

# Round Tube Tooling



## Bending Dies and Back Shoes: Imperial sizes

All Huth tooling is machined to specific tolerances from solid steel. After it is machined, it is gas-carburized and oil quenched to a minimum hardness of 58 Rockwell "C" scale. We do not use cast iron for any of our tooling. All Huth tooling listed below is available from shelf stock. However, Huth will manufacture custom tooling to your specification for sizes not listed in this schedule.



	Full 5" Centerline Radius Die	Full 4" Centerline Radius Die	5" Centerline Radius Die	4" Centerline Radius Die	3.5" Centerline Radius Die	Full Back Shoes (2 required)	Half Shoes (1 required)	Three- Quarter Shoes (1 required)	Quarter Shoes (1 required)
SIZE (Outside Diameter)						(2) 855 Pins Required Each	(1) 855 Pin Required	(1) 855 Pin Required	(1) 855 Pin Required
Tooling Part Numbers									
1/2"				4012	3012	1012	1027		
5/8"				4058	3058	1058	1029		
3/4"			5034	4034	3034	1034	1035		
0.840"					3084	1840	1085		
7/8"				4078	3078	1078	1031		
0.922"				4092	3092	1092	1002		
1"			5100	4100	3100	1100	1037		
1.050"			5105	4105	3105	1105	1005		
1 1/8"			5118	4118	3118	1118	1033		
1.163"			5116	4116	3116	1116	1016		
1 1/4"			5114	4114	3114	1114	1039		1084
1 5/16"			5056	4056	3056	1256	1356		
1 3/8"			5138	4138	3138	1138	1041		1083
1 1/2"	5812		5112	4112	3112	1112	1038		1082
1 5/8"		4858	5158	4158	3158	1158	1042		1081
1 3/4"	5834	4834	5134	4134	3134	1134	1040	1036	
1 7/8"	5878		5178	4178	3178	1178	1043	1044	
2"	5820	4820	5200	4200	3200	1200	1045	1046	
2 1/8"			5218	4218	3218	1218	1051	1053	
2 1/4"	5824		5414	4414	3414	4211	4416	4413	
2 3/8"			5438	4438	3438	4237	4437		
2 1/2"	5825		5412	4409		4412	4410	4415	
2 3/4"			5534			1234	1236	1235	
2 7/8"			5578			1378	1379		
3"			5530			1350	1352	1351	



# Round Tube Tooling



## Bending Dies and Back Shoes: Metric sizes

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	5 INCH CENTER- LINE RADIUS	4 INCH CENTER- LINE RADIUS	3 INCH CENTER- LINE RADIUS	FULL BACK SHOES (2 REQUIRED)	HALF SHOES (1 REQUIRED)	¾ SHOES (1 REQUIRED)
METRIC SIZE	PART NUMBERS					
40mm	5040	4040	3040	1340	1405	1540
42mm	5042	4042	3042	1342	1425	1542
45mm	5045	4045	3045	1345	1455	1545
48mm	5048	4048	3048	1348	1448	1548
50mm	5050	4050	3050	1349	1450	1550
54mm***	5218	4218	3218	1218	1051	1053
55mm	5055	4055	3055	1355	1445	1555
60mm	5060	4060		1360	1460	1560

\*\*\*  $2\frac{1}{8} = 54\text{mm}$

