Repeatable Conduit Bending Chart

CONDUIT	Deduct	Length	Stub "FC"	Length "ED"	Travel	Gain	B to B	DCOB	OD	Travel Z	Travel T
Chicago .5"											
Chicago .75"											
Chicago 1"											
EMT .5"											
EMT .75"											
EMT 1"											
EMT 1.25"											
EMT 1.5"											
EMT 2"											
EMT 2.5"											
EMT 3"											
EMT 3.5"											
EMT 4"											
IMC .5"											
IMC .75"											
IMC 1"											
IMC 1.25"											
IMC 1.5"											
IMC 2"											
Rigid .5"											
Rigid .75"											
Rigid 1"											
Rigid 1.25"											
Rigid 1.5"											
Rigid 2"											
Rigid 2.5"											
Rigid 3"											
Rigid 3.5"											
Rigid 4"											
Robroy .5"											
Robroy .75"											
Robroy 1"											
Robroy 1.25"											
Robroy 1.5"											
Robroy 2"											
Robroy 3"											

a = Place mark on conduit before installing conduit in bender
b = Place mark on conduit before installing conduit in bender
z = Place mark on conduit at a stationary point at the back of the bender before bending 90 degree bend and enter value in the Travel z cell in chart
t = Place mark on conduit at a stationary point at the back of the bender after bending 90 degree bend and enter value in the Travel t cell in chart

Deduct = af
Length = L
Stub fc = cf
Length de = de
Travel = bz - bt
gain = (cf + de) - L
B to B = af - ((cf + de) - L)
OD = Outside diameter of conduit
DCOB = (Deduct - Radius) Distance from the front of the bending shoe to the center of bend.
Travel z = bz
Travel t = bt