

Trumpf TruBend 7036 (40 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	40	35	0.156 / 0.065
.060 16 ga	0.48	0.384" (10MM)	0.281	0.317	40	35	0.400 / 0.288
.075 14 ga	0.60	0.472" (12MM)	0.332	0.361	40	35	0.300 / 0.225
.105 12 ga	0.84	5/8" (16MM)	0.406	0.440	40	35	0.380 / 0.350
.120 11 ga	0.96	5/8" (16MM)	0.406	0.440	31	35	0.315 / 0.380
.135 10 ga	1.08	1" (30MM)	0.85	0.875	40	35	0.350 / 0.355 (1.8mm)
.188 Plate	1.50	1.5" (40MM)	1.17	1.173	24	35	0.415 / 0.328
.250 Plate	2.00	2" (50MM)	1.25	1.375	30.5	35	0.350 / 0.342
.313 Plate	2.50	2" (50MM)	1.25	1.375	17.5	35	0.335 / 0.328
.375 Plate	3.00	3" (70MM)	1.69	1.875	16.5	55	0.362 / 0.3145

5052 AL K factors	Thickness	K factor	86° (90°) dies available		Radius punches available	
			Size	Length	Size	Length
	0.0478	0.135				
	0.063	0.500	0.3149" (8mm)	40	0.04 R (1mm)	40
	0.080	0.410	0.472" (12mm)	40	0.16 R (4mm)	40
	0.100	0.485	5/8" (16mm)	40	0.375 R	40
	0.125	0.500	1.5" (40mm)	40	0.500 R	40
	0.188	0.415			0.750 R	40
	0.250	0.345			1.000 R	40
	0.313	0.328				
0.375	0.3135					

NOTES:

- 1) Die bed is 40" and 36.7" between columns
Max flange at upright 16"
Max interior box ID = 2.625"



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