






PIPE BENDING MACHINES - FORMERS AND COUNTERFORMERS UNI 42-UNI 60






■ FORMERS TYPE "C" IN MM

Cast-iron formers complete with ring to be used without mandrel TYPE C for bending hard copper, steel, stainless steel, bonderized, titanium tubes etc. To be used with Counterformer and/or roller according to tube wall-thickness, from diam. 6 to diam. 60.

UNI								COD./CÓD.
	Ømm	R	min.	max.				
42 - 60	6	30	1	2	•	2,5	•	000636
	8	30	1	2	•	2,5	•	000637
	10	30	1	2	•	2,5	•	000526
	10	40	1	2	•	2,5	•	000426
	12	36	1	2	•	2,5	•	000309
	12	48	1	2	•	2,5	•	000310
	14	42	1	2	•	2,5	•	000311
	14	56	1	2	•	2,5	•	000312
	15	45	1	2	•	2,5	•	000307
	15	60	1	2	•	2,5	•	000308
	16	48	1	2	•	2,5	•	000305
	16	64	1	2	•	2,5	•	000306
	17	51	1	2	•	2,5	•	000313
	17	68	1	2	•	2,5	•	000314
	18	54	1	2	•	2,5	•	000303
	18	72	1	2	•	2,5	•	000304
	19	57	1	2	•	2,5	•	000326
	19	76	1	2	•	2,5	•	000327
	20	60	1	2	•	2,5	•	000281
	20	80	1	2	•	2,5	•	000286
60	22	66	1	2	•	2,5	•	000282
	22	88	1	2	•	2,5	•	000182
	24	72	1	2	•	2,5	•	000301
	24	96	1	2	•	2,5	•	000302
	25	75	1	2	•	2,5	•	000283
	25	100	1	2	•	2,5	•	000284
	26	78	1	2	•	2,5	•	000299
	26	104	1	2	•	2,5	•	000300
	28	84	1	2	•	2,5	•	000297
	28	112	1	2	•	2,5	•	000298
	30	90	1	2	•	2,5	•	000147
	30	120	1	2	•	2,5	•	000148
	32	96	1	2,5	•	2,5	•	000287
	32	128	1	2,5	•	2,5	•	000289
	34	102	1	2,5	•	2,5	•	000290
	34	136	1	2,5	•	2,5	•	000291
	35	105	1	2,5	•	2,5	•	000145
	35	140	1	2,5	•	2,5	•	000146
37	111	1	2,5	•	2,5	•	000292	
37	148	1	2,5	•	2,5	•	000293	
38	114	1	2,5	•	2,5	•	000143	
38	152	1	2,5	•	2,5	•	000144	
40	120	1	2,5	•	2,5	•	000294	
40	160	1	2,5	•	2,5	•	000295	
42	126	1	2,5	•	2,5	•	000141	
42	168	1	2,5	•	2,5	•	000142	
45	135	1	2,5	•	2,5	•	000750	
45	180	1	2,5	•	2,5	•	000414	
50	150	1	2,5	•	2,5	•	000751	
50	200	1	2,5	•	2,5	•	000285	
54	162	1	2,5	•	2,5	•	000752	
54	216	1	2,5	•	2,5	•	000629	

■ FORMERS TYPE "E" IN INCHES


Cast-iron formers complete with ring to be used without mandrel TYPE E for bending hard copper, steel, stainless steel, bonderized, titanium tubes etc. To be used with Counterformer and/or roller according to tube wall-thickness, from diam. 1/4" to diam. 2" 3/8.

UNI								COD./CÓD.	
	Ø"WHI	Ømm	R	min.					max.
42 - 60	1/4	6,35	3D	1	2	•	2,5	•	000633
	5/16	7,94	3D	1	2	•	2,5	•	000634
	3/8	9,52	3D	1	2	•	2,5	•	000635
	1/2	12,70	3D	1	2	•	2,5	•	000332
	1/2	12,70	4D	1	2	•	2,5	•	000333
	5/8	15,88	3D	1	2	•	2,5	•	000334
	5/8	15,88	4D	1	2	•	2,5	•	000335
	3/4	19,05	3D	1	2	•	2,5	•	000552
	3/4	19,05	4D	1	2	•	2,5	•	000553
	7/8	22,22	3D	1	2	•	2,5	•	000554
	7/8	22,22	4D	1	2	•	2,5	•	000339
	1"	25,40	3D	1	2	•	2,5	•	000340
	1"	25,40	4D	1	2	•	2,5	•	000341
	1"1/8	28,58	3D	1	2	•	2,5	•	000342
	1"1/8	28,58	4D	1	2	•	2,5	•	000343
	1"1/4	31,75	3D	1	2,5	•	2,5	•	000344
	1"1/4	31,75	4D	1	2,5	•	2,5	•	000345
	1"3/8	34,92	3D	1	2,5	•	2,5	•	000346
	1"3/8	34,92	4D	1	2,5	•	2,5	•	000347
	1"1/2	38,10	3D	1	2,5	•	2,5	•	000348
1"1/2	38,10	4D	1	2,5	•	2,5	•	000349	
1"5/8	41,28	3D	1	2,5	•	2,5	•	000507	
1"5/8	41,28	4D	1	2,5	•	2,5	•	000509	
60	1"3/4	44,45	3D	1	2,5	•	2,5	•	000562
	1"3/4	44,45	4D	1	2,5	•	2,5	•	000563
	1"7/8	47,62	3D	1	2,5	•	2,5	•	000754
	1"7/8	47,62	4D	1	2,5	•	2,5	•	000565
	2"	50,80	3D	1	2,5	•	2,5	•	000755
	2"	50,80	4D	1	2,5	•	2,5	•	000350
	2"1/8	53,98	3D	1	2,5	•	2,5	•	000756
	2"1/8	53,98	4D	1	2,5	•	2,5	•	000582

