# Bending allowance values for bending angle φ = 25° (mm)

| Radius r | Material Thickness t | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.3 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.5 | 2.0 | 2.5 | 3.0 | 4.0 | 5.0 |
| 0.2 | 0.66 | 0.91 | 1.00 | 1.15 | | | | | | | | |
| 0.5 | 1.51 | 1.72 | 1.82 | 2.01 | 2.20 | 2.39 | 2.69 | | | | | |
| 1.0 | 2.87 | 3.07 | 3.18 | 3.38 | 3.57 | 3.77 | 4.07 | 4.61 | 5.17 | | | |
| 1.5 | 4.24 | 4.42 | 4.54 | 4.74 | 4.94 | 5.18 | 5.44 | 6.03 | 6.67 | 7.24 | | |
| 2.0 | 5.61 | 5.79 | 5.90 | 6.10 | 6.33 | 6.55 | 6.81 | 7.44 | 8.02 | 8.67 | 10.01 | |
| 2.5 | 6.97 | 7.14 | 7.25 | 7.48 | 7.68 | 7.90 | 8.20 | 8.82 | 9.41 | 10.19 | 11.55 | 12.58 |
| 3.0 | 8.32 | 8.51 | 8.60 | 8.83 | 9.04 | 9.25 | 9.56 | 10.17 | 10.79 | 11.54 | 12.90 | 14.23 |
| 3.5 | 9.67 | 9.86 | 9.96 | 10.18 | 10.39 | 10.60 | 10.91 | 11.52 | 12.14 | 12.91 | 14.36 | 15.58 |
| 4.0 | 11.02 | 11.23 | 11.31 | 11.54 | 11.74 | 11.96 | 12.26 | 12.88 | 13.49 | 14.26 | 15.71 | 16.93 |
| 4.5 | 12.38 | 12.58 | 12.66 | 12.89 | 13.09 | 13.31 | 13.61 | 14.23 | 14.85 | 15.61 | 17.06 | 18.29 |
| 5.0 | 13.73 | 13.93 | 14.01 | 14.24 | 14.45 | 14.66 | 14.97 | 15.58 | 16.20 | 16.98 | 18.42 | 19.64 |
| 5.5 | 15.08 | 15.28 | 15.37 | 15.59 | 15.80 | 16.02 | 16.32 | 16.93 | 17.55 | 18.34 | 19.77 | 20.99 |
| 6.0 | 16.43 | 16.64 | 16.72 | 16.95 | 17.15 | 17.37 | 17.67 | 18.29 | 18.90 | 19.69 | 21.12 | 22.35 |
| 6.5 | 17.79 | 17.99 | 18.07 | 18.30 | 18.50 | 18.72 | 19.02 | 19.64 | 20.26 | 21.04 | 22.48 | 23.70 |
| 7.0 | 19.14 | 19.34 | 19.42 | 19.65 | 19.86 | 20.07 | 20.38 | 20.99 | 21.61 | 22.39 | 23.83 | 25.05 |
| 7.5 | 20.49 | 20.70 | 20.78 | 21.00 | 21.21 | 21.43 | 21.73 | 22.35 | 22.96 | 23.75 | 25.18 | 26.40 |
| 8.0 | 21.84 | 22.05 | 22.13 | 22.36 | 22.56 | 22.78 | 23.08 | 23.70 | 24.31 | 25.10 | 26.53 | 27.76 |
| 8.5 | 23.20 | 23.40 | 23.48 | 23.71 | 23.91 | 24.13 | 24.44 | 25.05 | 25.67 | 26.45 | 27.89 | 29.11 |
| 9.0 | 24.55 | 24.75 | 24.83 | 25.06 | 25.27 | 25.48 | 25.79 | 26.40 | 27.02 | 27.80 | 29.24 | 30.46 |
| 9.5 | 25.90 | 26.11 | 26.19 | 26.41 | 26.62 | 26.84 | 27.14 | 27.76 | 28.37 | 29.16 | 30.59 | 31.81 |
| 10 | 27.26 | 27.46 | 27.54 | 27.77 | 27.97 | 28.19 | 28.49 | 29.11 | 29.72 | 30.51 | 31.94 | 33.17 |
| 11 | | | | | | | | 31.81 | 32.43 | 33.22 | 34.65 | 35.87 |
| 12 | | | | | | | | 34.52 | 35.13 | 35.92 | 37.35 | 38.58 |
| 13 | | | | | | | | 37.22 | 37.84 | 38.63 | 40.06 | 41.28 |
| 14 | | | | | | | | 39.93 | 40.55 | 41.33 | 42.76 | 43.99 |
| 15 | | | | | | | | | 43.25 | 44.04 | 45.47 | 46.69 |
| 16 | | | | | | | | | 45.96 | 46.74 | 48.18 | 49.40 |
| 17 | | | | | | | | | 48.66 | 49.45 | 50.88 | 52.10 |
| 18 | | | | | | | | | 51.37 | 52.15 | 53.59 | 54.81 |
| 19 | | | | | | | | | | 54.86 | 56.29 | 57.51 |
| 20 | | | | | | | | | | 57.56 | 59.00 | 60.22 |
| 21 | | | | | | | | | | 60.27 | 61.70 | 62.92 |
| 22 | | | | | | | | | | | 64.41 | 65.63 |
| 23 | | | | | | | | | | | 67.11 | 68.33 |