

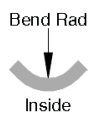
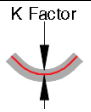

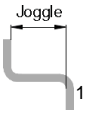
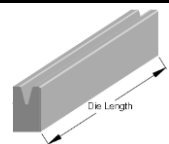


# Pressing Tool Allowances\*

Thickness (mm)	1	2	3	4	5	6	8	10	12	16							
	16	16	22	22	35	35	50	35	50	50	55	70	70	70	100	100	150
	85°	85°	85°	85°	85°	85°	85°	85°	85°	85°	85°	85°	85°	85°	85°	85°	85°
	2.50	2.48	3.48	4.48	4.98	4.45	6.98		6.99	7.10	6.59	8.60	9.03	9.05	12.60	12.60	19.33
	2.50	2.50	2.50	3.50	6.00	5.50	8.50		8.50	7.50	8.50	11.5	10.5		16.0	15.0	
		1.53	1.51	0.98		2.99		4.43	4.42	7.1	6.59	8.6	9.03	9.05	12.6	12.6	19.33
	0.32	0.39	0.39	0.34	0.37	0.40	0.31		0.37	0.41	0.37	0.36	0.37	0.41	0.36	0.38	0.36
	-0.21	0.30	0.14	0.35	0.25	0.33	0.27	0.28	0.33	0.28	0.33	0.33	0.35		0.33	0.36	
		0.34	0.32	0.31		0.41		0.46	0.42	0.41	0.37	0.36	0.37	0.41	0.36	0.38	0.36
	10	10	13	13	21	21	30	21	30	30	33	42	42	42	59	59	88
	31	31	31	31	31	31	31	31	31	31	55	85	85	85	95	95	95
	3100	3100	3100	3100	3100	3100	3100	3100	3100	3100	4100	4100	4100	4100	4100	4100	4100

Stainless Steel 304/316

Mild Steel 250

Aluminium 5005

Aluminium 5052

<sup>1</sup> When using minimum joggle, consider tool height. If flange is longer than tool height, include a pre-bend.

\*Above allowances are based on 85 knife tooling and transverse grain.

\*Any hole within folding area disturbs overall dimensions and may distort the part.