

# Bending formers and back formers

Accessories for REMS Curvo 50, REMS Curvo,  
REMS Curvo 22V and REMS Sinus

Bending formers and back formers, 180°, form and pressure resistant, in high-strength, high-slide, glass-fibre reinforced polyamide or aluminum 90° (Ø 21.3 R 103, Ø 26.9 R 102, Ø 33.7 R 100, Ø 35 R 100, Ø 42 R 140, Ø 42.4 R 140, Ø 50 R 135, Ø 1" R 100, Ø 1 1/4" R 140). Optimum matching of bending former and back former guarantees material-compatible gliding without cracks and creases. Angle scale provided on each bending former and mark on the back former ensure precise bending. Rapid change of bending formers and back formers.



Info

| Bending former and back former for pipes Ø mm/inch O.D. | R mm              | X mm 90° | X mm 45° | Bending former material | REMS Sinus |          |            |          |          | REMS Curvo |          |          |            |          | REMS Curvo 22 V |          |          |            |          | REMS Curvo 50 |          |          |         |            | Art.-No. | €      |
|---------------------------------------------------------|-------------------|----------|----------|-------------------------|------------|----------|------------|----------|----------|------------|----------|----------|------------|----------|-----------------|----------|----------|------------|----------|---------------|----------|----------|---------|------------|----------|--------|
|                                                         |                   |          |          |                         | Cu         | St 10312 | St 10305-U | St 10305 | St 10255 | Cu         | St 12735 | St 10312 | St 10305-U | St 10305 | Cu              | St 12735 | St 10312 | St 10305-U | St 10305 | Cu            | St 12735 | St 10312 | St 1127 | St 10305-U | St 10305 |        |
| 10                                                      | 40                | 45       | 20       | P                       | •          |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581400   | 203,00 |
| 12                                                      | 45                | 49       | 22       | P                       | •          | •        | •          |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581410   | 154,00 |
| 14, 10 U, 1/4" (DN 6)                                   | 50                | 53       | 23       | P                       | •          | •        | •          |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581420   | 149,00 |
| 15                                                      | 55                | 56       | 25       | P                       | •          | •        | •          |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581430   | 166,00 |
| 15                                                      | 65                | 70       | 32       | P                       | •          | •        | •          |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581290R  | 184,00 |
| 16, 12 U                                                | 60                | 62       | 28       | P                       | •          | •        | •          | •        |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581440   | 167,00 |
| 17, 15 U                                                | 56                | 60       | 27       | P                       |            |          | •          |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581110   | 205,00 |
| 18, 14 U, 15 U, 3/8" (DN 10)                            | 70                | 75       | 33       | P                       | •          | •        | •          | •        |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581450   | 168,00 |
| 20, 16 U, 18 U                                          | 75                | 80       | 36       | P                       | •          | •        | •          |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581080   | 268,00 |
| 21.3, 1/2" (s = 1.6/2.0/2.6)                            | 103               | 110      | 50       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581480   | 610,00 |
| 22, 18 U, 1/2" (DN 15)                                  | 77                | 81       | 36       | A                       | •          | •        | •          |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581460   | 303,00 |
| 22, 18 U, 1/2" (DN 15)                                  | 88                | 91       | 41       | P                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581470   | 419,00 |
| 24, 22 U                                                | 75                | 85       | 38       | P                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581130   | 324,00 |
| 25                                                      | 98                | 103      | 46       | P                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581180   | 356,00 |
| 26                                                      | 98                | 108      | 49       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581270   | 407,00 |
| 26.9, 3/4" (s = 1.6/2.0/2.6)                            | 102               | 108      | 49       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581490   | 670,00 |
| 28 <sup>1)</sup>                                        | 102 <sup>3)</sup> | 108      | 49       | P                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581070   | 312,00 |
| 28, 3/4" (DN 20) <sup>2)</sup>                          | 102 <sup>3)</sup> | 110      | 50       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581260   | 395,00 |
| 28, 3/4" (DN 20) <sup>2)</sup>                          | 114               | 120      | 54       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581310   | 425,00 |
| 30, 28 U                                                | 98                | 105      | 47       | P                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581150   | 393,00 |
| 32                                                      | 98                | 110      | 50       | P                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581280   | 382,00 |
| 32                                                      | 114               | 121      | 54       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581320   | 444,00 |
| 1" (DN 25)                                              | 100               | 105      | 47       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581520   | 560,00 |
| 33.7, 1" (s = 1.6/2.0/2.6)                              | 100               | 105      | 47       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581520   | 560,00 |
| 35                                                      | 100               | 105      | 47       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581500   | 560,00 |
| 35                                                      | 140               | 150      | 68       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581350   | 660,00 |
| 40                                                      | 140               | 148      | 67       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581330   | 610,00 |
| 42                                                      | 140               | 155      | 70       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581510   | 600,00 |
| 1 1/4" (DN 32)                                          | 140               | 150      | 68       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581530   | 590,00 |
| 42.4, 1 1/4" (s = 2.0/2.6)                              | 140               | 150      | 68       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581530   | 590,00 |
| 50                                                      | 135               | 143      | 64       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581540   | 790,00 |
| 3/8" (9.5 mm)                                           | 43                | 48       | 22       | P                       | •          |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581200   | 257,00 |
| 1/2" (12.7 mm)                                          | 52                | 60       | 27       | P                       | •          |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581210   | 245,00 |
| 5/8" (15.9 mm)                                          | 63                | 70       | 32       | P                       | •          |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581220   | 276,00 |
| 3/4" (19.1 mm)                                          | 75                | 82       | 37       | P                       | •          |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581230   | 327,00 |
| 7/8" (22.2 mm)                                          | 98                | 107      | 48       | P                       | •          |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581240   | 384,00 |
| 1" (25.4 mm)                                            | 101               | 112      | 50       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581360R  | 499,00 |
| 1" (25.4 mm)                                            | 101               | 112      | 50       | P                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581370   | 381,00 |
| 1 1/8" (28.6 mm)                                        | 102               | 110      | 44       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581260   | 395,00 |
| 1 1/8" (28.6 mm)                                        | 115               | 117      | 53       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581380   | 425,00 |
| 1 1/4" (31.8 mm)                                        | 114               | 123      | 55       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581320   | 444,00 |
| 1 1/4" (31.8 mm)                                        | 133               | 145      | 65       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581390   | 700,00 |
| 1 3/8" (34.9 mm)                                        | 100               | 105      | 47       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581500   | 560,00 |
| 1 3/8" (34.9 mm)                                        | 140               | 150      | 68       | A                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581350   | 660,00 |
| 1 3/8" (41.3 mm)                                        | 140               | 155      | 70       | S                       |            |          |            |          |          | •          |          |          |            |          | •               |          |          |            |          | •             |          |          |         |            | 581560   | 327,00 |

