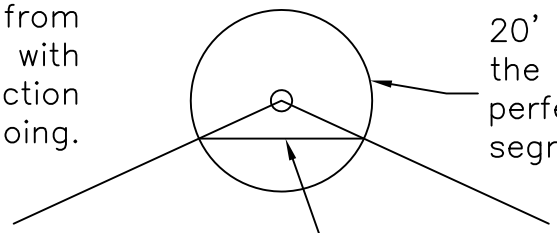
BENDS MADE FROM PIPE

L (LENGTH OF PIPE)	D (DIAMETER)	A (TANGENT LENGTH FOR WELD ENDS)	LE: (EFFECTIVE LENGTH FOR BENDING)	MINIMUM RADIUS OF BEND (PER D)	MINIMUM DEGREES OF BEND SUGGESTED
METERS/FT	INCHES	METERS/FT	METERS/FT	PER ASME B31.4	PER FDS
12.2m or 40'	12"	2m or 6.5616'	8m or 26.2466'	18	30
12.2m or 40'	14"	2m or 6.5616'	8m or 26.2466'	21	30
12.2m or 40'	16"	2m or 6.5616'	8m or 26.2466'	24	30
12.2m or 40'	18"	2m or 6.5616'	8m or 26.2466'	27	30
12.2m or 40'	20"	2m or 6.5616'	8m or 26.2466'	30	30
12.2m or 40'	22"	2m or 6.5616'	8m or 26.2466'	30	30
12.2m or 40'	24"	2m or 6.5616'	8m or 26.2466'	30	30
12.2m or 40'	26"	2m or 6.5616'	8m or 26.2466'	30	30
12.2m or 40'	28"	2m or 6.5616'	8m or 26.2466'	30	21
12.2m or 40'	30"	2m or 6.5616'	8m or 26.2466'	30	21
12.2m or 40'	32"	2m or 6.5616'	8m or 26.2466'	30	21

ANYTHING OVER THE CALLED OUT MINIMUM RADIUS OR MINIMUM DEGREES SUGGESTED: BREAKDOWN YOUR PI'S

EXAMPLE OF PI BREAKDOWN

Now add your 2 New PI's and (Break) the Line Segment from the inside and then Fillet with a radius of (0) the direction the centerline is going.



20' RADIUS / Keep drawing the circle until you get a perfect 40' or 12.2m line segment.

12.2m or 40' (TYP)
LENGTH OF STRAIGHT PIPE
ALL BREAKDOWNS WILL HAVE A 12.2m or 40' PIECE OF PIPE FOR EACH LINE SEGMENT

HOW TO CREATE AN EQUATION

$$\frac{BK = 0+00}{AH = 1+00}\ (-\text{ Subtract})$$

$$\frac{BK = 1+00}{AH = 0+00}\ (+\text{ Add})$$