

# Bending formers and back formers

Accessories for REMS Curvo 50,  
REMS Curvo and REMS Sinus

Bending formers and back formers, 180°, form and pressure resistant, in high-strength, high-slide, glass-fibre reinforced polyamide or aluminum 90° (Ø 21,3 R 103, Ø 26,9 R 102, Ø 33,7 R 100, Ø 35 R 100, Ø 42 R 140, Ø 42,4 R 140, Ø 50 R 135, Ø 1" R 100, Ø 1¼" R 140). Optimum matching of bending former and back former guarantees material-compatible gliding without cracks and creases. Angle scale provided on each bending former and mark on the back former ensure precise bending. Rapid change of bending formers and back formers.



| Bending former<br>and back former<br>for pipes<br>Ø mm/inch O.D. | R<br>mm           | X<br>mm<br>90° | X<br>mm<br>45° | → REMS Sinus |      |          |            |          |          | → REMS Curvo |   |    |          |      |          | → REMS Akku-Curvo |          |          |          |   |    | → REMS Curvo 50 |      |          |            |          |          | Art.-No. |          |        |
|------------------------------------------------------------------|-------------------|----------------|----------------|--------------|------|----------|------------|----------|----------|--------------|---|----|----------|------|----------|-------------------|----------|----------|----------|---|----|-----------------|------|----------|------------|----------|----------|----------|----------|--------|
|                                                                  |                   |                |                | Cu           | Cu-U | St 10312 | St 10305-U | St 10305 | St 10255 | St 50086     | V | Cu | Cu 12735 | Cu-U | St 10312 | St 10305-U        | St 10305 | St 10255 | St 50086 | V | Cu | Cu 12735        | Cu-U | St 10312 | St 10305-U | St 10305 | St 10255 |          | St 50086 | V      |
| 10                                                               | 40                | 45             | 20             | ●            |      |          | ●          |          |          | ●            |   |    |          | ●    |          |                   |          |          | ●        |   |    |                 |      | ▲        |            |          | ▲        |          |          | 581400 |
| 12                                                               | 45                | 49             | 22             | ●            |      | ●        |            |          |          | ●            |   |    | ●        |      | ●        |                   |          |          | ●        |   |    |                 | ▲    |          | ▲          |          |          |          |          | 581410 |
| 14, 10 U, ¼" (DN 6)                                              | 50                | 53             | 23             | ●            | ●    |          | ●          |          |          | ●            | ● |    | ●        |      | ●        | ●                 |          |          | ●        |   |    | ▲               |      | ▲        |            | ▲        |          | ▲        |          | 581420 |
| 15, 12 U                                                         | 55                | 56             | 25             | ●            | ●    | ●        | ●          |          |          | ●            |   | ●  | ●        | ●    | ●        |                   |          |          | ●        |   |    | ▲               |      | ▲        |            | ▲        |          |          |          | 581430 |
| 16, 12 U                                                         | 60                | 62             | 28             | ●            | ●    |          | ●          | ●        | ●        | ●            |   | ●  |          | ●    |          | ●                 | ●        | ●        | ●        |   | ▲  |                 | ▲    |          | ▲          |          | ▲        | ▲        |          | 581440 |
| 17, 15 U                                                         | 56                | 60             | 27             |              |      |          | ●          |          | ●        |              |   |    | ●        |      |          |                   |          | ●        |          |   | ▲  |                 |      |          |            |          | ▲        | ▲        |          | 581110 |
| 18, 14 U, 15 U, ⅜" (DN 10)                                       | 70                | 75             | 33             | ●            | ●    | ●        | ●          |          | ●        | ●            |   | ●  | ●        | ●    | ●        | ●                 | ●        | ●        | ●        |   | ▲  | ▲               | ▲    |          | ▲          | ▲        | ▲        |          |          | 581450 |
| 20, 16 U, 18 U                                                   | 75                | 80             | 36             | ●            | ●    | ●        |            |          | ●        | ●            |   | ●  |          |      |          | ●                 | ●        | ●        | ●        |   | ▲  |                 | ▲    |          | ▲          |          | ▲        | ▲        |          | 581080 |
| 21.3, ½" (s = 1.6/2.0/2.6)                                       | 103               | 110            | 50             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 | ■    |          |            | ■        |          |          | 581480   |        |
| 22, 18 U, ½" (DN 15)                                             | 77                | 81             | 36             | ●            | ●    |          | ●          |          |          | ●            | ● | ●  | ●        | ●    | ●        |                   |          |          | ●        |   | ▲  | ▲               | ▲    |          | ▲          | ▲        |          |          |          | 581460 |
| 22, 18 U, ½" (DN 15)                                             | 88                | 91             | 41             |              |      |          |            |          |          | ●            | ● | ●  | ●        | ●    | ●        |                   |          |          | ●        |   | ▲  | ▲               | ▲    |          | ▲          | ▲        |          |          |          | 581470 |
| 24, 22 U                                                         | 75                | 85             | 38             |              |      |          |            |          |          | ●            |   |    | ●        |      |          |                   |          |          | ●        |   | ▲  |                 |      |          | ▲          |          |          |          |          | 581130 |
| 25                                                               | 98                | 103            | 46             |              |      |          |            | ●        | ●        |              |   |    | ●        |      | ●        | ●                 | ●        | ●        |          |   |    |                 |      |          | ▲          | ▲        | ▲        |          |          | 581180 |
| 26                                                               | 98                | 108            | 49             |              |      |          |            | ●        |          |              |   |    | ●        |      |          |                   |          | ●        |          |   |    |                 |      |          |            | ▲        | ▲        |          |          | 581270 |
| 26.9, ¾" (s = 1.6/2.0/2.6)                                       | 102               | 108            | 49             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 | ■    |          |            | ■        |          |          | 581490   |        |
| 28 <sup>1)</sup>                                                 | 102 <sup>3)</sup> | 108            | 49             |              |      |          |            |          | ●        |              |   |    |          |      |          |                   |          | ●        |          |   | ▲  |                 |      |          |            |          |          |          |          | 581070 |
| 28, ¾" (DN 20) <sup>2)</sup>                                     | 102               | 110            | 50             |              |      |          |            |          | ●        |              | ● |    | ●        | ●    |          |                   |          | ●        |          |   | ▲  |                 | ▲    |          | ▲          | ▲        |          |          |          | 581260 |
| 28, ¾" (DN 20) <sup>2)</sup>                                     | 114               | 120            | 54             |              |      |          |            |          | ●        |              | ● |    | ●        | ●    | ●        |                   |          | ●        |          |   | ▲  |                 | ▲    |          | ▲          | ▲        |          |          |          | 581310 |
