

# BENDING TOOLS

Gas and water pipes, boiler pipes, electrical installation pipes, and pipes made of special materials such as copper and stainless steel. Bend forming is an art of its own and accordingly requires not only know-how but also the right tools.

In addition to the shape of the tube to be bent, wall thickness, outside diameter, the quality of the tube as well as the shape of the desired end result are decisive for the choice of tool. GEDORE therefore offers a comprehensive selection of hand tube benders, bending machines and eccentric angle benders. The matching bending tools and accessories are also available. The intelligently put together sets make it easier to choose the right equipment.



## **i** HOW DO I FIND THE RIGHT BENDING TOOL?

- The bending tool must always be adapted to the shape of the workpiece
- Outer diameter of a tube is indicated by "D"
- "S" defines the wall thickness of the tube
- Important: always measure the radius to the centre of the tube.
- If several bends are to be made consecutively, it is essential to specify the distance between the bends, "L2"



VERSATILE  
SAFE  
DURABLE

### GEDORE BENDING TOOLS - THAT MAKES THE DIFFERENCE

- Durable quality for continuous professional use
- Material-friendly machining of workpieces
- Hand-operated, hydraulic and electro-hydraulic
- For a wide range of commercially available tube qualities

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### ALL APPLICATIONS COVERED

- Simple pipe benders
- Hydraulic bending
- Hydraulically operated pipe benders
- Tool sets in practical GEDORE i BOXX®es or L-BOXX®es
- Individual parts and accessories optionally available

## Bending tools

### 2415

Pipe bending pliers



- > Sizes from 4,75 to 10 mm Ø to 90°
- > With 2 reversible bending forms 3/16" - 1/4" Ø (4,75 - 6 mm Ø) and 8 - 10 mm Ø

- > For soft copper pipes EN 1057, all non-ferrous metal pipes as well as thin-walled precision steel pipes and brake lines

Code	No.	Ø mm	Ø"inch	l-mm	kg
1442007	241500	4,75-10,0	3/16-3/8	260	0,58

### 2423

Pipe bending pliers



- > Sizes from 10 to 22 mm Ø to 90°



#### Use:

- > For flexible steel and stainless steel pipes (up to max. 18 x 1.5 mm)
- > Soft (also heat-insulated) and semi-hard copper pipes EN 1057

Code	No.	Ø mm	r=mm	l-mm	kg
4564890	242310	10	43	420	1,4
4564970	242312	12	45	420	1,38
4565000	242315	15	60	560	2,14
4565190	242318	18	74	820	2,86
4565270	242322	22	86	820	4,18

### 1100-2431

Manual bending tool set  
9 pieces



- > Sizes from 6 to 15 mm Ø to 180°
- > For soft copper pipes EN 1057 (also with fixed coating)



- > Especially easy bending by ratchet movement with reversible ratchet 1/2" in long version
- > In GEDORE L-BOXX® 136 No. 1100 L

Code	No.	Contents	Pieces	kg
4568450	1100-243100	1 bending lever No. 243010 1 tool holding fixture No. 243070 1 reversible ratchet 1/2" No. 1993 U-10 L 5 pipe bending formers Ø 6, 8, 10, 12, 15 mm 1 pipe cutter 3-35 mm Ø No. 2250 3 + GEDORE L-BOXX® 136 No. 1100 L	9	7,35

### E 243

Parts



Code	No.	Designation	kg
2680203	243070	Tool holder	0,675
4566320	243010	Bending lever	0,98

### E 243

Bending former



Code	No.	Ø mm	r=mm	kg
4566750	243050	6	28	0,26
4566830	243051	8	28	0,25
4567050	243053	10	35	0,44
4567210	243055	12	35	0,41
4567640	243058	15	45	0,65

## 2785

Manual bending tool set  
7 pieces



INOX

FE

- > Sizes from 3 to 10 mm Ø to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391) with 0.75 - 1.0 mm wall thicknesses as well as bendable stainless steel pipes with 1.0 mm wall thicknesses

