

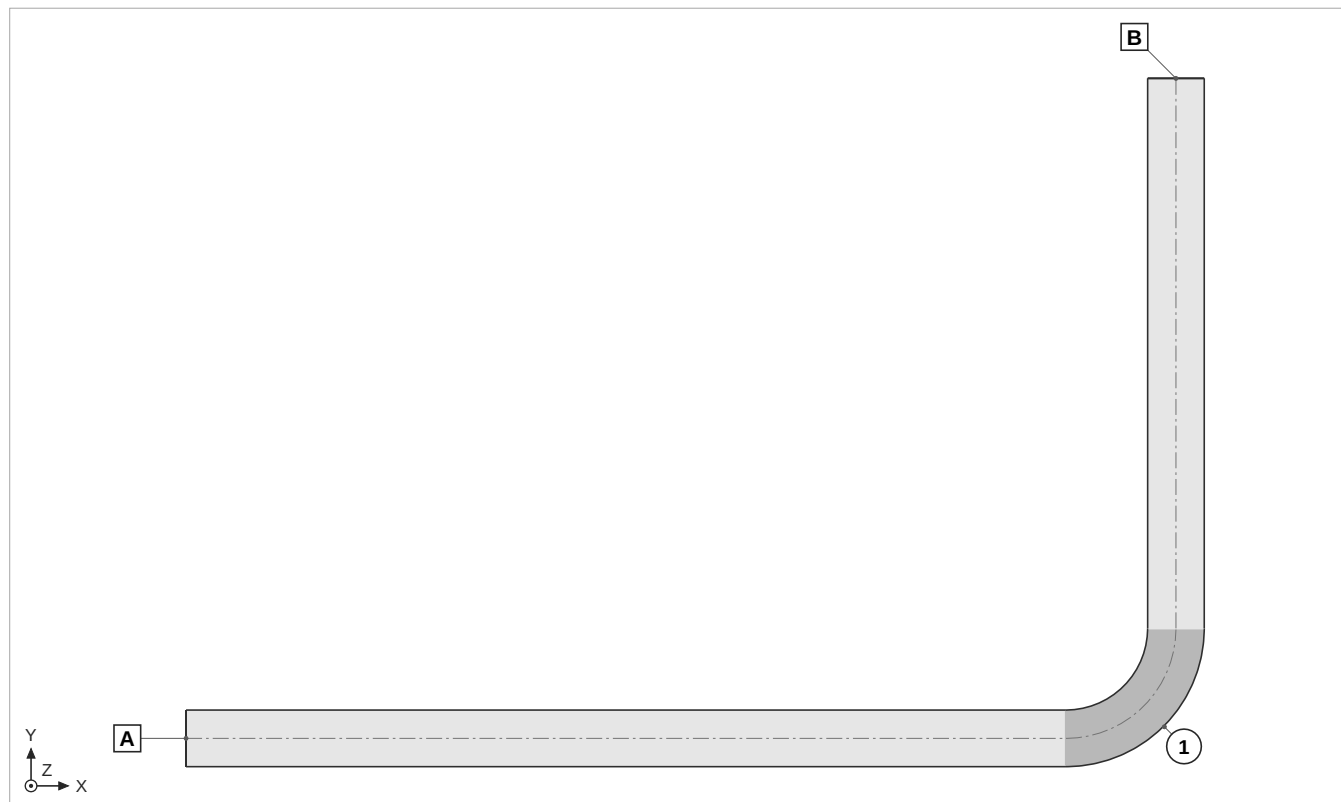
SHOP SHEET

Tube fabrication example - R001 2026-10-05
Total: 4 pcs Cut length: 2914.2 mm Mass: 3.31 kg
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TP00003 / r1 Pipe 25x2-1 (2)

QTY x4

TUBE 25 x 2 Precision tube EN 10305	MATERIAL Steel	CLR (DIE) 50 mm	CUT LENGTH 728.5 mm
BENDS 1	BENDER / DIE Sample setup / r1	SPRINGBACK None	MASS EACH 0.83 kg



True-shape view of the bend plane (the tube lies in one plane), component axes. Not to scale - dimensions are in the table.
Overall size X 462.5 x Y 312.5 x Z 25.0 mm

BEND TABLE (LRA)

BEND	L FEED (mm)	R ROTATION (°)	A ANGLE (°)	MARK FROM A (mm)
1	400.0	0.0	90.0	400.0
End	250.0			

NOTES

- End A leads: bends are numbered from end A (bend 1 is nearest to it) and the collet grips end B.
- L = straight between bend tangent points (incremental). The first L is measured from end A; End = the straight after the last bend.
- R = tube rotation between bends, counter-clockwise positive, seen from the front of the bender (where the bent part comes out) looking back along the tube toward the carriage (right-hand rule about the feed direction). Bend 1 is 0 (zero at first bend).
- A = finished bend angle (design).
- MARK FROM A = distance from end A to the start of each bend.
- CUT LENGTH = developed centreline length; no grip, trim or stock allowance added. Lengths in mm, angles in degrees.
- CLR = die centreline radius.
- Tolerances: per order or customer drawing (the design gives none).
- Setup limits: minimum entry 100 mm, minimum exit 100 mm, minimum between bends 100 mm, maximum set angle 120°.

Apex points, machine frame

A at origin, first straight +X, first bend in XY.

POINT	X (mm)	Y (mm)	Z (mm)
A	0.0	0.0	0.0
1	450.0	0.0	0.0
B	450.0	300.0	0.0

A to B centre distance: 540.8 mm.

Apexes are centreline intersections of the straights, not tube-surface points.