

# ES3 Folding Bend Radii and K-Factors

All measurements are in millimetres and bend radii are internals.



Material		Preferred Tooling		Resulting Bend	
Type	Thickness	Punch Radius	Die Width	Bend Radius	K-Factor
Aluminium 5052	1.2	1	8	1	0.44
Aluminium 5052	1.6	1	10	1.1	0.41
Aluminium 5052	2	1	12	1.2	0.33
Aluminium 5052	2.5	1	16	1.9	0.43
Aluminium 5052	3	1	24	2.3	0.43
Aluminium 5052	4	4	30	4.1	0.42
Aluminium 5052	5	4	40	4.2	0.41
Aluminium 5052	6	4	40	4.2	0.38
Mild Steel	1	1	8	1.1	0.29
Mild Steel	1.2	1	8	1.2	0.34
Mild Steel	1.6	1	10	1.4	0.36
Mild Steel	2	1	12	1.8	0.39
Mild Steel	2.5	1	16	2.5	0.38
Mild Steel	3	1	24	3.2	0.36
Mild Steel	4	4	30	4.5	0.35
Mild Steel	5	4	40	5	0.39
Mild Steel	6	4	50	6.5	0.38
Mild Steel	8	8	60	8.8	0.40
Mild Steel	10	10	80	11	0.38
Mild Steel	12	10	120	16.8	0.41
Stainless Steel	0.9	1	8	1.6	0.42
Stainless Steel	1.2	1	8	1.8	0.41
Stainless Steel	1.6	1	10	2.5	0.43
Stainless Steel	2	1	12	3	0.43
Stainless Steel	2.5	1	16	3.5	0.35
Stainless Steel	3	1	24	4.6	0.42
Stainless Steel	4	4	30	5.8	0.40
Stainless Steel	5	4	40	6.7	0.42
Stainless Steel	6	4	40	8	0.36
Stainless Steel	8	8	80	16	0.43
Stainless Steel	10	10	80	16	0.42