

Save with Pipe Tooling Kits

(Additional Savings when Purchased with Machine)

Description	Material Size	Centerline Radius - Inches -	Min. Wall	Center Former Part#	Counterbend Die Part#	Available with Ercolina Machines
PIPEKIT1	½"	1.8	.109	153R046P0500	155P0500	TB60
	¾"	2.2	.113	153R056P0750	155P0750	
	1"	2.6	.133	153R067P1000	155P1000	
	1¼"	3.5	.140	153R090P1250	155P1250	
	1½"	3.9	.145	153R100P1500	155P1500	
	2"	5.9	.109	153R150P2000	155P2000	
PIPEKIT2	½"	1.8	.109	153R046P0500	155P0500	SB48
	¾"	2.2	.113	153R056P0750	155P0750	
	1"	2.6	.133	153R067P1000	155P1000	
	1¼"	3.5	.140	153R090P1250	155P1250	
	1½"	3.9	.145	153R100P1500	155P1500	
Handrail Pipe Kit	1¼"	3.5	.140	153R090P1250	155P1250	SB48, TB60 TB80
	1½"	3.9	.145	153R100P1500	155P1500	
PIPEKIT4	1¼"	3.5	.140	153R090P1250	155P1250	TB100, TB130
	1½"	3.9	.145	153R100P1500	155P1500	
	2"	5.9	.109	153R150P2000	155P2000	
	2½"	11.8	.203	157R300P2500-80	155P2500	
	3"	11.8	.216	157R300P3000-80	155P3000	
PIPEKIT6	1"	2.6	.133	153R067P1000	155P1000	TB80
	1¼"	3.5	.140	153R090P1250	155P1250	
	1½"	3.9	.145	153R100P1500	155P1500	
	2"	5.9	.109	153R150P2000	155P2000	
	2½"	10.2	.203	157R260P2500-80	155P2500	

Refer to machine specifications for individual capacities.



Save with Tube Tooling Kits

(Additional Savings when Purchased with Machine)

Description	Material Size	Centerline Radius - Inches -	Min. Wall	Center Former Part#	Counterbend Die Part#	Available with Ercolina Machines
Small Radius Tube Kit TUBEKIT1SR	¾"	2.6	.035	153R067T0750	155T0750	TB60 TB100, TB130
	⅞"	2.2	.065	153R056T0875	154T0875	
	1"	2.6	.065	153R067T1000	154T1000	
	1¼"	3.2	.083	153R082T1250	154T1250	
	1½"	3.9	.083	153R100T1500	154T1500	
	2"	5.9	.095	153R150T2000	154T2000	
Small Radius Tube Kit TUBEKIT2SR	¾"	2.6	.035	153R067T0750	154T0750	SB48
	⅞"	2.2	.065	153R056T0875	154T0875	
	1"	2.6	.065	153R067T1000	154T1000	
	1¼"	3.2	.083	153R082T1250	154T1250	
	1½"	3.9	.083	153R100T1500	154T1500	
Large Radius Tube Kit TUBEKIT1	¾"	2.6	.035	153R067T0750	154T0750	TB60, TB100, TB130
	⅞"	2.6	.035	153R067T0875	154T0875	
	1"	3.2	.035	153R082T1000	154T1000	
	1¼"	4.4	.035	153R112T1250	154T1250	
	1½"	5.9	.049	153R150T1500	154T1500	
	1¾"	6.7	.065	153R170T1750	154T1750	
	2"	7.5	.065	153R190T2000	154T2000	
Large Radius Tube Kit TUBEKIT2	¾"	2.6	.035	153R067T0750	154T0750	SB48
	⅞"	2.6	.035	153R067T0875	154T0875	
	1"	3.2	.035	153R082T1000	154T1000	
	1¼"	4.4	.035	153R112T1250	154T1250	
	1½"	5.9	.049	153R150T1500	154T1500	
	1¾"	6.7	.065	153R170T1750	154T1750	
Large Radius Tube Kit TUBEKIT5	1"	3.2	.035	153R082T1000	154T1000	TB80
	1¼"	4.4	.035	153R112T1250	154T1250	
	1½"	5.9	.049	153R150T1500	154T1500	
	1¾"	6.7	.065	153R170T1750	154T1750	
	2"	7.5	.065	153R190T2000	154T2000	

Refer to machine specifications for individual capacities.

Pipe Information



Pipe dimensions are based on I.D. of material (2" sch. 40 pipe measures 2.375" O.D.).