| 30, 28 U                                                         | 98                | 105            | 47             |              |      |          |            |          | ●        |              |   |    | ●        |      |          |                   |          |          |          |   | ▲  |                 |      |          | ▲          |          |          |          |          | 581150 |
| 32                                                               | 98                | 110            | 50             |              |      |          | ●          |          |          |              |   |    |          |      |          |                   |          | ●        |          |   |    |                 |      |          |            |          | ▲        |          |          | 581280 |
| 32                                                               | 114               | 121            | 54             |              |      |          |            | ●        |          |              |   |    |          |      |          | ●                 | ●        |          |          |   | ●  | ▲               |      |          |            |          |          | ▲        | ▲        | 581320 |
| 1" (DN 25)                                                       | 100               | 105            | 47             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 |      |          |            |          | ■        |          |          | 581520 |
| 33.7, 1" (s = 1.6/2.0/2.6)                                       | 100               | 105            | 47             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 | ■    |          |            | ■        |          |          |          | 581520 |
| 35                                                               | 100               | 105            | 47             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   | ■  |                 | ■    |          |            | ■        |          |          |          | 581500 |
| 35                                                               | 140               | 150            | 68             |              |      |          |            |          | ●        |              |   |    |          |      |          |                   |          |          |          |   | ▲  |                 | ▲    |          |            |          |          |          |          | 581350 |
| 40                                                               | 140               | 148            | 67             |              |      |          |            |          |          |              |   |    |          |      |          | ●                 |          |          |          |   |    |                 |      |          |            |          |          | ▲        |          | 581330 |
| 42                                                               | 140               | 155            | 70             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   | ■  |                 | ■    |          |            | ■        |          |          |          | 581510 |
| 1¼" (DN 32)                                                      | 140               | 150            | 68             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 |      |          |            | ■        |          |          |          | 581530 |
| 42.4, 1¼" (s = 2.0/2.6)                                          | 140               | 150            | 68             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 | ■    |          |            | ■        |          |          |          | 581530 |
| 50                                                               | 135               | 143            | 64             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 |      |          |            |          |          | ■        |          | 581540 |
| ⅜" (9.5 mm)                                                      | 43                | 48             | 22             | ●            |      |          |            |          |          | ●            | ● |    |          |      |          |                   |          |          | ●        | ● |    |                 |      | ▲        | ▲          |          |          |          |          | 581200 |
| ½" (12.7 mm)                                                     | 52                | 60             | 27             | ●            |      |          |            |          |          | ●            | ● |    |          |      |          |                   |          |          | ●        | ● |    |                 |      | ▲        | ▲          |          |          |          |          | 581210 |
| ⅝" (15.9 mm)                                                     | 63                | 70             | 32             | ●            |      |          |            |          |          | ●            | ● |    |          |      |          |                   |          |          | ●        | ● |    |                 |      | ▲        | ▲          |          |          |          |          | 581220 |
| ¾" (19.1 mm)                                                     | 75                | 82             | 37             | ●            |      |          |            |          |          | ●            | ● |    |          |      |          |                   |          |          | ●        | ● |    |                 |      | ▲        | ▲          |          |          |          |          | 581230 |
| ⅞" (22.2 mm)                                                     | 98                | 107            | 48             | ●            |      |          |            |          |          | ●            | ● |    |          |      |          |                   |          |          | ●        | ● |    |                 |      | ▲        | ▲          |          |          |          |          | 581240 |
| 1" (25.4 mm)                                                     | 101               | 112            | 50             |              |      |          |            |          |          | ●            |   |    |          |      |          |                   |          |          | ●        |   |    |                 |      | ▲        |            |          |          |          |          | 581370 |
| 1⅛" (28.6 mm)                                                    | 102               | 110            | 44             |              |      |          |            |          |          | ●            | ● |    |          |      |          |                   |          |          | ●        | ● |    |                 |      | ▲        | ▲          |          |          |          |          | 581260 |
| 1⅜" (28.6 mm)                                                    | 115               | 117            | 53             |              |      |          |            |          |          | ●            |   |    |          |      |          |                   |          |          | ●        |   |    |                 |      | ▲        |            |          |          |          |          | 581380 |
| 1½" (31.8 mm)                                                    | 114               | 123            | 55             |              |      |          |            |          |          | ●            |   |    |          |      |          |                   |          |          | ●        |   |    |                 |      | ▲        | ▲          |          |          |          |          | 581320 |
| 1¾" (31.8 mm)                                                    | 133               | 145            | 65             |              |      |          |            |          |          | ●            |   |    |          |      |          |                   |          |          | ●        |   |    |                 |      | ▲        |            |          |          |          |          | 581390 |
| 1⅝" (34.9 mm)                                                    | 100               | 105            | 47             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 |      | ■        |            |          |          |          |          | 581500 |
| 1⅞" (34.9 mm)                                                    | 140               | 150            | 68             |              |      |          |            |          |          | ●            | ● |    |          |      |          |                   |          |          | ●        |   |    |                 |      | ▲        | ▲          |          |          |          |          | 581350 |
| 1⅝" (41.3 mm)                                                    | 140               | 155            | 70             |              |      |          |            |          |          |              |   |    |          |      |          |                   |          |          |          |   |    |                 |      | ■        | ■          |          |          |          |          | 581510 |

