1 mm	156R90D3
1/2"GAS-21,3					153/1R46D1/2"	2,5 mm	153/1R56D1/2"	2 mm	153/1R67D1/2"	1 mm	156R82D1/2"G	1 mm	156R90D1
3/4"GAS-26,9											153/1R82D3/4"	2 mm	156R90D3
1"GAS-33,7													
1 1/4"GAS-42,25													
1 1/2"GAS-48,25													
2"GAS-60,3													
2 1/2"P-73													
2 1/2"GAS-76													

I RAGGI INDICATI GARANTISCONO UN'OTTIMA QUALITÀ DI CURVA. IN QUALCHE CASO DIPENDENDO DAL MATERIALE, RAGGI LEGGERMENTE INFERIORI POTR

ENIBILI	
N MATRICE	CON RULLO
R240	R300
R240	R300
R260	R300
R315	R380

SI RACCOMANDA DI USARE IL RULLO ART. 0501 INVECE DELLA CONTROMATRICE CON TUTTI I TUBI DI SPESSORE SUPERIORE A 4 mm

I RAGGI INDICATI SONO A CENTRO CURVA

Spess. Min.	Ragg. di Curv. R250	Spess. Min.	Ragg. di Curv. R260	Spess. Min.	Ragg. di Curv. R300	Spess. Min.	Ragg. di Curv. R301-380	∅ TUBO	CONTROMATRICI OTTONE	CONTROMATRICI PLASTICA
1 mm	157NR250D1/4" O.D.	1 mm	157NR260D1/4" O.D.	1 mm	157OR300D1/4" O.D.	1 mm	●	1/4"OD-6,30	154-1/4"	—
1 mm	157NR250D3/8" O.D.	1 mm	157NR260D3/8" O.D.	1 mm	157OR300D3/8" O.D.	1 mm	●	3/8"OD-9,52	154-3/8"	—
1 mm	157NR250D1/2" O.D.	1 mm	157NR260D1/2" O.D.	1 mm	157OR300D1/2" O.D.	1 mm	●	1/2"OD-12,70	154-1/2"	154P-1/2"
1 mm	157NR250D5/8" O.D.	1 mm	157NR260D5/8" O.D.	1 mm	157OR300D5/8" O.D.	1 mm	●	5/8"OD-15,88	154-5/8"	154P-5/8"
1 mm	157NR250D3/4" O.D.	1 mm	157NR260D3/4" O.D.	1 mm	157OR300D3/4" O.D.	1 mm	●	3/4"OD-19,05	154-3/4"	154P-3/4"
1 mm	157NR250D7/8" O.D.	1 mm	157NR260D7/8" O.D.	1 mm	157OR300D7/8" O.D.	1 mm	●	7/8"OD-22,22	154-7/8"	154P-7/8"
1 mm	157NR250D1" O.D.	1 mm	157NR260D1" O.D.	1 mm	157OR300D1" O.D.	1 mm	●	1"OD-25,40	154-1"	—
1 mm	157NR250D11/8" O.D.	1 mm	157NR260D11/8" O.D.	1 mm	157OR300D11/8" O.D.	1 mm	●	1 1/8"OD-28,58	154-1 1/8"	—
1 mm	157NR250D1 1/4" O.D.	1 mm	157NR260D1 1/4" O.D.	1 mm	157OR300D1 1/4" O.D.	1 mm	●	1 1/4"OD-31,75	154-1 1/4"	—
1 mm	157NR250D1 3/8" O.D.	1 mm	157NR260D1 3/8" O.D.	1 mm	157OR300D1 3/8" O.D.	1 mm	●	1 3/8"OD-34,92	154-1 3/8"	—
1 mm	157NR250D1 1/2" O.D.	1 mm	157NR260D1 1/2" O.D.	1 mm	157OR300D1 1/2" O.D.	1 mm	●	1 1/2"OD-38,10	154-1 1/2"	—
1 mm	157NR250D1 5/8" O.D.	1 mm	157NR260D1 5/8" O.D.	1 mm	157OR300D1 5/8" O.D.	1 mm	●	1 5/8"OD-41,28	154-1 5/8"	—
1,2 mm	157NR250D1 3/4" O.D.	1,2 mm	157NR260D1 3/4" O.D.	1 mm	157OR300D1 3/4" O.D.	1 mm	●	1 3/4"OD-44,45	154-1 3/4"	—
1,2 mm	157NR250D1 7/8" O.D.	1,2 mm	157NR260D1 7/8" O.D.	1 mm	157OR300D1 7/8" O.D.	1 mm	●	1 7/8"OD-47,62	154-1 7/8"	—
1,5 mm	157NR250D2" O.D.	1,5 mm	157NR260D2" O.D.	1 mm	157OR300D2" O.D.	1 mm	●	2"OD-50,80	154-2"	—
1,5 mm	157NR250D2 1/8" O.D.	1,5 mm	157NR260D2 1/8" O.D.	1 mm	157OR300D2 1/8" O.D.	1 mm	●	2 1/8"OD-53,97	154-2 1/8"	—
1,5 mm	157NR250D2 1/4" O.D.	1,5 mm	157NR260D2 1/4" O.D.	1,2 mm	157OR300D2 1/4" O.D.	1 mm	●	2 1/4"OD-57,15	154-2 1/4"	—
2 mm	157NR250D2 3/8" O.D.	2 mm	157NR260D2 3/8" O.D.	1,5 mm	157OR300D2 3/8" O.D.	1,2 mm	●	2 3/8"OD-60,32	154-2 3/8"	—
	157QR250D3" O.D.	4 mm	157QR260D3" O.D.	3 mm	157RR300D3" O.D.	2 mm	●	3"OD-76	154-3"	—

