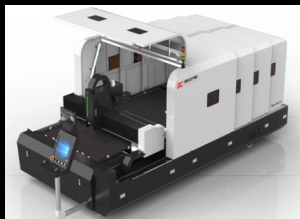


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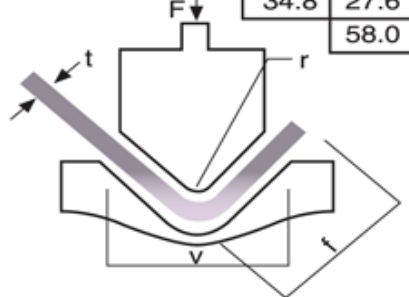
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PRESS BRAKE AIR-BENDING TONNAGE GUIDE

Force to Air-Bend Mild Steel (60,000 PSI)																	F = U.S. tons/lineal ft. of workpiece	All Dimensions in inches	
t	v	1/4	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	5	6	8	10	v	
ga.	f	3/16	9/32	11/32	7/16	9/16	11/16	7/8	1 1/8	1 3/8	1 3/4	2 3/16	2 13/16	3 1/2	4 1/2	5 1/2	6 7/8	f	
in.	r	1/32	1/16	5/64	7/64	9/64	5/32	13/64	1/4	5/16	13/32	33/64	5/8	3/4	1 1/32	1 5/16	1 5/8	ga.	
20	0.036	3.1	1.75	1.2															20
18	0.048	5.4	3.1	2.1	1.55	1.3													18
16	0.060	9.6	5.5	3.8	2.8	2.2	1.45												16
14	0.075		9.3	6.4	4.7	3.8	2.5	1.85											14
12	0.105		20.5	14.0	10.4	8.1	5.6	4.1	3.2	2.2									12
11	0.120			18.5	13.9	10.9	7.4	5.6	4.3	2.9	2.15								11
10	0.135			25.2	17.2	14.5	9.9	7.3	5.7	3.8	2.85	2.23							10
3/16	0.188				34.8	27.6	19.1	13.9	11.0	7.5	5.6	4.3							3/16
1/4	0.250					58.0	39.5	29.0	22.8	15.5	11.4	8.9	6.1	4.5					1/4
5/16	0.313						69.5	51.0	40.0	27.0	20.0	15.6	10.5	7.8	6.1				5/16
3/8	0.375							75.0	59.0	40.0	29.5	23.4	15.8	11.7	9.2	6.2	4.6		3/8
7/16	0.438								115.0	90.0	61.0	45.5	35.2	24.0	17.8	13.9	9.4	6.9	7/16
1/2	0.500									85.0	62.0	44.3	33.0	24.5	19.1	13.0	9.8		1/2
5/8	0.625										86.0	58.0	43.0	34.0	23.2	17.5			5/8
3/4	0.750											91.0	67.0	53.0	36.4	26.7			3/4
7/8	0.875												136.0	101.0	79.0	54.0	40.0		7/8
1	1.000													146.0	115.0	68.0	58.0		1



t = Workpiece thickness
r = Inside radius of formed part
v = Vee-die opening
f = Minimum flange

For steel of different tensile strength. F value differs in proportion to strength ratio. Inside radius r for mild steel, is about 5/32 of female die opening v. for any t. Shaded F values are for v = 8t, common for average 90° bending. For t = 1/2 inch or more, use v = 10t.

PLEASE VERIFY YOUR TOOLING IS CAPABLE OF HANDLING THE TONNAGE

*Tonnage requirements for coining are 3 to 5 times Greater than when air bending. Bending pressures for other metals are:

- Soft brass = 50% of pressure shown.
- Soft Aluminum = 50% of pressure shown.
- Aluminum alloys heat treated = same as steel.
- Stainless steel = 50% more than steel.

Hydraulic Shear Capacity Chart

Shear Capacity	3/16"	1/4"	3/8"	1/2"	5/8"	3/4"	1"
A36 Plate (tensile 58-80 ksi)	-	0.25	0.375	0.5	0.625	0.75	1
A514-T1 Plate (tensile 110-130 ksi)	0.105	0.188	0.281	0.375	0.5	0.625	0.75
A572 (tensile 60-75 ksi)	0.135	0.25	0.375	0.5	0.625	0.75	1
A588 COR-TEN B (tensile 70-80 ksi)	0.135	0.25	0.375	0.5	0.625	0.75	1
Annealed 40-50 Carbon HR Sheet & Plate	0.105	0.188	0.281	0.375	0.5	0.625	0.75
A.I.S.I 4130 HRSheet - Annealed	0.105	0.188	0.281	0.375	0.5	0.625	0.75
A.I.S.I. 4140 HRPlate - Annealed	--	0.188	0.281	0.375	0.5	0.625	0.75
A.I.S.I. 6150 HRPlate - Annealed	--	0.188	0.281	0.375	0.5	0.625	0.75
A.I.S.I. 8620 HRPlate - Annealed	--	0.188	0.281	0.375	0.5	0.625	0.75
Floor Plate	0.135	0.25	0.375	0.5	0.625	0.75	1
Stainless Steels 302, 304, 316, 410, 430	0.105	0.188	0.281	0.375	0.5	0.625	0.75
Aluminum 1100-0, 1100-H14, 1100-H16, 2024-0 3003-H14 5005-H34, 5052-0 5052-H32 5052-H34, 5086-H32 6061-0 6061-T6	0.21	0.375	0.562	0.75	1	1.125	1.5
Aluminum 2024-T3 2024-T4 7075-T6	0.188	0.25	0.375	0.5	0.625	0.75	1
Inconel 718	0.105	0.188	0.281	0.375	0.5	0.625	0.75
Hastalloy	0.105	0.188	0.281	0.375	0.5	0.625	0.75

For Reference Only