



# BENDING SYSTEMS

## HOW DO I FIND THE RIGHT BENDING TOOL

>615



## PIPE BENDING PLIERS

NO. 2415

>618



## MANUAL PIPE BENDER - DRAW BENDING OPERATION

>619



## MANUAL BENDING TOOL SETS NO. 243

>619



## MANUAL BENDING TOOL SETS NO. 278

>620



## UNIVERSAL MANUAL PIPE BENDER NO. 276

>624



## MANUAL PIPE BENDER - PUSHING BENDING OPERATION NO. 2456

>625



## PIPE BENDING MACHINES - DRAW BENDING OPERATION

>627



## PIPE BENDING MACHINES - PUSHING BENDING OPERATION NO. 256-261

>630



## PIPE BENDING MACHINES HYDRAULIC

>633



## ECCENTRIC ANGLE BENDERS

NO. 280

>635



# TOP QUALITY TO MEET MAXIMUM REQUIREMENTS

- › Use of the most up-to-date machinery and environmentally-friendly production processes
- › Everything is based on tightly controlled and selected materials
- › Experienced and reliable specialists vouch for precision-like processing
- › Stringent quality checks after each production step ensure a constantly high level
- › High-grade industrial quality for the toughest forms of continuous use and safety in everyday work



## Everything handled down to a tee

- › The absence of Chrome 6 in the tools is simply a matter of course for us and has been so for many years.
- › Best-possible results are down to the unique manufacturing processes and special treatment for tools



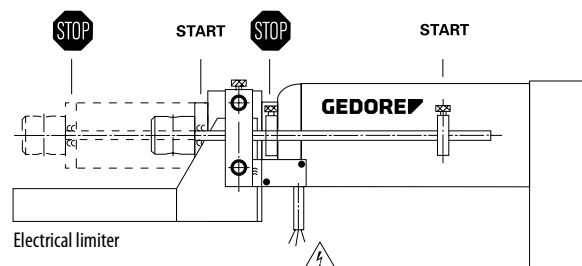
## GEDORE Pipe bending systems

### Advantages and benefits

#### Features that make the difference ...

- › Durable quality for heavy professional use
- › Gentle handling of workpieces
- › Suitable for solving problems, a variety of materials and applications
- › From simple bending pliers to an electro-hydraulic bending machine for 4" pipes
- › Hand-operated, hydraulic and electro-hydraulic
- › For the complete range of standard pipe grades

### Pipe materials



Solving problems is our strength - Please ask us!

# USEFUL INFORMATION

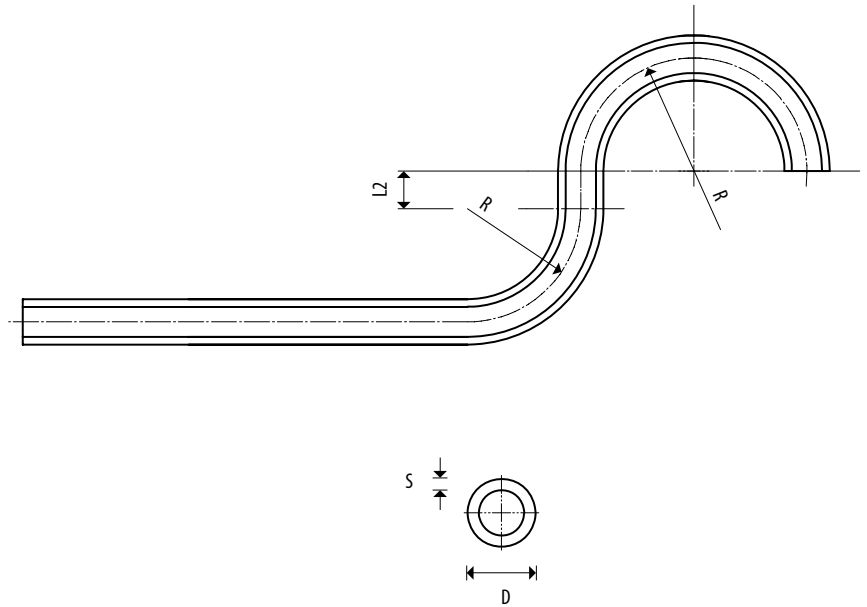
How do I find the right bending tool?

You need to consider the following points when choosing your bending machine:

- > Do you want to bend by hand?
- > Do you want to use a vice?
- > Is the machine to be hydraulically operated?
- > Is the machine to be electrically operated, and if so at what voltage?

The following points also need to be taken into account; refer to adjacent sketch:

- > The shape of the pipe to be bent (round-section, square-section, etc.)
  - > The outside diameter "D" of the pipe
  - > The wall thickness "S" of the pipe
  - > The pipe grade (e.g. steel, stainless steel, NF metals, etc.)
  - > The required bending angle (e.g. 90°, 180° ... etc.)
  - > Are bending radii "R" specified? (Example:  $3 \times D = R$  - this corresponds to a 25 mm outside diameter pipe with a bending radius of 75 mm)
  - > Important: the radius is measured to the middle of the tube = neutral area
  - > Details of the length "L" of the overall pipe
  - > Are a number of bends to be made in succession? - If so, it is essential to state the distance between the pipe bends, "L2"
  - > Are there any specifications for the pipe or the finished pipe bends which go beyond the details listed here (e.g. in power-station construction, the food industry or similar)?
- > A more detailed overview of the possible uses of our pipe bending machines and tools is given in the next pages.



**GEDORE**  
WERKZEUGE FÜR DIE LEISTUNG

### Fragebogen für Biegemaschinen

**Bitte anfordern:**  **Handbuch**

Name: \_\_\_\_\_  
 Firmenname: \_\_\_\_\_  
 Straße: \_\_\_\_\_  
 Land: PLZ / ORT: \_\_\_\_\_  
 Tel./Fax: \_\_\_\_\_  
 Email: \_\_\_\_\_  
 Datum: \_\_\_\_\_

Bitte Nr.: \_\_\_\_\_

Zur Eingabehilfe sind für Ihre Einzelstücke geeignete Blätter für folgende Angaben beifolgend:

**1. Art des Gestells**

Wie soll das Gestell eingesetzt werden?  gestützt (z.B. Werkstattheimer)  an (z.B. B. Maschinenständer)

Is an gangeter Schraubtrieb vorhanden?  ja  nein

Is eine mechanische Wähltrieb vorhanden?  ja  nein

Is eine Motorantriebsung vorhanden?  220V/120V  230V/115V

Wie soll die Antriebsleistung sein?  100-150 W  100-150 W

Wie soll das Gestell hergestellt werden?  Stahl / Welle  Stahl / Welle

Spezielle Anforderungen an das Gestell wie Gewicht, oder Platzbeschränkungen, Maße, Spindelmechanik, Einsatz einer Wähltriebmechanik o.ä.:

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Fügen Sie dieser Anfrage bitte technische Zeichnungen oder Handblätter bei. Anlagen "nach Zeichnung Nr. (falls angegeben)"

\_\_\_\_\_

**GEDORE**  
WERKZEUGE FÜR DIE LEISTUNG

### 2. Angaben zum Material

**2.1. Rohr**

| Art | Material | Form | Abmessungen   | Längen in mm  | Stückzahl | Material | Stückzahl |
|-----|----------|------|---------------|---------------|-----------|----------|-----------|
| 1   | 2        | 3    | 4, 5, 6, 7, 8 | 9, 10, 11, 12 | 13        | 14       | 15        |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |

Art: \_\_\_\_\_  
 Material: Stahl / Edelstahl / Kupfer / Aluminium o.ä. Angaben der Profile: gegeben / angegeben  
 Länge: nach Zeichnung / nach Zeichnung  
 Form: nach Zeichnung / nach Zeichnung

**2.2. Winkel**

| Art | Material | Form | Abmessungen   | Längen in mm  | Stückzahl | Material | Stückzahl |
|-----|----------|------|---------------|---------------|-----------|----------|-----------|
| 1   | 2        | 3    | 4, 5, 6, 7, 8 | 9, 10, 11, 12 | 13        | 14       | 15        |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |
|     |          |      |               |               |           |          |           |

Art: \_\_\_\_\_  
 Material: Stahl / Edelstahl / Kupfer / Aluminium o.ä. Angaben der Profile: gegeben / angegeben  
 Länge: nach Zeichnung / nach Zeichnung  
 Form: nach Zeichnung / nach Zeichnung

**2.3. Winkel**

Art: \_\_\_\_\_  
 Material: \_\_\_\_\_  
 Länge: \_\_\_\_\_  
 Form: \_\_\_\_\_

Bitte anfordern:  **Handbuch**

Name: \_\_\_\_\_  
 Firmenname: \_\_\_\_\_  
 Straße: \_\_\_\_\_  
 Land: PLZ / ORT: \_\_\_\_\_  
 Tel./Fax: \_\_\_\_\_  
 Email: \_\_\_\_\_  
 Datum: \_\_\_\_\_



