TONNAGE CHART

MATERIAL THICKNESS		WIDTH OF FEMALE VEE DIE OPENING																										
Gauge	**Dec.**	**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**	**12**	**14**	**15**	**20**	**24**	**30**
20	.0360	2.5	2	1.6	1.1	1.2																						
18	.0478		3.5	2.8	2.1	1.7	1.3																					
16	.0598			6.0	5.3	3.7	2.8	2.2	1.7																			
14	.0747					5.5	4.6	3.5	3.0	2.5	2.1																	
13	.0897						6.4	5.5	4.3	3.6	3.2	2.8																
12	.1046						9.2	6.9	6.0	5.0	4.3	3.9	3.1															
11	.1196							10.1	8.0	7.0	6.1	5.3	4.3	2.9														
10	.1345								10.3	8.7	7.8	6.9	5.7	3.9														
9	.1495									11.9	9.8	8.8	7.0	5.0	3.7													
3/16	.1870									21.5	16.9	13.9	11.2	8.3	6.7	4.9												
1/4	.2500											27.5	22.1	15.0	11.6	9.	7.9	6.7										
5/16	.3120												39.2	26.5	19.3	15.0	12.5	10.4	7.7									
3/8	.3750													42.7	31.2	23.8	19.5	16.3	12.4	9.6								
7/16	.4380														45.5	35.2	28.5	24.4	17.4	15.0	11.5							
1/2	.5000															48.5	39.5	33.2	24.6	19.5	16.1	13.4							
5/8	.6260																	57.9	42.8	33.1	27.3	23.3	17.0						
3/4	.7500																		68.7	53.5	43.6	36.5	27.1	21.0					
7/8	.8750																			81	64	53	39.5	31.4					
1	1.000																				91	76	56	44					
1-1/4	1.250																						98	76	62	51	38		
1-1/2	1.500																							118.5	97.5	81	60	47	
1-3/4	1.750																								144	119	88	69	51
2	2.000																									165	122	97	71
2-1/2	2.500																										215	169	125
3	3.000																											266	197

Approximate tons per lineal foot of forming based on Air Bending 90° bend in mild steel.

When using material over 1/2", it is usual practice to have die opening 10 times the metal thickness.

The shaded figures represent ideal conditions for right angle bending: punch with radius equal to metal thickness and die opening, approximately eight times the metal thickness. Resulting bend has inside radius approximately equal to metal thickness. Resulting bed has inside radius approximately equal to metal thickness. Bending pressure required for other metals as compared to 60,000 P.S.I tensile mild steel on chart.

Soft Brass	50% of pressure listed
Soft Aluminum	50% of pressure listed
Aluminum Alloy (heat treated)	Same as steel
Stainless Steel	50% more than steel
Chrome Molybdenum	100% more than steel