

iFORMERS AND COUNTERFORMERS - For bending without mandrel

■ FORME TIPO "A" IN MILLIMETRI

Forme in alluminio complete di anello da utilizzare senza anima
TIPO A per curvare tubi in rame crudo e ricotto, alluminio, ottone
ricotto e acciaio per elettricisti. Da usare solo con le controforme.

▲ MILLIMETER SIZED FORMERS TYPE "A"

Aluminium formers with ring to use without mandrel, TYPE A for
bending hard and soft copper tubes, aluminium pipes, annealed
brass pipes and steel tubes for electricians. To use with guides only.

UNI		Ø mm	R mm	COD./CÓD.
		6	30	000638
		8	30	000639
		10	30	000482
		10	40	000483
		12	36	000315
		12	48	000316
		14	42	000317
		14	56	000318
		15	45	000358
		15	60	000247
		16	48	000239
		16	64	000181
		17	51	000324
		17	68	000325
		18	54	000246
		18	72	000248
		19	57	000322
		19	76	000323
		20	60	000198
		20	80	000256
		22	66	000240
		22	98	000170
		24	72	000328
		24	96	000255
		25	75	000241
		25	100	000169
		26	78	000242
		26	104	000257
		28	84	000252
		28	112	000183
		30	90	000195
		30	120	000253
		32	96	000243
		32	128	000184
		32 [multistrato]	128	000184.M
		34	102	000329
		34	136	000330
		35	105	000244
		35	140	000249
		37	111	000320
		37	148	000321
		38	114	000245
		38	152	000185
		40	120	000196
		40	160	000254
		40 [multistrato]	160	000254.M
		42	126	000251
		42	166	000250
		43	180	000197
		50	200	000259
		60	240	000164
		63 [multistrato]	240	000971

■ FORME TIPO "B" IN POLICI REALI (WHT)

Forme in alluminio complete di anello da utilizzare senza anima
TIPO B per curvare tubi in rame crudo e ricotto, alluminio, ottone
ricotto e acciaio per elettricisti. Da usare solo con le controforme.

▲ WHT INCH SIZED FORMERS TYPE "B"

Aluminium formers with ring to use without mandrel TYPE B for
bending hard and soft copper tubes, aluminium pipes, annealed
brass pipes and steel tubes for electricians. To use with guides only.

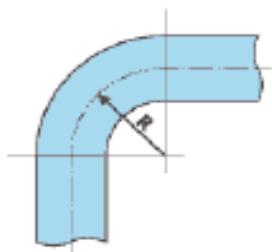
UNI		Ø*WHT	Ø mm	R	COD./CÓD.
		1/4	6,35	3D	000630
		5/16	7,94	3D	000631
		3/8	9,52	3D	000632
		1/2	12,70	3D	000261
		1/2	12,70	4D	000262
		5/8	15,88	3D	000263
		5/8	15,88	4D	000264
		3/4	19,05	3D	000265
		3/4	19,05	4D	000266
		7/8	22,22	3D	000267
		7/8	22,22	4D	000268
		1"	25,40	3D	000269
		1"	25,40	4D	000270
		1 1/8	28,58	3D	000271
		1 1/8	28,58	4D	000272
		1 1/4	31,75	3D	000273
		1 1/4	31,75	4D	000274
		1 3/8	34,92	3D	000275
		1 3/8	34,92	4D	000276
		1 1/2	38,10	3D	000277
		1 1/2	38,10	4D	000278
		1 5/8	41,28	3D	000506
		1 5/8	41,28	4D	000508
		1 3/4	44,45	4D	000532
		1 7/8	47,62	4D	000579
		2"	50,80	4D	000179
		2 1/4	57,15	4D	000280
		2 3/8	60,32	4D	000581

FORME E CONTROFORME SPECIALI A RICHIESTA
SPECIAL FORMERS AND GUIDES ON REQUEST
FORMAS Y CONTRAFORMAS ESPECIALES A PETICIÓN

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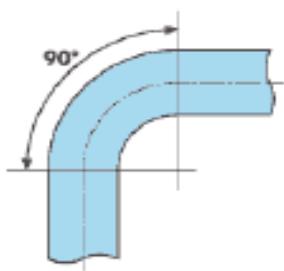
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USEFUL INFORMATION FOR THE PURCHASE OF A PIPE BENDING MACHINE TYPE UNI INFORMACIONES UTILES PARA COMPRAR UNA CURVADORA UNI



1 E' indispensabile sapere il tipo di materiale del tubo da curvare, il diametro esterno [mm/polci gas/WHT polci reit], lo spessore [mm] e il raggio di curvatura che si vuole ottenere.

