

MILD STEEL AIR BEND CAPACITY CHART

Mild Steel	Vee Die Opening Nominal Inches	Tons (2,000lb) Per Foot	LINEAR FEET											
			Mechanical Press Brakes - Standard Stroke Only											
			5	5AC	9	9AC	12	12AC	13	13AC	21	34	36	50
			90/135	90/135	150/225	150/225	200/300	200/300	260/400	260/400	400/600	520/750	650/1000	1000/1500
(20 GA) 0.036	0.250	3.10	40.3	40.3	67.1	67.1	89.5	89.5	-	-	-	-	-	-
	0.312	2.30	54.3	54.3	90.5	90.5	-	-	-	-	-	-	-	-
	0.375	1.70	73.4	73.4	-	-	-	-	-	-	-	-	-	-
	0.438	1.40	89.1	89.1	-	-	-	-	-	-	-	-	-	-
	0.500	1.10	-	-	-	-	-	-	-	-	-	-	-	-
	0.625	0.09	-	-	-	-	-	-	-	-	-	-	-	-
(18 GA) 0.048	0.250	5.3	23.6	23.6	39.3	39.3	52.3	52.3	69.8	69.8	-	-	-	-
	0.312	4.0	31.2	31.2	52.0	52.0	69.4	69.4	92.5	92.5	-	-	-	-
	0.375	3.0	41.6	41.6	69.4	69.4	92.6	92.6	-	-	-	-	-	-
	0.438	2.5	50.0	50.0	83.3	83.3	-	-	-	-	-	-	-	-
	0.500	2.2	56.7	56.7	94.6	94.6	-	-	-	-	-	-	-	-
	0.625	1.7	73.4	73.4	-	-	-	-	-	-	-	-	-	-
	0.750	1.3	-	-	-	-	-	-	-	-	-	-	-	-
(16 GA) 0.060	0.375	5.6	22.3	22.3	37.2	37.2	49.6	49.6	66.1	66.1	99.1	-	-	-
	0.438	4.5	27.8	27.8	46.3	46.3	61.7	61.7	82.2	82.2	-	-	-	-
	0.500	3.8	32.0	32.0	54.8	54.8	73.0	73.0	-	-	-	-	-	-
	0.625	2.8	44.6	44.6	74.3	74.3	-	-	-	-	-	-	-	-
	0.750	2.2	56.7	56.7	94.6	94.6	-	-	-	-	-	-	-	-
	0.875	1.8	69.4	69.4	-	-	-	-	-	-	-	-	-	-
	1.000	1.5	83.3	83.3	-	-	-	-	-	-	-	-	-	-
(14 GA) 0.075	0.438	7.6	16.4	16.4	27.4	27.4	36.5	36.5	48.7	48.7	73.0	-	-	-
	0.500	6.3	19.8	19.8	33.0	33.0	44.0	44.0	58.7	58.7	88.1	-	-	-
	0.625	4.7	26.0	26.0	44.3	44.3	59.0	59.0	78.7	78.7	-	-	-	-
	0.750	3.5	35.7	35.7	59.5	59.5	79.3	79.3	-	-	-	-	-	-
	0.875	3.0	41.6	41.6	69.4	69.4	-	-	-	-	-	-	-	-
	1.000	2.5	50.0	50.0	83.3	83.3	-	-	-	-	-	-	-	-
	1.125	2.1	59.5	59.5	-	-	-	-	-	-	-	-	-	-
(12 GA) 0.105	1.250	1.8	69.4	69.4	-	-	-	-	-	-	-	-	-	-
	0.625	9.7	12.9	12.9	21.5	21.5	28.6	28.6	38.1	38.1	57.2	71.5	-	-
	0.750	8.0	15.6	15.6	26.0	26.0	34.7	34.7	46.3	46.3	69.4	-	-	-
	0.875	6.5	19.0	19.0	32.0	32.0	42.7	42.7	56.9	56.9	85.3	-	-	-
	1.000	5.6	22.3	22.3	37.2	37.2	49.6	49.6	66.1	66.1	-	-	-	-
	1.125	4.6	27.1	27.1	45.2	45.2	60.3	60.3	80.4	80.4	-	-	-	-
