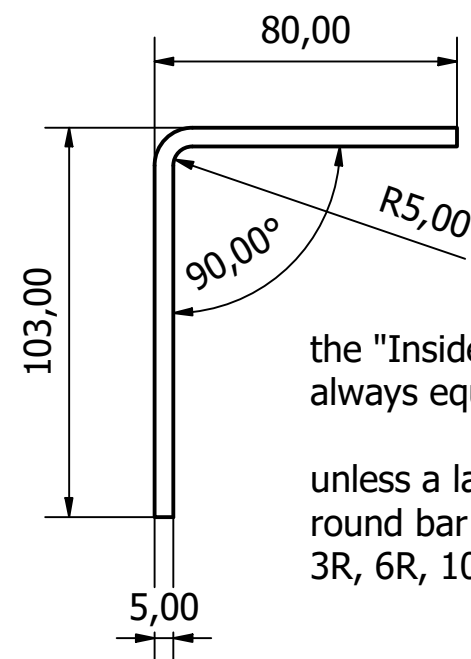


drawn with 0.39 Kfactor,
 this is an average of our kfactor
 as kfactor changes with the V and the Blade used with each thickness
 general rule for what V to be used is 8-10x the material thickness.

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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