





## USEFUL INFORMATION

544

## PIPE BENDING SPRINGS NO. 2450



544

## PIPE BENDING PLIERS NO. 241-242



544 - 545

## MANUAL PIPE BENDER – DRAW BENDING OPERATION

### MANUAL BENDING TOOL SETS NO. 243



546

### MANUAL BENDING TOOL SETS NO. 244



547

### MANUAL BENDING TOOL SETS NO. 278



548 - 550

### MANUAL BENDING TOOL SETS NO. 240



551

### UNIVERSAL MANUAL PIPE BENDER NO. 276



551

## MANUAL PIPE BENDER – PUSHING BENDING OPERATION NO. 2454-2456



552 - 553

## PIPE BENDING MACHINES – DRAW BENDING OPERATION

### PIPE BENDING MACHINES HYDRAULIC NO. 246



554

### PIPE BENDING MACHINES HYDRAULIC NO. 249



555

## PIPE BENDING MACHINES – PUSHING BENDING OPERATION NO. 255-260



556 - 561

## ECCENTRIC ANGLE BENDERS NO. 280



562 - 564

## RING BENDING MACHINE NO. 285



565

## PIPE STRAIGHTENING TOOL NO. 286



565

## HOW DO I FIND THE RIGHT BENDING TOOL

566 - 567

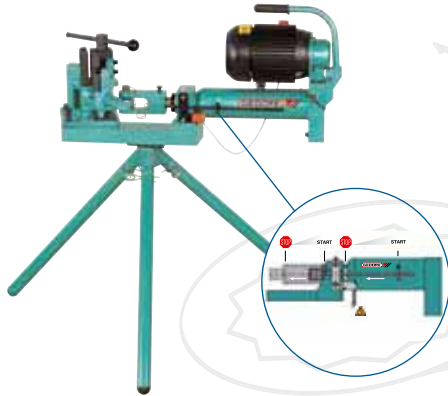




## GEDORE Pipe bending systems

### Features that make the difference...

- ✔ Durable quality for heavy professional use
- ✔ Gentle handling of workpieces
- ✔ Suitable for solving problems, a variety of materials and applications



Electrical limiter

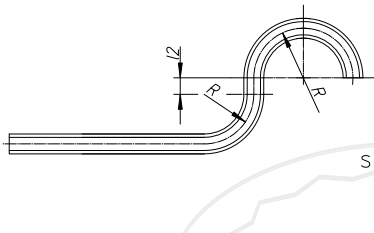
- ✔ From simple bending pliers to an electro-hydraulic bending machine for 3" pipes
- ✔ Hand-operated, hydraulic and electro-hydraulic
- ✔ For the complete range of standard pipe grades
- ✔ Solving problems is our strength - Please ask us!



## Useful information

You need to consider the following points when choosing your bending machine:

- ✔ Do you want to bend by hand?
- ✔ Do you want to use a vice?
- ✔ Is the machine to be hydraulically operated?
- ✔ Is the machine to be electrically operated, and if so at what voltage?



The following points also need to be taken into account; refer to adjacent sketch:

- ✔ The shape of the pipe to be bent (round-section, square-section, etc.)
- ✔ The outside diameter "D" of the pipe
- ✔ The wall thickness "S" of the pipe
- ✔ The pipe grade (e.g. steel, stainless steel, NF metals, etc.)
- ✔ The required bending angle (e.g. 90°, 180° ... etc.)
- ✔ Are bending radii "R" specified? (Example: 3 x D = R - this corresponds to a 25 mm outside diameter pipe with a bending radius of 75 mm)
- ✔ Important: the radius is measured to the middle of the tube = neutral area
- ✔ Details of the length "L" of the overall pipe
- ✔ Are a number of bends to be made in succession? - If so, it is essential to state the distance between the pipe bends, "L2"
- ✔ Are there any specifications for the pipe or the finished pipe bends which go beyond the details listed here (e.g. in power-station construction, the food industry or similar)?

A more detailed overview of the possible uses of our pipe bending machines and tools is given in the next pages.

## PIPE BENDING SPRINGS

2450

### COPPER PIPE BENDING SPRING

- ✔ From 6.5 to 16 mm
- ✔ For soft copper pipes EN 1057



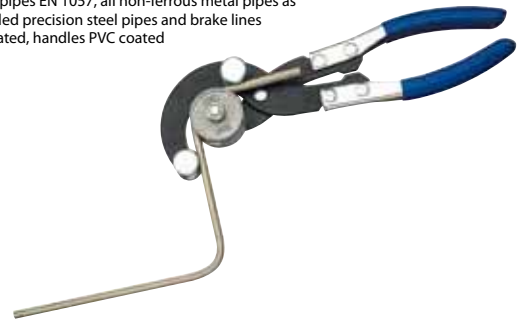
Code	No.	Ø mm	l mm	r mm	l mm
4573610	245006	6,5	250	55	5
4538460	245008	8,0	250	90	5
4538540	245010	10,0	275	110	5
4538620	245012	12,0	300	180	5
4538700	245015	15,0	300	200	5
4574180	245016	16,0	300	275	5

## PIPE BENDING PLIERS

2415

### PIPE BENDING PLIERS

- ✔ Sizes from 4.75 - 10 mm Ø up 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
- ✔ Bright nickel-plated, handles PVC coated



Code	No.	Ø mm	Ø inch	r mm	l mm	l mm
1442007	241500	4,75-10,0	3/16-3/8	260	580	1

E 2415

### SPARE BENDING FORMER



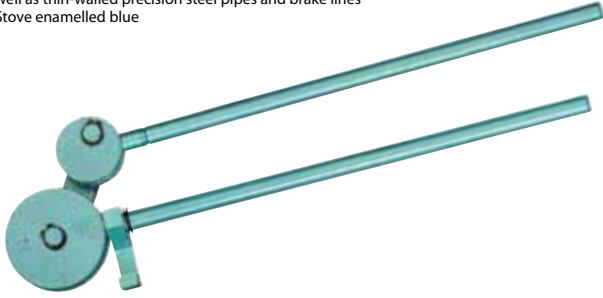
Code	No.	Ø mm	Ø inch	r mm	l mm	l mm
1442910	241506	4,75-6,0	3/16-1/4	15	40	1
1442929	241510	8,0-10,0	5/16-3/8	15	40	1





**2410****PIPE BENDING PLIERS**

- ✔ Sizes from 4.75 to 12 mm Ø up to 180°
- ✔ For soft copper pipes EN 1057, non-ferrous metal pipes as well as thin-walled precision steel pipes and brake lines
- ✔ Stove enamelled blue



Code	No.	Ø mm	r = mm	l-mm-H	l	⊞
4564460	<b>241005</b>	4,75-5,0	18	255	525	1
4564540	<b>241006</b>	6,0	18	275	520	1
4564620	<b>241008</b>	8,0	28	340	780	1
4564700	<b>241010</b>	10,0	28	400	1110	1
4634690	<b>241012</b>	12,0	35	400	1800	1

**2420****PIPE BENDING PLIERS with bending rail**

- ✔ Sizes from 10 to 22 mm Ø, bends up to 90°
- ✔ With small radii
- ✔ For soft copper pipes EN 1057 and soft steel pipes (also with fixed coating)
- ✔ Blue powder-coated, handles PVC coated



Code	No.	Ø mm	r = mm	l-mm-H	l	⊞
1461516	<b>242010</b>	10	30	420	1.4	1
1461524	<b>242012</b>	12	30	420	1.4	1
1461532	<b>242014</b>	14	45	560	2.1	1
1409417	<b>242015</b>	15	45	560	2.2	1
1461540	<b>242016</b>	16	60	560	2.2	1
1409433	<b>242018</b>	18	74	820	3.0	1
1461567	<b>242020</b>	20	75	820	4.3	1
1461575	<b>242022</b>	22	75	820	4.3	1

**2423****PIPE BENDING PLIERS with roller**

- ✔ Sizes from 10 to 22 mm Ø, bends up to 90°
- ✔ For bendable steel and stainless steel pipes (max. wall thickness 1.5 mm) as well as soft, heat-insulated copper pipes EN 1057
- ✔ Enamelled blue



Code	No.	Ø mm	r = mm	l-mm-H	l	⊞
4564890	<b>242310</b>	10	43	420	1.4	1
4564970	<b>242312</b>	12	43	420	1.4	1
4565000	<b>242315</b>	15	60	560	2.1	1
4565190	<b>242318</b>	18	74	820	2.9	1
4538030	<b>242320</b>	20	86	820	3.6	1
4565270	<b>242322</b>	22	86	820	4.2	1

**2424****PIPE BENDING PLIERS with bending rail**

- ✔ Sizes from 10 to 22 mm Ø, bends up to 90°
- ✔ For thin-walled, bendable steel pipes (max. wall thickness 1.5 mm) as well as soft copper pipes EN 1057 (also with fixed coating)
- ✔ Slide rail powder-coated, enamelled blue



Code	No.	Ø mm	r = mm	l-mm-H	l	⊞
4565350	<b>242410</b>	10	43	420	1.4	1
4626670	<b>242412</b>	12	43	420	1.4	1
4565430	<b>242415</b>	15	60	560	2.1	1
4565510	<b>242418</b>	18	74	820	2.9	1
4565780	<b>242420</b>	20	86	820	3.6	1
4565860	<b>242422</b>	22	86	820	4.3	1

**2425****PIPE BENDING PLIERS HH with plastic slide rail**

- ✔ Sizes from 12 to 22 mm Ø, up to 90°
- ✔ Especially for semi-hard and soft copper pipes EN 1057
- ✔ Enamelled blue, with plastic slide rail



Code	No.	Ø mm	r = mm	l-mm-H	l	⊞
1224689	<b>242512</b>	12	43	420	1.4	1
1224670	<b>242515</b>	15	60	560	2.0	1
1224050	<b>242518</b>	18	74	820	2.8	1
1223690	<b>242522</b>	22	86	820	4.1	1





**MANUAL PIPE BENDER – DRAW BENDING OPERATION**

**243**

**MANUAL BENDING TOOL SET**

- ✔ In different sizes up to 90° or 180°
- ✔ For soft copper pipes EN 1057 (also with fixed coating), thin-walled precision steel pipes as well as pipes in non-ferrous metals
- ✔ Single-hand use of the benders with hand lever no. 243020 / 243030 or clamped to a vice with stationary bending former holder no. 243040
- ✔ Stove enamelled blue
- ✔ Delivery in sheet steel case no. 243090
- ✔ Special sets may be assembled to order

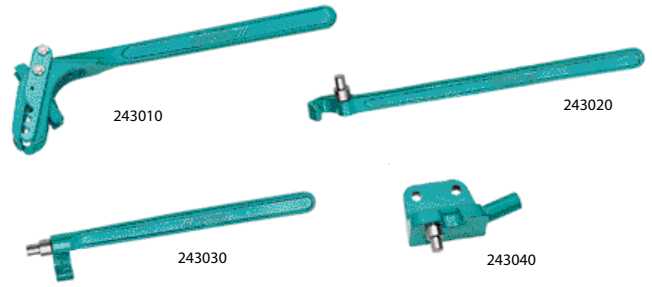


Code	No.	📏
4568450	<b>243100</b> 1 bending lever No. 243010 1 hand lever 90° No. 243020 1 hand lever 180° No. 243030 1 bending former holder, stationary No. 243040 5 bending formers 8, 10, 12, 14, 15 mm 1 pipe cutter 4-32 mm Ø No. 230010 1 sheet steel case No. 243090	9.4
4538380	<b>243200</b> 1 bending lever No. 243010 1 hand lever 90° No. 243020 4 bending formers for pipes with Ø 8, 10, 12, 15 mm 1 sheet steel case No. 243090	6.6
4568530	<b>243600</b> 1 bending lever No. 243010 1 hand lever 90° No. 243020 1 hand lever 180° No. 243030 1 bending former holder, stationary No. 243040 5 bending formers 5/16, 3/8, 7/16, 1/2, 5/8" 1 pipe cutter 4-32 mm Ø No. 230010 1 sheet steel case No. 243090	9.4
4568610	<b>243700</b> 1 bending lever No. 243010 1 hand lever 90° No. 243020 4 bending formers for pipes with Ø 5/16, 3/8, 1/2, 5/8" 1 sheet steel case No. 243090	6.7



**E 243**

**PARTS**



Code	No.	📏	📦
4566320	<b>243010</b> Bending lever	980	1
4566400	<b>243020</b> Hand lever 90 degrees	920	1
4566590	<b>243030</b> Hand lever 180 degrees	920	1
4566670	<b>243040</b> Bending former holder, stationary	950	1
4504050	<b>230010</b> Pipe cutter QUICK AUTOMATIC 4-32 mm	435	1
4568370	<b>243090</b> Sheet steel case	3460	1

