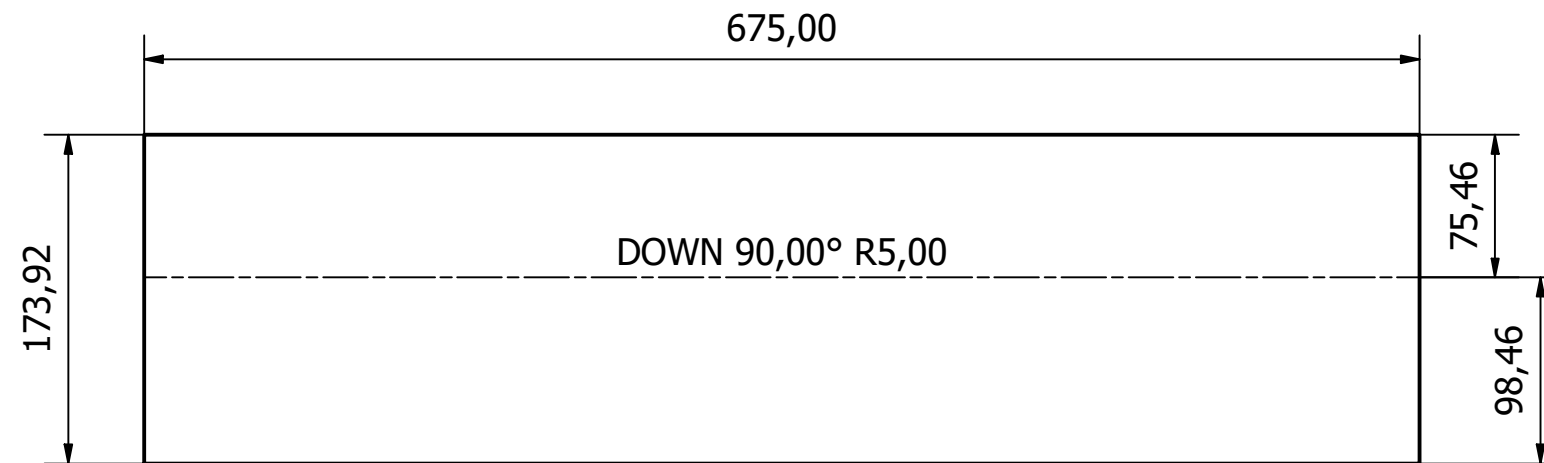
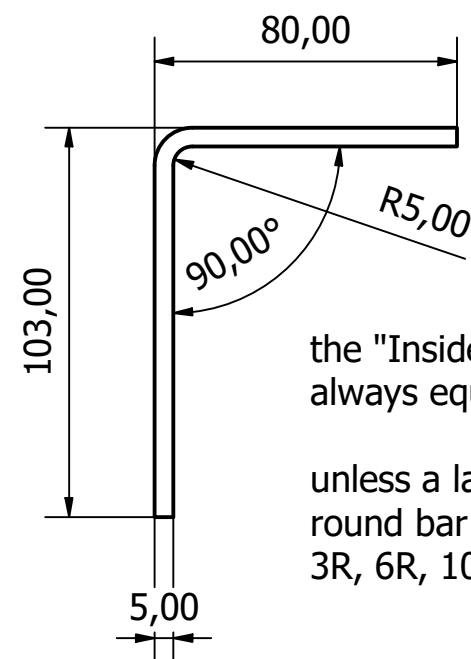




drawn with 0.39 Kfactor,
this is an average of our kfactor
as kfactor changes with the V and the Blade used with each thickness
general rule for what V to be used is 8-10x the material thickness.

if you want perfect 0.2mm -/+ accuracy then a stepfile (.stp) will
need to be supplied and we will run it through our CNC pressbrake
software.



the "Inside fold radius" should
always equal the material thickness, never smaller than.

unless a larger internal radius is required.
round bar tooling available for such requests are
3R, 6R, 10R, and 15R

MINIMUM INFORMATION NEEDED.

the information needed for folding on the PDF
if supplying just PDF and a DXF cutting file
is whats shown here, a flat pattern and a side view,

flat pattern to have the fold line, the measurement to the fold line,
the degree's to be folded and the radius of the fold.

the side view to have the overall measurements of the folded part
of the desired development, angles in degree's, and the bend radius.

material thickness, material type, and quantity to be also noted, unless
it is noted else where, but best practice to put on the pdf drawing.

Designed by KE-Kahil	Checked by KANYANA ENGINEERING PTY LTD	Approved by	Date	Date 7/02/2022	
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