R mm Bending radius mm at the neutral axis of the bend (DVGW GW 392)  
X mm Correction dimension for a 90° or 45° bend  
s mm Wall thickness  
<sup>1)</sup> hard, semi-hard copper pipes, also thin-walled, EN 1057  
<sup>2)</sup> hard copper pipes EN 1057  
<sup>3)</sup> According to DVGW work sheet GW 392 for hard and semi-hard copper pipes  
Ø 28 mm minimum bending radius 114 mm necessary. Wall thickness ≥ 0.9 mm.  
▲ Adaptor block 10–40, support 10–40 (Art.-No. 582120) necessary.  
■ Adaptor block 35–50, support 35–50 (Art.-No. 582110) necessary.  
Cu: hard, half-hard, soft copper tubes, also thin-wall, EN 1057  
Cu 12735: Copper pipes K65 for refrigeration and air conditioning technology in accordance with EN 12735-1, EN 12449  
St 10312: stainless steel pipes of the press fitting systems EN 10312, series 2, EN 10088, EN 10217-7  
St 1127: stainless steel pipes EN ISO 1127, EN 10217-7  
St 10305-U: coated, soft carbon steel pipes of the press fitting systems EN 10305-3  
St 10305: soft precision steel pipes EN 10305-1, EN 10305-2, EN 10305-3, carbon steel pipes EN 10305-3  
St 10255: Steel pipes (threaded pipes) EN 10255  
St 50086: Electrical installation pipes DIN EN 50086  
U: coated  
V: multi-layer composite tubes of pressfitting systems

## Bending to size

If a bend is required at a certain point on the pipe, a length correction must be made to suit the pipe size. The correction dimension X specified in Fig. 1 must be considered for a 90° or 45° bend. The set dimension L must be reduced by the amount X here. If, e.g., the dimension L for pipe size 22 is 400 mm and a bend with a bending radius of 77 mm is to be made, the dimension line should be marked on the pipe at 319 mm. This line is then – as shown in Fig. 1 – to be aligned with the 0-mark on the bending former.

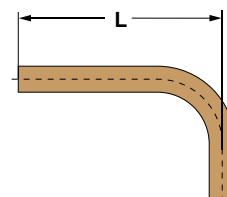
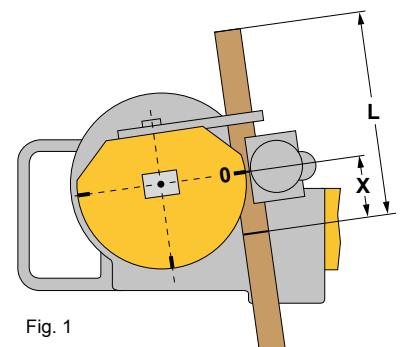


Fig. 1