PIPE BENDING MACHINES - FORMERS AND COUNTERFORMERS UNI 42-UNI 60

■ FORMERS TYPE "L" IN MM


Cast-iron formers complete with ring to be used without mandrel TYPE L for bending gas tubes. To be used with Counterformer and/or roller according to tube wall-thickness.



UNI	Ø" GAS	EQUIVALENT mm	R. mm	COD/ CÓD
42	1/4	13.72	47	000524
	3/8	17.2	53.5	000194
	1/2	21.3	59	000193
	3/4	26.9	78	000165
	1"	33.7	100	000171
	1"1/4	42.40	127.20	000824
	1" 1/4	42.40	150	000172
60	1"1/2	48.3	144.75	000793
	1" 1/2	48.3	199.5	000331

■ FORMERS TYPE "H" IN MM

Cast-iron formers complete with ring to be used without mandrel TYPE H for bending steel, hydraulics, stainless steel pipes with tight radii (about 2D).



UNI	Ø mm max.	R min.	R max. (mm)	COD/ CÓD .
42-60	20	30	43	H.30-43
	30	43.1	61	H.43-61
	38	61.1	76	H.61-76
	42	76.1	91	H.76-91
	45	91.1	128	H.91-128

■ COUNTERFORMERS (MILLIMETER SIZES)



ITEM	CÓD
Ø 6 - 8	420060
Ø 10 - 12	420061
Ø 12 - 14	420062
Ø 15 - 17	420063
Ø 15 - 18	420064
Ø 16 - 18	420025
Ø 19 - 26	420065
Ø 20 - 24	420066
Ø 20 - 25	420026
Ø 20 - 26	420067
Ø 22 - 28	420027
Ø 30 - 32	420068
Ø 32 - 38	420028
Ø 32 - 40	420069
Ø 34 - 37	420070
Ø 35 - 38	420071
Ø 35 - 40	420029
Ø 42	420072
Ø 42 (1)	420075
Ø 45	420076
Ø 50	420077
Ø 50 (1)	420077.60
Ø 54	420078
Ø 60	420081

1. For UNI 60
2. Double coated Aluminium Type Mepla, Alupex e simila r)

■ COUNTERFORMERS (REAL INCHES SIZES)



ITEM	COD.
Ø 1/4 - 5/16	420103
Ø 3/8 - 1/2	420104
Ø 5/8 - 3/4	420105
Ø 7/8 - 1"	420030
Ø 1"1/4 - 1"1/2	420039
Ø 1"1/8 - 1"3/8	420031
Ø 1"5/8	420100
Ø 1"5/8 solo/only/ UNI 60 - 70/C	420101
Ø 1"3/4	420102
Ø 1"3/4 solo/only/UNI 60 - 70/C	420106
Ø 1"7/8	420107
Ø 2"	420108
Ø 2"1/8	420109

PIPE BENDING MACHINES - FORMERS AND COUNTERFORMERS UNI 42-UNI 60

■ COUNTERFORMERS (GAS INCHES SIZES)



ARTICOLO/ITEM/ARTÍCULO	CÓD
Ø 1/8 - 1/4	420130
Ø 3/8 - 1/2	420131
Ø 3/4 - 1"	420032
Ø 1"1/4	420132
Ø 1"1/4 solo/only/solamente UNI 60 - 70/C	420133
Ø 1"1/2	420134

■ ROLLS IN MM FOR UNI 42




ITEM	CÓD
Universal UNI 42	595362
Ø 10	595363
Ø 12	595364
Ø 14	595365
Ø 15	595366
Ø 16	595367
Ø 17	595368
Ø 18	595369
Ø 19	595370
Ø 20	595371
Ø 22	595372
Ø 24	595373
Ø 25	595374
Ø 26	595375
Ø 28	595376
Ø 30	595377
Ø 32	595378
Ø 34	595379
Ø 35	595380
Ø 37	595381
Ø 38	595382
Ø 40	595383
Ø 42	595384

■ ROLLS (Real Inches Sizes) FOR UNI 42




ITEM	CÓD
Ø 1/4"	595385
Ø 3/8"	595386
Ø 1/2"	595387
Ø 5/8"	595388
Ø 3/4"	595389
Ø 7/8"	595390
Ø 1"	595391
Ø 1"1/8	595392
Ø 1"1/4	595393
Ø 1"3/8	595394
Ø 1"1/2	595395
Ø 1"5/8	595396

