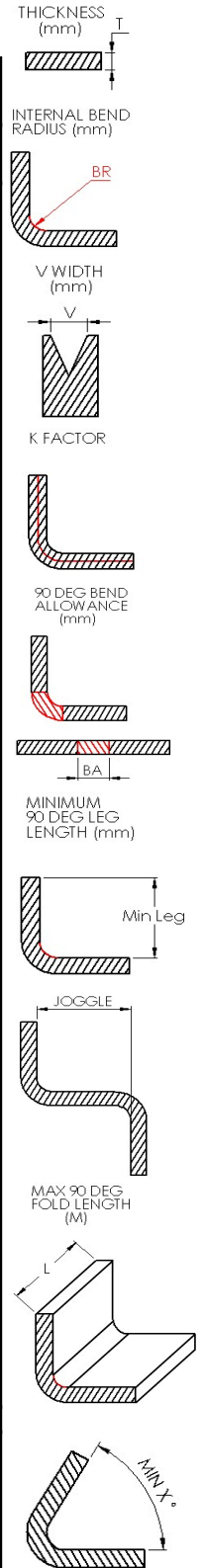


Mild Steel / Cold rolled / Hot rolled - Bend Table

Thickness	Top Punch	V Width	K Factor - 3D development	Bend Allowance 2D development	Internal Bend Rad	Min Flange	Min Joggle	Max Length	Min Angle 'X'
0.5mm 1mm	R1	6v	0.29	0.985	1	4	7	3000	30°
	R1	10v	0.17	1.15	1.3	8.5	9	4000	30°
	R4	10v	0.48	1.47	4	8.5	9	4000	60°
1.2mm	R1	10v	0.2	1.3	1	8.5	13	4000	30°
	R4	10v	0.45	1.63	4	8.5	13	4000	60°
1.6mm	R1	10v	0.24	1.5	1.3	8.5	13	4000	30°
	R4	10v	0.47	1.8	4	8.5	13	4000	60°
	R1	12v	0.2	1.6	1.5	9.5	15	4000	30°
	R4	12v	0.47	1.8	4	9.5	15	4000	60°
2.0mm	R1	12v	0.34	1.8	1.5	9.5	15	4000	30°
	R4	12v	0.43	2.2	4	9.5	15	4000	80°
	R1	16v	0.28	1.97	2	11.5	20	4000	30°
	R4	16v	0.43	2.2	4	11.5	20	4000	60°
2.5mm	R1	16v	0.27	2.4	2	11.5	20	4000	30°
	R4	16v	0.19	2.6	4	11.5	20	4000	80°
	R1	20v	0.17	2.6	2.5	13.5	22	4000	30°
	R4	20v	0.22	2.77	4	13.5	22	4000	60°
3.0mm	R1	20v	0.24	2.8	2.5	13.5	19	4000	30°
	R4	20v	0.15	3.1	4	13.5	19	4000	60°
	R1	24v	0.23	2.88	3.2	15.5	22	4000	30°
	R4	24v	0.08	3.25	4	15.5	22	4000	60°
4.0mm	R1	24v	0.22	3.75	3.2	15.5	22	4000	30°
	R4	24v	0.2	3.8	4	15.5	22	4000	80°
	R1	30v	0.22	3.76	4.4	20	30	3000	82°
	R4	30v	0.18	3.87	4.8	20	30	3000	80°
5.0mm	R4	30v	0.24	4.46	4.4	20	30	3000	80°
	R4	40v	0.37	4.83	5	26.5	35	4000	60°
	R4	50v	0.5	5	6.5	30	40	4000	80°
6.0mm	R4	40v	0.41	5.35	5.5	26.5	35	4000	80°
	R4	50v	0.36	5.65	6.5	30	40	4000	80°
8.0mm	R10	50v	0.22	7.95	6.5	30	50	2000	80°
	R4	80v	0.24	7.8	10	50	80	3000	80°
	R10	80v	0.2	8	11	50	80	2500	80°
	R4	100v	0.14	8.4	13	60	100	2000	80°
	R10	100v	0.16	8.25	12	60	100	2000	80°
10.0mm**	R4	80v	0.31	8.85	TBC	50	80	2200	80°
**	R10	80v	0.24	9.4	TBC	50	80	2200	80°
**	R4	100v	0.19	9.85	TBC	60	100	2000	80°
**	R10	100v	0.1	10.45	TBC	60	100	2000	80°



MAX HEIGHT FOR A 3 SIDED BOX = 400mm

MAX HEIGHT FOR A 4 SIDED BOX = 200mm

CONDITIONS APPLY FOR PARTS OVER 50kg (WEIGHT)

****Note: 10mm to 16mm can be folded subject to weight and length****

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