MEDI BENDER® MB42 - SUPER BENDER® 060A - SUPER BENDER® SB48 - TOP BENDER® 050 - TOP BENDER® TB60 - MEGABENDER VS76

I RAGGI INDICATI GARANTISCONO UN'OTTIMA QUALITÀ DI CURVA. IN QUALCHE CASO DIPENDENDO DAL MATERIALE, RAGGI LEGGERMENTE INFERIORI POTREBBERO ESSERE POSSIBILI - CONTATTARE IL RIVENDITORE AUTORIZZATO. NCML

Spess. Min.	Ragg. di Curv. R250	Spess. Min.	Ragg. di Curv. R260	Spess. Min.	Ragg. di Curv. R300	Spess. Min.	Ragg. di Curv. R301-380	∅ TUBO	CONTROMATRICI OTTONE	CONTROMATRICI ACCIAIO
"G 1 mm	157NR250D1/4"G	1 mm	157NR260D1/4"G	1 mm	157OR300D1/4"G	1 mm	●	1/4"GAS-13,25	155-1/4"	—
"G 1 mm	157NR250D3/8"G	1 mm	157NR260D3/8"G	1 mm	157OR300D3/8"G	1 mm	●	3/8"GAS-17,2	155-3/8"	—
"G 1 mm	157NR250D1/2"G	1 mm	157NR260D1/2"G	1 mm	157OR300D1/2"G	1 mm	●	1/2"GAS-21,3	155-1/2"	—
"G 1 mm	157NR250D3/4"G	1 mm	157NR260D3/4"G	1 mm	157OR300D3/4"G	1 mm	●	3/4"GAS-26,9	155-3/4"	—
1 mm	157NR250D1"G	1 mm	157NR260D1"G	1 mm	157OR300D1"G	1 mm	●	1"GAS-33,7	155-1"	155A-1"
"G 1 mm	157MR250D1 1/4"G	1 mm	157NR260D1 1/4"G	1 mm	157OR300D1 1/4"G	1 mm	●	1 1/4"GAS-42,25	155-1 1/4"	155A-1 1/4"
"G 1,2 mm	157MR250D1 1/2"G	1,2 mm	157NR260D1 1/2"G	1 mm	157OR300D1 1/2"G	1 mm	●	1 1/2"GAS-48,25	155-1 1/2"	155A-1 1/2"
2 mm	157MR250D2"G	2 mm	157NR260D2"G	1,5 mm	157OR300D2"G	1 mm	●	2"GAS-60,3	155-2"	155A-2"
	157QR250D2 1/2"P	4 mm	157QR260D2 1/2"P	2,5 mm	157RR300D2 1/2"P	2 mm	●	2 1/2"P-73	155-2 1/2"P	—
	157QR250D2 1/2"G	4 mm	157QR260D2 1/2"G	2,5 mm	157RR300D2 1/2"G	2 mm	●	2 1/2"GAS-76	155-2 1/2"	—