It is necessary to know the type of material of the pipe to bend, the outside diameter [mm/gas inch/WHT reit inch], the pipe wall thickness [mm] and the required bending radius.



2 Il raggio di curvatura [da non confondersi con l'angolo di curvatura] è la distanza che intercorre tra l'ipotetico centro cerchio e il centro del tubo curvato.

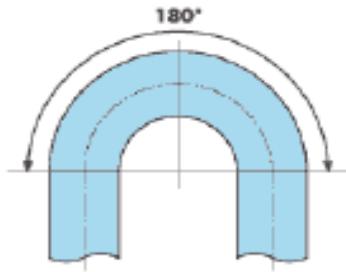
Quando parliamo di raggio 3D oppure 4D significa che il raggio di curvatura è 3 o 4 volte il diametro esterno del tubo (es. Ø 40 mm, raggio 3D = 40 x 3 = 120 mm).

Ricordiamo che più il raggio di curvatura è grande e migliore è il risultato del tubo lavorato.

The bending radius [not to confuse with the bending angle] is the distance between the hypothetical centre of the circle and the center of the bent pipe.

When speaking of radius 3D or 4D we mean that the bending radius is 3 or 4 times the outside diameter of the pipe (example: diam. 40 mm, radius 3D = 40 x 3 = 120 mm).

Bear in mind that the bigger the bending radius, the better the result on the bent pipe will be.



3 L'angolo di curvatura espresso in gradi determina l'ampiezza della curva.

The bending angle, expressed in degrees, determines the width of the bend.

4 Si curva senza l'ausilio dell'anima quando non ci hanno esigenze particolari o quando si devono lavorare tubi spessi e/o con raggi di curvatura 3D/4D o superiori. Invece si curva con l'ausilio dell'anima quando ci sono esigenze particolari o quando si devono lavorare tubi sottili e/o con raggi di curvatura 2D/2,5D.

You can bend without using the mandrel system when you do not have particular exigencies or when you must bend thick pipes and/or with bending radii 3D/4D or bigger ones.

On the contrary you must bend with mandrel system everytime you have particular exigencies or when you must bend thin pipes and/or with smaller bending radii 2D/2,5D.

SPHEROIDAL GRAPHITE IRON FORMERS WITH HOOK TYPE G IN WHT INCH AND GAS INCH

To use without mandrel to bend S37 steel pipes, stainless steel pipes, hard and soft copper pipes, aluminium and soft brass pipes.

■ Forme per curvare tubi in acciaio S37, acciaio inox, rame duro e ricotto, alluminio, ottone ricotto e simili.

▲ Formers to bend S37 steel, stainless steel, hard and soft copper, aluminium and soft brass pipes and similar ones.

ATTENZIONE: Le forme dal R. 90 al R. 190 per la curvatura mod. UNI 42 sono specifiche per questo modello.

ATTENTION: The formers from R. 90 to R. 190 are specific for the UNI 42 pipe bending machine.

MOD. UNI	Ø TUBO Ø TUBE Ø TUBO	R. 36		R. 46		R. 56		R. 67	
		mm. R. 36	mm. min. R. 36	mm. R. 46	mm. min. R. 46	mm. R. 56	mm. min. R. 56	mm. R. 67	mm. min. R. 67
42	1/4 (6,35 mm)	00W1/4R36	1	00W1/4R46	1	00W1/4R56	1	00W1/4R67	1
	5/16 (7,94 mm)	00W5/16R36	1	00W5/16R46	1	00W5/16R56	1	00W5/16R67	1
60	3/8 (9,52 mm)	00W3/8R36	1	00W3/8R46	1	00W3/8R56	1	00W3/8R67	1
70	1/2 (12,70 mm)	00W1/2R36	1	00W1/2R46	1	00W1/2R56	1	00W1/2R67	1
76	5/8 (15,88 mm)	00W5/8R36	2	00W5/8R46	1	00W5/8R56	1	00W5/8R67	1
76	3/4 (19,05 mm)			00W3/4R46	2,5	00W3/4R56	1,5	00W3/4R67	1
76	7/8 (22,22 mm)			00W7/8R46	2	00W7/8R56	1,5	00W7/8R67	1
89	1" (25,40 mm)				00W1R56	2	00W1R67	1	
	1 1/8 (28,58 mm)				00W1 1/8R56	2,5	00W1 1/8R67	1	
	1 1/4 (31,75 mm)					00W1 1/4R56	2,5		
60	1 3/8 (34,92 mm)								
70	1 1/2 (38,10 mm)								
76	1 5/8 (41,28 mm)								
76	1 3/4 (44,45 mm)								
89	1 7/8 (47,02 mm)								
70	2" (50,80 mm)								

