

Trumpf TruBend 5320 (360 T)

Bend table minimum guidelines chart is for steel (A36) up to a 90° single bend ONLY. See notes below for other bends or alternate materials. Standard radius is equal to material thickness.

MATERIAL THICKNESS	8X THK	STANDARD DIE WIDTH	MINIMUM ENTITY TO BEND	MINIMUM FLANGE LENGTH	LONGEST BEND	MAX DEGREE	K FACTOR MS / SS
(.048)18 ga	0.38	0.384" (10MM)	0.281	0.317	159"	35 OR HEM	0.156 / 0.065
(.060)16 ga	0.48	0.384" (10MM)	0.281	0.317	159"	35 OR HEM	0.400 / 0.283
(.075)14 ga	0.60	0.472" (12MM)	0.332	0.361	159"	35 OR HEM	0.300 / 0.225
(.105)12 ga	0.84	5/8" (16MM)	0.406	0.440	159"	35 OR HEM	0.380 / 0.350
(.120)11 ga	0.96	5/8" (16MM)	0.406	0.440	159"	35 OR HEM*	0.315 / 0.380
(.135)10 ga	1.08	1" (30MM)	0.85	0.875	172	35	0.350 / 0.355 (16mm)
.188 Plate	1.50	1.5" (40MM)	1.17	1.175	172	35	0.415 / 0.328
.250 Plate	2.00	2" (50MM)	1.25	1.375	172	35	0.350 / 0.342
.313 Plate	2.50	2" (50MM)	1.25	1.375	159	35	0.395 / 0.328
.375 Plate	3.00	3" (70MM)	1.69	1.875	159	55	0.362 / 0.3145
.500 Plate	4.00	4" (100MM)	2.25	2.500	90	55	0.300 / 0.300
.625 Plate	5.00	6" (150MM)	3.25	3.750	80	85	0.285 / 0.296
.750 Plate	6.00	6" (150MM)	3.25	3.750	80	85	0.265 / 0.265
1.00 Plate	8.00	6" (150MM)	3.5	4.00	80	85	0.235 / 0.235

5052 AL K factors	Thickness	K factor
	0.0478	0.135
	0.063	0.500
	0.080	0.410
	0.100	0.485
	0.125	0.500
	0.188	0.415
	0.250	0.345
	0.313	0.328
	0.375	0.3135

86° (90°) dies available		Radius punches available	
Size	Length	Size	Length
0.3149" (8mm)	42	0.04 R (1mm)	159
0.472" (12mm)	42	0.16 R (4mm)	159
5/8" (16mm)	42	0.375 R	78.75
1.5" (40mm)	159	0.500 R	98.50
		0.750 R	78.75
		1.000 R	98.50
		1.500 R	78.75

NOTES:

- 1) Can Hem up to 10ga Sheet at 159.5" long*
- 2) Die bed is 174" and is 145" between the uprights
Max flange at upright 16"
Max interior box ID = 5" or 10" with extensions



GK MACHINE, INC. DONALD, OR
503-678-5525 www.gkmachine.com

