


JEELIX

PRODUCT BROCHURE

CONTACT US

 +86-555-6767188

 info@jeelix.com

 www.jeelix.com

www.jeelix.com

ABOUT US

100

Customers spread
across the globe

1000000+

Annual production capacity
of over 1,000,000 toolings

99%

Customer satisfaction

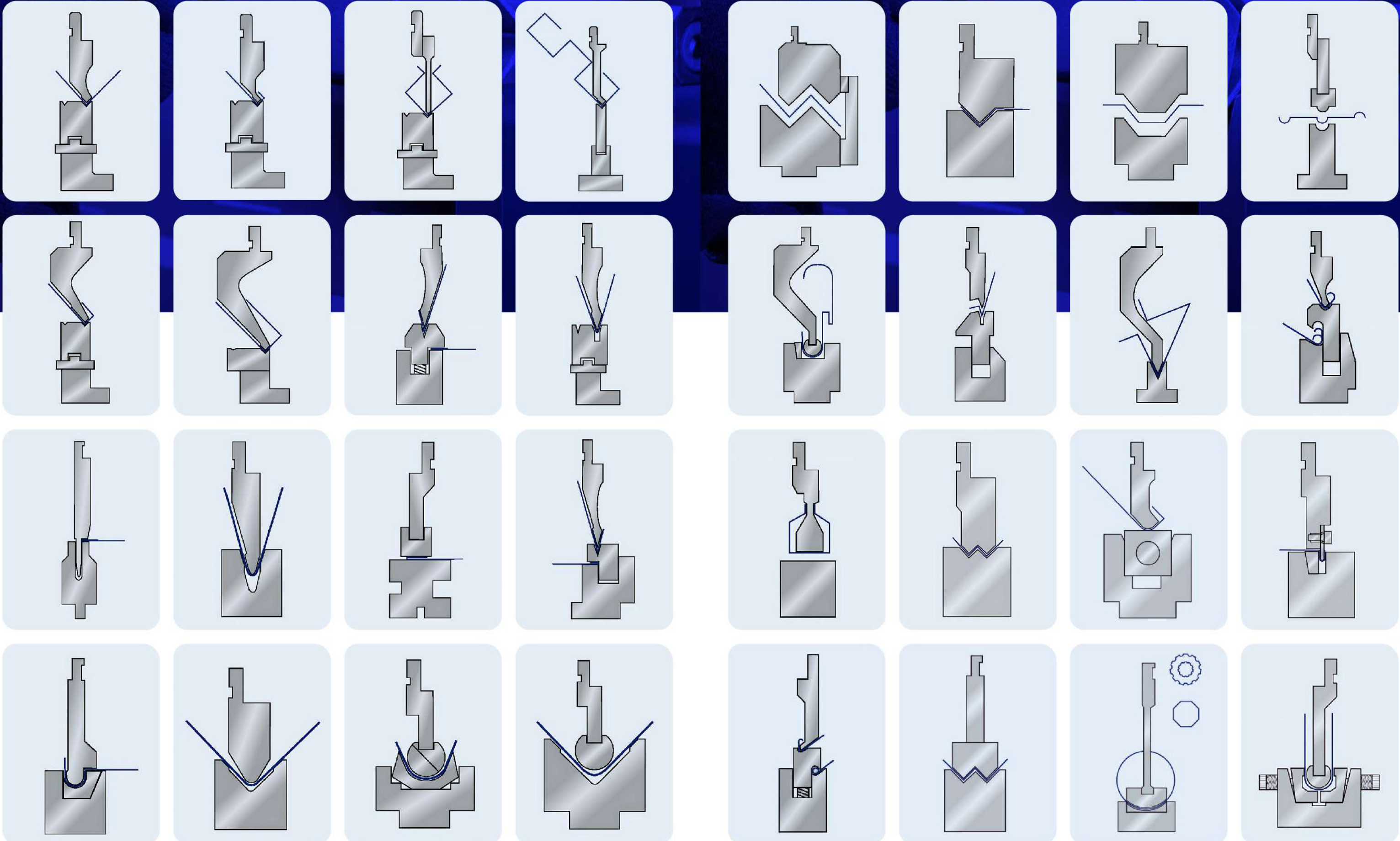
Our product line covers all major categories in the press brake tooling field, including punch and die sets for Amada, Euro, Trumpf, and Wila series, as well as tooling for various special applications. Whether it's standardized products or customized solutions, JEELIX can meet all customer needs.