Commercial Pipe and Wall Thickness							
Nominal Size	O.D.	Schedule					XX Strong
		5	10	40	80	160	
1/4"	.540		.065	.088	.119		
3/8"	.675		.065	.091	.126		
1/2"	.840	.065	.083	.109	.147	.188	.294
3/4"	1.050	.065	.083	.113	.154	.219	.308
1"	1.315	.065	.109	.133	.179	.250	.358
1 1/4"	1.660	.065	.109	.140	.191	.250	.382
1 1/2"	1.900	.065	.109	.145	.200	.281	.400
2"	2.375	.065	.109	.154	.218	.343	.436
2 1/2"	2.875	.083	.120	.203	.276	.375	.552
3"	3.500	.083	.120	.216	.300	.438	.600
3 1/2"	4.000	.083	.120	.226	.318		.636
4"	4.500	.083	.120	.237	.337	.531	.674

Steel & Polymer Pipe Counterbending Dies

STEEL

Pipe Size	Outside Diameter	Counterbend Die Part#
3/8"	.675	155AP0375
1/2"	.840	155AP0500
3/4"	1.050	155AP0750
1"	1.315	155AP1000
1 1/4"	1.660	155AP1250
1 1/2"	1.900	155AP1500
2"	2.375	155AP2000

Steel used for heavy wall or abrasive application.

STEEL SUPPORT WITH REPLACEABLE POLYMER INSERT

Pipe Size	Outside Diameter	Counterbend Die Part#
1"	1.315	155SP1000
1 1/4"	1.660	155SP1250
1 1/2"	1.900	155SP1500
2"	2.375	155SP2000

Polymer recommended for materials with a polished finish such as stainless and aluminum.



REPLACEABLE POLYMER INSERTS

1"	1.315	155SP1000INS
1 1/4"	1.660	155SP1250INS
1 1/2"	1.900	155SP1500INS
2"	2.375	155SP2000INS

Consult factory for tooling sizes not shown.



Tooling for Pipe

Pipe Size	Outside Diameter	Wall Thickness Sch. / Inch	Min. CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
1/4"	.540	40 - .088	1.4	40mm	153R036P0250	155P0250
3/8"	.675	40 - .091	1.4		153R036P0375	155P0375
		10 - .065	2.2		153R056P0375	
1/2"	.840	40 - .109	1.8		153R046P0500 ●	155P0500
		10 - .083	2.2		153R056P0500	
		5 - .065	2.6		153R067P0500	
		5 - .065	4.4		156R112P0500	
3/4"	1.050	40 - .113	2.2		153R056P0750 ●	155P0750
		10 - .083	2.6		153R067P0750	
		5 - .065	3.2		153R082P0750	
		5 - .065	5.1	50mm	156R130P0750	
1"	1.315	40 - .133	2.6	40mm	153R067P1000 ●	155P1000
		10 - .109	3.2	40mm	153R082P1000	
		10 - .109	3.9	50mm	156R100P1000	
		5 - .065	4.4	40mm	153R112P1000	
		5 - .065	6.7	50mm	156R170P1000	
		5 - .065	6.7	110mm	157R170P1000-110	
1 1/4"	1.660	40 - .140	3.5	50mm	153R090P1250 ●	155P1250
		40 - .140	3.9		153R100P1250	
		10 - .109	5.1		153R130P1250	
		5 - .065	5.9		153R150P1250	
		5 - .065	7.5		153R190P1250	
		5 - .065	8.9		157R225P1250	
		5 - .065	8.9	110mm	157R225P1250-110	
1 1/2"	1.900	40 - .145	3.9	50mm	153R100P1500 ●	155P1500
		40 - .145	5.1		153R130P1500	
		40 - .145	5.9		153R150P1500	
		10 - .109	6.7		153R170P1500	
		5 - .065	7.5		153R190P1500	
		5 - .065	9.8		157R250P1500	
		5 - .065	9.8	110mm	157R250P1500-110	

