



HUTH™ PRODUCT LINE

- Benders
- Tooling
- Expanders
- Accessories and Add Ons

The Best Equipment, Tools and Service ...
for Tube Fabricators Around the World

HUTH BENDERS

Huth Tube and pipe benders

- The top of the line "ram-style" compression benders available anywhere.
- American made. Built by experienced masters.
- Rugged I-beam construction. ... Tough as hell. Lasts decades.

The HB-10: "The Full Package"

The best value in the market ... **Includes 028 Tooling Package (see pg 4)!**

- 5 HP motor gives 58,000 pounds of bending force, more than enough for 3 inch tubing
- Electrical knee control for hands-free operation
- Comes with comprehensive tooling package and instructional DVD
- Easy-To-Use Knee Pad Control
- Manual Depth-of-Bend Indicator
- Complete Manual Control
- 58,000 lbs of bending power - More than enough for 3" tubing
- Flat Tool Tray



All Huth Benders give you:

- Built in Heavy-Duty Swager/Expander gives you complete end-finishing capabilities - 1" to 3" tubing on the swager end and 1" to 5½" tubing on the expander end
- Rugged I-Beam construction
- A High Speed Option for 25% faster bending
- Exclusive Safety-Guard Package
- Front swivel casters
- 220V, 60 Hz Operation. Single-Phase requires 30 amp service. 3-Phase requires 20 amp service. (Other voltages and 50Hz available.)
- Bending Die Retainers

The "Heavy Duty" Model 2600 ... for BIG JOBS.

- 7.5 HP motor for 85,000 pounds of unmatched bending power
- Heavy steel reinforced framing
- Heavy duty gates and bushings
- Reinforced bending gates and frame
- Large volume reservoir
- Elevated center of bend
- Push button controls
- Easy-to-use knee control for forward/reverse
- Automatic depth-of-bend selector
- Bends schedule/thick wall pipe with ease



Visit www.huthbenders.com for our complete line of quality benders!



HUTH BENDERS

Huth's Remote Performance Bender (Model HRP-1620)

Operate bender away from the machine (when supporting a long tube)

Work more closely to the bend area. Simply move controls out of the way!

Built on the time-tested HB10/1600 platform

- 5 HP motor gives 58,000 pounds of bending force, more than enough for 3" tubing
- Heavy duty swager/expander for full end-finishing ability
- Expanding ability 1" to 5.5"
- Electrical knee control for hands-free operation

New pendant control station allows you to move while you work!



Tooling sold separately

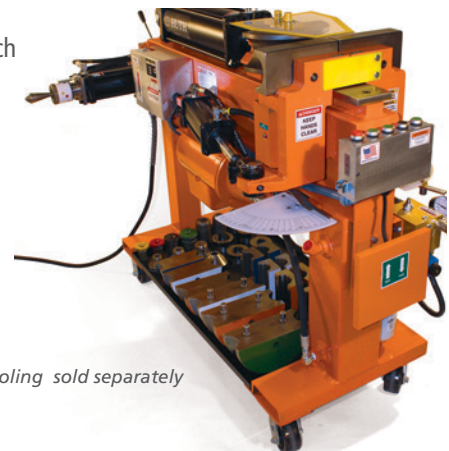
The 2806 "Production Work-Horse"

- Automatic depth of bend indicator makes repeatable bends easy
- More control options with both push button and knee controls
- Easy-To-Use Knee Pad Control or Foot Pedal Control
- Push Button Control
- Automatic Depth-of-Bend Selector
- Complete Manual Control
- High Speed Option available
- 58,000 lbs Of Bending Power - More than enough for 3" tubing
- Heavy duty Hydraulic Cylinders
- Flat Tool Tray (2806 only)

... and the Sturdy 2008

Features listed at left (for 2806) plus:

- Swager Tray
- Auxiliary On/Off Switch
- Deluxe Tool Tray



Tooling sold separately



Pipe Bending for Thousands of Applications

The value of portable, affordable pipe benders was quickly evident when Huth first introduced them. With a Huth bender, it is not necessary to keep a variety of pre-bent pipes in inventory. **With a few sizes of straight tubing on hand, you can quickly bend pipes for thousands of applications.**

Today's Huth Benders are used in many more automotive and non-automotive applications than Gerry Huth ever dreamed! You will find our benders in shops working to make the fastest cars in the neighborhood, and building specialty equipment for cars and sporting goods. You'll find them in a wide variety of welding and fabrication shops, as well as manufacturing operations and prototyping facilities. Huth products are used in production for such products as furniture, car parts, hand railings and many other applications that require pipe bending and end finishing.