# APPLICATIONS OF THE GEDORE PIPE BENDER

| Size   | Nennweite | Outer diameter mm | Wall thickness | No. 241500 max. 90° | No. 2423... max. 90° | No. 243.../1100-243100 max. 180° | No. 245610 / 1100-245680 max. 90° | No. 245611 / 1100-245681 max. 90° | No. 249... max. 90° | No. 250... max. 90° | No. 256... max. 90° | No. 257... / 258... max. 90° | No. 259... / 260... max. 90° | No. 261... max. 90° | No. 276... max. 180° | No. 2785... / 1101-278501 max. 180° | No. 2786... / 1100-278601 max. 180° | No. 2787... max. 180° | No. 1100-278801 max. 180° |
|--|-----------|-------------------|----------------|---------------------|----------------------|----------------------------------|-----------------------------------|-----------------------------------|---------------------|---------------------|---------------------|------------------------------|------------------------------|---------------------|----------------------|-------------------------------------|-------------------------------------|-----------------------|---------------------------|
| <b>Gas and water pipes EN 10255-M</b>                |           |                   |                |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              |                              |                     |                      |                                     |                                     |                       |                           |
| 3/8"   | DN 10     | 17,2 mm           | 2,35 mm        |                     |                      |                                  |                                   |                                   | •                   |                     | •                   | •                            | •                            |                     | •                    |                                     |                                     |                       |                           |
| 1/2"   | DN 15     | 21,3 mm           | 2,65 mm        |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            |                     | •                    |                                     |                                     |                       |                           |
| 3/4"   | DN 20     | 26,9 mm           | 2,65 mm        |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            |                     | •                    |                                     |                                     |                       |                           |
| 1"   | DN 25     | 33,7 mm           | 3,25 mm        |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 1.1/4"   | DN 32     | 42,4 mm           | 3,25 mm        |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 1.1/2"   | DN 40     | 48,3 mm           | 3,25 mm        |                     |                      |                                  |                                   |                                   | •                   | •                   |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 2"   | DN 50     | 60,3 mm           | 3,65 mm        |                     |                      |                                  |                                   |                                   |                     |                     |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 2.1/2"   | DN 65     | 76,1 mm           | 3,65 mm        |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              | •                            | •                   |                      |                                     |                                     |                       |                           |
| 3"   | DN 80     | 88,9 mm           | 4,05 mm        |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              | •                            | •                   |                      |                                     |                                     |                       |                           |
| 4"   | DN 100    | 114,3 mm          | 4,50 mm        |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              |                              | •                   |                      |                                     |                                     |                       |                           |
| <b>Gas and water pipes EN 10255-H</b>                |           |                   |                |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              |                              |                     |                      |                                     |                                     |                       |                           |
| 3/8"   | DN 10     | 17,2 mm           | 2,90 mm        |                     |                      |                                  |                                   |                                   | •                   |                     | •                   | •                            | •                            |                     | •                    |                                     |                                     |                       |                           |
| 1/2"   | DN 15     | 21,3 mm           | 3,25 mm        |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            |                     | •                    |                                     |                                     |                       |                           |
| 3/4"   | DN 20     | 26,9 mm           | 3,25 mm        |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            |                     | •                    |                                     |                                     |                       |                           |
| 1"   | DN 25     | 33,7 mm           | 4,05 mm        |                     |                      |                                  |                                   |                                   |                     | •                   | •                   | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 1.1/4"   | DN 32     | 42,4 mm           | 4,05 mm        |                     |                      |                                  |                                   |                                   |                     | •                   | •                   | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 1.1/2"   | DN 40     | 48,3 mm           | 4,05 mm        |                     |                      |                                  |                                   |                                   |                     | •                   |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 2"   | DN 50     | 60,3 mm           | 4,50 mm        |                     |                      |                                  |                                   |                                   |                     |                     |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 2.1/2"   | DN 65     | 76,1 mm           | 4,50 mm        |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              | •                            | •                   |                      |                                     |                                     |                       |                           |
| 3"   | DN 80     | 88,9 mm           | 4,85 mm        |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              | •                            | •                   |                      |                                     |                                     |                       |                           |
| 4"   | DN 100    | 114,3 mm          | 5,40 mm        |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              |                              | •                   |                      |                                     |                                     |                       |                           |
| <b>Distilling pipes EN 10220, metric steel pipes</b> |           |                   |                |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              |                              |                     |                      |                                     |                                     |                       |                           |
| 3/8"   | DN 10     | 17,2 mm           | ≥ 1,80 mm      |                     |                      |                                  |                                   |                                   | •                   |                     |                     |                              |                              |                     |                      |                                     |                                     |                       |                           |
|  |           | 20,0 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                   |                                   | •                   |                     | •                   | •                            | •                            |                     | •                    |                                     |                                     |                       |                           |
| 1/2"   | DN 15     | 21,3 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            |                     |                      |                                     |                                     |                       |                           |
|  |           | 22,0 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                   |                                   | •                   |                     | •                   | •                            | •                            |                     | •                    |                                     |                                     |                       |                           |
|  |           | 25,0 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            | •                   | •                    |                                     |                                     |                       |                           |
| 3/4"   | DN 20     | 26,9 mm           | ≥ 2,30 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            |                     |                      |                                     |                                     |                       |                           |
|  |           | 28,0 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            | •                   | •                    |                                     |                                     |                       |                           |
|  |           | 30,0 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            | •                   | •                    |                                     |                                     |                       |                           |
|  |           | 32,0 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 1"   | DN 25     | 33,7 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   | •                   | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
|  |           | 38,0 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
|  |           | 42,0 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 1.1/4"   | DN 32     | 42,4 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
|  |           | 44,5 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   |                     |                     |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 1.1/2"   | DN 40     | 48,3 mm           | ≥ 2,60 mm      |                     |                      |                                  |                                   |                                   | •                   | •                   |                     | •                            | •                            | •                   |                      |                                     |                                     |                       |                           |
| 2"   | DN 50     | 60,3 mm           | ≥ 2,90 mm      |                     |                      |                                  |                                   |                                   |                     | •                   |                     |                              | •                            | •                   |                      |                                     |                                     |                       |                           |
| 2.1/2"   | DN 65     | 76,1 mm           | ≥ 2,90 mm      |                     |                      |                                  |                                   |                                   |                     |                     |                     |                              | •                            | •                   |                      |                                     |                                     |                       |                           |

depending on size / finish / pipe properties

| Size   | Nominal size | Outer diameter mm | Wall thickness | No. 241500 max. 90° | No. 2423... max. 90° | No. 243.../1100-243100 max. 180° | No. 245610/1100-245680 max. 90° | No. 245611/1100-245681 max. 90° | No. 249... max. 90° | No. 250... max. 90° | No. 256... max. 90° | No. 257.../258... max. 90° | No. 259.../260... max. 90° | No. 261... max. 90° | No. 276... max. 180° | No. 2785.../1101-278501 max. 180° | No. 2786.../1100-278601 max. 180° | No. 2787... max. 180° | No. 1100-278801 max. 180° |
|--|--------------|-------------------|----------------|---------------------|----------------------|----------------------------------|---------------------------------|---------------------------------|---------------------|---------------------|---------------------|----------------------------|----------------------------|---------------------|----------------------|-----------------------------------|-----------------------------------|-----------------------|---------------------------|
| <b>Electrical installation pipes EN 60423</b>              |              |                   |                |                     |                      |                                  |                                 |                                 |                     |                     |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| M 12   |              | 12,0 mm           | ≥ 1,00 mm      |                     |                      |                                  |                                 |                                 | ●                   |                     |                     |                            |                            |                     |                      | ●                                 |                                   |                       |                           |
| M 16   |              | 16,0 mm           | ≥ 1,00 mm      |                     |                      |                                  |                                 |                                 | ●                   |                     |                     |                            |                            |                     |                      | ●                                 |                                   |                       |                           |
| M 20   |              | 20,0 mm           | ≥ 1,00 mm      |                     |                      |                                  |                                 |                                 | ●                   |                     |                     |                            |                            |                     |                      | ●                                 |                                   |                       |                           |
| M 25   |              | 25,0 mm           | ≥ 1,20 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      | ●                                 |                                   |                       |                           |
| M 32   |              | 32,0 mm           | ≥ 1,20 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      | ●                                 |                                   |                       |                           |
| M 40   |              | 40,0 mm           | ≥ 1,20 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| M 50   |              | 50,0 mm           | ≥ 1,20 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| <b>Banister-rail tubes</b>                                 |              |                   |                |                     |                      |                                  |                                 |                                 |                     |                     |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| 3/8"   | DN 10        | 17,2 mm           | ≥ 1,75 mm      |                     |                      |                                  |                                 |                                 | ●                   |                     |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| 1/2"   | DN 15        | 21,3 mm           | ≥ 1,75 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| 3/4"   | DN 20        | 26,9 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| 1"   | DN 25        | 33,7 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| 1.1/4"   | DN 32        | 42,4 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| 1.1/2"   | DN 40        | 48,3 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| 2"   | DN 50        | 60,3 mm           | ≥ 2,00 mm      |                     |                      |                                  |                                 |                                 |                     | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| <b>Multi-layer composite pipes</b>                         |              |                   |                |                     |                      |                                  |                                 |                                 |                     |                     |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
|  |              | 12,0 mm           | ≥ 1,50 mm      |                     | ●                    |                                  | ●                               | ●                               | ●                   |                     |                     |                            |                            |                     |                      |                                   | ●                                 |                       | ●                         |
|  |              | 14,0 mm           | ≥ 2,00 mm      |                     |                      |                                  | ●                               | ●                               |                     |                     |                     |                            |                            |                     |                      |                                   | ●                                 |                       | ●                         |
|  |              | 16,0 mm           | ≥ 2,00 mm      |                     |                      |                                  | ●                               | ●                               | ●                   |                     |                     |                            |                            |                     |                      |                                   | ●                                 |                       | ●                         |
|  |              | 18,0 mm           | ≥ 2,00 mm      |                     | ●                    |                                  | ●                               | ●                               | ●                   |                     |                     |                            |                            |                     |                      |                                   | ●                                 |                       | ●                         |
|  |              | 20,0 mm           | ≥ 2,00 mm      |                     |                      |                                  | ●                               | ●                               | ●                   |                     | ●                   | ●                          | ●                          |                     |                      |                                   |                                   | ●                     | ●                         |
|  |              | 26,0 mm           | ≥ 3,00 mm      |                     |                      |                                  |                                 |                                 |                     |                     |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
|  |              | 32,0 mm           | ≥ 3,00 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   | ●                   | ●                          | ●                          | ●                   |                      |                                   |                                   |                       |                           |
|  |              | 40,0 mm           | ≥ 3,50 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
|  |              | 50,0 mm           | ≥ 4,00 mm      |                     |                      |                                  |                                 |                                 | ●                   | ●                   |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| <b>Copper pipes EN 1057 half-hard, Outer diameter mm</b>   |              |                   |                |                     | 12, 15, 18, 22       |                                  |                                 |                                 | 12-22               |                     |                     |                            |                            |                     |                      |                                   |                                   |                       |                           |
| <b>Copper pipes EN 1057 soft, Outer diameter mm</b>        |              |                   |                | 4,75-10             | 10, 12, 15, 18, 22   | 6-15                             | 10-22                           | 6-22                            | 12-28               |                     |                     |                            |                            |                     | 8-22                 |                                   |                                   |                       |                           |
| <b>Sheathed copper pipes, Outer diameter mm</b>            |              |                   |                |                     | 12, 15, 18, 22       |                                  | 12-22                           | 12-22                           | 12-32               |                     |                     |                            |                            |                     | 12-22                |                                   |                                   |                       |                           |
| <b>Thin-walled NF pipes, Outer diameter mm</b>             |              |                   |                | 4,75-10             | 10, 12, 15, 18, 22   | 6-15                             |                                 |                                 | 12-42               | 25-60,3             |                     |                            |                            |                     | 8-32                 |                                   |                                   |                       |                           |
| <b>Hydraulic pipes EN 10305-1, Outer diameter mm</b>       |              |                   |                | 4,75-6              | 10, 12, 15, 18       | 6-12                             | 10-18                           | 6-18                            | 12-42               | 25-60,3             | 20-32               | 20-42                      | 20-42                      | 25-42               | 8-28                 | 3-10                              | 6-18                              | 20-25                 | 6-25                      |
| <b>Precision steel pipes EN 10305-3, Outer diameter mm</b> |              |                   |                | 4,75-6              | 10, 12, 15, 18       | 6-12                             | 10-18                           | 6-18                            | 12-50               | 25-60,3             | 20-32               | 20-44,5                    | 20-44,5                    | 25-44,5             | 8-28                 | 3-10                              | 6-18                              | 20-25                 | 6-25                      |
| <b>Stainless steel pipes EN 10088-3, Outer diameter mm</b> |              |                   |                |                     | 10, 12, 15, 18       |                                  |                                 | 6-18                            | 12-50               | 25-60,3             | 20-32               | 20-44,5                    | 20-44,5                    | 25-44,5             | 8-28                 | 3-10                              | 6-18                              | 20-25                 | 6-25                      |

depending on size / finish / pipe properties



## Pipe bending pliers

### 2415 PIPE BENDING PLIERS



- > Sizes from 4.75 - 10 mm Ø up to 90°
- > With 2 reversible bending forms 3/16" - 1/4" Ø (4,75 - 6 mm Ø) and 8 - 10 mm Ø
- > For soft copper pipes EN 1057, all non-ferrous metal pipes as well as thin-walled precision steel pipes and brake lines
- > Bright nickel-plated, handles PVC coated



