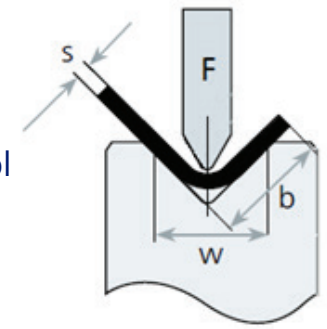


Bending Force Chart

Tonnes per meter for Mild Steel 400mpa

ri – radius inside
w- width of bottom tool
s – thickness
b – minimum length
F – force KN



	6	8	10	12	16	20	24	30	40	50	60	70	80	90	100	120	w
S	4.5	6	7.5	9	12	15	18	22.5	30	37.5	45	52.5	60	67.5	75	90	b
	1	1.3	1.6	1.9	2.6	3.2	3.8	4.8	6.4	8	9.6	11	13	14	16	19	ri
0.75	52	39	31	26													
1	93	70	56	47	35												
1.25	145	109	87	73	55	44											
1.5	209	157	126	105	79	63											
1.75		214	171	143	107	86	71										
2			223	186	140	112	93										
2.5				291	218	175	145	116									
3					314	251	209	168	126								
3.5					428	342	285	228	171	137							
4						447	372	298	223	179	149						
4.5						566	471	377	283	226	189	162					
5								466	349	279	233	200	175				
6								670	503	402	335	287	251	223			
7									684	547	456	391	342	304	274		
8										715	596	511	447	397	358	298	
10												798	698	621	559	466	
12													1005	894	804	670	

Chart shows F- force per meter in KN