



Approximate Minimum Radii For 90-Degree Cold Bend Of Aluminum Alloys

APPROXIMATE MINIMUM RADII FOR 90° COLD BEND

Where range is shown, use smaller radius with extreme caution.

ALLOY	TEMPER	RADII For Various Thicknesses Expresses in Terms of Thickness "t"							
		1/64 Inch	1/32 Inch	1/16 Inch	1/8 Inch	3/16 Inch	1/4 Inch	3/8 Inch	1/2 Inch
1100	-O	O	O	O	O	O	O	O	1t-2t
	-H12	O	O	O	O	O-1t	O-1t	O-1t	1t-3t
	-H14	O	O	O	O	O-1t	O-1t	O-1t	2t-3t
	-H16	O	O	O-1t	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2-1/2t-3-1/2t	3t-4t
	-H18	O-1t	1/2-1-1/2t	1t-2t	1-1/2t-3t	2t-4t	2t-4t	3t-5t	3t-6t
Alclad 2014	-O	O	O	O	O	O-1t	O-1t	1-1/2t-3t	3t-5t
	-T3	1t-2t	1-1/2t-3t	2t-4t	3t-5t	4t-6t	4t-6t	5t-7t	5-1/2t-8t
	-T4	1t-2t	1-1/2t-3t	2t-4t	3t-5t	4t-6t	4t-6t	5t-7t	5-1/2t-8t
	-T6	2t-4t	3t-5t	3t-5t	4t-6t	5t-7t	6t-10t	7t-10t	8t-11t
2024	-O ²	O	O	O	O	O-1t	O-1t	1-1/2t-3t	3t-5t
	-T3 ²³	1-1/2t-3t	2t-4t	3t-5t	4t-6t	4t-6t	5t-7t	6t-8t	6t-9t
	-36 ²	2t-4t	3t-5t	4t-6t	5t-7t	5t-7t	6t-10t	7t-10t	8t-11t
	-T42	1-1/2t-3t	2t-4t	3t-5t	4t-6t	4t-6t	5t-7t	6t-8t	6t-9t
	-T81	3-1/2t-5t	4-1/2t-6t	5t-7t	6-1/2t-8t	7t-9t	8t-10t	9t-11t	9t-12t
	-T86	4t-5-1/2t	5t-7t	6t-8t	7t-10t	8t-11t	10t-13t	10t-13t	1t-2t
3003	-O	O	O	O	O	O	O	O	1t-2t
	-H12	O	O	O	O	O-1t	O-1t	O-1t	1t-3t
	-H14	O	O	O	O-1t	O-1t	1/2t-1-1/2t	1t-2-1/2t	1-1/2t-3t
	-H16	O-1t	01t	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2t-4t	1-1/2t-4t	3t-5t
	-H18	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2t-4t	3t-5t	4t-6t	4t-7t	5t-8t
5052	-O	O	O	O	O	O-1t	O-1t	1/2t-1-1/2t	1t-2t
	-H32	O	O	O	O-1t	O-1t	1/2t-1-1/2t	1t-2t	1-1/2t-2-1/2t
	-H34	O	O	O-1t	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2t-3t	2-1/2t-3-1/2t
	-H36	O-1t	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2t-4t	2t-4t	2-1/2t-5t	3t-5-1/2t
	-H38	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2t-4t	3t-5t	4t-6t	4t-7t	5t-8t
6061 7075	-O	O	O	O	O	O-1t	O-1t	1/2t-2t	1t-1-1/2t
	-T4 ²	O-1t	O-1t	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2t-4t	2-1/2t-4t	3t-5t
	-T6 ²	O-1t	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2t-4t	3t-4t	3-1/2t-5-1/2t	4t-6t
	-O	O	O	O-1t	1/2t-1-1/2t	1t-2t	1-1/2t-3t	2-1/2t-4t	3t-5t
	-T6 ²	2t-4t	3t-5t	4t-6t	5t-7t	5t-7t	6t-10t	7t-11t	7t-12t

- Minimum permissible radius over which sheet or plate may be bent varies with nature of forming operation. type of forming equipment, and design and condition of tools. Minimum working radius for a given material or hardest alloy and temper fold a given radius can be ascertained only by actual trial under contemplated conditions of fabrication. Where range is shown, use a smaller radius with extreme caution
- Alclad sheet can be bent over slightly smaller radii than the corresponding tempers of the uncoated alloy.
- Immediately after quenching, this alloy can be formed over appreciable smaller radii.

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.