



PRESS BRAKE SYSTEMS

2025 PRODUCT CATALOG

Precision bending platforms engineered for modern fabrication—from compact all-electric systems to synchronized tandem and high-tonnage machines.



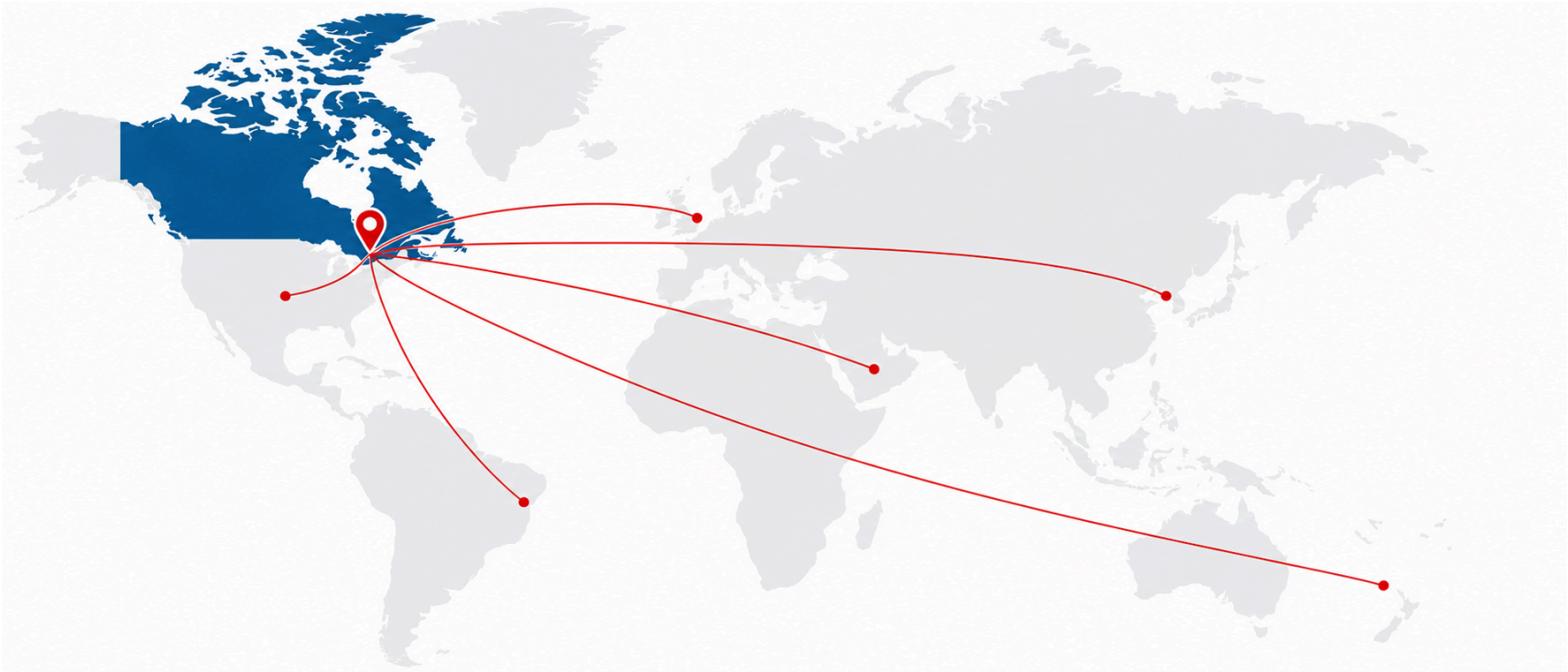
BENDRYX EQUIPMENT

FULL ELECTRIC | SERVO HYBRID | TANDEM | HIGH TONNAGE

CANADA-BASED SALES AND SERVICE

WHERE THE CUSTOMER IS, THE SERVICE IS THERE

BENDRYX press brake systems are supported through RiseTek Machinery in Canada, with application guidance, installation coordination, operator training and responsive parts support.



CANADA

SALES, APPLICATIONS AND SERVICE COORDINATION

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CONNECTED FABRICATION

MORE PROFESSIONAL.
MORE EFFICIENT.

Integrated loading, bending, transfer and stacking modules reduce manual handling and support repeatable unattended production. Each system is engineered around the workpiece, process sequence, required throughput and available floor space.

AUTOMATIC LOADING

Material storage, retrieval and loading modules reduce waiting time.