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Tooling for Pipe

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Pipe Size	Outside Diameter	Wall Thickness Sch. / Inch	Min. CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
2"	2.375	40 - .154	5.1	50mm	153R130P2000	155P2000
		10 - .109	5.9		153R150P2000 ●	
		5 - .065	7.5		153R190P2000	
		5 - .065	8.9		157R225P2000	
		5 - .065	10.2		157R260P2000	
		5 - .065	10.2	80mm	157R260P2000-80	
		5 - .065	11.8	50mm	157R300P2000	
		5 - .065	11.8	80mm	157R300P2000-80	
		5 - .065	11.8	110mm	157R300P2000-110	
2½"	2.875	40 - .203	10.2	80mm	157R260P2500-80	155P2500
		40 - .203	11.8		157R300P2500-80	
		40 - .203	11.8	110mm	157R300P2500-110	
		10 - .120	13.8	80mm	157R350P2500-80	
		10 - .120	13.8	110mm	157R350P2500-110	
3"	3.500	40 - .216	11.8	80mm	157R300P3000-80	155P3000
		40 - .216	11.8	110mm	157R300P3000-110	
		40 - .216	13.8	80mm	157R350P3000-80	
		10 - .120	17.7	110mm	157R450P3000-110	
4"	4.500	40 - .237	13.8	110mm	157R350P400-110	152BP4000
		10 - .120	22.0	110mm	157R560P400-110**	
6"	6.625	40 - .280	23.2	130mm	157R590P6000-130	152BP6000
		10 - .134	31.5	130mm	157R800P6000-130**	

3D Tooling

5D Tooling

Included in standard Pipe Tooling Kits (pg. 15)

80mm drive diameter available for TB80 / TB100 / TB130
110mm drive diameter available for TB130 / TB180
130mm drive diameter available for TB180 only

Bending of non-ferrous material may require tooling modification.

*Select models require counterbending die support 050E when bending radii 225mm and larger.
Refer to machine manual for CLR capacities and drive.

All standard Ercolina® counterbending dies are provided in bronze.

**Center Former Part# 157R560P400-110 and 157R800P6000-130 require lead time.



Tooling for Round Tube

Tube Size	Outside Diameter	Wall Thickness	Minimum CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
1/4"	.250	.035	1.4	40mm	153R036T0250	154T0250
3/8"	.375	.035	1.4		153R036T0375	154T0375
1/2"	.500	.035	1.4		153R036T0500	154T0500
5/8"	.625	.083	1.4		153R036T0625	154T0625
		.035	1.8		153R046T0625	
3/4"	.750	.083	1.8		153R046T0750	154T0750
		.065	2.2		153R056T0750	
		.035	2.6		153R067T0750 ● ●	
7/8"	.875	.083	1.8		153R046T0875	154T0875
		.065	2.2		153R056T0875 ●	
		.035	2.6		153R067T0875 ●	
1"	1.000	.083	2.2		153R056T1000	154T1000
		.065	2.6		153R067T1000 ●	
		.035	3.2		153R082T1000 ●	
1 1/8"	1.125	.095	2.2		153R056T1125	154T1125
		.083	2.6		153R067T1125	
		.035	3.2		153R082T1125	
1 1/4"	1.250	.095	2.6		153R067T1250	154T1250
		.083	3.2		153R082T1250 ●	
		.035	4.4		153R112T1250 ●	
1 3/8"	1.375	.083	3.2		153R082T1375	154T1375
		.035	4.4		153R112T1375	
1 1/2"	1.500	.109	3.5	50mm	153R090T1500	154T1500
		.083	3.9	40mm	153R100T1500 ●	
		.083	4.4		156R112T1500	
1 1/2"	1.500	.065	5.1	50mm	153R130T1500	154T1500
		.049	5.9		153R150T1500 ●	
		.035	6.7		156R170T1500	
		.035	7.5		153R190T1500	
1 5/8"	1.625	.109	3.5		153R090T1625	154T1625
		.083	3.9		153R100T1625	
		.065	5.1		153R130T1625	
		.049	5.9		153R150T1625	
		.035	6.7		153R170T1625	
		.035	7.5		153R190T1625	
1 3/4"	1.750	.109	3.9		153R100T1750	154T1750
		.095	5.1		153R130T1750	
		.095	5.9		153R150T1750	
		.065	6.7		153R170T1750 ●	
		.035	7.5		156R190T1750	

