

BEND SHEET

Press brake examples 2026-10-17

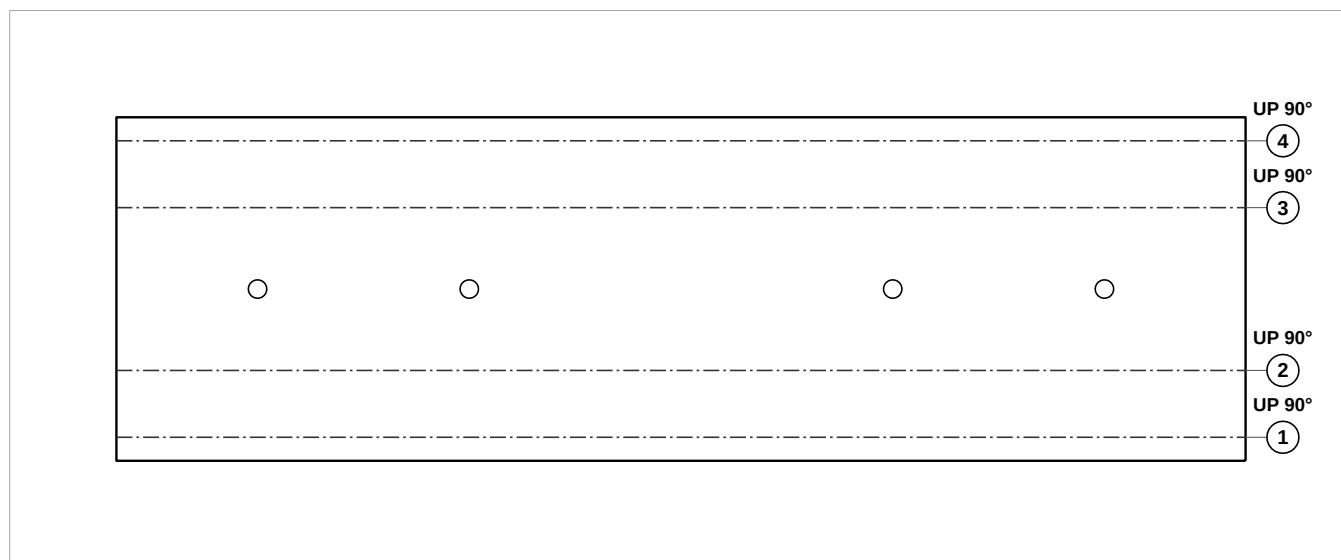
1 part 4 bends

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Lipped C channel

MATERIAL S235JR structural steel	THICKNESS 2.0 mm	DIE Amada 1V V16 88° H60 V 16.0 mm, 88°	PUNCH Amada 604 88° R0.6 H67 R 0.6 mm, H 67.0 mm
MACHINE Shop brake 40 t x 1250	UNITS mm	FLAT SIZE 800.0 x 243.4 mm	BENDS 4

FLAT PATTERN



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

Overall 800.0 x 243.4 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	800.0	18.7 / 51.4	16.67	edge	Top face up	123.5
2	B4	UP	90°	2.7	800.0	18.7 / 51.4	16.67	edge	Turn end for end	123.5
3	B2	UP	90°	2.7	800.0	51.4 / 119.4	49.36	flange B1	Turn end for end	123.5
4	B3	UP	90°	2.7	800.0	119.4 / 51.4	117.36	flange B2	Same placement	123.5

TOOLS BY STEP

STEP	PUNCH	DIE	SECTION CHECK
1	Amada 604 88° R0.6 H67; 835 mm: 835	Amada 1V V16 88° H60; 835 mm: 835	Clear (sampled)
2	Amada 604 88° R0.6 H67; 835 mm: 835	Amada 1V V16 88° H60; 835 mm: 835	Clear (sampled)
3	Amada 604 88° R0.6 H67; 835 mm: 835	Amada 1V V16 88° H60; 835 mm: 835	Clear (sampled)
4	Amada 604 88° R0.6 H67; 835 mm: 835	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 96 sampled poses of 4 steps (3.2 s).
- No problems found in the available checks.

Lipped C channel (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.

