

RECOMMENDED MINIMUM BEND RADII FOR 90-DEGREE COLD FORMING OF SHEET

The radii listed are the minimum recommended for bending sheets and plates without fracturing in a standard press brake with air bend dies. Other types of bending operations may require larger radii or permit smaller radii. The minimum permissible radii will also vary with the design and condition of the tooling.

ALLOY	TEMPER	RADII FOR VARIOUS THICKNESS EXPRESSED IN TERMS OF THICKNESS "t"			
		1/64 in.	1/32 in.	1/16 in.	1/8 in.
1100	O	0	0	0	0
	H12	0	0	0	1/2t
	H14	0	0	0	1t
	H16	0	1/2t	1t	1 1/2t
	H18	1t	1t	1 1/2t	2 1/2t
2024	O	0	0	0	1/2t
	T3	2 1/2t	3t	4t	5t
	T361	3t	4t	5t	6t
	T4	2 1/2t	3t	4t	5t
	T81	4 1/2t	5 1/2t	6t	7 1/2t
	T861	5t	6t	7t	8 1/2t
	3003	O	0	0	0
	H12	0	0	0	1/2t
	H14	0	0	0	1t
	H16	1/2t	1t	1t	1 1/2t
	H18	1t	1 1/2t	2t	2 1/2t
3004	O	0	0	0	1/2t
	H32	0	0	1/2t	1t
	H34	0	1t	1t	1 1/2t
	H36	1t	1t	1 1/2t	2 1/2t
	H38	1t	1 1/2t	2 1/2t	3t
3005	O	0	0	0	0
	H12	0	0	0	1/2t
	H14	0	1/2t	1/2t	1 1/2t
	H16	1/2t	1t	1t	2t
	H18	1t	1 1/2t	2t	2 1/2t

ALLOY	TEMPER	RADII FOR VARIOUS THICKNESS EXPRESSED IN TERMS OF THICKNESS "t"			
		1/64 in.	1/32 in.	1/16 in.	1/8 in.
5005	O	0	0	0	0
	H12	0	0	0	1/2t
	H14	0	0	0	1t
	H16	1/2t	1t	1t	1 1/2t
	H18	1t	1 1/2t	2t	2 1/2t
	H32	0	0	0	1/2t
	H34	0	0	0	1t
	H36	1/2t	1t	1t	1 1/2t
	H38	1t	1 1/2t	2t	2 1/2t
5050	O	0	0	0	1/2t
	H32	0	0	0	1t
	H34	0	0	1t	1 1/2t
	H36	1t	1t	1 1/2t	2t
	H38	1t	1 1/2t	2 1/2t	3t
5052	O	0	0	0	1/2t
	H32	0	0	1t	1 1/2t
	H34	0	1t	1 1/2t	2t
	H36	1t	1t	1 1/2t	2 1/2t
	H38	1t	1 1/2t	2 1/2t	3t
5657	H25	0	0	0	1t
	H27	1t	1 1/2t	2 1/2t	3t
6061	O	0	0	0	1t
	T4	0	0	1t	1 1/2t
	T6	1t	1t	1 1/2t	2 1/2t
7075	O	0	0t	1t	1t
	T6	3t	4t	5t	6t