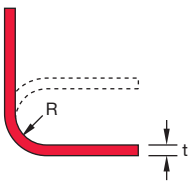
Notice

Bending of flat aluminium sheets

Minimum bending radii must be adhered to when bending flat sheets, depending on the strength and condition of the material. Bending below these minimum values may cause cracks in the material. The following illustration shows the recommended minimum bending radii for the aluminium alloys approved by Kalzip.



Recommended minimum bending radius R

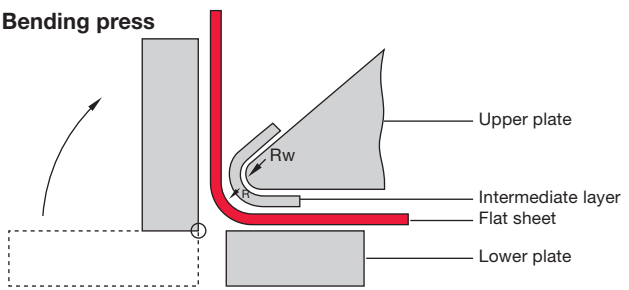
Hardness/Condition Bending angle	¼ hard H32/42	½ hard H34/44 ¾ hard H36/46
≤ 90°	1,0 x t	1,5 x t
> 90°	2,0 x t	3,0 x t

t = material thickness

Example: Material thickness 1.0 mm, hardness/condition ¾ hard, bending angle 180°
Minimum bending radius R = 3.0 x 1.0 R = 3.0 mm

If the radius (Rw) of the bending press is smaller than the permissible minimum bending radius (R), you can enlarge the radius (Rw) by using an intermediate layer (flat sheet strip).

Bending press



In conjunction with this we would like to again point out that our flat sheets do not possess folding properties.

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