preferred recommended 90 degree bend radii for various sheet metals.

ALUMINUM Where necessary 5052-H32 may be bent to 1T and 6061-T6 to 1-1/2T						STEEL (American Iron and Steel Institute) 1) See AISI's " Fabrication guidlines for cold bending"			
THK	**6061-T6**	**5052-H32**	**5052-H34 6061-T4 2024-0**	**3003-0 1100-0 6061-S0 5052-S0**	**2024-T3**	**1020 1025 4130 ANN**	**4130 NORM**	**18-8 TYPE 304**	**18-8 TYPE 302**
.020	.063	.063	.063	.063	.063	.063	.063	.063	.063
.025	.094	.063	.063	.031	.094	.063	.063	.063	.063
.028	.094	.063	.063	.031	.094	.063	.063	.063	.094
.032	.094	.063	.063	.031	.125	.063	.094	.063	.094
.040	.125	.063	.094	.063	.188	.094	.125	.094	.125
.050	.156	.094	.094	.063	.188	.094	.156	.094	.125
.063	.188	.094	.125	.063	.250	.094	.188	.125	.188
.074	.250	.125	.156	.094	.281	.125	.250	.156	.250
.080	.281	.125	.156	.094	.344	.125	.250	.156	.250
.090	.312	.156	.188	.094	.375	.125	.281	.188	.250
.100	.375	.156	.188	.125	.438	.156	.312	.250	.281
.125	.500	.188	.250	.125	.562	.188	.375	NR	NR
.140	.562	.250	.281	.156	.625	.188	.438	NR	NR
.188	.625	.312	.375	.188	.875	.375	.500	NR	NR

1) Steels with lower carbon content are easier to weld and form. ASTM-A366 (.10 carbon content) may be bent back on itself in any direction without cracking. Typical applications: refrigerators, ranges, washing machines, auto and truck bodies, signs, panels, shelving, furniture, and stamped parts

Table 2

ALUMINUM

ALLOY	TEMPER	RADII EXPRESSED IN TERMS OF THICKNESS "T"							
		1/64	1/32	1/16	1/8	3/16	1/4	3/8	1/2
1100	0	0	0	0	0	1/2T	1T	1T	11/2T
	H12	0	0	0	1/2T	1T	1T	11/2T	2T
	H14	0	0	0	1T	1T	11/2T	2T	21/2T
	H16	0	1/2T	1T	11/2T	11/2T	21/2T	3T	4T
	H18	1T	1T	11/2T	21/2T	3T	31/2T	4T	41/2T
5052	0	0	0	0	1/2T	1T	1T	11/2T	11/2T
	H32	0	0	1T	11/2T	11/2T	11/2T	11/2T	2T
	H34	0	1T	11/2T	2T	2T	21/2T	21/2T	3T
	H36	1T	1T	11/2T	21/2T	3T	31/2T	4T	41/2T
	H38	1T	11/2T	21/2T	3T	4T	5T	51/2T	61/2T
6061	0	0	0	0	1T	1T	1T	11/2T	2T
	T4	0	0	1T	11/2T	21/2T	3T	31/2T	4T
	T6	1T	1T	11/2T	21/2T	3T	31/2T	41/2T	5T

This Table is an excerpt from the Aluminum Association Data Book. You can see a complete list of alloys, along with other very useful aluminum information by purchasing their book, "Aluminum Standards and Data".