**E 243**

**BENDING FORMER**



Code	No.	Ø inch	Ø mm	r = mm	📏	📦
4566750	<b>243050</b>		6,0	28	225	1
4566830	<b>243051</b>		8,0	28	200	1
4567050	<b>243053</b>		10,0	35	320	1
4567210	<b>243055</b>		12,0	35	300	1
4567560	<b>243057</b>		14,0	45	460	1
4567640	<b>243058</b>		15,0	45	420	1
4567720	<b>243059</b>		16,0	45	405	1
4567800	<b>243065</b>	5/16	7,94	28	220	1
4567990	<b>243066</b>	3/8	9,53	35	340	1
4568020	<b>243067</b>	7/16	11,11	35	315	1
4568100	<b>243068</b>	1/2	12,7	45	495	1
4568290	<b>243069</b>	5/8	15,88	45	410	1



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**MANUAL BENDING TOOL SET**

- In different sizes up to 180°
- For soft copper pipes EN 1057, hydraulic and precision steel pipes as well as pipes in non-ferrous metals
- For use in a vice
- Power-saving lever mechanism for easy operation
- Stove enamelled blue
- Delivery in sheet steel case no. 244090
- Special sets may be assembled to order



Code	No.	
4571750	<b>244100</b> 1 basic unit No. 244070 1 bending lever No. 244080 6 bending formers for pipes with Ø 15, 16, 18, 20, 22, 28 mm 1 pipe cutter 4-32 mm Ø No. 230010 1 sheet steel case No. 244090	25.4
4571830	<b>244200</b> 1 basic unit No. 244070 1 bending lever No. 244080 4 bending tools for pipes with Ø 15, 18, 22, 28 mm 1 sheet steel case No. 244090	22.4
4573450	<b>244600</b> 1 basic unit No. 244070 1 bending lever No. 244080 4 bending tools for pipes with Ø 5/8, 3/4, 7/8, 1" 1 pipe cutter 4-32 mm Ø No. 230010 1 sheet steel case No. 244090	22.8
4568880	<b>244010</b> 1 basic unit No. 244070 1 bending lever No. 244080 1 sheet steel case No. 244090 without bending tools	14.3



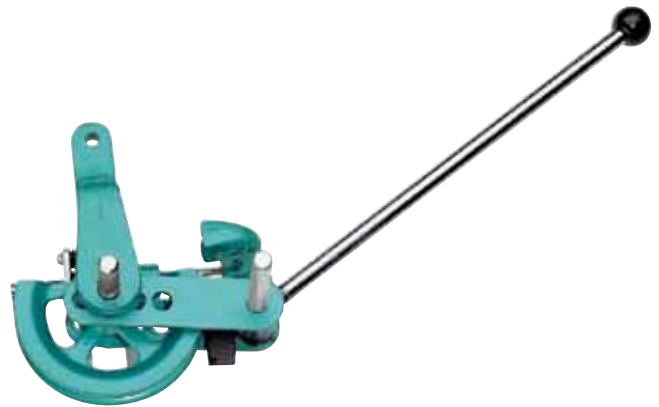
➔ 921



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E 244

**PARTS**



Code	No.		
4569930	<b>244070</b> Basic unit	4.9	1
4571590	<b>244080</b> Bending lever	2.4	1
4504050	<b>230010</b> Pipe cutter QUICK AUTOMATIC 4-32 mm	0.4	1
4571670	<b>244090</b> Sheet steel case	7.0	1

E 244

**BENDING TOOLS**

- Consisting of bending former and bending rail



Code	No.		$\varnothing$ mm	r = mm		
4571910	<b>244210</b>		10,00	40	0.9	1
4572050	<b>244212</b>		12,00	40	0.9	1
4572210	<b>244214</b>		14,00	50	1.2	1
4572480	<b>244215</b>		15,00	50	1.1	1
4572560	<b>244216</b>		16,00	50	1.1	1
4572720	<b>244218</b>		18,00	65	1.5	1
4572800	<b>244220</b>		20,00	65	1.4	1
4572990	<b>244222</b>		22,00	85	2.3	1
4573100	<b>244225</b>		25,00	100	3.5	1
4573290	<b>244228</b>		28,00	100	3.2	1
4573370	<b>244230</b>		30,00	100	3.1	1
4568960	<b>244035</b>	5/8	15,88	50	1.1	1
4569180	<b>244036</b>	3/4	19,05	65	1.5	1
4569260	<b>244037</b>	7/8	22,22	85	2.1	1
4569340	<b>244038</b>	1	25,40	100	3.4	1



➔ 923



487





**2780 - 2785**

**MANUAL BENDING TOOL SET**

- ✔ Sizes from 3 to 10 mm up to 180°
- ✔ No. 2780 with steel bending formers for precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391)
- ✔ No. 2785 with aluminium bending forms also for bendable stainless steel pipes with 1.0 - 1.2 mm wall thicknesses
- ✔ For clamping in a vice or useable as bending pliers
- ✔ Enamelled blue, with black plastic handles



278001



278501



Code	No.	
4539780	<b>278000</b>	1 basic tool body No. 278070, 1 bending lever No. 278080, 4 steel bending formers for pipes with Ø 3-4, 5-6, 7-8, 10 mm
1543199	<b>278001</b>	1 basic tool body No. 278070, 1 bending lever No. 278080, 4 steel bending formers for pipes with Ø 3-4, 5-6, 7-8, 10 mm
1589830	<b>278500</b>	1 basic tool body No. 278570, 1 bending lever No. 278581, 4 aluminium bending formers for pipes with Ø 3-4, 5-6, 7-8, 10 mm
1589849	<b>278501</b>	1 basic tool body No. 278570, 1 bending lever No. 278581, 4 aluminium bending formers for pipes with Ø 3-4, 5-6, 7-8, 10 mm

**E 2780 - E 2785**

**PARTS**



278080



278070

**E 2780 - E 2785**

**BENDING FORMER**

- ✔ No. 278004-278010 steel type
- ✔ No. 278504-278510 aluminium type



Code	No.	mm	mm
4603110	<b>278070</b>	640	1
2293625	<b>278570</b>	640	1
4603380	<b>278080</b>	380	1
2293641	<b>278581</b>	380	1
1526189	<b>278090</b>	1040	1

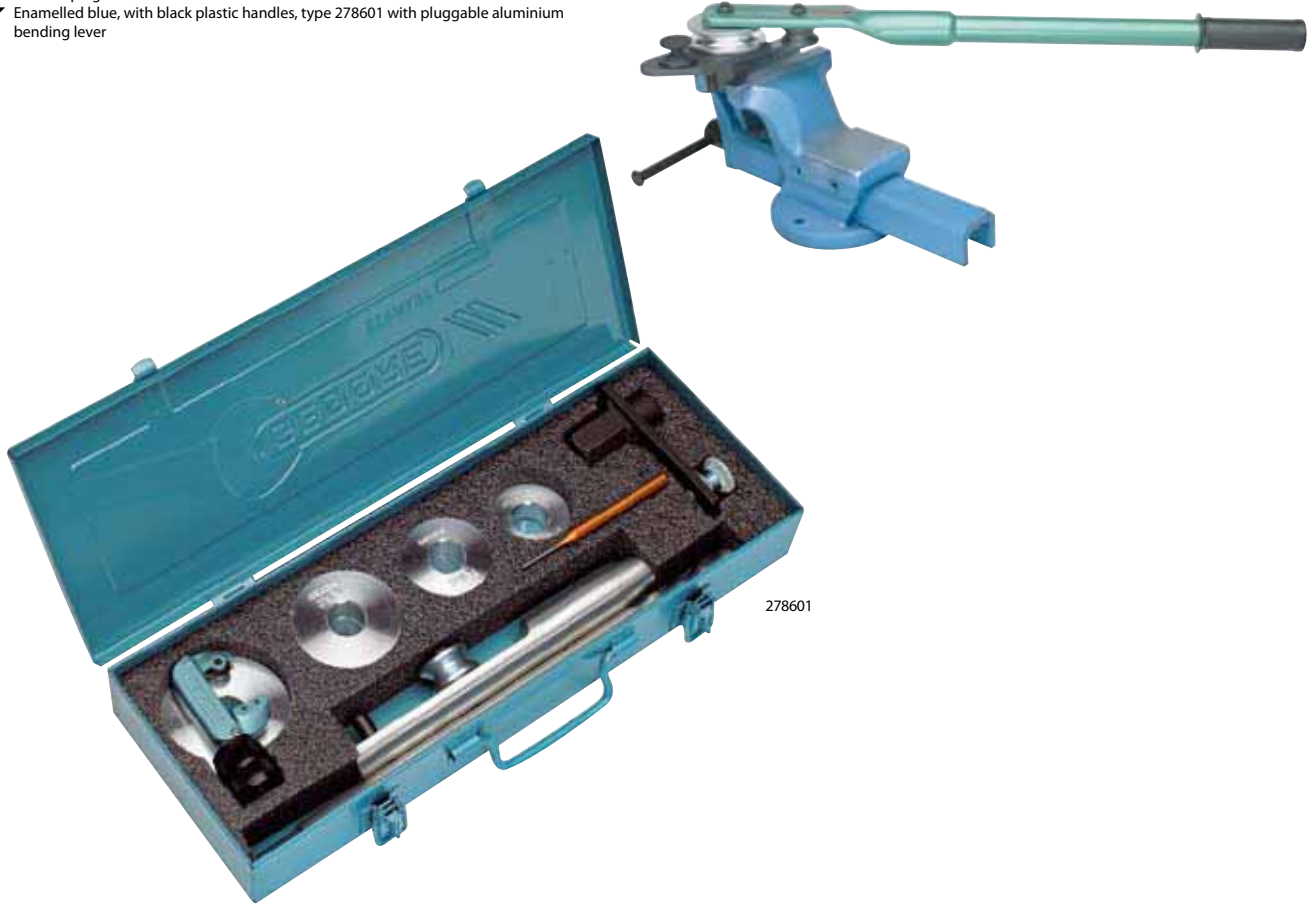
Code	No.	Ø mm	r = mm	mm	mm
4602650	<b>278004</b>	3-4	14	49	1
4602730	<b>278006</b>	5-6	16	63	1
4602810	<b>278008</b>	7-8	24	156	1
4603030	<b>278010</b>	10	29	220	1
1576798	<b>278504</b>	3-4	14	20	1
1576801	<b>278506</b>	5-6	16	25	1
1576828	<b>278508</b>	7-8	24	55	1
1576836	<b>278510</b>	10	29	85	1



## 2781 - 2786

### MANUAL BENDING TOOL SET

- ✔ Sizes from 6 to 18 mm up to 180°
- ✔ No. 2781 with steel bending formers for precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391)
- ✔ No. 2786 with aluminium bending forms also for bendable stainless steel pipes with 1.2 - 1.5 mm wall thicknesses
- ✔ For clamping in a vice
- ✔ Enamelled blue, with black plastic handles, type 278601 with pluggable aluminium bending lever



278601

Code	No.	
4603460	<b>278100</b>	1 basic tool body No. 278170, 1 bending lever No. 278180, 6 steel bending formers for pipes with Ø 6-8, 10-12, 14, 15, 16, 18 mm
1589857	<b>278600</b>	1 basic tool body No. 278670, 1 bending lever No. 278681, 6 aluminium bending formers for pipes with Ø 6-8, 10-12, 14, 15, 16, 18 mm
1611526	<b>278601</b>	1 basic tool body No. 278670, 1 bending lever pluggable No. 278680, 6 aluminium bending formers for pipes with Ø 1 pipe cutter 4-35 mm, 1 pin punch 3 mm, 1 sheet steel case No. 278190

## E 2781 - E 2786

### PARTS



## E 2781 - E 2786

### BENDING FORMER

- ✔ No. 278108-278118 steel type
- ✔ No. 278608-278618 aluminium type



Code	No.	Ø mm	r = mm		
4603540	<b>278108</b>	6-8	32	560	1
4603620	<b>278112</b>	10-12	36	600	1
4603700	<b>278114</b>	14	36	560	1
4624890	<b>278115</b>	15	43	880	1
4603890	<b>278116</b>	16	43	850	1
4603970	<b>278118</b>	18	50	1180	1
1576844	<b>278608</b>	6-8	32	200	1
1576852	<b>278612</b>	10-12	36	220	1
1576879	<b>278614</b>	14	36	200	1
1576887	<b>278615</b>	15	43	320	1
1576895	<b>278616</b>	16	43	320	1
1576909	<b>278618</b>	18	50	450	1