ROBOTIC BENDING

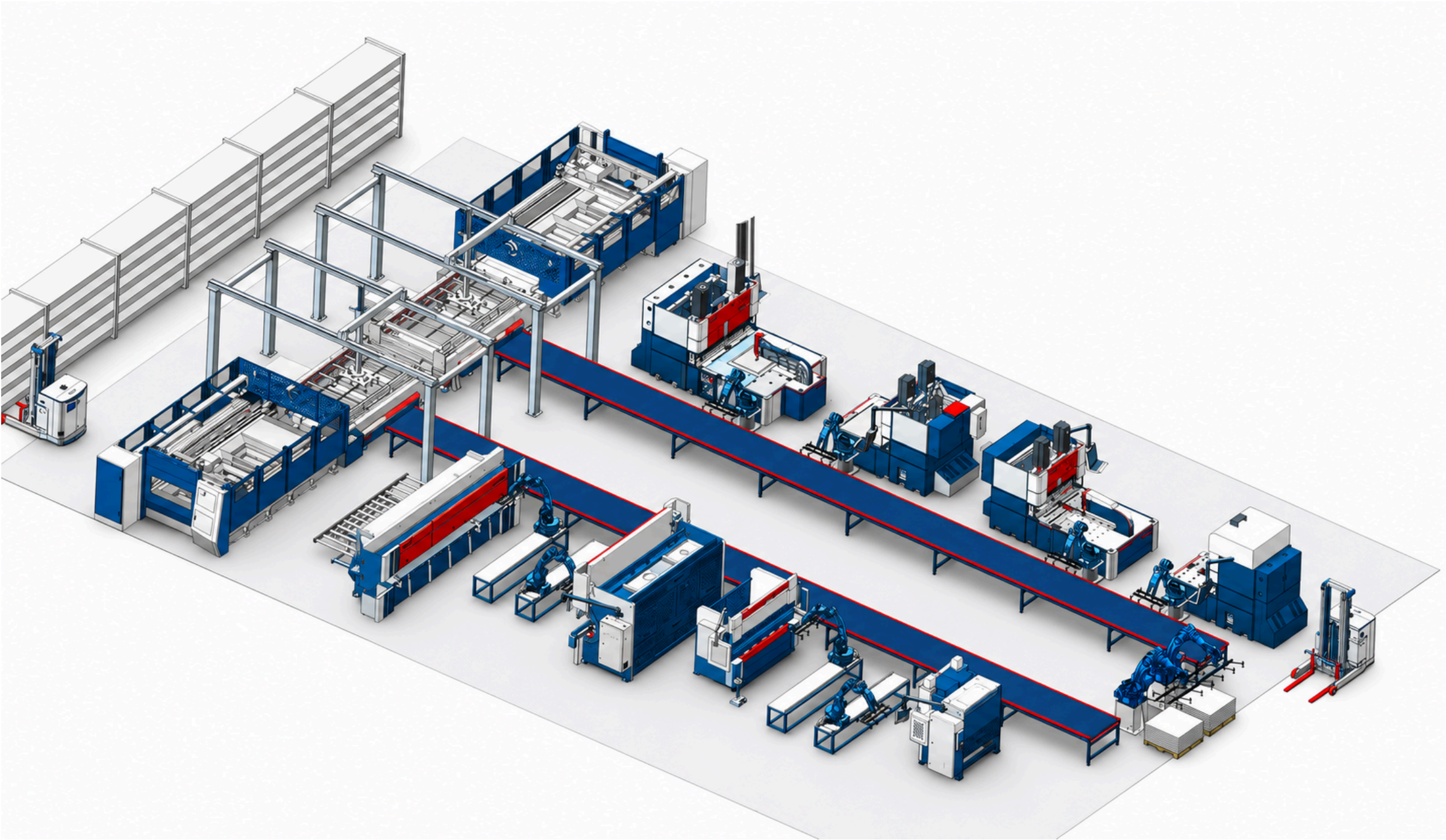
Repeatable part manipulation for stable high-volume production.

FLEXIBLE FLOW

Cells can combine cutting, bending, transfer and stacking operations.

SAFER HANDLING

Automated movement reduces forklift traffic and manual lifting.



FULL ELECTRIC SERVO PRESS BRAKE

PRECISION, SPEED, ENERGY SAVINGS

The BENDRYX E-Series eliminates hydraulic oil while delivering fast slider motion, repeatable positioning and a compact production footprint.

- All-electric servo drive
- Up to 6+1 controlled axes
- 25–80 ton configurations



E-SERIES TECHNICAL SPECIFICATIONS

MODEL	FORCE	WORKBENCH	BETWEEN COLUMNS	THROAT	STROKE	OPENING	MAIN MOTOR
BX-E080-2500	80 ton	2,500 mm	2,190 mm	400 mm	150 mm	420 mm	20 × 2 kW
BX-E060-2000	60 ton	2,000 mm	1,930 mm	400 mm	150 mm	420 mm	8.6 × 2 kW
BX-E040-1500	40 ton	1,500 mm	1,430 mm	400 mm	150 mm	420 mm	8.6 × 2 kW
BX-E035-1200	35 ton	1,200 mm	1,130 mm	400 mm	150 mm	420 mm	5.5 × 2 kW
BX-E025-0800	25 ton	800 mm	635 mm	300 mm	150 mm	420 mm	8.6 kW

MATCHED TO YOUR APPLICATION

E-SERIES CONFIGURATION LIST & CNC SYSTEM

CONFIGURATION RANGE

FORCE 25-80 ton	WORKING LENGTH 800-2,500 mm	CONTROLLED AXES 3 to 6+1	DRIVE Direct electric servo
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MODEL / FAMILY	FORCE	WORKING LENGTH	GAUGE
BX-E025-0800	25 ton	800 mm	3 axis
BX-E035-1200	35 ton	1,200 mm	4 axis
BX-E040-1500	40 ton	1,500 mm	6 axis
BX-E060-2000	60 ton	2,000 mm	6 axis
BX-E080-2500	80 ton	2,500 mm	6+1 axis

Final configuration, tooling, controller and safety package are confirmed against the part mix and production method.

CNC SYSTEM OPTIONS



DELEM
DA-53Tx, DA-58Tx, DA-66S and DA-69S options with graphical programming, bend sequencing, correction and production management.



CYBELEC
CT-8, CT-12 and CT-15 touchscreen options with fast program access, 2D/3D workflows and configuration-dependent axis control.

6-AXIS REAR GAUGE

- Servo positioning for speed and repeatability
- Expandable axis architecture by model
- Reserved upgrade positions on selected systems
- Application-matched fingers and supports



UP-ACTING HYBRID CNC PRESS BRAKE

STABLE, PRECISE BENDING

The BENDRYX UAH-Series combines a compact footprint, stable up-acting ram control and straightforward CNC operation for small- and medium-format work.