WHT	R. 90		R. 100		R. 130	
	mm. R. 90	mm. min. R. 90	mm. R. 100	mm. min. R. 100	mm. R. 130	mm. min. R. 130
	00W1/4R90	1	00W1/4R100	1	00W1/4R130	
	00W5/16R90	1	00W5/16R100	1	00W5/16R130	
	00W3/8R90	1	00W3/8R100	1	00W3/8R130	
	00W1/2R90	1	00W1/2R100	1	00W1/2R130	
	00W5/8R90	1	00W5/8R100	1	00W5/8R130	
	00W3/4R90	1	00W3/4R100	1	00W3/4R130	
	00W7/8R90	1	00W7/8R100	1	00W7/8R130	
	00W1R90	1	00W1R100	1	00W1R130	
	00W1 1/8R90	2,5	00W1 1/8R100	1	00W1 1/8R130	
	00W1 1/4R90	2,5	00W1 1/4R100	2	00W1 1/4R130	
	00W1 3/8R90	2	00W1 3/8R100	3	00W1 3/8R130	
	00W1 1/2R90	3	00W1 1/2R100	2	00W1 1/2R130	
	00W1 5/8R90	3	00W1 5/8R100	3	00W1 5/8R130	
	00W1 3/4R90	3	00W1 3/4R100	3	00W1 3/4R130	
	00W1 7/8R90	3	00W1 7/8R100	3	00W1 7/8R130	
						00W2R130

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■ FORME TIPO "E" IN WHT (POLICI REALI)

Forme in ghisa sferoidale completa di anello da utilizzare senza animo TIPO E per curvare tubi in ottone crudo, acciaio, acciaio inox, baderizzati, titanio etc. Da usare con le controforme o i rulli in base allo spessore del tubo, (dal diam. 1/4" al diam. 2" 3/8").

▲ WHT INCH SIZED FORMERS TYPE "E"

Spheroidal graphite iron formers with ring to use without mandrel TYPE E for bending hard brass, steel, stainless steel, baderized, titanium tubes etc. To use with guides or rollers according to the tube wall-thickness from Ø 1/4" to Ø 2" 3/8".

UNI			mm. min.	mm. max.			mm. min.	mm. max.		COD./CÓD.
70/C-76-89	ØWHT Ø mm.	R				Ø mm.	min.	max.		
	2 1/4	57,15	3D	1	2,5		*	2,5	*	00075770
	2 1/4	57,15	4D	1	2,5		*	2,5	*	00035170
	2 3/8	60,30	3D	1	2,5		*	2,5	*	00075870
	2 3/8	60,30	4D	1	2,5		*	2,5	*	00058370
	2 1/2	63,5	180	1	2,5		*	2,5	*	0001104
	2 1/2	63,5	240	1	2,5		*	2,5	*	0001105
	2 5/8	66,7	228	1	2,5		*	2,5	*	0001108
	2 7/8	73	228	1	2,5		*	2,5	*	0001108
	3"	76	228	1	2,5		*	2,5	*	0001102
	3 1/4	82,5	355	1	2,5		*	2,5	*	0001224
	3 1/2	89,9	355	1	2,5		*	2,5	*	0001225

UNI			mm. min.	mm. max.			mm. min.	mm. max.		COD./CÓD.
70/C-76-89	ØWHT Ø mm.	R				Ø mm.	min.	max.		
	2 1/4	57,15	3D	1	2,5		*	2,5	*	00075770
	2 1/4	57,15	4D	1	2,5		*	2,5	*	00035170
	2 3/8	60,30	3D	1	2,5		*	2,5	*	00075870
	2 3/8	60,30	4D	1	2,5		*	2,5	*	00058370
	2 1/2	63,5	180	1	2,5		*	2,5	*	0001104
	2 1/2	63,5	240	1	2,5		*	2,5	*	0001105
	2 5/8	66,7	228	1	2,5		*	2,5	*	0001108
	2 7/8	73	228	1	2,5		*	2,5	*	0001108
	3"	76	228	1	2,5		*	2,5	*	0001102
	3 1/4	82,5	355	1	2,5		*	2,5	*	0001224
	3 1/2	89,9	355	1	2,5		*	2,5	*	0001225

■ FORME TIPO "L" IN POLICI GAS

Forme in ghisa sferoidale complete di anello da utilizzare senza animo TIPO L per curvare tubi gas da usare con le controforme o i rulli in base allo spessore del tubo.