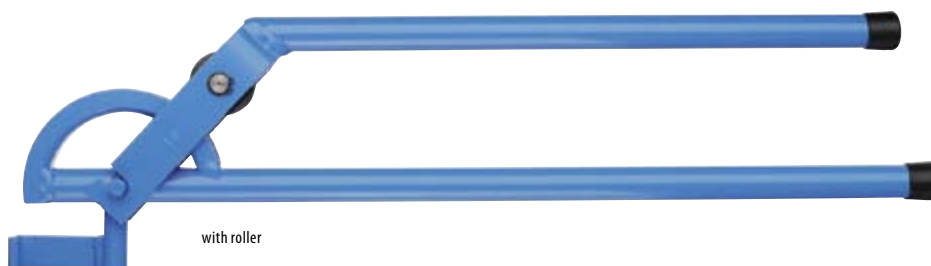
| Ø mm      | Ø inch   | l mm | kg    | Code    | No.    |
|-----------|----------|------|-------|---------|--------|
| 4,75-10,0 | 3/16-3/8 | 260  | 0.580 | 1442007 | 241500 |

### 2423 PIPE BENDING PLIERS



with roller and plastic slide rail

- > Sizes from 10 to 22 mm Ø, bends up to 90°
- > For bendable steel and stainless steel pipes (up to max. 18 x 1.5 mm) as well as soft (also heat-insulated) and semi-hard copper pipes EN 1057
- > Universal use - by exchanging the roller by the plastic slide rail different pipe qualities can be worked
- > Enamelled blue



| Ø mm | r = mm | l mm | kg  | Code    | No.    |
|------|--------|------|-----|---------|--------|
| 10   | 43     | 420  | 1.4 | 4564890 | 242310 |
| 12   | 45     | 420  | 1.4 | 4564970 | 242312 |
| 15   | 60     | 560  | 2.1 | 4565000 | 242315 |
| 18   | 74     | 820  | 2.9 | 4565190 | 242318 |
| 22   | 86     | 820  | 4.2 | 4565270 | 242322 |

## Manual pipe bender - Draw bending operation

1100-2431  
MANUAL BENDING TOOL SET

in L-BOXX® 136



- > Sizes from 6 to 15 mm Ø, up to 180°
- > For soft copper pipes EN 1057 (also with fixed coating), thin-walled precision steel pipes as well as pipes in non-ferrous metals
- > For clamping in a vice or useable as bending pliers
- > Power-saving due to free selectable initial bending angle
- > Easy bending with reversible ratchet 1/2" in long version
- > Enamelled blue
- > Delivery in GEDORE L-BOXX® 136 no. 1100 L
- > Dimensions: W 442 x D 357 x H 151 mm



| Contents                                  | kg  | Code    | No.         |
|---|-----|---------|-------------|
| 1 bending lever No. 243010                | 7.4 | 4568450 | 1100-243100 |
| 1 tool holder no. 243070                  |     |         |             |
| 1 reversible ratchet 1/2" no. 1993 U-10 L |     |         |             |
| 5 bending formers 8, 10, 12, 14, 15 mm    |     |         |             |
| 1 pipe cutter Ø 3-35 mm no. 2250 3        |     |         |             |
| 1 GEDORE L-BOXX® 136 no. 1100 L           |     |         |             |

E 243  
PARTSE 243  
BENDING FORMER

| Description                                 | kg    | Code    | No.         | Ø mm        | r = mm | kg    | Code    | No.    |
|---|-------|---------|-------------|-------------|--------|-------|---------|--------|
| <b>Bending lever</b>                        | 0.980 | 4566320 | 243010      | <b>6,0</b>  | 28     | 0.260 | 4566750 | 243050 |
| <b>Tool holder</b>                          | 0.675 | 2680203 | 243070      | <b>8,0</b>  | 28     | 0.250 | 4566830 | 243051 |
| <b>Reversible ratchet 1/2", long 350 mm</b> | 0.696 | 6154550 | 1993 U-10 L | <b>10,0</b> | 35     | 0.440 | 4567050 | 243053 |
| <b>Pipe cutter for copper pipes 3-35 mm</b> | 0.335 | 2964031 | 2250 3      | <b>12,0</b> | 35     | 0.410 | 4567210 | 243055 |
|   |       |         |             | <b>15,0</b> | 45     | 0.650 | 4567640 | 243058 |





# 2785 MANUAL BENDING TOOL SET

INOX FE

- > Sizes from 3 to 10 mm up to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391), and bendable stainless steel pipes with 0.75 - 1.0 mm wall thicknesses
- > With 5 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8 and 10 mm
- > For clamping in a vice or useable as bending pliers



| Contents  |     | Code    | No.    |
|---|-----|---------|--------|
| <b>1 basic tool body no. 278570</b>                                     | 1.2 | 1589830 | 278500 |
| <b>1 bending lever no. 278581</b>                                       |     |         |        |
| <b>5 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8, 10 mm</b> |     |         |        |

# 1101-2785 MANUAL BENDING TOOL SET

INOX FE

in i-BOXX® 72

- > Sizes from 3 to 10 mm up to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391), and bendable stainless steel pipes with 0.75 - 1.0 mm wall thicknesses
- > With 5 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8 and 10 mm
- > For clamping in a vice or useable as bending pliers
- > With pipe cutter no. 231011 and pipe deburring reamer no. 232501
- > Delivery in GEDORE i-BOXX® 72 no. 1101 L
- > Dimensions: W 367 x D 316 x H 72 mm



1101-278501

| Contents  |     | Code    | No.         |
|---|-----|---------|-------------|
| <b>1 basic tool body no. 278570</b>                                     | 2.4 | 1589849 | 1101-278501 |
| <b>1 bending lever no. 278581</b>                                       |     |         |             |
| <b>5 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8, 10 mm</b> |     |         |             |
| <b>1 miniature pipe cutter Ø 4-16 mm no. 231000</b>                     |     |         |             |
| <b>1 pipe deburring reamer Ø 8-35 no. 232501</b>                        |     |         |             |
| <b>1 GEDORE i-BOXX® 72 no. 1101 L</b>                                   |     |         |             |

## E 2785 PARTS



| Description                                  |       | Code    | No.    |
|--|-------|---------|--------|
| <b>Basic tool body size 0</b>                | 0.640 | 2293625 | 278570 |
| <b>Bending lever size 0</b>                  | 0.380 | 2293641 | 278581 |
| <b>Miniature pipe cutter MINI-QUICK niro</b> | 0.125 | 4554070 | 231011 |
| <b>Pipe deburring reamer 8-35 mm</b>         | 0.180 | 1857681 | 232501 |

## E 2785 BENDING FORMER

> From high-quality aluminium



| Ø mm       | r = mm | Bore mm |       | Code    | No.    |
|------------|--------|---------|-------|---------|--------|
| <b>3-4</b> | 14     | 16      | 0.020 | 1576798 | 278504 |
| <b>5</b>   | 16     | 16      | 0.025 | 2963361 | 278505 |
| <b>6</b>   | 16     | 16      | 0.025 | 1576801 | 278506 |
| <b>8</b>   | 24     | 16      | 0.055 | 1576828 | 278508 |
| <b>10</b>  | 29     | 16      | 0.085 | 1576836 | 278510 |

# 2786 MANUAL BENDING TOOL SET



- > Sizes from 6 to 18 mm up to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391) with 1.0 - 2.0 mm wall thicknesses, composite pipes up to 16 mm as well as bendable stainless steel pipes with 1.0 - 1.5 mm wall thicknesses

- > With 8 bending formers for pipes with Ø 6, 8, 10, 12, 14, 15, 16, 18 mm
- > For clamping in a vice or in combination with tripod no. 268500 for stationary use



Vice not included

| Contents  | kg  | Code    | No.    |
|---|-----|---------|--------|
| <b>1 basic tool body no. 278670</b>   | 5.3 | 1589857 | 278600 |
| <b>1 bending lever no. 278681</b>   |     |         |        |
| <b>8 aluminium bending formers for pipes with Ø 6-8, 10-12, 14, 15, 16, 18 mm</b> |     |         |        |

# 1100-2786 MANUAL BENDING TOOL SET



in L-BOXX® 136

- > Sizes from 6 to 18 mm up to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391) with 1.0 - 2.0 mm wall thicknesses, composite pipes up to 16 mm as well as bendable stainless steel pipes with 1.0 - 1.5 mm wall thicknesses
- > With 8 bending formers for pipes with Ø 6, 8, 10, 12, 14, 15, 16, 18 mm
- > For clamping in a vice or in combination with tripod no. 268500 for stationary use
- > With pipe cutter no. 2180 3
- > Delivery in GEDORE L-BOXX® 136 no. 1100 L
- > Dimensions: W 442 x D 357 x H 151 mm



| Contents  | kg  | Code    | No.         |
|---|-----|---------|-------------|
| <b>1 basic tool body no. 278670</b>   | 8.3 | 1611526 | 1100-278601 |
| <b>1 bending lever pluggable no. 278680</b>                                       |     |         |             |
| <b>8 aluminium bending formers for pipes with Ø 6-8, 10-12, 14, 15, 16, 18 mm</b> |     |         |             |
| <b>1 pipe cutter Ø 3-35 mm no. 2180 3</b>   |     |         |             |
| <b>1 pin punch 3 mm</b>   |     |         |             |
| <b>1 GEDORE L-BOXX® 136 no. 1100 L</b>  |     |         |             |