MB 42 - SUPER BENDER® 060A -SB48 - TOP BENDER® 050 - TOP BENDER® TB60 - MEGABENDER VS76

ACCIAIO ST37 O SIMILI

MISURE IN: pollici O.D. - pollici GAS

NOTA: RAGGI MASSIMI

CC

SUPER BENDER® 060/A - SB48
TOP BENDER® 050
MEDI BENDER® MB42
MEGABENDER VS76/ TOP BENDER® TB6C

PER LE MATRICI SPECIALI DELLA MEDI BENDER® MB42/MB42P CONSULTARE IL CATALOGO A PAG. 30

Ragg. di Curv. R90	Spess. Min.	Ragg. di Curv. R100	Spess. Min.	Ragg. di Curv. R112	Spess. Min.	Raggio di Curv. R130	Sposs. Min.	Ragg. di Curv. R150	Spess. Min.	Ragg. di Curv. R170	Spess. Min.	Ragg. di Curv. R190	Spess. Min.	Ragg. d R2
156R90D1/4" O.D.	1 mm	156R100D1/4" O.D.	1 mm	156R112D1/4" O.D.	1 mm	156R130D1/4" O.D.	1 mm	156R150D1/4" O.D.	1 mm	156R170D1/4" O.D.	1 mm	156R190D1/4" O.D.	1 mm	157MR22
156R90D3/8" O.D.	1 mm	156R100D3/8" O.D.	1 mm	156R112D3/8" O.D.	1 mm	156R130D3/8" O.D.	1 mm	156R150D3/8" O.D.	1 mm	156R170D3/8" O.D.	1 mm	156R190D3/8" O.D.	1 mm	157MR22
156R90D1/2" O.D.	1 mm	156R100D1/2" O.D.	1 mm	156R112D1/2" O.D.	1 mm	156R130D1/2" O.D.	1 mm	156R150D1/2" O.D.	1 mm	156R170D1/2" O.D.	1 mm	156R190D1/2" O.D.	1 mm	157MR22
156R90D5/8" O.D.	1 mm	156R100D5/8" O.D.	1 mm	156R112D5/8" O.D.	1 mm	156R130D5/8" O.D.	1 mm	156R150D5/8" O.D.	1 mm	156R170D5/8" O.D.	1 mm	156R190D5/8" O.D.	1 mm	157MR22
156R90D3/4" O.D.	1 mm	156R100D3/4" O.D.	1 mm	156R112D3/4" O.D.	1 mm	156R130D3/4" O.D.	1 mm	156R150D3/4" O.D.	1 mm	156R170D3/4" O.D.	1 mm	156R190D3/4" O.D.	1 mm	157MR22
156R90D7/8" O.D.	1 mm	156R100D7/8" O.D.	1 mm	156R112D7/8" O.D.	1 mm	156R130D7/8" O.D.	1 mm	156R150D7/8" O.D.	1 mm	156R170D7/8" O.D.	1 mm	156R190D7/8" O.D.	1 mm	157MR22
53R90D1"	1 mm	156R100D1" O.D.	1 mm	156R112D1" O.D.	1 mm	156R130D1" O.D.	1 mm	156R150D1" O.D.	1 mm	156R170D1" O.D.	1 mm	156R190D1" O.D.	1 mm	157MR22
56R90D1 1/8" O.D.	1 mm	156R100D1 1/8" O.D.	1 mm	153R112D1 1/8"	1 mm	156R130D1 1/8" O.D.	1 mm	156R150D1 1/8" O.D.	1 mm	156R170D1 1/8" O.D.	1 mm	156R190D1 1/8" O.D.	1 mm	157MR225
56R90D1 1/4" O.D.	2 mm	156R100D1 1/4" O.D.	2 mm	153R112D1 1/4"	1 mm	156R130D1 1/4" O.D.	1 mm	156R150D1 1/4" O.D.	1 mm	156R170D1 1/4" O.D.	1 mm	156R190D1 1/4" O.D.	1 mm	157MR225
53R90D1 3/8"	2 mm	156R100D1 3/8" O.D.	2 mm	153R112D1 3/8"	1 mm	156R130D1 3/8" O.D.	1 mm	156R150D1 3/8" O.D.	1 mm	156R170D1 3/8" O.D.	1 mm	156R190D1 3/8" O.D.	1 mm	157MR225
53R90D1 1/2"	3 mm	153R100D1 1/2"	2 mm	156R112D1 1/2" O.D.	2 mm	153R130D1 1/2"	1,5 mm	153R150D1 1/2"	1,2 mm	153R170D1 1/2"	1,2 mm	153R190D1 1/2"	1 mm	157MR225
53R90D1 5/8"	3 mm	153R100D1 5/8"	2 mm	153R112D1 5/8"	2 mm	153R130D1 5/8"	1,5 mm	153R150D1 5/8"	1,2 mm	153R170D1 5/8"	1,2 mm	153R190D1 5/8"	1mm	157MR225
		153R100D1 3/4"	3 mm			153R130D1 3/4"	2,5 mm	153R150D1 3/4"	2,5 mm	153R170D1 3/4"	1,5 mm	153R190D1 3/4"	1,5 mm	157MR225
		153R100D1 7/8"	3 mm			153R130D1 7/8"	2,5 mm	153R150D1 7/8"	2,5 mm	153R170D1 7/8"	2 mm	153R190D1 7/8"	1,5 mm	157MR225
						153R130D2"	3 mm	153R150D2"	2,5 mm	153R170D2"	2,5 mm	153R190D2"	1,5 mm	157MR22
						153R130D2 1/8"	3 mm	153R150D2 1/8"	2,5 mm	156R170D2 1/8" O.D.	2,5 mm	153R190D2 1/8"	1,5 mm	157MR225
						153R130D2 1/4"	3 mm	153R150D2 1/4"	2,5 mm	156R170D2 1/4" O.D.	2,5 mm	153R190D2 1/4"	2mm	157MR225
						153R130D2 3/8"	3 mm	153R150D2 3/8"	2,5 mm	156R170D2 3/8" O.D.	2,5 mm	153R190D2 3/8"	2 mm	157MR225

