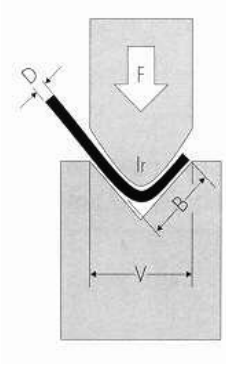
JHMSERVICE +4530943320

Table showing needed opening in die for 90 degr. folding operations –material quality 450 N/mm²

	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V
D	2,8	4	5	5,5	7	8,5	10	11	13,	14	17,	22	28	35	45	55	70	89	113	140	175	B
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	4	3																				
0,6	6	4	4	4																		
0,8		7	7	5	4																	
1		11	10	8	7	6																
1,2			14	12	10	8	7	6														
1,4				15	13	11	10	9	8													
1,6					17	15	13	11	10	9												
2						22	19	17	15	13	11											
2,3							25	23	19	17	15	12										
2,6								28	25	22	18	14										
3									34	30	24	19	15									
3,2										33	26	20	16	13								
3,5										43	34	27	21	17								
4											44	34	27	21	17							
4,5												44	34	27	21							
5												52	42	33	26	21						
6													60	48	38	30	24					
7															52	41	33	26				
9																67	54	43				
10																85	67	53	42			
12																	96	76	60	56		
16																		136	107	86		
19																			150	125	100	
22																				160	130	
25																				210	170	
30																					240	

= Recommended tonnage for sharpest 90 degr. fold



D Material thickness
F Tonnage per metre to make a 90 degr. fold in die (numbers in diagonal)
Ir Inner radius
B Minimum arm length in fold
V Opening width in die

Material Quality

Steel 370 – 450 N/mm2
Material Quality
Steel 370 – 450 N/mm2

Stainless steel 650 – 700 N/mm2
Aluminium 200 – 300 N/mm2
Stainless steel 650 – 700 N/mm2

Refined, corroded or non-oiled sheets increase the necessary folding power essentially.

Determining opening width in die

Sheet thickness mm D	0,5 – 2,5	3,0 – 8,0	9,0 – 10,0	12,0 >
Opening width in die V	6 x D	8 x D	10 x D	12 x D

Determining minimum arm length in fold

Angel	165°	135°	120°	90°	60	45	30
Arm length	0,51 x V	0,55 x V	0,58 x V	0,71 x V	1 x V	1,31 x V	1,94 x V

min. $\frac{V}{2}$ + mat.thickness