

## ES3 Bend Radii & K-Factors

Material		Press Brake		Bend Properties	
Material	Thickness	Punch Radius	Die Width	Bend Radius	K Factor
Aluminium 5005	1.2mm	1mm	8mm	1mm	0.44
Aluminium 5052	1.6mm	1mm	10mm	1.1mm	0.41
Aluminium 5052	2mm	1mm	12mm	1.2mm	0.49
Aluminium 5052	2.5mm	1mm	16mm	1.9mm	0.43
Aluminium 5052	3mm	1mm	24mm	2.3mm	0.43
Aluminium 5052	4mm	4mm	30mm	4.1mm	0.42
Aluminium 5052	5mm	4mm	40mm	4.2mm	0.41
Aluminium 5052	6mm	4mm	40mm	4.2mm	0.38
Mild Steel Cold Rolled	1.2mm	1mm	8mm	1.2mm	0.34
Mild Steel Cold Rolled	1.6mm	1mm	10mm	1.4mm	0.36
Mild Steel Cold Rolled	2mm	1mm	12mm	1.8mm	0.39
Mild Steel Cold Rolled	2.5mm	1mm	16mm	2.5mm	0.38
Mild Steel Hot Rolled	3mm	1mm	24mm	3.2mm	0.36
Mild Steel Hot Rolled	4mm	4mm	30mm	4.5mm	0.35
Mild Steel Hot Rolled	5mm	4mm	40mm	5.4mm	0.37
Mild Steel Hot Rolled	6mm	4mm	40mm	5.9mm	0.4
Mild Steel Hot Rolled	8mm	8mm	60mm	8.8mm	0.33
Mild Steel Hot Rolled	10mm	10mm	80mm	11mm	0.38
Stainless Steel 304	1.2mm	1mm	8mm	1.8mm	0.41
Stainless Steel 304	1.6mm	1mm	10mm	2.5mm	0.43
Stainless Steel 304	2mm	1mm	12mm	3mm	0.43
Stainless Steel 304	2.5mm	1mm	16mm	3.5mm	0.35
Stainless Steel 304	3mm	1mm	24mm	4.6mm	0.42
Stainless Steel 304	4mm	4mm	30mm	4.8mm	0.4
Stainless Steel 304	5mm	4mm	40mm	6.7mm	0.42
Stainless Steel 304	6mm	4mm	40mm	8mm	0.36