

BEND CHART FOR STAINLESS STEEL (520 - 600 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	
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	MM	INSIDE RADIUS
		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	IN	
0.5	0.020	60	50																				kN/m	FORCE
		2.1	1.7																					
0.6	0.024	90	60	60	60																		kN/m	
		3.1	2.1	2.1	2.1																			
0.7	0.028	120	80	80	60	60																	kN/m	
		4.1	2.7	2.7	2.1	2.1																		
0.8	0.031		110	110	80	60																	kN/m	
			3.8	3.8	2.7	2.1																		
0.9	0.035		130	120	100	90	70																kN/m	
			4.5	4.1	3.4	3.1	2.4																	
1.0	0.039		170	150	120	110	90																kN/m	
			5.8	5.1	4.1	3.8	3.1																	
1.2	0.047			210	180	150	120	110	90														kN/m	
				7.2	6.2	5.1	4.1	3.8	3.1															
1.5	0.059				290	230	200	170	150	130	120												kN/m	
					9.9	7.9	6.9	5.8	5.1	4.5	4.1													
2.0	0.079						330	290	260	230	200	170											kN/m	
								11.3	9.9	8.9	7.9	6.9	5.8											
2.5	0.098								390	350	300	250	190										kN/m	
										13.4	12.0	10.3	8.6	6.5										
3.0	0.118									510	450	360	290	230									kN/m	
										17.5	15.4	12.3	9.9	7.9										
4.0	0.157										650	510	410	320	260								kN/m	
												22.3	17.5	14.0	11.0	8.9								
5.0	0.197											780	630	500	390	320							kN/m	
													26.7	21.6	17.1	13.4	11.0							
6.0	0.236												900	720	570	450	360						kN/m	
														30.8	24.7	19.5	15.4	12.3						
8.0	0.315															1020	810	650	510				kN/m	
																	34.9	27.8	22.3	17.5				
10	0.394																1280	1010	800	630			kN/m	
																		43.9	34.6	27.4	21.6			
12	0.472																	1440	1170	900	830		kN/m	
																			49.3	40.1	30.8	28.4		Tons/ft
15	0.591																		1800	1410	1140		kN/m	
																				61.7	48.3	39.1		Tons/ft
20	0.787																			2500	2080	1670	kN/m	
																					85.7	71.3	57.2	Tons/ft
25	0.984																				3150	2550	kN/m	
																						107.9	87.4	Tons/ft
30	1.181																					3600	kN/m	
																							123.3	Tons/ft