



Tooling Styles	American, European, Wila, WT
Forming Method	Type: Air, Bottom Bending, Coining Die Angle: 30°, 75°, 85°, 86°, 88°, 90°
Nose Radius	Nose Radius = 1 Metal Thickness (mild steel)
Vee Opening	Vee Opening = 8 x Material Thickness (mild steel) Bend Radius = 5/32 x Vee Die Opening (Plate, High Strength Steel - Larger Vee Required)
Flange Length	Minimum Flange = 1/2 Vee + 2(Material Thickness)
Forming Tonnage	Tonnage to bend part based on method of bending, material type/ thickness/length, vee opening (Reference Capacity Charts)
Die Cross Sections	Gooseneck, Acute, etc.
Tooling Capacities	Verify tonnage to bend part vs. maximum die capacity (tons/ft)
Machine Capacities	Recommended to stay under 85% of maximum machine tonnage
Machine Die Space	Check: Open height, Closed height, Stroke, Throat depth, Filler block height, Clamping
Tooling Tolerances	Planed Centerline +/- 0.015" Ground Centerline +/- 0.0008"
Resources	cionlinestore.com Press Brake Capacities Booklet