

METAL THICKNESS		Pressbrake Bending Tonnage Chart (tons per ft. of bend @ specific die opening / radius)																						
		WIDTH OF LOWER DIE OPENING																						
Gauge	Inches	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4	1-1/2	2	2-1/2	3	3-1/2	4	5	6	7	8	10	
20	.036	3.1	2.3	1.8	1.4	1.2	1.0																	
18	.048	5.4	4.0	3.1	2.5	2.2	1.7	1.3																
16	.060	9.6	7.1	5.6	4.5	3.8	2.8	2.2	1.8	1.5														
14	.075		11.9	9.3	7.6	6.4	4.7	3.8	3.0	2.5	2.1	1.9												
13	.090						6.8	5.5	4.3	3.7	3.3	2.9												
12	.105			20.5	16.7	13.5	10.4	7.7	6.5	5.6	4.4	4.1	3.2	2.2										
11	.120					18.5	13.9	10.9	8.8	7.5	6.2	5.6	4.3	3.2	2.2									
10	.135					25.2	17.2	14.5	11.3	9.9	8.5	7.3	5.7	4.0	2.9	2.3								
9	.150									13.1	11.9	9.0	7.0	5.2	3.7									
3/16	.188							27.4	23.1	19.3	16.4	14.3	11.2	7.6	5.8	4.5								
1/4	.250									39.4	33.3	29.5	22.7	15.4	11.5	9.1	7.5	6.2						
5/16	.313																							
3/8	.375																							
7/16	.437																							
1/2	.500																							
5/8	.625																							
3/4	.750																							
7/8	.875																							
1	1.00																							
Formed Radius		1/32	3/64	1/16	5/64	5/64	3/32	1/8	9/64	5/32	11/64	3/16	15/64	5/16	25/64	15/32	25/64	5/8	25/32	15/16	1-3/32	1-1/4	1-9/16	
Min. Flange Dim.		3/16	7/32	1/4	9/32	5/16	7/16	1/2	5/16	5/8	11/16	3/4	15/64	1-3/16	1-7/16	1-3/4	2	2-1/4	2-3/4	3-3/8	4	4-1/2	5-1/2	

Shaded box represents the OPTIMUM lower die opening / radius for given thickness.

Values are based on Mild Steel, AIR bent to 90 Degrees.

Tonnage adjustment for materials OTHER than Mild Steel: 50.4 39.8 27.0 19.7 16.0 12.7 10.6 7.7

Soft Aluminum & Brass = 50% LESS pressure than Mild Steel
 Aluminum Alloys and/or Heat Treated Aluminum = Same as Steel
 Stainless Steel = 50% MORE pressure than Mild Steel