

"THE BRUTE" STANDARD ROUND TUBE DIE SETS

O.D.	CLR	DDWA	DWBA	Min. Wall 4130	Max. Wall 4130
3/4"	3"	180°	160°	0.058	0.134
3/4"	3-1/2"	120°	110°	0.058	0.134
7/8"	3"	180°	160°	0.058	0.134
7/8"	3-1/2"	120°	110°	0.058	0.134
7/8"	4"	120°	110°	0.058	0.134
7/8"	4-1/2"	120°	110°	0.058	0.134
1"	3"	180°	160°	0.065	0.134
1"	3-1/2"	120°	110°	0.058	0.134
1"	4"	120°	110°	0.058	0.134
1"	4-1/2"	120°	110°	0.058	0.134
1-1/8"	3"	180°	160°	0.095	0.134
1-1/8"	3-1/2"	120°	110°	0.083	0.134
1-1/8"	4"	120°	110°	0.065	0.134
1-1/8"	4-1/2"	120°	110°	0.058	0.134
1-1/4"	4"	120°	110°	0.065	0.134
1-1/4"	4-1/2"	120°	110°	0.058	0.134
1-1/4"	5"	120°	110°	0.058	0.134
1-1/4"	6"	120°	110°	0.058	0.134
1-3/8"	4-1/2"	120°	110°	0.095	0.134
1-3/8"	5"	120°	110°	0.083	0.134
1-3/8"	6"	120°	110°	0.058	0.134
1-1/2"	4-1/2"	120°	110°	0.095	0.134
1-1/2"	5"	120°	110°	0.083	0.134
1-1/2"	6"	120°	110°	0.065	0.134
1-1/2"	7"	120°	110°	0.058	0.134
1-5/8"	6"	120°	110°	0.083	0.134
1-5/8"	7"	120°	110°	0.065	0.134
1-3/4"	6"	120°	110°	0.083	0.134
1-3/4"	7"	120°	110°	0.065	0.134
2"	6"	120°	110°	0.12	0.134
2"	7"	120°	110°	0.095	0.134
2-1/4"	7"	120°	110°	0.120	1.34
2-1/2"	7"	120°	110°	0.120	1.34

to Complete 180 Degree Bend



"THE BRUTE" METRIC ROUND TUBE DIE SETS

O.D.	CLR	CLR in Inches	DDWA	DWBA	Min. Wall 4130	Max. Wall 4130
20mm	50.8mm	2	180°	160°	1.5mm	3.40mm
20mm	76.2mm	3	180°	160°	1.5mm	3.40mm
20mm	88.9mm	3.5	180°	160°	1.5mm	3.40mm
20mm	114.3mm	4.5	180°	160°	1.5mm	3.40mm
20mm	127mm	5	180°	160°	1.5mm	3.40mm
22mm	76.2mm	3	180°	160°	1.5mm	3.40mm
22mm	88.9mm	3.5	120°	110°	1.5mm	3.40mm
22mm	114.3mm	4.5	180°	160°	1.5mm	3.40mm
22mm	127mm	5	180°	160°	1.5mm	3.40mm
25mm	152.4mm	6	180°	160°	1.5mm	3.40mm
25mm	76.2mm	3	120°	110°	1.5mm	3.40mm
25mm	88.9mm	3.5	180°	160°	1.5mm	3.40mm
25mm	114.3mm	4.5	120°	110°	1.5mm	3.40mm
25mm	127mm	5	120°	110°	1.5mm	3.40mm
25mm	152.4mm	6	120°	110°	1.5mm	3.40mm
28mm	88.9mm	3.5	180°	160°	1.5mm	3.40mm
28mm	114.3mm	4.5	120°	110°	1.5mm	3.40mm
28mm	127mm	5	120°	110°	1.5mm	3.40mm
28mm	152.4mm	6	120°	110°	2.1mm	3.40mm
30mm	88.9mm	3.5	180°	160°	1.5mm	3.40mm
30mm	114.3mm	4.5	120°	110°	1.5mm	3.40mm
30mm	127mm	5	120°	110°	1.5mm	3.40mm
30mm	152.4mm	6	120°	110°	2.1mm	3.40mm
32mm	114.3mm	4.5	120°	110°	1.5mm	3.40mm
32mm	127mm	5	120°	110°	1.5mm	3.40mm
32mm	152.4mm	6	120°	110°	1.5mm	3.40mm
35mm	114.3mm	4.5	120°	110°	2.4mm	3.40mm
35mm	127mm	5	120°	110°	1.7mm	3.40mm
35mm	152.4mm	6	120°	110°	1.7mm	3.40mm
38mm	114.3mm	4.5	120°	110°	2.4mm	3.40mm
38mm	127mm	5	120°	110°	2.1mm	3.40mm
38mm	152.4mm	6	120°	110°	1.5mm	3.40mm
40mm	127mm	5	120°	110°	2.1mm	3.40mm
40mm	152.4mm	6	120°	110°	2.1mm	3.40mm
45mm	127mm	5	120°	110°	2.4mm	3.40mm
45mm	152.4mm	6	120°	110°	2.1mm	3.40mm
50mm	152.4mm	6	120°	110°	2.4mm	3.40mm

CLR - Center Line Radius

Meaning the bend radius is measured from the center of the rotation point on the die to the middle of the tubing.