▲ GAS INCH SIZED FORMERS TYPE "L"

Spheroidal graphite iron formers with ring to use without mandrel TYPE L for bending gas tubes. To use with guides or rollers according to the tube wall thickness.

UNI		Ø GAS	CORRISPONDenza EQUIVALENT CONVERSION	R,	COD./CÓD.
N/C-76-89	Ø mm. mm.		mm. mm.		
	1/4		13,72	47	000524
	3/8		17,2	53,5	00019d
	1/2		21,3	59	00019g
	5/8		26,9	78	000145

■ FORME TIPO "H" IN MILLIMETRI

Forme in ghisa sferoidale da utilizzare senza animo TIPO H per curvare tubi in acciaio, acciaio inox aerodinamico (con spessore minimo 3 mm) con raggi stretti circa 2 volte il diametro del tubo.

▲ MILLIMETER SIZED FORMERS TYPE "H"

Spheroidal graphite iron formers to use without mandrel TYPE H for bending steel, hydraulic stainless steel pipes (minimum thickness 3 mm) with tight radii (about 2D).

UNI	Ø mm. mm.	R min.	R max. [mm]	COD./CÓD.
42-60-70/C-76	20	30	43	H.30-43
	30	43,1	61	H.43-61
	38	61,1	76	H.61-76
	42	76,1	91	H.76-91
	45	91,1	128	H.91-128
	60	101	115	H.101-115
	60	115,1	130	H.115-130
	60	130,1	150	H.130-150
	60	150,1	170	H.150-170
	60	170,1	200	H.170-200
70/C-76	60	200,1	240	H.200-240
	60	240,1	280	H.240-280

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**CONTROFORME IN OTTONE IN MM
MILLIMETER SIZED BRASS GUIDES
CONTRAFORMAS DE LATÓN EN MILÍMETROS**

ARTICOLO/ITEM/ARTÍCULO	COD./CÓD.
Ø 6-8	420060
Ø 10-12	420061
Ø 12-14	420062
Ø 15-17	420063
Ø 15-18	420064
Ø 16-18	420025
Ø 19-26	420065
Ø 20-24	420066
Ø 20-25	420026
Ø 20-26	420067
Ø 22-28	420027
Ø 30-32	420068
Ø 32-38	420028
Ø 32-40	420069
Ø 34-37	420070
Ø 35-38	420071
Ø 35-40	420029
Ø 42	420072
Ø 42 per rame/for copper/para cobre UNI 42	420073
Ø 42 per rame/for copper/para cobre UNI 60-70/C	420074
Ø 42 per ferro/para UNI 60-70/C	420075
Ø 45	420076
Ø 50	420077
Ø 54	420078
Ø 60	420079
Ø 63 (*)	420081
Ø 65	CF76BM65
Ø 70	CF76BM70
Ø 75	CF76BM75
Ø 80*	CF89BM80
Ø 85*	CF89BM85
Ø 90*	CF89BM90

(*) Tubo multistrato/Double coated aluminium pipe (type Meplo, Alupex and similar ones)/Tubo multicapa

**CONTROFORME WHT (POLICI REALI)
WHT INCH SIZED BRASS GUIDES
CONTRAFORMAS EN PULGADAS REALES**

ARTICOLO/ITEM/ARTÍCULO	COD./CÓD.
Ø 1/4 - 5/16	420103
Ø 3/8 - 1/2	420104
Ø 5/8 - 3/4	420105
Ø 7/8 - 1"	420030
Ø 11/16 - 11/12	420039
Ø 11/8 - 13/8	420031
Ø 15/8	420100
Ø 15/8 solo/only/soloamente UNI 60-70/C	420101
Ø 13/8	420102
Ø 13/8 solo/only/soloamente UNI 60-70/C	420106
Ø 17/8	420107
Ø 21/8	420108
Ø 21/8	420109
Ø 21/4	420110
Ø 23/8	420111
Ø 21/2	420112
Ø 25/8*	CF76B2.5/8W
Ø 23/8*	CF76B2.3/4W
Ø 27/8*	CF76B2.7/8W
Ø 31/4*	CF89B3.1/4W
Ø 31/2*	CF89B3.1/2W

