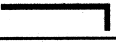
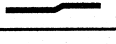
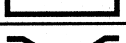
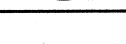


SHAPE	DESCRIPTION	AIRFORM	BOTTOMING
	VEE DIE	60	150
	WIPING	—	250
	OFFSET	150	300/600
	MTL. THK. OFFSET	300	600
	CHANNEL	225	300
	VEE RIB	200	600
	W DIE	300	600
	OPEN HAT CHANNEL	300	450
	SQ. HAT CHANNEL	—	600
	PERFORM CURL	—	300
	PERFORM CURL	—	200
	CLOSE CURL	—	300
	RADIUS	—	180/300
SHAPE CONSIDERATIONS		Large Radi Angle Variation Concave or Convex Slides	Mat'l. Thk. Radi Min. Angle Variation Maintain Flatness

PRESS BRAKE MULTIPLE BEND CHART

RULE OF THUMB formula for making multiple bends on a press brake. For shape shown, in **mild steel** with radii equal to metal thickness unless otherwise noted.

Multiply Metal Thickness by factor = Tons per Foot

MATERIAL MODIFIERS

Stainless Steel x 1.55

Aluminum

3303-H14 (1/2 hard) x .35

5052-H34 (1/2 hard) x .65

6061-T6 x .75