ONO DISPONIBILI A RICHIESTA

156 MATRICI SEMI STANDARD IN ACCIAIO **157** MATRICI SPECIALI A RICHIESTA IN ACCIAIO ● A RICHIESTA

Ragg. di Curv. R90	Spess. Min.	Ragg. di Curv. R100	Spess. Min.	Ragg. di Curv. R112	Spess. Min.	Raggio di Curv. R130	Spess. Min.	Ragg. di Curv. R150	Spess. Min.	Ragg. di Curv. R170	Spess. Min.	Ragg. di Curv. R190	Spess. Min.	Ragg. di R22
56R90D1/4"G	1 mm	156R100D1/4"G	1 mm	156R112D1/4"G	1 mm	156R130D1/4"G	1 mm	156R150D1/4"G	1 mm	156R170D1/4"G	1 mm	156R190D1/4"G	1 mm	157MR225
56R90D3/8"G	1 mm	156R100D3/8"G	1 mm	156R112D3/8"G	1 mm	156R130D3/8"G	1 mm	156R150D3/8"G	1 mm	156R170D3/8"G	1 mm	156R190D3/8"G	1 mm	157MR225
56R90D1/2"G	1 mm	156R100D1/2"G	1 mm	156R112D1/2"G	1 mm	156R130D1/2"G	1 mm	156R150D1/2"G	1 mm	156R170D1/2"G	1 mm	156R190D1/2"G	1 mm	157MR225
56R90D3/4"G	1 mm	156R100D3/4"G	1 mm	156R112D3/4"G	1 mm	156R130D3/4"G	1 mm	156R150D3/4"G	1 mm	156R170D3/4"G	1 mm	156R190D3/4"G	1 mm	157MR225
53/1R90D1"G	2 mm	156R100D1"G	2 mm	153/1R112D1"	1 mm	156R130D1"G	1 mm	156R150D1"G	1 mm	156R170D1"G	1 mm	156R190D1"G	1 mm	157MR225
53/1R90D1 1/4"	3 mm	153/1R100D1 1/4"	2 mm	153/1R112D1 1/4"	3,2 mm	153/1R130D1 1/4"	1,5 mm	153/1R150D1 1/4"	1,2 mm	153/1R170D1 1/4"G	1,2 mm	153/1R190D1 1/4"	1 mm	157MR225D1
		153/1R100D1 1/2"	3,5 mm			153/1R130D1 1/2"	3 mm	153/1R150D1 1/2"	2,5 mm	153/1R170D1 1/2"	2 mm	153/1R190D1 1/2"	1,5 mm	157MR225D1
						153/1R130D2"	3 mm	153/1R150D2"	2,5 mm	156R170D2"	2,5 mm	153/1R190D2"	2 mm	157MR225

