

BEND CHART

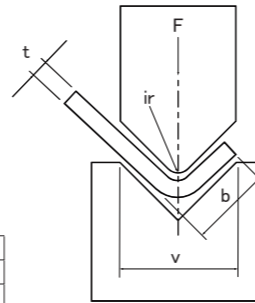
Please scan QR code and see Vol.3.



t : Material thickness
(Tensile Strength 450~500N/mm²)

F : Pressure per 1m (kN/m)
ir : Radius of punch tip

b : Minimum length of flange
v : Width of die



For mild steel

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	v
(mm)	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir
0.5	40	30																				
0.6	60	40	40	40																		
0.8		70	70	50	40																	
1		110	100	80	70	60																
1.2			140	120	110	80	70	60														
1.4				150	130	110	100	90	80													
1.5				200	170	150	130	110	100	90												
1.6					170	150	130	110	100	90												
2						220	190	170	150	130	110											
2.3							250	230	190	170	150	120										
2.6								280	250	220	180	140										
3									340	300	240	190	150									
3.2										340	270	220	170	140								
3.5											330	260	200	160	130							
4											430	340	270	210	170							
4.5												440	340	270	210							
5												520	420	330	260	210						
6													600	480	380	300	240					
7														520	410	330	260					
9															670	540	430					
10															850	670	530	420				
12																960	780	600	550			
16																	1360	1070	860			
19																		1500	1250	1000		
20																		1700	1350	1080		
22																				1600	1300	
25																				2100	1700	
30																					2400	

