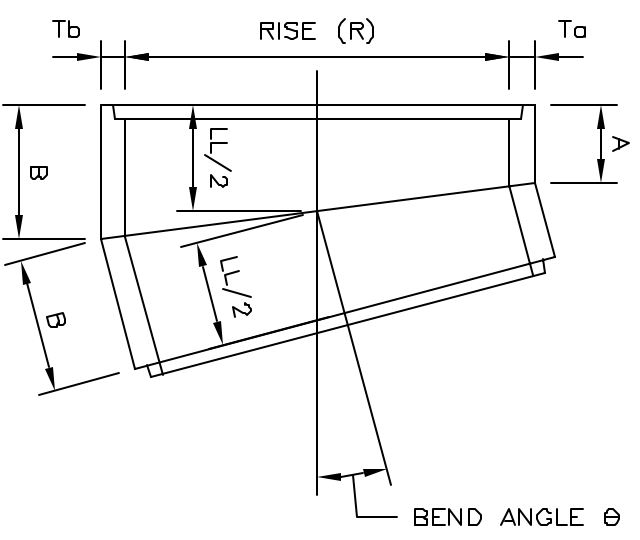


HORIZONTAL BEND  
{PLAN VIEW}



VERTICAL BEND  
{ELEVATION VIEW}

DESIGN PROCEDURE

LAY LENGTH, LL, SHOULD BE 4', 5', OR 6'

$$A = \frac{LL}{2} - \tan\left(\frac{\theta}{2}\right) \times \left(\frac{S \text{ or } R}{2} + T_d\right)$$

$$B = \frac{LL}{2} + \tan\left(\frac{\theta}{2}\right) \times \left(\frac{S \text{ or } R}{2} + T_d\right)$$

NOTES

1. "A" SHOULD BE GREATER THAN 16".
2. TOTAL WEIGHT SHOULD BE LESS THAN 35,000 LBS.
3. WHEN CALCULATING A & B, USE "S" FOR HORIZONTAL BENDS AND "R" FOR VERTICAL BENDS.

BEND SECTION DETAIL