

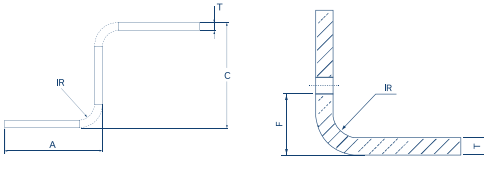
**BENDING CAPABILITIES:**  
Sheet  
Bending



**FABRINOX™**

Your Complete Manufacturing Solution

## SHEET BENDING: 3CR12



Based on 90° Bends

Rows in blue are the standard, while rows in white are alternative options.

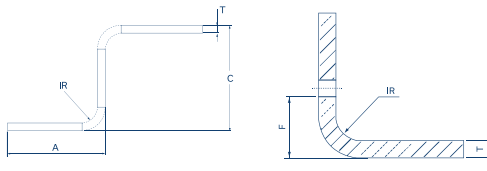
3CR12					
Thickness (T)	Inside Radius (IR)	K-Factor	Minimum Bend A-After Bending	Minimum S-Bend C-After Bending	Minimum Hole Distance After Bending (F) to avoid deformation
1	1.1	0.43	5.4	12	4.9
1	1.3	0.46	7	12	4.9
1	1.8	0.41	10.1	15	5.1
1.2	1	0.41	5.6	13	5
1.2	1	0.35	7.1	13	5.1
1.2	1.4	0.37	10.2	15	5.2
1.5	1.3	0.37	7.4	13	5.3
1.5	1.5	0.37	10.4	16	5.4
1.5	2.1	0.40	13.5	19	7.5
2	1.7	0.39	10.8	17	5.8
2	2.1	0.40	13.9	20	7.8
2	2.7	0.37	17	21	9
2	2.9	0.40	20	23	10
2.5	1.9	0.41	11.1	18	6.1
2.5	2.4	0.41	14.3	21	8.2
2.5	2.6	0.37	17.4	21	9.3
2.5	3.3	0.42	20.4	24	10.4
3	2.4	0.41	14.6	22	8.6
3	1.8	0.39	17.5	22	9.5
3	2.9	0.42	20.7	24	10.6
3	3.8	0.41	25.4	36	13.9
4.5	4.1	0.36	22.1	29	12.1
4.5	4.3	0.42	26.5	39	14.9
4.5	4.6	0.41	34.1	39	17
4.5	5	0.40	41.7	49	20.1

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## BENDING CAPABILITIES

3CR12					
Thickness (T)	Inside Radius (IR)	K-Factor	Minimum Bend A-After Bending	Minimum S-Bend C-After Bending	Minimum Hole Distance After Bending (F) to avoid deformation
6	5.4	0.41	27.8	43	16.3
6	6.4	0.40	35.5	45	18.5
6	6.9	0.42	43	55	21.5
6	9.7	0.43	58.6	65	28.1
8	6.9	0.38	44.6	59	23.1
8	9.4	0.38	60.2	68	29.6
8	13.1	0.35	83.7	93	38.6
10	11.6	0.43	61.2	71	31.1
10	15.3	0.37	85.4	97	40.4
12	9.8	0.41	62.8	73	32.2
12	12.7	0.41	85.9	94	40.9

### SHEET BENDING: MILD STEEL



Based on 90° Bends

Rows in blue are the standard, while rows in white are alternative options.

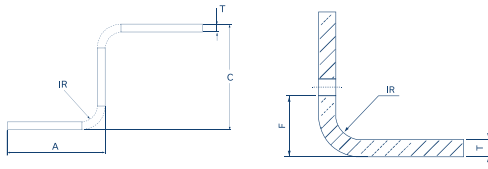
MILD STEEL					
Thickness (T)	Inside Radius (IR)	K-Factor	Minimum Bend A-After Bending	Minimum S-Bend C-After Bending	Minimum Hole Distance After Bending (F) to avoid deformation
0.5	1	0.44	5.1	12	4.5
0.5	1.2	0.30	6.7	12	4.6
0.8	1.1	0.38	5.3	12	4.8
0.8	1.2	0.21	7	13	4.9
0.8	1.7	0.37	10	15	4.9
1	1.1	0.43	5.4	13	4.9
1	1.2	0.25	7.1	13	5.1
1	1.9	0.38	10.2	16	5.1
1.2	0.9	0.30	5.7	13	5.1
1.2	1.3	0.39	7.2	13	5.1
1.2	1.5	0.32	10.3	16	5.2