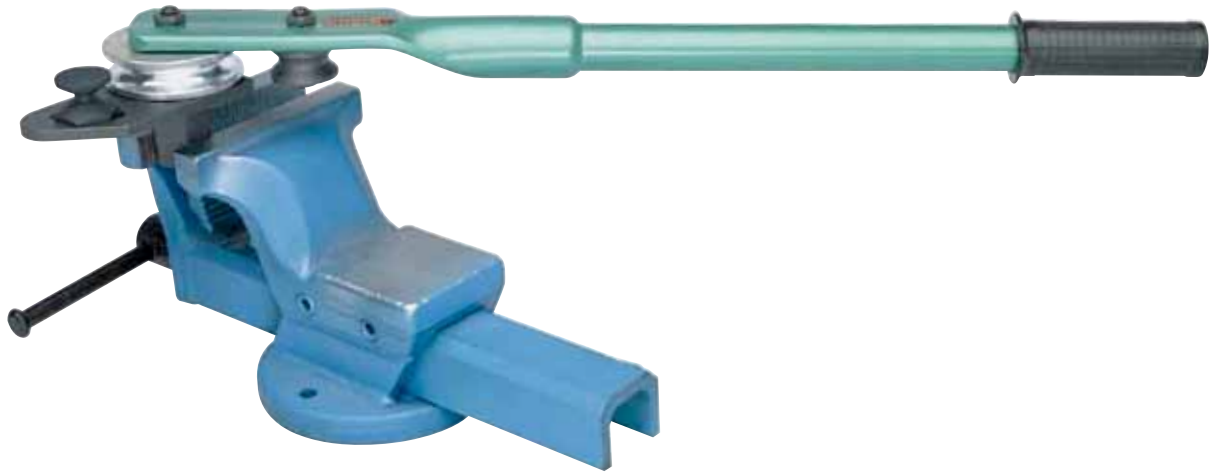
Code	No.		
4604000	<b>278170</b>	1240	1
	Basic tool body size 1		
1677209	<b>278670</b>	1240	1
	Basic tool body size 1 for VA		
4604190	<b>278180</b>	2300	1
	Bending lever size 1		
2293692	<b>278681</b>	2300	1
	Bending lever size 1 for VA		
1626043	<b>278680</b>	1930	1
	Bending lever size 1 pluggable for VA		
1611534	<b>278190</b>	4180	1
	Sheet steel case for 278601		



**2782 - 2787**

**MANUAL BENDING TOOL SET**

- ✔ Sizes from 20 to 25 mm up to 180°
- ✔ No. 2782 with steel bending formers for precision steel pipes EN 10305-3 (DIN 2394), hydraulic pipes EN 10305-1 (DIN 2391)
- ✔ No. 2787 with aluminium bending forms also for bendable stainless steel pipes with 1.5 - 2.0 mm wall thicknesses
- ✔ For clamping in a vice
- ✔ Enamelled blue, with black plastic handles



Code	No.	Weight
4539860	<b>278200</b> 1 basic tool body No. 278270, 1 bending lever No. 278280, 3 steel bending formers for pipes with Ø 20, 22, 25 mm	22.6
1589865	<b>278700</b> 1 basic tool body No. 278770, 1 bending lever No. 278781, 3 aluminium bending formers for pipes with Ø 20, 22, 25 mm	13.0

**E 2782 - E 2787**

**PARTS**



Code	No.	Weight	Icon
4604510	<b>278270</b> Basic tool body size 2	4140	1
2293706	<b>278770</b> Basic tool body size 2 for VA	4140	1
4604780	<b>278280</b> Bending lever size 2	3000	1
2293722	<b>278781</b> Bending lever size 2 for VA	3000	1

**E 2782 - E 2787**

**BENDING FORMER**

- ✔ No. 278220-278225: steel type
- ✔ No. 278720-278725: aluminium type



Code	No.	Ø mm	r = mm	Weight	Icon
4604270	<b>278220</b>	20	85	5380	1
4604350	<b>278222</b>	22	85	5180	1
4604430	<b>278225</b>	25	85	4900	1
1576917	<b>278720</b>	20	85	2000	1
1576925	<b>278722</b>	22	85	1950	1
1576933	<b>278725</b>	25	85	1950	1



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922



  
**487**

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923



  
**487**



**240**

**PIPE BENDER SET with slide rail / with roller**

- ✔ Sizes from 12 to 22 mm Ø up to 180°
- ✔ No. 2400: With slide rail for semi-hard and soft copper pipes EN 1057, soft steel pipes (also with fixed coating) as well as aluminium and brass pipes
- ✔ No. 2405: With rollers for semi-hard and soft copper pipes EN 1057, hydraulic pipes EN 10305-1 (DIN 2391), precision steel pipes EN 10305-3 (DIN 2394) as well as soft steel, aluminium and brass pipes
- ✔ For use in a vice
- ✔ Delivery in assembly case no. 240090



Code	No.		
4537730	<b>240001</b>	4 pipe bending tools with slide rail for pipe-Ø 12, 15, 18, 22 mm 1 pipe cutter 4-35 mm 1 pipe deburring reamer 4-35 mm No. 232001 1 assembly case No. 240090	17.9
4632800	<b>240501</b>	4 pipe bending tools with roller for pipe-Ø 12, 15, 18, 22 mm 1 pipe cutter 4-35 mm 1 pipe deburring reamer 4-35 mm No. 232001 1 assembly case No. 240090	17.9
4562250	<b>240090</b>	Assembly case, empty	4.6

**240**

**PIPE BENDER with slide rail / with roller**

- ✔ Sizes from 10 to 22 mm Ø up to 180°
- ✔ No. 2400: With slide rail for semi-hard and soft copper pipes EN 1057, soft steel pipes (also with fixed coating) as well as aluminium and brass pipes
- ✔ No. 2405: With rollers for semi-hard and soft copper pipes EN 1057, hydraulic pipes EN 10305-1 (DIN 2391), precision steel pipes EN 10305-3 (DIN 2394) as well as soft steel, aluminium and brass pipes
- ✔ For use in a vice



Code	No.	Ø mm	r = mm		
2001284	<b>240010</b>	10	45	1.7	1
4561790	<b>240012</b>	12	45	1.7	1
4561950	<b>240015</b>	15	65	2.1	1
4562170	<b>240018</b>	18	80	3.5	1
4537810	<b>240022</b>	22	80	4.4	1
2001292	<b>240510</b>	10	45	1.7	1
4633020	<b>240512</b>	12	45	1.7	1
4633290	<b>240515</b>	15	65	2.1	1
4633450	<b>240518</b>	18	80	3.5	1
4633610	<b>240522</b>	22	80	4.4	1

**276**

**UNIVERSAL PIPE BENDER**

- ✔ Sizes from 6 to 32 mm Ø and 1/8 to 3/4" up to 180°
- ✔ For semi-hard and soft copper pipes EN 1057 up to 22 mm Ø, stainless steel pipes EN 10088-3 (DIN 17 440) up to 28 x 1.5 mm, hydraulic pipes EN 10305-1 (DIN 2391) and precision steel pipes EN 10305-3 (DIN 2394) up to 28 mm, electrical installation pipes EN 60423 up to M 32, composite pipes up to 32 mm, non-ferrous metal pipes and insulated pipes as well as gas and water pipes EN 10255 (DIN 2440/2441) up to 3/4"
- ✔ For use in a vice or installation on the workbench
- ✔ Set up for connecting to a length and angle stop as well as bending lever extension possible (not included)
- ✔ Enamelled blue

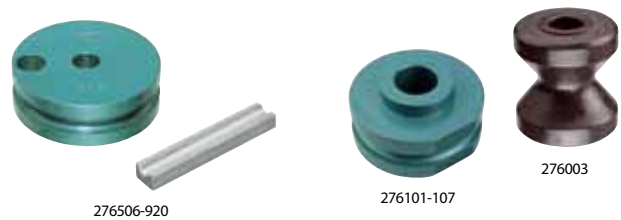


Code	No.		
4600010	<b>276000</b>	Basic equipment with bending lever extension no. 268230, without bending tools	16.7
4600280	<b>276001</b>	Angled stop	1.8
4606210	<b>280130</b>	Length stop	0.7
			<b>51.48</b>

**E 276**

**BENDING TOOLS**

- ✔ No. 276506-276920: Bending former with aluminium slide rail for metric pipes
- ✔ No. 276101-276107: Bending former for gas and water pipes EN 10255 (DIN 2440/2441), use with pressure roller no. 276003 (1/8-3/4")



Code	No.	Size	Ø mm	r = mm	Electrical installation ducts EN 60423		
4600950	<b>276506</b>		6,0	40		1.5	1
4601090	<b>276508</b>		8,0	40		1.4	1
4601170	<b>276510</b>		10,0	40		1.4	1
4601250	<b>276512</b>		12,0	40		1.4	1
1553682	<b>276912</b>		12,0	81	M12	6.5	1
4601330	<b>276514</b>		14,0	50		1.9	1
4601410	<b>276515</b>		15,0	50		1.8	1
4601680	<b>276516</b>		16,0	68		4.7	1
1553690	<b>276916</b>		16,0	81	M16	6.5	1
4601760	<b>276518</b>		18,0	68		4.7	1
4601840	<b>276519</b>		19,0	68		4.6	1
4601920	<b>276520</b>		20,0	68		4.6	1
1553704	<b>276920</b>		20,0	105	M20	4.8	1
4602060	<b>276522</b>		22,0	81		6.5	1
4602140	<b>276525</b>		25,0	105	M25	4.7	1
4602300	<b>276528</b>		28,0	126		5.4	1
4602490	<b>276530</b>		30,0	153		7.0	1
4602570	<b>276532</b>		32,0	153	M32	7.0	1
4600440	<b>276101</b>	1/8	10,2	40		1.2	1
4600520	<b>276102</b>	1/4	13,5	40		1.2	1
4600600	<b>276103</b>	3/8	17,2	50		1.6	1
4600790	<b>276105</b>	1/2	21,3	68		2.4	1
4600870	<b>276107</b>	3/4	26,9	80		5.8	1
4600360	<b>276003</b>	1/8-3/4				0.5	1




## MANUAL PIPE BENDER – PUSHING BENDING OPERATION

### 2455

#### PIPE BENDER SET MANUAL

- ✔ Sizes from 10 to 22 mm Ø up to 90°
- ✔ For soft copper pipes EN 1057 (also heat-insulated)
- ✔ Mechanical ratchet feed
- ✔ Deliver in plastic case no. 245590




Code	No.	
4634850	<b>245510</b> 1 basic unit, mechanical no. 245570 7 bending tools for pipes with Ø 10, 12, 14, 15, 18, 20, 22 mm 1 plastic case no. 245590	5.0

### 2454

#### PIPE BENDER SET FOR COMPOSITE PIPES hydraulic

- ✔ Sizes from 16 to 32 mm Ø up to 90°
- ✔ For multi-layer composite pipes
- ✔ Hydraulic drive without great effort
- ✔ Delivery in plastic case no. 245490




Code	No.	
1443550	<b>245410</b> 1 basic unit, hydraulic no. 245670 4 bending tools for pipes with Ø 16, 20, 26, 32 mm 1 plastic case no. 245490	7.3

### 2456

#### PIPE BENDER SET hydraulic

- ✔ Sizes from 10 to 22 mm Ø up to 90°
- ✔ For soft copper pipes EN 1057 up to 22 mm (also heat-insulated) as well as precision steel pipes EN 10305-3 (DIN 2394) up to 18 x 1.5 mm
- ✔ Hydraulic drive without great effort
- ✔ Delivery in plastic case no. 245590




Code	No.	
4635230	<b>245610</b> 1 basic unit, hydraulic no. 245670 7 bending tools for pipes with Ø 10, 12, 14, 15, 18, 20, 22 mm 1 plastic case no. 245590	6.2

### 2456

#### PIPE BENDER SET hydraulic, heavy-duty

- ✔ From 6 to 22 mm Ø, bends up to 90°
- ✔ For soft copper pipes EN 1057 up to 22 mm (also heat-insulated), precision steel pipes EN 10305-3 (DIN 2394) up to 18 x 2 mm, as well as annealed stainless steel pipes up to 18 x 1.2 mm
- ✔ Hydraulic drive without great effort
- ✔ In plastic case no. 245690



Code	No.	
1585495	<b>245611</b> 1 basic unit, hydraulic no. 245670 10 bending tools for pipes with Ø 6, 8, 10, 12, 14, 15, 16, 18, 20, 22 mm 1 plastic case no. 245690	7.5