# 1100-2788 MANUAL BENDING TOOL SET



in L-BOXX® 136

- > Sizes from 3 to 10 mm up to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391) with 0.75 - 2.0 mm wall thicknesses, composite pipes up to 16 mm as well as bendable stainless steel pipes with 1.0 - 1.5 mm wall thicknesses
- > With 10 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8, 10, 12, 14, 15, 16 and 18 mm
- > For clamping in a vice
- > Can be used as bending pliers up to size 10 mm
- > As from sizes 12 mm also for stationary use with tripod no. 268500
- > With pipe cutter no. 2180 3
- > Delivery in GEDORE L-BOXX® 136 no. 1100 L
- > Dimensions: W 442 x D 357 x H 151 mm



Contents

- 1 basic tool body 3-18 mm no. 278570
- 1 bending lever 3-18 mm no. 278581
- 1 basic tool body 6-18 mm no. 278670
- 1 bending lever 6-18 mm pluggable no. 278680
- 10 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8, 10, 12, 14, 15, 16, 18 mm
- 1 pipe cutter Ø 3-35 mm no. 2180 3
- 1 pin punch 3 mm
- 1 GEDORE L-BOXX® 136 no. 1100 L



8.7

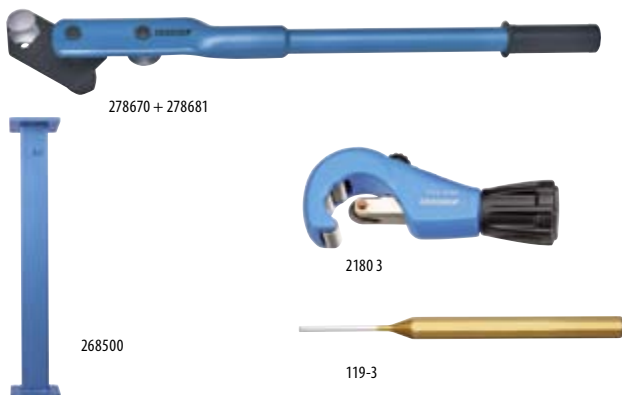
Code

2963515

No.

1100-278801

## E 2786 PARTS



## E 2786 BENDING FORMER

> From high-quality aluminium



| Description  | kg   | Code    | No.    |
|--|------|---------|--------|
| <b>Basic tool body size 1</b>                        | 1.2  | 1677209 | 278670 |
| <b>Bending lever size 1</b>                          | 2.3  | 2293692 | 278681 |
| <b>Bending lever size 1 pluggable</b>                | 1.9  | 1626043 | 278680 |
| <b>Tripod</b>  | 21.2 | 2681072 | 268500 |
| <b>Pipe cutter for stainless steel pipes 3-35 mm</b> | 0.3  | 2964066 | 2180 3 |
| <b>Pin punch 3 mm</b>                                | 0.1  | 8758800 | 119-3  |

| Ø mm      | r = mm | Bore mm | kg    | Code    | No.    |
|-----------|--------|---------|-------|---------|--------|
| <b>6</b>  | 32     | 30      | 0.200 | 2963442 | 278606 |
| <b>8</b>  | 32     | 30      | 0.200 | 1576844 | 278608 |
| <b>10</b> | 36     | 30      | 0.220 | 2963450 | 278610 |
| <b>12</b> | 36     | 30      | 0.220 | 1576852 | 278612 |
| <b>14</b> | 36     | 30      | 0.200 | 1576879 | 278614 |
| <b>15</b> | 43     | 30      | 0.320 | 1576887 | 278615 |
| <b>16</b> | 43     | 30      | 0.320 | 1576895 | 278616 |
| <b>18</b> | 50     | 30      | 0.450 | 1576909 | 278618 |

# 2787

## MANUAL BENDING TOOL SET



- > Sizes from 20 to 25 mm up to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391) with 1.5 - 2.5 mm wall thicknesses, composite pipes up to 25 mm as well as bendable stainless steel pipes with 1.5 - 2.0 mm wall thicknesses
- > For clamping in a vice
- > With 3 aluminium bending formers for pipes with Ø 20, 22, 25 mm
- > Enamelled blue, with black plastic handles



Vice not included

| Contents  | kg   | Code    | No.    |
|---|------|---------|--------|
| <b>1 basic tool body no. 278770</b>                               | 13.0 | 1589865 | 278700 |
| <b>1 bending lever no. 278781</b>                                 |      |         |        |
| <b>3 aluminium bending formers for pipes with Ø 20, 22, 25 mm</b> |      |         |        |

## E 2787

### PARTS



278770 + 278781



268500

## E 2787

### BENDING FORMER

- > From high-quality aluminium



| Description                   | kg   | Code    | No.    | Ø mm      | r = mm | Bore mm | kg  | Code    | No.    |
|-------------------------------|------|---------|--------|-----------|--------|---------|-----|---------|--------|
| <b>Basic tool body size 2</b> | 4.1  | 2293706 | 278770 | <b>20</b> | 85     | 42      | 2.0 | 1576917 | 278720 |
| <b>Bending lever size 2</b>   | 3.0  | 2293722 | 278781 | <b>22</b> | 85     | 42      | 2.0 | 1576925 | 278722 |
| <b>Tripod</b>                 | 21.2 | 2681072 | 268500 | <b>25</b> | 85     | 42      | 2.0 | 1576933 | 278725 |



# 276 UNIVERSAL PIPE BENDER



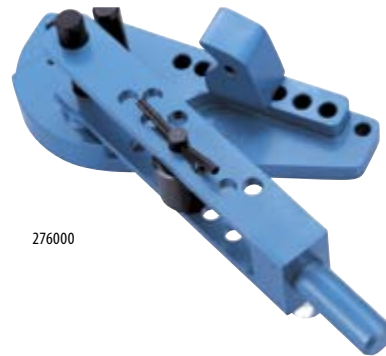
- > Sizes from 8 to 32 mm Ø and 3/8 to 3/4" up to 180°
- > For semi-hard and soft copper pipes EN 1057 up to 22 mm Ø, stainless steel pipes EN 10088-3 (DIN 17 440) up to 28 x 1.5 mm, hydraulic pipes EN 10305-1 (DIN 2391) and precision steel pipes EN 10305-3 (DIN 2394) up to 28 mm, electrical installation pipes EN 60423 up to M 32, composite pipes up to 32 mm, non-ferrous metal pipes and insulated pipes as well as gas and water pipes EN 10255 (DIN 2440/2441) up to 3/4"
- > For use in a vice or installation on the workbench
- > Set up for connecting to a length and angle stop as well as bending lever extension possible (not included)
- > Enamelled blue



276001




280130



276000



268500

| Description   |  kg | Code    | No.    |
|---|--|---------|--------|
| <b>Basic equipment with bending lever extension no. 268230, without bending tools</b> | 16.7   | 4600010 | 276000 |
| <b>Angled stop</b>  | 1.8  | 4600280 | 276001 |
| <b>Length stop</b>  | 0.7  | 4606210 | 280130 |
| <b>Tripod, height 990 mm</b>  | 21.2   | 2681072 | 268500 |

## E 276 BENDING TOOLS

- > No. 276508-276532: Bending former with aluminium slide rail for metric pipes
- > No. 276103-276107: Bending former for gas and water pipes EN 10255 (DIN 2440/2441), use with

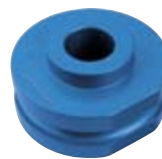
pressure roller no. 276003 (3/8-3/4")




2765



2761



276003

| Description                                 | Ø mm | Size    | r = mm | Electrical installation ducts EN 60423 |  kg | Code    | No.    |
|---|------|---------|--------|--|--|---------|--------|
| <b>Bending former with slide rail 8 mm</b>  | 8,0  |         | 40     |  | 1.4  | 4601090 | 276508 |
| <b>Bending former with slide rail 10 mm</b> | 10,0 |         | 40     |  | 1.4  | 4601170 | 276510 |
| <b>Bending former with slide rail 12 mm</b> | 12,0 |         | 40     |  | 1.4  | 4601250 | 276512 |
| <b>Bending former with slide rail 14 mm</b> | 14,0 |         | 50     |  | 1.9  | 4601330 | 276514 |
| <b>Bending former with slide rail 15 mm</b> | 15,0 |         | 50     |  | 1.8  | 4601410 | 276515 |
| <b>Bending former with slide rail 16 mm</b> | 16,0 |         | 68     |  | 4.7  | 4601680 | 276516 |
| <b>Bending former 3/8"</b>                  | 17,2 | 3/8     | 50     |  | 1.6  | 4600600 | 276103 |
| <b>Bending former with slide rail 18 mm</b> | 18,0 |         | 68     |  | 4.7  | 4601760 | 276518 |
| <b>Bending former with slide rail 20 mm</b> | 20,0 |         | 68     |  | 4.6  | 4601920 | 276520 |
| <b>Bending former 1/2"</b>                  | 21,3 | 1/2     | 68     |  | 2.4  | 4600790 | 276105 |
| <b>Bending former with slide rail 22 mm</b> | 22,0 |         | 81     |  | 6.5  | 4602060 | 276522 |
| <b>Bending former with slide rail 25 mm</b> | 25,0 |         | 105    | M25                                    | 4.7  | 4602140 | 276525 |
| <b>Bending former 3/4"</b>                  | 26,9 | 3/4     | 80     |  | 5.8  | 4600870 | 276107 |
| <b>Bending former with slide rail 28 mm</b> | 28,0 |         | 126    |  | 5.4  | 4602300 | 276528 |
| <b>Bending former with slide rail 30 mm</b> | 30,0 |         | 153    |  | 7.0  | 4602490 | 276530 |
| <b>Bending former with slide rail 32 mm</b> | 32,0 |         | 153    | M32                                    | 7.0  | 4602570 | 276532 |
| <b>Pressure roller</b>                      |      | 3/8-3/4 |        |  | 0.5  | 4600360 | 276003 |

## Manual pipe bender - Pushing bending operation

### 2456 BENDING TOOL SET

hydraulic

- > Sizes from 10 to 22 mm Ø up to 90°
- > For soft copper pipes EN 1057 up to 22 mm (also heat-insulated), composite pipes up to 20 mm as well as precision steel pipes EN 10305-3 (DIN 2394) up to 18 x 1.5 mm
- > With 7 bending formers for pipes with Ø 10, 12, 14, 15, 18, 20 and 22 mm and corresponding counter-supports
- > Hydraulic drive without great effort
- > Delivery in plastic case no. 245590



| Contents  | kg  | Code    | No.    |
|---|-----|---------|--------|
| <b>1 base unit, hydraulic no. 245670</b>                              | 6.2 | 4635230 | 245610 |
| <b>7 bending tools for pipes with Ø 10, 12, 14, 15, 18, 20, 22 mm</b> |     |         |        |
| <b>1 plastic case no. 245590</b>                                      |     |         |        |

