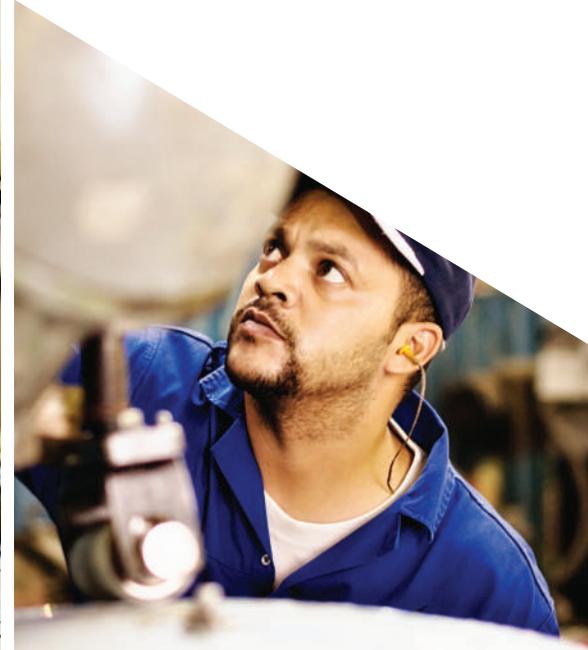
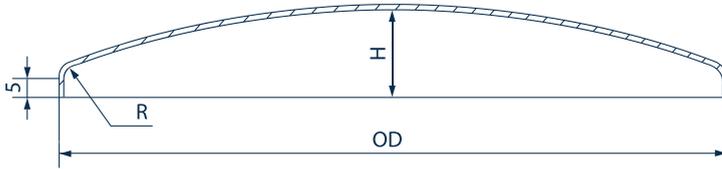


FORMING CAPABILITIES:
Dishing &
Knuckling



Your Complete Manufacturing Solution

DISHING & KNUCKLING



Mild Steel							
Plate Thickness	2	2.5	3	4	4.5	5	6
R6	✓	✓	x	x	x	x	x
R20	x	x	✓	✓	✓	x	x
R25	x	x	✓	✓	✓	✓	✓

Stainless Steel & 3CR12						
Plate Thickness	2	2.5	3	4	4.5	6
R6	✓	✓	x	x	x	x
R20	x	x	✓	✓	✓	x
R25	x	x	✓	✓	✓	✓

Machine & Tool Limits			
Cut Size		Knuckling Size Limit	
Tool	Minimum - Ø300 (automatic)	R6	R20 & R25
Machine	Maximum - Ø2400 (automatic)	Ø250 – Ø1000	Ø1000 – Ø4000

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			✓	✓	✓	✓	✓	✓
1200-1500	120-160					✓	✓	✓	✓
1500-2400	160-250					✓	✓	✓	✓

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.