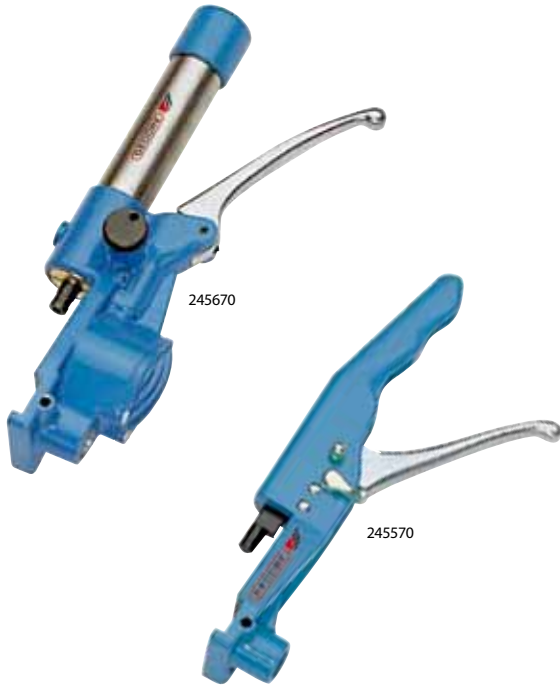






### E 2454 - E 2456

#### PARTS



Code	No.	⌀ mm	⊠
4634930	<b>245570</b> Basic unit, mechanical	1150	1
4635310	<b>245670</b> Basic unit, hydraulic	2350	1
1443437	<b>245490</b> Plastic case empty for no. 245410	1700	1
4635070	<b>245590</b> Plastic case empty for no. 245510 + 245610	1700	1
1585568	<b>245690</b> Plastic case empty for no. 245611	1700	1



### E 2454 - E 2456

#### BENDING TOOLS

- ▣ The bending former and counter-support are needed in each instance
- ▣ Bending former no. 245805-245824 and counter-support no. 245710-245731 for metric pipes
- ▣ Bending former no. 245916-245932 and counter-support no. 245740-245770 for composite pipes



Code	No.	⌀ mm	r = mm	⊠	⊠
4635820	<b>245805</b>	5	31	100	1
4635900	<b>245806</b>	6	31	100	1
4636040	<b>245808</b>	8	31	100	1
4636120	<b>245810</b>	10	31	100	1
4636200	<b>245812</b>	12	34	110	1
4636390	<b>245814</b>	14	41	120	1
4636470	<b>245815</b>	15	48	140	1
4636550	<b>245816</b>	16	49	150	1
4636630	<b>245817</b>	17	51	140	1
4636710	<b>245818</b>	18	72	190	1
4636980	<b>245820</b>	20	80	200	1
4637010	<b>245822</b>	22	88	200	1
4637280	<b>245824</b>	24	90	200	1
1443399	<b>245916</b>	16	49	140	1
1443402	<b>245920</b>	20	80	180	1
1443410	<b>245926</b>	26	93	240	1
1443429	<b>245932</b>	32	119	480	1
4635580	<b>245710</b> Counter-support	5-12		380	1
4635660	<b>245720</b> Counter-support	14-17		460	1
1585509	<b>245721</b> Counter-support reinforced	14-17		380	1
4635740	<b>245730</b> Counter-support	18-24		460	1
1585517	<b>245731</b> Counter-support reinforced	18-24		480	1
1443356	<b>245740</b> Counter-support composite pipes	16		340	1
1443364	<b>245750</b> Counter-support composite pipes	20		440	1
1443372	<b>245760</b> Counter-support composite pipes	26		480	1
1443380	<b>245770</b> Counter-support composite pipes	32		840	1



923



487



921



487


**PIPE BENDING MACHINES – DRAW BENDING OPERATION**


246

**PIPE BENDING MACHINE manual-hydraulic**

- ▀ Sizes from 12 to 28 mm Ø up to 180°
- ▀ For semi-hard and soft copper pipes EN 1057 up to 28 mm Ø, stainless steel pipes EN 10088-3 (DIN 17 440) up to 22 x 1.5 mm, hydraulic pipes EN 10305-1 (DIN 2391) and precision steel pipes EN 10305-3 (DIN 2394) up to 22 x 2 mm, composite pipes up to 20 mm as well as gas and water pipes EN 10255-M (DIN 2440) up to 3/4"
- ▀ Pressure 60 kN
- ▀ On pivotable tripod
- ▀ Delivery in wooden assembly case





Code	No.	
4538890	<b>246100</b> 1 basic tool No. 246070 1 pump, manual-hydraulic, No. 246080 1 pivotable tripod No. 268000 5 bending tools for pipes with Ø 12, 15, 18, 22, 28 mm	57.0

Code	No.	
4574260	<b>246010</b> 1 basic tool No. 246070 1 pump, manual-hydraulic, No. 246080 1 pivotable tripod No. 268000 without bending tools	49.0

**E 246**

**PARTS**

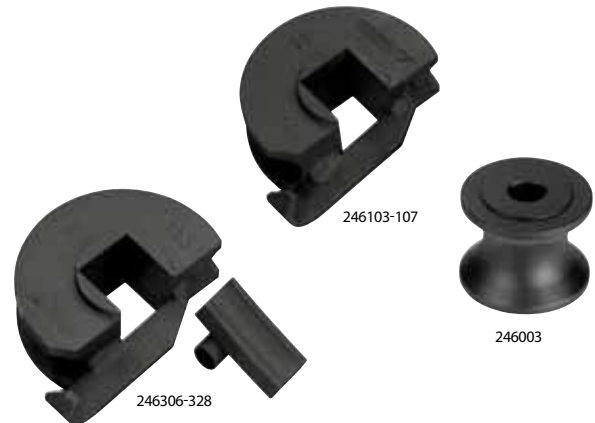
Code	No.		
4574340	<b>246070</b> Basic tool without hydraulic pump	15.5	1
4574420	<b>246080</b> Pump, manual-hydraulic	16.2	1
4599760	<b>268000</b> Pivotable tripod	6.2	1





**E 246**

**BENDING TOOLS**

- ▀ No. 246306-246328: Bending form with slide rail for metric pipes
- ▀ No. 246103-246107: Bending form for gas and water pipes EN 10255-M (DIN 2440), use with pressure roller no. 246003 (3/8"-3/4")



Code	No.	Size	Ø mm	r = mm		
4637870	<b>246306</b>		6,0	35	0.6	1
4637950	<b>246308</b>		8,0	35	0.5	1
4638090	<b>246310</b>		10,0	45	0.5	1
4575070	<b>246312</b>		12,0	45	0.5	1
4575150	<b>246314</b>		14,0	55	0.9	1
4575230	<b>246315</b>		15,0	55	0.9	1
4575310	<b>246316</b>		16,0	75	1.1	1
4575660	<b>246318</b>		18,0	75	1.4	1
4575740	<b>246320</b>		20,0	75	1.8	1
4575820	<b>246322</b>		22,0	85	2.0	1
4575900	<b>246325</b>		25,0	85	3.1	1
4576040	<b>246328</b>		28,0	112	4.0	1
4637440	<b>246103</b>	3/8	17,2	55	1.2	1
4637520	<b>246105</b>	1/2	21,3	65	1.7	1
4637600	<b>246107</b>	3/4	26,9	85	3.6	1
4637360	<b>246003</b>	3/8-3/4			0.3	1

 **250**



GEDORE also manufactures pipe benders for thin-walled pipes up to 2" - please enquire!



249

**PIPE BENDING MACHINE manual-hydraulic**

- ✔ Sizes from 12 to 54 mm Ø up to 90°
- ✔ For copper pipes EN 1057, precision steel pipes EN 10305-3 (DIN 2394) and hydraulic pipes EN 10305-1 (DIN 2391), stainless steel pipes EN 10088-3 (DIN 17 440) up to 42 mm, uncoated pipes and pipes with fixed coating, composite pipes as well as electrical installation pipes EN 60423
- ✔ Pressure 100 kN
- ✔ On pivotable tripod
- ✔ Delivery in wooden assembly case

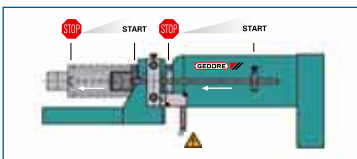


Code	No.	
4580150	<b>249000</b>	76.0
1 pump manual-hydraulic No. 254200 1 base unit with pivotable tripod No. 249310 without bending tools		

249

**PIPE BENDING MACHINE electro-hydraulic**

- ✔ Sizes from 12 to 54 mm Ø up to 90°
- ✔ For copper pipes EN 1057, precision steel pipes EN 10305-3 (DIN 2394) and hydraulic pipes EN 10305-1 (DIN 2391), stainless steel pipes EN 10088-3 (DIN 17 440) up to 42 mm, uncoated pipes and pipes with fixed coating, composite pipes as well as electrical installation pipes EN 60423
- ✔ Electrical limiter for continuous pre-setting and repetition in the production of pipe bends
- ✔ Pressure 100 kN
- ✔ On pivotable tripod
- ✔ Delivery in wooden assembly case



Code	No.	
4580230	<b>249001</b>	111.0
1 pump electro-hydraulic 380-415 V No. 254601 1 base unit with pivotable tripod No. 249311 without bending tools		
1547593	<b>249002</b>	111.0
1 pump electro-hydraulic 230 V No. 254651 1 base unit with pivotable tripod No. 249311 without bending tools		

E 249

**PARTS**

- ✔ Pumps exchangeable for benders no. 257, 258 and 280

Code	No.		
4582280	<b>249310</b>	42.5	1
Base unit with tripod for manual-hydraulic bending tool			
4640310	<b>249311</b>	53.7	1
Base unit with tripod for electro-hydraulic bending tool			
4584810	<b>254200</b>	21.5	1
Pump 2" manual-hydraulic			
1599984	<b>254601</b>	41.0	1
Pump 2" 380-415 V with electrical limiter			
1599992	<b>254651</b>	40.8	1
Pump 2" 230 V with electrical limiter			

E 249

**BENDING TOOLS**

- ✔ Consisting of bending former, pipe holder and aluminium slide rail
- ✔ For shaping stainless steel pipes, bending formers, pipe holders and steel bending rails - chemically nickel-plated - are available on request
- ✔ Special sizes available on request



Code	No.	Size	Ø mm	Electrical installation ducts EN 60423	Precision steel pipes EN 10305-3	Cu pipes EN 1057	r = mm		
1527339	<b>249812</b>	12,0		M 12	12	12	85	2.9	1
4640660	<b>249815</b>	15,0			15	15	85	2.9	1
4654290	<b>249816</b>	16,0		M16	16	16	85	2.9	1
4654370	<b>249818</b>	18,0			18	18	85	2.9	1
4654530	<b>249820</b>	20,0			20	20	85	2.9	1
1546090	<b>249020</b>	20,0		M20			100	3.9	1
4654610	<b>249822</b>	22,0			22	22	85	2.9	1
4582520	<b>249825</b>	25,0			25		85	3.5	1
1546120	<b>249025</b>	25,0		M25			100	3.9	1
4582600	<b>249828</b>	28,0			28		85	3.5	1
4580310	<b>249028</b>	28,0				28	100	3.5	1
4582790	<b>249830</b>	30,0			30		85	3.4	1
4580580	<b>249030</b>	30,0					100	3.7	1
4580660	<b>249032</b>	32,0			32		100	6.5	1
1546147	<b>249132</b>	32,0		M32			150	7.5	1
4580820	<b>249035</b>	35,0			35		100	6.0	1
4580900	<b>249135</b>	35,0				35	150	7.3	1
4581120	<b>249138</b>	38,0			38		150	7.1	1
4581200	<b>249140</b>	40,0			40		150	7.7	1
1546163	<b>249240</b>	40,0		M40			200	12.9	1
4581470	<b>249142</b>	42,0			42		150	7.7	1
1561944	<b>249242</b>	42,0					200	13.4	1
4581550	<b>249145</b>	45,0			45		150	7.5	1
4581710	<b>249250</b>	50,0		M50	50		200	13.1	1
4582010	<b>249254</b>	54,0					200	12.4	1
1742655	<b>249503</b>	3/8	17,2				85	4.0	1
1639935	<b>249505</b>	1/2	21,3				100	4.0	1
1422820	<b>249507</b>	3/4	26,9				100	6.5	1
1276190	<b>249510</b>	1	33,7				150	7.5	1
1549561	<b>249512</b>	1.1/4	42,4				150	7.5	1
1232401	<b>249515</b>	1.1/2	48,3				200	14.5	1
2125242	<b>249605</b>	12,7					100	3.9	1
2125250	<b>249606</b>	15,88					100	3.9	1
2125269	<b>249607</b>	19,05					100	3.9	1
2125277	<b>249608</b>	22,22					150	7.5	1
2125293	<b>249610</b>	25,4					200	12.9	1
2125315	<b>249612</b>	31,75					200	12.9	1