HUTH DIE PACKAGES

DIE PACKAGE

Radius Dies			010	011	013	028
No.	Radius	Size				
3112	3"	1 1/2"		x	x	x
4112	4"	1 1/2"	x		x	
5112*	5"	1 1/2"			x	
3134	3"	1 3/4"		x	x	x
4134	4"	1 3/4"	x	x	x	
5134*	5"	1 3/4"			x	
3200	3"	2"	x	x	x	
4200	4"	2"	x	x	x	x
5200*	5"	2"	x	x		x
5820*	5"	2" 180°			x	
3414	3"	2 1/4"			x	
4414	4"	2 1/4"	x	x	x	x
5414*	5"	2 1/4"	x	x		x
5824*	5"	2 1/4" 180°			x	
4409	4"	2 1/2"		x	x	
5412*	5"	2 1/2"	x	x	x	x
5530*	5"	3"		x	x	x
*=-requires 41041 retainer						
Back Shoes (2 required)			010	011	013	028
No.	Pcs.	Size				
1112	2	1 1/2"	x	x	x	x
1134	2	1 3/4"	x	x	x	x
1200	2	2"	x	x	x	x
4211	2	2 1/4"	x	x	x	x
4412	2	2 1/2"	x	x	x	x
1350	2	3"		x	x	x
Three Quarter Shoes			010	011	013	028
No.	Size					
1036	1 3/4"				x	
1046	2"			x	x	
4413	2 1/4"			x	x	
4415	2 1/2"				x	
1351	3"				x	
Half Shoes			010	011	013	028
No.	Size					
1038	1 1/2"		x	x	x	x
1040	1 3/4"		x	x	x	x
1045	2"		x	x	x	x
4416	2 1/4"		x	x	x	x
4410	2 1/2"		x	x	x	x
1352	3"				x	
Expander Segments			010	011	013	028
No.	Size					
472	1 1/2" - 1 3/4"		x	x	x	x
474	1 3/4" - 2 1/8"		x	x	x	x
475	2 1/8" - 2 1/2"		x	x	x	x
476	2 1/2" - 3"			x	x	x
Flaring Tools			010	011	013	028
No.	Size					
518	2" Double Flare and 1 1/2" Flat Flare			x		
Flaring Segment 45°			010	011	013	028
No.	Size					
440	1 1/2" to 2 1/2"				x	

DIE PACKAGE

Collets (2 pieces included)		010	011	013	028
No.*	Size				
1712	1 1/2"	x	x	x	x
1734	1 3/4"	x	x	x	x
1720	2"	x	x (DF)	x	x
1725	2 1/4"	x	x	x	x
1750	2 1/2"	x	x	x	x
1730	3"			x	
Ball Joint Segments		010	011	013	028
No.	Size				
419	2"		x		
420	2 1/4"		x		
421	2 1/2"		x		
Male Ball Joints		010	011	013	028
No.	Size				
550	1 3/4"			x	x
552	2"			x	x
553	2 1/4"			x	x
554	2 1/2"			x	x
Female Ball Joints		010	011	013	028
No.	Size				
555	1 3/4" - 2"	x	x	x	x
556	2 1/4" - 2 1/2"	x	x	x	x
Doming Dies		010	011	013	028
No.	Size				
557	1 3/4" to 2 1/2"			x	x
558	2 1/2" to 2 3/4"			x	x
Arbors (Solid Piece)		010	011	013	028
No.	Size				
572	1 3/8" - 1 3/4"	x	x	x	x
573	1 3/4" to 4"	x	x	x	x
Swage Dies		010	011	013	028
No.	Size				
112	1 1/2"		x	x	x
134	1 3/4"		x	x	x
178	1 7/8"		x	x	
120	2"		x		
125	2 1/4"		x		
150	2 1/2"		x		
130	3"			x	
*For 2", 2 1/4", 2 1/2", 2 3/4" IDs, can use male ball joint tools 550, 552, 553, 554					
Reducing Dies		010	011	013	028
No.	Size				
780	2" to 1 3/4"			x	
781	2 1/4" to 2"			x	
782	2 1/2" to 2 1/4"			x	
783	3" to 2 1/2"			x	
Accessories		010	011	013	028
No.	Size				
815	Die Holder	x		x	x
816	Die Holding Pin	x		x	x
825	Quick Disconnect kit		x	x	
835	Tube cutter	x	x	x	
852	Blank Plate			x	
855	Die Pins	x	x	x	x
870	O-Rings-Rubber Assist.			x	x
892	Collet Holder			x	

Die Packages

Huth has combined the tooling you'll be reaching for most often into comprehensive, convenient tooling "die packages".

We make these an unbelievable value for you, and they combine the tooling for bending and end-finishing with the accessories you need to get the most from your bender.

Some even include Huth's exclusive Program Card Bending System (H980), containing all the information you need to bend pipes for thousands of applications (1928 Model A's through 2001).

010 Die Package Tooling



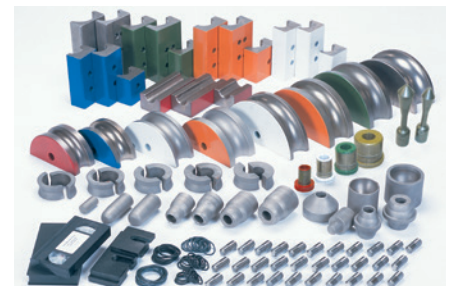
011 Die Package Tooling



013 Die Package Tooling



028 Die Package Tooling



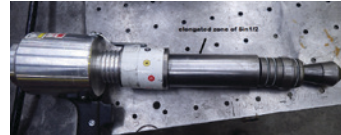
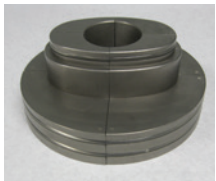
HUTH TOOLING: CUSTOM TOOLING AND TOOL PACKAGES

Custom Tooling

All Huth tooling is machined to specific tolerances from solid steel. After it is machined, it is gas-carburized and oil quenched to a minimum hardness of 58 Rockwell "C" scale. We do not use cast iron for any of our tooling.

