

HUTH BENDING CAPACITIES



Stock tooling is available for:

Round Tubing Standard	- ½" through 3"
Round Tubing Metric	- 40 MM through 60 MM
Schedule Pipe	- ¾" through 2"
Square Tubing	- ¾" through 2 ½"
Rectangle 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	HD 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 applies as listed under minimum gages however they should be verified at Huth.

Pipe: Standard Machines will bend a maximum 1 ½" Sch 40 pipe. The Heavy Duty Model will bend a maximum 2" Sch 40 pipe. All pipe sizes should be verified at Huth.

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"	14 GA	8 GA (3/16" wall)	8 GA
1 ½"	12 GA	¼" wall	8 GA
2"	18 GA	13 GA	11 GA (⅛" wall)
2 ¼"	16 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 need to be verified.

We also make custom dies and dies for flat stock.

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