JEELIX

JEELIX EQUIPMENT



PRESS BRAKE TOOLING



AMADA PRESS BRAKE PUNCH

LS18
26°

A	R	H	T/M
35°	0.8	67.06	50

LS11
35°
45°

A	R	H	T/M
35°	0.8	67.06	50
45°	1	65.05	70

LS10.21
30°

A	R	H	T/M
30°	0.6	140.06	100
30°	3	140.01	100

LS13
35°
60°

A	R	H	T/M
35°	5	65.01	100
60°	6	64.98	100

LS20
60°

A	R	H	T/M
60°	0.8	75	70
60°	2	73.8	70

LS12
35°

A	R	H	T/M
35°	0.5	90.06	70
35°	0.8	90.05	70
35°	1.5	90.01	70

LS10.53
45°

A	R	H	T/M
45°	6	100	100

LS10.93
60°

A	R	H	T/M
60°	8	200	150

LS10.52
30°

A	R	H	T/M
30°	0.5	135	50
30°	0.5	135	50

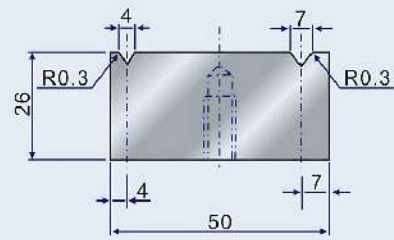
LS10.86
30°

A	R	H	T/M
30°	0.6	140.06	40

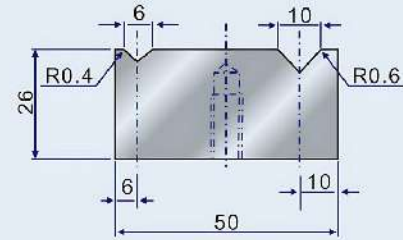
L=835mm

AMADA PRESS BRAKE DIE

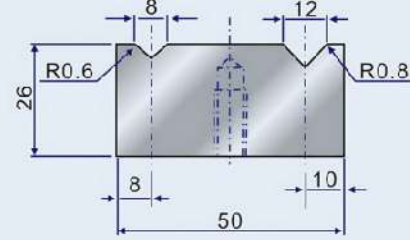
YS101 88° 90°



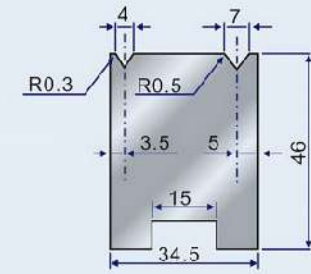
YS123 88° 90°



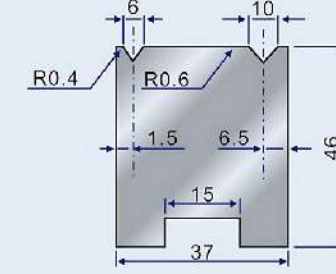
YS124 88° 90°



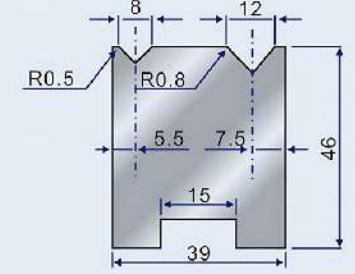
YS501 88° 90°



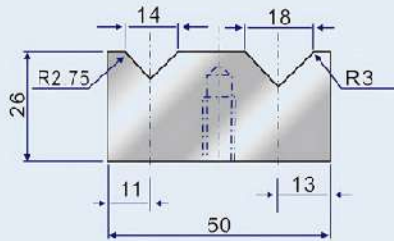
YS502 88° 90°



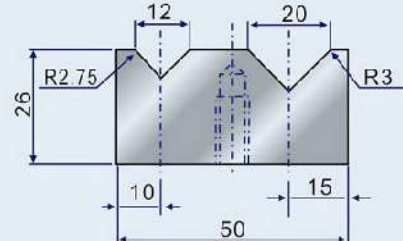
YS503 88° 90°



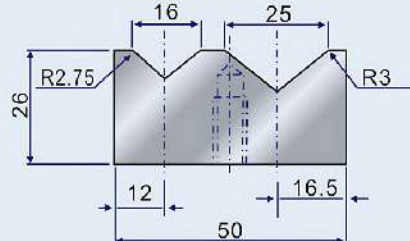
YS125 88° 90°



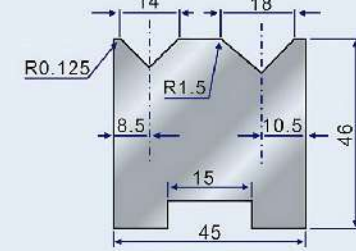
YS126 88° 90°



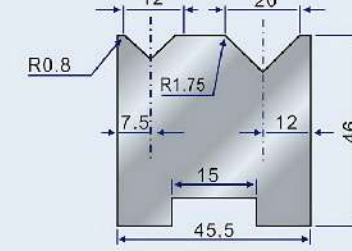
YS127 88° 90°



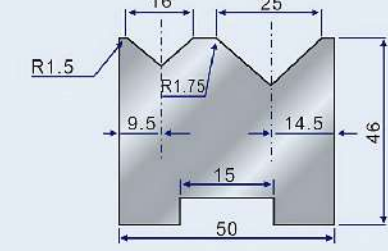
YS504 88° 90°



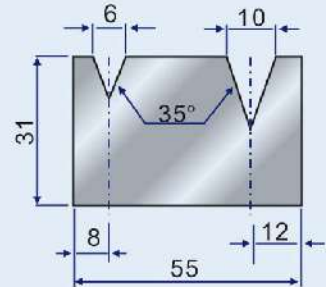
YS505 88° 90°



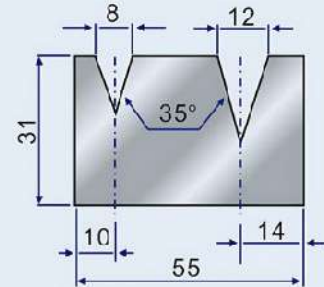
YS506 88° 90°



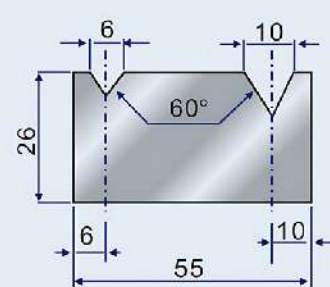
YS20.12 35°



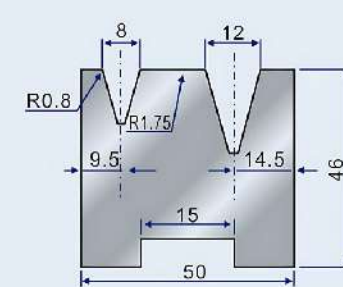
YS20.13 35°



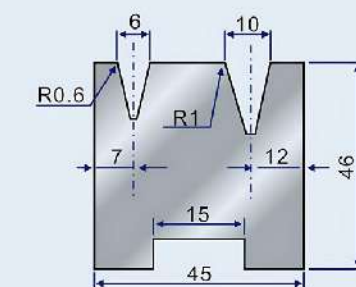
YS20.12 60°



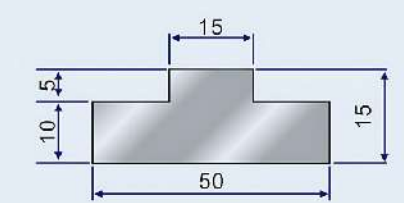
YS507 30°



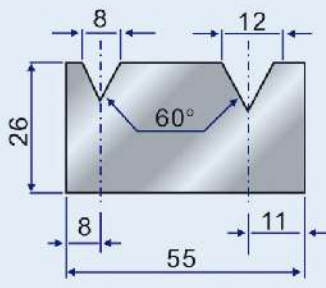
YS508 30°



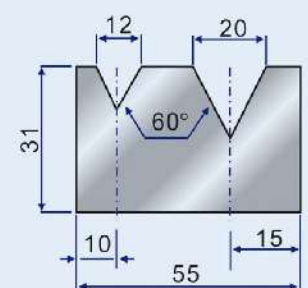
YS40.15



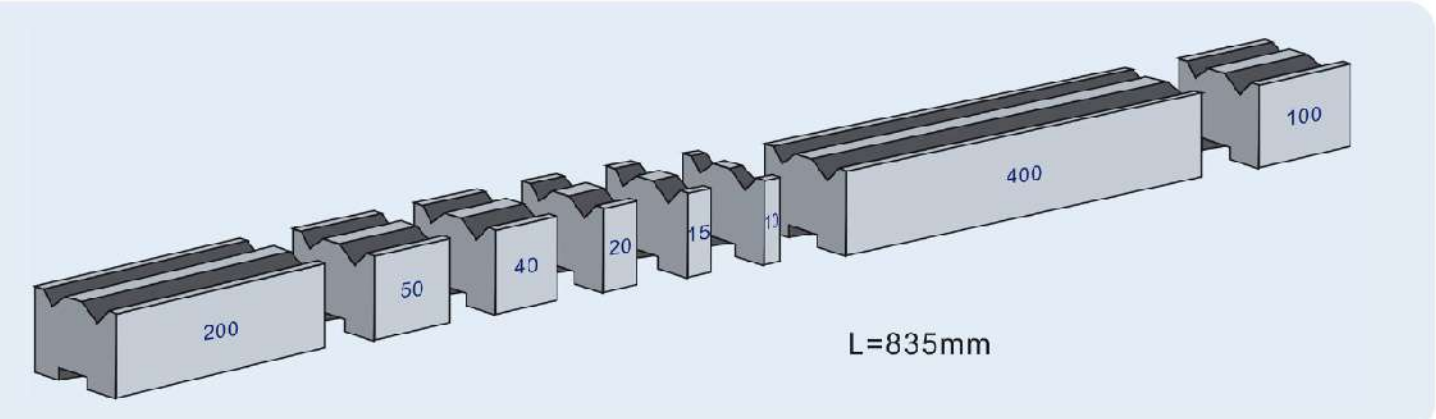
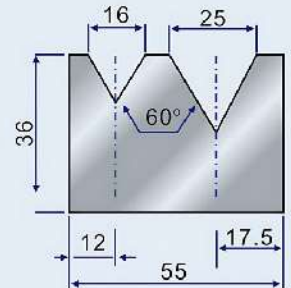
YS20.13 60°