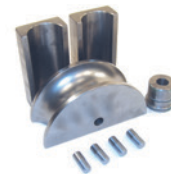
Huth will manufacture tooling to your specifications for sizes not listed in this schedule. We count among our many custom tooling customers leaders in metal fabrication in the automotive, aerospace and manufacturing industries.

Call for details. 800-558-7808.



Tool Packages

Many of our operator customers have a narrower need than a comprehensive die package, but still appreciate a deal on multiple tool sets. We have combined the tools that go together for some of the industry's most important applications into affordable and convenient tool packages to make life easier and more profitable for you!



074 Die Package - Use with 1674 Expander Only			1988 3" End Finishing Package		1992 3" Tooling Package		1995 2 3/4" Tooling Package		1996 3" Short Tooling Package		1997 2 3/4" Short Tooling Package	
No.	Type	Size	No.	Product Description	No.	Product Description	No.	Product Description	No.	Product Description	No.	Product Description
574*	Arbor	2 7/8" to 6"	892	Collet Holder - 3"	5530	Radius Die - 3"	5534	5" Radius Die - 2 3/4"	5530	5" Radius Die - 3"	5534	5" Radius Die - 2 3/4"
572	Arbor	1 3/8" to 1 3/4" (Solid Piece)	1730	Collet - 3"	1350	Back Shoe (2) - 3"	1234	Back Shoe (2) - 2 3/4"	1350	Back Shoe (2) - 3"	1234	Back Shoe (2) - 2 3/4"
573	Arbor	1 3/4" to 4" (Solid Piece)	130	Swage Die - 3"	1351	Three-Quarter Shoe - 3"	1235	Three-Quarter Shoe - 2 3/4"	855	Die Pins (4)	855	Die Pins (4)
472	Segment	1 1/2" to 1 3/4" (Solid Surface)	783	Reducer (3" to 2 1/2")	1352	Half Shoe - 3"	1236	Half Shoe - 2 3/4"	Choice of one of the following:		Choice of one of the following:	
474	Segment	1 3/4" to 2 1/8"	853	Flaring / Flanging Tool (1 1/2" to 3 1/2")	855	Die Pins (6)	855	Die Pins (6)	1351	Three-Quarter Shoe with Pin	1235	Three-Quarter Shoe with Pin
475	Segment	2 1/8" to 2 1/2"			892	Collet Holder - 3"	1729*	Collet - 2 3/4"	1352	Half Shoe with Pin	1236	Half Shoe with Pin
476	Segment	2 1/2" to 3"			1730	Collet	790	Reducer (3" to 2 3/4")	476 *	Segment Set (2 1/2" ID to 3" ID)	476 *	Segment Set (2 1/2" ID to 3" ID)
481	Segment	2 7/8" to 3 1/2"			853	Flaring/Flanging Tool 1 1/2" to 3 1/2"	129	Swage Die - 2 3/4"	*Requires Arbor 508 and Arbor Tip 499 (or) Arbor 573		*Requires Arbor 508 and Arbor Tip 499 (or) Arbor 573	
482	Segment	3 3/8" to 4"			783	Reducer (3" to 2 1/2")	*Requires 892 Collet Holder					
483	Segment	3 7/8" to 4 1/2"			130	Swage Die - 3"						
484	Segment	4 3/8" to 5"			476*	Segment Set (2 1/2" ID to 3" ID)						
485	Segment	4 7/8" to 5 1/2"			*Requires Arbor 508 and Arbor Tip 499 (or) Arbor 573							
486	Segment	5 3/8" to 6"										
O'Rings	O'Rings	Assorted										

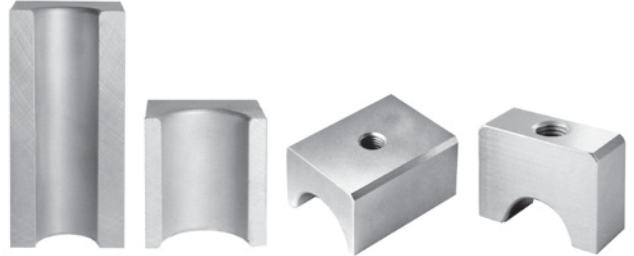
* All sizes are ID



HUTH TOOLING: BENDING DIES AND BACK SHOES

Bending Dies and Back Shoes

All Huth tooling is machined to specific tolerances from solid steel. After it is machined, it is gas-carburized and oil quenched to a minimum hardness of 58 Rockwell "C" scale. We do not use cast iron for any of our tooling. All Huth tooling is available from shelf stock. However, Huth will manufacture custom tooling to your specification for sizes not listed in this schedule.



Full Radius Dies		
	Full 5"	Full 4"
Size	No.	No.
1 1/2"	5812	
1 5/8"		4858
1 3/4"	5834	4834
1 7/8"	5878	
2"	5820	4820
2 1/4" **	5824	
2 1/2" **	5825	
	**4" Thick	

Regular Radius Dies			
	5"	4"	3"
SIZE	No.	No.	No.
1/2"		4012	3012
5/8"		4058	3058
3/4"	5034	4034	3034
0.840"			3084
7/8"		4078	3078
0.922"		4092	3092
1"	5100	4100	3100
1.050"	5105	4105	3105
1 1/8"	5118	4118	3118
1.163"	5116	4116	3116
1 1/4"	5114	4114	3114
1 5/16"	5056	4056	3056
1 3/8"	5138	4138	3138
1 1/2"	5112	4112	3112
1 5/8"	5158	4158	3158
1 3/4"	5134	4134	3134
1 7/8"	5178	4178	3178
2"	5200	4200	3200
2 1/8"***	5218	4218	3218
2 1/4"***	5414	4414	3414
2 3/8"***	5438	4438	3438
2 1/2"***	5412	4409	
3"***	5530		
	**4" Thick	**4" Thick	**4" Thick

