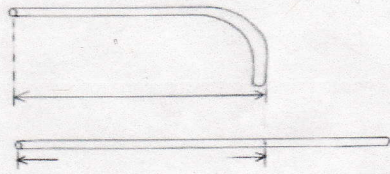


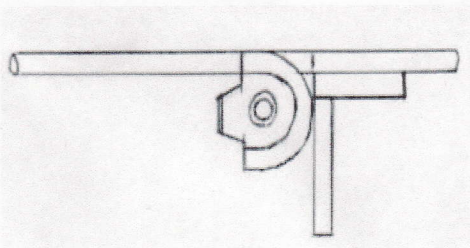
90 degree conduit bends

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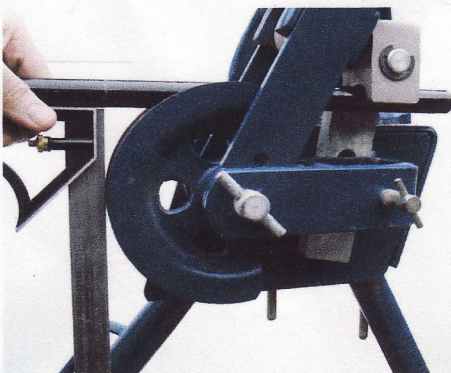
if you want a piece of 20mm conduit measuring 70cm from the back of the bend to the end of the thread



measure and mark your tube at 70cm. place the tube in the bending machine with the thread and most of the 70cm sticking out of the back of the bending machine



Using your set square line up your 70cm mark with the front edge of the bending machine former. making sure that the conduit is touching and parallel with the set square you will also need a bit of pressure forcing the conduit down slightly so it touches the top of the bending machine stop.

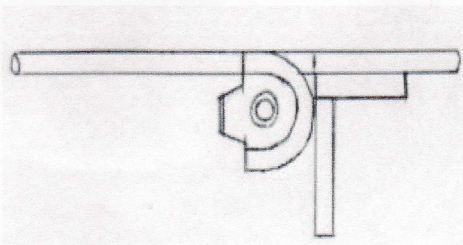


now bend your conduit to 90 degrees taking it out of the bending machine and measuring it. it will be 70cms from the back of the bend to the end of the thread.

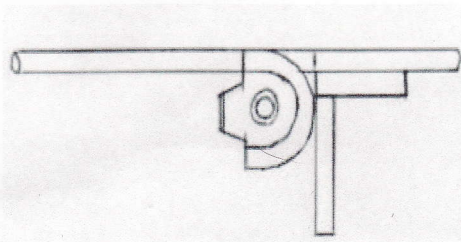
We will improve on these techniques later see page 3



that method will work for 16mm, 20mm, 25mm and 32mm metal conduit. in the picture below. I would like to bend another piece of conduit 70cm from the back of the bend to the end of the thread, but when I put the 70cm so it sticks out the back of the bending machine as before. the longer piece sticking out of the front will hit the floor once I start to bend it.



here are some ways round it turn the conduit round so the 70cm is sticking out of the front. but if we bend the 20mm conduit now



it will be 50 mm or 2 1/2 times the diameter of the conduit to long. therefore 70cm minus 50 mm equals 65cm. Line your 65cm mark up with the set square and former as before now bend the tube to 90 degrees.

conclusion your measurement when sticking out of the back of the bending machine minus nothing for your measurement sticking out of the front of the bending machine minus 2 1/2 times the diameter of the conduit
20mm conduit equals minus 50mm
25 mm conduit equal minus 67 1/2 mm