

## STANDARD TOOLING

|                |              | Stainless Steel 304 & 316          |                        | Mild Steel |             | Aluminium 5052 H32       |                 |                                       |      |      |
|----------------|--------------|------------------------------------|------------------------|------------|-------------|--------------------------|-----------------|---------------------------------------|------|------|
| Thickness (mm) | V width (mm) | Die Name<br>Die Width<br>Die Angle | Bend Rad (inside) (mm) | K factor   | Offset (mm) | Min Flange @90° (mm) (!) | Min Joggle (mm) | Tooling Length / Max Fold Length (mm) |      |      |
| 0.5            | 4            | EV/S-W4<br>8mm<br>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<br>16mm (6 - 10)(@)<br>30° | 1.20                   | 0.45       | 0.31        | 5.7                      | 6.8             | 1550                                  |      |      |
|                |              |                                    | 1.10                   | 0.45       | 0.31        |                          |                 | 1550                                  |      |      |
|                |              |                                    | 1.00                   | 0.60       | 0.42        |                          |                 | 1550                                  |      |      |
| 0.9            | 8            | EV002<br>20mm<br>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<br>20mm<br>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<br>25mm<br>30°               | EV023/S<br>16mm<br>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<br>30mm<br>30°               | EV024<br>30mm<br>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<br>30mm<br>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<br>40mm<br>30°              | EVO26<br>35mm<br>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<br>45mm<br>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<br>50mm<br>40°             | EVO28<br>55mm<br>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<br>75mm<br>86°               |                        | 8.50       | 0.30        | 1.80                     | 32.3            | 45                                    | 3100 |      |
|                |              |                                    |                        | 6.50       | 0.37        | 2.22                     |                 |                                       | 3550 |      |
|                |              |                                    |                        | -          | -           | -                        |                 |                                       | -    |      |
| 8              | 60           | EV-W60<br>75mm<br>86°              |                        | 10.50      | 0.31        | 2.48                     | 38.2            | 52                                    | 2050 |      |
|                |              |                                    |                        | 8.80       | 0.38        | 3.04                     |                 |                                       | 2050 |      |
|                |              |                                    |                        | -          | -           | -                        |                 |                                       | -    |      |

## VLM TOOLING (Heavy duty tooling for thick material)

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

(!): 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.