**RULLI IN POLICI WHT (POLICI REALI) PER UNI 42
WHT INCH SIZED ROLLERS FOR UNI 42
RODILLOS EN PULGADAS REALES PARA UNI 42**

ARTICOLO/ITEM/ARTÍCULO	COD./CÓD.
Ø 1/4"	595395
Ø 3/8"	595399
Ø 1/2"	595399
Ø 5/8"	595398
Ø 3/4"	595399
Ø 7/8"	595390
Ø 1"	595391
Ø 11/8	595392
Ø 11/4	595393
Ø 13/8	595394
Ø 11/2	595395
Ø 15/8	595396

**CONTROFORME IN POLICI GAS
GAS INCH SIZED BRASS GUIDES
CONTRAFORMAS EN PULGADAS GAS**

ARTICOLO/ITEM/ARTÍCULO	COD./CÓD.
Ø 1/8 - 1/4	420130
Ø 3/8 - 1/2	420131
Ø 3/4 - 1"	420032
Ø 11/4	420132
Ø 11/4 solo/only/soloamente UNI 60-70/C	420133
Ø 11/2	420134
Ø 2"	420155
Ø 21/2"	CF76BG2.1/2-3W
Ø 3"	CF89BG3

**CONTROFORME SPECIALI PER UNI 60 AI E UNI 30 SPEED
(SOLO CON ALBERO RIDOTTO) IN MM
MILLIMETER SIZED SPECIAL GUIDES FOR THE UNI 60 AI
AND UNI 30 SPEED (WITH REDUCED SHAFT ONLY)
CONTRAFORMAS ESPECIALES PARA LA UNI 60 AI
Y UNI 30 SPEED (SOLO CON EJE REDUCIDO) EN MM.**

ARTICOLO/ITEM/ARTÍCULO	COD./CÓD.
Ø 6-8	224014
Ø 10-12	420013
Ø 14-16	420014
Ø 18-22	420010
Ø 12-15	420009
Ø 17-20	420008

**CONTROFORME SPECIALI PER UNI 60 AI E UNI 30 SPEED
(SOLO CON ALBERO RIDOTTO) IN WHT (POLICI REALI)
WHT INCH SIZED GUIDES FOR THE UNI 60 AI
AND UNI 30 SPEED (WITH REDUCED SHAFT ONLY)
CONTRAFORMAS ESPECIALES PARA LA UNI 60 AI Y
UNI 30 SPEED (SOLO CON EJE REDUCIDO) EN PULGADAS REALES**

ARTICOLO/ITEM/ARTÍCULO	COD./CÓD.
Ø 1/4-5/16	224018
Ø 1/4-3/8	224017
Ø 1/2-5/8	420006

**RULLI IN MILLIMETRI PER UNI 42
MILLIMETER SIZED ROLLERS FOR UNI 42
RODILLOS EN MILLIMETROS PARA UNI 42**

ARTICOLO/ITEM/ARTÍCULO	COD./CÓD.
Universale/universal/universal UNI 42	595362
Ø 10	595363
Ø 12	595364
Ø 14	595365
Ø 15	595366
Ø 16	595367
Ø 17	595368
Ø 18	595369
Ø 19	595370
Ø 20	595371
Ø 22	595372
Ø 24	595373
Ø 25	595374
Ø 26	595375
Ø 28	595376
Ø 30	595377
Ø 32	595378
Ø 34	595379
Ø 35	595380
Ø 37	595381
Ø 38	595382
Ø 40	595383
Ø 42	595384

(*) IN BRONZO / IN BRONZE / DE BRONCE

**RULLI IN POLICI WHT (POLICI REALI) PER UNI 42
WHT INCH SIZED ROLLERS FOR UNI 42
RODILLOS EN PULGADAS REALES PARA UNI 42**

ARTICOLO/ITEM/ARTÍCULO	COD./CÓD.
Rullo Ø 1/2"	595136
Rullo Ø 5/8"	595137
Rullo Ø 3/4"	595138
Rullo Ø 7/8"	595139
Rullo Ø 1"	595140
Rullo Ø 11/8	595141
Rullo Ø 11/4	595142
Rullo Ø 13/8	595147
Rullo Ø 11/2	595129
Rullo Ø 15/8	595142
Rullo Ø 13/4	595143
Rullo Ø 17/8	595144

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