- Up-acting hybrid architecture
- 35–100 ton configurations
- 3 / 5-axis rear gauge options



UAH-SERIES TECHNICAL SPECIFICATIONS

MODEL	FORCE	WORKBENCH	BETWEEN COLUMNS	THROAT	STROKE	OPENING	MAIN MOTOR
BX-UAH-H100-3100	100 ton	3,100 mm	2,550 mm	405 mm	100 mm	390 mm	7.5 kW
BX-UAH-H080-2500	80 ton	2,500 mm	2,090 mm	405 mm	100 mm	390 mm	7.5 kW
BX-UAH-H060-2000	60 ton	2,000 mm	1,700 mm	405 mm	100 mm	390 mm	5.5 kW
BX-UAH-H050-1600	50 ton	1,600 mm	1,220 mm	405 mm	100 mm	390 mm	4.0 kW
BX-UAH-H035-1200	35 ton	1,200 mm	1,020 mm	300 mm	100 mm	390 mm	3.0 kW

MATCHED TO YOUR APPLICATION

UAH-SERIES CONFIGURATION LIST & CNC SYSTEM

CONFIGURATION RANGE

FORCE 35-100 ton	WORKING LENGTH 1,200-3,100 mm	CONTROLLED AXES 3 or 5	DRIVE Servo-hydraulic
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MODEL / FAMILY	FORCE	WORKING LENGTH	GAUGE
BX-UAH-H035-1200	35 ton	1,200 mm	3 / 5 axis
BX-UAH-H050-1600	50 ton	1,600 mm	3 / 5 axis
BX-UAH-H060-2000	60 ton	2,000 mm	3 / 5 axis
BX-UAH-H080-2500	80 ton	2,500 mm	3 / 5 axis
BX-UAH-H100-3100	100 ton	3,100 mm	3 / 5 axis

Final configuration, tooling, controller and safety package are confirmed against the part mix and production method.

CNC SYSTEM OPTIONS



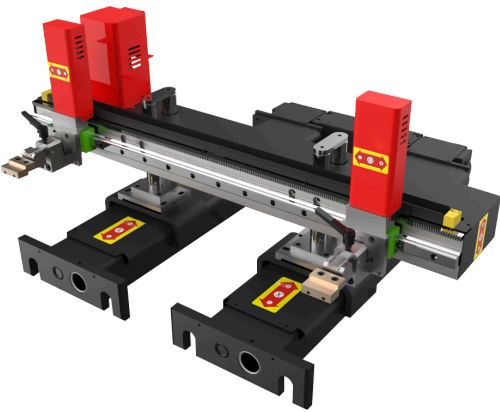
DELEM
DA-53Tx, DA-58Tx, DA-66S and DA-69S options with graphical programming, bend sequencing, correction and production management.



CYBELEC
CT-8, CT-12 and CT-15 touchscreen options with fast program access, 2D/3D workflows and configuration-dependent axis control.

3 / 5-AXIS REAR GAUGE

- Servo positioning for speed and repeatability
- Expandable axis architecture by model
- Reserved upgrade positions on selected systems
- Application-matched fingers and supports



ADAPTIVE SERVO HYBRID CNC PRESS BRAKE

STRAIGHTNESS FOR DEMANDING WORK

A servo-hydraulic platform for accurate bending of larger and thicker workpieces. Adaptive compensation, a rigid frame and multi-axis rear-gauge options support consistent angles and overall part straightness.

- Adaptive compensation
- 4-axis rear gauge architecture
- 80–220 ton configurations



AS-SERIES TECHNICAL SPECIFICATIONS

MODEL	FORCE	WORKBENCH	BETWEEN COLUMNS	THROAT	STROKE	OPENING	MAIN MOTOR
BX-AS-H080-2500	80 ton	2,500 mm	2,000 mm	400 mm	160 mm	450 mm	7.5 kW
BX-AS-H110-2500 / 3200 / 4000	110 ton	2,500–4,000 mm	2,000–3,500 mm	400 mm	200 mm	500 mm	7.5 kW
BX-AS-H130-2500 / 3200 / 4000	130 ton	2,500–4,000 mm	2,000–3,500 mm	400 mm	200 mm	500 mm	8.8 kW
BX-AS-H170-3200 / 4000	170 ton	3,200–4,000 mm	2,700–3,500 mm	400 mm	200 mm	500 mm	8.8 kW
BX-AS-H220-3200 / 4000	220 ton	3,200–4,000 mm	2,700–3,500 mm	400 mm	250 mm	560 mm	11 kW

Model suffix identifies nominal working length. Full configuration mapping is included in the companion Excel workbook.

MATCHED TO YOUR APPLICATION

AS-SERIES CONFIGURATION LIST & CNC SYSTEM

CONFIGURATION RANGE

FORCE 80-220 ton	WORKING LENGTH 2,500-4,000 mm	CONTROLLED AXES 4 axis	DRIVE Adaptive hybrid
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MODEL / FAMILY	FORCE	WORKING LENGTH	GAUGE
BX-AS-H080-2500	80 ton	2,500 mm	4 axis
BX-AS-H110 family	110 ton	2,500-4,000 mm	4 axis
BX-AS-H130 family	130 ton	2,500-4,000 mm	4 axis
BX-AS-H170 family	170 ton	3,200-4,000 mm	4 axis
BX-AS-H220 family	220 ton	3,200-4,000 mm	4 axis

Final configuration, tooling, controller and safety package are confirmed against the part mix and production method.

CNC SYSTEM OPTIONS



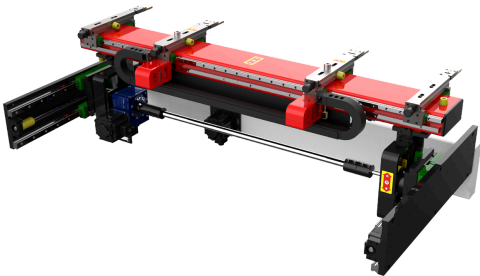
DELEM
DA-53Tx, DA-58Tx, DA-66S and DA-69S options with graphical programming, bend sequencing, correction and production management.



CYBELEC
CT-8, CT-12 and CT-15 touchscreen options with fast program access, 2D/3D workflows and configuration-dependent axis control.