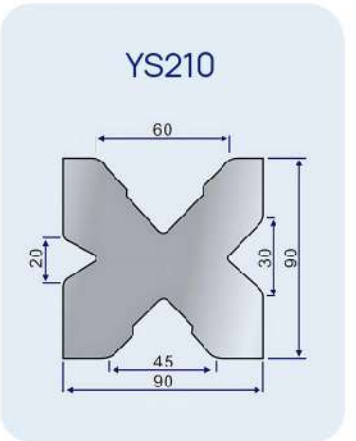
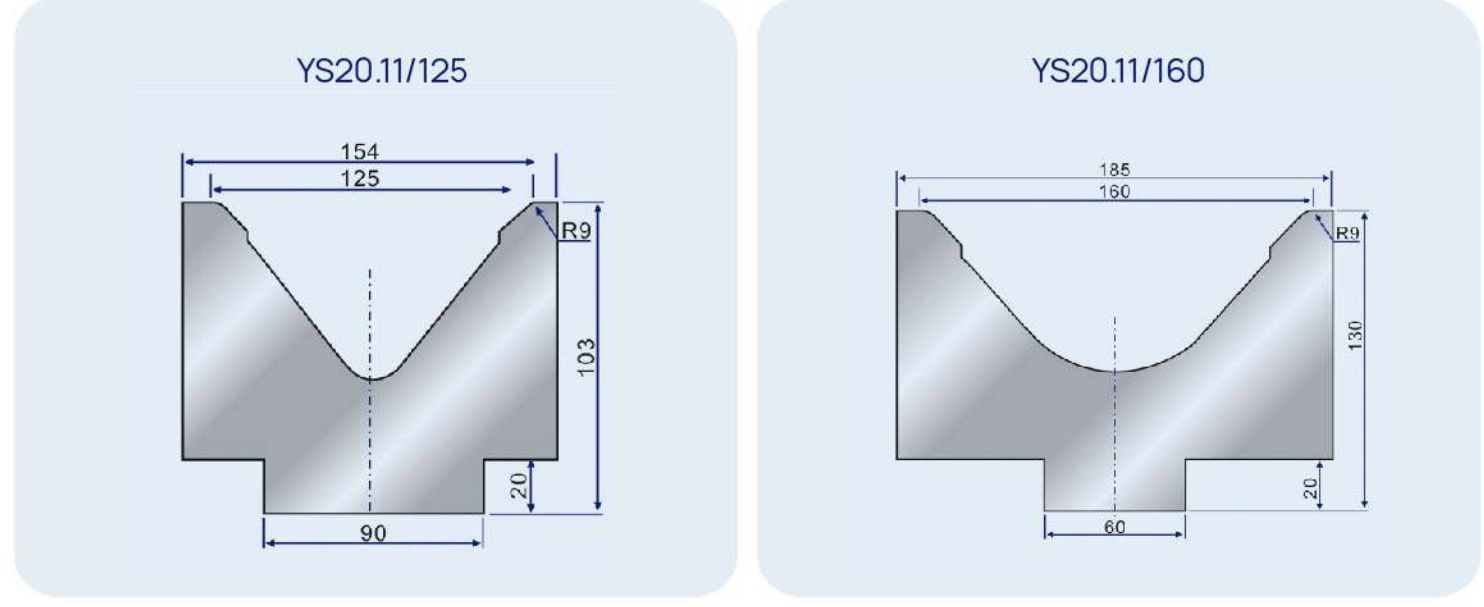
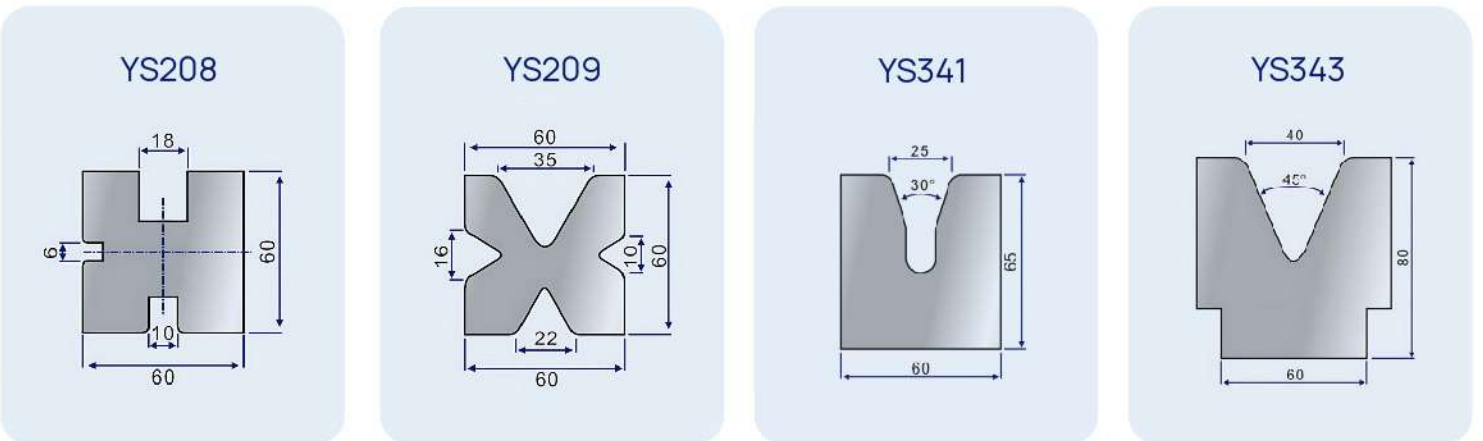
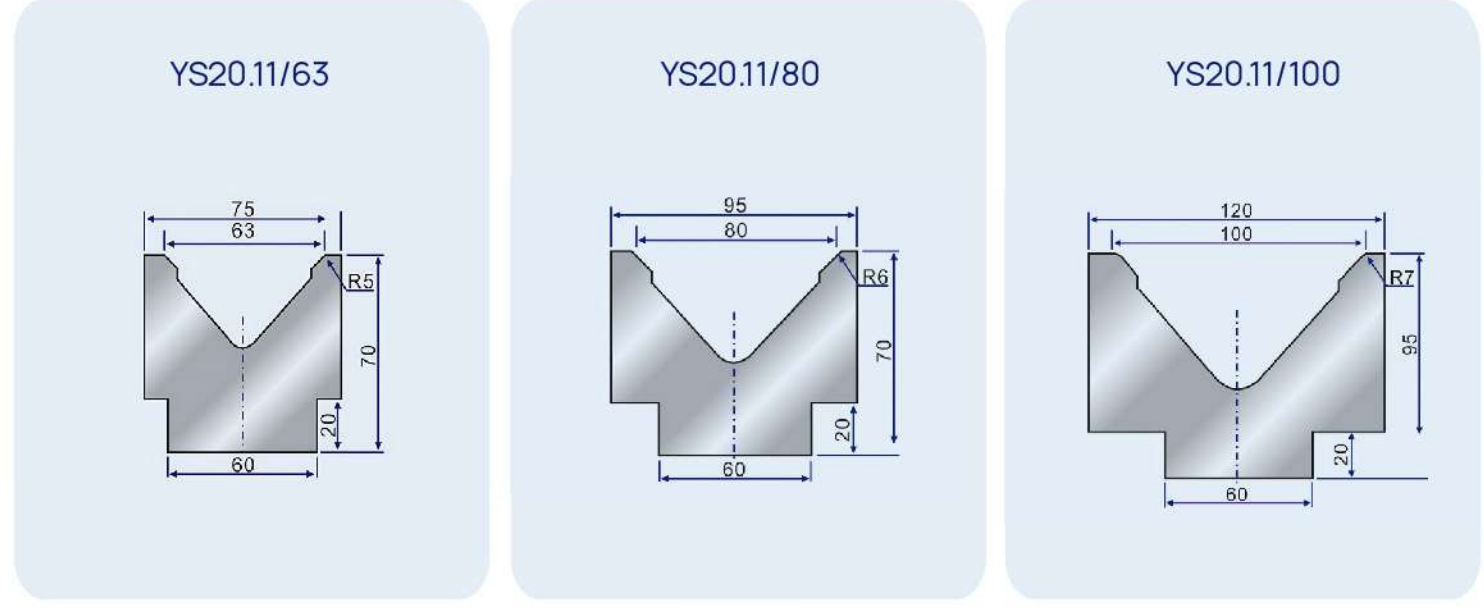
