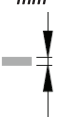






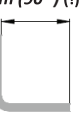
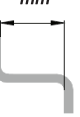


Folding Data

V8.1

STANDARD TOOLING

STANDARD TOOLING			Stainless Steel 304 & 316		Mild Steel		Aluminium 5052		Aluminium 5005	
STANDARD DIES										
Thickness <i>mm</i>	V width <i>mm</i>	Die name		Bend Rad <i>(inside)</i>	K factor	Offset <i>mm</i>	Min Flange <i>mm (90 °) (!)</i>	Joggle <i>mm</i>	Tooling Length / Max Fold Length <i>mm</i>	
		Die width 	Die angle 							
0.5	4	EV/S-W4		1.10	0.45	0.22	5.7	4.5	500	
		8mm		1.00	0.45	0.22			500	
		86°		1.00	0.60	0.30			500	
0.7	6	EV001/S		1.20	0.45	0.31	5.7	6.8	1785	
		16mm (6 - 10)(@)		1.10	0.45	0.31			1785	
		30°		1.00	0.60	0.42			1785	
0.9	8	EV002		1.50	0.39	0.35	5.7	11.5	4200	
		20mm		1.40	0.39	0.35			4200	
		30°		1.00	0.60	0.54			4200	
1.2	8	EV002		1.50	0.35	0.42	5.7	11.5	4200	
		20mm		1.40	0.37	0.44			4200	
		30°		1.50	0.56	0.67			4200	
1.5	12	EV004	EVO23/S	2.30	0.31	0.47	7.8 7.6	14.9	4200	320
		25mm	16mm	1.90	0.30	0.45			4200	320
		30°	86°	1.50	0.39	0.59			4200	320
2	16	EV005	EVO24	3.10	0.34	0.68	10.4 10.1	18.3	4200	4200
		30mm	30mm	2.60	0.36	0.72			4200	4200
		30°	86°	1.75	0.46	0.91			4200	4200
2.5	20	EV025		3.90	0.35	0.88	12.7	19	4200	
		30mm		3.20	0.36	0.90			4200	
		86°		3.50	0.45	1.12			4200	
3	24	(#)EV007	EVO26	4.30	0.32	0.96	15.6 15.2	24.1	4200	4200
		40mm	35mm	3.90	0.36	1.08			4200	4200
		30°	86°	4.08	0.40	1.20			-	4200
4	30	EV027		5.40	0.33	1.32	19.1	28	4200	
		45mm		4.00	0.39	1.56			4200	
		86°		4.10	0.42	1.67			4200	
5	40	OZU-032	EVO28	6.90	0.31	1.55	26.2 25.6	37	3230	4200
		50mm	55mm	5.10	0.35	1.75			3230	4200
		40°	86°	6.50	0.40	2.00			3230	4200
6	50	EVO29		8.50	0.30	1.80	32.3	45	3550	
		75mm		6.50	0.37	2.22			3550	
		86°		8.30	0.39	2.34			3550	
8	60	EV-W60		10.50	0.31	2.48	38.2	52	2005	
		75mm		8.80	0.38	3.04			2005	
		86°		10.50	0.39	3.12			2005	

VLM TOOLING (Heavy duty tooling for thick material)

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