

Sheet Metal Fabrication

The complete design guide

Press brake forming

Press brake forming is the process where metal is bent or folded when a die and a punch are used to bend the sheet of metal.

This is most often used to form parts from ferrous alloy steel great for both prototype and production runs.

The maximum sheet thickness is usually less than 8 times the



Bending



Bending is a good method which gives desired shape for the design require.

Bending is performed available in 2 forms.



Forming near holes

When a bend is made too close to a hole the hole may become deformed. To save the cost of punching or drilling in a secondary operation, the following formulae can be used to calculate the minimum distance required.

As a rule of thumb, the distance from the outside of the material to the bottom of the cutout should be equal to the minimum flange length as prescribed by the air bend force chart.

For a hole $\leq 1"$ diameter the minimum distance $(D) = 2T + R$

For a slot or hole $> 1"$ diameter the minimum distance $(D) = 2.5T + R$

When using a punch press, or laser cutting, holes should never be less than that of the material thickness.



The minimum distance to adjacent features for bend radius

Feature Type	Minimum distance guideline
Minimum hole and slot	≥ 2 times the material thickness + bend radius
Minimum slot and hole	≥ 2 times the material thickness + bend radius
Minimum hole to slot end edge	≥ 2 times the material thickness
Minimum adjacent slot and hole	≥ 2 times the material thickness
Minimum to adjacent hole and slot edge	≥ 2 times the material thickness
Minimum to adjacent hole and hole	≥ 2 times the material thickness + bend radius
Minimum to adjacent hole and slot	≥ 2 times the material thickness + bend radius
Minimum to adjacent hole	≥ 2 times the material thickness

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