Back Shoes (Full, Half, 3/4, 1/4)				
	Back Shoes	Half Shoes	Three-Quarter Shoes	Quarter Shoes
	(2 required)	(1 Required)	(1 Required)	(1 Required)
	*(2) 855 Pins Required Each	*(1) 855 Pin Required	*(1) 855 Pin Required	*(1) 855 Pin Required
SIZE*	No.	No.	No.	No.
1/2"	1012	1027		
5/8"	1058	1029		
3/4"	1034	1035		
0.840"	1840	1085		
7/8"	1078	1031		
0.922"	1092	1002		
1"	1100	1037		
1.050"	1105	1005		
1 1/8"	1118	1033		
1.163"	1116	1016		
1 1/4"	1114	1039		1084
1 5/16"	1256	1356		
1 3/8"	1138	1041		1083
1 1/2"	1112	1038		1082
1 5/8"	1158	1042		1081
1 3/4"	1134	1040	1036	
1 7/8"	1178	1043	1044	
2"	1200	1045	1046	
2 1/8"***	1218	1051	1053	
2 1/4"***	4211	4416	4413	
2 3/8" **	4237	4437		
2 1/2"***	4412	4410	4415	
2 3/4"***	1234	1236	1235	
2 7/8"***	1378	1379		
3"***	1350	1352	1351	
	**4" Thick	** 4" Thick	** 4" Thick	

Need metric tooling?
We have it!

Vintage tooling available!

If you don't see it here,
Call us at 800-558-7808!



HUTH TOOLING: SPECIALTY BENDING AND SWAGE TOOLING

Specialty Bending Dies and Back Shoes: For thousands of applications.

Controlled wrinkle dies for hard to bend metals like stainless steel, square dies to bend tough square tubing, and dies to bend flat stock ... Huth has the power, the tools and the know-how for what the fabricator needs to bend!

Controlled Wrinkle Dies



No.	DESCRIPTION	MODEL	No.	BACKSHOE SIZE (2 required)
3112W	3" RADIUS DIE, 1 1/2"	ALL	1112	1 1/2" **
4112W	4" RADIUS DIE, 1 1/2"	ALL	1112	1 1/2" **
5112W	5" RADIUS DIE, 1 1/2"	ALL	1112	1 1/2" **
5158W	5" RADIUS DIE, 1 5/8"	ALL	1158	1 5/8" **
3134W	3" RADIUS DIE, 1 3/4"	ALL	1134	1 3/4" **
4134W	4" RADIUS DIE, 1 3/4"	ALL	1134	1 3/4" **
5134W	5" RADIUS DIE, 1 3/4"	ALL	1134	1 3/4" **
3200W	3" RADIUS DIE, 2"	ALL	1200	2" **
4200W	4" RADIUS DIE, 2"	ALL	1200	2" **
5200W	5" RADIUS DIE, 2"	ALL	1200	2" **
4414W	4" RADIUS DIE, 2 1/4"	ALL	4211	2 1/4" **
5414W	5" RADIUS DIE, 2 1/4"	ALL	4211	2 1/4" **
4409W	4" RADIUS DIE, 1 1/2"	ALL	4412	2 1/2" **
5412W	5" RADIUS DIE, 2 1/2"	ALL	4412	2 1/2" **
5534W	5" RADIUS DIE, 2 3/4"	ALL	1234	2 3/4" **
5578W	5" RADIUS DIE, 2 7/8"	ALL	1378	2 7/8" **
5530W	5" RADIUS DIE, 3"	ALL	1350	3" **
5531*	5" RADIUS DIE, 3"	2600	1350*	3" **

Square Dies



No.	Radius	SIZE	No.	BACKSHOE SIZE (2 Required)
3334	3"	3/4"	1000	3/4" to 1 1/2" *
4334	4"	3/4"	1000	3/4" to 1 1/2" *
3310	3"	1"	1000	3/4" to 1 1/2" *
4310	4"	1"	1000	3/4" to 1 1/2" *
4314	4"	1 1/4"	1000	3/4" to 1 1/2" *
5314	5"	1 1/4"	1000	3/4" to 1 1/2" *
5312	5"	1 1/2"	1000	3/4" to 1 1/2" *
5320	5"	2"	1020	2" *
5325	5"	2 1/4"	1025	2 1/4" *
5350	5"	2 1/2"	1054	2 1/2" *
5330*	5"	3" - 14 Ga	1030*	3" *

Flat Stock Bending Dies



No.	Radius	SIZE	No.	BACKSHOE SIZE
3303	3 1/2"	Variable*	1003	Flat Stock Back Shoe (2 Req.)*
**(4) #855 Pins Required				

Rectangular 2" x 3"

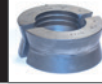
No.	Backshoe (2 req)	No.	Bending Die
1021	2" by 3" Easy way	5320	5" radius, 2" dia.
1022	2" by 3" Hard way	5322	5" radius, 3" dia.