**PIPE BENDING MACHINES – PUSHING BENDING OPERATION**

**max. bending capacities Pipe bending machines 255-260**

Bender no.	Gas and water pipes EN 10205 (DIN 2440/2441)		Distilling pipes EN 10220 (DIN 2448)		Electrical installation pipes EN 60423	Railing tubes *)	Metric tubes *)		Multi-layer composite pipes
	up to 90°	up to 180°	up to 90°		up to 90°	up to 90°	up to 90°	up to 180°	up to 90°
	Size	Size	Size	Ø mm	Nominal size	Size	Ø mm	Ø mm	Ø mm
255 - 256	3/8 - 1.1/4"	-	3/8 - 1"	25 - 32	M12 - M20	3/8 - 3/4"	14 - 35	-	-
257 - 258	3/8 - 2"	3/4 - 1.1/2"	3/8 - 1.1/2"	25 - 51	M12 - M40	3/8 - 1.1/4"	14 - 51	25 - 50	40 - 63 (No. 258)
259 - 260	3/8 - 3"	-	3/8 - 2.1/2"	25 - 70	M12 - M50	3/8 - 2"	14 - 70	-	-

\*) Specifications under reserve - as these are dependent on the respective wall thickness

**255 - 256**

**PIPE BENDING MACHINE 3/8" - 1.1/4"**

- ✔ For gas and water pipes EN 10205 (DIN 2440/2441) up to max. 90°
- Available in various designs:**
  - ✔ - manually or electro-hydraulically operated
  - ✔ - with open or fold-open bending frame
  - ✔ - as the basic tool without bending former or as a set with bending former no. 263103-112
- ✔ Pressure 60 kN
- ✔ Delivery in assembly case

**Optional bending tools under no. 263 - 265 available for:**

- ✔ - Distilling pipes EN 10220 (DIN 2448) from 3/8 to 1" or 25 to 32 mm
- ✔ - Railing tubes from 3/8 to 3/4"
- ✔ - Electrical installation pipes EN 60423 from M12 to M20
- ✔ - Metric pipes from 14 to 35 mm
- ✔ Bending tools for stainless steel pipes on request



**257 - 258**

**PIPE BENDING MACHINE 3/8" - 2"**

- ✔ For gas and water pipes EN 10205 (DIN 2440/2441) up to max. 90°
- ✔ With bending tools as an option which can be used up to a max. 180°
- Available in various designs:**
  - ✔ - manually or electro-hydraulically operated
  - ✔ - with open or fold-open bending frame
  - ✔ - as the basic tool without bending former or as a set with bending former no. 263103-120
- ✔ Pressure 100 kN
- ✔ Delivery in assembly case

**Optional bending tools under no. 263 - 267 available for:**

- ✔ - Distilling pipes EN 10220 (DIN 2448) from 3/8 to 1.1/2" or 25 to 51 mm
- ✔ - Railing tubes from 3/8 to 1.1/4"
- ✔ - Electrical installation pipes EN 60423 from M12 to M40
- ✔ - Metric pipes from 14 to 51 mm
- ✔ - Multi-layer composite pipes from 40 to 63 mm (no. 258)
- ✔ - Gas and water pipes EN 10205 (DIN 2440/2441) from 3/4 to 1.1/2" up to 180°
- ✔ - Metric pipes from 25 to 50 mm up to 180°
- ✔ - straightening steel pipes and scaffold tubes 1.1/2"
- ✔ Bending tools for stainless steel pipes on request



Code	No.	included in delivery	Ill.	W
4586190	<b>255000</b>	manual-hydraulic, fold-open bending frame, without bending formers	A	39.0
4586270	<b>255100</b>	manual-hydraulic, fold-open bending frame, with 5 bending formers no. 263103-112	A	48.0
4586350	<b>255500</b>	electro-hydraulic 380-415 V, fold-open bending frame, without bending formers	B	65.0
4586430	<b>255510</b>	electro-hydraulic 380-415 V, fold-open bending frame, with 5 bending formers no. 263103-112	B	74.0
4586510	<b>255600</b>	electro-hydraulic 230 V, fold-open bending frame, without bending formers	B	65.0
4586780	<b>255610</b>	electro-hydraulic 230 V, fold-open bending frame, with 5 bending formers no. 263103-112	B	74.0
4586860	<b>256000</b>	manual-hydraulic, open bending frame, without bending formers	C	47.0
4586940	<b>256100</b>	manual-hydraulic, open bending frame, with 5 bending formers no. 263103-112	C	56.0
4587080	<b>256500</b>	electro-hydraulic 380-415 V, open bending frame, without bending formers	D	73.0
4587160	<b>256510</b>	electro-hydraulic 380-415 V, open bending frame, with 5 bending formers no. 263103-112	D	82.0
4587240	<b>256600</b>	electro-hydraulic 230 V, open bending frame, without bending formers	D	73.0
4587320	<b>256610</b>	electro-hydraulic 230 V, open bending frame, with 5 bending formers no. 263103-112	D	82.0

Code	No.	included in delivery	Ill.	W
4587400	<b>257000</b>	manual-hydraulic, fold-open bending frame, without bending formers	A	54.0
4587590	<b>257100</b>	manual-hydraulic, fold-open bending frame, with 7 bending formers no. 263103-120	A	75.0
4587670	<b>257500</b>	electro-hydraulic 380-415 V, fold-open bending frame, without bending formers	B	78.0
4587750	<b>257510</b>	electro-hydraulic 380-415 V, fold-open bending frame, with 7 bending formers no. 263103-120	B	99.0
4587830	<b>257600</b>	electro-hydraulic 230 V, fold-open bending frame, without bending formers	B	78.0
4587910	<b>257610</b>	electro-hydraulic 230 V, fold-open bending frame, with 7 bending formers no. 263103-120	B	99.0
4588050	<b>258000</b>	manual-hydraulic, open bending frame, without bending formers	C	73.0
4588130	<b>258100</b>	manual-hydraulic, open bending frame, with 7 bending formers no. 263103-120	C	95.0
4588210	<b>258500</b>	electro-hydraulic 380-415 V, open bending frame, without bending formers	D	98.0
4588480	<b>258510</b>	electro-hydraulic 380-415 V, open bending frame, with 7 bending formers no. 263103-120	D	119.0
4588560	<b>258600</b>	electro-hydraulic 230 V, open bending frame, without bending formers	D	98.0
4588640	<b>258610</b>	electro-hydraulic 230 V, open bending frame, with 7 bending formers no. 263103-120	D	119.0



**259 - 260****PIPE BENDING MACHINE 3/8" - 3"**

- For gas and water pipes EN 10205 (DIN 2440/2441) up to max. 90°

**Available in various designs:**

- manually or electro-hydraulically operated
- with open or fold-open bending frame
- as the basic tool without bending former or as a set with bending former no. 263103-130
- Pressure 160 kN
- Delivery in assembly case

**Optional bending tools under no. 263 - 265 available for:**

- Distilling pipes EN 10220 (DIN 2448) from 3/8 to 2.1/2" or 25 to 70 mm
- Railing tubes from 3/8 to 2"
- Electrical installation pipes EN 60423 from M12 to M50
- Metric pipes from 14 to 70 mm

Bending tools for stainless steel pipes on request



Code	No.	included in delivery	Ill.	Price
4588720	<b>259000</b>	manual-hydraulic, fold-open bending frame, without bending formers	A	98.0
4588800	<b>259100</b>	manual-hydraulic, fold-open bending frame, with 9 bending formers no. 263103-130	A	173.0
4588990	<b>259500</b>	electro-hydraulic 380-415 V, fold-open bending frame, without bending formers	B	123.0
4589020	<b>259510</b>	electro-hydraulic 380-415 V, fold-open bending frame, with 9 bending formers no. 263103-130	B	198.0
4589100	<b>259600</b>	electro-hydraulic 230 V, fold-open bending frame, without bending formers	B	123.0
4589290	<b>259610</b>	electro-hydraulic 230 V, fold-open bending frame, with 9 bending formers no. 263103-130	B	198.0
4589370	<b>260000</b>	manual-hydraulic, open bending frame, without bending formers	E	120.0
4589450	<b>260100</b>	manual-hydraulic, open bending frame, with 9 bending formers no. 263103-130	E	207.0
4589530	<b>260500</b>	electro-hydraulic 380-415 V, open bending frame, without bending formers	F	155.0
4589610	<b>260510</b>	electro-hydraulic 380-415 V, open bending frame, with 9 bending formers no. 263103-130	F	242.0
4589880	<b>260600</b>	electro-hydraulic 230 V, open bending frame, without bending formers	F	155.0
4589960	<b>260610</b>	electro-hydraulic 230 V, open bending frame, with 9 bending formers no. 263103-130	F	242.0

**258****PIPE BENDING MACHINE MSR 40 - 63 MM**

- For multi-layer composite pipes up to a max. 90°

**Available in various designs:**

- manually or electro-hydraulically operated
- as basic tool without bending former or as a set with bending former no. 263940-963 and no. 258940-963
- Pressure 100 kN
- Delivery in assembly case

**Optional bending tools under no. 263 - 267 available for:**

- Gas and water pipes EN 10205 (DIN 2440/2441) from 3/8 to 2"
- Distilling pipes EN 10220 (DIN 2448) from 3/8 to 1.1/2" or 25 to 51 mm
- Railing tubes from 3/8 to 1.1/4"
- Electrical installation pipes EN 60423 from M12 to M40
- Metric pipes from 14 to 51 mm
- Gas and water pipes EN 10205 (DIN 2440/2441) from 3/4 to 1.1/2" up to 180°
- Metric pipes from 25 to 50 mm up to 180°
- straightening steel pipes and scaffold tubes 1.1/2"

Bending tools for stainless steel pipes on request



Code	No.	included in delivery	Price
4588050	<b>258000</b>	manual-hydraulic, open bending frame, without bending formers	73.0
2302829	<b>258102</b>	manual-hydraulic, open bending frame, with bending formers no. 263940-963 and counter-supports no. 258940-963	79.0
4588210	<b>258500</b>	electro-hydraulic 380-415 V, open bending frame, without bending formers	98.0
2302837	<b>258512</b>	electro-hydraulic 380-415 V, open bending frame, with bending formers no. 263940-963 and counter-supports no. 258940-963	104.0
4588560	<b>258600</b>	electro-hydraulic 230 V, open bending frame, without bending formers	98.0
2302845	<b>258612</b>	electro-hydraulic 230 V, open bending frame, with bending formers no. 263940-963 and counter-supports no. 258940-963	104.0

**i 261**

GEDORE also manufactures pipe benders for pipes up to 4" - please enquire!

**➔ 268****559****➔ 254****559****➔ 2631-2671****560 - 561**



**254**

**PUMP manual-hydraulic**

- Available in various power stages
- For bending without great effort
- Option to re-fit with electrical drive no. 254950 (380-415 V) or no. 254955 (230 V)



Code	No.	Size	Use in machine No.	Weight
4584730	<b>254100</b>	1.1/4	255-256	16.2
4584810	<b>254200</b>	2	249, 257-258, 2804	21.5
4585030	<b>254300</b>	3	259-260	29.3

**254**

**PUMP electro-hydraulic**

- Available in various power stages
- No. 254601 and no. 254651 with electrical limiter for continuous pre-setting and repetition in the production of pipe bends



without electrical limiter

with electrical limiter

Code	No.	Size	Use in machine No.	Connection voltage Volt	Weight
4585380	<b>254500</b>	1.1/4	255-256	380-415	35.0
4585460	<b>254550</b>	1.1/4	255-256	230	35.0
4585540	<b>254600</b>	2	257-258	380-415	40.0
1599984	<b>254601</b>	2	249, 2804	380-415	41.0
4585620	<b>254650</b>	2	257-258	230	40.0
1599992	<b>254651</b>	2	249, 2804	230	40.8
4585700	<b>254700</b>	3	259-260	380-415	48.0
4585890	<b>254750</b>	3	259-260	230	48.0

**269**

**HYDRAULIC OIL 1 litre**

- For use with all GEDORE hydraulic pumps
- The volume stated is required each time



Code	No.	for pumps	required volume litre	Weight
4599920	<b>269000</b>	1.1/4"	0,90	880 1
		2"	1,25	
		3"	1,90	

**E 254**

**GASKET SET**

- For all GEDORE hydraulic pumps with machine number 254....
- For equipment with other than the stated machine no. available on request
- Contains the most-frequently required wear parts
- We also recommend that the hydraulic oil is changed each time, see no. 269



Code	No.	for	Weight	Quantity
4687890	<b>254160</b>	Machine no. 2541...	70	1
4689080	<b>254260</b>	Machine no. 2542...	75	1
4690170	<b>254360</b>	Machine no. 2543...	80	1
4690840	<b>254560</b>	Machine no. 2545...	70	1
4624620	<b>254660</b>	Machine no. 2546...	75	1
4691140	<b>254760</b>	Machine no. 2547...	80	1



