

**STANDARD INSIDE BEND RADIUS FOR SHEET METAL**

GAGE	ALUMINUM					MAGNESIUM				STEEL							
	1100-0 3003-0 5052-0 6061-0	3003-H14 2024-0 5052-H34 6061-T4	7075-0 7178-0	2024-T3 2024-T4 6061-T6	7075-T6 7178-T6	QQ-M-44 (AZ31B)				18-8 CRES			17-7 Ph		1020 1025	4130 8630 ANLD	4130 8630 NORM
						ANNEALED		HARD		ANLD	QTR HARD	HALF HARD	COND A	COND THD			
						550°F	ROOM	325°F	ROOM								
.016	.03	.03	.03	.06	.09	.06	.09	.09	.19	.06	.06	.06	.03	.16	.06	.06	
.018	.03	.03	.03	.06	.12	.06	.09	.09	.19	.06	.06	.06	.03	.16	.06	.06	
.020	.03	.03	.03	.06	.12	.06	.09	.09	.19	.06	.06	.06	.03	.16	.06	.06	
.022	.03	.06	.06	.09	.12	.06	.12	.12	.22	.06	.06	.06	.03	.16	.06	.06	
.025	.03	.06	.06	.09	.12	.06	.16	.12	.25	.06	.06	.06	.03	.16	.06	.06	
.028	.03	.06	.06	.09	.16	.06	.16	.16	.28	.06	.06	.09	.03	.19	.06	.09	
.030										.06	.06	.09			.06	.09	
.032	.03	.06	.06	.12	.16	.06	.19	.16	.31	.06	.06	.09	.03	.25	.06	.09	
.035										.06	.09	.09	.03	.25		.09	
.036	.06	.06	.06	.16	.19	.09	.22	.19	.38	.06	.09	.12	.03	.31	.09	.12	
.038															.09	.12	
.040	.06	.06	.06	.16	.19	.09	.22	.19	.44	.06	.09	.12	.03	.31	.09	.12	
.042										.06	.09	.12	.03	.31		.16	
.045	.06	.09	.09	.19	.25	.09	.25	.25	.50	.06	.09	.12	.06	.38	.09	.16	
.050	.06	.09	.09	.19	.25	.09	.25	.25	.50	.06	.09	.12	.06	.38	.09	.16	
.051	.06	.09	.09	.19	.25	.09	.25	.25	.50								
.056	.06	.12	.12	.22	.28	.12	.28	.28	.56	.06	.12	.16	.06	.44	.09	.19	
.062										.06	.12	.19	.06	.50			
.063	.06	.12	.12	.22	.31	.16	.31	.31	.62	.06	.12	.19	.06	.50	.09	.19	
.064	.06	.12	.12	.22	.31	.16	.31	.31	.62								
.071	.09	.12	.12	.28	.38	.16	.38	.38	.81	.09	.16	.22	.09	.62	.09	.22	
.072	.09	.12	.12	.28	.34	.16	.38	.38	.81								
.078										.09	.16	.22	.09	.62	.12	.25	
.080	.09	.16	.19	.34	.44	.19	.44	.44	.81	.09	.16	.22	.09	.62	.12	.25	
.081	.09	.16	.19	.34	.38	.19	.44	.44	.81								
.083															.12	.25	
.090	.09	.19	.19	.38	.50	.19	.44	.44	1.00	.09	.19	.25	.16	.75	.12	.28	
.091	.09	.19	.19	.38	.50	.19	.44	.44	1.00								
.093										.09	.19	.25	.16	.75			
.094															.12	.28	
.100	.12	.22	.22	.44	.62	.25	.50	.50	1.00	.12	.22	.28	.22	.88	.16	.31	
.102	.12	.22	.22	.44	.62	.25	.50	.50	1.00								
.109										.12	.22	.31	.22		.16	.31	
.112	.12	.25	.28	.50	.75	.25	.56	.56	1.12	.12	.22	.31	.22		.16	.34	
.125	.12	.25	.28	.56	.88	.25	.62	.62	1.25				.25		.16	.38	
.140	.12	.34	.38	.62	1.00	.34	.69	.69	1.50				.28		.19	.38	
.156	.16	.38	.44	.75	1.12	.38	.75	.75	1.62				.31		.22	.44	
.160	.16	.38	.44	.75	1.12	.38	.75	.75	1.62				.31		.22	.44	
.180	.19	.44	.50	.88	1.25	.38	1.00	1.00	1.88				.34		.28	.50	
.188	.19	.50	.56	.88	1.25	.38	1.00	1.00	1.88				.34		.34	.50	
.190	.19	.50	.56	.88	1.25	.38	1.00	1.00	1.88				.34		.34	.50	
.200																	
.224						.50	1.25	1.25	2.50								
.250						.50	1.25	1.25	2.50								
.312						.75	1.75	1.75	3.12								