

Tube Bending Radius Chart

NPS	Diameter (mm)	Min. Bending Radius (mm) - Hot Bending	Min. Bending Radius (mm) - Cold Bending
2	60.3	-	≥700
2 1/2	73	-	≥700
3	88.9	≥135 (≥1.5D)	≥710
3 1/2	101.6	≥155 (≥1.5D)	≥810
4	114.3	≥170(≥1.5D)	≥920
5	141.3	≥220(≥1.5D)	≥1130
6	168.3	≥250(≥1.5D)	≥1350
-8	219.1	≥350(≥1.5D)	≥1750
10	273.0	≥700 (≥2.5D)	≥2200
12	323.9	≥850 (≥2.5D)	≥2600
14	355.6	≥1100 (≥3.0D)	≥2850
16	406.4	≥1250(≥3.0D)	≥3250
18	457.2	≥1400 (≥3.0D)	≥3660
20	508.0	≥1550(≥3.0D)	≥4060
22	558.8	≥1700 (≥3.0D)	≥4470
24	609.6	≥1850(≥3.0D)	≥4880
26	660.4	≥1980 (≥3.0D)	≥5280
28	711.2	≥2140 (≥3.0D)	≥5690
30	762.0	≥2290 (≥3.0D)	≥6090
32	812.8	≥2450(≥3.0D)	≥6500
34	863.6	≥2590(≥3.0D)	≥6900
36	914.4	≥2750(≥3.0D)	≥7350
38	965.2	≥2900 (≥3.0D)	≥7750
40	1016.0	≥3050 (≥3.0D)	≥8150
42	1066.8	≥3200 (≥3.0D)	≥8550
44	1117.6	≥3350(≥3.0D)	≥89450
46	1168.4	≥3510 (≥3.0D)	≥9400
48	1219.2	≥3660(≥3.0D)	≥9800

