

Table 3-1
RECOMMENDED MINIMUM BEND RADII FOR 90° COLD BENDS
OF SHEET AND PLATE ①②③④⑤ (Continued)

Alloy	Temper	RADII FOR VARIOUS THICKNESSES EXPRESSED IN TERMS OF THICKNESS "t"							
		1/64 in.	1/32 in.	1/16 in.	1/8 in.	3/16 in.	¼ in.	3/8 in.	½ in.
5252	H25	0	0	1t	2t
	H28	1t	1½t	2½t	3t
5254	O	0	0	½t	1t	1t	1t	1½t	1½t
	H32	0	½t	1t	1½t	1½t	2t	2½t	3½t
	H34	½t	1t	1½t	2t	2½t	3t	3½t	4t
	H36	1t	1½t	2t	3t	3½t	4t	4½t	5t
	H38	1½t	2½t	3t	4t	5t	5t	6½t	6½t
5454	O	0	½t	1t	1t	1t	1½t	1½t	2t
	H32	½t	½t	1t	2t	2t	2½t	3t	4t
	H34	½t	1t	1½t	2t	2½t	3t	3½t	4t
5456	O	1t	1t	1½t	1½t	2t	2t
	H321	2t	2t	2½t	3t	3½t
5457	O	0	0	0
5652	O	0	0	0	½t	1t	1t	1½t	1½t
	H32	0	0	1t	1½t	1½t	1½t	1½t	2t
	H34	0	1t	1½t	2t	2t	2½t	2½t	3t
	H36	1t	1t	1½t	2½t	3t	3½t	4t	4½t
	H38	1t	1½t	2½t	3t	4t	5t	5½t	6½t
5657	H25	0	0	0	1t
	H28	1t	1½t	2½t	3t
6061	O	0	0	0	1t	1t	1t	1½t	2t
	T4	0	0	1t	1½t	2½t	3t	3½t	4t
	T6	1t	1t	1½t	2½t	3t	3½t	4½t	5t
7050	T7	8t	9t	9½t
7072	O	0	0
	H14	0	0
	H18	1t	1t
7075	O	0	0	1t	1t	1½t	2½t	3½t	4t
	T6	3t	4t	5t	6t	6t	8t	9t	9½t
7178	O	0	0	1t	1½t	1½t	2½t	3½t	4t
	T6	3t	4t	5t	6t	6t	8t	9t	9½t

① The radii listed are the minimum recommended for bending sheets and plates without fracturing in a standard press brake with air bend dies. Other types of bending operations may require larger radii or permit smaller radii. The minimum permissible radii will also vary with the design and condition of the tooling.

② Alclad sheet in the heat-treatable alloys can be bent over slightly smaller radii than the corresponding tempers of the bare alloy.

③ Heat-treatable alloys can be formed over appreciably smaller radii immediately after solution heat treatment.

④ The H112 temper (applicable to non-heat treatable alloys) is supplied in the as-fabricated condition without special property control but usually can be formed over radii applicable to the H14 (or H34) temper or smaller.

⑤ The reference test method is ASTM E290.

⑥ Tempers T361 and T861 formerly designated T36 and T86, respectively.