INOX, RAME CRUDO E SIMILI

: IN: pollici O.D. - pollici GAS

IEDI BENDER® MB42/MB42P CONSULTARE IL CATALOGO A PAG. 30

NOTA: RAGGI MASSIMI OTTENIBILI

	CON CONTROMATRICE	CON RULLO
SUPER BENDER® 060/A - SB48	= R240	R300
TOP BENDER® 050	= R240	R300
MEDI BENDER® MB42	= R260	R300
MEGABENDER VS76/ TOP BENDER® TB60	= R315	R380

Spess. Min.	Ragg. di Curv. R100	Spess. Min.	Ragg. di Curv. R112	Spess. Min.	Raggio di Curv. R130	Spess. Min.	Ragg. di Curv. R150	Spess. Min.	Ragg. di Curv. R170	Spess. Min.	Ragg. di Curv. R190	Spess. Min.	Ragg. di Curv. R225	Spess. Min.
1 mm	156R100D1/4" O.D.	1 mm	156R112D1/4" O.D.	1 mm	156R130D1/4" O.D.	1 mm	156R150D1/4" O.D.	1 mm	156R170D1/4" O.D.	1 mm	156R190D1/4" O.D.	1 mm	157MR225D1/4" O.D.	1 mm
1 mm	156R100D3/8" O.D.	1 mm	156R112D3/8" O.D.	1 mm	156R130D3/8" O.D.	1 mm	156R150D3/8" O.D.	1 mm	156R170D3/8" O.D.	1 mm	156R190D3/8" O.D.	1 mm	157MR225D3/8" O.D.	1 mm
1 mm	156R100D1/2" O.D.	1 mm	156R112D1/2" O.D.	1 mm	156R130D1/2" O.D.	1 mm	156R150D1/2" O.D.	1 mm	156R170D1/2" O.D.	1 mm	156R190D1/2" O.D.	1 mm	157MR225D1/2" O.D.	1 mm
1 mm	156R100D5/8" O.D.	1 mm	156R112D5/8" O.D.	1 mm	156R130D5/8" O.D.	1 mm	156R150D5/8" O.D.	1 mm	156R170D5/8" O.D.	1 mm	156R190D5/8" O.D.	1 mm	157MR225D5/8" O.D.	1 mm
1 mm	156R100D3/4" O.D.	1 mm	156R112D3/4" O.D.	1 mm	156R130D3/4" O.D.	1 mm	156R150D3/4" O.D.	1 mm	156R170D3/4" O.D.	1 mm	156R190D3/4" O.D.	1 mm	157MR225D3/4" O.D.	1 mm
1 mm	156R100D7/8" O.D.	1 mm	156R112D7/8" O.D.	1 mm	156R130D7/8" O.D.	1 mm	156R150D7/8" O.D.	1 mm	156R170D7/8" O.D.	1 mm	156R190D7/8" O.D.	1 mm	157MR225D7/8" O.D.	1 mm
1,5 mm	156R100D1" O.D.	1 mm	156R112D1" O.D.	1 mm	156R130D1" O.D.	1 mm	156R150D1" O.D.	1 mm	156R170D1" O.D.	1 mm	156R190D1" O.D.	1 mm	157MR225D1" O.D.	1 mm
2,5 mm	156R100D1 1/8" O.D.	2 mm	153R112D1 1/8"	1 mm	156R130D1 1/8" O.D.	1 mm	156R150D1 1/8" O.D.	1 mm	156R170D1 1/8" O.D.	1 mm	156R190D1 1/8" O.D.	1 mm	157MR225D11/8" O.D.	1 mm
2,5 mm	156R100D1 1/4" O.D.	2 mm	153R112D1 1/4"	2 mm	156R130D1 1/4" O.D.	1 mm	156R150D1 1/4" O.D.	1 mm	156R170D1 1/4" O.D.	1 mm	156R190D1 1/4" O.D.	1 mm	157MR225D1 1/4" O.D.	1 mm
	156R100D1 3/8" O.D.	3 mm	153R112D1 3/8"	2,5 mm	156R130D1 3/8" O.D.	1 mm	156R150D1 3/8" O.D.	1 mm	156R170D1 3/8" O.D.	1 mm	156R190D1 3/8" O.D.	1 mm	157MR225D1 3/8" O.D.	1 mm
			153R112D1 1/2"	2 mm	153R130D1 1/2"	2 mm	153R150D1 1/2"	2 mm	153R170D1 1/2"	1,5 mm	153R190D1 1/2"	1,2 mm	157MR225D1 1/2" O.D.	1 mm
			153R112D1 5/8"	3,2 mm	153R130D1 5/8"	2 mm	153R150D1 5/8"	2 mm	153R170D1 5/8"	1,5 mm	153R190D1 5/8"	1,2mm	157MR225D1 5/8" O.D.	1 mm
					153R130D1 3/4"	3 mm	153R150D1 3/4"	3 mm	153R170D1 3/4"	2,5 mm	153R190D1 3/4"	2 mm	157MR225D1 3/4" O.D.	1,2 mm
					153R130D1 7/8"	3 mm	153R150D1 7/8"	3 mm	153R170D1 7/8"	2,5 mm	153R190D1 7/8"	2 mm	157MR225D1 7/8" O.D.	1,2 mm
							153R150D2"	3 mm	153R170D2"	3 mm	153R190D2"	2,5 mm	157MR225D2" O.D.	2 mm
									156R170D2 1/8" O.D.	3 mm	153R190D2 1/8"	2,5 mm	157MR225D2 1/8" O.D.	2,5 mm
									156R170D2 3/8" O.D.	3 mm	153R190D2 3/8"	2,5 mm	157MR225D2 3/8" O.D.	2,5 mm

