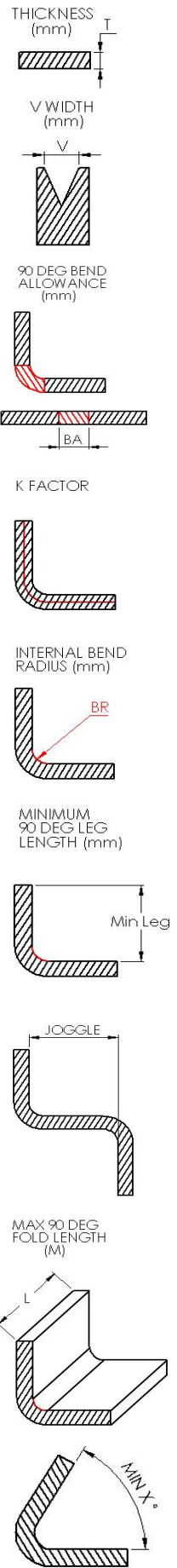


Mild Steel - 90° Bend Table

Thickness	V Width	Top Punch	Bend Allowance	K Factor	Internal Bend Rad	Min Flange	Min Joggle	Max Length	Min Angle
1mm	6v	R1	0.985	0.29	1	4	7	3000	30°
	8v	R1	1.07	0.29	1	7	7	3000	30°
	8v	R4	1.48	0.48	4	7	11	3000	60°
	10v	R1	1.15	0.17	1.3	8.5	8.5	4000	30°
	10v	R4	1.47	0.48	4	8.5	8.5	4000	60°
1.2mm	8v	R1	1.22	0.21	1	7	7	3000	30°
	8v	R4	1.63	0.45	4	7	7	3000	60°
	10v	R1	1.3	0.2	1.3	8.5	13	4000	30°
	10v	R4	1.63	0.45	4	8.5	13	4000	60°
1.5mm	10v	R1	1.5	0.24	1.3	8.5	13	4000	30°
	10v	R4	1.8	0.47	4	8.5	13	4000	60°
	12v	R1	1.6	0.2	1.5	9.5	15	3000	30°
	12v	R4	1.8	0.47	4	9.5	15	3000	60°
2.0mm	12v	R1	1.8	0.34	1.5	9.5	15	3000	30°
	12v	R4	2.2	0.43	4	9.5	15	3000	80°
	16v	R1	1.97	0.28	2	11.5	20	4000	30°
	16v	R4	2.2	0.43	4	11.5	20	4000	80°
2.5mm	16v	R1	2.4	0.27	2	11.5	20	4000	30°
	16v	R4	2.6	0.19	4	11.5	20	4000	80°
	20v	R1	2.6	0.17	2.5	13.5	19	3000	82°
	20v	R4	2.77	0.22	4	13.5	19	3000	80°
3.0mm	20v	R1	2.8	0.24	2.5	13.5	19	3000	82°
	20v	R4	3.1	0.15	4	13.5	19	3000	80°
	24v	R1	2.88	0.23	3.2	15.5	22	4000	30°
	24v	R4	3.25	0.08	4	15.5	22	4000	80°
4.0mm	24v	R1	3.75	0.22	3.2	15.5	22	4000	30°
	24v	R4	3.8	0.2	4	15.5	22	4000	80°
	30v	R1	3.76	0.22	4.4	20	30	4000	82°
	30v	R4	3.87	0.18	4.8	20	30	4000	80°
5.0mm	30v	R4	4.46	0.24	4.4	20	30	3500	80°
	40v	R4	4.83	0.37	5	26.5	35	4000	80°
	50v	R4	5	0.5	6.5	30	40	4000	80°
6.0mm	40v	R4	5.35	0.41	5.5	26.5	35	3200	80°
	50v	R4	5.65	0.36	6.5	30	40	4000	80°
8.0mm	50v	R4	7.15	0.34	6.5	30	50	2000	80°
	50v	R10	7.95	0.22	10	30	50	2000	80°
	80v	R4	7.8	0.24	10	50	80	3000	80°
	80v	R10	8	0.2	11	50	80	2500	80°
	100v	R4	8.4	0.14	13	60	100	1000	80°
10.0mm	80v	R4	8.85	0.31	0.24	50	80	2200	80°
	80v	R10	9.4	0.24	0.2	50	80	2200	80°
	100v	R4	9.85	0.19	0.14	60	100	1000	80°
	100v	R10	10.45	0.1	0.16	60	100	1000	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