

**BEND DEDUCTION/BEND ALLOWANCE
CHART
BASED ON EMPIRICAL FORMULA**

BEND ALLOWANCE

For 90 Degree Angles

To get *bend allowance* for other angles:

Divide these by 90 then multiply by desired angle.

EXAMPLE: B.A. for .048 mat with .062 B.R. at 30 degrees
 $.131/90 = .0014555 \times 30 = .044$ B.A.

MATERIAL THICKNESS →

RAD ↓	.020	.024	.030	.036	.040	.048	.050	.059	.063	.071	.074	.080	.090	.100	.111	.125	.135	.160	.190	.250
.015	.038	.040	.045	.049	.052	.057	.058													
.032	.064	.067	.071	.075	.078	.084	.085	.092	.096											
.047	.088	.090	.095	.099	.102	.107	.109	.115	.118	.124	.126									
.062	.111	.114	.118	.122	.125	.131	.132	.139	.141	.147	.149	.153	.160							
.093	.160	.163	.167	.171	.174	.180	.181	.187	.190	.196	.198	.202	.209	.216	.224	.234	.241			
.125	.210	.213	.217	.221	.224	.230	.231	.238	.240	.246	.248	.252	.259	.266	.274	.284	.291	.308	.330	.372
.156	.259	.262	.266	.270	.273	.278	.280	.286	.289	.295	.163	.301	.308	.315	.323	.333	.340	.357	.378	.420
.187	.307	.310	.315	.319	.321	.327	.329	.335	.338	.343	.345	.350	.360	.364	.371	.381	.388	.406	.427	.469
.219	.358	.360	.365	.369	.372	.377	.379	.385	.388	.393	.395	.400	.407	.414	.421	.431	.438	.456	.477	.519
.250	.406	.409	.413	.417	.420	.426	.427	.434	.436	.442	.444	.448	.455	.462	.470	.480	.487	.504	.526	.568
.281	.455	.458	.462	.466	.469	.475	.476	.482	.485	.491	.493	.497	.504	.511	.519	.529	.536	.553	.574	.616
.312	.503	.506	.510	.515	.518	.523	.525	.531	.534	.539	.541	.546	.553	.560	.567	.577	.584	.602	.623	.665
.375	.602	.605	.609	.614	.616	.622	.623	.630	.632	.638	.640	.644	.651	.658	.666	.676	.683	.701	.722	.764
.437	.700	.702	.707	.711	.714	.719	.721	.727	.730	.735	.737	.742	.749	.756	.763	.773	.780	.799	.819	.861
.500	.798	.801	.805	.810	.812	.818	.819	.826	.829	.834	.836	.841	.848	.855	.862	.872	.879	.897	.918	.860
.750	1.191	1.194	1.198	1.202	1.205	1.210	1.212	1.218	1.221	1.226	1.228	1.233	1.240	1.247	1.254	1.264	1.271	1.289	1.310	1.352
.875	1.387	1.389	1.394	1.398	1.401	1.406	1.408	1.414	1.417	1.422	1.425	1.429	1.436	1.443	1.451	1.460	1.467	1.485	1.506	1.548
1.00	1.583	1.586	1.590	1.594	1.598	1.602	1.604	1.610	1.613	1.619	1.621	1.625	1.632	1.639	1.647	1.656	1.663	1.681	1.702	1.744

BEND DEDUCTION 90 Degrees

MATERIAL THICKNESS →

RAD ↓	.020	.024	.030	.036	.040	.048	.050	.059	.063	.071	.074	.080	.090	.100	.111	.125	.135	.160	.190	.250
.015	.032	.038	.045	.053	.058	.069	.071													
.032	.040	.045	.053	.061	.066	.076	.079	.092	.100											
.047	.046	.051	.059	.067	.072	.082	.085	.099	.102	.113	.116									
.062	.053	.058	.066	.073	.079	.089	.092	.103	.109	.119	.123	.131	.145							
.093	.066	.071	.079	.087	.092	.102	.105	.117	.122	.132	.136	.144	.157	.170	.184	.203	.216			
.125	.079	.085	.093	.101	.106	.116	.119	.130	.137	.146	.150	.158	.171	.184	.199	.216	.229	.262	.301	.379
.156	.093	.098	.106	.114	.119	.130	.132	.144	.149	.160	.164	.171	.184	.197	.211	.230	.243	.275	.314	.392
.187	.107	.112	.120	.128	.133	.143	.146	.157	.163	.173	.177	.185	.198	.211	.225	.243	.256	.284	.323	.406
.219	.121	.126	.134	.141	.147	.157	.159	.171	.177	.187	.191	.199	.212	.225	.239	.257	.270	.302	.341	.419
.250	.134	.139	.147	.155	.160	.170	.173	.185	.190	.200	.204	.212	.225	.238	.252	.270	.283	.316	.355	.433
.281	.147	.153	.160	.168	.173	.184	.186	.198	.203	.214	.217	.225	.238	.251	.266	.284	.295	.329	.368	.446
.312	.161	.166	.174	.182	.187	.197	.200	.211	.217	.227	.231	.239	.251	.265	.279	.297	.310	.343	.381	.459
.375	.188	.193	.201	.209	.214	.224	.227	.238	.244	.254	.258	.266	.279	.292	.306	.324	.337	.370	.409	.486
.437	.215	.220	.228	.235	.241	.251	.254	.265	.271	.281	.285	.293	.306	.319	.333	.351	.364	.396	.435	.513
.500	.242	.247	.255	.262	.268	.278	.281	.292	.298	.308	.312	.320	.333	.346	.360	.378	.391	.424	.463	.540
.750	.350	.355	.363	.370	.376	.386	.389	.400	.406	.416	.420	.428	.440	.454	.468	.486	.499	.531	.570	.648
.875	.404	.409	.417	.424	.430	.440	.442	.454	.459	.470	.474	.481	.494	.507	.522	.540	.553	.585	.624	.702
1.00	.458	.436	.470	.478	.483	.494	.496	.508	.513	.523	.527	.535	.548	.561	.575	.594	.607	.639	.678	.756

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