

HUTH BENDING CAPACITIES



Stock tooling is available for:

Round Tubing Standard: ½" through 3"
 Round Tubing Metric: 40 MM through 60 MM
 Schedule Pipe: ½" through 2"
 Square Tubing: ¾" through 2 ½"
 Rectangular Tubing: 2" by 3"

Stock radius dies available in: 3 ½", 4" & 5" Center Line Radius

Maximum depth of bends: 3 ½" = 135°, 4" = 148°, 5" = 160°

Special full radius dies can be made that will bend: 3 ½" = 150°, 4" = 165°, 5" = 175°

Round Tubing

Diameter	Minimum wall	Standard Bender	Heavy Duty Bender
		(5in Cylinder) Maximum wall	(6in Cylinder) Maximum wall
1" Dia. & less	20 GA	Solid Bar	Solid Bar
1 ⅛" – 1 ½"	18 GA	Solid Bar	Solid Bar
1 ⅝" – 1 ¾"	16 GA	Solid Bar	Solid Bar
1 ⅞" – 2"	16 GA	10 GA	Solid Bar
2 ⅛" – 2 ½"	14 GA	10 GA	10 GA
2 ¾" – 3"	14 GA	13 GA	11 GA

Stainless Steel Tubing follows as listed under min. gages, however your material should be verified at Huth.

Pipe: Standard Machines will bend a maximum 1 ½" nominal (1.9" OD) Sch 40 pipe. Heavy Duty Models will bend a maximum 2" nominal (2.375" OD) Sch 40 pipe. All pipe sizes should be verified.

Square Tubing

Size	Minimum wall	Standard Bender	HD Bender
		(5in Cylinder) Maximum wall	(6in Cylinder) Maximum wall
¾" – 1"	18 GA	11 GA	8 GA (3/16" wall)
1 ¼"	16 GA	8 GA (3/16" wall)	8 GA
1 ½"	16 GA	¼" wall	8 GA
2"	14 GA	13 GA	11 GA (1/8" wall)
2 ¼"	14 GA	14 GA	11 GA
2 ½"	14 GA	14 GA	11 GA
3"	---	----	12 GA

Rectangular Tubing

Standard machine 2" by 3" - .095 wall can be bent the easy way. (3" vertical).
 Heavy Duty model 2" by 3" - .095 wall can be bent the hard way. (2" vertical).

Material bending other than mild steel needs to be verified.
We also make custom dies and dies for flat stock.

Note: Verify Your Material
 Materials vary ...
 Maximums noted are generalizations. Near limits, have your material verified as successfully bendable

