

WingBend dies

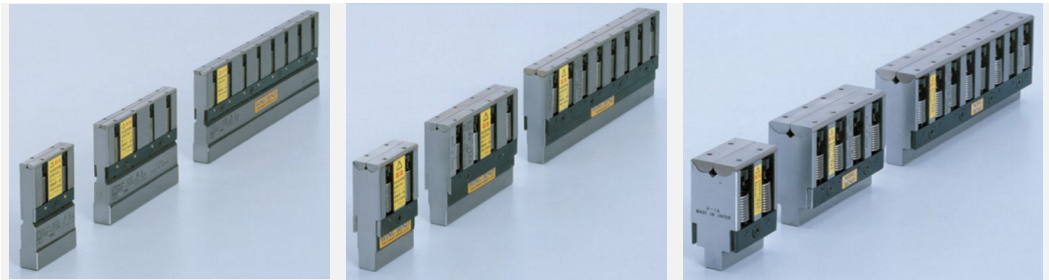
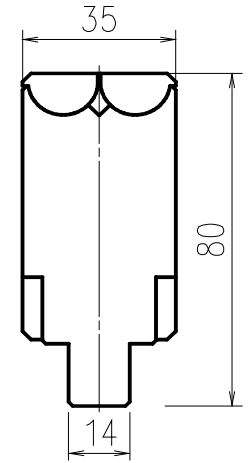
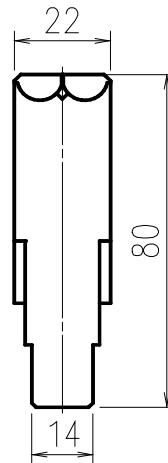
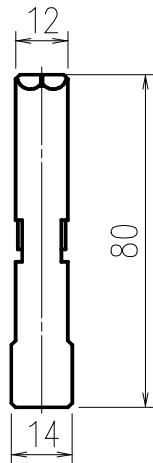
WB120-A

WB230-A

WB350-A

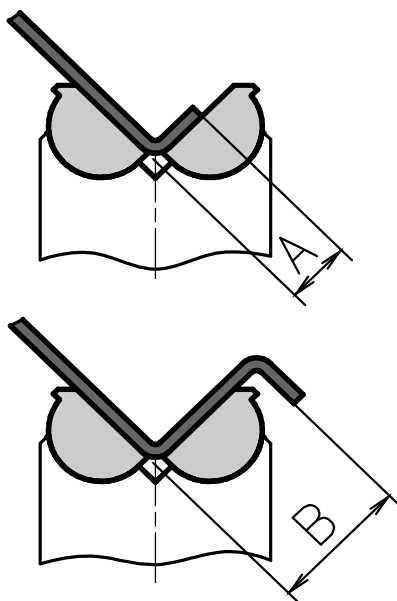
WingBend bending features

- very small flanges
- wide range of materials using the same die
- small bend radii
- bends closer to holes
- forming oblique flanges
- less scratches
- scratch-free bending for film protected sheet metal



Equivalent die opening		up to V6	up to V10	up to V15
Mat. thickness	Mild steel	0,5 ~ 1,2	0,5 ~ 2,3	1,0 ~ 3,2
	Stainless steel	0,5 ~ 1,0	0,5 ~ 2,0	1,0 ~ 3,0
	Aluminium	0,5 ~ 1,0	0,5 ~ 2,0	1,0 ~ 3,0
Min. angle		80°	80°	80°
Tonnage		1000 kN/m	1000 kN/m	1000 kN/m
Code and weight per tool length	50mm	70120A (0,4Kg)	70230A (0,6Kg)	70350A (0,9Kg)
	100mm	70120B (0,7Kg)	70230B (1,2Kg)	70350B (1,5Kg)
	200mm	70120C (1,4Kg)	70230C (2,3Kg)	70350C (3Kg)

Tonnage and process data:



How to read table data:

Tonnage (kN/m)			
A	Min. flange length (mm)		B
			Min. offset value (mm)

t (mm)	WB120-A		WB230-A		WB350-A	
0,5	50		50		40	
	3,6	7,3	5,7	12,2	8,1	19,3
0,8	100		70		50	
	3,8	7,4	5,9	12,4	8,4	19,5
1	150		80		60	
	4,0	7,4	6,1	12,6	8,6	19,7
1,2	240		110		70	
	4,1	7,5	6,2	12,7	8,8	19,9
1,6			200		140	
			6,4	12,9	9,0	20,2
2			300		200	
			6,6	13,0	9,4	20,4
2,3			400		260	
			6,8	13,2	9,6	20,6
2,6					340	
					9,8	20,8
3,2					510	
					10,2	21,0

Note:

- this chart is showing bending data for mild steel
- bending operation in the dark range is not recommended
- Min. flange length and min. offset value are reference values