

- Lower tools

Stainless Steel 304 & 316

Mild Steel

Aluminium 5052

Thickness	V Width	Die Width Angle° Name	Bend Rad Inside	K Factor	Min Fold	Joggle	Die Length		
0.9	8	EV002 20mm 30°	1.5	0.39	5.6	11.5	EV002 3050		
			1.4	0.39					
			1	0.6					
1.2	8	EV002 20mm 30°	1.5	0.35	5.6	11.5	EV002 3050		
			1.4	0.37					
			1.5	0.56					
1.5	12	EV004 25mm 30°	2.3	0.31	7.8	14.9	EV004 3050		
			1.9	0.3					
			2	0.54					
2.0	16	EV005 30mm 30°	EV024 30mm 86°	3.1	0.34	9.5/11.5	18.3	EV005 2450	EV024 3050
				2.6	0.36				
				2.6	0.57				
2.5	20	EV025 30mm 86°		3.9	0.35	12	19	EV025 3050	
				3.2	0.36				
				3.2	0.54				
3.0	24	*EV007 40mm 30°	EVO26 35mm 86°	4.3	0.32	14.5/16.1	24.1	EV007 3050	EVO26 3050
				3.9	0.36				
				3.8	0.55				
4.0	30	EV027 45mm 86°		5.4	0.33	18	28	2300	
				4.0	0.39			3050	
				5.1	0.55			3050	
5.0	40	OZU-032 50mm 40°		6.9	0.31	24	32.2	2000	
				5.1	0.35			3050	
				6.2	0.44			3050	
6.0	40	OZU-032 50mm 40°		6.7	0.33	24	32.2	1400	
				5.1	0.36			1700	
				7.2	0.4			2800	
8.0	62.5	VLM-W62 120mm 40°		10.4	0.28	41	72.9	VLM-W62 2 X 250	
				7.7	0.31				
10	82.5	VLM-W82 120mm 50°		13.8	0.28	54	96.6	VLM-W82 2 X 250	
				10.6	0.28				
12	102.5	VLM-W102 120mm 60°		17.8	0.26	66	120.4	VLM-W102 2 X 250	
				12.9	0.32				

Max thickness for crushed edge 2mm.

Any hole within folding area disturbs overall dimensions and may distort the part.

When using minimum joggle, consider tool height (if flange is longer than tool height include pre-bend).