4-AXIS REAR GAUGE

- Servo positioning for speed and repeatability
- Expandable axis architecture by model
- Reserved upgrade positions on selected systems
- Application-matched fingers and supports



SINGLE SERVO HYBRID CNC PRESS BRAKE

HIGH CAPACITY FOR THICK PLATE

An all-steel welded press brake with a servo-driven hydraulic power system, automatic deflection compensation and a reliable rear gauge. Built for a broad range of tonnage and working-length requirements.

- Tempered welded frame
- Automatic deflection compensation
- 35–400 ton configurations



SS-SERIES CONFIGURATION RANGE

MODEL FAMILY	FORCE	AVAILABLE WORKBENCHES	THROAT	STROKE	OPENING	MAIN MOTOR
BX-SS-H035	35 ton	1,200 / 1,600 mm	300 mm	100 mm	390 mm	4 kW
BX-SS-H050	50 ton	1,600 / 2,000 mm	300 mm	100 mm	390 mm	5.5 kW
BX-SS-H080	80 ton	2,000 / 2,500 / 3,200 mm	400 mm	160 mm	450 mm	7.5 kW
BX-SS-H110 / H130	110–130 ton	2,500 / 3,200 / 4,000 mm	400 mm	200 mm	500 mm	7.5–8.8 kW
BX-SS-H170 / H220	170–220 ton	3,200 / 4,000 / 5,000 mm	400 mm	200–250 mm	500–560 mm	8.8–11 kW
BX-SS-H250 / H320 / H400	250–400 ton	3,200 / 4,000 / 5,000 / 6,000 mm	500 mm	250–320 mm	560–650 mm	18.5–30 kW

Complete length-by-length model codes and factory cross-reference are provided in the companion Excel workbook.

MATCHED TO YOUR APPLICATION

SS-SERIES CONFIGURATION LIST & CNC SYSTEM

CONFIGURATION RANGE

FORCE 35-400 ton	WORKING LENGTH 1,200-6,000 mm	CONTROLLED AXES 4 to 6	DRIVE Single servo hybrid
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MODEL / FAMILY	FORCE	WORKING LENGTH	GAUGE
BX-SS-H035 / H050	35-50 ton	1,200-2,000 mm	4 axis
BX-SS-H080	80 ton	2,000-3,200 mm	4 axis
BX-SS-H110 / H130	110-130 ton	2,500-4,000 mm	4 axis
BX-SS-H170 / H220	170-220 ton	3,200-5,000 mm	4 / 6 axis
BX-SS-H250 / H320 / H400	250-400 ton	3,200-6,000 mm	4 / 6 axis

Final configuration, tooling, controller and safety package are confirmed against the part mix and production method.

CNC SYSTEM OPTIONS



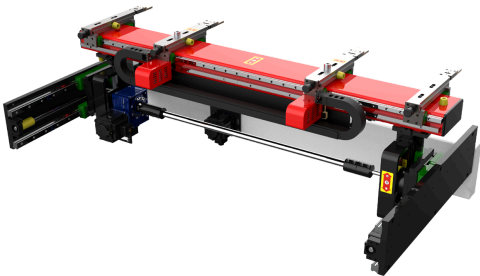
DELEM
DA-53Tx, DA-58Tx, DA-66S and DA-69S options with graphical programming, bend sequencing, correction and production management.



CYBELEC
CT-8, CT-12 and CT-15 touchscreen options with fast program access, 2D/3D workflows and configuration-dependent axis control.

4 / 6-AXIS REAR GAUGE

- Servo positioning for speed and repeatability
- Expandable axis architecture by model
- Reserved upgrade positions on selected systems
- Application-matched fingers and supports



DUAL SERVO HYBRID CNC PRESS BRAKE

EFFICIENCY WITH HEAVY-DUTY RIGIDITY

A dual-servo oil-electric hybrid platform with high structural rigidity, lower heat generation and reduced working noise. Available in integral or split-frame configurations for demanding production environments.

- Dual-servo hybrid drive
- High-rigidity mainframe
- 80–400 ton configurations



DS-SERIES CONFIGURATION RANGE

MODEL FAMILY	FORCE	AVAILABLE WORKBENCHES	THROAT	STROKE	OPENING	MAIN MOTOR
BX-DS-H080	80 ton	2,500 / 3,200 mm	400 mm	160 mm	450 mm	7.5 kW
BX-DS-H110 / H130	110–130 ton	2,500 / 3,200 / 4,000 mm	400 mm	200 mm	500 mm	7.5–8.8 kW
BX-DS-H170 / H220	170–220 ton	3,200 / 4,000 / 5,000 mm	400 mm	200–250 mm	500–560 mm	8.8–11 kW
BX-DS-H250	250 ton	3,200 / 4,000 / 5,000 / 6,000 mm	500 mm	250 mm	560 mm	18.5 kW
BX-DS-H320	320 ton	3,200 / 4,000 / 5,000 / 6,000 / 8,000 mm	500 mm	300 mm	620 mm	22 kW
BX-DS-H400	400 ton	3,200 / 4,000 / 5,000 / 6,000 / 8,000 mm	500 mm	320 mm	650 mm	30 kW

Model suffix identifies nominal working length. Split-frame options are available on selected configurations.

MATCHED TO YOUR APPLICATION

DS-SERIES CONFIGURATION LIST & CNC SYSTEM

CONFIGURATION RANGE

FORCE 80-400 ton	WORKING LENGTH 2,500-8,000 mm	CONTROLLED AXES 4 to 6	DRIVE Dual servo hybrid
MODEL / FAMILY	FORCE	WORKING LENGTH	GAUGE
BX-DS-H080	80 ton	2,500-3,200 mm	4 axis
BX-DS-H110 / H130	110-130 ton	2,500-4,000 mm	4 axis
BX-DS-H170 / H220	170-220 ton	3,200-5,000 mm	4 / 6 axis
BX-DS-H250	250 ton	3,200-6,000 mm	4 / 6 axis
BX-DS-H320 / H400	320-400 ton	3,200-8,000 mm	4 / 6 axis

Final configuration, tooling, controller and safety package are confirmed against the part mix and production method.

