


Laying Length = L 1 + L 2

Ø = Maximum Deflecting Angle

PIPE DIA.	MAXIMUM DEFLECTION ANGLE Ø					
	ROUND RCP SIZES			ROUND RCP SIZES		
	ROUND PIPE			ARCH PIPE		
in	4' LAY	5' LAY	8' LAY	4' LAY	6' LAY	8' LAY
12	90°	--	--	--	--	--
15	85°	90°	--	--	--	--
18	70°	90°	--	35°	--	--
24	60°	90°	--	25°	--	--
		6' LAY				
30	50°	90°	--	20°	50°	--
36	40°	85°	90°	--	40°	60°
42	35°	80°	90°	--	35°	55°
48	30°	70°	90°	--	30°	50°
54	--	65°	90°	--	30°	45°
60	--	60°	85°	--	25°	40°
66	--	55°	80°	--	--	--
72	--	50°	75°	--	20°	35°

1. Use standard 7-1/2 degree bends whenever possible.
2. Specify hand fabricated bends to the nearest 5 degree increments.
3. Special bends with unequal legs can be fabricated. A scale drawing should be done to check for the 1.3' minimum wall length.
4. Consult the Office for sizes larger than 72".

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SCALE	none	TITLE
DATE	6/27/16	HAND FABRICATED BENDS FOR NON-GASKETED PIPE
DR'N.	RTF	
REVISION DATE	6/27/2016	DRAWING NUMBER