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## BENDING CAPABILITIES

MILD STEEL					
Thickness (T)	Inside Radius (IR)	K-Factor	Minimum Bend A-After Bending	Minimum S-Bend C-After Bending	Minimum Hole Distance After Bending (F) to avoid deformation
1.6	1.3	0.39	7.4	14	5.4
1.6	1.8	0.36	10.6	17	5.3
1.6	2.5	0.42	13.7	20	7.6
2	1.9	0.35	10.9	18	5.9
2	2.5	0.41	13.9	20	7.9
2	2.8	0.39	17	21	9
2	3.4	0.32	20.3	24	10.2
2.5	2.1	0.40	11.2	19	6.2
2.5	2.4	0.37	14.3	21	8.3
2.5	3	0.37	17.5	22	9.4
2.5	3.5	0.36	20.6	24	10.5
3	2.3	0.38	14.6	22	8.6
3	3.2	0.39	17.8	23	9.8
3	3.4	0.38	20.9	25	10.8
3	4.7	0.37	25.7	37	14.1
4	4.8	0.41	21.8	29	11.8
4	6.3	0.42	26.6	40	15
4	6.5	0.40	34.2	40	17.1
4	8.1	0.42	42	53	20.4
4.5	4.5	0.41	22	30	12
4.5	4.2	0.27	27	40	15.5
4.5	6.9	0.40	34.6	42	17.6
4.5	8.4	0.38	42.5	54	21
5	6.2	0.43	27.2	42	15.6
5	6.4	0.39	34.9	43	17.8
5	7.4	0.39	42.6	54	21.1
6	5.4	0.40	27.8	43	16.3
6	6.4	0.41	35.5	44	18.4
6	7.5	0.39	43.3	56	21.8
6	9.7	0.39	58.8	66	28.2
8	8.2	0.41	44.7	60	23.2
8	9.9	0.39	60.2	68	29.7
8	12.9	0.40	83.3	92	38.3
10	9.2	0.39	46.4	65	24.9
10	11.4	0.39	61.9	73	31.4
10	14.3	0.39	85	95	40
12	9.8	0.41	62.8	73	32.2
12	11.8	0.41	85.7	95	40.7

## SHEET BENDING: STAINLESS STEEL



Based on 90° Bends

Rows in blue are the standard, while rows in white are alternative options.

STAINLESS STEEL					
Thickness (T)	Inside Radius (IR)	K-Factor	Minimum Bend A-After Bending	Minimum S-Bend C-After Bending	Minimum Hole Distance After Bending (F) to avoid deformation
0.5	1.2	0.24	5.2	12	4.7
0.5	1.4	0.4	6.7	12	4.7
0.7	1.2	0.53	5.2	12	4.7
0.7	1.4	0.46	6.8	12	4.8
0.9	1.2	0.36	5.4	12	4.9
0.9	1.6	0.37	7	13	5
0.9	2.2	0.33	10.2	16	5.2
1.2	1.2	0.34	5.7	13	5.2
1.2	1.5	0.35	7.2	13	5.2
1.2	2.3	0.29	10.5	16	5.4
1.5	1.6	0.39	7.4	14	5.4
1.5	2.4	0.35	10.6	17	5.6
1.5	3.2	0.4	13.8	20	7.8
2	2.3	0.33	11	18	6
2	3.2	0.34	14.2	21	8.2
2	4.2	0.39	17.3	22	9.3
2	4.7	0.37	20.5	26	10.4
2.5	3.3	0.37	14.5	22	8.5
2.5	3.9	0.37	17.6	23	9.6
2.5	4.9	0.35	20.9	26	10.9
3	3.2	0.38	14.8	23	8.8
3	4	0.38	18	24	10
3	4.8	0.38	21.2	27	11.1
3	6.7	0.35	26.1	40	14.6
4	6.7	0.36	26.9	41	15.3
4	8.2	0.38	34.6	43	17.6
4	9.4	0.35	42.4	55	20.9

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## BENDING CAPABILITIES

STAINLESS STEEL					
Thickness (T)	Inside Radius (IR)	K-Factor	Minimum Bend A-After Bending	Minimum S-Bend C-After Bending	Minimum Hole Distance After Bending (F) to avoid deformation
4.5	6.8	0.37	27.2	42	15.7
4.5	8.2	0.36	35.1	44	18
4.5	9.6	0.37	42.8	55	21.3
6	7.7	0.37	36	46	18.9
6	9.8	0.37	43.9	59	22.4
6	14.1	0.36	59.8	71	29.3
8	9.7	0.36	45.4	63	23.8
8	14.6	0.38	61.3	75	30.8
8	18.9	0.39	84.7	100	39.6
10	14.5	0.4	62.5	76	32
10	19.1	0.4	86	100	41
12	16.5	0.38	87	102	42