- > With 5 aluminium bending moulds

Code	No.	Contents	Pieces	
1589830	278500	1 basic tool body 3-10 mm no. 278570 1 bending lever 3-10 mm no. 278581 5 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8, 10 mm	7	1,2

## 1101-2785

Manual bending tool set  
9 pieces



INOX

FE

- > Sizes from 3 to 10 mm to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391) with 0.75 - 1.0 mm wall thicknesses as well as bendable stainless steel pipes with 1.0 mm wall thicknesses

- > With 5 aluminium bending moulds
- > Delivery in GEDORE L-BOXX® 72 no. 1101 L

Code	No.	Contents	Pieces	
1589849	1101-278501	1 basic frame 3-10 mm No. 278570 1 bending lever 3-10 mm No. 278581 5 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8, 10 mm 1 miniature pipe cutter 4-16 mm Ø No. 231011 1 pipe deburring reamer 8-35 mm Ø No. 232501 + GEDORE i-BOXX® 72 No. 1101 L	9	2,4

## E 2785

Parts



Code	No.	Designation	
2293625	278570	Basic tool body size 0	0,64
2293641	278581	Bending lever size 3-10 mm	0,38

## E 2785

Bending former



- > Made of high strength aluminium

Code	No.	Ø mm	r=mm	Bore mm	
1576798	278504	3-4	14	16	0,02
2963361	278505	5	16	16	0,025
1576801	278506	6	16	16	0,025
1576828	278508	8	24	16	0,055
1576836	278510	10	29	16	0,085

## Bending tools

### 2786

Manual bending tool set  
10 pieces



INOX FE MT


> Sizes from 6 to 18 mm Ø to 180°

**Use:**

- > Precision steel pipes EN 10305-3 (DIN 2394)
- > Hydraulic pipes EN 10305-1 (DIN 2391) with 1.0 - 2.0 mm wall thicknesses

> Composite pipes up to 16 mm

- > Bendable stainless steel tubes with wall thicknesses from 1.0 - 1.5 mm
- > With 8 aluminium bending moulds

Code	No.	Contents	Pieces	
1589857	278600	1 basic tool body 6-18 mm no. 278670 1 bending lever 6-18 mm no. 278681 8 aluminium bending formers for pipes with Ø 6-8, 10-12, 14, 15, 16, 18 mm	10	5,26

### 1100-2786

Manual bending tool set  
12 pieces



INOX FE MT


> Sizes from 6 to 18 mm to 180°

**Use:**

- > Precision steel pipes EN 10305-3 (DIN 2394)
- > Hydraulic pipes EN 10305-1 (DIN 2391) with 1.0 - 2.0 mm wall thicknesses

> Composite pipes up to 16 mm

- > Bendable stainless steel tubes with wall thicknesses from 1.0 - 1.5 mm
- > With 8 aluminium bending moulds
- > In GEDORE L-BOXX® 136 No. 1100 L

Code	No.	Contents	Pieces	
1611526	1100-278601	1 basic frame 6-18 mm No. 278670 1 bending lever 6-18 mm attachable No. 278680 8 aluminium bending formers for pipes with Ø 6, 8, 10, 12, 14, 15, 16, 18 mm 1 pipe cutter 3-35 mm Ø No. 2180 3 1 pin punch 3 mm + GEDORE L-BOXX® 136 No. 1100 L	12	8,28

### 1100-2788

Manual bending tool set  
16 pieces



INOX FE MT


> Sizes from 3 to 18 mm to 180°

**Use:**

- > Precision steel pipes EN 10305-3 (DIN 2394)
- > Hydraulic pipes EN 10305-1 (DIN 2391) with 1.0 - 2.0 mm wall thicknesses

> Composite pipes up to 16 mm

- > Bendable stainless steel tubes with wall thicknesses from 1.0 - 1.5 mm
- > With 10 bending moulds made of aluminium
- > In GEDORE L-BOXX® 136 No. 1100 L