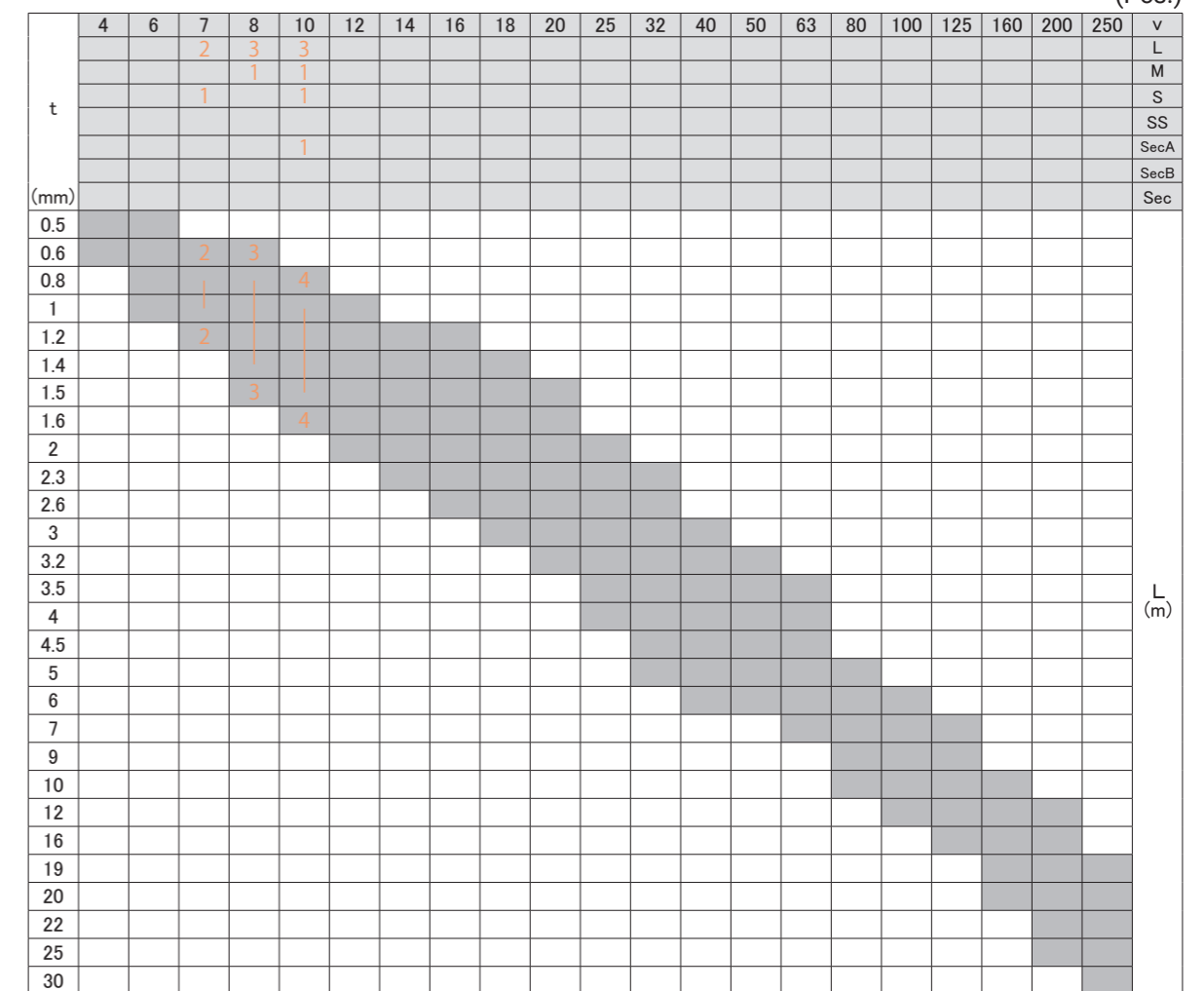
For stainless

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	v
(mm)	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir
0.5	60	50																				
0.6	90	60	60	60																		
0.7	120	80	80	60	60																	
0.8		110	110	80	70																	
0.9		130	120	100	90	70																
1		170	150	120	110	90																
1.2			210	180	150	120	110	90														
1.5				290	230	200	170	150	130	120												
2					330	290	260	230	200	170	190											
2.5						390	350	300	250	190												
3							510	450	360	290	230											
4								650	510	410	320	260										
5									780	630	500	390	320									
6										900	720	570	450	360								
8											1020	810	650	510								
10												1290	1010	800	630							
12													1440	1170	900	830						
15														1800	1410	1140						
20															2500	2080	1670					
25																3150	2550					
30																	3600					

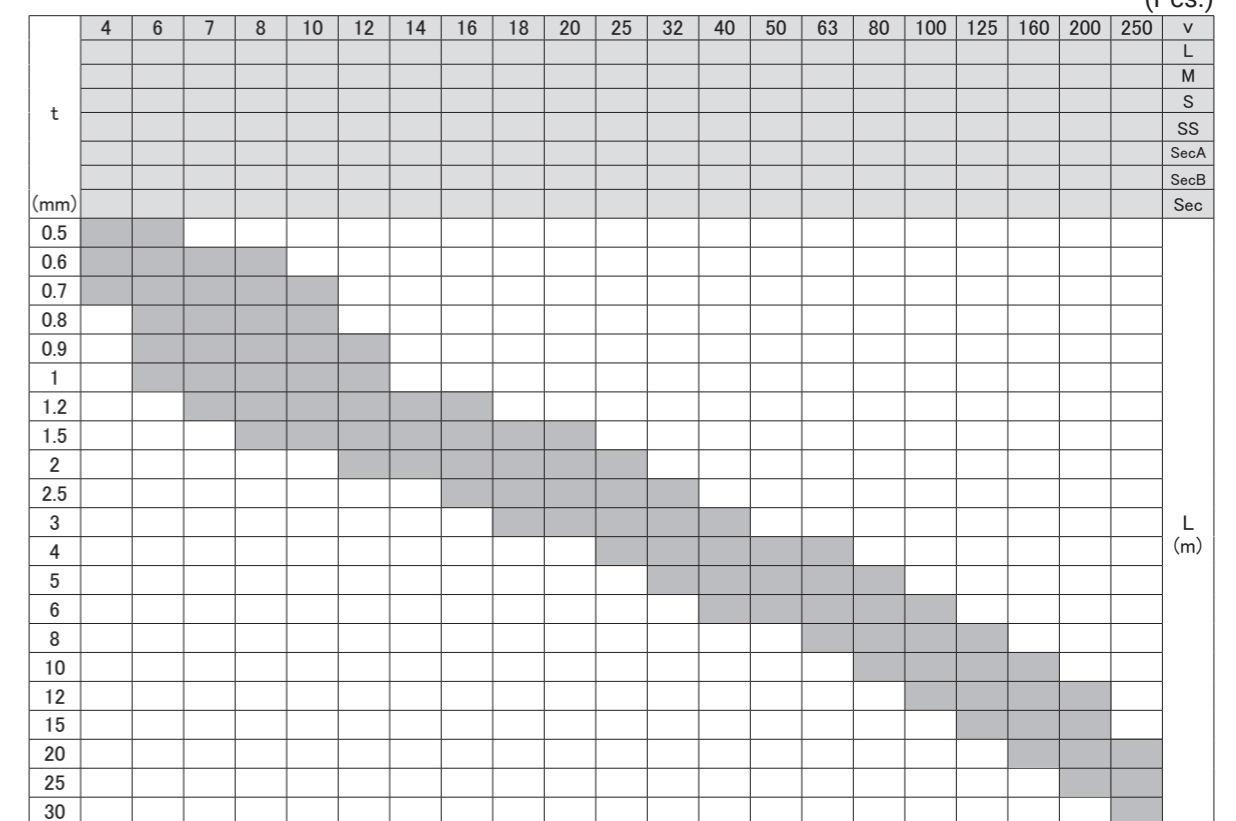
Please share your stock list with cowoker.

