## Tonnage Chart

Force required in tons per foot to air bend 60,000 PSI tensile strength mild steel. Adjust proportionally for tensile strength of other materials or bend type.

### Tensile Strength

<table>
<thead>
<tr>
<th>Multiplier:</th>
<th>Soft Aluminum &amp; Brass - .50</th>
<th>Aluminum Alloys - .75</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/2 Hard Brass</td>
<td>1.25</td>
<td>Stainless Steel - 1.50</td>
</tr>
</tbody>
</table>

### Bend Multiplier

<table>
<thead>
<tr>
<th>Bend Type</th>
<th>Multiplier</th>
<th>Bend Type</th>
<th>Multiplier</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bottom Bend</td>
<td>2.5</td>
<td>Material Thickness Offset</td>
<td>5 to 10</td>
</tr>
<tr>
<td>Large Radius</td>
<td>3 to 5</td>
<td>Large Offset</td>
<td>2.5 to 10</td>
</tr>
<tr>
<td>Teardrop Hem</td>
<td>3.75</td>
<td>3-Bend 'W' Die</td>
<td>5 to 10</td>
</tr>
<tr>
<td>Flat Hem</td>
<td>5</td>
<td>3-Bend 'V' Vee</td>
<td>3.5 to 10</td>
</tr>
<tr>
<td>2-Bend U-Channel</td>
<td>5</td>
<td>Half Round Rib</td>
<td>6</td>
</tr>
<tr>
<td>4-Bend Hat Channel</td>
<td>5 to 10</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>