Tooling for Round Tube

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Tube Size	Outside Diameter	Wall Thickness	Minimum CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
1 7/8"	1.875	.109	3.9	50mm	153R100T1875	154T1875
		.095	5.1		153R130T1875	
		.083	5.9		156R150T1875	
		.065	6.7		153R170T1875	
		.035	7.5		153R190T1875	
2"	2.000	.109	4.7		153R120T2000	154T2000
		.109	5.1		156R130T2000	
		.095	5.9		153R150T2000 ●	
		.083	6.7		156R170T2000	
		.065	7.5		153R190T2000 ●	
2 1/8"	2.125	.134	4.7		153R120T2125	154T2125
		.109	5.1		153R130T2125	
		.083	5.9		153R150T2125	
		.083	6.7		156R170T2125	
		.065	7.5		153R190T2125	
2 1/4"	2.250	.109	5.1		153R130T2250	154T2250
		.095	5.9		153R150T2250	
		.083	6.7		156R170T2250	
		.083	7.5		153R190T2250	
2 3/8"	2.375	.109	5.1		153R130T2375	154T2375
		.095	5.9		153R150T2375	
		.083	6.7		156R170T2375	
		.083	7.5		153R190T2375	
2 1/2"	2.500	.083	8.9		157R225T2500*	154T2500
		.083	9.8		157R250T2500*	
		.065	10.2		157R260T2500*	
		.065	11.8		157R300T2500*	
3"	3.000	.156	9.8		157R250T3000*	154T3000
		.156	10.2		157R260T3000*	
		.120	11.8		157R300T3000*	
3"	3.000	.216	10.2	80mm	157R260T3000-80	154T3000
		.156	11.8		157R300T3000-80	
3 1/4"	3.250	.216	11.8		157R300T3250-80	154BT3250
		.216	11.8		157R300P3000-80	155P300
3 1/2"	3.500	.216	11.8		157R350P3000-80	
		.216	13.8			
4"	4.000	.216	13.8	110mm	157R350T4000-11	155BT4000

●

Included in standard small radius
Tube Tooling Kits (pg. 16)

●

Included in standard large radius
Tube Tooling Kits (pg. 16)

80mm drive diameter available for TB80 / TB100 / TB130

110mm drive diameter available for TB130 / TB180 – 130mm drive diameter available for TB180 only

Bending of non-ferrous material may require tooling modification.

*Select models require counterbending die support 050E when bending radii 225mm and larger.

Refer to machine manual for CLR capacities and drive.

All standard Ercolina® counterbending dies are provided in bronze.



Round Tube Information

Minimum Achievable “Centerline Radius” with Standard Tooling

Tube Size	Wall Thickness							
	.035 20 Ga.	.049 18 Ga.	.065 16 Ga.	.083 14 Ga.	.095 13 Ga.	.109 12 Ga.	.120 11 Ga.	.134 10 Ga.
¼"	1.4	1.4	1.4	1.4	1.4	1.4	.78	.78
⅜"	1.4	1.4	.78	.78	.78	.78	.78	.78
½"	1.4	1.4	1	1	1	1	1	1
⅝"	1.8	1.8	1.8	1.4	1.4	1.4	1.4	1.4
¾"	2.6	2.6	2.6	1.8	1.8	1.8	1.8	1.8
⅞"	2.6	2.6	2.2	1.8	1.8	1.8	1.8	1.8
1"	3.2	3.2	2.6	2.2	2.2	2.2	2.2	2.2
1⅛"	3.2	3.2	3.2	2.6	2.2	2.2	2.2	2.2
1¼"	4.4	4.4	4.4	3.2	2.6	2.6	2.6	2.6
1⅜"	4.4	4.4	4.4	3.2	3.2	3.2	3.2	3.2
1½"	7.5	5.9	5.1	3.9	3.9	3.5	3.5	3.5
1⅝"	7.5	5.9	5.1	3.9	3.9	3.5	3.5	3.5
1¾"			6.7	6.7	5.1	3.9	3.9	3.9
1⅞"			7.5	5.9	5.1	3.9	3.9	3.9
2"			7.5	7.5	5.9	4.7	4.7	4.7
2⅛"			7.5	7.5	5.9	5.1	5.1	4.7
2¼"				7.5	5.9	5.1	5.1	5.1
2⅜"				7.5	5.9	5.1	5.1	5.1
2½"					11.8	10.2	9.8	
3"					11.8	10.2	9.8	



Tube dimensions are based on O.D. of material (2" tube measures 2.00" O.D.).

All standard Ercolina counterbending dies are provided in bronze.

*Polished tooling for round tube recommended for materials with a polished finish such as stainless and aluminum.

Optional polymer counterbending dies available on request. Consult factory for more information.

Steel & Polymer Tube Counterbending Dies

STEEL

Tube Size	Outside Diameter	Counterbend Die Part#
¾"	.750	154AT0750
⅞"	.875	154AT0875
1"	1.000	154AT1000
1¼"	1.250	154AT1250
1⅜"	1.375	154AT1375
1½"	1.500	154AT1500
1¾"	1.750	154AT1750
1⅞"	1.875	154AT1875
2"	2.000	154AT2000
2¼"	2.250	154AT2250
2½"	2.500	154AT2500

Steel used for heavy wall or abrasive application.