Code	No.	Contents	Pieces	
2963515	1100-278801	1 basic frame 3-10 mm No. 278570 1 bending lever 3-10 mm No. 278581 1 basic frame 6-18 mm No. 278670 1 bending lever 6-18 mm attachable No. 278680 10 aluminium bending formers for pipes with Ø 3-4, 5, 6, 8, 10, 12, 14, 15, 16, 18 mm 1 pipe cutter 3-35 mm Ø No. 2180 3 1 pin punch 3 mm + GEDORE L-BOXX® 136 No. 1100 L	16	8,28

### E 2786

Parts



Code	No.	Designation	
<b>1626043</b>	278680	Bending lever size 6-18 mm pluggable	1,93
<b>1677209</b>	278670	Basic tool body size 1	1,24
<b>2293692</b>	278681	Bending lever size 6-18 mm	2,3

### E 2786

Bending former



> Made of high strength aluminium

Code	No.	Ø mm	r=mm	Bore mm	
<b>2963442</b>	278606	6	32	30	0,2
<b>1576844</b>	278608	8	32	30	0,2
<b>2963450</b>	278610	10	36	30	0,22
<b>1576852</b>	278612	12	36	30	0,22
<b>1576879</b>	278614	14	36	30	0,2
<b>1576887</b>	278615	15	43	30	0,32
<b>1576895</b>	278616	16	43	30	0,32
<b>1576909</b>	278618	18	50	30	0,45

### 2787

Manual bending tool set  
5 pieces



Vice not included



- > Sizes from 20 to 25 mm Ø to 180°
- > For precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391) with 1.5 - 2.5 mm wall thicknesses, composite pipes

- up to 25 mm as well as bendable stainless steel pipes with 1.5 - 2.0 mm wall thicknesses
- > With 3 aluminium bending moulds

Code	No.	Contents	Pieces	
<b>1589865</b>	278700	1 basic tool body 20-25 mm no. 278770 1 bending lever 20-25 mm no. 278781 3 aluminium bending formers for pipes with Ø 20, 22, 25 mm	5	13,04

### E 2787

Parts



Code	No.	Designation	
<b>2293706</b>	278770	Basic tool body size 2	4,14
<b>2293722</b>	278781	Bending lever size 20-25 mm	3

### E 2787

Bending former



> Made of high strength aluminium

Code	No.	Ø mm	r=mm	Bore mm	
<b>1576917</b>	278720	20	85	42	2
<b>1576925</b>	278722	22	85	42	1,95
<b>1576933</b>	278725	25	85	42	1,95

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## Bending tools

### E 276

Bending tool



- > No. 276508-276532: Bending mould with aluminium bending rail for metric tubes
- > No. 276103-276107: Bending form for gas and water pipes EN 10255 (DIN 2440/2441), a pressure roller No. 276003 (3/8-3/4") is also required

Code	No.	Designation	∅ mm	Pipe-∅ [inch]	r=mm	Electrical installation pipe-∅ EN 60423	
4600790	276105	Bending former 1/2"	21,3	1/2			2,4
4600870	276107	Bending former 3/4"	5,8	3/4	80		5,8
4601090	276508	Bending former with slide rail 8 mm	8		40		1,44
4601250	276512	Bending former with slide rail 12 mm	12		40		1,36
4601330	276514	Bending former with slide rail 14 mm	14		50		1,86
4601410	276515	Bending former with slide rail 15 mm	15		50		1,82
4601680	276516	Bending former with slide rail 16 mm	16		68		4,74
4602140	276525	Bending former with slide rail 25 mm	25		105	M25	4,74

### 2456

Manual bending tool set hydraulic



- > Sizes from 10 to 22 mm ∅ to 90°
- > For soft copper pipes EN 1057 up to 22 mm (also heat-insulated), composite pipes up to 20 mm as well as precision steel pipes EN 10305-3 (DIN 2394) up to 18 x 1.5 mm

- > With 7 bending forms and corresponding counter holders
- > In plastic case No. 245590

Code	No.	Contents	Pieces	
4635230	245610	1 Basic unit, hydraulic No. 245670 7 bending tools for tubes with ∅ 10, 12, 14, 15, 18, 20, 22 mm 1 plastic case no. 245590	9	5,87
1585495	245611	1 Basic unit, hydraulic No. 245670 10 bending tools for tubes with ∅ 6, 8, 10, 12, 14, 15, 16, 18, 20, 22 mm 1 plastic case no. 245690	12	7,5

