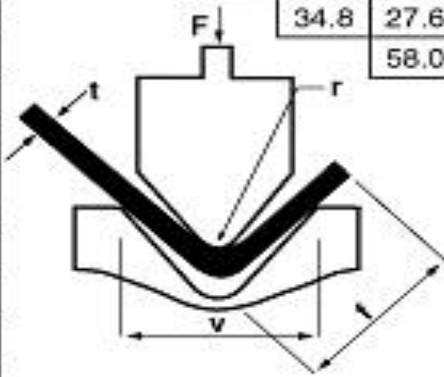


JR Machinery Press Brake Tonnage Chart

Shaded areas are recommended v-opening

Force to Air-Bend Mild Steel (60,000 PSI)																			
F = U.S. tons/lineal ft. of workpiece																			
All Dimensions in Inches																			
t	v	1/4	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	5	6	8	10	v	
	f	3/16	9/32	11/32	7/16	9/16	11/16	7/8	1 1/8	1 3/8	1 3/4	2 3/16	2 13/16	3 1/2	4 1/2	5 1/2	6 7/8	f	
ga.	r	1/32	1/16	5/64	7/64	9/64	5/32	13/64	1/4	5/16	13/32	33/64	5/8	3/4	1 1/32	15/16	15/8	ga.	
20	0.036	3.1	1.75	1.2															20
18	0.048	5.4	3.1	2.1	1.55	1.3	F Values												18
16	0.060	9.6	5.5	3.8	2.8	2.2	1.45											16	
14	0.075		9.3	6.4	4.7	3.8	2.5	1.85									14		
12	0.105		20.5	14.0	10.4	8.1	5.6	4.1	3.2	2.2						12			
11	0.120			18.5	13.9	10.9	7.4	5.6	4.3	2.9	2.15					11			
10	0.135			25.2	17.2	14.5	9.9	7.3	5.7	3.8	2.85	2.23				10			
3/16	0.188				34.8	27.6	19.1	13.9	11.0	7.5	5.6	4.3				3/16			
1/4	0.250					58.0	39.5	29.0	22.8	15.5	11.4	8.9	6.1	4.5			1/4		
5/16	0.313						69.5	51.0	40.0	27.0	20.0	15.6	10.5	7.8	6.1			5/16	
3/8	0.375							75.0	59.0	40.0	29.5	23.4	15.8	11.7	9.2	6.2	4.6	3/8	
7/16	0.438							115.0	90.0	61.0	45.5	35.2	24.0	17.8	13.9	9.4	6.9	7/16	
1/2	0.500									85.0	62.0	44.3	33.0	24.5	19.1	13.0	9.8	1/2	
5/8	0.625										86.0	58.0	43.0	34.0	23.2	17.5	5/8		
3/4	0.750											91.0	67.0	53.0	36.4	26.7	3/4		
7/8	0.875												136.0	101.0	79.0	54.0	40.0	7/8	
1	1.000													146.0	115.0	68.0	58.0	1	



t = Workpiece thickness
 r = Inside radius of formed part
 v = Vee-die opening
 f = Minimum flange

Shaded area to 1/2" material thickness are 8 times material thickness.

When using material 1/2" and thicker, it is usual practice to have v-opening 10 times material thickness

Approximate tons per lineal foot of forming – based on air bending 90 degree bend in mild steel