### 1100-2456 BENDING TOOL SET

hydraulic, in L-BOXX® 136

- > Sizes from 10 to 22 mm Ø up to 90°
- > For soft copper pipes EN 1057 up to 22 mm (also heat-insulated), composite pipes up to 20 mm as well as precision steel pipes EN 10305-3 (DIN 2394) up to 18 x 1.5 mm
- > With 7 bending formers for pipes with Ø 10, 12, 14, 15, 18, 20 and 22 mm and corresponding counter-supports
- > Hydraulic drive without great effort
- > With pipe cutter no. 2250 3
- > Delivery in GEDORE L-BOXX® 136 no. 1100 L
- > Dimensions: W 442 x D 357 x H 151 mm



| Contents  | kg  | Code    | No.         |
|---|-----|---------|-------------|
| <b>1 base unit, hydraulic no. 245670</b>  | 6.9 | 2963531 | 1100-245680 |
| <b>7 aluminium bending formers for pipes with Ø 10, 12, 14, 15, 18, 20, 22 mm</b> |     |         |             |
| <b>3 counter-supports reinforced Ø 6-12, 14-17, 18-22 mm</b>                      |     |         |             |
| <b>1 pipe cutter Ø 3-35 mm no. 2250 3</b>   |     |         |             |
| <b>1 GEDORE L-BOXX® 136 no. 1100 L</b>  |     |         |             |

### 2456 BENDING TOOL SET

hydraulic, heavy-duty

- > Sizes from 6 to 22 mm Ø up to 90°
- > For soft copper pipes EN 1057 up to 22 mm (also heat-insulated), composite pipes up to 20 mm, precision steel pipes EN 10305-3 (DIN 2394) up to 18 x 2 mm, as well as annealed stainless steel pipes up to 18 x 1.2 mm
- > With 10 bending formers for pipes with Ø 6, 8, 10, 12, 14, 15, 16, 18, 20 and 22 mm and corresponding counter-supports
- > Hydraulic drive without great effort
- > In plastic case no. 245690



| Contents   | kg  | Code    | No.    |
|--|-----|---------|--------|
| <b>1 base unit, hydraulic no. 245670</b>   | 7.5 | 1585495 | 245611 |
| <b>10 bending tools for pipes with Ø 6, 8, 10, 12, 14, 15, 16, 18, 20, 22 mm</b> |     |         |        |
| <b>1 plastic case no. 245690</b>   |     |         |        |



# 1100-2456 BENDING TOOL SET



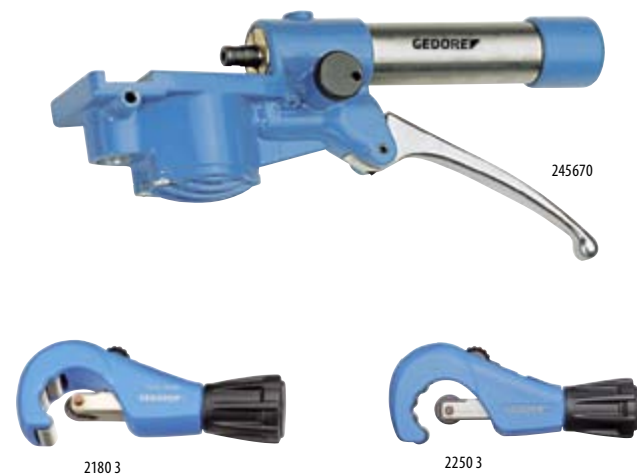
hydraulic, heavy-duty, in L-BOXX® 136

- > Sizes from 6 to 22 mm Ø up to 90°
- > For soft copper pipes EN 1057 up to 22 mm (also heat-insulated), composite pipes up to 20 mm, precision steel pipes EN 10305-3 (DIN 2394) up to 18 x 2 mm, as well as annealed stainless steel pipes up to 18 x 1.2 mm
- > With 10 bending formers for pipes with Ø 6, 8, 10, 12, 14, 15, 16, 18, 20 and 22 mm and corresponding counter-supports
- > Hydraulic drive without great effort
- > With pipe cutter no. 2180 3
- > Delivery in GEDORE L-BOXX® 136 no. 1100 L
- > Dimensions: W 442 x D 357 x H 151 mm



| Contents  | kg  | Code    | No.         |
|---|-----|---------|-------------|
| <b>1 base unit, hydraulic no. 245670</b><br><b>10 aluminium bending formers for pipes with Ø 6, 8, 10, 12, 14, 15, 16, 18, 20, 22 mm</b><br><b>1 counter-support Ø 6-12 mm</b><br><b>2 counter-supports reinforced Ø 14-17, 18-22 mm</b><br><b>1 pipe cutter Ø 3-35 mm no. 2180 3</b><br><b>1 GEDORE L-BOXX® 136 no. 1100 L</b> | 8.2 | 2963558 | 1100-245681 |

## E 2456 PARTS



| Description  | kg    | Code    | No.    |
|--|-------|---------|--------|
| <b>Basic unit, hydraulic</b>                         | 2.350 | 4635310 | 245670 |
| <b>Pipe cutter for copper pipes 3-35 mm</b>          | 0.335 | 2964031 | 2250 3 |
| <b>Pipe cutter for stainless steel pipes 3-35 mm</b> | 0.335 | 2964066 | 2180 3 |

## E 2457 - E 2458 BENDING TOOLS

- > The counter-support no. 245710-245731 are needed
- > For metric pipes



| Description                                | Ø mm  | r = mm | kg    | Code    | No.    |
|--|-------|--------|-------|---------|--------|
| <b>Cast aluminium bending former 6 mm</b>  | 6     | 31     | 0.100 | 4635900 | 245806 |
| <b>Cast aluminium bending former 8 mm</b>  | 8     | 31     | 0.100 | 4636040 | 245808 |
| <b>Cast aluminium bending former 10 mm</b> | 10    | 31     | 0.100 | 4636120 | 245810 |
| <b>Cast aluminium bending former 12 mm</b> | 12    | 34     | 0.110 | 4636200 | 245812 |
| <b>Cast aluminium bending former 14 mm</b> | 14    | 41     | 0.120 | 4636390 | 245814 |
| <b>Cast aluminium bending former 15 mm</b> | 15    | 48     | 0.140 | 4636470 | 245815 |
| <b>Cast aluminium bending former 16 mm</b> | 16    | 49     | 0.150 | 4636550 | 245816 |
| <b>Cast aluminium bending former 18 mm</b> | 18    | 72     | 0.190 | 4636710 | 245818 |
| <b>Cast aluminium bending former 20 mm</b> | 20    | 80     | 0.200 | 4636980 | 245820 |
| <b>Cast aluminium bending former 22 mm</b> | 22    | 88     | 0.200 | 4637010 | 245822 |
| <b>Counter-support 6-12 mm</b>             | 6-12  |        | 0.380 | 4635580 | 245710 |
| <b>Counter-support 14-17 mm</b>            | 14-17 |        | 0.460 | 4635660 | 245720 |
| <b>Counter-support 14-17 mm reinforced</b> | 14-17 |        | 0.380 | 1585509 | 245721 |
| <b>Counter-support 18-22 mm</b>            | 18-22 |        | 0.460 | 4635740 | 245730 |
| <b>Counter-support 18-22 mm reinforced</b> | 18-22 |        | 0.480 | 1585517 | 245731 |

Pipe bending machines - Draw bending operation

249  
PIPE BENDING MACHINE

manual-hydraulic



- > Sizes from 12 to 50 mm Ø and 3/8" to 1.1/2" up to 90°
- > For copper pipes EN 1057, precision steel pipes EN 10305-3 (DIN 2394) and hydraulic pipes EN 10305-1 (DIN 2391), stainless steel pipes EN 10088-3 (DIN 17 440) up to 42 mm, uncoated pipes and pipes with fixed coating, composite pipes as well as electrical installation pipes EN 60423

- > Pressure 100 kN
- > On pivotable tripod
- > Delivery in wooden assembly case

**Bending tools for further pipe types and sizes available on request**



| Contents   | kg   | Code    | No.    |
|--|------|---------|--------|
| 1 pump manual-hydraulic no. 254200                                 | 76.0 | 4580150 | 249000 |
| 1 base unit with pivotable tripod no. 249310 without bending tools |      |         |        |

249  
PIPE BENDING MACHINE

electro-hydraulic

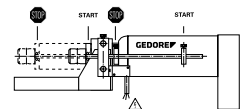


- > Sizes from 12 to 50 mm Ø and 3/8" to 1.1/2" up to 90°
- > For copper pipes EN 1057, precision steel pipes EN 10305-3 (DIN 2394) and hydraulic pipes EN 10305-1 (DIN 2391), stainless steel pipes EN 10088-3 (DIN 17 440) up to 42 mm, uncoated pipes and pipes with fixed coating, composite pipes as well as electrical installation pipes EN 60423
- > Electrical limiter for continuous pre-setting and repetition in the production of pipe bends
- > Pressure 100 kN
- > On pivotable tripod
- > Delivery in wooden assembly case

**Bending tools for further pipe types and sizes available on request**



Electrical limiter



| Contents   | kg    | Code    | No.    |
|--|-------|---------|--------|
| 1 pump electro-hydraulic 380-415 V 50/60 Hz no. 254601             | 111.0 | 4580230 | 249001 |
| 1 base unit with pivotable tripod no. 249311 without bending tools |       |         |        |
| 1 pump electro-hydraulic 230 V 50/60 Hz no. 254651                 | 111.0 | 1547593 | 249002 |
| 1 base unit with pivotable tripod no. 249311 without bending tools |       |         |        |

