



306-244-1133
220 Ave J S, Saskatoon, SK

Longitudinal Bends

Suggested Minimal Bend Radius

Grade		Thickness in.	Up to $\frac{1}{4}$	Over $\frac{1}{4}$ to $\frac{1}{2}$	Over $\frac{1}{2}$ to 1	Over 1 to $1\frac{5}{8}$	Over $1\frac{5}{8}$ 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 $\frac{1}{2}$ t	1 $\frac{1}{2}$ t	2t	3t	-	
44W	300W		1 $\frac{1}{2}$ t	2t	3t	4t	-	
50W	350W		2 $\frac{1}{2}$ t	2 $\frac{1}{2}$ t	4t	-	-	
QT100			3 $\frac{1}{2}$ t	3 $\frac{1}{2}$ t	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.