Press Brake Bending Tonnage Chart

Approximate Pressure in Tons per Linial Foot Required to make 90 deg. Air Bend on Mild Steel with Various Width Die Openings

Width of V-Die Opening	Metal Thickness (T)																	
	26 G .010"	24 G .024"	22 G .030"	20 G .036"	18 G .048"	16 G .060"	14 G .075"	13 G .090"	12 G .105"	11 G .120"	10 G .135"	9 G .149"	7 G 3/16" .187"	1/4" .250"	5/16" .313"	3/8" .375"	7/16" .437"	1/2" 0.50"
1/8"	*1.2*	2.1	3.6															
3/16"	0.8	*1.4*	2.5	4.1														
1/4"	0.5	1.1	*1.8*	2.9	5.4													
5/16"		0.7	1.4	*2.2*	4.0	7.0												
3/8"			1.0	1.7	*2.9*	5.6	8.8											
1/2"				1.2	2.2	*3.6*	6.0	10.0										
5/8"					1.6	2.7	*4.5*	6.8	10.1									
3/4"					1.3	2.2	3.4	*5.4*	7.4	10.5								
7/8"						1.7	3.0	4.3	*6.3*	8.8	11.3							
1"						1.4	2.5	3.7	5.4	*7.2*	9.6	13.1						
1-1/8"							2.1	3.3	4.4	6.2	*8.4*	11.9	16.4					
1-1/4"							1.7	2.9	4.0	5.4	7.0	*9.0*	14.0	28.8				
1-1/2"								3.2	4.3	5.6	6.7	*11.2*	22.0	38.0				
2"									3.2	4.1	5.2	7.6	*15.3*	26.0	41.0			
2-1/2"										2.4	3.5	5.8	11.5	*19.2*	29.9	45.2		
3"												2.2	4.5	9.1	16.0	*24.0*	35.0	47.9
3-1/2"														7.5	12.5	19.4	*28.0*	39.0
4"														6.2	10.6	16.0	24.0	*33.1*

Figures that are bold are the pressures required using a punch with a radius equal to the metal thickness and die opening approximately eight times metal thickness.
This combination produces an air bend with an inside radius nearly equal to metal thickness - a good practical minium for 90 deg. bends.

Soft Aluminum	50% of pressure listed
Aluminum Alloy (Heat treated)	Same as steel
Stainless Steel	50% more than steel