



# Minimum Radius Guide on Mild Steel Material

Profile Type	CE40			CE50		
	Profile Dimensions	Min. CLR Inches	Wall	Profile Dimensions	Min. CLR Inches	Wall
Pipe	1/2"	6	.109	3/4"	8	.113
	1"	10	.133	2"	12	.154
	2"	18	.154	2 1/2"	16	.203
Tube	1"	6	.120	1"	6	.120
	1 1/2"	12	.120	2 1/2"	18	.120
	2 1/2"	25	.083	3"	24	.120
Square Tube	3/4" x 3/4"	6	.083	3/4" x 3/4"	6	.083
	1 1/2" x 1 1/2"	16	.083	2" x 2"	20	.120
	2" x 2"	24	.120	2 1/2" x 2 1/2"	30	.120
Rectangular Tube Hard way	1/2" x 1 1/4"	10	.083	1/2" x 1"	8	.083
	1" x 1 1/2"	12	.120	1 1/2" x 2 1/2"	18	.120
	1" x 2"	24	.120	1 1/2" x 3"	34	.120
Rectangular Tube Easy way	1 1/4" x 1/2"	10	.083	1 1/4" x 1/2"	10	.083
	2" x 1"	20	.120	2 1/2" x 1 1/2"	24	.120
				3" x 1 1/2"	32	.120
Round Solid	3/4"	4 *	NA	3/4"	4 *	NA
	1 1/4"	12	NA	1 1/2"	14	NA
Square Solid	3/4"	4 *	NA	3/4"	4 *	NA
	1"	8	NA	1 1/4"	10	NA
	1 1/4"	10	NA	1 1/2"	10	NA
Rectangular Solid Hard way	1/2" x 1 1/2"	12	NA	3/8" x 3/4"	6 *	NA
	1/4" x 2"	16	NA	1/2" x 2"	10	NA
	1/2" x 2"	18	NA	1/2" x 2 1/2"	18	NA
Rectangular Solid Easy way	1 1/4" x 3/8"	6 *	NA	2" x 1/2"	8	NA
	2 1/2" x 1/2"	8	NA	4" x 1/2"	12	NA
	3" x 1/2"	16	NA			
Angle "Leg Out"	1" x 1"	8	.120	1" x 1"	8	.120
	1 1/2" x 1 1/2"	12	.120	2" x 2"	16	.187
	2" x 2"	16	.187	2 1/2" x 2 1/2"	20	.187
Angle "Leg In"	1" x 1"	10	.120	1" x 1"	10	.120
	1 1/2" x 1 1/2"	16	.120	2" x 2"	18	.236
	2" x 2"	28	.187	2 1/2" x 2 1/2"	22	.236
C "Leg Out"	1 1/2" x 1/2"	10	.120	1 1/4" x 1/2"	10	.120
	2" x 1 1/4"	14	.187	3" x 1 1/2"	15	.187
C "Leg In"	1 1/2" x 3/4"	10	.187	1 1/2" x 3/4"	10	.187
	2 1/2" x 1 1/4"	14	.187	3" x 1 1/2"	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
3/4"	6	.113	1 1/2"	16	.145	2"	16	.154
2"	12	.154	3"	24	.216	4"	36	.237
3"	30	.216						
1"	6	.120	1 1/2"	16	.120	2"	12	.120
2 1/2"	20	.203	4"	30	.187	4"	32	.187
3 1/2"	30	.187				6"	76	.187
3/4" x 3/4"	6	.083	1 1/2" x 1 1/2"	12	.120	2" x 2"	14	.120
2" x 2"	20	.120	3" x 3"	48	.187	4" x 4"	72	.187
2 1/2" x 2 1/2"	30	.216						
1/2" x 1"	6	.083	1/2" x 1 1/2"	10	.120	1" x 2 1/2"	16	.187
1 1/2" x 2 1/2"	18	.120	2" x 4"	48	.187	2" x 4"	48	.187
1 1/2" x 4"	36	.187						
1 1/4" x 1/2"	6	.083	1 1/2" x 1/2"	10	.120	2 1/2" x 1"	14	.187
2 1/2" x 1 1/2"	24	.120	4" x 2"	72	.187	4" x 2"	72	.187
4" x 1 1/2"	60	.187						
1"	8 *	NA	1 1/4"	6 *	NA	1 1/2"	8 *	NA
1 3/4"	16	NA	2"	16	NA	2 1/2"	24	NA
5/8"	4 *	NA	1 1/2"	10 *	NA	1 1/2"	14	NA
1 1/4"	8	NA	2"	16	NA	2"	18	NA
1 3/4"	20	NA						
3/8" x 3/4"	6 *	NA	1/2" x 1 1/2"	14	NA	1/2" x 1 1/2"	16	NA
1/2" x 2"	8	NA	1/2" x 3"	32	NA	3/4" x 4"	42	NA
3/4" x 3"	40	NA						
2" x 1 1/2"	6	NA	1 1/2" x 1 1/2"	12	NA	2" x 1 1/2"	14	NA
4" x 3/4"	8	NA	4" x 1"	16	NA	6" x 1"	32	NA
1" x 1"	10	.156	1 1/2" x 1 1/2"	14	.187	2" x 2"	16	.187
2" x 2"	18	.236	3" x 3"	28	.375	3" x 3"	28	.375
2 1/2" x 2 1/2"	26	.236				4" x 4"	36	.500
1" x 1"	14	.156	1 1/2" x 1 1/2"	16	.187	2" x 2"	20	.187
2" x 2"	28	.236	3" x 3"	32	.375	3" x 3"	32	.375
2 1/2" x 2 1/2"	36	.236				4" x 4"	40	.500
1 1/2" x 3/4"	10	.156	2" x 1"	14	.187	2" x 1"	14	.187
3 1/8" x 1"	12	.236	4" x 1 1/2"	24	.187	6" x 2"	60	.375
1 1/2" x 3/4"	10	.203	2" x 1"	14	.125	2" x 1"	14	.187
4" x 1 1/2"	18	.236	4" x 1 1/2"	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.