When ordering spares, do indicate the pump number affixed at the pump housing

**E 255 - E 260**

**BENDING FRAME**

- Available in the open or fold-open design
- Without add-on components



fold-open

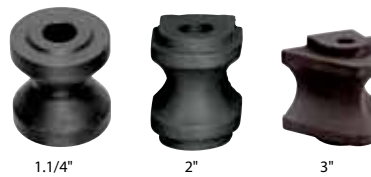
open

Code	No.	Size	Use in machine No.	Execution	Weight
4641200	<b>255010</b>	1.1/4	255	fold-open	7.7
4641550	<b>256010</b>	1.1/4	256	open	15.4
4642010	<b>257010</b>	2	257	fold-open	12.4
4642440	<b>258010</b>	2	258	open	31.2
4642870	<b>259010</b>	3	259	fold-open	37.2
4643170	<b>260010</b>	3	260	open	95.0

**E 255 - E 260**

**COUNTER-SUPPORT (PIECE)**

- Please note: 2 pieces of them are needed



1.1/4"

2"

3"

Code	No.	Size	Use in machine No.	Weight	Quantity
4641390	<b>255015</b>	1.1/4	255	1.6	1
4641630	<b>256015</b>	1.1/4	256	1.4	1
4642280	<b>257015</b>	2	257	3.2	1
4642520	<b>258015</b>	2	258	2.9	1
4642950	<b>259015</b>	3	259	5.3	1
4643250	<b>260015</b>	3	260	4.3	1





### E 255 - E 260

#### COUNTER-SUPPORT FIXING PIN (PIECE)

► Please note: 2 pieces of them are needed



Code	No.	Size	Use in machine No.	⚡	📦
4641470	<b>255020</b>	1.1/4	255	300	1
4641710	<b>256020</b>	1.1/4	256	850	1
4642360	<b>257020</b>	2	257	440	1
4642600	<b>258020</b>	2	258	960	1
4643090	<b>259020</b>	3	259	480	1
4643330	<b>260020</b>	3	260	2020	1

### E 255 - E 260

#### U-YOKE



Code	No.	Size	Use in machine No.	⚡	📦
4721660	<b>256030</b>	1.1/4	255-256	180	1
4641980	<b>258030</b>	2	249, 257-258, 2804	400	1
4643410	<b>260030</b>	3	259-260	480	1

### 254

#### ELECTRICAL CONVERSION KIT

- Complete retrofitting set for hand hydraulic pumps consisting of electric motor (380-415 V or 230 V), cam drive, conveying unit, carrying handle and all incidental parts needed
- For all hand-operated GEDORE hydraulic pumps 1.1/4", 2" and 3" from 2001, for older pumps on request



► \* Can only be used in connection with electrical limiter no. 254680

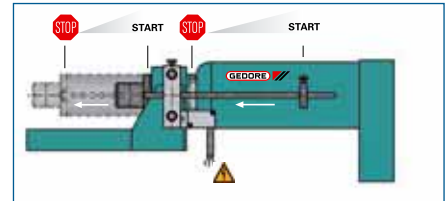
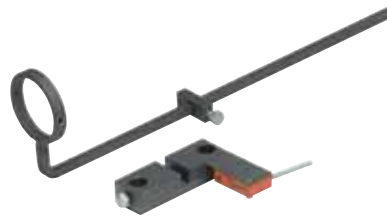


Code	No.	Use in machine No.	Connection voltage Volt	⚡
4718870	<b>254950</b>	249*, 255-260, 2804*	380-415	19.0
4718950	<b>254955</b>	249*, 255-260, 2804*	230	19.0

### 254

#### ELECTRICAL LIMITER

- For continuous pre-setting and repetition in the production of pipe bends
- Electrically-powered pipe and angle bending tools no. 249 and 2804 can be upgraded
- Enamelled black



Code	No.	Use in machine No.	⚡
1441345	<b>254680</b>	249, 2804	750

### 254

#### EXTENSION CABLE

- For electro-hydraulic pumps 1.1/4", 2" and 3"



380-415 V



230 V

Code	No.	Description	Connection voltage Volt	⚡	📦
4694080	<b>254982</b>	CEE extension cable 5 m	380-415	1.7	1
4694160	<b>254983</b>	CEE extension cable 10 m	380-415	3.1	1
4694240	<b>254984</b>	Safety extension cable 5 m	230	0.9	1
4694320	<b>254985</b>	Safety extension cable 10 m	230	1.6	1

### 268

#### INSTALLATION TRIPOD, PIVOTABLE

- Available in 2 sizes
- For GEDORE pipe bender no. 255-260 (standard equipment for benders no. 246, 249 and 2804)
- Enamelled blue



Code	No.	Height	Use	⚡
4599760	<b>268000</b>	480	for manual-hydraulic benders 1.1/4" and 2"	6.2
4599840	<b>268001</b>	680	for manual-hydraulic benders 3" and electric-hydraulic benders 1.1/4" to 3"	17.4




**2631**

**GREY CAST IRON BENDING FORMER UP TO 90°**

- For gas and water pipes EN 10255 (DIN 2440/2441)
- Enamelled black




Code	No.	Use in machine No.	Size	Ø mm	r = mm	
4539000	<b>263103</b>	255-260	3/8	17,2	45	0.9
4539190	<b>263105</b>	255-260	1/2	21,3	50	1.3
4539270	<b>263107</b>	255-260	3/4	26,9	75	2.2
4590460	<b>263110</b>	255-260	1	33,7	100	2.3
4590540	<b>263112</b>	255-260	1.1/4	42,4	115	2.4
4539350	<b>263115</b>	257-260	1.1/2	48,3	150	5.3
4539430	<b>263120</b>	257-260	2	60,3	200	6.7
4590620	<b>263125</b>	259-260	2.1/2	76,1	320	21.2
4590700	<b>263130</b>	259-260	3	88,9	380	30.4

**2630**

**STEEL BENDING FORMER UP TO 90°**

- For gas and water pipes EN 10255 (DIN 2440/2441)
- For surface-protective bending
- Phosphated

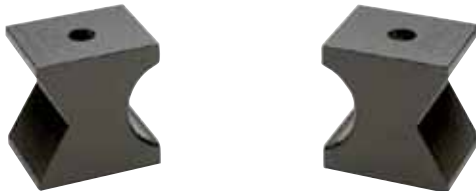



Code	No.	Use in machine No.	Size	Ø mm	r = mm	
4644220	<b>263003</b>	255-260	3/8	17,2	45	1.9
4655850	<b>263005</b>	255-260	1/2	21,3	50	1.3
4655930	<b>263007</b>	255-260	3/4	26,9	75	2.2
4656070	<b>263010</b>	255-260	1	33,7	100	2.3
4656150	<b>263012</b>	255-260	1.1/4	42,4	126	5.8
4656230	<b>263015</b>	257-260	1.1/2	48,3	145	5.3
4656310	<b>263020</b>	257-260	2	60,3	200	11.2
4656580	<b>263025</b>	259-260	2.1/2	76,1	320	21.2
4656660	<b>263030</b>	259-260	3	88,9	380	44.5

**2632**

**COUNTER-SUPPORT (PAIR) UP TO 90°**

- For surface-protective bending of uncoated steel pipes and the like
- Hardened, phosphated



Code	No.	Use in machine No.	
4591510	<b>263267</b>	257	9.1
4591780	<b>263268</b>	258	8.5
4591860	<b>263269</b>	259	15.6
4591940	<b>263270</b>	260	13.6



**922**



**487**




**2640**

**STEEL BENDING FORMER UP TO 90°**

- For standard-walled distilling pipes EN 10220 (DIN 2448) and metric pipes
- Phosphated




Code	No.	Use in machine No.	Size	Ø mm	r = mm	
4595260	<b>264003</b>	255-260	3/8	17,2	55	2.0
4595340	<b>264005</b>	255-260	1/2	21,3	75	2.5
4595420	<b>264007</b>	255-260	3/4	26,9	90	3.5
4595500	<b>264010</b>	255-260	1	33,7	130	5.4
4595690	<b>264012</b>	257-260	1.1/4	42,4	180	10.2
4596230	<b>264048</b>	257-260	1.1/2	48,3	220	11.8
4596660	<b>264060</b>	259-260	2	60,3	270	21.3
4596900	<b>264076</b>	259-260	2.1/2	76,1	420	49.3
4592750	<b>264014</b>	255-260		14,0	70	2.2
4592830	<b>264015</b>	255-260		15,0	70	2.3
4592910	<b>264016</b>	255-260		16,0	70	2.2
4593050	<b>264018</b>	255-260		18,0	90	3.4
4593130	<b>264020</b>	255-260		20,0	90	3.4
4593210	<b>264022</b>	255-260		22,0	90	3.2
4595770	<b>264025</b>	255-260		25,0	115	3.6
4595850	<b>264030</b>	255-260		30,0	140	6.7
4595930	<b>264032</b>	255-260		32,0	140	6.6
4596070	<b>264038</b>	257-260		38,0	170	8.2
4596150	<b>264044</b>	257-260		44,5	190	10.7
4596310	<b>264051</b>	257-260		51,0	220	15.4
4596580	<b>264057</b>	259-260		57,0	250	15.1
4596740	<b>264063</b>	259-260		63,5	270	22.1
4596820	<b>264070</b>	259-260		70,0	315	23.9

**2649**

**STEEL BENDING FORMER UP TO 90°**

- For electrical installation pipes EN 60423
- Phosphated




Code	No.	Use in machine No.	Ø mm	r = mm	
1549626	<b>264912</b>	255-260	M12	115	4.1
4597390	<b>264916</b>	255-260	M16	115	4.1
1549634	<b>264920</b>	255-260	M20	130	5.4
1549642	<b>264925</b>	257-260	M25	160	5.7
1549650	<b>264932</b>	257-260	M32	170	8.7
1549669	<b>264940</b>	257-260	M40	220	10.4
1549677	<b>264950</b>	259-260	M50	250	19.5

**2650**

**STEEL BENDING FORMER UP TO 90°**

- For railing pipes with wall thickness from 1.75 to 2.00 mm
- Phosphated



Code	No.	Use in machine No.	Size	Ø mm	r = mm	
4539510	<b>265003</b>	255-260	3/8	17,2	110	3.6
4598280	<b>265005</b>	255-260	1/2	21,3	110	3.6
4598010	<b>265007</b>	255-260	3/4	26,9	137	6.1
4598360	<b>265010</b>	257-260	1	33,7	190	9.4
4545830	<b>265012</b>	257-260	1.1/4	42,4	220	12.4
4644650	<b>265015</b>	259-260	1.1/2	48,3	250	13.7
4644730	<b>265020</b>	259-260	2	60,3	315	25.0



### 2633

#### STEEL BENDING FORMER UP TO 180°

- For gas and water pipes EN 10255 (DIN 2440/2441)
- For bends up to 180° piston extension no. 260819 and counter-support no. 263503 - 263504 are required
- Phosphated



Code	No.	Use in machine No.	Size	Ø mm	r = mm	↕
4592240	<b>263307</b>	257-258	3/4	26,9	110	4.7
4592320	<b>263310</b>	257-258	1	33,7	115	6.1
4592400	<b>263312</b>	257-258	1.1/4	42,4	115	6.4
4592590	<b>263315</b>	257-258	1.1/2	48,3	140	9.4

### 2634

#### STEEL BENDING FORMER UP TO 180°

- For metric pipes
- For bends up to 180° piston extension no. 260819 and counter-support no. 263503 - 263504 are required
- Phosphated



Code	No.	Use in machine No.	Ø mm	r = mm	↕
4593480	<b>263425</b>	257-258	25	110	3.5
4593560	<b>263428</b>	257-258	28	110	6.6
4593640	<b>263430</b>	257-258	30	110	6.4
4593720	<b>263432</b>	257-258	32	130	7.4
4593800	<b>263435</b>	257-258	35	130	7.1
4593990	<b>263438</b>	257-258	38	150	10.8
4594020	<b>263440</b>	257-258	40	150	10.3
4594100	<b>263442</b>	257-258	42	150	11.9
4594290	<b>263448</b>	257-258	48	150	11.3
4594370	<b>263450</b>	257-258	50	150	10.8

### 2608

#### WORKING PISTON EXTENSION

- For producing bends up to 180°
- For bending formers no. 2633 and 2634

Code	No.	↕ (mm)	↕
4696450	<b>260819</b>	160	2.4

### 2635

#### COUNTER-SUPPORT (PAIR) UP TO 180°

- For producing hairpin bends up to 180°
- For bending formers no. 2633 and 2634
- Enamelled blue



