

BEND CHART FOR MILD STEEL (450-500 MPA TENSILE STRENGTH)

THICKNESS		4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	MM	DIE SIZE	
		0.157	0.236	0.276	0.315	0.394	0.472	0.551	0.630	0.709	0.787	0.984	1.260	1.575	1.969	2.480	3.150	3.937	4.921	6.299	7.874	9.843	IN		
		2.8	4	5	5.5	7	8.5	10	11	13	14	17.5	22	28	35	45	57	71	89	113	140	175	MM	MINIMUM FLANGE	
		0.110	0.157	0.197	0.217	0.276	0.335	0.394	0.433	0.512	0.551	0.689	0.866	1.102	1.378	1.772	2.244	2.795	3.504	4.449	5.512	6.890	IN		
		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	MM	INSIDE RADIUS	
MM	IN	0.028	0.039	0.043	0.051	0.063	0.079	0.091	0.102	0.118	0.130	0.157	0.197	0.256	0.315	0.394	0.512	0.630	0.787	1.024	1.299	1.614	IN		
0.5	0.020	40	30																				kN/m	FORCE	
		1.4	1.0																						Tons/ft
0.6	0.024	60	40	40	40																		kN/m		
		2.1	1.4	1.4	1.4																				Tons/ft
0.8	0.031		70	70	50	40																	kN/m		
			2.4	2.4	1.7	1.4																			Tons/ft
1.0	0.039		110	110	80	70	60																kN/m		
			3.8	3.8	2.7	2.4	2.1																		Tons/ft
1.2	0.047			140	120	100	80	70	60														kN/m		
				4.8	4.1	3.4	2.7	2.4	2.1																Tons/ft
1.4	0.055				150	130	110	100	90	80													kN/m		
					5.1	4.5	3.8	3.4	3.1	2.7															Tons/ft
1.6	0.063					170	150	130	110	100	90												kN/m		
						5.8	5.1	4.5	3.8	3.4	3.1														Tons/ft
2.0	0.079						220	190	170	150	130	110											kN/m		
							7.5	6.5	5.8	5.1	4.5	3.8													Tons/ft
2.3	0.091							250	230	190	170	150	120										kN/m		
								8.6	7.9	6.5	5.8	5.1	4.1												Tons/ft
2.6	0.102								280	250	220	180	140										kN/m		
									9.6	8.6	7.5	6.2	4.8												Tons/ft
3.0	0.118									340	300	240	190	150									kN/m		
										11.6	10.3	8.2	6.5	5.1											Tons/ft
3.2	0.126										340	270	220	170	140								kN/m		
											11.6	9.3	7.5	5.8	4.8										Tons/ft
3.5	0.138											330	260	200	160	130							kN/m		
												11.3	8.9	6.9	5.5	4.5									Tons/ft
4.0	0.157											430	340	270	210	170							kN/m		
												14.7	11.6	9.3	7.2	5.8									Tons/ft
4.5	0.177												440	340	270	210							kN/m		
													15.1	11.6	9.3	7.2									Tons/ft
5.0	0.197												520	420	330	260	210						kN/m		
													17.8	14.4	11.3	8.9	7.2							Tons/ft	
6.0	0.236													600	480	380	300	240					kN/m		
														20.6	16.4	13.0	10.3	8.2						Tons/ft	
7.0	0.276															520	410	330	260				kN/m		
																17.8	14.0	11.3	8.9					Tons/ft	
9.0	0.354																670	540	430				kN/m		
																	23.0	18.5	14.7					Tons/ft	
10	0.394																850	670	530	420			kN/m		
																	29.1	23.0	18.2	14.4				Tons/ft	
12	0.472																	960	780	600	550		kN/m		
																		32.9	26.7	20.6	18.8			Tons/ft	
16	0.630																		1360	1070	860		kN/m		
																			46.6	36.7	29.5			Tons/ft	
19	0.748																			1500	1250	1000		kN/m	
																				51.4	42.8	34.3		Tons/ft	
22	0.866																				1600	1300		kN/m	
																					54.8	44.5		Tons/ft	
25	0.984																					2100	1700		kN/m
																						71.9	58.2		Tons/ft
30	1.181																						2400		kN/m
																							82.2		Tons/ft