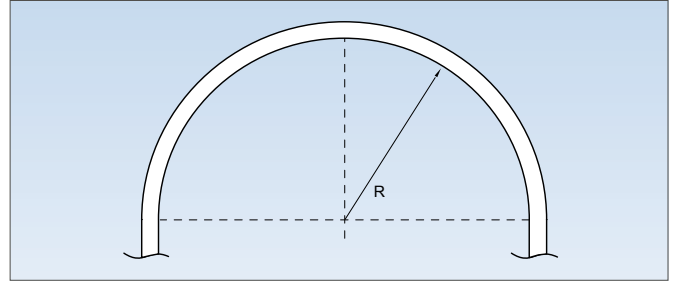


6 ASSEMBLY INSTRUCTIONS

6.4 Bending Henco pipe

The Henco pipe must be bent without heat application. For pipes having a diameter larger than $\varnothing 26$ elbow fittings should be used. The pipes can be bent manually as well as with an internal or external spiral spring. The following bending radii are to be respected for pipes up to and including $\varnothing 26$ mm.



Pipe	Minimum bending radius manual/external spiral spring (mm)		Minimum bending radius internal spiral spring (mm)	
	Henco Standard	Henco RIXc	Henco Standard	Henco RIXc
14 x 2	R 70 (5xDu)		R 42 (3xDu)	
16 x 2	R 80 (5xDu)	R 128 (8xDu)	R 48 (3xDu)	R 128 (8xDu)
18 x 2	R 90 (5xDu)		R 54 (3xDu)	
20 x 2	R 100 (5xDu)	R 140 (7xDu)	R 60 (3xDu)	R 100 (5xDu)
26 x 3	R 130 (5xDu)	R 182 (7xDu)	R 78 (3xDu)	R 130 (5xDu)



Bending with external spiral spring



Bending with internal spiral spring



Bending manually

The bend should start at least 5 x the outer diameter off a fitting.
Never use cracked pipes!

