BEND DEDUCTION CHART

STEEL

Thickness	Bend Radius	Die Opening	BD
.030	.031	.157	.051
.035	.031	.230	.064
.048	.031	.275	.079
.062	.047	.315	.100
.062	.250	.709	.190
.075	.063	.472	.128
.090	.070	.551	.154
.105	.070	.472	.158
.105	.078	.551	.178
.105 (Accupress)	Min	1.00 Vee	.202
.120	.109	.630	.200
.135	.141	.710	.215
.135	.141	.984	.230
.187	Min	.787	.296
.187	Min	1.26	.316
.187	.125	2.00	.384
.187	.187	2.25	.426
.250	Min	1.18	.395
.250	.125	2.00	.430
.250	.125	2.50	.457
.250	.250	2.50	.470
.312	.250	2.625	.580
.312	.125	1.75	.514
.375	.062	2.50	.610
.375	.125	1.75	.620
.375	.125	2.50	.625
.375	.250	2.25	.670
.375 Dia Rod	.125	1.75	.563
.500	.125	2.625	.790
.500	.250	2.625	.820
.500	.500	4.00	.910
.625	Min	4.00	1.155

BEND DEDUCTION CHART

STAINLESS STEEL

Thickness	Bend Radius	Die Opening	BD
.020			
.025			
.030	.031	.157	.053
.035	.031	.230	.064
.048	.031	.276	.090
.060	.047	.394	.112
.075	.063	.472	.140
.090	.070	.551	.167
.105	.078	.551	.200
.105	.078	.472	.172
.120	.109	.630	.215
.135	.141	.787	.250
.187	Min	1.26	.340
.187	.375	2.00	.420
.250	.125	2.00	.480
.250	.125	2.50	.562
.250	.125	2.625	.511
.250	.250	2.00	.500
.250	.750	4.00	.617
.375	Min	4.00	.840
.375	Min	2.75	.670
.375	.250	4.00	.852

ALUMINUM

Thickness	Bend Radius	Die Opening	BD
.025			
.030	.031	.157	.043
.036	.031	.236	.055
.048	.031	.275	.071
.060	.047	.315	.100
.074	.063	.472	.113
.080	.063	.551	.125
.090	.070	.551	.135
.105	.078	.551	.154
.125	.125	.551	.200
.125	.109	.551	.172
.125	.375	.709	.330

BEND DEDUCTION CHART

.125 DP	Min Rad	.984	.313
.187	.156	.787	.265
.187	Min	1.26	.300
.187	.250	1.26	.351
.250	Min	1.26	.384
.250	.250	2.00	.432
.250 6061	.375	3.50	.486
.375	.125	2.75	.612
.375 5086 Alloy	.750	2.50	.800
.500			

COPPER

Thickness	Bend Radius	Die Opening	BD
.250	Min Rad (4702)	1.26	.425 @ 90D
.250	Min Rad (4702)	1.26	.080 @ 135D
.375	Min Rad	2 5/8	.605
.375	Min Rad	2 5/8	.249 @ 135D