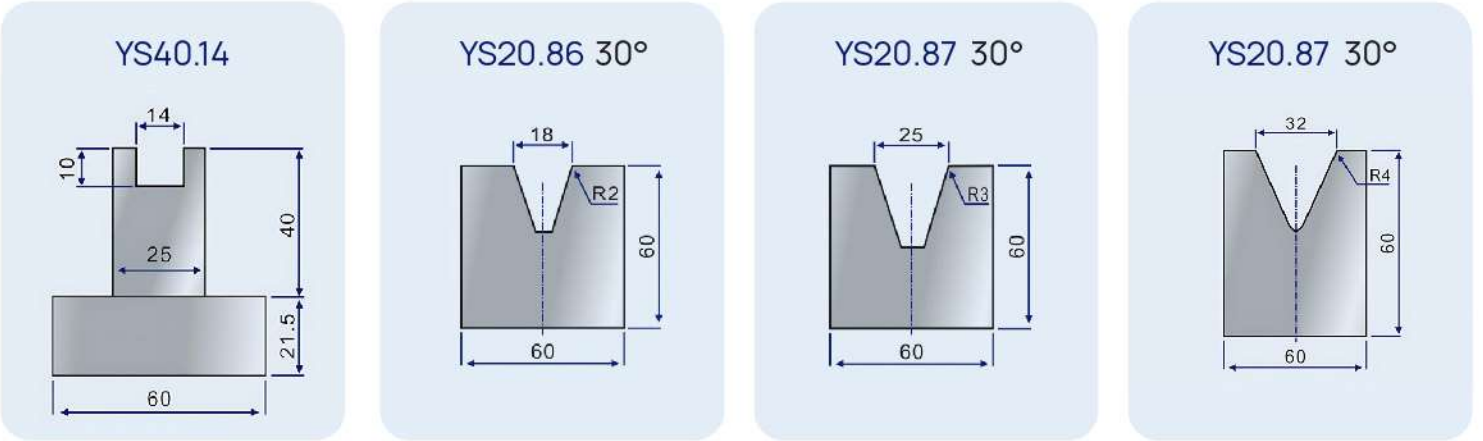
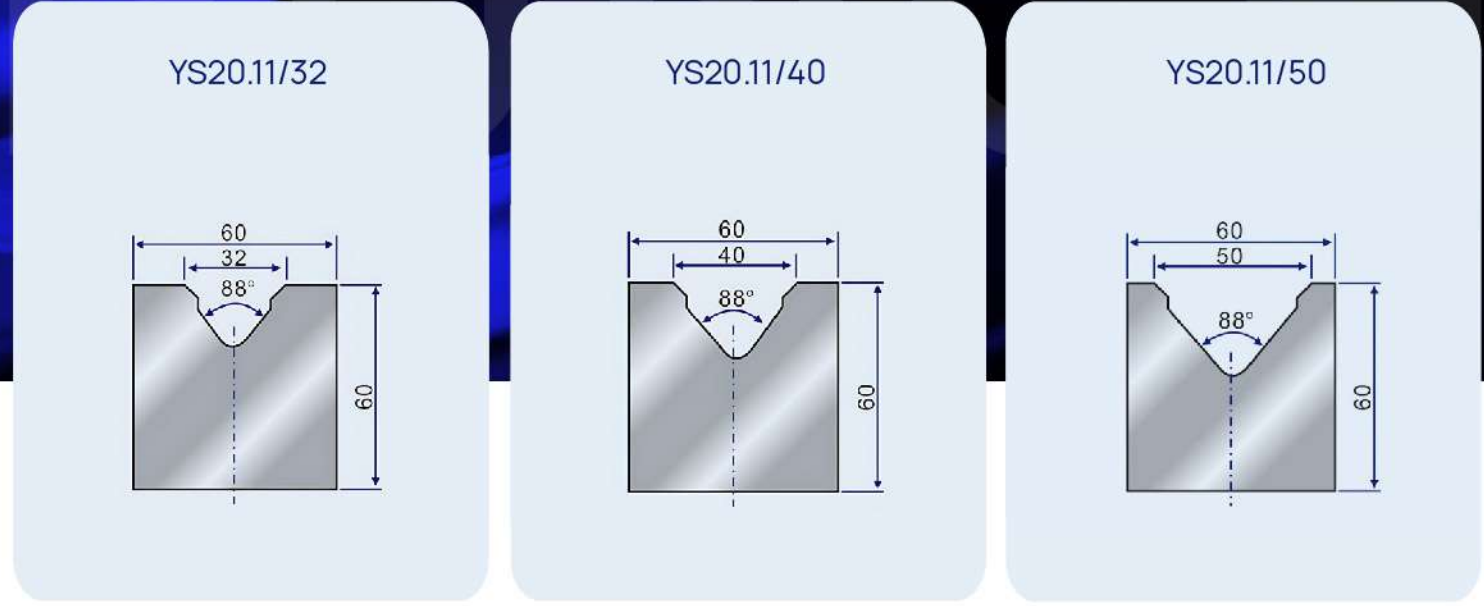
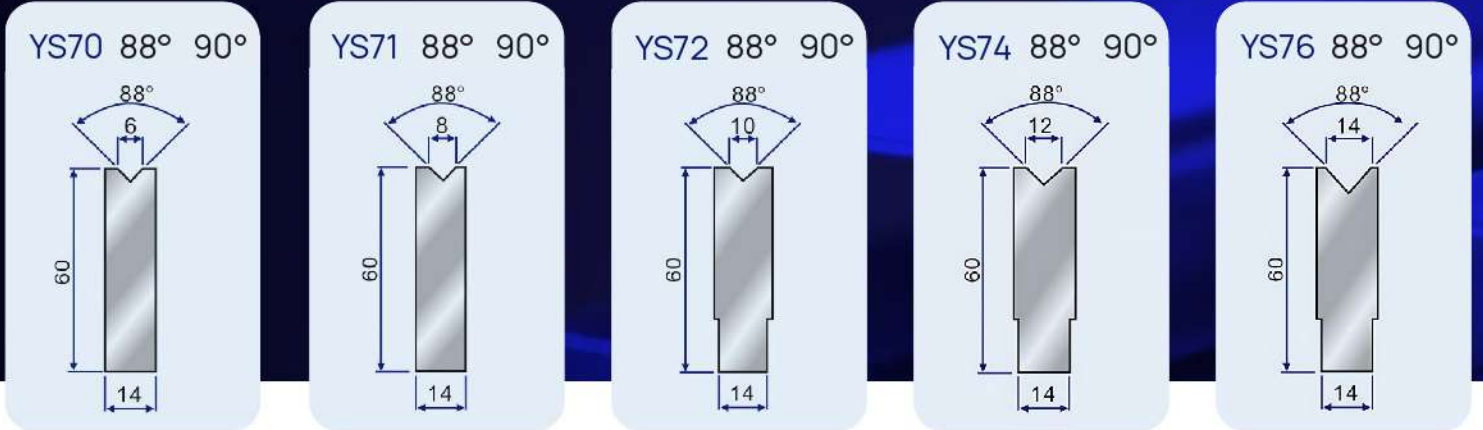
YS20.14 60°



