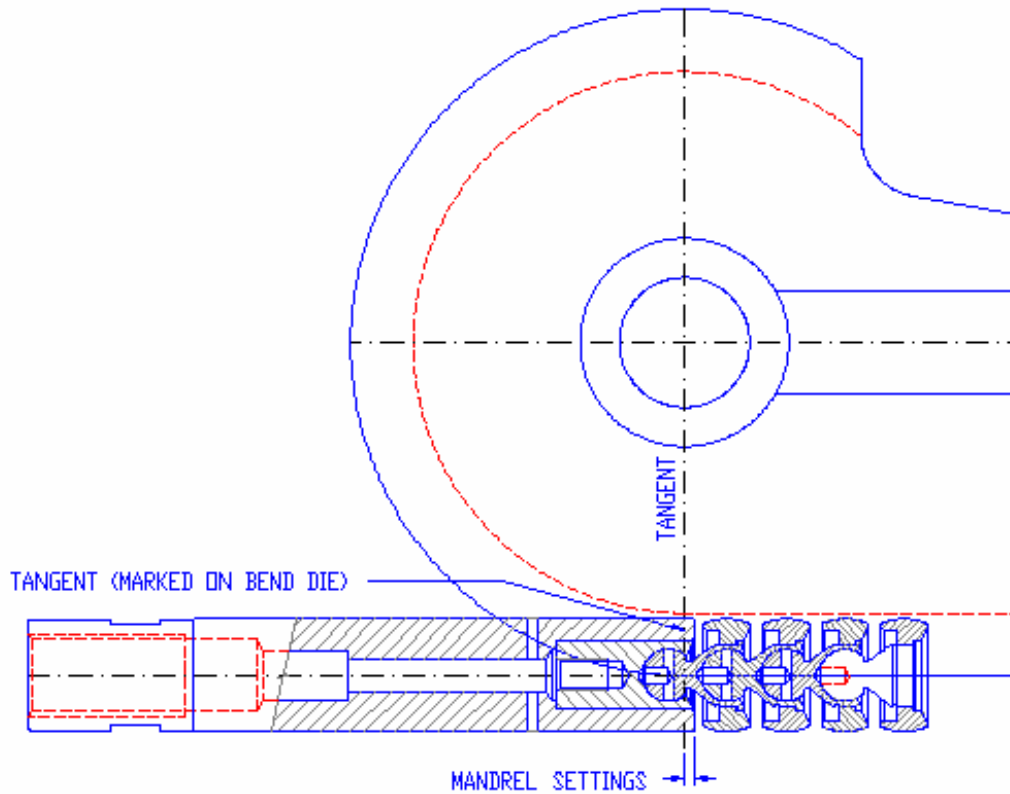


Mandrel Tangent Settings



Tip of mandrel shank should project past the tangent. Location of mandrel settings is specified in chart below. These tangent settings are a starting point for proper mandrel setup. Fine adjustment should be done after analyzing your bent tube.

Link	Tube Size O.D.	Tangent Setting	Thread in Mandrel
#2	.314 - .499	0.075	# 10-24
#3	.500 - .624	0.1	5/16 - 18
#4	.625 - .749	0.125	5/16 - 18
#5	.750 - .936	0.17	3/8 - 16
#6	.937 - 1.124	0.205	5/8 - 11
#7	1.125 - 1.499	0.125	5/8 - 11
#8	1.500 - 1.749	0.125	1" - 8
#9	1.750 - 2.124	0.187	1" - 8
#10	2.125 - 2.624	0.25	1" - 8
#11	2.625 - 3.374	0.25	1 3/4" - 10
#12	3.375 - 4.624	0.312	1 3/4" - 10
#13	4.625 - 6.625	0.375	1 3/4" - 10