■ ROLLS (GAS INCHES SIZES) FOR UNI 60




ITEM	CÓD
Ø 1/4"	595134
Ø 3/8"	595104
Ø 1/2"	595105
Ø 3/4"	595106
Ø 1"	595238
Ø 1"1/4	595108
Ø 1"1/2	595284
Ø 2"	595285
Ø 2"1/2	595413
Ø 3"	595422

■ ROLLS (GAS INCHES SIZES) FOR UNI 42



ITEM	CÓD
Ø 1/4"	595397
Ø 3/8"	595398
Ø 1/2"	595399
Ø 3/4"	595400
Ø 1"	595401
Ø 1"1/4	595402

■ ROLLS IN MM FOR UNI 60



ITEM	CÓD
Universal UNI 60	595155
Rullo Ø 10	595113
Rullo Ø 12	595114
Rullo Ø 14	595115
Rullo Ø 15	595103
Rullo Ø 16	595116
Rullo Ø 17	595112
Rullo Ø 18	595102
Rullo Ø 19	595117
Rullo Ø 20	595089
Rullo Ø 22	595090
Rullo Ø 24	595118
Rullo Ø 25	595091
Rullo Ø 26	595119
Rullo Ø 28	595092
Rullo Ø 30	595093
Rullo Ø 32	595109
Rullo Ø 34	595111
Rullo Ø 35	595094
Rullo Ø 37	595120
Rullo Ø 38	595132
Rullo Ø 40	595110
Rullo Ø 42	595101
Rullo Ø 45	595271
Rullo Ø 50	595122
Rullo Ø 52	595272
Rullo Ø 54	595273

■ ROLLS (REAL INCHES SIZES) FOR UNI 60



ITEM	CÓD
Ø 1/2"	595136
Ø 5/8"	595137
Ø 3/4"	595138
Ø 7/8"	595139
Ø 1"	595140
Ø 1"1/8	595141
Ø 1"1/4	595147
Ø 1"3/8	595286
Ø 1"1/2	595129
Ø 1"5/8	595142
Ø 1"3/4	595143
Ø 1"7/8	595144
Ø 2"	595145
Ø 2"1/8	595287
Ø 2"1/4	595146
Ø 2"3/8	595288
Ø 2"1/2	595409
Ø 2"5/8	595410
Ø 2"3/4	595411
Ø 2"7/8	595412
Ø 3"	595413
Ø 3"1/4	595420
Ø 3"1/2	595421

ACCESSORIES FOR UNI 42 AND UNI 60

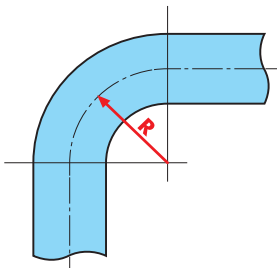


Special guide for two rolls to be used for bending pipes over 2.5 thickness (it must be used with 2 rolls according to pipe's diameter). This special tool avoids pipe's exterior flattening. Can be used with formers type C-E-L-H-G.
A- to be used on UNI 42 electrical / digital single phase (max 1" gas) (code 000844)
B- to be used on all UNI 60 versions (code 000969)

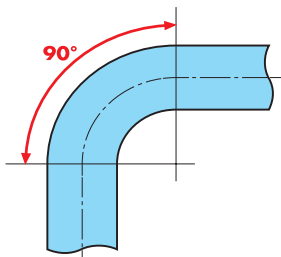


Reinforcement tie-rod for formers C-E-L-G. To be used when bending stainless steel pipes with diameter over 33 mm (and corresponding inch sizes), and also other types of tubes with diameter over 42mm (and corresponding inch sizes). To be used on UNI 60 electric single-phase, digital (code 00744)

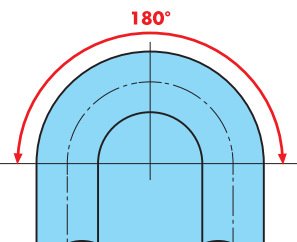
USEFUL INFORMATION FOR THE PURCHASE OF A PIPE BENDING MACHINE TYPE UNI



1 It is necessary to know the type of material of the pipe to bend, the outside diameter (mm/gas inch/Wht real inch), the pipe wall-thickness (mm) and the required bending radius.



2 The bending radius (not to confuse with the bending angle) is the distance between the hypothetical centre of the circle and the centre of the bent pipe.
When speaking of radius 3D or 4D we mean that the bending radius is 3 or 4 times the outside diameter of the pipe (example: diam.40 mm, radius 3D = $40 \times 3 = 120\text{mm}$).
Bear in mind that the bigger the bending radius, the better the result on the bent pipe will be.



3 The bending angle, expressed in degrees, determines the width of the bend.

4 You can bend without using the mandrel system when you do not have particular exigencies or when you must bend thick pipes and/or with bending radii 3D/4D or bigger ones.
On the contrary you must bend with mandrel system everytime you have particular exigencies or when you must bend thin pipes and/or with smaller bending radii 2D/2,5D.