NIBILI A RICHIESTA

TRICI SEMI STANDARD IN ACCIAIO **157** MATRICI SPECIALI A RICHIESTA IN ACCIAIO A RICHIESTA

Spess. Min.	Ragg. di Curv. R100	Spess. Min.	Ragg. di Curv. R112	Spess. Min.	Raggio di Curv. R130	Spess. Min.	Ragg. di Curv. R150	Spess. Min.	Ragg. di Curv. R170	Spess. Min.	Ragg. di Curv. R190	Spess. Min.	Ragg. di Curv. R225	Spess. Min.
1 mm	156R100D1/4"G	1 mm	156R112D1/4"G	1 mm	156R130D1/4"G	1 mm	156R150D1/4"G	1 mm	156R170D1/4"G	1 mm	156R190D1/4"G	1 mm	157MR225D1/4"G	1 mm
1 mm	156R100D3/8"G	1 mm	156R112D3/8"G	1 mm	156R130D3/8"G	1 mm	156R150D3/8"G	1 mm	156R170D3/8"G	1 mm	156R190D3/8"G	1 mm	157MR225D3/8"G	1 mm
1 mm	156R100D1/2"G	1 mm	156R112D1/2"G	1 mm	156R130D1/2"G	1 mm	156R150D1/2"G	1 mm	156R170D1/2"G	1 mm	156R190D1/2"G	1 mm	157MR225D1/2"G	1 mm
1,5 mm	156R100D3/4"G	1,5 mm	156R112D3/4"G	1 mm	156R130D3/4"G	1 mm	156R150D3/4"G	1 mm	156R170D3/4"G	1 mm	156R190D3/4"G	1 mm	157MR225D3/4"G	1 mm
	156R100D1"G	3 mm	153/1R112D1"	2,5 mm	156R130D1"G	1 mm	156R150D1"G	1 mm	156R170D1"G	1 mm	156R190D1"G	1 mm	157MR225D1"G	1 mm
			153/1R112D1 1/4"	2,5 mm	153/1R130D1 1/4"	2 mm	153/1R150D1 1/4"	2 mm	153/1R170D1 1/4"G	1,5 mm	153/1R190D1 1/4"G	1,2 mm	157MR225D1 1/4"G	1 mm
					153/1R130D1 1/2"	3 mm	153/1R150D1 1/2"	3 mm	153/1R170D1 1/2"	2,5 mm	153/1R190D1 1/2"	2 mm	157MR225D1 1/2"G	1,5 mm
									156R170D2"G	3,5 mm	153/1R190D2"	2,5 mm	157MR225D2"G	2,5 mm

BERO ESSERE POSSIBILI - CONTATTARE IL RIVENDITORE AUTORIZZATO. NCML

N.B.CONTROMATRICI PER RAME CRUDO: PER CURVARE QUEST

SI RACCOMANDA DI USARE IL RULLO ART. 0501 INVECE DELLA CONTROMATRICE CON TUTTI I TUBI DI SPESSORE SUPERIORE A 4 mm

I RAGGI INDICATI SONO A CENTRO CURVA

Ragg. di Curv. R250	Spess. Min.	Ragg. di Curv. R260	Spess. Min.	Ragg. di Curv. R300	Spess. Min.	Ragg. di Curv. R301-380	∅ TUBO	CONTROMATRICI OTTONE	CONTROMATRICI PLASTICA
