



# SPIRAL

# BENDING



BENDING THE RULES<sup>®</sup>

503.692.6010

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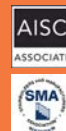
No fillers added to  
inside of HSS stringers.



No splitting HSS prior to  
bending & welding material  
back together.






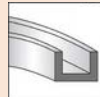
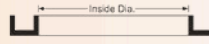


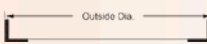

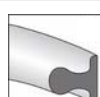









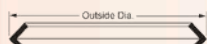



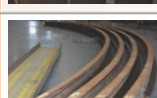










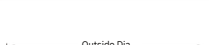



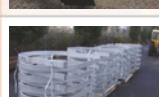

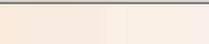

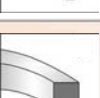





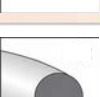

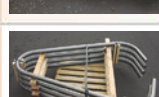

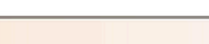
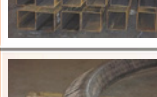


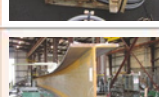









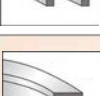
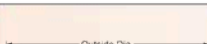



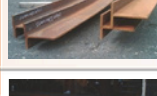
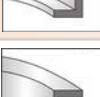

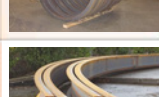


No "Built-Up" sections made  
out of plate. Only mill-produced  
HSS material (unless requested).







# CAPACITIES CHART

Section	3D Image	2D Image	Photo	Capacities	Section	3D Image	2D Image	Photo	Capacities
Angle Leg Out				All sizes through 8" x 8" x 11/4"	Channel the Hard Way (X-X Axis)				All Mill Produced Sizes
Angle Leg In				All sizes through 8" x 8" x 11/4"	Rail Ball In				All sizes up to approximately 175#
Angle Heel In				All sizes through 8" x 8" x 11/4"	Rail Ball Out				All sizes up to approximately 175#
Angle Heel Out				All sizes through 8" x 8" x 11/4"	Rail Ball Up				All sizes up to approximately 175#
Angle Heel Up				All sizes through 8" x 8" x 11/4"	Round Pipe & Tube				Roll/Cold Bending: 3/16" OD through 28" OD Induction/Hot Bending: 6" OD through 28" OD Rotary Draw/Mandrel Bending: 1/2" OD through 6" Pipe (Sch80)
Flat Bar the Hard Way				Any thickness and size through 2-1/2" x 16" (section is dependent on thickness to width)	Rect. Tube the Hard Way				20" x 12" x .625" (Maximum mill produced size-bending capacity is greater)
Plate/Flat Bar the Easy Way				*Plate: 2-1/2" plate up to 10'0" in width *Flat Bar the Easy Way: Any thickness and size through 4" x 22" (section is dependent on thickness to width)	Rect. Tube the Easy Way				20" x 12" x .625" (Maximum mill produced size-bending capacity is greater)
Square Bar				All Mill Produced Sizes	Square Tube				16" x 16" x .625" (Maximum mill produced size-bending capacity is greater)
Round Bar				All mill produced sizes	Square Tube Diagonally				16" x 16" x .625" (Maximum mill produced size-bending capacity is greater)
Beam the Easy Way (Y-Y Axis)				S3/W4 through W33 x 241# W36 x 210# and W40 x 183#	Tee Stem In				All sizes through 12" Stems (weight per foot maximums would need to be calculated based on WF origin)
Beam the Hard Way (X-X Axis)				S3/W4 through W36 x 230#	Tee Stem Out				All sizes through 12" Stems (weight per foot maximums would need to be calculated based on WF origin)
Channel Flanges In				All mill produced sizes	Tee Stem Up				All sizes through 12" Stems (weight per foot maximums would need to be calculated based on WF origin)
Channel Flanges Out				All mill produced sizes	Bulb Flat		Bulb Stem-In or Stem Out		All mill sizes produced up to 430 mm x 20 mm (16.93" wide x .787" thick)

# YOUR STEEL BENDING EXPERTS