

FORMING CAPABILITIES:
Dishing

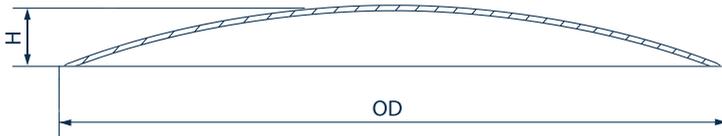


FABRINOX™

Your Complete Manufacturing Solution

DISHING

Dishing of a circular plate is done by means of a top and bottom toolset on a vertical hydraulic press. Fabrinox has 4 sets from small to large. A smaller radius tool will form a deeper dish (Inside Height) than a larger tool, but will require more labour to dish. A well finished dish has a smooth surface, while a too shallow dish could have a dimpled surface. To obtain a smooth finish, the tooling needs to be bottomed on the last forming run.



Machine & Tool Limits	
	Cut Size
Tool	Ø140 mm - Ø300 mm (manual)
	Minimum - Ø300 (automatic)
Machine	Maximum - Ø2400 (automatic)

Dishing Size & Depth Guide per Material Thickness (MS, SS, 3CR12)									
ØOD (mm)	Inside Height	1.6	2	2.5	3	4	4,5	5	6
140-200	30-50	✓	✓	✓					
200-500	30-50		✓	✓	✓				
500-800	50-80		✓	✓	✓	✓	✓		
800-1200	80-120			✓	✓	✓	✓	✓	✓

The heights provided are a range that is easily obtainable. Shallower or deeper dishes can be formed, but will increase price and decrease finish quality.

Important Notice:

Please note that this information is for guidance only and final information must be confirmed by a Fabrinox Sales Technician to include all possible variances.