

FOREMOST BANTAM

PRESS BRAKE

TONNAGE CHART

PRESSURE REQUIREMENTS IN TONS PER LINEAR FOOT TO MAKE 90 DEGREE AIR BENDS

GA. INCH		WIDTH OF FEMALE DIE OPENING																				
		1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	7/8"	1"	1-1/8"	1-1/4"	1-1/2"	2"	2-1/2"	3"	3-1/2"	4"	5"	6"	7"	8"	
20	.036"	1.5	1.1	0.9	0.6	0.5																
		2.9	2.2	1.7	1.2	1.0																
		4.4	3.3	2.6	1.8	1.5																
18	.048"		2.0	1.5	1.1	0.8	0.7															
			4.0	2.9	2.2	1.6	1.3															
			6.0	4.4	3.3	2.4	2.0															
16	.060"			2.8	1.8	1.4	1.1	0.9														
					5.6	3.6	2.7	2.2	1.7													
					8.4	5.4	4.1	3.3	2.6													
14	.075"				3.0	2.3	1.7	1.5	1.3	1.1												
					6.0	4.5	3.4	3.0	2.5	2.1												
					9.0	6.8	5.1	4.5	3.8	3.2												
13	.090"					3.4	2.7	2.2	1.9	1.7	1.5											
						6.8	5.4	4.3	3.7	3.3	2.9											
						10.2	8.1	6.5	5.6	5.0	4.4											
12	.105"					5.1	3.7	3.2	2.7	2.2	2.0	1.6										
						10.1	7.4	6.3	5.4	4.4	4.0	3.2										
						15.2	11.1	9.5	8.1	6.6	6.0	4.8										
11	.120"					5.3	4.4	3.6	3.1	2.7	2.2	1.6										
						10.5	8.8	7.2	6.2	5.4	4.3	3.2										
						15.8	13.2	10.8	9.3	8.1	6.5	4.8										
10	.135"							5.7	4.8	4.2	3.5	2.8	2.1									
								11.3	9.6	8.4	7.0	5.6	4.1									
								17.0	14.4	12.6	10.5	8.4	6.2									
9	.150"							6.6	6.0	4.5	3.4	2.6	1.8									
								13.1	11.9	9.0	6.7	5.2	3.5									
								19.7	17.9	13.5	10.1	7.8	5.3									
7	.188"								8.2	7.0	5.6	3.8	2.9	2.3								
									16.4	14.0	11.2	7.6	5.8	4.5								
									24.6	21.0	16.8	11.4	8.7	6.8								
1/4"	.250"								14.4	11.0	7.7	5.8	4.6	3.8	3.1							
									28.8	22.0	15.3	11.5	9.1	7.5	6.2							
									43.2	33.0	23.0	17.3	13.7	11.3	9.3							
5/16"	.312"										19.0	13.0	9.6	8.0	6.3	5.3	3.8					
											38.0	26.0	19.2	16.0	12.5	10.6	7.6					
											57.0	39.0	28.8	24.0	18.8	15.9	11.4					
3/8"	.375"										20.5	15.0	12.0	9.7	8.0	6.2	4.7					
											41.0	29.9	24.0	19.4	16.0	12.3	9.3					
											61.5	44.9	36.0	29.1	24.0	18.5	14.0					
7/16"	.487"												22.6	17.5	14.0	12.0	8.5	7.3	5.6			
													45.2	35.0	28.0	24.0	17.0	14.6	11.1			
													67.8	52.5	42.0	36.0	25.5	21.9	16.7			
1/2"	.500"													24.0	19.5	16.6	12.0	9.5	7.8	6.4		
														47.9	39.0	33.1	24.0	19.0	15.6	12.7		
														71.9	58.5	49.7	36.0	28.5	23.4	19.1		
APPROX. INSIDE 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"	1-3/32"	1-1/4"	
MINIMUM INSIDE FLANGE		3/16"	7/32"	1/4"	5/16"	7/16"	1/2"	9/16"	5/8"	11/16"	3/4"	15/16"	1-3/16"	1-7/16"	1-3/4"	2"	2-1/4"	2-3/4"	3-3/8"	4"	4-1/2"	

= soft aluminum & brass (30,000 psi)
 = mild steel & aluminum alloys (60,000 psi)
 = stainless steel (90,000 psi)
 (figure is in tons per linear foot)

MATERIAL THICKNESS

Shaded areas are for dies with female openings approximately 8 times the material thickness, and with the radius on the top punch equal to the material thickness. These conditions are considered ideal for 90 degree air bending.