



Greenway & Associates
 3811 450th St | Orange City, IA 51041
 800-742-4457 | www.greenwayassoc.com

TONNAGE CHART

Press Brake Bending

THICKNESS OF METAL		PRESSURE IN TONS PER LINEAR FOOT REQUIRED TO MAKE 90 DEGREE AIR BEND IN MILD STEEL																							
		WIDTH OF FEMALE DIE OPENING																							
GAUGE	INCHES	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	7/8"	1"	1.125"	1.25"	1.5"	2	2.5"	3"	3.5"	4"	5"	6"	7"	8"	10"	12"		
20	0.036	2.9	2.2	1.7	1.2	1.0																			
18	0.048		4.0	2.9	2.2	1.6	1.3																		
16	0.060			5.6	3.6	2.7	2.2	1.7																	
14	0.075				6.0	4.5	3.4	3.0	2.5	2.1															
13	0.090					6.8	5.4	4.3	3.7	3.3	2.9														
12	0.105					10.1	7.4	6.3	5.4	4.4	4.0	3.2													
11	0.120						10.5	8.8	7.2	6.2	5.4	4.3	3.2												
10	0.135							11.3	9.6	8.4	7.0	5.6	4.1												
9	0.150								13.1	11.9	9.0	6.7	5.2	3.5											
7	0.188									16.4	14.0	11.2	7.6	5.8	4.5										
1/4	0.250										28.8	22.0	15.3	11.5	9.1	7.5	6.2								
5/16	0.312											38.0	26.0	19.2	16.0	12.5	10.6	7.6							
3/8	0.375												41.0	29.9	24.0	19.4	16.0	12.3							
7/16	0.437													45.2	35.0	28.0	24.0	17.0	14.6	11.1					
1/2	0.500														47.9	39.0	33.1	24.0	19.0	15.6	12.7				
5/8	0.625															69.5	58.0	42.2	32.4	26.0	23.0	16.5			
3/4	0.750																92.0	69.0	52.2	42.2	36.0	27.0	21.0		
7/8	0.875																	104.0	80.0	63.0	52.5	39.4	31.2		
1"	1.000																		112.2	90.0	76.0	56.2	44.0		
AIR FORM RADIUS		1/32	3/64	1/16	5/64	3/32	1/8	9/64	5/32	11/64	3/16	15/64	5/16	25/64	15/32	35/64	5/8	25/32	15/16	1.09"	1.25"	1.56"	1.87"		
MIN. FLANGE INS. DIM.		3/16	7/32	1/4	5/16	7/16	1/2	9/16	5/8	11/16	3/4	15/16	1.188"	1.438"	1.75"	2"	2.25"	2.75"	3.38"	4"	4.5"	5.5"	6.5"		
PRESSURES IN RED ARE FOR DIES WITH FEMALE OPENINGS APPROX. 8 X METAL THICKNESS WITH RADIUS ON MALE DIE EQUAL TO METAL THICKNESS AND ARE CONSIDERED IDEAL FOR RIGHT ANGLE BENDING																									
BENDING PRESSURES REQUIRED FOR OTHER METALS AS COMPARED TO 60,000 PSI TENSILE MILD STEEL ON CHART:																									
SOFT BRASS: 50% OF PRESSURE LISTED												STAINLESS STEEL: 50% MORE THAN STEEL													
SOFT ALUMINUM: 50% OF PRESSURE LISTED												CHROME MOLYBDENUM: 100% MORE THAN STEEL													
ALUMINUM ALLOYS (HEAT TREATED): SAME AS STEEL												A36: 30% MORE THAN STEEL													