CNC SYSTEM OPTIONS



DELEM
DA-53Tx, DA-58Tx, DA-66S and DA-69S options with graphical programming, bend sequencing, correction and production management.



CYBELEC
CT-8, CT-12 and CT-15 touchscreen options with fast program access, 2D/3D workflows and configuration-dependent axis control.

4 / 6-AXIS REAR GAUGE

- Servo positioning for speed and repeatability
- Expandable axis architecture by model
- Reserved upgrade positions on selected systems
- Application-matched fingers and supports

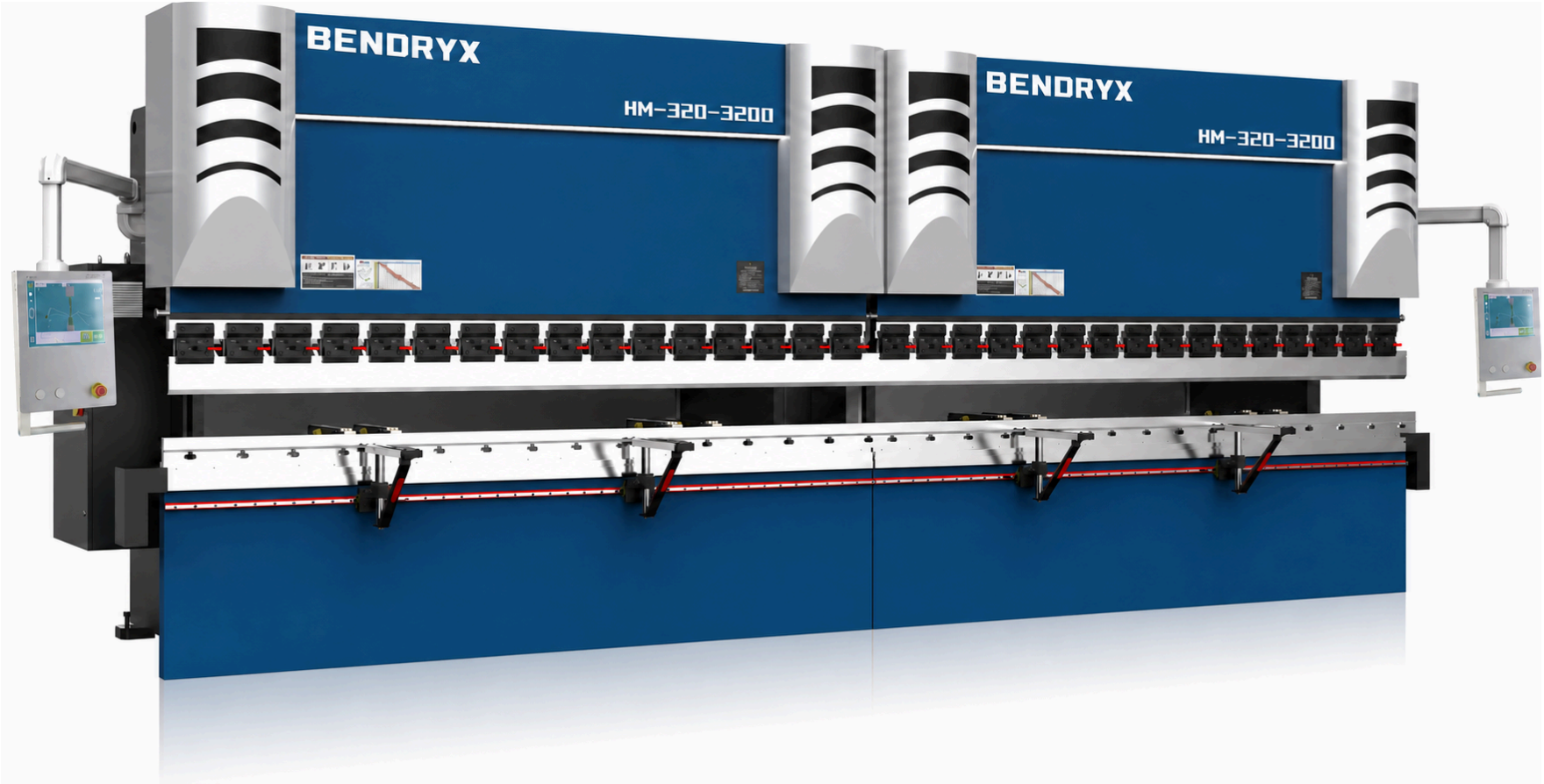


TANDEM CNC
PRESS BRAKE

LONG-PART BENDING, SYNCHRONIZED

Two synchronized press brakes configured for long and specialized workpieces. The machines can operate together or independently, with optional real-time hydraulic compensation for consistent bending across extended lengths.

- Linked or independent operation
- 6,400 mm combined workbench
- Optional real-time compensation



ST-SERIES TECHNICAL SPECIFICATIONS

MODEL	COMBINED FORCE	COMBINED WORKBENCH	THROAT	STROKE	OPENING	CONTROL	OPERATION
BX-ST320-6400	640 ton	6,400 mm	500 mm	300 mm	620 mm	Delem / Cybelec	Linked or independent

Custom tandem combinations are engineered to application, tooling, material and part-handling requirements.

MATCHED TO YOUR APPLICATION

ST-SERIES CONFIGURATION LIST & CNC SYSTEM

CONFIGURATION RANGE

FORCE 640 ton combined	WORKING LENGTH 6,400 mm combined	CONTROLLED AXES Linked CNC	DRIVE Dual-machine hybrid
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MODEL / FAMILY	FORCE	WORKING LENGTH	GAUGE
BX-ST320-6400	640 ton	6,400 mm	Linked CNC
Custom ST-Series	Application based	Engineered length	Linked / independent

Final configuration, tooling, controller and safety package are confirmed against the part mix and production method.

