
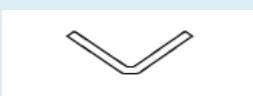


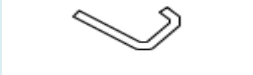
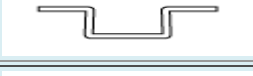


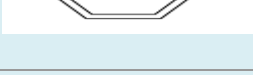
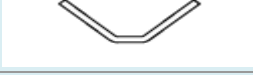
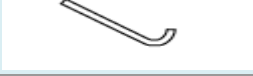





JR Machinery Press Brake Shape Chart

Multiply metal thickness by factor shown. This will equal approximate tons / foot for bend.
For shape as shown in mild steel with radii equal to the metal thickness

Shape	Type of Bend	Air Form	Bottoming
	90° Rib Form	200	600
	90° Bottom / V Bottom	60	150
	Channel	225	300
	Closing	-----	300
	Double Form	----	450
	Hat Channel	-----	600
	M.T. Offset	300	600
	Offset	150	300/600
	Open Hat Channel	300	450
	Radius	-----	180/300
	Single Form	-----	200
	Wipe Die	-----	250
HEM	Open Hem	150	420- closed
Shape Considerations		Large Radii, angle variation, Concave or convex sides	Mat'l thickness, radii, min. angle variation, maintain flatness
Multipliers: Type 304 stainless : x 1.55 Aluminum 5052-H34 : x .65 Aluminum 6061-T6 : x .75			