YS20.15 60°



AMADA PRESS BRAKE DIE



AMADA PRESS BRAKE DIE

YS010

V	A	R	S	Rf/P	T/M
6	90°	0.4	14	0.5	100
6	88°	0.4	14	0.5	100
6	60°	0.4	14	0.5	100
6	45°	0.4	14	0.5	100
6	30°	0.4	14	1.0	100

YS011

V	A	R	S	Rf/P	T/M
8	90°	0.5	14	0.5	100
8	88°	0.5	14	0.5	100
8	60°	0.5	14	0.7	60
8	45°	0.5	14	0.5	50
8	30°	0.5	14	2.0	35

YS017

V	A	R	S	Rf/P	T/M
6	88°	0.4	14	0.5	100
6	60°	0.4	14	0.5	60
6	45°	0.6	14	0.5	50
6	30°	0.6	14	1.0	35

YS018

V	A	R	S	Rf/P	T/M
8	88°	0.5	14	0.5	100
8	60°	0.5	14	0.7	60
8	45°	0.8	18	0.5	50
8	30°	0.8	18	2.0	35

YS012

V	A	R	S	Rf/P	T/M
10	90°	0.6	18	0.5	100
10	88°	0.6	18	0.5	100
10	60°	0.6	18	0.7	60
10	45°	1.0	18	0.5	50
10	30°	1.0	24	2.0	50

YS013

V	A	R	S	Rf/P	T/M
12	90°	0.8	18	0.5	100
12	88°	2.75	18	0.5	100
12	60°	0.8	18	0.5	60
12	45°	1.5	24	0.7	50
12	30°	1.5	24	2.0	40

