



HOW TO CUT ODD ANGLE LONGE RADIUS ELBOW														
NOM SIZE	OUT SIDE ARC(DEG)							IN SIDE ARC(DEG)						
	1°	5°	10°	15°	22 1/2°	37 1/2°	45°	1°	5°	10°	15°	22 1/2°	37 1/2°	45°
2	1.9	9.5	18.3	27.8	42.1	69.9	83.3	0.8	4	7.9	11.9	18.3	30.2	36.5
2 1/2	2.4	11.1	23	34.1	51.6	85.7	103.2	1.2	4.8	9.5	15.1	23	38.1	46
3	2.8	14.3	28.6	41.3	62.7	104	124.6	1.2	6.4	12.7	18.3	27.8	46	54
3 1/2	3.2	15.9	32.5	48.4	72.2	120	144.5	1.6	7.1	14.3	21.4	32.5	54	65.1
4	3.6	18.3	36.5	54.8	82.6	137.3	164.3	1.6	7.9	16.7	24.6	37.3	61.9	74.6
5	4.8	23	45.2	68.3	102.4	170.7	204.8	1.9	10.3	20.6	31.8	46.8	78.6	94.4
6	5.6	27	54.8	81.8	123	204.8	254.3	2.4	12.7	25.4	38.1	56.4	94.5	113.5
8	7.1	36.5	72.2	108.7	162.7	271.5	325.4	3.2	17.5	34.1	50.8	77	127.8	153.2
10	8.7	45.2	90.5	135.7	203.2	388.9	406.4	4	21.4	42.9	64.3	96	160.3	192.1
12	11.1	54	108	161.9	242.9	405.6	486.6	5.6	25.4	51.6	77.8	115.9	192.9	231.8
14	12.7	61.9	123.8	185.7	279.4	465.1	588.8	6.4	31	61.9	92.9	139.7	232.6	279.4
16	14.3	71.4	142.1	212.7	319.1	531.8	630.2	7.1	35.7	71.4	106.4	159.5	286.9	320.7
18	15.9	79.4	159.5	239.7	358.8	598.5	718.3	7.9	39.7	79.4	119.9	179.4	299.2	358.8
20	17.5	88.9	177.8	265.9	399.3	665.2	797.7	8.7	44.5	88.9	133.4	199.2	332.6	398.5
22	19.1	97.6	195.3	292.9	438.9	731.8	877.9	9.5	48.4	97.6	147.1	219.1	365.1	338.9
24	21.4	106.4	212.7	319.1	478.6	797.7	951.3	10.3	53.2	106.4	150.5	239.7	398.5	478.6
26	23	115.1	231	346.1	518.3	864.4	1037.4	11.9	57.9	115.1	173	259.6	432.6	518.3
30	26.2	133.4	265.9	400.1	598.5	997	1197	13.5	66.7	133.4	200	299.2	498.5	598.5
34	29.4	150	300.8	452.4	678.7	1131.1	1366.7	15.1	75.4	150	226.2	339.7	565.9	601.7
36	31	158.8	318	479.4	716.8	1193.8	1435.9	15.9	79.4	168.8	239.7	358.8	600.1	717.6
42	36.5	185.7	371.5	558.8	837.4	1396.2	1674.8	18.3	92.9	185.7	269.1	419.1	699.9	837.4

PREPARATION BY
TECHNICAL OFFICE AREA 1