	1.250	4.1	30.5	30.5	50.8	50.8	67.7	67.7	-	-	-	-	-	-
(11 GA) 0.120	1.500	3.2	38.4	39.0	65.0	65.0	86.7	86.7	-	-	-	-	-	-
	2.000	2.3	40.2	53.5	90.4	90.4	-	-	-	-	-	-	-	-
	0.750	11.1	11.3	11.3	18.8	18.8	25.0	25.0	33.3	33.3	50.0	63.0	83.3	-
	0.875	9.0	13.9	13.9	23.1	23.1	30.8	30.8	41.1	41.1	61.7	77.1	-	-
	1.000	7.5	16.7	16.7	27.8	27.8	37.0	37.0	49.3	49.3	74.0	-	-	-
	1.125	6.3	19.8	19.8	33.0	33.0	44.0	44.0	58.7	58.7	88.1	-	-	-
	1.250	5.5	22.7	22.7	37.8	37.8	50.5	50.5	67.3	67.3	-	-	-	-
(10 GA) 0.135	1.500	4.4	27.9	28.4	47.3	47.3	63.1	63.1	84.1	84.1	-	-	-	-
	2.000	2.9	31.9	42.4	71.7	71.7	-	-	-	-	-	-	-	-
	0.875	11.9	10.5	10.5	17.5	17.5	23.3	23.3	31.1	31.1	46.6	58.3	77.7	-
	1.000	9.9	12.6	12.6	21.0	21.0	28.0	28.0	37.4	37.4	56.1	70.1	-	-
	1.125	8.5	14.0	14.0	25.0	25.0	32.0	32.0	43.5	43.5	65.3	-	-	-
	1.250	7.3	17.1	17.1	28.5	28.5	38.0	38.0	50.7	50.7	76.0	-	-	-
	1.500	5.8	21.2	21.5	35.9	35.9	47.8	47.8	63.8	63.8	-	-	-	-
0.188	2.000	4.0	23.1	30.8	52.0	52.0	69.4	69.4	92.4	92.4	-	-	-	-
	2.500	3.1	25.3	31.8	57.0	57.0	88.8	88.8	-	-	-	-	-	-
	1.125	16.4	7.6	7.6	12.7	12.7	16.9	16.9	22.6	22.6	33.8	42.3	56.4	84.6
	1.250	14.3	8.7	8.7	14.6	14.6	19.4	19.4	25.9	25.9	38.8	48.5	64.7	-
	1.500	11.2	11.0	12.0	19.0	19.0	25.0	25.0	34.0	34.0	49.6	61.9	82.6	-
0.250	2.000	7.5	12.3	16.4	27.8	27.8	37.0	37.0	49.3	49.3	74.0	92.4	-	-
	2.500	5.7	13.8	17.3	31.0	31.0	48.3	48.3	62.3	62.3	-	-	-	-
	3.000	4.4	14.0	18.6	32.7	40.9	60.0	60.0	70.9	70.9	-	-	-	-
	1.250	29.5	4.2	4.2	7.1	7.1	9.4	9.4	12.5	12.5	18.8	23.5	31.3	47.0
	1.500	22.7	5.5	5.5	9.2	9.2	12.2	12.2	16.3	16.3	24.4	30.6	40.7	61.1
	2.000	15.4	6.0	8.0	13.0	14.0	18.0	18.0	24.0	24.0	36.0	45.0	60.0	90.1
	2.500	11.4	6.5	8.6	15.5	15.5	24.2	24.2	31.0	31.0	46.6	60.9	81.0	-
0.250	3.000	9.0	6.8	9.1	16.0	20.0	29.3	29.3	34.7	34.7	56.0	74.6	-	-
	3.500	7.4	7.1	9.5	16.7	20.8	31.1	31.1	40.5	40.5	58.4	-	-	-
	4.000	6.1	7.4	10.0	17.6	22.0	32.7	32.7	43.7	45.9	65.6	-	-	-

* Press Brake tonnage capacity at mid stroke and near bottom of stroke. Series 5AC, 9AC and 13AC tonnage capacity ratings listed are for low speed operation.