

Stainless Steel 304 &amp; 316

Mild Steel

Aluminium 5052

**STANDARD TOOLING**

STANDARD DIES										
Thickness mm	V width mm	Die name, width & angle	Bend Rad (inside)	K factor	Offset mm	Min Flange mm (90 °) (!)	Joggle mm	Max Fold Length mm		
0.5	4	EV/S-W4 8mm 86°	1.10	0.45	0.22	5.7	4.5	500		
			1.00	0.45	0.22			500		
			1.00	0.60	0.30			500		
0.7	6	EV001/S 16mm (6 - 10)(@) 30°	1.20	0.45	0.31	5.7	6.8	1750		
			1.10	0.45	0.31			1750		
			1.00	0.60	0.42			1750		
0.9	8	EV002 20mm 30°	1.50	0.39	0.35	5.7	11.5	4200		
			1.40	0.39	0.35			4200		
			1.00	0.60	0.54			4200		
1.2	8	EV002 20mm 30°	1.50	0.35	0.42	5.7	11.5	4200		
			1.40	0.37	0.44			4200		
			1.50	0.56	0.67			4200		
1.5	12	EV004 25mm 30°	EV023/S 16mm 86°	2.30	0.31	0.47	7.8 7.6	14.9	4200	450
				1.90	0.30	0.45			4200	450
				2.00	0.54	0.81			4200	450
2	16	EV005 30mm 30°	EV024 30mm 86°	3.10	0.34	0.68	10.4 10.1	18.3	4200	4200
				2.60	0.36	0.72			4200	4200
				2.60	0.57	1.14			4200	4200
2.5	20	EV025 30mm 86°		3.90	0.35	0.88	12.7	19	4200	
				3.20	0.36	0.90			4200	
				3.20	0.54	1.35			4200	
3	24	(#)EV007 40mm 30°	EVO26 35mm 86°	4.30	0.32	0.96	15.6 15.2	24.1	4200	4200
				3.90	0.36	1.08			4200	4200
				3.80	0.55	1.65			-	4200
4	30	EV027 45mm 86°		5.40	0.33	1.32	19.1	28	4200	
				4.00	0.39	1.56			4200	
				5.10	0.55	2.20			4200	
5	40	OZU-032 50mm 40°	EVO28 55mm 86°	6.90	0.31	1.55	26.2 25.6	37	3230	3500
				5.10	0.35	1.75			3230	4200
				6.20	0.44	2.20			3230	4200
6	50	EVO29 65mm 86°		8.50	0.30	1.80	32.3	45	3100	
				6.50	0.37	2.22			3550	
				(%) 7.60	0.40	2.40			3550	
8	60	EV-W60 75mm 86°		10.50	0.31	2.48	38.2	52	2050	
				8.80	0.38	3.04			2050	
				-	-	-			-	

**VLM TOOLING**

8	62	VLM-W62 120mm 40°	10.40	0.28	2.24	41.3	72.9	2000
			7.70	0.31	2.48			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 60°	-	-	-	80	170	-
			15.20	0.32	5.12			1500
			-	-	-			-

(!): Those values are valid for short folds only (&lt; 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. (%): Be aware that depending on the supplier, the material might crack. Use R10.0 top tool if possible (bend rad 10.0).