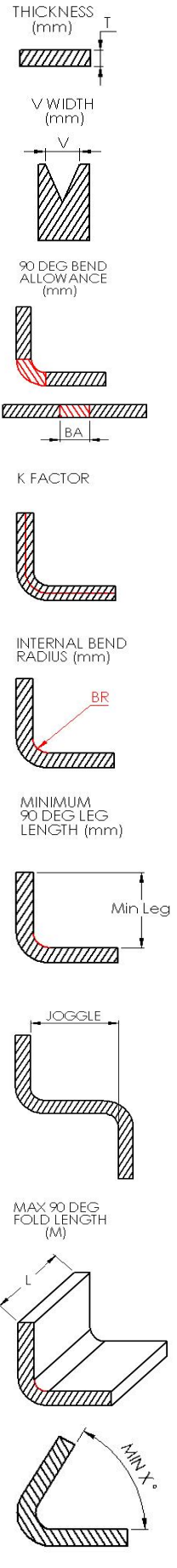


Aluminium - 90° Bend Table

Thickness	V Width	Top Punch	Bend Allowance	K Factor	Internal Bend Rad	Min Flange	Min Joggle	Max Length	Min Angle
1mm	6v	R1	1	0.28	1	4	7	3000	30°
	8v	R1	1.1	0.28	1	7	7	3000	30°
	8v	R4	1.48	0.48	4	7	11	3000	60°
	10v	R1	1.2	0.05	1	8.5	8.5	4000	30°
	10v	R4	1.47	0.48	4	8.5	8.5	4000	60°
1.2mm	8v	R1	1.25	0.17	1	7	7	3000	30°
	8v	R4	1.63	0.45	4	7	7	3000	60°
	10v	R1	1	0.45	1	8.5	13	4000	30°
	10v	R4	1.63	0.45	4	8.5	13	4000	60°
1.5mm	10v	R1	1.3	0.35	1	8.5	13	4000	30°
	10v	R4	1.8	0.47	4	8.5	13	4000	60°
	12v	R1	1.6	0.14	1.2	9.5	15	3000	30°
	12v	R4	1.8	0.47	4	9.5	15	3000	60°
2.0mm	12v	R1	1.6	0.4	1.2	9.5	15	3000	30°
	12v	R4	2.2	0.43	4	9.5	15	3000	80°
	16v	R1	1.6	0.4	1.25	11.5	20	4000	30°
	16v	R4	2.2	0.43	4	11.5	20	4000	80°
2.5mm	16v	R1	2.1	0.4	1.6	11.5	20	4000	30°
	16v	R4	2.55	0.19	4	11.5	20	4000	80°
	20v	R1	2.5	0.22	2	13.5	19	3000	82°
	20v	R4	2.77	0.22	4	13.5	19	3000	80°
3.0mm	20v	R1	2.8	0.26	2	13.5	19	3000	82°
	20v	R4	3	0.15	4	13.5	19	3000	80°
	24v	R1	2.6	0.4	2.6	15.5	22	4000	30°
	24v	R4	3.2	0.1	4	15.5	22	4000	80°
4.0mm	24v	R1	3.3	0.37	2.6	15.5	22	4000	30°
	24v	R4	3.6	0.27	4	15.5	22	4000	80°
	30v	R1	3.83	0.19	3.5	20	30	4000	82°
	30v	R4	3.5	0.27	4	20	30	4000	80°
5.0mm	30v	R4	4.2	0.46	3.5	20	30	4000	80°
	40v	R4	4.3	0.5	4.4	26.5	35	4000	80°
	50v	R4	4.3	0.5	5.2	30	40	4000	80°
6.0mm	40v	R4	5.35	0.41	4	26.5	35	4000	80°
	50v	R4	5.85	0.32	5.8	30	40	4000	80°
8.0mm	50v	R4	7.4	0.3	5.2	30	50	4000	80°
	50v	R10	7.95	0.22	10	30	50	2500	80°
	80v	R4	8.6	0.11	8	50	80	3000	80°
	80v	R10	8.8	0.08	10	50	80	2500	80°
	100v	R4	7.85	0.24	9.5	60	100	1000	80°
	100v	R10	7.95	0.22	10	60	100	1000	80°
8.0mm	50v	R4	7.4	0.3	5.2	30	50	4000	80°



MAX HEIGHT FOR A 3 SIDED BOX = 400mm

MAX HEIGHT FOR A 4 SIDED BOX = 200mm

Note: 12 and 16mm can be folded subject to weight and length. Contact our quote team to discuss your requirements

Highlighted lines are our ideal folding settings