Need to bend other sizes? Call 800-558-7808

End Finishing Swager Tooling

Clamp collets for a sure grip, swage dies to re-shape and expand tube ends, dies to reduce pipe for a handy slip-fit, and ball joint tools that can also flare or dome tube ends ... Huth tooling gives you the end finishing versatility you need.

Clamp Collets



No.	Size
1775	3/4" EMT
1709	1" EMT
1710	1"
1718	1 1/8"
1714	1 1/4"
1756	1 5/16"
1738	1 3/8"
1712	1 1/2"
1758	1 5/8"
1734	1 3/4"
1778	1 7/8"
1720	2"
1720DF	2" Double Flare (Use with Part #518)
1728	2 1/8"
1725	2 1/4"
1723	2 3/8"
1750	2 1/2"
1729	2 3/4" *
1731	2 7/8" *
1730	3" *

*Requires 892 Collet Holder

Swage Dies



No.	Size
110	1"
118	1 1/8"
114	1 1/4"
138	1 3/8"
112	1 1/2"
158	1 5/8"
134	1 3/4"
178	1 7/8"
120	2"
128	2 1/8"
125	2 1/4"
123	2 3/8"
150	2 1/2"
129	2 3/4"

Header Collector Tool



No.	Size
101	3"
102	3 1/2"

Reducing Dies*



*Require Collet holder 890, 891, or 892.

No.	Size
775	3/4" EMT
779	1" EMT
780	2" to 1 3/4"
781	2 1/4" to 2"
782	2 1/2" to 2 1/4"
783	3" to 2 1/2"
784	2" to 1 7/8"
785	1 3/4" to 1 5/8"
786	1 5/8" to 1 1/2"
787	1 1/2" to 1 3/8"
788	1 3/8" to 1 1/4"
789	1 1/4" to 1 1/8"

Flaring/Flanging Tools



No.	Size
518	Flare Tool - 2" Double Flare and 1 1/2" Flat Flare*
519	Flare Tool - 1 3/4" and 1 5/8" Double Flat Flare*
853	Pipe Flanger 1 1/2" to 3" - (Replaces Pipe Flangers 848, 849, 850, 851)

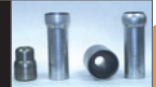
*NOT SHOWN

Ball Joint Tools - Female



No.	Size
555	1 3/4", 1 7/8", 2" (Female)
556	2 1/4" to 2 1/2" (Female)
564	2 3/4" to 3" (Female)

Ball Joint Tools - Male



No.	Size
550	1 3/4" (Male)
551	1 7/8" (Male)
552	2" (Male)
553	2 1/4" (Male)
554	2 1/2" (Male)
557	1 3/4" to 2 1/2" (Domer)
558	2 5/8" to 2 3/4" (Domer)

**Need Metric tooling?
We have it!
Call 800-558-7808
for details**



HUTH TOOLING: END FINISHING EXPANDER TOOLING



End Finishing Expander tooling creates the end finishes you need quickly.

All Huth tooling is machined to specific tolerances from solid steel. After it is machined, it is gas-carburized and oil quenched to a minimum hardness of 58 Rockwell "C" scale. We do not use cast iron for any of our tooling. All Huth tooling is available from shelf stock. However, Huth will manufacture custom tooling to your specification for sizes not listed in this schedule.

Arbors and Tips



Arbors	
No.	Description
572	Arbor, 1 ³ / ₈ " ID - 1 ³ / ₄ " ID, Solid Piece, (Same as #508 and #498 Combination)
573	Arbor, 1 ³ / ₄ " ID - 4" ID, Solid Piece, (Same as #508 and #499 Combination)
503	Arbor 2 ³ / ₄ " ID - 5 ¹ / ₂ " ID
574	Arbor 2 ⁷ / ₈ " ID - 6" ID (H1674 Model)

Arbors	
No.	Description
495	Arbor 1 ¹ / ₄ " - 1 ¹ / ₂ " (1680/1685 Models Only)
496	Small Arbor 1 ⁵ / ₁₆ " - 1 ¹ / ₄ " (1680 /1685 Models Only)
497	Small Arbor 1 ¹ / ₄ " - 4" (Requires 498 and 499 Tips) (1680/1685 Models Only)

Arbors and Tips	
No.	Description
575 / 570	Arbor 1 ⁵ / ₁₆ " - 1 ¹ / ₄ " ID with Spacer 570
508	Arbor 1 ³ / ₈ " ID - 4" ID
498	Small Arbor Tip - 1 ³ / ₈ " ID to 1 ³ / ₄ " ID
499	Large Arbor Tip - 1 ³ / ₄ " ID to 4" ID

Expanding Segment Tooling

Segments			
No.	Descrip.*	Finger No.	Comments
470	1 ⁵ / ₁₆ " - 1 ³ / ₃₂ "	670	Used with 575 with 570 Spacer or 496 Arbor
404	1 ³ / ₃₂ " - 1 ¹ / ₄ "	604	
400	1 ³ / ₁₆ " - 1 ¹ / ₂ "	600	Used with 500 or 495 Arbor
472	1 ³ / ₈ " - 1 ³ / ₄ "	672	Used with 572 Arbor or 508 Arbor+ 498 Tip
473	1 ³ / ₈ " - 1 ³ / ₄ "	673	
474	1 ³ / ₄ " - 2 ¹ / ₈ "	674	Used with 573 Arbor or 508 Arbor + 499 Tip
475	2 ¹ / ₈ " - 2 ¹ / ₂ "	675	Used with 573 Arbor or 508 Arbor + 499 Tip
476	2 ¹ / ₂ " - 3"	676	
477	3" - 3 ¹ / ₂ "	677	Used with 503 Arbor Requires 512 or 523 Adj Collar
478	3 ¹ / ₂ " - 4"	678	
403	2 ³ / ₄ " - 3 ¹ / ₈ "	603	Used with 503 Arbor Requires 512 or 523 Adj Collar
406	3 ¹ / ₈ " - 3 ¹ / ₂ "	606	
408	3 ¹ / ₂ " - 4"	608	Used with 503 Arbor Requires 512 or 523 Adj Collar
450	4" - 4 ⁷ / ₈ "	650	
451	4 ⁷ / ₈ " - 5 ¹ / ₂ "	651	Used with 503 Arbor Requires 512 or 523 Adj Collar