CNC SYSTEM OPTIONS



DELEM
DA-53Tx, DA-58Tx, DA-66S and DA-69S options with graphical programming, bend sequencing, correction and production management.



CYBELEC
CT-8, CT-12 and CT-15 touchscreen options with fast program access, 2D/3D workflows and configuration-dependent axis control.

SYNCHRONIZED REAR GAUGING

- Servo positioning for speed and repeatability
- Expandable axis architecture by model
- Reserved upgrade positions on selected systems
- Application-matched fingers and supports



CNC MULTI-MACHINE TANDEM HYDRAULIC PRESS BRAKE

EXTREME TONNAGE FOR SPECIAL WORK

A multi-machine electro-hydraulic system for very large bending applications. Closed-loop slider control, bidirectional deflection compensation and configurable auxiliary handling support long, heavy and specialized workpieces.

- 3,200–30,000 kN models
- Closed-loop slider control
- Adjustable lower-die system



X-SERIES ENGINEERED RANGE

MODEL	FORCE	WORKBENCH	BETWEEN COLUMNS	THROAT	STROKE	OPENING	MAIN MOTOR
BX-X03200-7000	3,200 kN	7,000 mm	5,800 mm	600 mm	400 mm	800 mm	2 × 30 kW
BX-X04000-7000	4,000 kN	7,000 mm	5,800 mm	600 mm	400 mm	800 mm	2 × 37 kW
BX-X05000-8000	5,000 kN	8,000 mm	6,800 mm	700 mm	500 mm	900 mm	2 × 45 kW
BX-X06300-8000	6,300 kN	8,000 mm	6,800 mm	700 mm	500 mm	900 mm	2 × 55 kW
BX-X08000-9000	8,000 kN	9,000 mm	7,800 mm	800 mm	600 mm	1,000 mm	2 × 75 kW
BX-X10000-9000	10,000 kN	9,000 mm	7,800 mm	800 mm	600 mm	1,000 mm	2 × 90 kW

Additional engineered configurations extend to 30,000 kN. Final specifications are application-dependent.

MATCHED TO YOUR APPLICATION

X-SERIES CONFIGURATION LIST & CNC SYSTEM

CONFIGURATION RANGE

FORCE 3,200-30,000 kN	WORKING LENGTH 6,000-9,000 mm	CONTROLLED AXES Application based	DRIVE Electro-hydraulic
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MODEL / FAMILY	FORCE	WORKING LENGTH	GAUGE
BX-X03200-7000	3,200 kN	7,000 mm	Engineered
BX-X04000-7000	4,000 kN	7,000 mm	Engineered
BX-X05000-8000	5,000 kN	8,000 mm	Engineered
BX-X06300-8000	6,300 kN	8,000 mm	Engineered
BX-X08000 / X10000	8,000-10,000 kN	9,000 mm	Engineered

Final configuration, tooling, controller and safety package are confirmed against the part mix and production method.

CNC SYSTEM OPTIONS



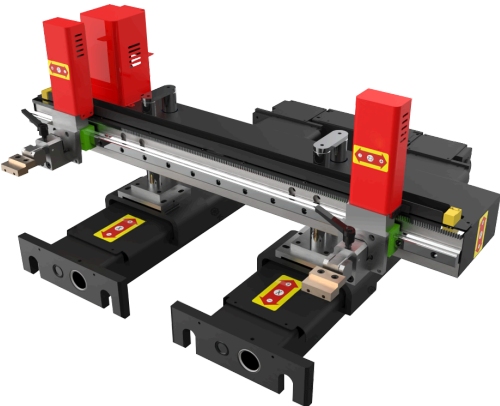
DELEM
DA-53Tx, DA-58Tx, DA-66S and DA-69S options with graphical programming, bend sequencing, correction and production management.



CYBELEC
CT-8, CT-12 and CT-15 touchscreen options with fast program access, 2D/3D workflows and configuration-dependent axis control.

ENGINEERED REAR GAUGE

- Servo positioning for speed and repeatability
- Expandable axis architecture by model
- Reserved upgrade positions on selected systems
- Application-matched fingers and supports



CONTROL, POSITIONING AND FRAME INTEGRITY

CNC CONTROLS & REAR GAUGING

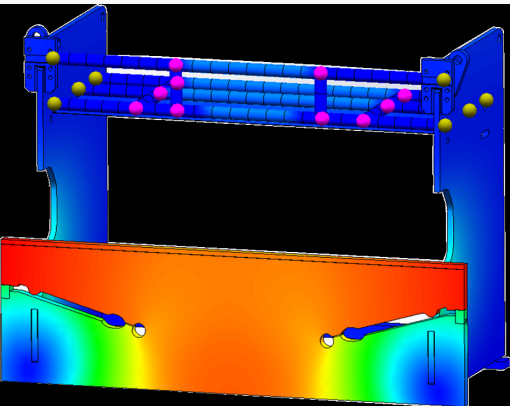
Controller, axis and structural packages are selected around bend complexity, operator workflow and production requirements.



DELEM CNC

High-resolution touchscreen programming for fast setup and graphical bend development.

- DA-53Tx / DA-58Tx / DA-66S / DA-69S
- 2D and 3D graphical programming
- Automatic bend sequence and correction
- Offline programming and USB transfer



FRAME ANALYSIS

Finite-element analysis supports optimized load paths, controlled deformation and long-term frame stability under rated bending force.

