



# Minimum Radius Guide on Mild Steel Material

Profile Type	CE35			CE40			CE50		
	Profile Dimensions	Min. CLR Inches	Wall	Profile Dimensions	Min. CLR Inches	Wall	Profile Dimensions	Min. CLR Inches	Wall
Pipe	½"	6	.109	½"	6	.109	¾"	8	.113
	1"	10	.133	1"	10	.133	2"	12	.154
	1¼"	15	.140	2"	18	.154	2½"	16	.203
Tube	1"	6	.120	1"	6	.120	1"	6	.120
	1½"	12	.120	1½"	12	.120	2½"	18	.120
	2"	16	.095	2½"	25	.083	3"	24	.120
Square Tube	¾"	8	.065	¾" x ¾"	6	.083	¾" x ¾"	6	.083
	1½"	18	.120	1½" x 1½"	16	.083	2" x 2"	20	.120
				2" x 2"	24	.120	2½" x 2½"	30	.120
Rectangular Tube Hard way	¾" x 1"	10	.065	½" x 1¼"	10	.083	½" x 1"	8	.083
	½" x 1¼"	14	.095	1" x 1½"	12	.120	1½" x 2½"	18	.120
				1" x 2"	24	.120	1½" x 3"	34	.120
Rectangular Tube Easy way	1" x ¾"	10	.065	1¼" x ½"	10	.083	1¼" x ½"	10	.083
	1¼" x ½"	18	.095	2" x 1"	20	.120	2½" x 1½"	24	.120
							3" x 1½"	32	.120
Round Solid	¾"	4*	NA	¾"	4*	NA	¾"	4*	NA
				1¼"	12	NA	1½"	14	NA
Square Solid	⅝"	4*	NA	¾"	4*	NA	¾"	4*	NA
	1"	8	NA	1"	8	NA	1¼"	10	NA
				1¼"	10	NA	1½"	10	NA
Rectangular Solid Hard way	¾" x 1¼"	8	NA	½" x 1½"	12	NA	¾" x ¾"	6*	NA
	¾" x 1½"	10	NA	¼" x 2"	16	NA	½" x 2"	10	NA
				½" x 2"	18	NA	½" x 2½"	18	NA
Rectangular Solid Easy way	1¼" x ⅜"	6	NA	1¼" x ⅜"	6*	NA	2" x ½"	8	NA
	1½" x ⅜"	8	NA	2½" x ½"	8	NA	4" x ½"	12	NA
				3" x ½"	16	NA			
Angle "Leg Out"	1" x 1"	8	.125	1" x 1"	8	.120	1" x 1"	8	.120
	1½" x 1½"	16	.187	1½" x 1½"	12	.120	2" x 2"	16	.187
				2" x 2"	16	.187	2⅜" x 2⅜"	20	.187
Angle "Leg In"	1" x 1"	10	.125	1" x 1"	10	.120	1" x 1"	10	.120
	1½" x 1½"	18	.187	1½" x 1½"	16	.120	2" x 2"	18	.236
				2" x 2"	28	.187	2⅜" x 2⅜"	22	.236
C "Leg Out"	1¼" x ½"	8	.187	1½" x ½"	10	.120	1¼" x ½"	10	.120
				2" x 1¼"	14	.187	3" x 1½"	15	.187
C "Leg In"	1½" x ¾"	8	.187	½" x ¾"	10	.187	1½" x ¾"	10	.187
				2½" x 1¼"	14	.187	3" x 1½"	16	.187

1. Capacities based on mild grade material, number of bending passes may vary.
2. Tie Bar accessory required for bending large profiles.
3. Two roll drive machines increase minimum CLR.

# Minimum Radius Guide on Mild Steel Material

CE60			CE70			CE100		
Profile Dimensions	Min. CLR Inches	Wall	Profile Dimensions	Min. CLR Inches	Wall	Profile Dimensions	Min. CLR Inches	Wall
¾"	6	.113	1½"	16	.145	2"	16	.154
2"	12	.154	3"	24	.216	4"	36	.237
3"	30	.216						
1"	6	.120	1½"	16	.120	2"	12	.120
2½"	20	.203	4"	30	.187	4"	32	.187
3½"	30	.187				6"	76	.187
¾" x ¾"	6	.083	1½" x 1½"	12	.120	2" x 2"	14	.120
2" x 2"	20	.120	3" x 3"	48	.187	4" x 4"	72	.187
2½" x 2½"	30	.216						
½" x 1"	6	.083	½" x 1½"	10	.120	1" x 2½"	16	.187
1½" x 2½"	18	.120	2" x 4"	48	.187	2" x 4"	48	.187
1½" x 4"	36	.187						
1¼" x ½"	6	.083	1½" x ½"	10	.120	2½" x 1"	14	.187
2½" x 1½"	24	.120	4" x 2"	72	.187	4" x 2"	72	.187
4" x 1½"	60	.187						
1"	8*	NA	1¼"	6*	NA	1½"	8*	NA
1¾"	16	NA	2"	16	NA	2½"	24	NA
5/8"	4*	NA	1½"	10*	NA	1½"	14	NA
1¼"	8	NA	2"	16	NA	2"	18	NA
1¾"	20	NA						
⅜" x ¾"	6*	NA	½" x 1½"	14	NA	½" x 1½"	16	NA
½" x 2"	8	NA	½" x 3"	32	NA	¾" x 4"	42	NA
¾" x 3"	40	NA						
2" x ½"	6	NA	1½" x ½"	12	NA	2" x ½"	14	NA
4" x ¾"	8	NA	4" x 1"	16	NA	6" x 1"	32	NA
1" x 1"	10	.156	1½" x 1½"	14	.187	2" x 2"	16	.187
2" x 2"	18	.236	3" x 3"	28	.375	3" x 3"	28	.375
2⅜" x 2⅜"	26	.236				4" x 4"	36	.500
1" x 1"	14	.156	1½" x 1½"	16	.187	2" x 2"	20	.187
2" x 2"	28	.236	3" x 3"	32	.375	3" x 3"	32	.375
2⅜" x 2⅜"	36	.236				4" x 4"	40	.500
1½" x ¾"	10	.156	2" x 1"	14	.187	2" x 1"	14	.187
3⅜" x 1"	12	.236	4" x 1½"	24	.187	6" x 2"	60	.375
1½" x ¾"	10	.203	2" x 1"	14	.125	2" x 1"	14	.187
4" x 1½"	18	.236	4" x 1½"	24	.187	6" x 2"	60	.375

\*Special tooling required

Consult CML USA, Inc. Ercolina® with application questions.

Consult factory for material and radii not shown.