

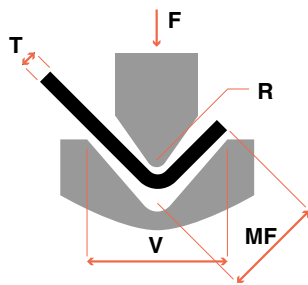
Force to air-bend mild steel

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	
	MF	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	
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	1 5/16	1 5/8	
20	.036	3.1	1.75	1.2														
18	.048	5.4	3.1	2.1	1.55	1.3		F Values										
16	.060	9.6	5.5	3.8	2.8	2.2	1.45											
14	.075		9.3	6.4	4.7	3.8	2.5	1.85										
12	.105		20.5	14.0	10.4	8.1	5.6	4.1	3.2	2.2								
11	.120			18.5	13.9	10.9	7.4	5.6	4.3	2.9	2.15							
10	.135			25.2	17.2	14.5	9.9	7.3	5.7	3.8	2.85	2.23						
3/16	.188				34.8	27.6	19.1	13.9	11.0	7.5	5.6	4.3						
1/4	.250					58.0	39.5	29.0	22.8	15.5	11.4	8.9	6.1	4.5				
5/16	.313						69.5	51.0	40.0	27.0	20.0	15.6	10.5	7.8	6.1			
3/8	.375							75.0	61.0	40.0	29.5	23.4	15.8	11.7	9.2	6.2	4.6	
7/16	.438								115.0	85.0	61.0	45.5	35.2	24.0	17.8	13.9	9.4	6.9
1/2	.500									85.0	62.0	44.3	33.0	24.5	19.1	13.0	9.8	
5/8	.625											86.0	58.0	43.0	34.0	23.2	17.5	
3/4	.750												91.0	67.0	53.0	36.4	26.7	
7/8	.875													136.0	101.0	79.0	54.0	40.0
1	1.00														146.0	115.0	68.0	58.0

For steel of different tensile strength, F value differs in proportion to strength ratio.

Inside radius for mild steel is about 5/32 of female die opening

Shaded F values are for V = 8t, common for average 90° bending. For T ≥ 1/2" use V = 10t



F: US ton/linear ft. T: Workpiece thickness R: Inside radius of form V: Vee-die opening MF: Minimum flange

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PO Box 1789

Riverview FL, 33569

P: 813.444.4555

F: 813.333.0450