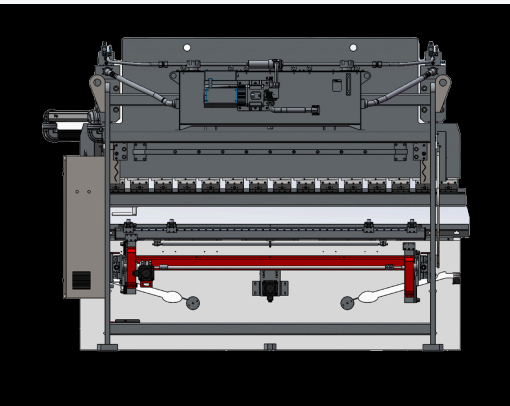
- Tempered welded construction
- Deflection compensation integration
- Application-specific throat and daylight



CYBELEC CNC

Clear operator interface with scalable axis control and straightforward program management.

- CT-8 / CT-12 / CT-15
- Touchscreen graphical workflow
- Network and USB connectivity
- Manual simulation and program storage



POSITIONING & HYDRAULICS

Matched power, feedback and guiding systems support stable pressure, repeatable slider motion and accurate backgauge positioning.

- Optical scale feedback
- Servo motor energy management
- Independent hydraulic reservoir options
- 4- and 6-axis rear gauge packages

OPERATOR PROTECTION AND CLOSED-LOOP QUALITY

SAFETY DEVICES & LASER ANGLE COMPENSATION



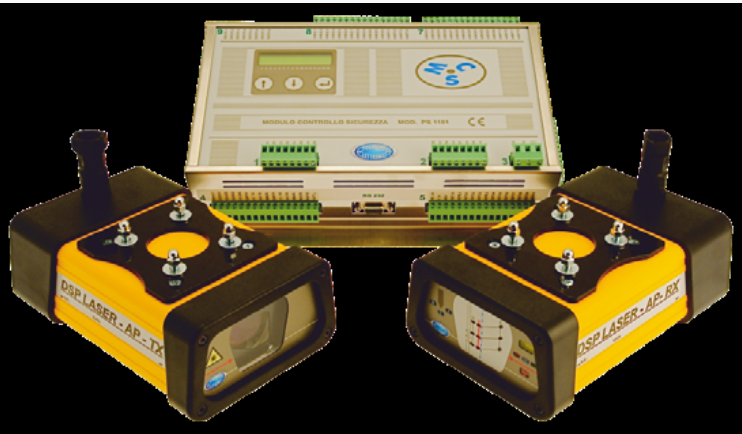
DSP LASER SAFETY

Tool-following laser protection monitors the working zone and immediately interrupts hazardous downward motion.



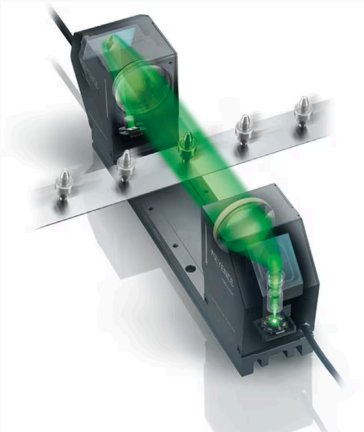
MSD LASER SAFETY

Compact transmitter and receiver protection for upper or lower beam installation and safe high-speed operation.



DSP AP-MCS

Integrated transmitter, receiver and safety control module with monitored communication to the CNC system.



LASER ANGLE DETECTION & COMPENSATION

Non-contact measurement communicates with the CNC in real time to verify the bend angle and apply correction. The system supports higher accuracy without changing tools and can account for material spring-back.

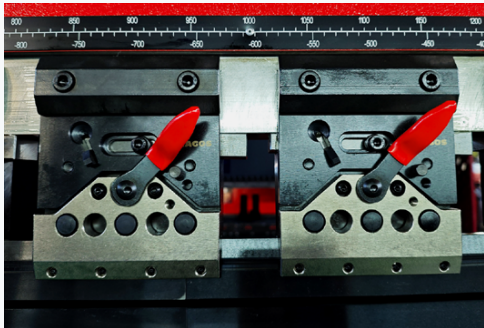


PORTABLE ANGLE MEASUREMENT

A handheld option for fast verification, quality checks and process correction at the machine.

FASTER CHANGEOVER AND SAFER PLATE SUPPORT

TOOL CLAMPING & SHEET FOLLOWERS



MANUAL TOP CLAMPING

Simple mechanical clamping for reliable standard tooling changes.



AUTOMATIC TOP CLAMPING

Single-point operation improves clamping consistency and changeover speed.



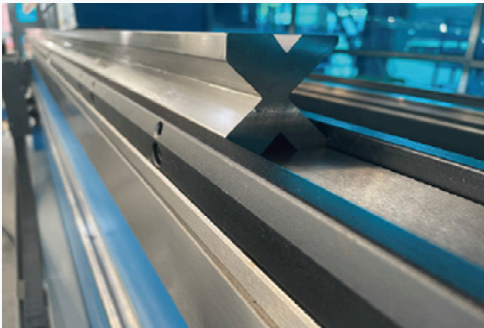
HYDRAULIC TOP CLAMPING

Fast horizontal or vertical loading with automatic seating and alignment.



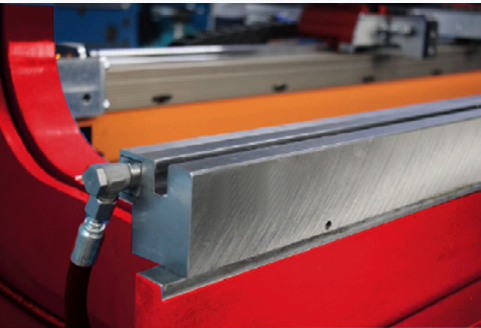
PNEUMATIC TOP CLAMPING

Self-aligning intermediate clamp for quick release and tooling setup.