Code	No.	Use in machine No.	↕
4594610	<b>263503</b>	257	17.5
4594880	<b>263504</b>	258	16.8

### 2639

#### BENDING FORMER MSR UP TO 90°

- For multi-layer composite pipes
- A counter-support set no. 2589 is needed for each size
- For surface-protective bending
- Made of plastic



Code	No.	Use in machine No.	Ø mm	r = mm	↕
2302853	<b>263940</b>	258	40	160	1.7
2302861	<b>263950</b>	258	50	200	2.1
2302888	<b>263963</b>	258	63	220	2.4

### 2589

#### COUNTER-SUPPORT (PAIR) MSR UP TO 90°

- For surface-protective bending of multi-layer composite pipes
- Made of plastic



Code	No.	Use in machine No.	↕
2302918	<b>258940</b>	258	2.1
2302934	<b>258950</b>	258	2.0
2302942	<b>258963</b>	258	1.9

### 2670

#### STRAIGHTENING TOOL

- For steel pipes and scaffold tubes 1.1/2"
- We recommend its use together with the counter-supports no. 267101 - 267102
- Phosphated



Code	No.	Use in machine No.	Size	Ø mm	↕
4697690	<b>267015</b>	257-258	1.1/2	48,3	6.2

### 2671

#### STRAIGHTENING COUNTER-SUPPORT (PAIR)

- For steel pipes and scaffold tubes 1.1/2"
- The ideal supplement for straightening tool no. 267
- Phosphated



Code	No.	Use in machine No.	Size	Ø mm	↕
1548379	<b>267101</b>	257	1.1/2	48,3	8.3
1546961	<b>267102</b>	258	1.1/2	48,3	7.7





**ECCENTRIC ANGLE BENDERS**

**max. bending capacities Angle benders 280**

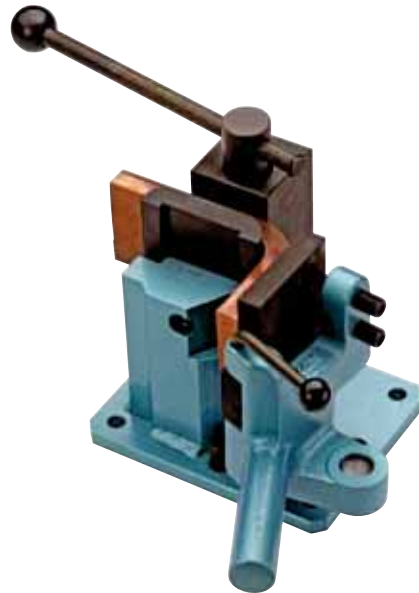
	70 mm working height		100 mm working height		120 mm working height	
	cold mm	hot mm	cold mm	hot mm	cold mm	hot mm
<b>Flat steel EN 10058 (DIN 1017)</b> (material strength 370 N/mm <sup>2</sup> )	70 x 6 (70 x 10)* (50 x 15)* (30 x 20)*	70 x 10 (70 x 20)* (50 x 25)*	100 x 10 80 x 12 50 x 15 30 x 20	100 x 20 80 x 25	120 x 8 100 x 10 80 x 12 50 x 15 30 x 20	120 x 20 80 x 25
<b>Square steel stock EN 10059 (DIN 1014)</b> (material strength 370 N/mm <sup>2</sup> )	6 (22)*	10 (30)*	22	30	22	30
<b>Round steel stock EN 10060 (DIN 1013)</b> (material strength 370 N/mm <sup>2</sup> )	6 (25)*	10 (30)*	25	30	25	30
<b>Angled steel stock EN 10056-1 (DIN 1028)</b> (material strength 370 N/mm <sup>2</sup> )	70 x 6	70 x 9	100 x 10	100 x 12	120 x 10	120 x 15
<b>CU-flat bars EN 13601</b> (material strength 250 N/mm <sup>2</sup> )	60 x 6 (60 x 30)*		100 x 30		120 x 10 100 x 30	
<b>AL-flat bars EN 754-5 (DIN 1769)</b> (material strength 160 N/mm <sup>2</sup> )	70 x 10 (70 x 30)*		100 x 30		120 x 15 100 x 30	


\* optional bending tool no. 280072 is necessary

**280**

**ECCENTRIC ANGLE BENDER 70 mm working height**



- ✔ For round, flat and angled stocks in steel, copper or aluminium up to 90°
- ✔ With bending tool sharp-edged / r = 4 mm no. 280071 for material thicknesses up to 6 mm
- ✔ Optionally available is the bending tool no. 280072 for greater material thicknesses - see E 280 bending tools
- ✔ With stepless adjustable angle stop no. 280125
- ✔ With length stop 400 mm no. 280130
- ✔ Manual base unit for mounting on a workbench (with optional available angle no. 280250 for vice fixture)



Code	No.	Included in delivery	
4539940	<b>280070</b>	Basic tool 70 mm working height, manual, with bending lever extension no. 268230	24.3

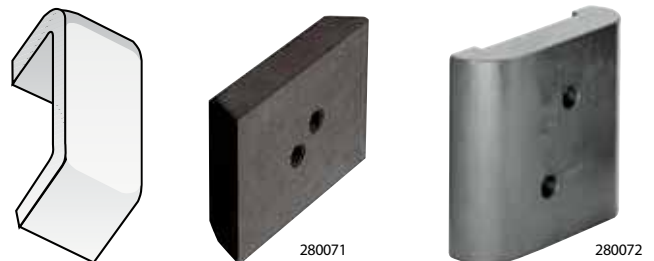
**E 280**



**ACCESSORIES**

Code	No.	Description		
2009544	<b>280250</b>	Angle for vice fixture	3.3	1
4644810	<b>280110</b>	Modification set for 100 mm working height	7.5	1
4645380	<b>280174</b>	Modification set for 120 mm working height	9.0	1

**E 280**

**BENDING TOOLS**



Code	No.	Description		
4605240	<b>280071</b>	Standard bending tool, sharp-edged / r = 4 mm for material thicknesses up to 6 mm	1.0	1
4605320	<b>280072</b>	Radiused bending tool r = 15 mm / r = 25 mm for material thicknesses up to 30 mm	1.1	1



 **923**

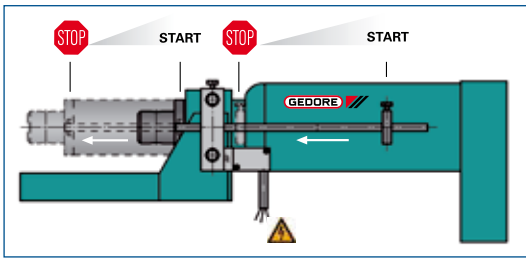
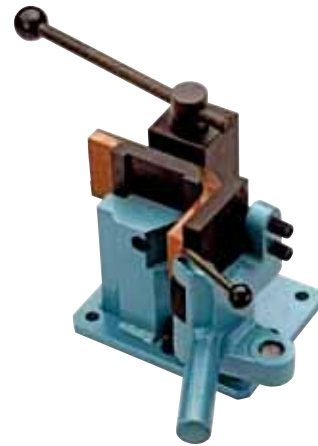


 **487**

**280****ECCENTRIC ANGLE BENDER 100 mm working height**

- For round, flat and angled stocks in steel, copper or aluminium up to 90°
- With bending tool sharp-edged /  $r = 4$  mm no. 280111 for material thicknesses up to 6 mm
- With bending tool  $r = 15$  mm /  $r = 25$  mm no. 280112 for material thicknesses up to 30 mm
- Optionally available are bending tools for a diversity of applications - see E 280 bending tools
- With stepless adjustable angle stop no. 280125, elektro-hydraulische Geräte mit stufenlos einstellbarer Endabschaltung
- With length stop 400 mm no. 280130
- Manual base unit for mounting on a workbench (with optional available angle no. 280250 for vice fixture)
- Hydraulic equipment mounted on pivotable tripod

CE



Code	No.	Included in delivery	Weight
4535010	<b>280100</b>	Basic tool 100 mm working height, manual, with bending lever extension no. 268230	26.5
4606640	<b>280400</b>	Basic tool 100 mm working height, on base plate with tripod No. 280210 and pump, manual-hydraulic no. 254200	102.4
4606720	<b>280401</b>	Basic tool 100 mm working height, on base plate with tripod No. 280210 and pump, electro-hydraulic, 380-415 V no. 254601	126.9
1547585	<b>280402</b>	Basic tool 100 mm working height, on base plate with tripod No. 280210 and pump, electro-hydraulic, 230 V no. 254651	126.9

E 280				
ACCESSORIES				
Pumps exchangeable for benders no. 249, 257 and 258				
Code	No.	Description	Weight	Qty
2009544	<b>280250</b>	Angle for vice fixture	3.3	1
4645380	<b>280174</b>	Modification set for 120 mm working height	9.0	1
4606560	<b>280210</b>	Base plate with tripod for use with hydraulic pump (in connection with no. 254200, no. 254601 or no. 254651)	33.2	1
4584810	<b>254200</b>	Pump 2", manual-hydraulic	21.5	1
1599984	<b>254601</b>	Pump 2" 380-415 V with electrical limiter	41.0	1
1599992	<b>254651</b>	Pump 2" 230 V with electrical limiter	40.8	1

**921**

**487**

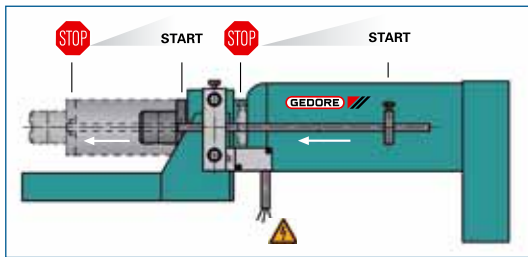
E 280				
BENDING TOOLS				
Code	No.	Description	Weight	Qty
4605400	<b>280111</b>	Standard bending tool, sharp-edged / $r = 4$ mm for material thicknesses up to 6 mm	1.5	1
4605590	<b>280112</b>	Radiused bending tool $r = 15$ mm / $r = 25$ mm for material thicknesses up to 30 mm	1.6	1
4605670	<b>280113</b>	Bending tool for producing saddles and rectangular bends, sharp-edged for material thicknesses up to 3 mm	0.9	1
4605750	<b>280114</b>	Bending tool for producing saddles and rectangular bends, $r = 4$ mm for material thicknesses up to 6 mm	0.9	1
4605830	<b>280115</b>	Bending tool for making diamond bends	0.7	1
4605910	<b>280116</b>	Bending tool for high saddles (use only in connection with no. 280113 + no. 280114)	1.2	1
4606050	<b>280117</b>	Offset block for narrow saddles	2.4	1




**280**

**ECCENTRIC ANGLE BENDER 120 mm working height**

- ✔ For round, flat and angled stocks in steel, copper or aluminium up to 90°
- ✔ With bending tool sharp-edged / r = 4 mm no. 280161 for material thicknesses up to 6 mm
- ✔ With bending tool r = 15 mm / r = 25 mm no. 280162 for material thicknesses up to 30 mm
- ✔ With stepless adjustable angle stop no. 280125, elektro-hydraulische Geräte mit stufenlos einstellbarer Endabschaltung
- ✔ With length stop 400 mm no. 280130
- ✔ Manual base unit for mounting on a workbench (with optional available angle no. 280250 for vice fixture)
- ✔ Hydraulic equipment mounted on pivotable tripod





Code	No.	Included in delivery	
4606130	<b>280120</b>	Basic tool 120 mm working height, manual, with bending lever extension no. 268230	27.9
4645620	<b>280420</b>	Basic tool 120 mm working height, on base plate with tripod No. 280210 and pump, manual-hydraulic no. 254200	103.8
4645700	<b>280421</b>	Basic tool 120 mm working height, on base plate with tripod No. 280210 and pump, electro-hydraulic, 380-415 V no. 254601	128.3
1544950	<b>280422</b>	Basic tool 120 mm working height, on base plate with tripod No. 280210 and pump, electro-hydraulic, 230 V no. 254651	128.3

**E 280**

**ACCESSORIES**



- ✔ Pumps exchangeable for benders no. 249, 257 and 258

Code	No.	Description		
2009544	<b>280250</b>	Angle for vice fixture	3.3	1
4606560	<b>280210</b>	Base plate with tripod for use with hydraulic pump (in connection with no. 254200, no. 254601 or no. 254651)	33.2	1
4584810	<b>254200</b>	Pump 2", manual-hydraulic	21.5	1
1599984	<b>254601</b>	Pump 2" 380-415 V with electrical limiter	41.0	1
1599992	<b>254651</b>	Pump 2" 230 V with electrical limiter	40.8	1

