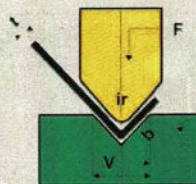


Air Bending Tonnage Chart: Mild Steel

How to Read the Pressure Chart

If the material thickness and inner radius are known, the following information can be obtained from the chart below:

1. Tonnage required to bend material of 1 metre length
2. V-width to be used
3. Minimum bend flange length



t mm	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V			
	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	b			
	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir			
0.5	4	3																							
0.6	6	4	4	4																					
0.8		7	7	5	4																				
1		11	10	8	7	6																			
1.2			14	12	10	8	7	6																	
1.4				15	13	11	10	9	8																
1.6					17	15	13	11	10	9															
2						22	19	17	15	13	11														
2.3							25	23	19	17	15	12													
2.6								28	25	22	18	14													
3									34	30	24	19	15												
3.2										34	27	22	17	14											
3.5											33	26	20	16	13										
4												43	34	27	21	17									
4.5													44	34	27	21									
5														52	42	33	26	21							
6															60	48	38	30	24						
7	t															52	41	33	26						
9	F																67	54	43						
10	ir																	85	67	53	42				
12	b																			96	78	60	55		
16	V																				136	107	86		
19																						150	125	100	
22																							160	130	
25																								210	170
30																									240

Material Thickness and V-Width

The distance across the die opening is known as the V-width. The appropriate V-width should be selected in accordance with the thickness of material being bent. The table below shows the optimum relationship between the material thickness and V-width, although in practice this relationship is often determined by specific requirements, including flange lengths (b), the components inner bend radius (ir) and the tonnage capacity of the machine and tooling.

Relationship of Material Thickness (t) and V-Width

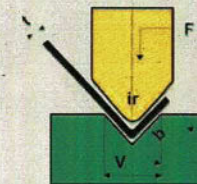
Material Thickness (t) mm	0.5 - 2.5	3.0 - 8.0	9.0 - 10.0	12.0 or more
V-Width	6 x t	8 x t	10 x t	12 x t

Air Bending Tonnage Chart: Stainless Steel

How to Read the Pressure Chart

If the material thickness and inner radius are known, the following information can be obtained from the chart below:

1. Tonnage required to bend material of 1 metre length
2. V-width to be used
3. Minimum bend flange length



t mm	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V		
	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	b		
	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir		
0.5	6	5																						
0.6	9	6	6	6																				
0.7	12	8	8	6	6																			
0.8		11	11	8	7																			
0.9		13	12	10	8	7																		
1		17	15	12	11	8																		
1.2			21	18	15	12	11	9																
1.5						20	17	15	13	12														
2							33	29	26	23	20	17												
2.5									39	35	30	25	19											
3										51	45	36	29	23										
4												65	51	41	32	26								
5													78	63	50	39	32							
6														90	72	57	45	36						
8	t														102	81	65	51						
10	F															128	101	80	63					
12	ir																144	117	90	83				
15	b																	180	141	114				
20	V																		250	208	167			
25																					315	255		
30																							360	

Material Thickness and V-Width

The distance across the die opening is known as the V-width. The appropriate V-width should be selected in accordance with the thickness of material being bent. The table below shows the optimum relationship between the material thickness and V-width, although in practice this relationship is often determined by specific requirements, including flange lengths (b), the components inner bend radius (ir) and the tonnage capacity of the machine and tooling.

Relationship of Material Thickness (t) and V-Width

Material Thickness (t) mm	0.5 - 2.5	3.0 - 8.0	9.0 - 10.0	12.0 or more
V-Width	6 x t	8 x t	10 x t	12 x t