

\*\*\*\*\* All fields shaded in light blue must be filled in for each conduit to be bent !! \*\*\*\*\*

Conduit #1	Conduit #2	Conduit #3	Conduit #4	Conduit #5
1.875	2.375	2.375	3.875	2.375
70	73	76	78	80
34	38	41	44	48
20	24.125	28.5	33.625	38.75

What is the outside diameter of the conduit? (i.e. 2 inch is 2.375")  
 What is the distance to the back of the 90?  
 What is the height of the stub up?  
 How many inches in between each conduit?  
 What is the first radius to center of the conduit?  
 (at least 8 x diameter of pipe)

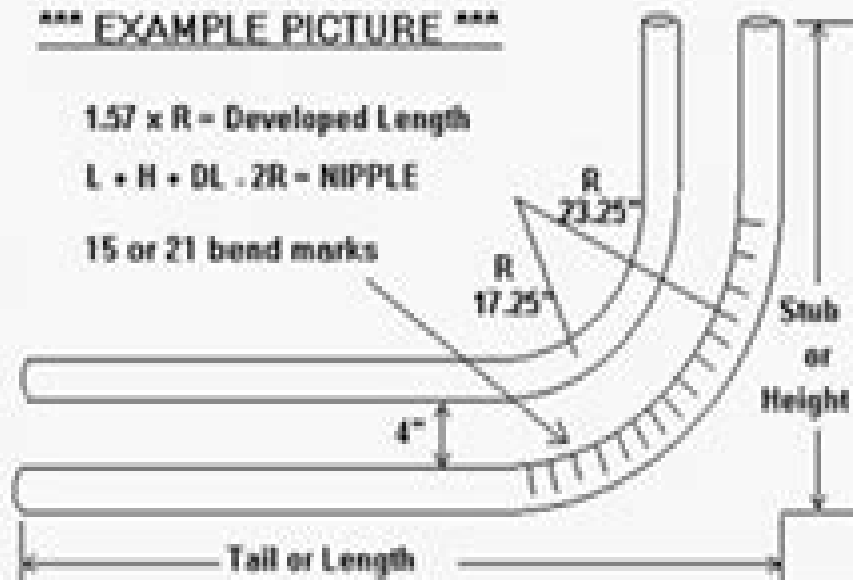
	Outside	Total				Distance	Distance		
Cond.	Diameter	Conduit	Radius	15 Marks	21 Marks	to center	to back	Stub up	Developed
		Length		Spaced	Spaced	mark	of 90	height	Length
#1	1.875	95.4	20	2.09033	1.49524	64.7625	70	34	31.4
#2	2.375	100.626	24.125	2.52508	1.80363	66.6256	73	38	37.87625
#3	2.375	104.745	28.5	2.963	2.13071	68.685	76	41	44.745
#4	3.875	107.541	33.625	3.51942	2.51387	68.8331	78	44	52.79125
#5	2.375	111.338	38.75	4.05583	2.89702	70.4813	80	48	60.8375

### \*\*\* EXAMPLE PICTURE \*\*\*

$1.57 \times R = \text{Developed Length}$

$L + H + DL - 2R = \text{NIPPLE}$

15 or 21 bend marks



# Standard Pipe Bending Radius Guide

**Louis Allen Harding, Arthur Cutts  
Willard**



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