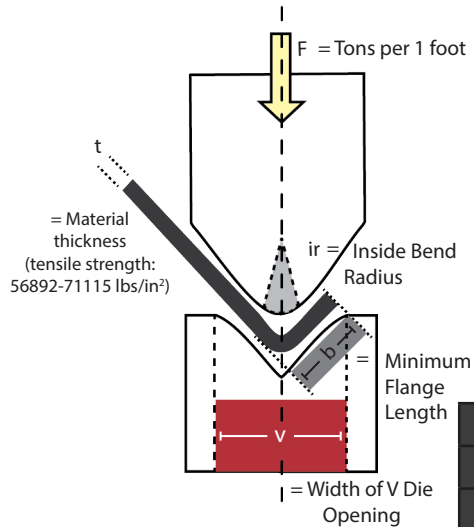


Air Bending Force Chart (Mild Steel)



With the material thickness and inside bend radius, you can use this chart to determine:

- Pressure required for bending the material for 1 foot
- Opening of the die to be used
- Minimum bendable flange length

		v = Width of V Die Opening																				
mm		4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250
inches		.156	.25	.281	.313	.375	.5	.563	.625	.688	.75	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0
		b = Minimum Flange Length																				
inches		.125	.188	.203	.219	.281	.344	.406	.438	.531	.563	.688	.875	1.125	1.375	1.750	2.188	2.188	3.5	4.5	5.5	6.875
		ir = Inside Bend Radius																				
inches		.031	.031	.047	.047	.063	.078	.094	.109	.125	.141	.156	.203	.250	.313	.406	.516	.625	.75	1.031	1.313	1.625
		F = Tons per 1 foot																				
20	.036	5.4	3.6	3.0	2.5	2.0	1.7															
18	.048		6.8	5.8	4.8	3.7	2.7	2.4	2.0													
16	.06				7.8	6.2	5.0	4.2	3.5	3.1	2.7											
14	.075					11.0	8.2	7.0	5.5	4.8	4.1	3.1										
12	.105						15.0	13.0	11.0	9.4	7.4	5.5	4.0									
11	.12								16.0	13.0	10.0	7.3	5.0	3.8								
10	.135										12.0	9.0	6.2	4.7	3.5							
.188	.188											24.0	15.0	11.0	7.5	5.7						
.250	.25												30.0	20.0	14.0	10.5	8.5					
.313	.313													36.0	25.0	18.0	13.0	10.0				
.375	.375														38.0	28.0	20.0	15.0	11.0			
.5	.5															52.0	39.0	30.0	22.0	16.0		
.625	.625																70.0	52.0	38.0	27.0	20.0	15.0
.75	.750																		66.0	43.0	32.0	22.0
1.0	1.0																			90.0	61.0	44.0
1.25	1.25																				102.0	70.0

↑ ↑ t = material thickness	
Gauge	Dec.

Die Opening Selection Formula

t	Gauge	12 or less	11 - 5/16"	3/8 - 1/2"	5/8" and up
	Inches	.105 or less	.120 - .313	.375 - .5	.625 and up
"V" Size		6 x t	8 x t	10 x t	12 x t