**E 280**

**BENDING TOOLS**



Code	No.	Description		
4645030	<b>280161</b>	Standard bending tool, sharp-edged / r = 4 mm for material thicknesses up to 6 mm	1.8	1
4645110	<b>280162</b>	Radiused bending tool r = 15 mm / r = 25 mm for material thicknesses up to 30 mm	2.0	1



## RING BENDING MACHINE

### Maximum bending capacities Ring bending machine no. 285

	mm
Flat bar EN 10058 (DIN 1017) (material strength 370 N/mm <sup>2</sup> )	50 x 6
Flat bar, vertical EN 10058 (DIN 1017) (material strength 370 N/mm <sup>2</sup> )	20 x 5 *
Square iron EN 10059 (DIN 1014) (material strength 370 N/mm <sup>2</sup> )	13 x 13
Round bar EN 10060 (DIN 1013) (material strength 370 N/mm <sup>2</sup> )	15 *
Angled sections EN 10056-1 (DIN 1028) (material strength 370 N/mm <sup>2</sup> )	20 x 20 x 3 *
T-iron EN 10055 (DIN 1024) (material strength 370 N/mm <sup>2</sup> )	20 x 20 x 3 *
Pipes	6 x 1.0 upto 18 x 1.5 *

\* Please note:  
Optional bending tools are required - see E 285

## 285

### RING BENDING MACHINE

- Manual 3-roller ring bending machine
- Vertical operation
- Standard roller set for flat and square stock included
- With two speeds
- Base unit for mounting on a workbench  
(with optional available angle no. 285250 for vice fixture)
- Enamelled blue



Code	No.		
4606800	<b>285000</b>	30.0	
Basic tool with standard roller set			

## E 285

### ACCESSORIES

Code	No.		
2009552	<b>285250</b>	3.3	1
Angle for vice fixture			

## 267

Straightening tools for scaffold tubes can be found under no. 267 on Pages



561

## E 285

### BENDING TOOLS



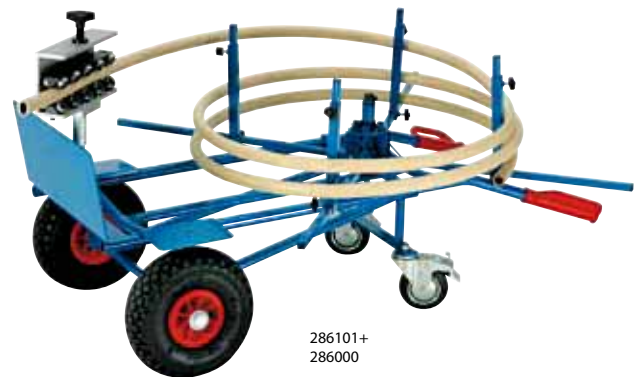
Code	No.		
4606990	<b>285001</b>	1.5	1
2-piece upper roller for shaping L and T sections, with leg inside			
4607020	<b>285002</b>	2.7	1
Set 2-piece lower rollers for shaping vertical flat stock, L and T sections, with leg outside			
4607100	<b>285006</b>	2.0	1
1 set rollers for shaping tubes 6x1 mm (1 upper drive roller, 2 lower rollers)			
4607290	<b>285008</b>	2.0	1
1 set rollers for shaping tubes 8x1 mm (1 upper drive roller, 2 lower rollers)			
4607370	<b>285010</b>	1.9	1
1 set rollers for shaping tubes 10x1 mm (1 upper drive roller, 2 lower rollers)			
4607450	<b>285012</b>	1.9	1
1 set rollers for shaping tubes 12x1 mm (1 upper drive roller, 2 lower rollers)			
4607530	<b>285014</b>	1.8	1
1 set rollers for shaping tubes 14x1 mm (1 upper drive roller, 2 lower rollers)			
4607610	<b>285015</b>	1.8	1
1 set rollers for shaping tubes 15x1 mm (1 upper drive roller, 2 lower rollers)			
4607880	<b>285016</b>	1.7	1
1 set rollers for shaping tubes 16x1 mm (1 upper drive roller, 2 lower rollers)			
4607960	<b>285018</b>	1.7	1
1 set rollers for shaping tubes 18x1.5 mm (1 upper drive roller, 2 lower rollers)			

## PIPE STRAIGHTENING TOOL

## 286

### PIPE STRAIGHTENING TOOL MSR

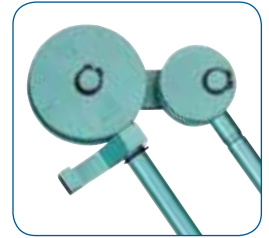
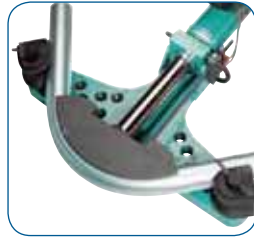
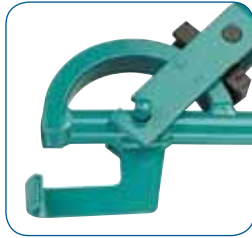
- From 14 to 26 mm Ø
- For multi-layer composite pipes (MSR) and soft copper pipes
- For use in a vice or in connection with pivoted and mobile coil reel
- Coil reel suitable for pipe coils from 220 to 1100 mm Ø, maximum pipe-coil height 400 mm



Code	No.		
1523066	<b>286000</b>	2.5	
Pipe straightening tool, without coil reel			
1531123	<b>286101</b>	22.5	
Coil reel, mobile, without straightening tool			



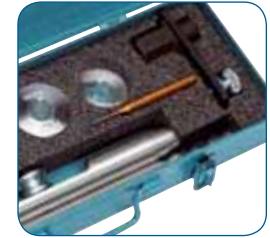
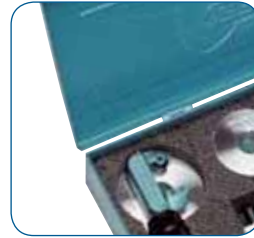
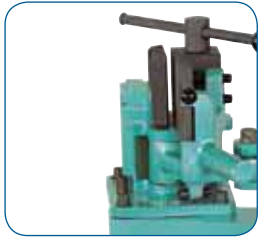




## APPLICATIONS OF THE GEDORE PIPE BENDER

Size	Outer diameter	Wall thickness	No. 2400 2405	No. 241	No. 2415	No. 2420 2423 2424 2425	No. 243	No. 244	No. 2454 2455 2456	No. 246	No. 249	No. 255 256	No. 257 258	No. 259 260	No. 276	No. 278	No. 285
<b>Gas and water pipes EN 10255-M (DIN 2440)</b>																	
1/8"	10,2 mm	2,00 mm															180°
1/4"	13,5 mm	2,35 mm															180°
3/8"	17,2 mm	2,35 mm								180°		90°	90°	90°			180°
1/2"	21,3 mm	2,65 mm								180°		90°	90°	90°			180°
3/4"	26,9 mm	2,65 mm								180°		90°	180°*	90°			180°
1"	33,7 mm	3,25 mm										90°	180°*	90°			
1.1/4"	42,4 mm	3,25 mm										90°	180°*	90°			
1.1/2"	48,3 mm	3,25 mm											180°*	90°			
2"	60,3 mm	3,65 mm											90°	90°			
2.1/2"	76,1 mm	3,65 mm												90°			
3"	88,9 mm	4,05 mm												90°			
<b>Gas and water pipes EN 10255-H (DIN 2441)</b>																	
1/8"	10,2 mm	2,65 mm															180°
1/4"	13,5 mm	2,90 mm															180°
3/8"	17,2 mm	2,90 mm										90°	90°	90°			180°
1/2"	21,3 mm	3,25 mm										90°	90°	90°			180°
3/4"	26,9 mm	3,25 mm										90°	180°*	90°			180°
1"	33,7 mm	4,05 mm										90°	180°*	90°			
1.1/4"	42,4 mm	4,05 mm										90°	180°*	90°			
1.1/2"	48,3 mm	4,05 mm											180°*	90°			
2"	60,3 mm	4,50 mm											90°	90°			
2.1/2"	76,1 mm	4,50 mm												90°			
3"	88,9 mm	4,85 mm												90°			
<b>Distilling pipes EN 10220 (DIN 2448)</b>																	
3/8"	17,2 mm	1,80 mm										90°	90°	90°			180°
1/2"	21,3 mm	2,00 mm										90°	90°	90°			180°
	25,0 mm	2,00 mm										90°	90°	90°			180°
3/4"	26,9 mm	2,30 mm										90°	90°	90°			180°
	30,0 mm	2,60 mm										90°	90°	90°			180°
	31,8 mm	2,60 mm										90°	90°	90°			
1"	33,7 mm	2,60 mm										90°	90°	90°			
	38,0 mm	2,60 mm											90°	90°			
1.1/4"	42,4 mm	2,60 mm											90°	90°			
	44,5 mm	2,60 mm											90°	90°			
1.1/2"	48,3 mm	2,60 mm											90°	90°			
	51,0 mm	2,60 mm											90°	90°			
	57,0 mm	2,90 mm												90°			
2"	60,3 mm	2,90 mm												90°			
	63,5 mm	2,90 mm												90°			
	70,0 mm	2,90 mm												90°			
2.1/2"	76,1 mm	2,90 mm												90°			





## APPLICATIONS OF THE GEDORE PIPE BENDER

Size	Outer diameter	Wall thickness	No. 2400 2405	No. 241	No. 2415	No. 2420 2423 2424 2425	No. 243	No. 244	No. 2454 2455 2456	No. 246	No. 249	No. 255 256	No. 257 258	No. 259 260	No. 276	No. 278	No. 285
<b>Electrical installation pipes EN 60423</b>																	
M 12	12,0 mm	1,00 mm									90°	90°	90°	90°	180°		
M 16	16,0 mm	1,00 mm									90°	90°	90°	90°	180°		
M 20	20,0 mm	1,00 mm									90°	90°	90°	90°	180°		
M 25	25,0 mm	1,20 mm									90°		90°	90°	180°		
M 32	32,0 mm	1,20 mm									90°		90°	90°	180°		
M 40	40,0 mm	1,20 mm									90°		90°	90°			
M 50	50,0 mm	1,20 mm									90°			90°			
<b>Banister-rail tubes</b>																	
3/8"	17,2 mm	1,75 mm									90°	90°	90°	90°	180°		
1/2"	21,3 mm	1,75 mm									90°	90°	90°	90°	180°		
3/4"	26,9 mm	2,00 mm									90°	90°	90°	90°	180°		
1"	33,7 mm	2,00 mm									90°		90°	90°			
1.1/4"	42,4 mm	2,00 mm									90°		90°	90°			
1.1/2"	48,3 mm	2,00 mm									90°			90°			
2"	60,3 mm	2,00 mm												90°			
<b>Multi-layer composite pipes</b>																	
	14,0 mm	2,00 mm				90°			90°	180°					180°		
	16,0 mm	2,00 mm				90°			90°	180°	90°				180°		
	18,0 mm	2,00 mm	180°			90°			90°	180°	90°				180°		
	20,0 mm	2,00 mm	180°			90°			90°	180°	90°				180°		
	26,0 mm	3,00 mm							90°						180°		
	32,0 mm	3,00 mm							90°		90°				180°		
	40,0 mm	3,50 mm									90°		90° (258)				
	50,0 mm	4,00 mm									90°		90° (258)				
	63,0 mm	4,50 mm											90° (258)				
<b>Copper pipes EN 1057 half-hard in mm</b>			12-22*			10-22*				6-28*	12-35				6-22		6-18*
<b>Copper pipes EN 1057 soft in mm</b>			12-22	4,75-12	4,75-10	10-22*	6-16*	10-22	5-22	6-28*	12-35				6-22		6-18*
<b>Sheathed copper pipes in mm</b>			*			*	*		*		*				*		
<b>Thin-walled NF pipes in mm</b>			12-22	4,75-12	4,75-10	10-22*	6-16*	10-30		12-28*	12-42				10-32		
<b>Hydraulic pipes EN 10305-1 (DIN 2391) in mm</b>			10-15 (2405)	4,75-12		10-18*	6-12*	10-22	5-18*	12-22*	12-42	14-32*	14-50*	14-76,1*	6-28*	3-25*	6-18*
<b>Precision steel pipes EN 10305-3 (DIN 2394) in mm</b>			10-15 (2405)	4,75-12		10-18*	6-12*	10-22	5-18*	12-22*	12-54	14-32*	14-50*	14-76,1*	6-28*	3-25*	6-18*
<b>Stainless steel pipes EN 10088-3 (DIN 17 440) in mm</b>						10-18*			5-18*	12-22*	12-42*	14-32*	14-40*	14-60,3*	6-28*	3-25*	

\*) depending on size / finish / pipe properties - see article description