YS019

V	A	R	S	Rf/P	T/M
10	88°	0.6	18	0.5	100
10	60°	0.6	18	0.5	60
10	45°	1.0	18	0.7	60
10	30°	1.0	24	2.0	50

YS020

V	A	R	S	Rf/P	T/M
12	88°	2.75	18	0.5	100
12	60°	0.8	18	0.5	60
12	45°	1.5	24	0.7	50
12	30°	1.5	24	2.0	40

YS0121

V	A	R	S	Rf/P	T/M
16	88°	2.75	24	0.5	100
16	60°	3	24	0.7	60
16	45°	2	24	1.0	50
16	30°	2	30	5.0	45

YS014

V	A	R	S	Rf/P	T/M
16	90°	1	24	0.5	100
16	88°	2.75	24	0.5	100
16	60°	3	24	0.7	60
16	45°	2	24	1.0	50
16	30°	2	30	5.0	40

YS015

V	A	R	S	Rf/P	T/M
20	90°	3	30	0.5	100
20	88°	3	30	0.7	60
20	60°	2.5	30	1.0	50
20	45°	2.5	35	5.0	50

YS016

V	A	R	S	Rf/P	T/M
25	88°	3	35	0.5	100
25	60°	3	35	1.7	60
25	45°	3	35	1.0	50
25	30°	3	40	5.0	50

L=835mm

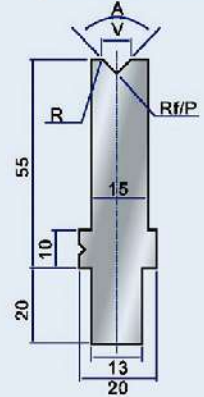
EUROPEAN PRESS BRAKE PUNCH

<p>L2S 85°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>85°</td> <td>1</td> <td>155</td> <td>130</td> </tr> </tbody> </table>	A	R	H	T/M	85°	1	155	130	<p>L4S 85°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>85°</td> <td>0.8</td> <td>155.05</td> <td>90</td> </tr> <tr> <td>85°</td> <td>1.5</td> <td>155.03</td> <td>90</td> </tr> </tbody> </table>	A	R	H	T/M	85°	0.8	155.05	90	85°	1.5	155.03	90	<p>L6S 30°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>30°</td> <td>1</td> <td>155.04</td> <td>160</td> </tr> <tr> <td>30°</td> <td>3</td> <td>155.04</td> <td>160</td> </tr> </tbody> </table>	A	R	H	T/M	30°	1	155.04	160	30°	3	155.04	160	<p>L8S 88°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>88°</td> <td>1</td> <td>155</td> <td>80</td> </tr> </tbody> </table>	A	R	H	T/M	88°	1	155	80	<p>LS10.61 30°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>30°</td> <td>1</td> <td>237</td> <td>50</td> </tr> </tbody> </table>	A	R	H	T/M	30°	1	237	50	<p>KS10.62 86°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>86°</td> <td>1</td> <td>237</td> <td>45</td> </tr> </tbody> </table>	A	R	H	T/M	86°	1	237	45	<p>LS10.63 60°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>60°</td> <td>3</td> <td>237</td> <td>100</td> </tr> </tbody> </table>	A	R	H	T/M	60°	3	237	100	<p>LS10.64 26°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>26°</td> <td>1</td> <td>157</td> <td>80</td> </tr> </tbody> </table>	A	R	H	T/M	26°	1	157	80
A	R	H	T/M																																																																												
85°	1	155	130																																																																												
A	R	H	T/M																																																																												
85°	0.8	155.05	90																																																																												
85°	1.5	155.03	90																																																																												
A	R	H	T/M																																																																												
30°	1	155.04	160																																																																												
30°	3	155.04	160																																																																												
A	R	H	T/M																																																																												
88°	1	155	80																																																																												
A	R	H	T/M																																																																												
30°	1	237	50																																																																												
A	R	H	T/M																																																																												
86°	1	237	45																																																																												
A	R	H	T/M																																																																												
60°	3	237	100																																																																												
A	R	H	T/M																																																																												
26°	1	157	80																																																																												
<p>L2R 88°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>85°</td> <td>1</td> <td>155</td> <td>100</td> </tr> </tbody> </table>	A	R	H	T/M	85°	1	155	100	<p>L4R 88°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>85°</td> <td>1.5</td> <td>155</td> <td>80</td> </tr> </tbody> </table>	A	R	H	T/M	85°	1.5	155	80	<p>L7R 30°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>30°</td> <td>1</td> <td>155.04</td> <td>160</td> </tr> <tr> <td>30°</td> <td>3</td> <td>155.04</td> <td>160</td> </tr> </tbody> </table>	A	R	H	T/M	30°	1	155.04	160	30°	3	155.04	160	<p>L8R 88°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>85°</td> <td>1</td> <td>155</td> <td>100</td> </tr> </tbody> </table>	A	R	H	T/M	85°	1	155	100	<p>LS10.65 88°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>88°</td> <td>1</td> <td>157</td> <td>80</td> </tr> </tbody> </table>	A	R	H	T/M	88°	1	157	80	<p>LS10.66 26°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>26°</td> <td>1</td> <td>180</td> <td>50</td> </tr> </tbody> </table>	A	R	H	T/M	26°	1	180	50	<p>LS10.67 78°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>78°</td> <td>1</td> <td>180</td> <td>50</td> </tr> </tbody> </table>	A	R	H	T/M	78°	1	180	50	<p>LS10.68 78°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>78°</td> <td>1</td> <td>180</td> <td>80</td> </tr> </tbody> </table>	A	R	H	T/M	78°	1	180	80				
A	R	H	T/M																																																																												
85°	1	155	100																																																																												
A	R	H	T/M																																																																												
85°	1.5	155	80																																																																												
A	R	H	T/M																																																																												
30°	1	155.04	160																																																																												
30°	3	155.04	160																																																																												
A	R	H	T/M																																																																												
85°	1	155	100																																																																												
A	R	H	T/M																																																																												
88°	1	157	80																																																																												
A	R	H	T/M																																																																												
26°	1	180	50																																																																												
A	R	H	T/M																																																																												
78°	1	180	50																																																																												
A	R	H	T/M																																																																												
78°	1	180	80																																																																												
				<p>LS10.69 78°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>78°</td> <td>2</td> <td>255</td> <td>45</td> </tr> </tbody> </table>	A	R	H	T/M	78°	2	255	45	<p>LS10.70 24°</p> <table border="1"> <thead> <tr> <th>A</th> <th>R</th> <th>H</th> <th>T/M</th> </tr> </thead> <tbody> <tr> <td>24°</td> <td>1.1</td> <td>120</td> <td>100</td> </tr> </tbody> </table>	A	R	H	T/M	24°	1.1	120	100																																																										
A	R	H	T/M																																																																												
78°	2	255	45																																																																												
A	R	H	T/M																																																																												
24°	1.1	120	100																																																																												

EUROPEAN PRESS BRAKE PUNCH

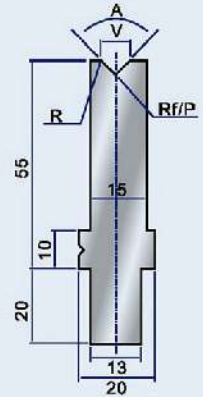
YM6

V	A	R	H	T	S	Rf/P	T/M
90°	6	90°	0.4	55	20	15	0.5 100
88°	6	88°	0.8	55	20	15	0.5 100
30°	6	30°	0.6	55	20	15	2.0 35



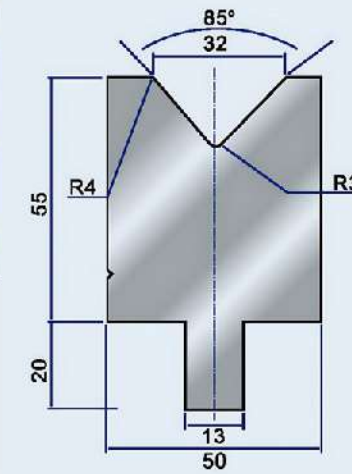
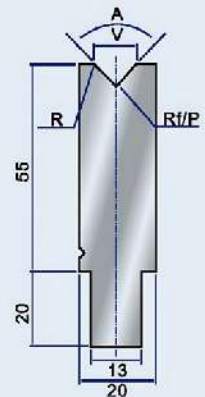
YM8

