

Mandrel Bent Stainless Steel Pipes

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RoHS 10

SPLM Semi-Seamless
Base Material Specification

Seam (Elimination of Weld Bead)

Ends are deburred only (Both SPLM and PIPM). Material: 304 Stainless Steel (Annealed)

PIPM Seamless Ornamental Pipes #400

Material: 304 Stainless Steel

t=1.0 (D=10, 15)
t=2.0 (D=22, 25, 32)
t=3.0 (D=38, 45, 50)

Specifying Angle 1 / Angle 2

U: Specify Angle (1) bent upward
L: bent downward
UU: Specify Angle (2) bent upward
LL: bent downward

Specifying Angle 3

LT: bend to left
RT: bend to right

- When Angle (2) begins with UU upward - When Angle (2) begins with LL downward

⚠ Bending process may cause scratches on the surface.

Type	Part Number	D	Bending Type	Bending R Tolerance ±3	Pipe Length			Bending Angle					
					LA	LB	LC	Specify (1)	Specify (2)	Specify (3)			
SPLM Semi-Seamless	2	3	1st Bending	40	80-600 1 mm increment.	40	U/L	UU/LL	RT/LT				
	4	5								6	8	10	12
	15	16								20	25	30	2nd Bending
	10	15								22	25	30	2nd Bending + 3rd Bending
	15	22								25	30	32	PIPM Ornamental Pipes
	25	32								38	45	50	
	38	45								50	100	130	
	100	130								150	180	30-90 1° increment ±0.5°	
	150	180								200	253	220	

Part Number Example

SPLM10 - B1 - 100 - 100 - L50

PIPM25 - B3 - 200 - 253 - 220 - L90 - UU75 - LT45

Three Dimensional Bending Example
For PIPM25-B3-200-253-220-L90-UU75-RT45

Part Number Alterations

Part Number - B - LA - LB - LC - U/L - UU/LL - RT/LT - (AUT/CUT/UA/CUC)

PIPM22 - B3 - 100 - 240 - 320 - U50 - UU35 - LT49 - AUT70

PIPM22 - B3 - 200 - 253 - 361 - U60 - UU35 - LT49 - CUA

Alterations	LA / LC Cut	Parallel Cutting
Code	AUT LA Cut CUT LC Cut	CUA LA Side CUC LC Side
Spec.	Cuts LA and LC. Ordering Code: AUT100 ⚠ AUT(CUT) ≥ R+D	Cuts LB parallel. Ordering Code: CUA

Resin Rods

Unfinished Exterior Surface

These Polyacetal and MC Nylon rod materials are used for various industrial purposes. Available from Ø10-Ø200.

Resin Rods - Unfinished Exterior Surface

RoHS 10

Part Number	Material	Grade	Color
RDJJS	Polyacetal	Standard	White
RDJKS			Black
RDJMS	MC Nylon	Standard	Blue
RDJFS	Fluororesin	Standard	White

L Dimension Tolerance

D	L Dimension Tolerance
10-50	0~+3.0
60-200	0~+10.0

D Dimension Tolerance (MC Nylon)

D	D Dimension Tolerance
20-30	0~+1.5
40-50	0~+3.0
60-120	0~+4.0
150-200	0~+5.0

Warpage Range of D (MC Nylon)

D	Warpage
20-200	4.0 or Less

(Other Than Above)

D	Warpage
10	5.0 or Less
15-200	3.0 or Less

⚠ Exterior surfaces are unfinished. Machined Surface, see P.2504
⚠ For Characteristic Values, refer to P.3067-3068

Type	Part Number	D	L
RDJMS	10, 15, 20, 25, 30, 40, 50, 60, 70, 80, 90, 100, 120		20-800
RDJJS			20-800
RDJKS		150, 180, 200	20-500

Type	Part Number	D	L
RDJFS	10, 15, 20, 25, 30, 40, 50, 60, 70, 80, 90, 100, 120		20-800
		150	20-500

Part Number Example

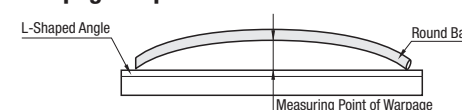
Part Number - L

RDJJS15 - 500

Examples of Available O.D. Dimensions

Material	Grade	Color	O.D.(D)
MC Nylon	Standard	Blue	10, 15, 35, 55, 65, 75, 85, 110, 130, 140, 160
Polyacetal	Standard	Black, White	35, 55, 65, 75, 85, 110, 130, 140, 160
Fluororesin	Standard	White	35, 55, 65

Warpage Inspection Method



Outer Dia. - Maximum and minimum diameters will be measured with a caliper.

Warpage - Rod is placed along an L-shaped Angle, as shown in the diagram above, and turned 360° about the outer diameter. Maximum clearance is measured with a ruler.