

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																							
		Tonnage adjustment for materials OTHER than Mild Steel:										50.4	39.8	27.0	19.7	16.0	12.7	10.6	7.7					
3/8	.375																							
		Soft Aluminum & Brass = 50% LESS pressure than Mild Steel										61.1	42.3	30.9	24.0	19.6	16.3	12.3	9.5					
7/16	.437																							
		Aluminum Alloys and/or Heat Treated Aluminum = Same as Steel											61.7	45.8	35.4	28.6	24.4	17.3	14.8	11.2				
1/2	.500																							
		Stainless Steel = 50% MORE pressure than Mild Steel											85.2	63.6	48.8	39.7	33.3	24.6	19.4	15.9	13.1			
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	

\*Based on MILD STEEL 65,000 psi Ultimate Tensile Strength