TONNAGE REQUIREMENTS

SAFETY WARNING

We do all we can to supply dies that will produce material that fits specification. Since we have no control over how the dies are actually put to use, it must be understood that it is the user who has the responsibility of making certain that a proper application with due regard to safety in operation is followed. Safety and industrial standards must be considered to insure that point of operation protection is effective.

Our dies are never intended to be used in equipment without a means provided for preventing hands or other parts of the body from entering or remaining in the die space at any time.

When using brake die tooling compliance with all safety requirements as outlined by the American National Standards Institute Bulletin A.N.S.I. #B11-3 as well as all other local, state, and federal standards which may apply, should be adhered to.

A copy of ANSI #B11-3 may be obtained from American National Standards Institute Inc. at 1430 Broadway, N.Y., N.Y. 10018.

PRESS BRAKE MULTIPLE BEND ALLOWANCES

RULE OF THUMB

Formula for making multiple bends on press brake. For shape as shown, in mild steel with radii equal the metal thickness unless otherwise noted.

Multiply Metal Thickness By Factor = Tons Per Ft.

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

Stainless Steel	(18-8 Annealed) Type 304	1.55
Aluminum	3303-H14 (1/2 Hard)	.35
	5052-H34 (1/2 Hard)	.65
	6061-T64	.75
Brass	70/30 (1/2 Hard)	1.10

SEE SAFETY WARNINGS ON INSIDE FRONT COVER