

## Bend Deductions

The following information has been tested by Prototek Sheet Metal and may vary from other manufacturers.

Radius - Internal Radius

Bend Deduction-Amount subtracted per bend (coined/set bends)

Air Bend - Deduction for air bend.

K-Factor - used for engineering programs, such as Pro-E and Solid Works

### Colled Rolled Steel - CRS

Thk	Radius	Bend Deduction	Notes	Air Bend	K-Factor
.018	.030	.034			.5261
.020	.030	.039			.4417
.024	.030	.036		.047	.6599
.030	.015	.047			.4125
.030	.030	.047		.054	.5491
.030	.060	.067			.3979
.030	.187	.122			.3875
.036	.030	.054			.546
.036	.090	.085			.4532
.040	.030	.065			.4437
.040	.060	.075			.4035
.048	.030	.072		.078	.4891
.048	.060	.088			.4477
.048	.090	.101			.4460
.048	.202	.151			.4204
.060	.030	.088		.103	.4762
.060	.045	.095			.4702
.060	.060	.106			.4218
.060	.375	.232			
.060	1.000	.510			.4160
.074	.030	.112		.125	.4318
.090	.030	.131		.147	.4377
.090	.125	.172			.4361
.104	.030	.151			.4277
.120	.030	.180		.205	.3866

.134	.030	.201			.3795
.175	.030	.270			
.178	.015		3/4 DIE	.280	
.187	.030	.280	1.50 DIE	.318	
.187	.030	-	1.25 DIE	.300	
.187	.060	.305			.3226

GALVANNEAL/GALVANIZED STEEL

Thk	Radius	Bend D.	Comments	Air Bend	K-Factor
.030	.030	.051			
.036	.030	.058			
.048	.030	.076			
.048	.060	.092			
.060	.030	.092			
.060	.060	.110			
.074	.030	.116			
.090	.030	.135			
.104	.030	.155			
.120	.030	.185			
.134	.030	.205			

ALUMINUM

Thk	Radius	Bend D.	Comments	Air Bend	K-Factor
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