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## Press Brake Forming

Shape	Type of Bend	Tonnage (tons/ft.)
	90° Rib Form	Radii 2T + 200 x M.T SHARP TO IT - 600 x M.T.
	90° Bot & Air B.	150 x M.T (60 x M.T.)
	Radius	180 x M.T.
	Offset	300 x M.T.
	M.T. Offset	600 x M.T.
	Channel	300 x M.T.
	Hat Channel	600 x M.T.
	Open Hat Channel	450 x M.T.
	Wipe Die 14 GA. Max.	250 x M.T.
	Single Form	200 x M.T.
	Double Form	300 x M.T.
	Closing	200 x M.T.