Consult factory for tooling sizes not shown.

STEEL SUPPORT WITH REPLACEABLE POLYMER INSERT

Tube Size	Outside Diameter	Counterbend Die Part#
1⅜"	1.375	154ST1375
1½"	1.500	154ST1500
1¾"	1.750	154ST1750
1⅞"	1.875	154ST1875
2"	2.000	154ST2000

Polymer recommended for materials with a polished finish such as stainless and aluminum.



REPLACEABLE POLYMER INSERT

1⅜"	1.375	154ST1375INS
1½"	1.500	154ST1500INS
1¾"	1.750	154ST1750INS
1⅞"	1.875	154ST1875INS
2"	2.000	154ST2000INS



Tooling for Square Tube

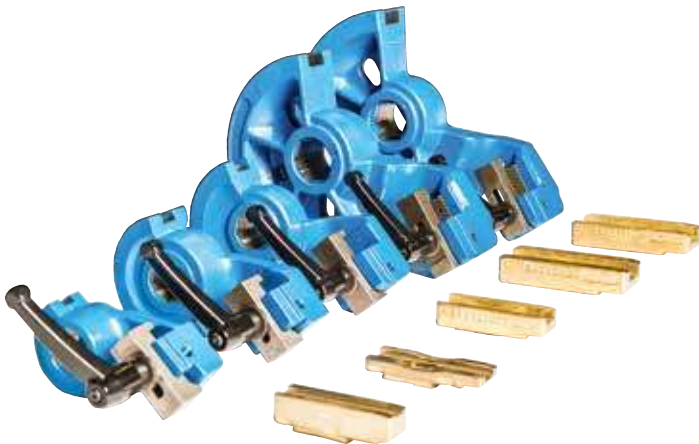


Tube Size	Outside Diameter	Wall Thickness	Minimum CLR Inch	Drive Diameter	Center Former Part#	Counterbend Die Part#
1/2"	.500	.065	1.4	40mm	1582AR0360500	1591A0500
		.049	1.8		1582AR0460500	
3/4"	.750	.120	1.8		1582AR0460750	1591A0750
		.065	2.6		1583AR0670750	
1"	1.000	.120	3.0		1583AR0761000	1591A1000
1"	1.000	.083	3.9	50mm	1585AR1001000	1591A1000
		.065	5.1		1587AR1301000	
		.049	5.9		1588AR1501000	
1 1/4"	1.250	.120	5.1		1587AR1301250	1591A1250
		.095	6.6		1589AR1701250	
1 1/2"	1.500	.120	5.9		1588AR1501500	1591A1500
		.095	7.4		15810AR1901500	
2"	2.000	.120	5.9		1588AR1502000	1591A2000
		.095	7.4		15810AR1902000	
2 1/2"	2.500	.125	11.8	80mm	15813AR30025-80	1591A2500
3"	3.000	.187	13.8		15814AR35030-80	1591A3000

80mm drive diameter available for TB80 / TB100 / TB130
Consult factory for tooling sizes not shown.



Tooling for Square Tube



Square Tube Tooling Kits

Description	Material Size	CLR -Inches-	Min. Wall	Center Former Part#	Counterbend Die Part#	Available with Ercolina Machines
TUBEKITSQ1	½"	1.8	.049	1582AR0460500	1591A0500	SB48, TB60 TB80, TB100 TB130
	¾"	2.6	.065	1583AR0670750	1591A0750	
	1"	3.0	.120	1583AR0761000	1591A1000	
	1¼"	5.1	.120	1587AR1301250	1591A1250	
	1½"	5.9	.120	1588AR1501500	1591A1500	
TUBEKITSQ2	½"	1.8	.049	1582AR0460500	1591A0500	TB60, TB80 TB100, TB130
	¾"	2.6	.065	1583AR0670750	1591A0750	
	1"	3.0	.120	1583AR0761000	1591A1000	
	1¼"	5.1	.120	1587AR1301250	1591A1250	
	1½"	5.9	.120	1588AR1501500	1591A1500	
	2"	5.9	.120	1588AR1502000	1591A2000	

Material Extraction Device for Square Tube



Part# **FP500P1-A**

Extractor plate assists in square material extraction for profiles, solid and hollow.

For use on 030 Mega Bender, TB60, SB48 and 48 Plus models.