



Aluminum Sheet Bending Coefficient Table

| Aluminum Sheet Thickness(mm) | Bending Angle(°) | Bending Coefficient(mm) |
|------------------------------|-------------------|-------------------------|
| 0.8mm | 90 | 1.5 |
| 1.0mm | 90 | 1.5 |
| | 45、 135 | 0.5 |
| 1.2mm | 90 | 2.0 |
| | 45、 135 | 0.5 |
| 1.5mm | 90 | 2.5 |
| | 45、 135 | 0.5 |
| | 60、 120 | 1.5 |
| 2.0mm | 90 | 3.0 |
| | 45、 135 | 1.0 |
| | 60、 120 | 2.5 |
| | 90° Grooving | 1.5 |
| 2.5mm | 90 | 4.0 |
| | 45、 135 | 1.5 |
| | 60、 120 | 3.0 |
| | 90° Grooving | 2.0 |
| 3.0mm | 90 | 5.0 |



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|--|--------------|-----|
| | 45、 135 | 3.0 |
| | 60、 120 | 4.5 |
| | 90° Grooving | 2.5 |

Notes: There are many calculation methods for bending coefficient; there are the K factor method, Y factor method, plate thickness deduction method, etc. The most common one we use is the bending deduction method. That is expanded size = length of straight side A + length of straight side B – bending coefficient. These formulas are commonly used in our production and cutting! For example: an ordinary aluminum veneer with a length and width of 1000mm and 90-degree folding edges of 20mm on all sides. Many people think that the cutting size is 1040*1040mm but the actual cutting size is 1034*1034mm because of the 90-degree bending of 2.0 and the non-grooving bending coefficient. It is 3.0mm. The length and width of the four-sided supported plate are bent with 2 knives each. The cutting size should be minus 6mm from the length and width.

Read More: [Minimum Recommended Bend Radius Chart of Aluminum and Steel Profiles](#)

Aluminum Bending Process: One of aluminum' s most remarkable attributes is its formability, and one of the primary methods for shaping this metal to your desired configuration is through bending. During the aluminum bending process, mechanical force is employed to transform the material into various shapes. However, it' s important to note that not all aluminum alloys and temper conditions are equally suited for bending.