

BEND SHEET

Press brake examples 2026-10-17

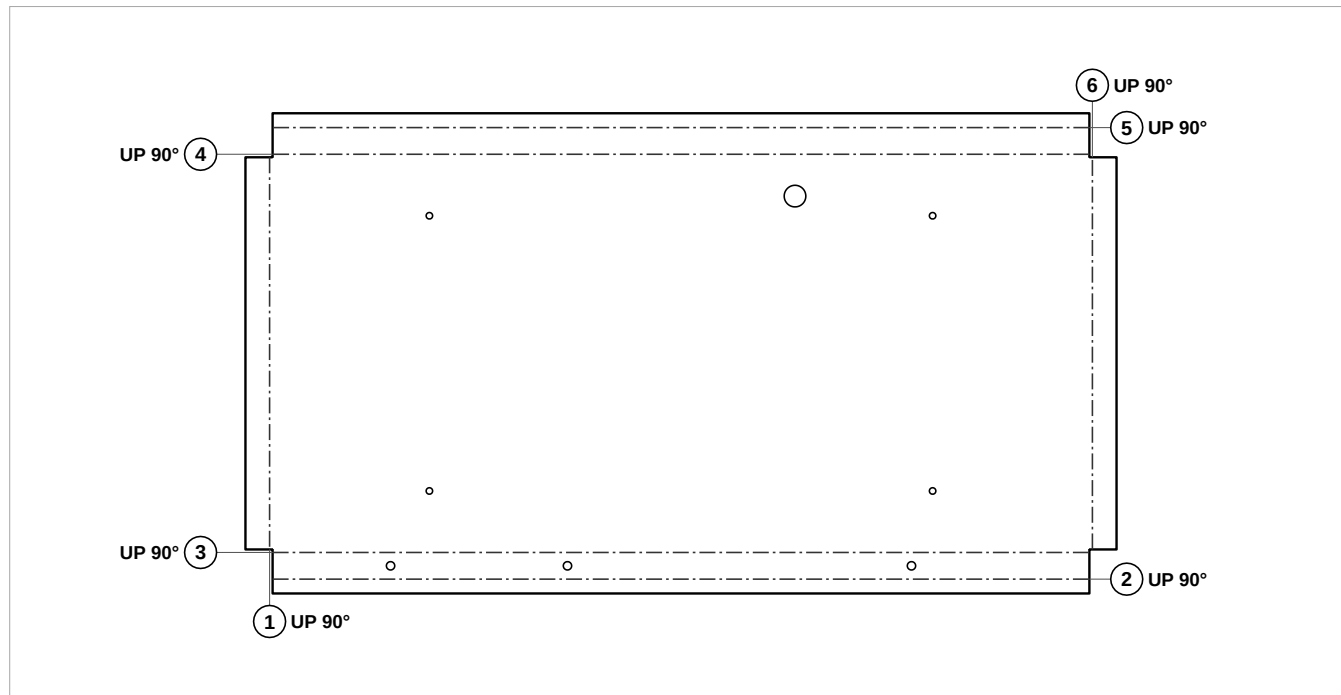
1 part 6 bends

Page 1 / 2

Cabinet door

MATERIAL S235JR structural steel	THICKNESS 1.5 mm	DIE Per step (see Tools by step)	PUNCH Per step (see Tools by step)
MACHINE Shop brake 40 t x 1250	UNITS mm	FLAT SIZE 886.3 x 488.5 mm	BENDS 6

FLAT PATTERN



Seen from the top face: UP bends fold toward you.

Overall 886.3 x 488.5 mm

BEND TABLE (BEND ORDER; FLANGES: GAUGE SIDE / FRONT)

STEP	BEND	DIR	ANGLE	Ri (mm)	LENGTH (mm)	FLANGES (mm)	X (mm)	GAUGE	HANDLING	FORCE (kN)
1	B1	UP	90°	2.7	399.0	26.2 / 840.4	24.57	edge	Top face up	34.7
2	B6	UP	90°	2.7	399.0	26.2 / 840.4	24.57	edge	Turn end for end	34.7
3	B2	UP	90°	2.7	831.0	16.2 / 30.4	14.57	edge	Rotate 90° CW	72.2
4	B5	UP	90°	2.7	831.0	16.2 / 30.4	14.57	edge	Turn end for end	72.2
5	B3	UP	90°	2.7	831.0	30.4 / 408.4	28.76	flange B2	Turn end for end	72.2
6	B4	UP	90°	2.7	831.0	30.4 / 408.4	28.76	flange B5	Turn end for end	72.2

TOOLS BY STEP

STEP	PUNCH	DIE	SECTION CHECK
1	UKB 11.151 / 835 mm; 835 mm	UKB 20.516 / 835 mm; 835 mm	Clear (sampled)
2	UKB 11.151 / 835 mm; 835 mm	UKB 20.516 / 835 mm; 835 mm	Clear (sampled)
3	UKB 11.151 / 835 mm; 835 mm	UKB 20.516 / 835 mm; 835 mm	Clear (sampled)
4	UKB 11.151 / 835 mm; 835 mm	UKB 20.516 / 835 mm; 835 mm	Clear (sampled)
5	Amada 804 88° R0.6 H120; 830 mm (1 mm short): 100L + 415 + 50 + 15 + 150 + 100R	Amada 1V V16 88° H60; 835 mm: 835	Clear (sampled)
6	Amada 804 88° R0.6 H120; 830 mm (1 mm short): 100L + 415 + 50 + 15 + 150 + 100R	Amada 1V V16 88° H60; 835 mm: 835	Clear (sampled)

CHECKS

- Tool search:** No interference found in the sampled sections, the axial wall checks or the 3D check.
- 3D check:** No contact with the punch, die or beam in 145 sampled poses of 6 steps (12.5 s).
- No problems found in the available checks.

Cabinet door (continued)

SIDE VIEWS

The part on the die before each bend, back gauge on the right; red: the moment of a collision. Each view to its own scale.

