

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.



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	187,00
12	45	49	22	P	●	●	●			●					●					●					581410	141,00
14, 10 U, 1/4" (DN 6)	50	53	23	P	●	●	●			●					●					●					581420	137,00
15	55	56	25	P	●	●	●			●					●					●					581430	153,00
15	65	70	32	P	●	●	●			●					●					●					581290R	170,00
16, 12 U	60	62	28	P	●	●	●	●		●					●					●					581440	154,00
17, 15 U	56	60	27	P		●				●					●					●					581110	189,00
18, 14 U, 15 U, 3/8" (DN 10)	70	75	33	P	●	●	●	●		●					●					●					581450	155,00
20, 16 U, 18 U	75	80	36	P	●	●	●			●					●					●					581080	247,00
21.3, 1/2" (s = 1.6/2.0/2.6)	103	110	50	S																					581480	556,00
22, 18 U, 1/2" (DN 15)	77	81	36	A	●	●	●			●					●					●					581460	184,00
22, 18 U, 1/2" (DN 15)	88	91	41	P						●					●					●					581470	270,00
24, 22 U	75	85	38	P						●					●					●					581130	299,00
25	98	103	46	P						●					●					●					581180	329,00
26	98	108	49	A						●					●					●					581270	454,00
26.9, 3/4" (s = 1.6/2.0/2.6)	102	108	49	S																					581490	620,00
28 ¹⁾	102 ³⁾	108	49	P						●					●					●					581070	288,00
28, 3/4" (DN 20) ²⁾	102 ³⁾	110	50	A						●					●					●					581260	444,00
28, 3/4" (DN 20) ²⁾	114	120	54	A						●					●					●					581310	385,00
30, 28 U	98	105	47	P						●					●					●					581150	363,00
32	98	110	50	P						●					●					●					581280	352,00
32	114	121	54	A						●					●					●					581320	454,00
1" (DN 25)	100	105	47	S																					581520	516,00
33.7, 1" (s = 1.6/2.0/2.6)	100	105	47	S																					581520	516,00
35	100	105	47	S																					581500	516,00
35	140	150	68	A						●					●					●					581350	606,00
40	140	148	67	A																					581330	611,00
42	140	155	70	S																					581510	552,00
1 1/4" (DN 32)	140	150	68	S																					581530	537,00
42.4, 1 1/4" (s = 2.0/2.6)	140	150	68	S																					581530	537,00
50	135	143	64	S																					581540	725,00
3/8" (9.5 mm)	43	48	22	P	●					●					●					●					581200	237,00
1/2" (12.7 mm)	52	60	27	P	●					●					●					●					581210	226,00
5/8" (15.9 mm)	63	70	32	P	●					●					●					●					581220	254,00
3/4" (19.1 mm)	75	82	37	P	●					●					●					●					581230	302,00
7/8" (22.2 mm)	98	107	48	P	●					●					●					●					581240	354,00
1" (25.4 mm)	101	112	50	A						●					●					●					581360R	461,00
1" (25.4 mm)	101	112	50	P						●					●					●					581370	351,00
1 1/8" (28.6 mm)	102	110	44	A						●					●					●					581260	444,00
1 1/8" (28.6 mm)	115	117	53	A						●					●					●					581380	385,00
1 1/4" (31.8 mm)	114	123	55	A						●					●					●					581320	454,00
1 1/4" (31.8 mm)	133	145	65	A						●					●					●					581390	641,00
1 3/8" (34.9 mm)	100	105	47	S																					581500	516,00
1 3/8" (34.9 mm)	140	150	68	A						●					●					●					581350	606,00
1 3/8" (41.3 mm)	140	155	70	S																					581510	552,00

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
¹⁾ hard, semi-hard copper pipes, also thin-walled, EN 1057
²⁾ hard copper pipes EN 1057
³⁾ 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.

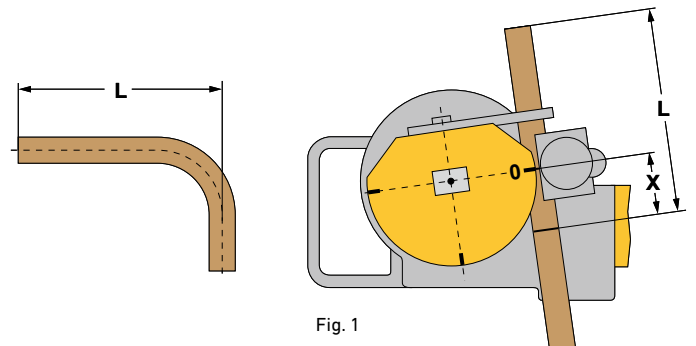


Fig. 1