

Bend Allowance Chart

Bending allowance chart for cold rolled steel sheet SPCC (electro galvanized sheet SECC)

TV	Angle	0.6	0.8	1	1.2	1.5	2	2.5	3	3.5	4	4.5	5	Shortest size
V4	90	0.9	1.4											2.8
	120		0.7											
	150		0.2											
V6	90		1.5	1.7	2.15									4.5
	120		0.7	0.86	1									
	150		0.2	0.3	0.4									
V7	90		1.6	1.8	2.1	2.4								5
	120		0.8	0.9	1									
	150		0.3	0.3	0.3									
V8	90		1.6	1.9	2.2	2.5								5.5
	30		0.3	0.34	0.4	0.5								
	45		0.6	0.7	0.8	1								
	60		1	1.1	1.3	1.5								
	120		0.8	0.9	1.1	1.3								
	150		0.3	0.3	0.2	0.5								

V10	90					2.7	3.2								7
	120					1.3	1.6								
	150					0.5	0.5								
V12	90					2.8	3.65	4.5							8.5
	30					0.5	0.6	0.7							
	45					1	1.3	1.5							
	60					1.7	2	2.4							
	120					1.4	1.7	2							
	150					0.5	0.6	0.7							
V14	90							4.3							10
	120							2.1							
	150							0.7							
V16	90							4.5	5						11
	120							2.2							
	150							0.8							
V18	90							4.6							13
	120							2.3							
	150							0.8							
V20	90							4.8	5.1		6.6				14
	120							2.3			3.3				
	150							0.8			1.1				
V25	90							5.7	6.4	7				17.5	

	120									2.8	3.1	3.4			
	150									1	1	1.2			
V32	90											7.5	8.2		22
	120												4		
	150												1.4		
V40	90												8.7	9.4	28
	120												4.3	4.6	
	150												1.5	1.6	

Bending allowance chart for aluminum plate

TV	Angle	0.6	0.8	1	1.2	1.5	2	2.5	3	3.5	4	4.5	5	Shortest
														size
V4				1.4										2.8
V6				1.6										4.5
V7				1.6	1.8									5
V8					1.8	2.4	3.1							5.5
V10						2.4	3.2							7
V12						2.4	3.2							8.5
V14							3.2							10
V16							3.2	4	4.8					11
V18									4.8					13

V20										4.8					14
V25										4.8	5.4	6			17.5
V32												6.3	6.9		22

Bending allowance chart for copper plate

TV	Angle	0.6	0.8	1	1.2	1.5	2	2.5	3	3.5	4	4.5	5	Shortest
														size
	90						3.6		5.2		6.8		8.4	28
	120													
	150													