Size L : 835 Size M : 500 Size S : 415 Size SS : 200
Sectionalized 370(10/10/15/20/25/40/50/100/100)
Sectionalized 365(20/25/30/40/50/100/100)
Sectionalized B 800(10/15/20/40/50/100/200/365)
(mm)

For mild steel ※Sample



For stainless



BEND CHART

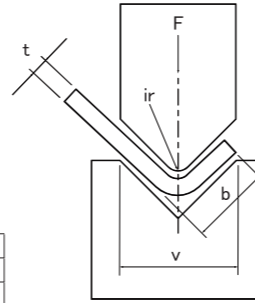
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For mild steel

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(mm)	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir
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0.6	60	40	40	40																		
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1.2			140	120	110	80	70	60														
1.4				150	130	110	100	90	80													
1.5				200	170	150	130	110	100	90												
1.6					170	150	130	110	100	90												
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4.5												440	340	270	210							
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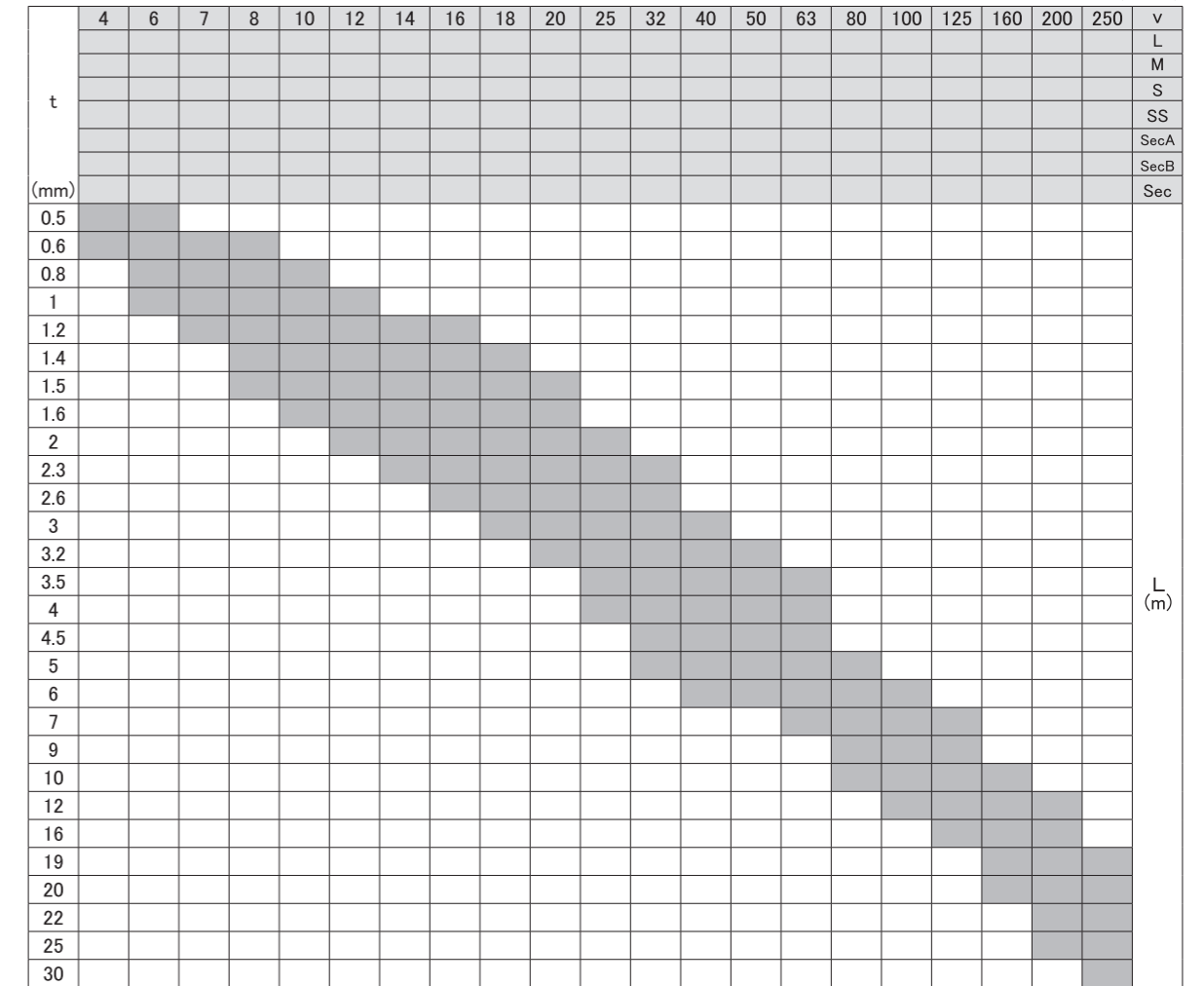
For stainless

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For mild steel



For stainless