### 1100-2456

Manual bending tool set hydraulic, in L-BOXX® 136



- > Sizes from 10 to 22 mm ∅ to 90°
- > For soft copper pipes EN 1057 up to 22 mm (also heat-insulated), composite pipes up to 20 mm as well as precision steel pipes EN 10305-3 (DIN 2394) up to 18 x 1.5 mm

- > With 7 bending forms and corresponding counter holders
- > Delivery in GEDORE L-BOXX® 136 no. 1100 L

Code	No.	Contents	Pieces	
2963531	1100-245680	1 Basic unit, hydraulic No. 245670 7 aluminium bending forms for tubes with ∅ 10, 12, 14, 15, 18, 20, 22 mm 3 counter holders ∅ 6-12, 14-17, 18-22 mm 1 Pipe cutter 3-35 mm ∅ No. 2250 3 GEDORE L-BOXX® 136 No. 1100 L	12	6,86
2963558	1100-245681	1 basic unit, hydraulic No. 245670 10 aluminium bending formers for pipes of ∅ 6, 8, 10, 12, 14, 15, 16, 18, 20, 22 mm 1 counter-support ∅ 6-12 mm 2 counter-supports reinforced ∅ 14-17, 18-22 mm 1 pipe cutter 3-35 mm ∅ No. 2180 3 + GEDORE L-BOXX® 136 No. 1100 L	15	9,62

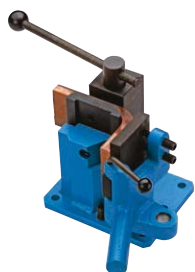
E 245  
Parts

Code	No.	Designation	
4635310	245670	Basic unit, hydraulic	2,35

E 2457 - E 2458  
Bending tool

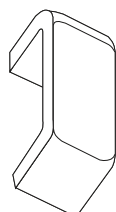
- > No. 245806-245822: Additional counter holders No. 245710-245731 are required
- > For metric pipes

Code	No.	Designation	$\varnothing$ mm	r=mm	
1585509	245721	Counter-support 14-17 mm reinforced			0,38
1585517	245731	Counter-support 18-22 mm reinforced			0,48
4635580	245710	Counter-support 6-12 mm			0,38
4635660	245720	Counter-support 14-17 mm			0,46
4635740	245730	Counter-support 18-22 mm			0,46
4635900	245806	Cast aluminium bending former 6 mm	6	31	0,1
4636040	245808	Cast aluminium bending former 8 mm	8	31	0,1
4636120	245810	Cast aluminium bending former 10 mm	10	31	0,1
4636200	245812	Cast aluminium bending former 12 mm	12	34	0,11
4636390	245814	Cast aluminium bending former 14 mm	14	41	0,12
4636470	245815	Cast aluminium bending former 15 mm	15	48	0,14
4636550	245816	Cast aluminium bending former 16 mm	16	49	0,15
4636710	245818	Cast aluminium bending former 18 mm	18	72	0,19
4636980	245820	Cast aluminium bending former 20 mm	20	80	0,2
4637010	245822	Cast aluminium bending former 22 mm	22	88	0,2

28070  
Eccentric angle bender

- > For round, flat and angle material made of steel, copper and aluminium up to 90°.
- > With infinitely adjustable angular stop
- > With length stop
- > Manual basic unit for mounting on the work-bench, with optional base frame No. 268500 also suitable for stationary use

Code	No.	Designation	
4539940	280070	Angle bender 70 mm	29,5
4535010	280100	Angle bender 100 mm	32,5
4606130	280120	Eccentric angle bender 120 mm	34,1

E 280  
Bending tools

Code	No.	Designation	
4605320	280072	Radiused bending tool 70 mm	1,12
4605670	280113	Bending tool for producing saddles, sharp-edged	0,85
4605750	280114	Bending tool for producing saddles	0,905
4605830	280115	Bending tool for making diamond bends	0,695
4605910	280116	Bending tool for high saddles	1,17
4606050	280117	Offset block	2,31