V	A	R	H	T	S	Rf/P	T/M
90°	6	90°	0.5	55	20	15	0.5 100
88°	6	88°	1.0	55	20	15	0.5 100
30°	6	30°	0.8	55	20	15	2.0 35



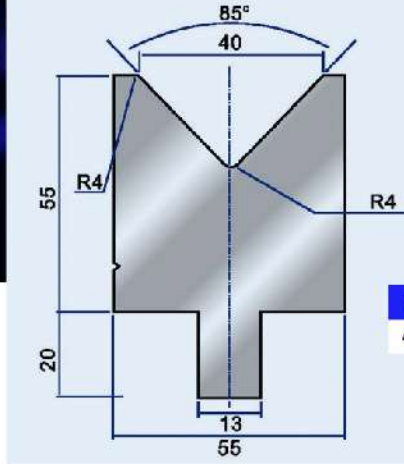
YM10

V	A	R	H	T	S	Rf/P	T/M
90°	10	90°	1.0	55	20	20	0.5 100
88°	10	88°	1.0	55	20	20	0.5 100
30°	10	30°	1.0	55	20	15	2.0 50



YM32
85°

V	A	R	S	Rf/P	T/M
32	85°	4.0	50	3.0	100

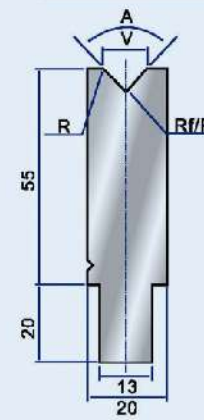


YM40
85°

V	A	R	S	Rf/P	T/M
40	85°	4.0	55	4.0	100

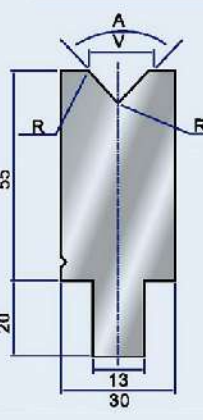
YM12

V	A	R	H	T	S	Rf/P	T/M
90°	12	90°	1.5	55	20	15	0.5 100
88°	12	88°	1.5	55	20	15	0.5 100
30°	12	30°	1.5	55	20	15	2.0 40



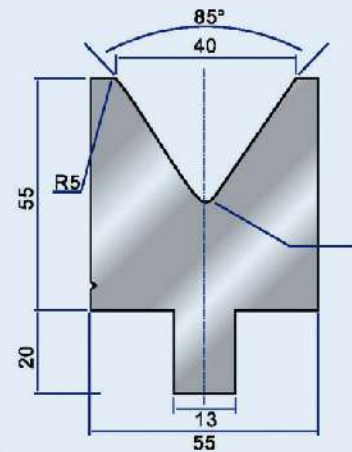
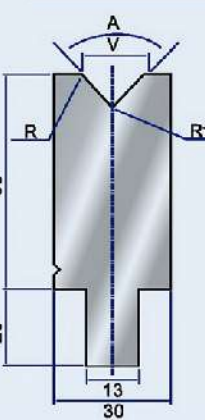
YM16