R mm Bending radius mm at the neutral axis of the bend (DVGW GW 392)  
X mm Correction dimension for a 90° or 45° bend  
s mm Wall thickness  
<sup>1)</sup> hard, semi-hard copper pipes, also thin-walled, EN 1057  
<sup>2)</sup> hard copper pipes EN 1057  
<sup>3)</sup> According to DVGW work sheet GW 392 for hard and semi-hard copper pipes  
Ø 28 mm minimum bending radius 114 mm necessary. Wall thickness ≥ 0.9 mm.  
▲ Adaptor block 10–40, support 10–40 (Art.-No. 582120) necessary.  
■ Adaptor block 35–50, support 35–50 (Art.-No. 582110) necessary.  
Cu: hard, half-hard, soft copper tubes, also thin-wall, EN 1057  
Cu 12735: Copper pipes K65 for refrigeration and air conditioning technology in accordance with EN 12735-1, EN 12449  
St 10312: stainless steel pipes of the press fitting systems EN 10312, series 2, EN 10088, EN 10217-7  
St 1127: stainless steel pipes EN ISO 1127, EN 10217-7  
St 10305-U: coated, soft carbon steel pipes of the press fitting systems EN 10305-3  
St 10305: soft precision steel pipes EN 10305-1, EN 10305-2, EN 10305-3, carbon steel pipes EN 10305-3  
St 10255: Steel pipes (threaded pipes) EN 10255  
St 50086: Electrical installation pipes DIN EN 50086  
U: coated  
V: multi-layer composite tubes of pressfitting systems  
P: Bending former made of glass fibre-reinforced polyamide  
A: Bending former made of aluminium  
S: Bending former made of spheroidal iron

## Bending to size

If a bend is required at a certain point on the pipe, a length correction must be made to suit the pipe size. The correction dimension X specified in Fig. 1 must be considered for a 90° or 45° bend. The set dimension L must be reduced by the amount X here. If, e.g., the dimension L for pipe size 22 is 400 mm and a bend with a bending radius of 77 mm is to be made, the dimension line should be marked on the pipe at 319 mm. This line is then – as shown in Fig. 1 – to be aligned with the 0-mark on the bending former.

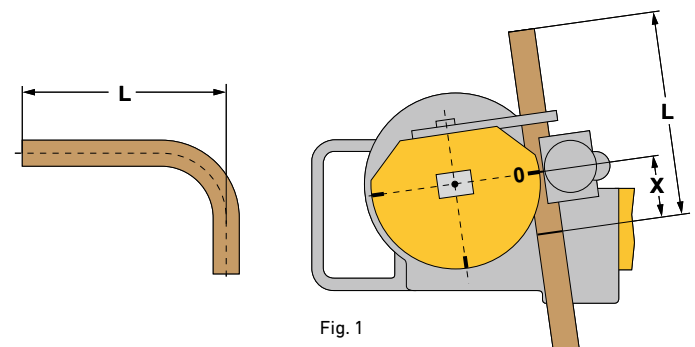


Fig. 1