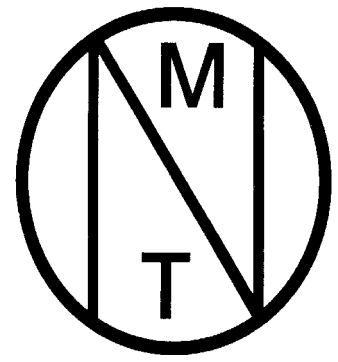


# Nyrock M & T Corp

Specialists in metal fabricating  
tooling and equipment

Phone: 845-353-1395 Fax: 845-353-1087

P.O. Box 831 Nyack, NY 10960



Approximate Tonnage required for bending 90  
degree air bends in mild steel (60,000 psi)

Thickness

WIDTH OF FEMALE DIE OPENING

Gauge	Inch	1/4	5/16	3/8	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4	1-1/2	2	2-1/2	3	3-1/2	4	6	8
20	.036	2.9	2.2	1.7	1.2	1.0													
18	.048		4.0	2.9	2.2	1.6	1.3												
16	.060			5.6	3.6	2.7	2.2	1.7											
14	.075				6.0	4.5	3.4	3.0	2.5	2.1									
13	.090					6.8	5.4	4.3	3.7	3.3	2.9								
12	.105					10.1	7.4	6.3	5.4	4.4	4.0	3.2							
11	.120						10.5	8.8	7.2	6.2	5.4	4.3	3.2						
10	.135							11.3	9.6	8.4	7.0	5.6	4.1						
9	.150								13.1	11.9	9.0	6.7	5.2	3.5					
7	.188									16.4	14.0	11.2	7.6	5.8	4.5				
1/4	.250										28.8	22	15.3	11.5	9.1	7.5	6.2		
5/16	.312											38.0	26.0	19.2	16.0	12.5	10.6		
3/8	.375												41.0	29.9	24.0	19.4	16.0	12.3	
7/16	.437													45.2	35.0	28.0	24.0	14.6	
1/2	.500														47.9	39.0	33.1	19.0	12.7
5/8	.625															69.5	58.0	32.4	23.0
3/4	.750																92.0	52.2	36.0

Air form radius	3-1/2	3/64	1/16	5/64	3/32	1/8	9/64	5/32	11/64	3/16	15/64	5/16	25/64	15/32	35/64	5/8	15/16	1-1/4
Min. flange inside dim.	3/16	7/32	1/4	5/16	7/16	1/2	9/16	5/8	11/16	3/4	15/16	1-13/16	1-7/16	1-3/4	2	2-1/4	3-3/8	4-1/2

Bending pressures required for other metals as compared to 60,000 psi tensile strength mild steel on above chart:

Soft Brass 50% of pressure listed  
Soft aluminum 50% of pressure listed  
Aluminum Alloys (heat treated) Same as steel

Stainless steel 50% more than steel  
Chrome Molybdenum 100% more than steel  
A36 Steel 30% more than steel

**Check out our Web Site: WWW.NYROCK.NET**