157NR250D1/4" O.D.	1 mm	157NR260D1/4" O.D.	1 mm	157OR300D1/4" O.D.	1 mm	●	1/4"OD-6,30	154-1/4"	—
157NR250D3/8" O.D.	1 mm	157NR260D3/8" O.D.	1 mm	157OR300D3/8" O.D.	1 mm	●	3/8"OD-9,52	154-3/8"	—
157NR250D1/2" O.D.	1 mm	157NR260D1/2" O.D.	1 mm	157OR300D1/2" O.D.	1 mm	●	1/2"OD-12,70	154-1/2"	154P-1/2"
157NR250D5/8" O.D.	1 mm	157NR260D5/8" O.D.	1 mm	157OR300D5/8" O.D.	1 mm	●	5/8"OD-15,88	154-5/8"	154P-5/8"
157NR250D3/4" O.D.	1 mm	157NR260D3/4" O.D.	1 mm	157OR300D3/4" O.D.	1 mm	●	3/4"OD-19,05	154-3/4"	154P-3/4"
157NR250D7/8" O.D.	1 mm	157NR260D7/8" O.D.	1 mm	157OR300D7/8" O.D.	1 mm	●	7/8"OD-22,22	154-7/8"	154P-7/8"
157NR250D1" O.D.	1 mm	157NR260D1" O.D.	1 mm	157OR300D1" O.D.	1 mm	●	1"OD-25,40	154-1"	—
157NR250D1 1/8" O.D.	1 mm	157NR260D1 1/8" O.D.	1 mm	157OR300D1 1/8" O.D.	1 mm	●	1 1/8"OD-28,58	154-1 1/8"	—
157NR250D1 1/4" O.D.	1 mm	157NR260D1 1/4" O.D.	1 mm	157OR300D1 1/4" O.D.	1 mm	●	1 1/4"OD-31,75	154-1 1/4"	—
157NR250D1 3/8" O.D.	1 mm	157NR260D1 3/8" O.D.	1 mm	157OR300D1 3/8" O.D.	1 mm	●	1 3/8"OD-34,92	154-1 3/8"	—
157NR250D1 1/2" O.D.	1 mm	157NR260D1 1/2" O.D.	1 mm	157OR300D1 1/2" O.D.	1 mm	●	1 1/2"OD-38,10	154-1 1/2"	—
157NR250D1 5/8" O.D.	1 mm	157NR260D1 5/8" O.D.	1 mm	157OR300D1 5/8" O.D.	1 mm	●	1 5/8"OD-41,28	154-1 5/8"	—
157NR250D1 3/4" O.D.	1,2 mm	157NR260D1 3/4" O.D.	1 mm	157OR300D1 3/4" O.D.	1 mm	●	1 3/4"OD-44,45	154-1 3/4"	—
157NR250D1 7/8" O.D.	1,2 mm	157NR260D1 7/8" O.D.	1 mm	157OR300D1 7/8" O.D.	1 mm	●	1 7/8"OD-47,62	154-1 7/8"	—
157NR250D2" O.D.	2 mm	157NR260D2" O.D.	1,5 mm	157OR300D2" O.D.	1,2 mm	●	2"OD-50,80	154-2"	—
157NR250D2 1/8" O.D.	2 mm	157NR260D2 1/8" O.D.	2 mm	157OR300D2 1/8" O.D.	1,2 mm	●	2 1/8"OD-53,97	154-2 1/8"	—
157NR250D2 3/8" O.D.	2 mm	157NR260D2 3/8" O.D.	2 mm	157OR300D2 3/8" O.D.	1,5 mm	●	2 3/8"OD-60,32	154-2 3/8"	—
				157RR300D3" O.D.	2 mm	●	3"OD-76	154-3"	—

