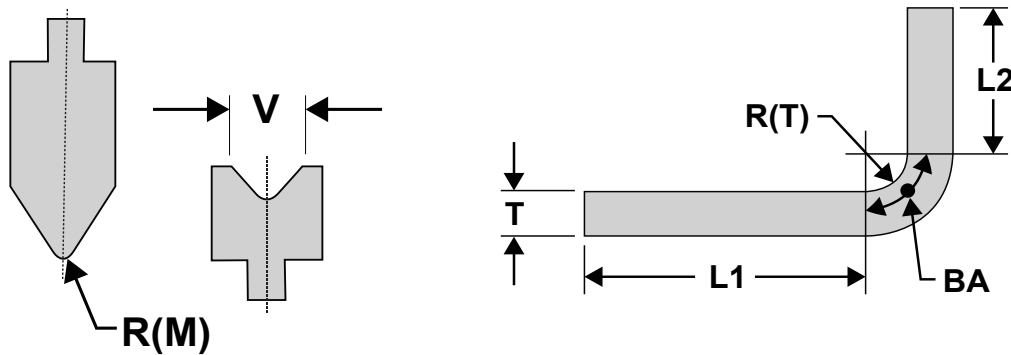


## Bend Allowances for Sheet Metal Air Bends (MILD STEEL ONLY)

BLANK WIDTH= L1 + L2 + BEND ALLOWANCE (BA)



MATERIAL THICKNESS T	RECOMMENDED DIE WIDTH V	RECOMMENDED MALE DIE RADIUS - R(M)	THEORETICAL BEND RADIUS $R(T) = 5/32 \times V$	ALLOWANCE FOR 90° BEND BA	FORMULA FOR BASIS OF CALCULATIONS
5/8 (.6250)	6	15/16	.9375	1.8644	BA= 1.57 (R + .4T)
1/2 (.5000)	5	3/4	.7813	1.5406	
1/2 (.5000)	4	5/8	.6250	1.2952	
3/8 (.3750)	3	7/16	.4687	.9713	
5/16 (.3125)	2-1/2	3/8	.3906	.8094	
1/4 (.2500)	2	5/16	.3125	.6476	
3/16 (.1875)	1-1/2	3/16	.2344	.4857	
10 GA (.1345)	1-1/8	1/8	.1757	.3605	
11 GA (.1196)	1"	1/8	.1562	.3203	
12 GA (.1046)	7/8	1/8	.1367	.2803	
13 GA (.0897)	3/4	1/16	.1172	.2403	
14 GA (.0747)	5/8	1/16	.0976	.2001	
15 GA (.0673)	1/2	1/16	.0781	.1649	
16 GA (.0598)	1/2	1/16	.0781	.1539	
18 GA (.0500)	3/8	1/32	.0586	.1181	
20 GA (.0359)	1/4	1/32	.0390	.0802	
21 GA (.0329)	1/4	1/32	.0390	.0786	
22 GA (.0299)	1/4	1/32	.0390	.0770	
23 GA (.0269)	1/4	1/32	.0390	.0754	

Calculated bend allowances are approximate, not exact. Actual dimensions can only be found by making the bend and measuring the results.  
The above formula is for right angle bends only. For gaging, remember to use only one leg and one-half of the bend allowance to approximate the distance.