



Tel: 905.319.5988
 800.463.0743
 Fax: 905.319.8796
 888.299.3919
 Burlington, ON CA
 E-Mail: sales@cansaw.com
 Web: www.cansaw.com

PRESS BRAKE BENDING TONNAGE CHART

Tons required per linear foot to bend mild steel having max. 72,000 PSI tensile strength and max. 40,000 PSI yield strength.

Thickness of metal		Width of V 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"	12"	
20	0.036	3.75	2.76	2.04	1.68	1.32																			
18	0.048	6.36	4.80	3.60	3.00	2.64	2.04	1.56																	
16	0.060	11.52	8.52	6.72	5.40	4.56	3.36	2.64	2.16	1.80															
14	0.075		14.25	11.04	9.12	7.56	5.64	4.20	3.60	3.00	2.52	2.16													
12	0.105				20.04	15.72	11.64	9.60	7.80	6.75	5.52	4.92	3.84												
11	0.120					23.04	17.04	13.32	10.80	9.00	7.56	6.60	5.28	3.48											
10	0.135						22.32	17.40	14.28	11.88	10.20	8.76	6.96	4.80											
3/16"	0.188							32.88	27.72	23.16	19.68	17.16	13.44	9.00	6.84	5.28									
1/4"	0.250									47.28	39.96	35.40	27.24	18.48	13.68	10.80	8.88	7.32							
5/16"	0.313										60.48	47.76	32.40	23.64	18.36	15.24	12.60	9.24							
3/8"	0.375		Soft brass - 50% of pressure shown										73.9	50.76	37.08	28.80	23.52	19.56	14.76	11.40					
7/16"	0.438		Soft Aluminum - 50% of pressure shown										74.04	54.96	42.48	34.32	29.28	20.76	17.76	13.44					
1/2"	0.500		Aluminum alloys heat treated - same as steel											76.32	58.56	47.64	39.96	29.52	23.28	19.08	15.72				
5/8"	0.625		Stainless steel - 50% more than steel												103.44	84.00	69.96	51.72	39.96	32.88	27.96	20.28			
3/4"	0.750		Chrome molybdenum - 100% more than steel													132.00	111.60	82.44	64.20	52.32	43.80	32.52	25.20		
7/8"	0.875																164.60	124.80	96.84	77.52	63.48	47.64	37.92		
1"	1.000																		171.60	135.60	109.44	91.44	67.56	53.04	

The tonnages indicated in black boxes are the die openings 8 times metal thickness below 1/4", the tonnages indicated in red boxes are for die opening 10 times metal thickness of 1/4" and above. The inside radius of a right angle bend is approximately equal to the thickness of the material. Bending tonnages for other metals, as compared to mild steel on chart, are as follows:

All of the above bending tonnages are nominal and represent average conditions.