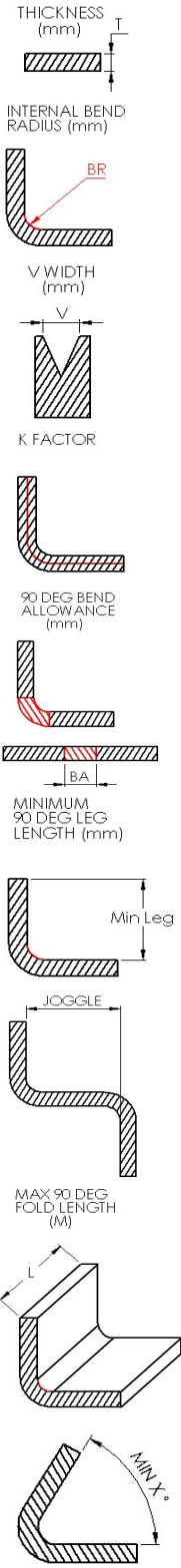


Aluminium - Bend Table

Thickness	Top Punch (BR)	V Width	K Factor - 3D development	Bend Allowance 2D development	Internal Bend Rad	Min Flange	Min Joggle	Max Length	Min Angle 'X'
0.5mm to 1mm	R1	6v	0.28	1	1	5	7	3000	30°
	R1	10v	0.05	1.2	1	8.5	9	4000	30°
1.2mm	R1	10v	0.45	1	1	8.5	13	4000	30°
	R2	10v	0.45	1	1	8.5	13	4000	50°
1.6mm	R1	10v	0.35	1.3	1	8.5	13	4000	30°
	R1	12v	0.14	1.6	1.2	9.5	15	4000	30°
2.0mm	R1	12v	0.4	1.6	1.2	9.5	15	4000	30°
	R2	16v	0.42	2	4	9.5	15	4000	80°
	R1	16v	0.4	1.6	1.25	11.5	20	4000	30°
2.5mm	R4	16v	0.43	2.2	4	11.5	20	4000	80°
	R1	16v	0.4	2.1	1.6	11.5	20	4000	30°
	R4	16v	0.19	2.55	4	11.5	20	4000	60°
3.0mm	R1	20v	0.22	2.5	2	13.5	19	4000	30°
	R4	20v	0.22	2.77	4	13.5	19	4000	60°
	R1	24v	0.26	2.8	2	13.5	19	4000	30°
	R4	24v	0.15	3	4	13.5	19	4000	60°
4.0mm	R1	24v	0.4	2.6	2.6	15.5	22	4000	30°
	R4	24v	0.1	3.2	4	15.5	22	4000	60°
	R1	30v	0.37	3.3	2.6	15.5	22	4000	90°
	R4	30v	0.27	3.6	4	15.5	22	4000	90°
5.0mm	R1	30v	0.19	3.83	3.5	20	30	4000	90°
	R4	30v	0.27	3.5	4	20	30	4000	90°
	R4	40v	0.46	4.2	3.5	20	30	4000	90°
6.0mm	R4	40v	0.5	4.3	4.4	26.5	35	4000	90°
	R4	50v	0.5	4.3	5.2	30	40	4000	90°
	R4	40v	0.41	5.35	4	26.5	35	4000	90°
8.0mm**	R4	50v	0.32	5.85	5.8	30	40	4000	90°
	R4	50v	0.3	7.4	5.2	30	50	3000	90°
**	R10	50v	0.22	7.95	10	30	50	3000	90°
**	R10	80v	0.08	8.8	10	50	80	3000	90°
**	R10	100v	0.22	7.95	10	60	100	3000	90°
**	R10	120v	0.21	7.95	10	60	100	3000	90°



ENSURE TO ADVISE US OF THE SEEN FACE/PVC FILM SIDE

MAX HEIGHT FOR A 3 SIDED BOX = 400mm

MAX HEIGHT FOR A 4 SIDED BOX = 200mm

CONDITIONS APPLY FOR PARTS OVER 50kg (WEIGHT)

****Note: 8mm to 16mm can be folded subject to weight and length****

WE HAVE A VARIETY OF RADIUS BARS & BUMP FORMING CAPABILITIES TO SUIT YOUR DESIGN