

GAIN FACTORS

Degree of Bend	Multiplier
1	.0000
2	.0000
3	.0000
4	.0000
5	.0000
6	.0001
7	.0001
8	.0003
9	.0003
10	.0005
11	.0006
12	.0008
13	.0010
14	.0013
15	.0015
16	.0018
17	.0022
18	.0026
19	.0031
20	.0036
21	.0042
22	.0048
23	.0055
24	.0062
25	.0071
26	.0079
27	.0090
28	.0100
29	.0111
30	.0126

Degree of Bend	Multiplier
31	.0136
32	.0150
33	.0165
34	.0181
35	.0197
36	.0215
37	.0234
38	.0254
39	.0276
40	.0298
41	.0322
42	.0347
43	.0373
44	.0400
45	.0430
46	.0461
47	.0493
48	.0527
49	.0562
50	.0600
51	.0637
52	.0679
53	.0721
54	.0766
55	.0812
56	.0860
57	.0911
58	.0963
59	.1018
60	.1075

Degree of Bend	Multiplier
61	.1134
62	.1196
63	.1260
64	.1327
65	.1397
66	.1469
67	.1544
68	.1622
69	.1703
70	.1787
71	.1874
72	.1964
73	.2058
74	.2156
75	.2257
76	.2361
77	.2470
78	.2582
79	.2699
80	.2891
81	.2944
82	.3074
83	.3208
84	.3347
85	.3491
86	.3640
87	.3795
88	.3955
89	.4121
90	.4292

GAIN = GAIN FACTOR FOR DEGREE OF BEND X RADIUS

EXAMPLE:

**FIND THE GAIN FOR AN 85 DEGREE BEND
USING A 7 INCH RADIUS**

$$\text{GAIN} = .3491 \times 7 = 2.4437 \text{ OR } 2 \frac{7}{16}$$

TABLE FOR OFFSET MULTIPLIER

Degree of Bend	Multiplier
1	57.30
2	28.65
3	19.11
4	14.33
5	11.47
6	9.57
7	8.21
8	7.18
9	6.39
10	5.76
11	5.24
12	4.81
13	4.45
14	4.13
15	3.86
16	3.63
17	3.42
18	3.24
19	3.07
20	2.92
21	2.79
22	2.67
23	2.56
24	2.46

Degree of Bend	Multiplier
25	2.37
26	2.28
27	2.20
28	2.13
29	2.06
30	2.00
31	1.94
32	1.89
33	1.84
34	1.79
35	1.74
36	1.70
37	1.66
38	1.62
39	1.59
40	1.56
41	1.52
42	1.49
43	1.46
44	1.44
45	1.41
46	1.39
47	1.37
48	1.35

**DISTANCE BETWEEN BENDS = OFFSET MULTIPLIER FOR
DEGREE X OFFSET HEIGHT**

EXAMPLE:

**FIND THE DISTANCE BETWEEN BENDS FOR A
15 INCH OFFSET USING 25 DEGREE BENDS.**

DISTANCE BETWEEN BENDS = 2.37 X 15 = 35.55 OR 35 9/16

DEVELOPED LENGTH

DEVELOPED LENGTH = .0175 X DEGREE OF BEND X RADIUS

EXAMPLE:

**FIND THE DEVELOPED LENGTH OF A 70 DEGREE
BEND USING AN 8 INCH RADIUS.**

DEVELOPED LENGTH = .0175 X 70 X 8 = 9.80 OR 9 13/16