Mandrel & Wiper Selection

Determine the wall factor and "D" of bend on the next page
Then select the appropriate mandrel/wiper configuration from the chart below. These are recommendations based on average conditions.

Wall Factor

	1	1.25	1.5	2	2.5	3	4
10	M 1	M 1	M 1	M 1	P	P	
15	M 1W	M 1W	M 1	M 1	P	P	
20	M 2W	M 1W	M 1W	M 1	M 1	M 1	P
25	M 3W	M 2W	M 1W	M 1W	M 1	M 1	M 1
30	M 3W	M 3W	M 2W	M 2W	M 1W	M 1	M 1
35	M 3W	M 3W	M 3W	M 2W	M 2W	M 2W	M 2
40	M 4W	M 3W	M 3W	M 3W	M 3W	M 3W	M 2W
45	M 4W	M 3W	M 3W	M 3W	M 3W	M 3W	M 2W
50	M 4W	M 3W	M 3W	M 3W	M 3W	M 3W	M 2W
60	M 4W	M 4W	M 3W	M 3W	M 3W	M 3W	M 2W
70	TW 5W	TW 5W	TW 5W	M 3W	M 3W	M 3W	M 3W
80	TW 5W	TW 5W	TW 5W	TW 5W	M 3W	M 3W	M 3W
90	TW 5W	TW 5W	TW 5W	TW 5W	M 3W	M 3W	M 3W
100	TW 5W	TW 5W	TW 5W	TW 5W	TW 5W	M 3W	M 3W
125	TW 5W	TW 5W	TW 5W	TW 5W	TW 5W	TW 5W	M 4W
150	TW 6W	TW 6W	TW 6W	TW 6W	TW 5W	TW 5W	TW 4W
175	TW 7W	TW 7W	TW 7W	TW 7W	TW 7W	TW 6W	TW 6W
200	TW 10W	TW 10W	TW 10W	TW 10W	TW 9W	TW 9W	TW 8W
225		UTW 10W	UTW 10W	UTW 10W	TW 10W	TW 10W	TW 10W
250			UTW 10W	UTW 10W	UTW 10W	UTW 10W	UTW 10W
275			UTW 10W	UTW 10W	UTW 10W	UTW 10W	UTW 10W

"D" of Bend

Selection

P=Plug Mandrel
M1 = 1 ball
M2 = 2 ball
T = Thin wall
UT = Ultra Thin wall
W = Wiper

Purple shaded area = Standard mandrel, Yellow shades area = Thin Wall Mandrel
Blue shaded area = Ultra Thin Wall Mandrel

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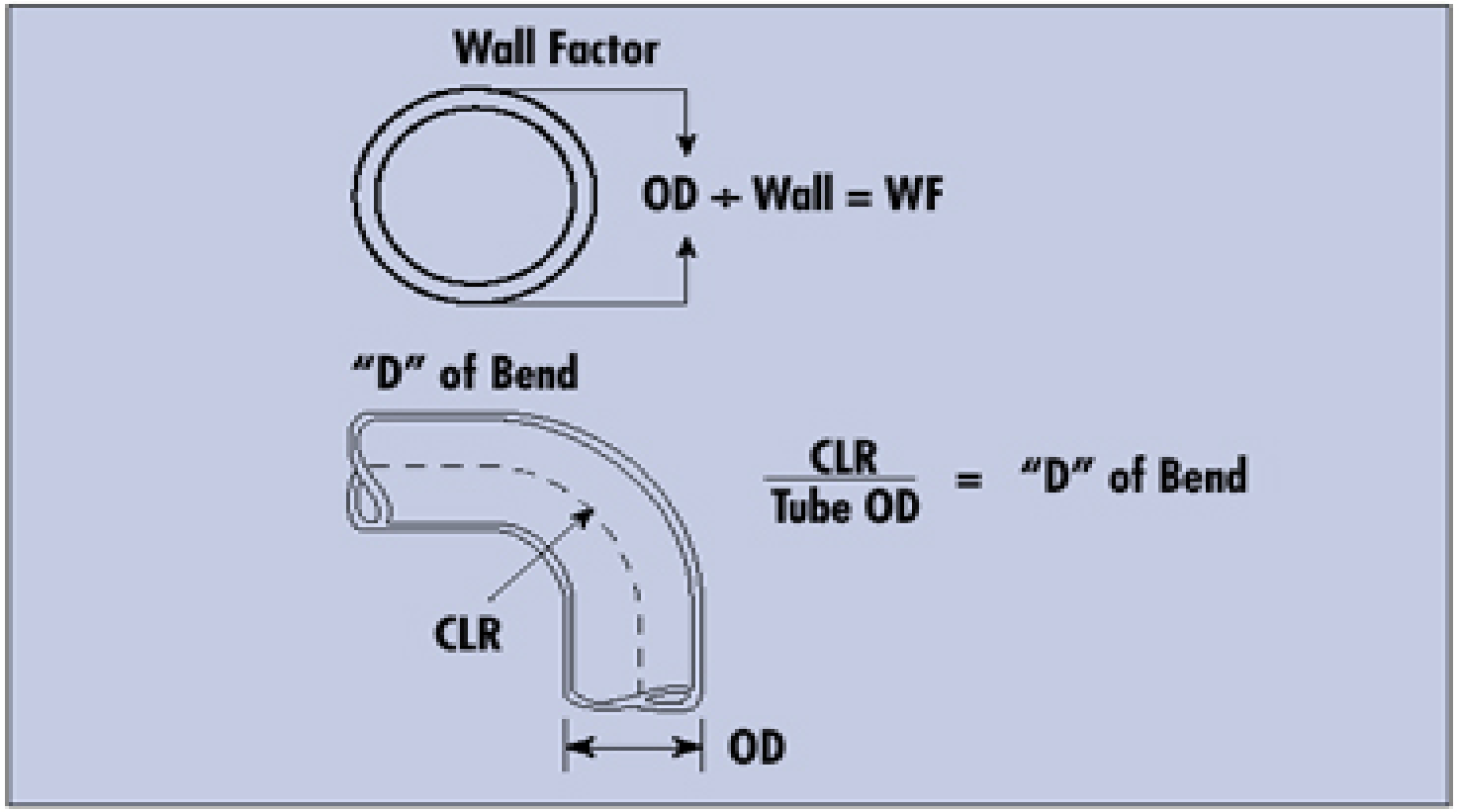

1) Determine the Wall Factor “WF”

2) Determine the “D” of Bend

3) Consult Chart to determine proper die set-up. (other page)