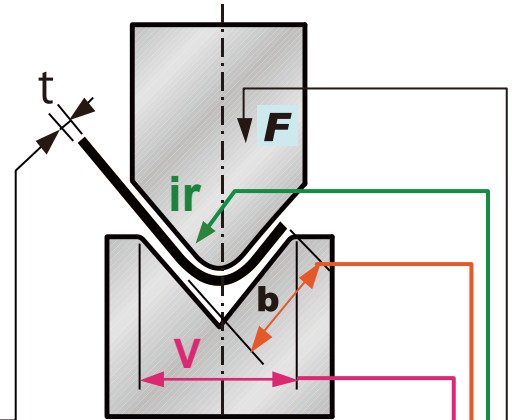


# How to Read Tonnage Chart

The chart can be useful when the material thickness and iR (product inner radius) are known.

1. Required tonnage to bend 1mm long material ( F )
2. Die's V width ( V-opening ) mm ( V )
3. Minimum flange length to bend mm ( b )



Thickness (t) mm	0.5 ~ 2.6	3.0 ~ 8	9 ~ 10	12 more
V width mm	6 × t	8 × t	10 × t	12 × t

SPCC : tensile strength 450 - 500 N/mm<sup>2</sup>

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V		
	2.8	4	5.0	5.5	7	8.5	10	11	13	14	17.5	22	28	35	45	57	71	89	113	140	175	b		
	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir		
0.5	40	30																						
0.6	60	40	40	40																				
0.8		70	70	50	40																			
1.0		110	100	80	70	60																		
1.2			140	120	100	80	70	60																
1.4				150	130	110	100	90	80															
1.6					170	150	130	110	100	90														
2.0						220	190	170	150	130	110													
2.3							250	230	190	170	150	120												
2.6								280	250	220	180	140												
3.0									340	300	240	190	150											
3.2										340	270	220	170	140										
3.5											330	260	200	160	130									
4.0												430	340	270	210	170								
4.5													440	340	270	210								
5.0														520	420	330	260	210						
6															600	480	380	300	240					
7																520	410	330	260					
9																	670	540	430					
10																		850	670	530	420			
12																			960	780	600	550		
16																				1360	1070	860		
19																					1500	1250	1000	
22																						1600	1300	
25																							2100	1700
30																								2400

**t** Material thickness (mm)  
(Tensile strength 450-500N/mm<sup>2</sup>)

**F** Pressure per meter (kN/m)

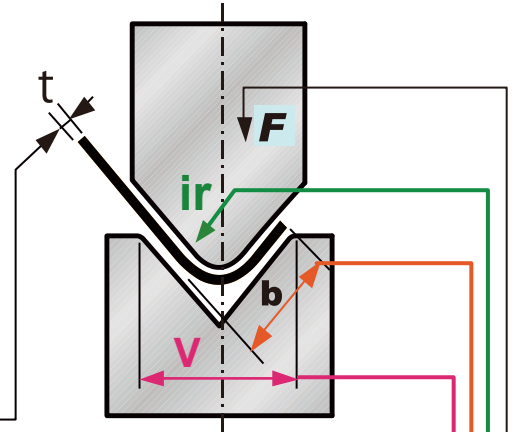
**ir** Inner bent radius (mm)

**b** Min. flange length (mm)

**V** Die opening (mm)

# How to Read Tonnage Chart

Thickness (t) mm	0.5 ~ 2.6	3.0 ~ 8	9 ~ 10	12 more
V width mm	6 × t	8 × t	10 × t	12 × t



Stainless steel : tensile strength 520 - 600 N/mm<sup>2</sup>

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	v	
t	2.8	4	5.0	5.5	7	8.5	10	11	13	14	17.5	22	28	35	45	57	71	89	113	140	175	b	
t	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir	
0.5	60	50																					
0.6	90	60	60	60																			
0.7	120	80	80	60	60																		
0.8		110	110	80	60																		
0.9		130	120	100	90	70																	
1.0		170	150	120	110	90																	
1.2			210	180	150	120	110	90															
1.5				290	230	200	170	150	130	120													
2.0					330	290	260	230	200	170													
2.5							390	350	300	250	190												
3.0								510	450	360	290	230											
4.0										650	510	410	320	260									
5.0											780	630	500	390	320								
6												900	720	570	450	360							
8														1020	810	650	510						
10															1280	1010	800	630					
12																1440	1170	900	830				
15																	1800	1410	1140				
20																		2500	2080	1670			
25																				3150	2550		
30																						3600	

**t** Material thickness (mm)  
 (Tensile strength 520-600N/mm<sup>2</sup>)  
**F** Pressure per meter (kN/m)  
**ir** Inner bent radius (mm)  
**b** Min. flange length (mm)  
**V** Die opening (mm)