254



>633





# E 249

## BENDING TOOLS

- > Consisting of bending former, pipe holder and aluminium slide rail
- > Bending formers, pipe holders and steel bending rails are available on request for shaping stainless steel pipes - chemically nickel plated
- > Special sizes available on request



| Ø mm  | Size  | Electrical installation ducts<br>EN 60423 | Precision steel pipes<br>EN 10305-3 | Cu pipes<br>EN 1057 | r = mm | Code    | No.    |
|-------|-------|---|-------------------------------------|---------------------|--------|---------|--------|
| 12,0  |       | M12                                       | 12                                  | 12                  | 85     | 1527339 | 249812 |
| 12,7  |       |   |                                     |                     | 100    | 2125242 | 249605 |
| 15,0  |       |   | 15                                  | 15                  | 85     | 4640660 | 249815 |
| 15,88 |       |   |                                     |                     | 100    | 2125250 | 249606 |
| 16,0  |       | M16                                       | 16                                  |                     | 85     | 4654290 | 249816 |
| 17,2  | 3/8   |   |                                     |                     | 85     | 1742655 | 249503 |
| 18,0  |       |   | 18                                  | 18                  | 85     | 4654370 | 249818 |
| 19,05 |       |   |                                     |                     | 100    | 2125269 | 249607 |
| 20,0  |       |   | 20                                  |                     | 85     | 4654530 | 249820 |
| 21,3  | 1/2   |   |                                     |                     | 100    | 1639935 | 249505 |
| 22,0  |       |   | 22                                  | 22                  | 85     | 4654610 | 249822 |
| 22,22 |       |   |                                     |                     | 150    | 2125277 | 249608 |
| 25,0  |       |   | 25                                  |                     | 85     | 4582520 | 249825 |
| 25,0  |       | M25                                       | 25                                  |                     | 100    | 1546120 | 249025 |
| 25,4  |       |   |                                     |                     | 200    | 2125293 | 249610 |
| 26,9  | 3/4   |   |                                     |                     | 100    | 1422820 | 249507 |
| 28,0  |       |   | 28                                  |                     | 85     | 4582600 | 249828 |
| 28,0  |       |   | 28                                  |                     | 100    | 4580310 | 249028 |
| 30,0  |       |   | 30                                  |                     | 85     | 4582790 | 249830 |
| 30,0  |       |   | 30                                  |                     | 100    | 4580580 | 249030 |
| 31,75 |       |   |                                     |                     | 200    | 2125315 | 249612 |
| 32,0  |       | M32                                       | 32                                  |                     | 150    | 1546147 | 249132 |
| 33,7  | 1     |   |                                     |                     | 150    | 1276190 | 249510 |
| 35,0  |       |   | 35                                  |                     | 150    | 4580900 | 249135 |
| 38,0  |       |   | 38                                  |                     | 150    | 4581120 | 249138 |
| 40,0  |       | M40                                       | 40                                  |                     | 200    | 1546163 | 249240 |
| 42,0  |       |   | 42                                  |                     | 200    | 1561944 | 249242 |
| 42,4  | 1.1/4 |   |                                     |                     | 150    | 1549561 | 249512 |
| 48,3  | 1.1/2 |   |                                     |                     | 200    | 1232401 | 249515 |
| 50,0  |       | M50                                       | 50                                  |                     | 200    | 4581710 | 249250 |

# 250


## PIPE BENDING MACHINE

manual-hydraulic

- > Sizes from 25 to 54 mm Ø and 1/2" to 2" up to 180°
- > Especially suitable for thornless bending of thin-walled stainless steel pipes EN 10088-3 (DIN 17 440) over 0.8 mm wall thickness
- > Also for copper pipes EN 1057, precision steel pipes EN 10305-3 (DIN 2394) and hydraulic pipes EN 10305-1 (DIN 2391), NF pipes, uncoated pipes as well as electrical installation pipes EN 60423
- > Pressure 160 kN
- > On pivotable tripod
- > Delivery in wooden assembly case

**Bending tools for further pipe types and sizes available on request**



| Contents                           |  | Code    | No.    |
|------------------------------------|---|---------|--------|
| 1 pump manual-hydraulic no. 254300 | 155.0   | 4583760 | 250000 |
| 1 base unit no. 250010             |   |         |        |
| 1 pivotable tripod no. 268001      |   |         |        |
| without bending tools              |   |         |        |

# 250 PIPE BENDING MACHINE

electro-hydraulic



- > Sizes from 25 to 54 mm Ø and 1/2" to 2" up to 180°
- > Especially suitable for thornless bending of thin-walled stainless steel pipes EN 10088-3 (DIN 17 440) over 0.8 mm wall thickness
- > Also for copper pipes EN 1057, precision steel pipes EN 10305-3 (DIN 2394) and hydraulic pipes EN 10305-1 (DIN 2391), NF pipes, uncoated pipes as well as electrical installation pipes EN 60423
- > Electrical limiter for continuous pre-setting and repetition in the production of pipe bends
- > Pressure 160 kN
- > On pivotable tripod
- > Delivery in wooden assembly case



**Bending tools for further pipe types and sizes available on request**

| Contents   |       | Code    | No.    |
|--|-------|---------|--------|
| <b>1 pump electro-hydraulic 380-415 V 50/60 Hz no. 254701</b><br><b>1 base unit no. 250010</b><br><b>1 pivotable tripod no. 268001</b><br><b>without bending tools</b> | 175.0 | 4583840 | 250001 |
| <b>1 pump electro-hydraulic 230 V 50/60 Hz no. 254751</b><br><b>1 base unit no. 250010</b><br><b>1 pivotable tripod no. 268001</b><br><b>without bending tools</b>     | 175.0 | 1380133 | 250002 |

# E 250 BENDING SETS

- > Consisting of bending former with aluminium slide rail and pipe holder
- > Bending formers, pipe holders and steel bending rails are available on request for shaping stainless steel pipes - chemically nickel plated
- > Special sizes available on request



| Ø mm  | Size  | Electrical installation ducts<br>EN 60423 | Precision steel pipes<br>EN 10305-3 | r = mm |        | Code    | No.    |
|-------|-------|---|-------------------------------------|--------|--------|---------|--------|
| 12,7  |       |   |                                     | 100    | 3.900  | 2125242 | 249605 |
| 15,88 |       |   |                                     | 100    | 3.900  | 2125250 | 249606 |
| 19,05 |       |   |                                     | 100    | 3.900  | 2125269 | 249607 |
| 21,3  | 1/2   |   |                                     | 100    | 4.000  | 1639935 | 249505 |
| 22,22 |       |   |                                     | 150    | 7.500  | 2125277 | 249608 |
| 25,0  |       | M25                                       | 25                                  | 100    | 3.940  | 1546120 | 249025 |
| 25,4  |       |   |                                     | 200    | 12.900 | 2125293 | 249610 |
| 26,9  | 3/4   |   |                                     | 100    | 6.500  | 1422820 | 249507 |
| 28,0  |       |   | 28                                  | 100    | 3.520  | 4580310 | 249028 |
| 30,0  |       |   | 30                                  | 100    | 3.740  | 4580580 | 249030 |
| 30,0  |       |   | 30                                  | 150    | 13.000 | 1679155 | 250330 |
| 31,75 |       |   |                                     | 200    | 12.900 | 2125315 | 249612 |
| 32,0  |       | M32                                       | 32                                  | 150    | 7.500  | 1546147 | 249132 |
| 33,7  | 1     |   |                                     | 150    | 7.500  | 1276190 | 249510 |
| 35,0  |       |   | 35                                  | 150    | 7.280  | 4580900 | 249135 |
| 38,0  |       |   | 38                                  | 150    | 7.080  | 4581120 | 249138 |
| 38,1  |       |   | 250                                 | 250    | 21.000 | 2125161 | 250615 |
| 40,0  |       | M40                                       | 40                                  | 200    | 12.920 | 1546163 | 249240 |
| 42,0  |       |   | 42                                  | 200    | 13.400 | 1561944 | 249242 |
| 42,4  | 1.1/4 |   |                                     | 150    | 7.500  | 1549561 | 249512 |
| 42,4  | 1.1/4 |   | 1.1/4                               | 200    | 15.000 | 4655340 | 250312 |
| 44,44 |       |   |                                     | 300    | 31.000 | 2125188 | 250617 |
| 48,3  | 1.1/2 |   |                                     | 200    | 14.500 | 1232401 | 249515 |
| 48,3  | 1.1/2 |   | 1.1/2                               | 250    | 21.000 | 4655420 | 250315 |
| 50,0  |       | M50                                       | 50                                  | 200    | 13.120 | 4581710 | 249250 |
| 50,8  |       |   |                                     | 300    | 31.000 | 2125226 | 250620 |
| 52,0  |       |   | 52                                  | 350    | 41.000 | 4640900 | 250352 |
| 54,0  |       |   | 54                                  | 250    | 21.000 | 2001152 | 250354 |
| 60,3  | 2     |   |                                     | 250    | 21.000 | 1148001 | 250520 |
| 60,3  | 2     |   | 2                                   | 400    | 55.000 | 4655500 | 250320 |



Pipe bending machines - Pushing bending operation

MAX. BENDING CAPACITIES PIPE BENDING MACHINES 256-261

| Pipe bending machine No. | Gas and water pipes<br>EN 10255 (DIN 2440/2441) | Distilling pipes<br>EN 10220 (DIN 2448) |           | Metric tubes *)   |
|--------------------------|---|---|-----------|-------------------|
|                          | up to 90°<br>Size                               | up to 90°<br>Size                       | ∅ mm      | up to 90°<br>∅ mm |
| 256                      | 3/8 - 1.1/4"                                    | 1/2 - 1"                                | 20 - 32   | 20 - 32           |
| 257 - 258                | 3/8 - 2"  | 1/2 - 1.1/2"                            | 20 - 44,5 | 20 - 44,5         |
| 259 - 260                | 3/8 - 3"  | 1/2 - 2.1/2"                            | 20 - 44,5 | 20 - 44,5         |
| 261                      | 1 - 4"  | 1 - 2.1/2"                              | 25 - 44,5 | 25 - 44,5         |

\*) Specifications under reserve - as these are dependent on the respective wall thickness

256  
PIPE BENDING MACHINE 3/8" - 1.1/4"



- > For gas and water pipes EN 10255 (DIN 2440/2441) up to max. 90°
- > With open bending frame
- > Pressure 60 kN
- > Delivery in assembly case

Available in various designs:

- > - manually or electro-hydraulically operated
- > - as the basic tool without bending former or as a set with bending former no. 263103-112

Optional bending tools under no. 263 - 264 available for:

- > - Distilling pipes EN 10220 (DIN 2448) from 1/2 to 1" or 20 to 32 mm
- > - Metric pipes from 20 to 32 mm

Bending tools for further pipe types and sizes and for stainless steel pipes on request



| included in delivery  | Ill. | kg   | Code    | No.    |
|---|------|------|---------|--------|
| manual-hydraulic, open bending frame, without bending formers                                   | C    | 47.0 | 4586860 | 256000 |
| manual-hydraulic, open bending frame, with 5 bending formers no. 263103-112                     | C    | 56.0 | 4586940 | 256100 |
| electro-hydraulic 380-415 V 50/60 Hz, open bending frame, without bending formers               | D    | 73.0 | 4587080 | 256500 |
| electro-hydraulic 380-415 V 50/60 Hz, open bending frame, with 5 bending formers no. 263103-112 | D    | 82.0 | 4587160 | 256510 |
| electro-hydraulic 230 V 50/60 Hz, open bending frame, without bending formers                   | D    | 73.0 | 4587240 | 256600 |
| electro-hydraulic 230 V 50/60 Hz, open bending frame, with 5 bending formers no. 263103-112     | D    | 82.0 | 4587320 | 256610 |

