



Tube Bending Guidelines: Ercolina 'Rotary Draw' Bending

May 2024

Tube OD (in.)	Centerline Bend Radii	Min. wall thickness	Straight Length
(in.)	(mm / in.)	thickness (in.)	minimum (in.)
0.250"	36mm / 1.42"	>or = .035"	3.00"
0.375"	36mm / 1.42"	>or = .035"	3.00"
0.500"	36mm / 1.42"	>or = .049"	3.00"
	50.8mm / 2.00"	>or = .049"	2.00"
0.625"	46mm / 1.81"	>or = .049"	3.25"
	50.8mm / 2.00"	>or = .049"	2.00"
	63.5mm / 2.50"	>or = .049"	2.00"
0.750"	46mm / 1.81"	>or = .058"	3.25"
	67mm / 2.64"	>or = .049"	4.00"
	98.4mm / 3.88"	>or = .049"	"
	153.4mm / 6.04"	>or = .035"	"
0.875"	46mm / 1.81"	>or = .083"	3.25"
	67mm / 2.64"	>or = .049"	4.00"
	96.8mm / 3.81"	>or = .049"	"
	150.6mm / 5.93"	>or = .035"	"
1.000"	56mm / 2.21"	>or = .120"	3.50"
	67mm / 2.64"	>or = .095"	4.00"
	82mm / 3.25"	>or = .058"	4.50"
	149.2mm / 5.88"	>or = .035"	4.50"
1.125"	67mm / 2.64"	>or = .083"	4.00"
	82mm / 3.25"	>or = .058"	4.50"
1.250"	82mm / 3.25"	>or = .120"	4.50"
	112mm / 4.41"	>or = .065"	4.50"
	151.4 / 5.96"	>or = .049" (.035 ??)	4.50"
1.375"	82mm / 3.25"	>or = .083"	4.50"
	112mm / 4.41"	>or = .065"	4.50"
1.500"	100mm / 3.94"	>or = .083"	4.50"
	150mm / 5.91"	>or = .065"	5.25"
1.625"	130mm / 5.12"	>or = .083"	5.00"
1.750"	150mm / 5.91"	>or = .083"	5.25"
	170mm / 6.70"	>or = .083"	5.75"
2.000"	150mm / 5.91"	>or = .120"	5.25"
	190mm / 7.50"	>or = .083"	6.00"
½" pipe (.840" od)	56mm / 2.21"		3.50"
¾" pipe (1.050" od)	67mm / 2.64"		4.00"
1" pipe (1.315" od)	67mm / 2.64"		4.00"
	82mm / 3.23"		4.50"
	112mm / 4.41"		4.50"
1 ¼" pipe (1.660" od)	130mm / 5.12"		5.00"