SUGGESTED MINIMUM BEND RADIUS - LONGITUDINAL BENDS

Grade		Thickness in.	Up to 1/4	Over 1/4 to 1/2	Over 1/2 to 1	Over 1 to 1-5/8	Over 1-5/8 to 2
Imperial	**Metric**	**Thickness mm**	**Up to 6**	**Over 6 to 12**	**Over 12 to 25**	**Over 25 to 40**	**Over 40 to 50**
38W	260W		1-1/2t	1-1/2t	2t	3t	-
44W	300W		1-1/2t	2t	3t	4t	-
50W	350W		2-1/2t	2-1/2t	4t	-	-
QT100			3-1/2t	3-1/2t	6t	-	-
AR400			5t	5t	-	-	-
Hardox 400			5t	5t	-	-	-

t= thickness in in. or mm

* Hot forming is recommended for all thicknesses not showing a value.
* Since temperature can be a major cause of bend failure, in no case should bending be carried out at a metal temperature below 60˚F (15˚C)
* Material of 50 ksi 350 Mpa and higher yield strength will require bending greater bending and hold-down force than lower strength steels and provisions must be made for a greater than usual degree of springback.
* The cold bending of structural shapes is a most difficult task and the steel producer should be consulted before cold bending of any degree of severity carried out.