



VIETZ Pipe Bending Machine EV 6-24"

Pipe data		Material and maximal wall thickness					Bending data			
Outside-Ø		X52 (API 5L)	X60 (API 5L)	X65 (API 5L)	X70 (API 5L)	X80 (API 5L)	Bending radius (40 x D)	Recommended bending angle on 30 cm bending step	theoretical maximal bending angle for 12 m pipe (*1) (*2)	theoretical maximal bending angle for 18 m pipe
Zoll	mm	mm	mm	mm	mm	mm	m	°	°	°
6	168,3	all	all	all	all	all	6,73	2,67	76,6	76,6
8	219,3	all	all	all	all	all	8,77	2,05	58,8	76,6
10	273,1	all	all	all	85,0	75,0	10,92	0,97	47,2	76,6
12	323,9	all	all	all	72,0	60,0	12,96	1,39	39,8	67,6
14	355,6	all	all	68,0	60,8	50,0	14,22	1,27	36,3	61,6
16	406,4	all	48,0	44,0	41,0	37,0	16,26	1,11	31,7	53,9
18	457,2	42,0	38,0	35,0	33,0	29,1	18,29	0,98	28,2	47,9
20	508,0	35,0	31,0	29,0	27,5	25,9	20,32	0,89	25,4	43,1
22	558,8	30,0	27,0	26,0	24,3	22,7	22,35	0,81	23,1	39,2
24	609,6	26,0	24,0	23,0	20,9	20,3	24,38	0,74	21,2	35,9

(*1) Average values, which consider connections for the free pipe ends, which will not be bent. Please refer to the table below.

12 m	8,6 m maximal effective bending range	29 bending steps for 12 m pipe
18 m	14,6 m maximal effective bending range	49 bending steps for 12 m pipe

(*2) The maximal recommended bending angle is only for pipe with wall thickness according to API 5L.
The bending angle for pipe with wall thickness outside of API 5L can differ greatly.

EV 6-24"	recommended not bandable ends of pipe		Note: The figures are recommended only and do not constitute a warranty. The description based on using a VIETZ-Mandrel. The bending result is depending from requirements as following: - The wall thickness of the pipe - The skill of the operator in handling the bending machine - The origin and the quality of the pipe - The type of pipe; spiral welded pipes accept only 75% of the recommended values - The type of bending set (PU-lined, coated or uncoated).
	front [m]	rear [m]	
	2	1,4	