Folding Data

V8.1

STANDARD TOOLING

Thickness *mm*	V width *mm*	Die name / Die width / Die angle	Bend Rad *(inside)*	K factor	Offset *mm*	Min Flange *mm (90 °)* (!)	Joggle *mm*	Tooling Length / Max Fold Length *mm*
			Stainless Steel 304 & 316	Mild Steel		Aluminium 5052		Aluminium 5005
STANDARD DIES								
0.5	4	EV/S-W4 8mm 86°	1.10 1.00 1.00	0.45 0.45 0.60	0.22 0.22 0.30	5.7	4.5	500 500 500
0.7	6	EV001/S 16mm (6 - 10)(@) 30°	1.20 1.10 1.00	0.45 0.45 0.60	0.31 0.31 0.42	5.7	6.8	1785 1785 1785
0.9	8	EV002 20mm 30°	1.50 1.40 1.00	0.39 0.39 0.60	0.35 0.35 0.54	5.7	11.5	4200 4200 4200
1.2	8	EV002 20mm 30°	1.50 1.40 1.50	0.35 0.37 0.56	0.42 0.44 0.67	5.7	11.5	4200 4200 4200
1.5	12	EV004 25mm 30° / EV023/S 16mm 86°	2.30 1.90 1.50	0.31 0.30 0.39	0.47 0.45 0.59	7.8|7.6	14.9	4200 / 320 4200 / 320 4200 / 320
2	16	EV005 30mm 30° / EV024 30mm 86°	3.10 2.60 1.75	0.34 0.36 0.46	0.68 0.72 0.91	10.4|10.1	18.3	4200 / 4200 4200 / 4200 4200 / 4200
2.5	20	EV025 30mm 86°	3.90 3.20 3.50	0.35 0.36 0.45	0.88 0.90 1.12	12.7	19	4200 4200 4200
3	24	(#)EV007 40mm 30° / EVO26 35mm 86°	4.30 3.90 4.08	0.32 0.36 0.40	0.96 1.08 1.20	15.6|15.2	24.1	4200 / 4200 4200 / 4200 - / 4200
4	30	EV027 45mm 86°	5.40 4.00 4.10	0.33 0.39 0.42	1.32 1.56 1.67	19.1	28	4200 4200 4200
5	40	OZU-032 50mm 40° / EVO28 55mm 86°	6.90 5.10 6.50	0.31 0.35 0.40	1.55 1.75 2.00	26.2|25.6	37	3230 / 4200 3230 / 4200 3230 / 4200
6	50	EVO29 75mm 86°	8.50 6.50 8.30	0.30 0.37 0.39	1.80 2.22 2.34	32.3	45	3550 3550 3550
8	60	EV-W60 75mm 86°	10.50 8.80 10.50	0.31 0.38 0.39	2.48 3.04 3.12	38.2	52	2005 2005 2005

VLM TOOLING (Heavy duty tooling for thick material)

8	62	VLM-W62 120mm 40°	10.40 7.70 12.00	0.28 0.31 0.35	2.24 2.48 2.80	41.3	72.9	2000 2000 2000
10	82.5	VLM-W82 120mm 50°	13.80 10.60 -	0.28 0.28 -	2.80 2.80 -	53.4	96.6	1600 2000 -
12	103.1	VLM-W102 120mm 60°	17.80 12.90 -	0.26 0.32 -	3.12 3.84 -	65.5	120.4	1600 2000 -
16	123.9	VLM-W122 200mm 70°	- 15.20 -	- 0.32 -	- 5.12 -	80	170	- 1500 -

(!): Those values are valid for short folds only(< 100mm). For longer folds, add 1mm to the min flange length per meter of folding.

(@): This Vee block isn't symetrical *(the centre of the vee is located 6mm from one side and 10mm from the other).*

(#): Excludes Aluminium.

(*): Limited R6, R8, R10 and R12.5 top tool segmentation.