## 257 - 258

## PIPE BENDING MACHINE 3/8" - 2"

INOX FE

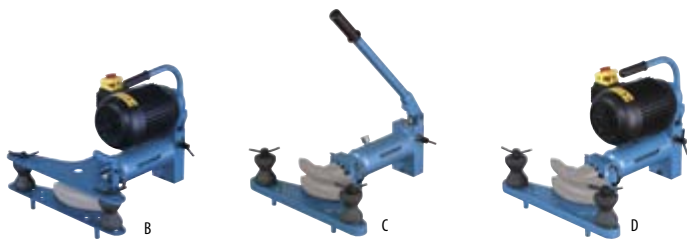
- > For gas and water pipes EN 10255 (DIN 2440/2441) up to max. 90°
- > Pressure 100 kN
- > Delivery in assembly case


**Available in various designs:**

- > - manually or electro-hydraulically operated
- > - with open or fold-open bending frame
- > - as the basic tool without bending former or as a set with bending former no. 263103-120

**Optional bending tools under no. 263 - 264 available for:**

- > - Distilling pipes EN 10220 (DIN 2448) from 1/2 to 1.1/2" or 20 to 44.5 mm
- > - Metric pipes from 20 to 44.5 mm

**Bending tools for further pipe types and sizes and for stainless steel pipes on request****MODEL 257:****FOLD-OPEN BENDING FRAME FOR MOBILE USE****MODEL 258:****OPEN BENDING FRAME FOR QUICK AND EFFICIENT WORKING**

| included in delivery   | III. |  | Code    | No.    |
|--|------|---|---------|--------|
| manual-hydraulic,<br>fold-open bending frame,<br>without bending formers                                   | A    | 54.0  | 4587400 | 257000 |
| manual-hydraulic,<br>fold-open bending frame,<br>with 7 bending formers no. 263103-120                     | A    | 75.0  | 4587590 | 257100 |
| electro-hydraulic 380-415 V 50/60 Hz,<br>fold-open bending frame,<br>without bending formers               | B    | 78.0  | 4587670 | 257500 |
| electro-hydraulic 380-415 V 50/60 Hz,<br>fold-open bending frame,<br>with 7 bending formers no. 263103-120 | B    | 99.0  | 4587750 | 257510 |
| electro-hydraulic 230 V 50/60 Hz,<br>fold-open bending frame,<br>without bending formers                   | B    | 78.0  | 4587830 | 257600 |
| electro-hydraulic 230 V 50/60 Hz,<br>fold-open bending frame,<br>with 7 bending formers no. 263103-120     | B    | 99.0  | 4587910 | 257610 |
| manual-hydraulic,<br>open bending frame,<br>without bending formers  | C    | 73.0  | 4588050 | 258000 |
| manual-hydraulic,<br>open bending frame,<br>with 7 bending formers no. 263103-120                          | C    | 95.0  | 4588130 | 258100 |
| electro-hydraulic 380-415 V 50/60 Hz,<br>open bending frame,<br>without bending formers                    | D    | 98.0  | 4588210 | 258500 |
| electro-hydraulic 380-415 V 50/60 Hz,<br>open bending frame,<br>with 7 bending formers no. 263103-120      | D    | 119.0   | 4588480 | 258510 |
| electro-hydraulic 230 V 50/60 Hz,<br>open bending frame,<br>without bending formers                        | D    | 98.0  | 4588560 | 258600 |
| electro-hydraulic 230 V 50/60 Hz,<br>open bending frame,<br>with 7 bending formers no. 263103-120          | D    | 119.0   | 4588640 | 258610 |



# 259 - 260

## PIPE BENDING MACHINE 3/8" - 3"



- > For gas and water pipes EN 10255 (DIN 2440/2441) up to max. 90°
- > Pressure 160 kN
- > Delivery in assembly case

**Available in various designs:**

- > - manually or electro-hydraulically operated
- > - with open or fold-open bending frame
- > - as the basic tool without bending former or as a set with bending former no. 263103-130

**Optional bending tools under no. 263 - 264 available for:**

- > - Distilling pipes EN 10220 (DIN 2448) from 1/2 to 2.1/2" or 20 to 44.5 mm
- > - Metric pipes from 20 to 44.5 mm

**Bending tools for further pipe types and sizes and for stainless steel pipes on request**

**MODEL 259:**

**FOLD-OPEN BENDING FRAME FOR MOBILE USE**

**MODEL 260:**

**OPEN BENDING FRAME FOR STATIONARY USE AND QUICK AND EFFICIENT WORKING**



| included in delivery  | III. | kg    | Code    | No.    |
|---|------|-------|---------|--------|
| <b>manual-hydraulic, fold-open bending frame, without bending formers</b>                                   | A    | 98.0  | 4588720 | 259000 |
| <b>manual-hydraulic, fold-open bending frame, with 9 bending formers no. 263103-130</b>                     | A    | 173.0 | 4588800 | 259100 |
| <b>electro-hydraulic 380-415 V 50/60 Hz, fold-open bending frame, without bending formers</b>               | B    | 123.0 | 4588990 | 259500 |
| <b>electro-hydraulic 380-415 V 50/60 Hz, fold-open bending frame, with 9 bending formers no. 263103-130</b> | B    | 198.0 | 4589020 | 259510 |
| <b>electro-hydraulic 230 V 50/60 Hz, fold-open bending frame, without bending formers</b>                   | B    | 123.0 | 4589100 | 259600 |
| <b>electro-hydraulic 230 V 50/60 Hz, fold-open bending frame, with 9 bending formers no. 263103-130</b>     | B    | 198.0 | 4589290 | 259610 |
| <b>manual-hydraulic, open bending frame, without bending formers</b>  | C    | 120.0 | 4589370 | 260000 |
| <b>manual-hydraulic, open bending frame, with 9 bending formers no. 263103-130</b>                          | C    | 207.0 | 4589450 | 260100 |
| <b>electro-hydraulic 380-415 V 50/60 Hz, open bending frame, without bending formers</b>                    | D    | 155.0 | 4589530 | 260500 |
| <b>electro-hydraulic 380-415 V 50/60 Hz, open bending frame, with 9 bending formers no. 263103-130</b>      | D    | 242.0 | 4589610 | 260510 |
| <b>electro-hydraulic 230 V 50/60 Hz, open bending frame, without bending formers</b>                        | D    | 155.0 | 4589880 | 260600 |
| <b>electro-hydraulic 230 V 50/60 Hz, open bending frame, with 9 bending formers no. 263103-130</b>          | D    | 242.0 | 4589960 | 260610 |

## 261 PIPE BENDING MACHINE 1" - 4"

INOX FE

- > For gas and water pipes EN 10255 (DIN 2440/2441) up to max. 90°
- > With fold-open bending frame
- > Pressure 200 kN
- > Delivery in wooden assembly case

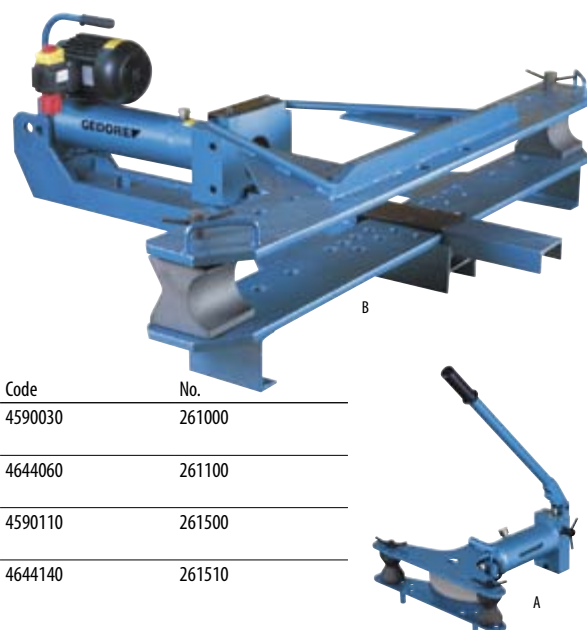
### Available in various designs:

- > - manually or electro-hydraulically operated
- > - as the basic tool without bending former or as a set with bending former no. 263113-130, 263040

### Optional bending tools under no. 263 - 264 available for:

- > - Distilling pipes EN 10220 (DIN 2448) from 1" to 2.1/2" or 25 to 44.5 mm
- > - Metric pipes from 25 to 44.5 mm

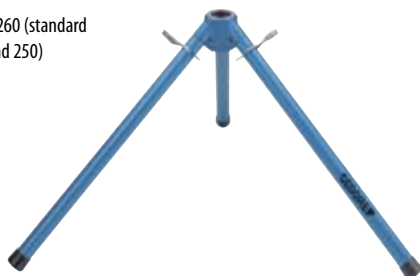
### Bending tools for further pipe types and sizes and for stainless steel pipes on request



| included in delivery  | Ill. |       | Code    | No.    |
|---|------|-------|---------|--------|
| <b>manual-hydraulic, fold-open bending frame, without bending formers</b>   | A    | 311.0 | 4590030 | 261000 |
| <b>manual-hydraulic, fold-open bending frame, with bending formers no. 263110-130, 263040</b>                     | A    | 480.0 | 4644060 | 261100 |
| <b>electro-hydraulic 380-415 V 50/60 Hz, fold-open bending frame, without bending formers</b>                     | B    | 330.0 | 4590110 | 261500 |
| <b>electro-hydraulic 380-415 V 50/60 Hz, fold-open bending frame, with bending formers no. 263110-130, 263040</b> | B    | 499.0 | 4644140 | 261510 |

## 268 INSTALLATION TRIPOD, PIVOTABLE

- > Available in 2 sizes
- > For GEDORE pipe bender no. 256-260 (standard equipment for benders no. 249 and 250)
- > Enamelled blue



| Height     | Use  |      | Code    | No.    |
|------------|--|------|---------|--------|
| <b>480</b> | for manual-hydraulic benders no. 256, 257, 258                               | 6.2  | 4599760 | 268000 |
| <b>680</b> | for manual-hydraulic benders no. 259, 260 and all electric-hydraulic benders | 17.4 | 4599840 | 268001 |

## 254 EXTENSION CABLE

- > For electro-hydraulic pumps 1.1/4", 2", 3" and 4"
- > Heavy rubber hose
- > Can be used in dry and damp rooms
- > For high mechanical loads, including construction sites



254983



254985

| Description                        | Connection voltage V |     | Code    | No.    |
|------------------------------------|----------------------|-----|---------|--------|
| <b>CEE extension cable 10 m</b>    | 380-415              | 3.1 | 4694160 | 254983 |
| <b>Safety extension cable 10 m</b> | 230                  | 1.6 | 4694320 | 254985 |

## 269 HYDRAULIC OIL

1 litre

- > For re-filling all GEDORE hydraulic pumps
- > For filling the volume stated in the table is required



| Litre    | for pumps  | use in machine no. | required volume litre |       | Code    | No.    |
|----------|------------|--------------------|-----------------------|-------|---------|--------|
| <b>1</b> | 2541, 2545 | 256                | 0,90                  | 0.880 | 4599920 | 269000 |
|          | 2542, 2546 | 249, 257, 258      | 1,25                  |       |         |        |
|          | 2543, 2547 | 250, 259, 260      | 1,90                  |       |         |        |
|          | 2544, 2548 | 261                | 3,50                  |       |         |        |

