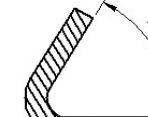
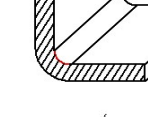
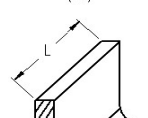
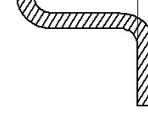
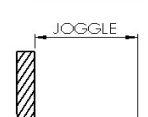
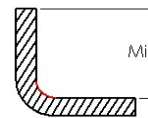
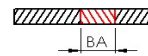
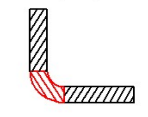
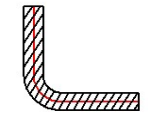
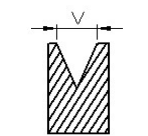
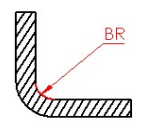
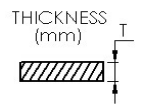


**Stainless Steel - Bend Table**

| 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' |
|-------------|-----------|---------|---------------------------|-------------------------------|-------------------|------------|------------|------------|---------------|
| 0.55 to 1mm | R1        | 10v     | 0.3                       | 1.15                          | 1                 | 8.5        | 9          | 4000       | 30°           |
| 1.2mm       | R1        | 10v     | 0.26                      | 1.39                          | 1.8               | 8.5        | 13         | 4000       | 30°           |
|             | R4        | 10v     | 0.45                      | 1.63                          | 4                 | 8.5        | 13         | 4000       | 60°           |
| 1.5mm       | R1        | 10v     | 0.33                      | 1.55                          | 1.8               | 8.5        | 13         | 4000       | 30°           |
|             | R1        | 12v     | 0.25                      | 1.66                          | 2.1               | 9.5        | 15         | 4000       | 30°           |
| 2.0mm       | R1        | 12v     | 0.29                      | 2                             | 2.1               | 9.5        | 15         | 4000       | 30°           |
|             | R1        | 16v     | 0.26                      | 2.2                           | 2.8               | 11.5       | 20         | 4000       | 30°           |
|             | R4        | 16v     | 0.43                      | 2.2                           | 4                 | 11.5       | 20         | 4000       | 80°           |
| 2.5mm       | R1        | 16v     | 0.22                      | 2.47                          | 2.8               | 11.5       | 20         | 4000       | 30°           |
|             | R4        | 16v     | 0.19                      | 2.64                          | 4                 | 11.5       | 20         | 4000       | 80°           |
|             | R1        | 20v     | 0.17                      | 2.6                           | 3.5               | 13.5       | 22         | 4000       | 82°           |
|             | R4        | 20v     | 0.22                      | 2.86                          | 4                 | 13.5       | 22         | 4000       | 80°           |
| 3.0mm       | R1        | 20v     | 0.23                      | 2.88                          | 3.5               | 13.5       | 19         | 4000       | 82°           |
|             | R4        | 20v     | 0.15                      | 3.1                           | 4                 | 13.5       | 19         | 4000       | 80°           |
|             | R1        | 24v     | 0.12                      | 3.2                           | 4.5               | 15.5       | 22         | 4000       | 30°           |
|             | R4        | 24v     | 0.05                      | 3.34                          | 5                 | 15.5       | 22         | 4000       | 80°           |
| 4.0mm       | R1        | 24v     | 0.17                      | 3.9                           | 4.5               | 15.5       | 22         | 4000       | 30°           |
|             | R4        | 24v     | 0.15                      | 3.95                          | 4                 | 15.5       | 22         | 4000       | 80°           |
|             | R1        | 30v     | 0.06                      | 4.24                          | 6.1               | 20         | 30         | 4000       | 82°           |
|             | R4        | 30v     | 0.01                      | 4.25                          | 4.9               | 20         | 30         | 4000       | 80°           |
| 5.0mm       | R4        | 30v     | 0.37                      | 4.9                           | 6.16              | 20         | 30         | 4000       | 80°           |
|             | R4        | 40v     | 0.3                       | 5.1                           | 7                 | 26.5       | 35         | 4000       | 80°           |
|             | R4        | 50v     | 0.23                      | 5.4                           | 9.1               | 30         | 40         | 4000       | 80°           |
| 6.0mm       | R4        | 40v     | 0.32                      | 5.8                           | 7                 | 26.5       | 35         | 4000       | 80°           |
|             | R4        | 50v     | 0.26                      | 6.5                           | 9                 | 30         | 40         | 4000       | 80°           |
| 8.0mm       | R4        | 50v     | 0.3                       | 7.45                          | 9.1               | 30         | 50         | 2400       | 80°           |
|             | R10       | 50v     | 0.22                      | 7.95                          | 10                | 30         | 50         | 2400       | 80°           |
|             | R4        | 80v     | 0.04                      | 9                             | 14                | 50         | 80         | 3000       | 80°           |
|             | R10       | 80v     | 0.02                      | 9.15                          | 12                | 50         | 80         | 3000       | 80°           |
|             | R10       | 100v    | 0.13                      | 8.5                           | 14                | 60         | 100        | 3000       | 80°           |
| 10.0mm**    | R4        | 80v     | 0.1                       | 10.35                         | 14                | 50         | 80         | 2000       | 80°           |
| **          | R10       | 80v     | 0.1                       | 10.4                          | 16                | 50         | 80         | 2000       | 80°           |
| **          | R4        | 100v    | 0.1                       | 10.6                          | 16.8              | 60         | 100        | 2000       | 80°           |
| **          | R10       | 100v    | 0.05                      | 10.95                         | 19                | 60         | 100        | 3000       | 80°           |



**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: 10mm to 12mm can be folded subject to weight and length\*\***

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