ERW

Welded Tubing. Beware this type of tubing has thin spots which may cause a bending problem. It is recommended when using this type to go one gauge thicker on the wall thickness.

MINIMUM WALL

Minimum recommended wall thickness for good high quality bends when using D.O.M. Or 4130 steel tubing.



"THE BRUTE" STANDARD PIPE DIE SETS (SCHEDULE 40)

Pipe Size	Q.D.	CLR	DDWA	DWBA
1/4" PIPE	0.54	3"	180°	160°
1/4" PIPE	0.54	3-1/2"	120°	110°
3/8" PIPE	0.675	3"	180°	160°
3/8" PIPE	0.675	3-1/2"	120°	110°
1/2" PIPE	0.84	3"	180°	160°
1/2" PIPE	0.84	3-1/2"	120°	110°
1/2" PIPE	0.84	4"	120°	110°
1/2" PIPE	0.84	4-1/2"	120°	110°
3/4" PIPE	1.05	3"	180°	160°
3/4" PIPE	1.05	3-1/2"	120°	110°
3/4" PIPE	1.05	4"	120°	110°
3/4" PIPE	1.05	4-1/2"	120°	110°
1" PIPE	1.315	3-1/2"	120°	110°
1" PIPE	1.315	4"	120°	110°
1" PIPE	1.315	4-1/2"	120°	110°
1" PIPE	1.315	5"	120°	110°
1" PIPE	1.315	6"	120°	110°
1-1/4" PIPE	1.66	4-1/2"	120°	110°
1-1/4" PIPE	1.66	5"	120°	110°
1-1/4" PIPE	1.66	6"	120°	110°
1-1/4" PIPE	1.66	7"	120°	110°
1-1/2" PIPE	1.9	4-1/2"	120°	110°
1-1/2" PIPE	1.9	5"	120°	110°
1-1/2" PIPE	1.9	6"	120°	110°
1-1/2" PIPE	1.9	7"	120°	110°
2" PIPE	2.375	7"	120°	110°

All Dies available in 240° Wrap Around to Complete 180° Bend

"THE BRUTE" SQUARE TUBE DIE SETS

O.D.	CLR	DDWA	DWBA	Min. Wall	Max. Wall
1/2"	3"	180°	160°	0.065	0.083
1/2"	3-1/2"	120°	110°	0.065	0.083
1/2"	4"	120°	110°	0.065	0.083
1/2"	4-1/2"	120°	110°	0.065	0.083
3/4"	3"	180°	160°	0.065	0.083
3/4"	3-1/2"	120°	110°	0.065	0.083
3/4"	4"	120°	110°	0.065	0.083
3/4"	4-1/2"	120°	110°	0.065	0.083
1"	3-1/2"	120°	110°	0.065	0.083
1"	4"	120°	110°	0.065	0.083
1"	4-1/2"	120°	110°	0.065	0.083
1"	5"	120°	110°	0.065	0.083
1"	6"	120°	110°	0.065	0.083
1-1/4"	5"	120°	110°	0.065	0.083
1-1/4"	6"	120°	110°	0.065	0.083
1-1/4"	7"	120°	110°	0.065	0.083
1-1/2"	6"	120°	110°	0.065	0.083
1-1/2"	7"	120°	110°	0.065	0.083

All Dies available in 240° Wrap Around to Complete 180° Bend

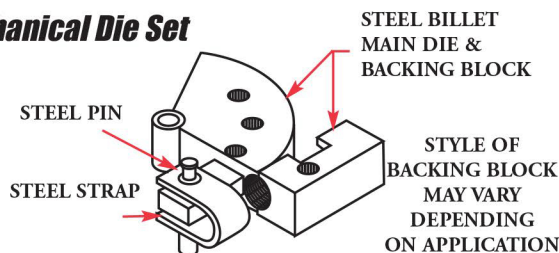
ALL STEEL DIE SETS HAVE A

LIFETIME WARRANTY

AGAINST BREAKAGE

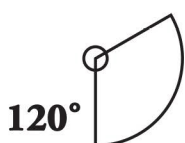
These are our standard dies. If you need a special size or need advice as to which radius die you may need for your job, please call and we will be glad to advise and help in any way possible. Bending square tubing thicker than 0.83 requires special dies.

Mechanical Die Set

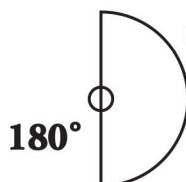


EACH DIE SET COMES WITH EVERYTHING SHOWN

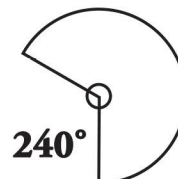
Consult chart for maximum bend information



On 3 1/2" CLR or larger 120° die sets are standard.



On Sets 3" CLR or less 180° die set is standard



Die Sets are also available in 240° wrap around for "U" bend. Call for pricing.