## 2631 GREY CAST IRON BENDING FORMER UP TO 90°

FE

- > For gas and water pipes EN 10255-M (DIN 2440)
- > Enamelled black



| Use in machine No. | Size  | Ø mm | r = mm | Bore mm |      | Code    | No.    |
|--------------------|-------|------|--------|---------|------|---------|--------|
| <b>256-260</b>     | 3/8   | 17,2 | 45     | 35,5    | 0,9  | 4539000 | 263103 |
| <b>256-260</b>     | 1/2   | 21,3 | 50     | 35,5    | 1,3  | 4539190 | 263105 |
| <b>256-260</b>     | 3/4   | 26,9 | 75     | 35,5    | 2,2  | 4539270 | 263107 |
| <b>256-261</b>     | 1     | 33,7 | 100    | 35,5    | 2,3  | 4590460 | 263110 |
| <b>256-261</b>     | 1.1/4 | 42,4 | 115    | 35,5    | 2,4  | 4590540 | 263112 |
| <b>257-261</b>     | 1.1/2 | 48,3 | 150    | 35,5    | 5,3  | 4539350 | 263115 |
| <b>257-261</b>     | 2     | 60,3 | 200    | 35,5    | 6,7  | 4539430 | 263120 |
| <b>259-261</b>     | 2.1/2 | 76,1 | 320    | 35,5    | 21,2 | 4590620 | 263125 |
| <b>259-261</b>     | 3     | 88,9 | 380    | 35,5    | 30,4 | 4590700 | 263130 |



## 2630 STEEL BENDING FORMER UP TO 90°

- > For gas and water pipes EN 10255 (DIN 2440/2441)
- > For surface-protective bending
- > Phosphated



| Use in machine No. | Size  | Ø mm  | r = mm | Bore mm | ⚖    | Code    | No.    |
|--------------------|-------|-------|--------|---------|------|---------|--------|
| <b>256-260</b>     | 1/2   | 21,3  | 50     | 35,5    | 1.3  | 4655850 | 263005 |
| <b>256-260</b>     | 3/4   | 26,9  | 75     | 35,5    | 2.2  | 4655930 | 263007 |
| <b>256-261</b>     | 1     | 33,7  | 100    | 35,5    | 2.3  | 4656070 | 263010 |
| <b>256-261</b>     | 1.1/4 | 42,4  | 126    | 35,5    | 5.8  | 4656150 | 263012 |
| <b>257-261</b>     | 1.1/2 | 48,3  | 145    | 35,5    | 5.3  | 4656230 | 263015 |
| <b>257-261</b>     | 2     | 60,3  | 200    | 35,5    | 11.2 | 4656310 | 263020 |
| <b>259-261</b>     | 2.1/2 | 76,1  | 320    | 35,5    | 21.2 | 4656580 | 263025 |
| <b>259-261</b>     | 3     | 88,9  | 380    | 35,5    | 44.5 | 4656660 | 263030 |
| <b>261</b>         | 4     | 114,3 | 600    | 35,5    | 98.0 | 4644300 | 263040 |

## 2640 STEEL BENDING FORMER UP TO 90°

INOX FE

- > For standard-walled distilling pipes EN 10220 (DIN 2448) and metric pipes
- > Phosphated

Bending tools for further pipe types and sizes and for stainless steel pipes on request



| Use in machine No. | Size  | Ø mm | r = mm | Bore mm | ⚖    | Code    | No.    |
|--------------------|-------|------|--------|---------|------|---------|--------|
| <b>256-260</b>     |       | 20,0 | 90     | 35,5    | 3.4  | 4593130 | 264020 |
| <b>256-260</b>     | 1/2   | 21,3 | 75     | 35,5    | 2.5  | 4595340 | 264005 |
| <b>256-260</b>     |       | 22,0 | 90     | 35,5    | 3.2  | 4593210 | 264022 |
| <b>256-261</b>     |       | 25,0 | 115    | 35,5    | 3.6  | 4595770 | 264025 |
| <b>256-260</b>     | 3/4   | 26,9 | 90     | 35,5    | 3.5  | 4595420 | 264007 |
| <b>256-261</b>     |       | 28,0 | 130    | 35,5    | 5.4  | 2910438 | 264028 |
| <b>256-261</b>     |       | 30,0 | 140    | 35,5    | 6.7  | 4595850 | 264030 |
| <b>256-261</b>     |       | 32,0 | 140    | 35,5    | 6.6  | 4595930 | 264032 |
| <b>256-261</b>     | 1     | 33,7 | 130    | 35,5    | 5.4  | 4595500 | 264010 |
| <b>257-261</b>     |       | 38,0 | 170    | 35,5    | 8.2  | 4596070 | 264038 |
| <b>257-261</b>     |       | 42,0 | 190    | 35,5    | 10.7 | 2910446 | 264042 |
| <b>257-261</b>     | 1.1/4 | 42,4 | 180    | 35,5    | 10.2 | 4595690 | 264012 |
| <b>257-261</b>     |       | 44,5 | 190    | 35,5    | 10.7 | 4596150 | 264044 |
| <b>257-261</b>     | 1.1/2 | 48,3 | 220    | 35,5    | 11.8 | 4596230 | 264048 |
| <b>259-261</b>     | 2     | 60,3 | 270    | 35,5    | 21.3 | 4596660 | 264060 |
| <b>259-261</b>     | 2.1/2 | 76,1 | 420    | 35,5    | 49.3 | 4596900 | 264076 |

### Eccentric angle benders

## MAX. BENDING CAPACITIES ANGLE BENDERS NO. 280

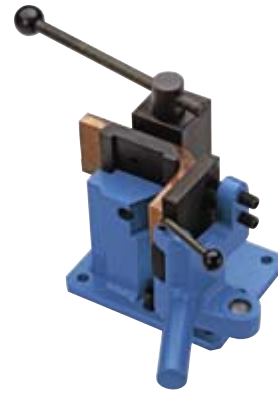
|  | 70 mm working height                             |                                     | 100 mm working height                     |                     | 120 mm working height                                |                     |
|--|--|-------------------------------------|---|---------------------|--|---------------------|
|  | cold mm  | hot mm                              | cold mm                                   | hot mm              | cold mm  | hot mm              |
| Flat steel EN 10058 (DIN 1017)<br>(material strength 370 N/mm <sup>2</sup> )           | 70 x 6<br>(70 x 10)*<br>(50 x 15)*<br>(30 x 20)* | 70 x 10<br>(70 x 20)*<br>(50 x 25)* | 100 x 10<br>80 x 12<br>50 x 15<br>30 x 20 | 100 x 20<br>80 x 25 | 120 x 8<br>100 x 10<br>80 x 12<br>50 x 15<br>30 x 20 | 120 x 20<br>80 x 25 |
| Square steel stock EN 10059 (DIN 1014)<br>(material strength 370 N/mm <sup>2</sup> )   | 6<br>(22)*                                       | 10<br>(30)*                         | 22  | 30                  | 22   | 30                  |
| Round steel stock EN 10060 (DIN 1013)<br>(material strength 370 N/mm <sup>2</sup> )    | 6<br>(25)*                                       | 10<br>(30)*                         | 25  | 30                  | 25   | 30                  |
| Angled steel stock EN 10056-1 (DIN 1028)<br>(material strength 370 N/mm <sup>2</sup> ) | 70 x 6   | 70 x 9                              | 100 x 10                                  | 100 x 12            | 120 x 10   | 120 x 15            |
| CU-flat bars EN 13601<br>(material strength 250 N/mm <sup>2</sup> )                    | 60 x 6<br>(60 x 30)*                             |                                     | 100 x 30                                  |                     | 120 x 10<br>100 x 30                                 |                     |
| AL-flat bars EN 754-5 (DIN 1769)<br>(material strength 160 N/mm <sup>2</sup> )         | 70 x 10<br>(70 x 30)*                            |                                     | 100 x 30                                  |                     | 120 x 15<br>100 x 30                                 |                     |

\* optional bending tool no. 280072 is necessary

# 280 ECCENTRIC ANGLE BENDER

70, 100 and 120 mm working height

- > For round, flat and angled stocks in steel, copper or aluminium up to 90°
- > With stepless adjustable angle stop
- > With length stop
- > Manual base unit for mounting on a workbench, with optional tripod no. 268500 for stationary use
- > With optional available angle no. 280250 for vice fixture
- > Optionally available are bending tools for a diversity of applications - see E 280 bending tools

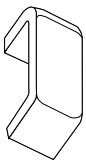


| Included in delivery  |  | Code    | No.    |
|---|---|---------|--------|
| Basic tool 70 mm working height, manual, with bending lever extension no. 268230  | 29.5  | 4539940 | 280070 |
| Basic tool 100 mm working height, manual, with bending lever extension no. 268230 | 32.5  | 4535010 | 280100 |
| Basic tool 120 mm working height, manual, with bending lever extension no. 268230 | 34.1  | 4606130 | 280120 |

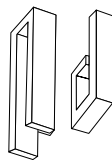
## E 280 BENDING TOOLS



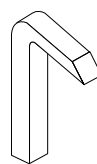
280072



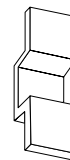
280113  
280114



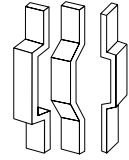
280115




280116



280117



| Description  | use in machine no.     |  | Code    | No.    |
|--|------------------------|---|---------|--------|
| Radiused bending tool $r = 15 \text{ mm}$ / $r = 25 \text{ mm}$ for material thicknesses up to 30 mm             | 280070                 | 1.1   | 4605320 | 280072 |
| Bending tool for producing saddles and rectangular bends, sharp-edged for material thicknesses up to 3 mm        | 280100                 | 0.8   | 4605670 | 280113 |
| Bending tool for producing saddles and rectangular bends, $r = 4 \text{ mm}$ for material thicknesses up to 6 mm | 280100                 | 0.9   | 4605750 | 280114 |
| Bending tool for making diamond bends  | 280070, 280100, 280120 | 0.7   | 4605830 | 280115 |
| Bending tool for high saddles  | 280100                 | 1.2   | 4605910 | 280116 |
| Offset block for narrow saddles  | 280100                 | 2.4   | 4606050 | 280117 |

## E 280 ACCESSORIES



280250


268500



411-150

>554



| Description            |  | Code    | No.    |
|------------------------|---|---------|--------|
| Tripod, height 990 mm  | 21.2  | 2681072 | 268500 |
| Angle for vice fixture | 3.3   | 2009544 | 280250 |