*All Sizes are IDs

1674 Segments			
No.	Descrip.*	Finger No.	Comments
481	2 ⁷ / ₈ " - 3 ¹ / ₂ "	681	Used with 574 Arbor (1674 Model Only)
482	3 ³ / ₈ " - 4"	682	
483	3 ⁷ / ₈ " - 4 ¹ / ₂ "	683	
484	4 ³ / ₈ " - 5"	684	
485	4 ⁷ / ₈ " - 5 ¹ / ₂ "	685	
486	5 ³ / ₈ " - 6"	686	
Flaring Segments			
No.	Descrip.*	Finger No.	Comments
405	1 ¹ / ₈ " - 1 ¹ / ₂ "	605	Used with 575 Arbor with 570 Spacer
440	1 ¹ / ₂ " - 2 ¹ / ₂ "	640	Used with 573 Arbor or 508 Arbor + 499 Tip

Ball Joint Segments			
No.	Descrip.*	Finger No.	Comments
410	1 ³ / ₄ " - 1 ⁷ / ₈ "	610	Used with 573 Arbor or 508 Arbor + 499 Tip
419	2"	619	
420	2 ¹ / ₄ "	620	
421	2 ¹ / ₂ "	621	
452	3"	652	
453	3 ¹ / ₂ "	653	
*Note: Original Tube Sizes			
V-Band Segment Set Tooling			
No.	Descrip.*	Finger No.	Comments
435	2"	635	Used with 573 Arbor or 508 Arbor + 499 Tip
436	2 ¹ / ₄ "	636	
437	2 ¹ / ₂ "	637	
438	2 ³ / ₄ "	638	
439	3"	639	

Bead Segments			
No.	Descrip.*	Finger No.	Comments
460	1 ¹ / ₄ "	660	Used with 575 Arbor and 570 Spacer
461	1 ¹ / ₂ "	661	Used with 500 Arbor
462	1 ³ / ₄ "	662	Used with 572 Arbor or 508 Arbor+ 498 Tip
463	2"	663	Used with 573 Arbor or 508 Arbor + 499 Tip
464	2 ¹ / ₄ "	664	
465	2 ¹ / ₂ "	665	
466	3"	666	
467	3 ¹ / ₂ "	667	
468	4"	668	
*Note: Original Tube Size			
Flanging Segments			
No.	Descrip.*	Finger No.	Comments
411	1 ³ / ₄ "	611	Used with 573 Arbor or 508+ 499 Tip - 413 or 414 Required
413	2"		Ring - Use with 411
414	2 ¹ / ₄ "		
412	2 ¹ / ₂ "	612	Used with 573 Arbor or 508 + 499 Tip - 418 Required
418	2 ¹ / ₂ "		Ring - Use with 412

Vintage tooling available!

We want you to have what you need!

We are a leader in custom tooling!
If you don't see it here, Call us at 800-558-7808!



EXPAND WITH HUTH!

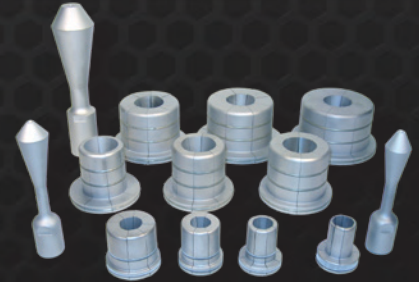


End finishing expanders and swagers help you raise your game

Swage or Expand Tubing anywhere with Huth's line of portable and workbench expanders.

Mounted on easy wheeling carts or compact stands, they help you form slip joints, flares and flat flares, ball joints, deep swage expansions and reductions.

- Flexible, creative, affordable tube connecting
- Easy to use! Huth's Accu-Sizer™ system for quick, precise expanding every time.
- Sturdy, well thought out, with built-in tool trays for easy access to tooling.
- 25,000 to 49,000 lbs of expanding power.



Model 1673: Portable Expander- Swager Expands and Reduces Pipe Diameter



Model 1674: Portable Expander with Two Powerful Cylinders



1673 Powerful Swager/Expander Features:

Swage box allows reductions up to 3 inch and solid tool expansions.

- A powerful 5 HP motor, single-phase (30 amp), or 3-phase (20 amp)
- Runs on 220 volt, 60 Hz supply. 50 Hz and other voltages available
- The 3½" cylinder produces 25,000 lbs. of expanding power
- Expanding capacity from 1" to 5½"
- Features Huth's Accu-Sizer™ automatic, preset expanding system for quick, precise expanding each and every time
- Adjustable Collar (41047) for expanding 1" to 3½"
- Collet Holder for 1" to 2½" O.D. tubing
- Swaging capacity from 1" to 3"
- "See-through" safety guards for increased protection during all operations
- Front swivel caster w/brake
- 15' power cord with male and female receptacles

The 1674 Dual Head Expander Features:

Now with the powerful 5" cylinder you can expand tubing from 3" up to, and larger than 6" diameter, 3" deep (5" deep tooling also available).