MEDI BENDER® MB42
SUPER BENDER® 060A - SUPER BENDER® SB48
TOP BENDER® 050 - SUPER BENDER® TB60
MEGABENDER VS76

Ragg. di Curv. R250	Spess. Min.	Ragg. di Curv. R260	Spess. Min.	Ragg. di Curv. R300	Spess. Min.	Ragg. di Curv. R301-380	∅ TUBO	CONTROMATRICI OTTONE	CONTROMATRICI PLASTICA
157NR250D1/4"G	1 mm	157NR260D1/4"G	1 mm	157OR300D1/4"G	1 mm	●	1/4"GAS-13,25	155-1/4"	—
157NR250D3/8"G	1 mm	157NR260D3/8"G	1 mm	157OR300D3/8"G	1 mm	●	3/8"GAS-17,2	155-3/8"	—
157NR250D1/2"G	1 mm	157NR260D1/2"G	1 mm	157OR300D1/2"G	1 mm	●	1/2"GAS-21,3	155-1/2"	—
157NR250D3/4"G	1 mm	157NR260D3/4"G	1 mm	157OR300D3/4"G	1 mm	●	3/4"GAS-26,9	155-3/4"	—
157NR250D1"G	1 mm	157NR260D1"G	1 mm	157OR300D1"G	1 mm	●	1"GAS-33,7	155-1"	—
157NR250D1 1/4"G	1 mm	157NR260D1 1/4"G	1 mm	157OR300D1 1/4"G	1 mm	●	1 1/4"GAS-42,25	155-1 1/4"	—
157NR250D1 1/2"G	1,2 mm	157NR260D1 1/2"G	1 mm	157OR300D1 1/2"G	1 mm	●	1 1/2"GAS-48,25	155-1 1/2"	—
157NR250D2"G	2 mm	157NR260D2"G	2 mm	157OR300D2"G	1,2 mm	●	2"GAS-60,3	155-2"	—
				157RR300D2 1/2"P	2 mm	●	2 1/2"P-73	155-2 1/2"P	—
				157RR300D2 1/2"G	2 mm	●	2 1/2"GAS-76	155-2 1/2	—

MB 42
SUPER BENDER® 060A - SB48
TOP BENDER® 050 - TOP BENDER® TB60
MEGABENDER VS76

ATERIALE DI PARTICOLARE DIFFICOLTÀ.SONO NECESSARIE LE CONTROMATRICI SPECIALI IN OTTONE Art. 152/1 DA 5 mm A 54 mm

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