

PRESS BRAKE FORMING TONNAGE (MILD STEEL)										
SHAPE	TYPE OF BEND	26 GA; 0.018	24 GA; 0.024	22 GA; 0.030	21 GA; 0.033	20 GA; 0.036	19 GA; 0.042	18 GA; 0.048	16 GA; 0.060	
V	90° BOTTOM (150T)	2.7 0.225	3.6 0.3	4.5 0.375	5 0.417	5.4 0.45	6.3 0.525	7.2 0.6	9 0.75	TONS PER FOOT TONS PER INCH
	90° AIR (60T)	1.1 0.092	1.4 0.117	1.8 0.15	2 0.167	2.2 0.183	2.5 0.208	2.9 0.242	3.6 0.3	TONS PER FOOT TONS PER INCH
V	90° RIB R = SHARP TOT	10.8 0.9	14.4 1.2	18 1.5	19.8 1.65	21.6 1.8	25.2 2.1	28.8 2.4	36 3	TONS PER FOOT TONS PER INCH
	90° RIB R=2T+ (200T)	3.6 0.3	4.8 0.4	6 0.5	6.6 0.55	7.2 0.6	8.4 0.7	9.6 0.8	12 1	TONS PER FOOT TONS PER INCH
V	RADIUS (180T)	3.2 0.267	4.3 0.358	5.4 0.45	5.9 0.492	6.5 0.542	7.6 0.833	8.6 0.717	10.8 0.9	TONS PER FOOT TONS PER INCH
	OFFSET (500T)	9 0.75	12 1	15 1.25	16.5 1.375	18 1.5	21 1.75	24 2	30 2.5	TONS PER FOOT TONS PER INCH
V	MATERIAL THICKNESS	10.8	14.4	18	19.8	21.6	25.2	28.8	36	TONS PER FOOT
	OFFSET (600T)	0.9	1.2	1.5	1.65	1.8	2.1	2.4	3	TONS PER INCH
V	CHANNEL (300T)	5.4 0.45	7.2 0.6	9 0.75	9.9 0.825	10.8 0.9	12.6 1.05	14.4 1.2	18 1.5	TONS PER FOOT TONS PER INCH
	HAT CHANNEL (600T)	10.8 0.9	14.4 1.2	18 1.5	19.8 1.65	21.6 1.8	25.2 2.1	28.8 2.4	36 3	TONS PER FOOT TONS PER INCH
V	OPEN HAT CHANNEL (450T)	8.1 0.675	10.8 0.9	13.5 1.125	14.9 1.242	16.2 1.35	18.9 1.575	21.6 1.8	27 2.25	TONS PER FOOT TONS PER INCH
	WIPE (250T)	4.5 0.375	6 0.5	7.5 0.625	8.2 0.688	9 0.75	10.5 0.875	12 1	15 1.25	TONS PER FOOT TONS PER INCH
V	SINGLE FORM (200T)	3.6 0.3	4.8 0.4	6 0.5	6.6 0.55	7.2 0.6	8.4 0.7	9.6 0.8	12 1	TONS PER FOOT TONS PER INCH
	DOUBLE FORM (300T)	5.4 0.45	7.2 0.6	9 0.75	9.9 0.825	10.8 0.9	12.6 1.05	14.4 1.2	18 1.5	TONS PER FOOT TONS PER INCH
V	CLOSING (200T)	3.6 0.3	4.8 0.4	6 0.5	6.6 0.55	7.2 0.6	8.4 0.7	9.6 0.8	12 1	TONS PER FOOT TONS PER INCH

SHAPE	TYPE OF BEND	15 GA; 0.067	14 GA; 0.075	13 GA; 0.090	12 GA; 0.105	11 GA; 0.120	10 GA; 0.134	7 GA; 0.179	
V	90° BOTTOM (150T)	10.1 0.842	11.2 0.933	13.5 1.125	15.8 1.317	18 1.5	20.1 1.675	26.9 2.242	TONS PER FOOT TONS PER INCH
	90° AIR (60T)	4 0.333	4.5 0.375	5.4 0.45	6.3 0.525	7.2 0.6	8 0.667	10.7 0.892	TONS PER FOOT TONS PER INCH
V	90° RIB R = SHARP TOT	40.2 3.35	45 3.75	54 4.5	63 5.25	72 6	80.4 6.7	107.4 8.95	TONS PER FOOT TONS PER INCH
	90° RIB R=2T+ (200T)	13.4 1.117	15 1.25	18 1.5	21 1.75	24 2	26.8 2.233	35.8 2.983	TONS PER FOOT TONS PER INCH
V	RADIUS (180T)	12.1 1.008	13.5 1.125	16.2 1.35	18.9 1.575	21.6 1.8	24.1 2.008	32.2 2.653	TONS PER FOOT TONS PER INCH
	OFFSET (500T)	33.5 2.732	37.5 3.125	45 3.75	52.5 4.375	60 5	67 5.533	89.5 7.453	TONS PER FOOT TONS PER INCH
V	MATERIAL THICKNESS	40.2	45	54	63	72	80.4	107.4	TONS PER FOOT
	OFFSET (600T)	3.25	3.75	4.5	5.25	6	6.7	8.95	TONS PER INCH
V	CHANNEL (300T)	20.1 1.675	22.5 1.875	27 2.25	31.5 2.025	36 3	40.2 3.35	53.7 4.475	TONS PER FOOT TONS PER INCH
	HAT CHANNEL (600T)	40.2 3.35	45 3.75	54 4.5	63 5.25	72 6	80.4 6.7	107.4 8.95	TONS PER FOOT TONS PER INCH
V	OPEN HAT CHANNEL (450T)	30.2 2.517	33.8 2.817	40.5 3.375	47.2 3.933	54 4.5	60.3 5.025	80.6 6.717	TONS PER FOOT TONS PER INCH
	WIPE (250T)	16.8 1.4	18.8 1.567	22.5 1.875	26.2 2.183	30 2.5	33.5 2.792	44.8 3.733	TONS PER FOOT TONS PER INCH
V	SINGLE FORM (200T)	13.4 1.117	15 1.25	18 1.5	21 1.75	24 2	26.8 2.233	35.8 2.983	TONS PER FOOT TONS PER INCH
	DOUBLE FORM (300T)	20.1 1.675	22.5 1.875	27 2.25	31.5 2.625	36 3	40.2 3.35	53.7 4.475	TONS PER FOOT TONS PER INCH
V	CLOSING (200T)	13.4 1.117	15 1.25	18 1.5	21 1.75	24 2	26.8 2.233	35.8 2.983	TONS PER FOOT TONS PER INCH