- Powerful 5 HP motor, single-phase (30 amp), or 3-phase (20 amp)
- Runs on 220 volt, 60 Hz supply. 50 Hz and other voltages available
- The 3½" cylinder produces 25,000 lbs. of expanding power and the 5" cylinder produces 49,000 lbs. of expanding power
- Expanding capacity from 1" to 6" and greater
- Features Huth's Accu-Sizer™ automatic, preset expanding system for quick, precise expanding each and every time
- Front swivel caster w/brake
- 15' power cord with male and female receptacles
- Includes 41047 Accu - Sizer adjustable collar for the 3-1/2" cylinder, and the 527 adjustable collar with the 528 collar extension for the 5" cylinder

Tooling sold separately



EXPAND WITH HUTH!

Bench-top and Portable Expanders quickly and easily size tube and pipe ends, anywhere! Auto stores, warehouses, fab shops and production settings.

1690 Bench Top Expander



- Compact design fits on your bench-top (12" x 20" x 24")
- 10 ft. power cord with male and female receptacles

1691 Portable Expander



- Compact 24" x 23" x 39" design on rugged cart for maximum portability
- 15 ft. power cord with male and female receptacles

1690 and 1691 Features

- Hands-free operation with foot pedal activation
- Create custom brackets with Rod Bracket Bender (Part 985)(optional)
- Standard expanding capacity from 1½" to 3½"
- Expanding capacity from 1" to 5½" with additional tooling
- Powerful 2 HP motor available in 110V, 30 Amp or 220V, 20 Amp. Motor runs on both 50Hz and 60Hz
- 25,000 lbs of expanding power
- Features Huth's Accu-Sizer™ automatic, preset expanding system for quick, precise expanding each and every time
- Built-in tool tray for easy access to tooling
- "See-through" safety guards for increased protection during all operations
- Includes: 572, 573 Arbors and 472, 474, 475, 476, 477 Segment Sets

1685S Mitey Mate Jr Expander... Now with 3" tooling included, gives you 17000 lbs of expanding force right in your hand. Now CE listed!



Small but powerful, the Mitey Mate Jr expander is ideal for making flares*, ball joints†, and slip connections wherever you need to work ... under a vehicle, in a work cell or on the bench.

- Set to operate at 3200 psi (shop air pressure between 80 and 120 psi maximum**)
- 1½" to 3" I.D. mufflers and pipes (3½"-4" capability with additional tooling)
- Comes with Huth's unique Accu-Sizer™ System for right-on expansions, job after job
- Expander weighs only 7 pounds
- All three pieces together weigh only 34 pounds
- Handy storage unit holds the expander, four segment sets and one of the two detachable arbor tips, is 9" high by 10½" square
- Power pedal is only 8" high, 10" long and 5" wide, and fits under the storage unit

*Requires use of No. 440 flaring segment

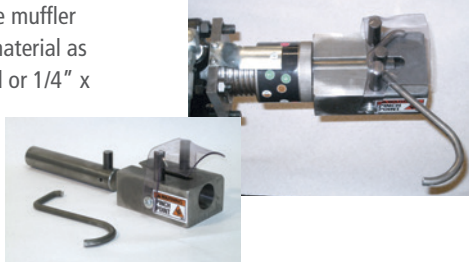
**Air regulator included in package

†Requires use of ball joint segment tools



Save Money! Bend your own Brackets. Rod Bracket Bender Part No. 985

You can quickly produce muffler hanger brackets from material as large as 1/2" dia. round or 1/4" x 1" flat.



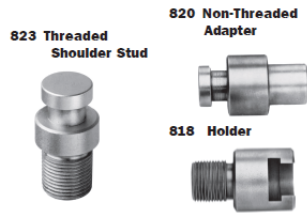
Ready Rak II™ Part No. 91176

Large rack ... Ideal for 3" tooling
25 1/4" x 5"
17 Slots
7 Trays (5" Deep)
Shown with 825 Quick Disconnect Tooling (Optional)



Changing End-Finishing Tools is Fast and Simple with Quick Disconnect Kit Part No. 825

The holder (Part Number 818) threads into the swager cylinder shaft of the bender, and the 10 threaded shoulder studs (Part Number 823) screw into your end-finishing tools. Non-threaded adapter (Part Number 820) works with all non-threaded tooling.



Grommet Grabber Part No. 987

is designed to remove hanger brackets from their rubber mounting grommets with a squeeze of the handles



Exhaust Pipe Shapers

Repairs dented and damaged pipe ends or muffler inlets and outlets. Heat treated for durability.

For use on pipe up to 3" dia. part number 984.

For 2" to 5" dia. pipe part number 982.



Muffler Stand Part No. 986

Safely supports exhaust components during installation, the Exhaust Support Stand measures 47" and extends to 79". The unit has an oversized support tray and rotates 360°. The spring loaded, quick-release extension mechanism is also self-locking.

Part No. 986.
(70 lb. Maximum Capacity)



A-Train Part No. 6006

Keeps tools at eye level for easy access, the A-Train has 8 large shelves (4 on each side) and can hold everything from radius dies to ball joint tools.