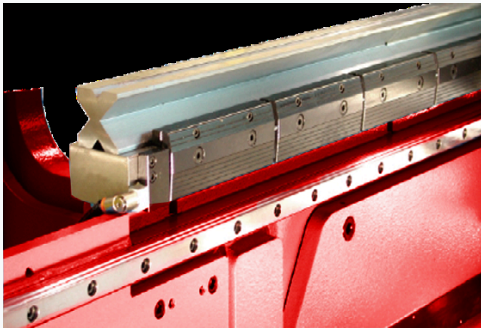
MANUAL BOTTOM CLAMPING

Standard lower-die clamping compatible with common tooling formats.



HYDRAULIC BOTTOM CLAMPING

Hydraulic lower clamp with local adjustment for fine angle control.



PNEUMATIC BOTTOM CLAMPING

Self-aligning center clamp for quick lower-die removal and installation.



SHEET FOLLOWERS

Floor-mounted or integrated synchronized supports reduce operator effort when bending large sheets.

HIGH PRECISION, STANDARDIZED SEGMENTS

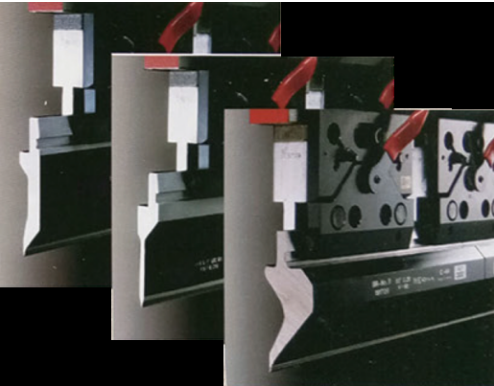
TOOLING PROFILES FOR CNC PRESS BRAKES

Standardized Tool Lengths

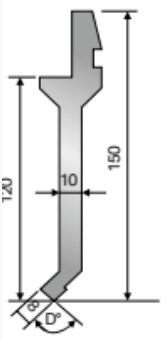
Quenched, precision-ground punches and dies support repeatable bending performance and longer service life. Standard segmented tooling simplifies assembly, handling and replacement across common working lengths.

835 mm Standard Segment	415 mm Half Segment
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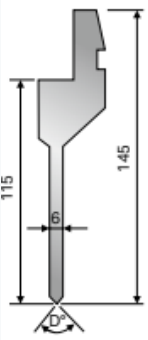
Typical combinations: 2,000 mm = 835 + 415 + 415 + segments; 3,200 mm = 835 × 3 + segmented section; 4,000 mm = 835 × 4 + segmented section.



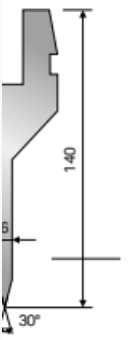
Tool selection is matched to material thickness, bend angle, inside radius, tonnage and clamping standard. Custom profiles are available through Machinist's Vault.



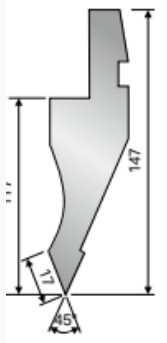
202 - 86 degrees
Original profile drawing from the tooling catalog.



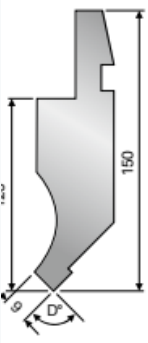
109 - 86 degrees
Original profile drawing from the tooling catalog.



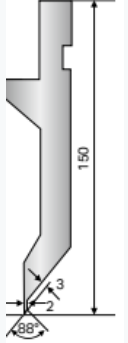
10870 - 90 degrees
Original profile drawing from the tooling catalog.



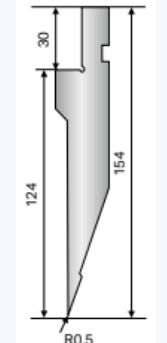
008 - 45 degrees
Original profile drawing from the tooling catalog.



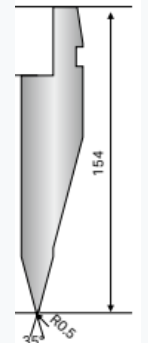
004 - 86 degrees
Original profile drawing from the tooling catalog.



0047 Gooseneck
Original relief profile for return flanges and formed-part clearance.



2108 - Sharp
Original profile drawing from the tooling catalog.



210 - Sharp
Original profile drawing from the tooling catalog.



452 - Flanging
Original profile drawing from the tooling catalog.

SETUP, STORAGE AND TONNAGE PLANNING

BENDING PRESSURE GUIDE



HIGH-CAPACITY TOOL CART

Organized mobile storage protects precision punches and dies while keeping common tooling close to the machine. Typical cart size: approximately 913 × 64 × 42 mm, fabricated from 3 mm cold plate.

F = Bending pressure (tons/m)

V = bottom-die opening · s = plate thickness · ri = inside radius. Values below are guidance for mild steel near 42 kg/mm² tensile strength.

RECOMMENDED V-OPENING & PRESSURE

Plate Thickness (mm)	V Opening (mm)	Approx. Inside Radius (mm)	Pressure (tons/m)	Typical Application
0.5	4	0.6	4	Light gauge
0.8	6	1.0	7	Light gauge
1.0	8	1.3	8	Light gauge
1.2	10	1.6	9	Light gauge
1.5	12	2.0	11	Light gauge
2.0	16	2.6	15	General fabrication
2.5	20	3.3	19	General fabrication
3.0	25	4.0	21	General fabrication
4.0	32	5.0	30	General fabrication
5.0	40	6.5	37	General fabrication
6.0	50	8.0	43	General fabrication
8.0	63	10	61	Heavy plate
10	80	13	75	Heavy plate
12	100	16	86	Heavy plate
15	125	20	107	Heavy plate
20	160	26	149	Heavy plate

Reference values are indicative only. Confirm actual tonnage against material grade, tensile strength, bend length, tooling radius and manufacturer limits before production.



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