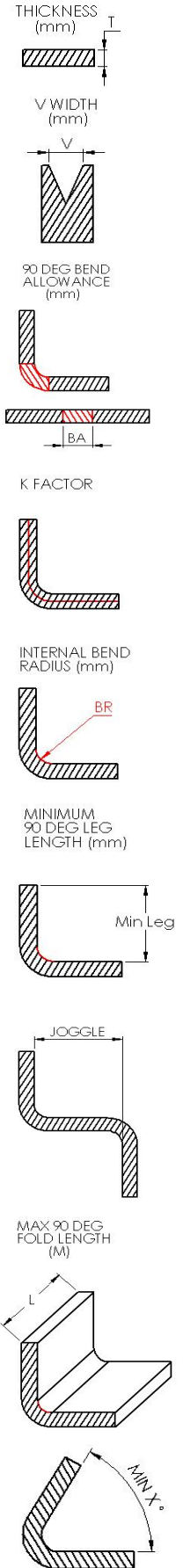


Stainless Steel - 90° Bend Table

Thickness	V Width	Top Punch	Bend Allowance	K Factor	Internal Bend Rad	Min Flange	Min Joggle	Max Length	Min Angle 'X'
1mm	6v	R1	0.975	0.36	1.2	4	7	3000	30°
	8v	R1	1.08	0.36	1.4	7	7	3000	30°
	8v	R4	1.48	0.48	4	7	11	3000	60°
	10v	R1	1.15	0.3	1.8	8.5	8.5	4000	30°
	10v	R4	1.47	0.48	4	8.5	8.5	4000	60°
1.2mm	8v	R1	1.29	0.22	1.4	7	7	3000	30°
	8v	R4	1.63	0.45	4	7	7	3000	60°
	10v	R1	1.39	0.26	1.8	8.5	13	4000	30°
	10v	R4	1.63	0.45	4	8.5	13	4000	60°
1.5mm	10v	R1	1.55	0.33	1.8	8.5	13	4000	30°
	10v	R4	1.8	0.47	4	8.5	13	4000	60°
	12v	R1	1.66	0.25	2.1	9.5	15	3000	30°
	12v	R4	1.8	0.47	4	9.5	15	3000	60°
2.0mm	12v	R1	2	0.29	2.1	9.5	15	3000	30°
	12v	R4	2.2	0.43	4	9.5	15	3000	80°
	16v	R1	2.2	0.26	2.8	11.5	20	4000	30°
	16v	R4	2.2	0.43	4	11.5	20	4000	80°
2.5mm	16v	R1	2.47	0.22	2.8	11.5	20	4000	30°
	16v	R4	2.64	0.19	4	11.5	20	4000	80°
	20v	R1	2.6	0.17	3.5	13.5	19	3000	82°
	20v	R4	2.86	0.22	4	13.5	19	3000	80°
3.0mm	20v	R1	2.88	0.23	3.5	13.5	19	3000	82°
	20v	R4	3.1	0.15	4	13.5	19	3000	80°
	24v	R1	3.2	0.12	4.5	15.5	22	4000	30°
	24v	R4	3.34	0.05	5	15.5	22	4000	80°
4.0mm	24v	R1	3.9	0.17	4.5	15.5	22	2400	30°
	24v	R4	3.95	0.15	4	15.5	22	2400	80°
	30v	R1	4.24	0.06	6.1	20	30	4000	82°
	30v	R4	4.25	0.01	6.9	20	30	4000	80°
5.0mm	30v	R4	4.9	0.37	6.16	20	30	2000	80°
	40v	R4	5.1	0.3	7	26.5	35	2800	80°
	50v	R4	5.4	0.23	9.1	30	40	4000	80°
6.0mm	40v	R4	5.8	0.32	7	26.5	35	1800	80°
	50v	R4	6.5	0.26	9	30	40	2400	80°
8.0mm	50v	R4	7.45	0.3	9.1	30	50	1200	80°
	50v	R10	7.95	0.22	10	30	50	1200	80°
	80v	R4	9	0.04	14	50	80	2000	80°
	80v	R10	9.15	0.02	12	50	80	2000	80°
	100v	R4	8.95	0.04	16	60	100	1000	80°
	100v	R10	8.5	0.13	14	60	100	1000	80°
10.0mm	80v	R4	10.35	0.1	14	50	80	1200	80°
	80v	R10	10.4	0.1	16	50	80	1200	80°
	100v	R4	10.6	0.1	16.8	60	100	1000	80°
	100v	R10	10.95	0.05	19	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