52" high, 38" long and 36" wide at the base. Made from heavy-duty angle iron, also has industrial strength swivel casters.



Header Flange Tooling

Huth now has arbors and segment sets to form shapes and sizes to match manifold flanges for your header construction. We have several sizes in stock and can custom build to your needs. This tooling will fit any of the Huth benders or expanders.



- H594 Arbor, Flange 1" x 14 Thread (All Machines Except 1685)
- H494 Arbor, Flange, 1685
- H360 Segment, Flange Header 1-3/4 x .049, 4-V
- H361 Segment, Flange Header 1-3/4 x .049, 5.7
- H362 Segment, Flange Header 1-7/8 x .049, C-7
- H363 Segment, Flange Header 1-7/8 x .049, 6.1



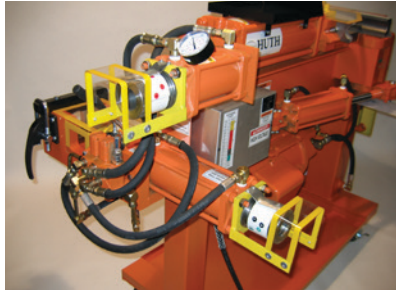
MORE ACCESSORIES AND ADD ONS

Double the expanding set-up of your Bender! Expander Option Kit Part No. 92222/92225

The 2nd cylinder allows two different expanding systems always available and ready to use, reducing changeover time.

Kit 92222 allows for addition of expanding from 1" to 5 1/2" by 2" deep. Or choose to install the Rod Bracket Bender (#H985) on the new cylinder and create hangers and brackets in seconds.

Kit 92225 allows for expanding from 3" to 5" by 3" deep. Arbor 574 included.



More Accurate End-Finishing with Huth's Accu-Sizer™. Now with metric and imperial measurements! Part No. 1986 (3" Swager Cylinders) or Part No. 1990 (3 1/2" Swager Cylinders)

Huth's Accu-Sizer™ preset expanding system, standard on all new Huth Benders, is available as a retrofit kit for benders built before August of 1988, which have a 3" swager cylinder.

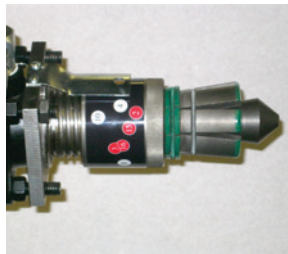
Accu-Sizer features:

- Accurate bull's-eye adjustments for precise expansions time after time

Consists of:

- | No. | Description |
|-------------|-------------------|
| 572 Arbor | 1 1/2" to 1 3/4" |
| 573 Arbor | 1 3/4" to 3 1/2" |
| 472 Segment | 1 1/2" to 1 3/4" |
| 474 Segment | 1 3/4" to 2 1/8" |
| 475 Segment | 2 1/8" to 2 1/2" |
| 513 | Snap Ring Nut |
| 514 | Snap Ring |
| 515 | Set Screw |
| 522 | Adjustable Collar |
| 595 | Gun Sight |
| 98042 | Sizing Decal |
| 98043 | Calibration Decal |
| 97240 | Machine Screw (2) |

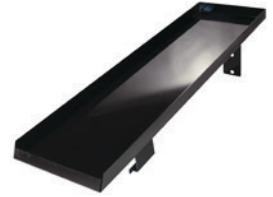
Installation, calibration instructions.
Model 1986 - for 3" Swager Cylinders
Model 1990 - for 3 1/2" Swager Cylinders



Bring Huth Quality Tooling to Your "Other Brand" Bender. Now all Huth tooling (except collets) is adaptable to other brand benders. All Huth arbors, segments and swage tooling will attach to the 1" 14-thread shaft without modification. Huth back shoes and dies also mount on the swing gates without modification. **Call 800-558-7808 for instructions and adapters for mounting Huth bending dies to the other brand sleds.**

Top Tray Part No. 81013

Easy to snap-on, this tray helps you organize your tooling where it is easy to access, on top of your bender!



Tube Cutter #30 for 3" Part No. 835

Simple, easy to use tube cutter cuts any tube up to 3" diameter



Rotation Dial

Part No. 996 Clockwise

Part No. 976cc Counter-clockwise



O Ring Kits 870 (Rubber) and 859 (Steel)



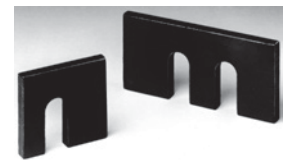
(10 ea, 50 total pieces)



(5 ea, 25 total pieces)

Tough, Close Bends Faster, Easier And Better

Simple, slip-in spacers nearly duplicate the action of the cutout gates by moving the back shoes and the pipe farther from the gates during bending operations.



1080 Half Shoe on Left,
1079 Full Shoe on Right

Space Makers help you contend with that second close bend with ease and without any die interference (provided bending radius does not exceed 4"). You can use these spacers with a half shoe and a full shoe in any tube diameter. Plus, you can substitute a three-quarter shoe for the half-shoe.

Huth Bender Training DVD

Designed to reduce training time for new technicians, this 42-minute bender training DVD includes clear visual instruction to reduce mistakes. Order Part Number 97305.



Huth's Program Cards

More than 7,500 strong...Huth's program cards enable even the beginning installer to start with a stick of tubing and end up with an OE-fit pipe. Model A through 2001.



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