V	A	R	H	T	S	Rf/P	T/M
90°	16	90°	2.0	55	30	30	0.5 100
88°	16	88°	2.0	55	30	30	0.5 100
30°	16	30°	2.0	55	30	30	2.0 45



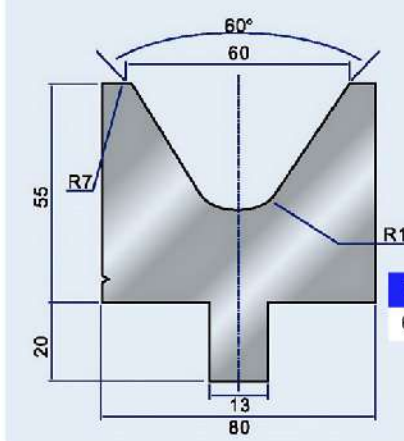
YM20

V	A	R	H	T	S	Rf/P	T/M
90°	16	90°	2.0	55	30	30	0.5 100
88°	16	88°	2.0	55	30	30	0.5 100
30°	16	30°	2.0	55	30	30	2.0 45



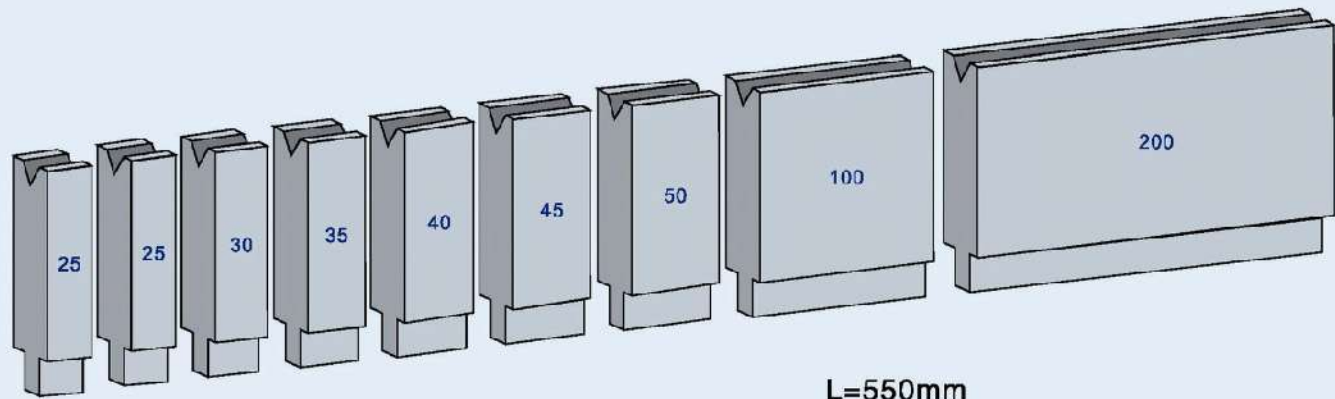
YM32
60°

V	A	R	S	Rf/P	T/M
40	60°	5.0	55	5.0	100

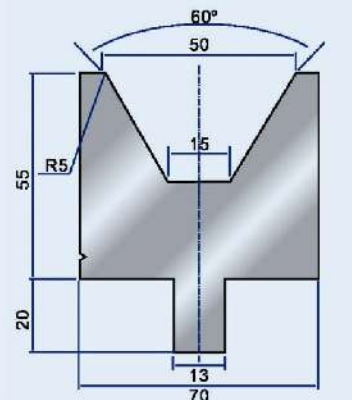


YM60
60°

V	A	R	S	Rf/P	T/M
60	60°	7.0	80	15	100



L=550mm



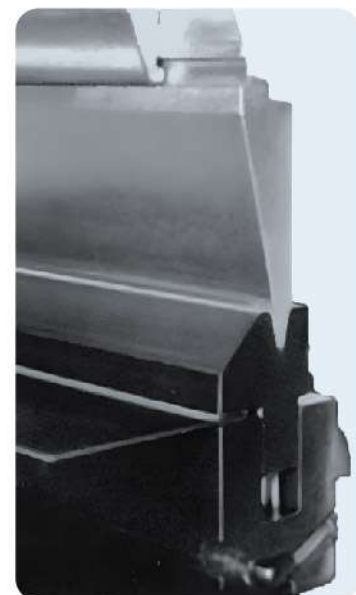
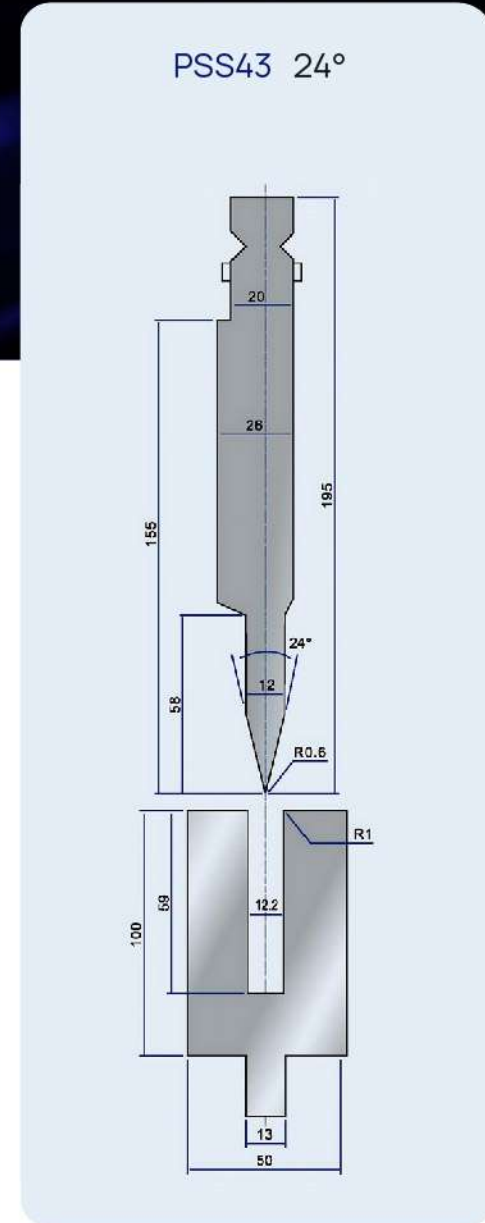
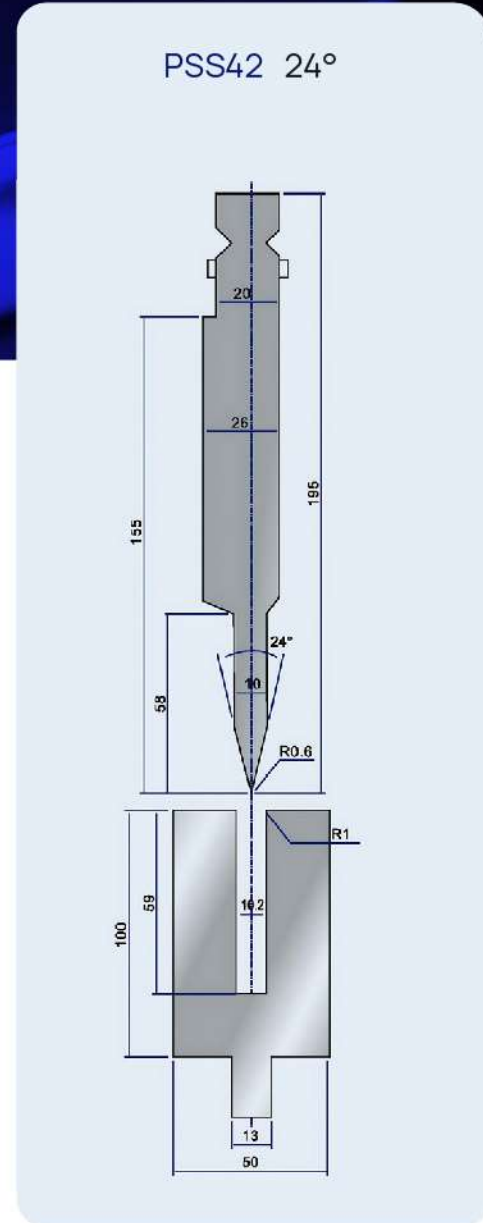
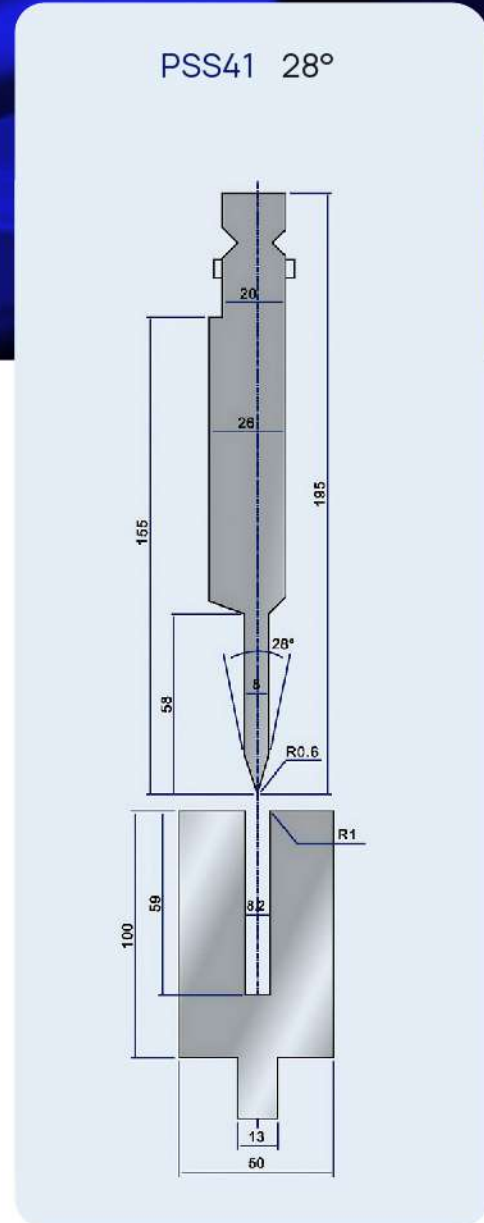
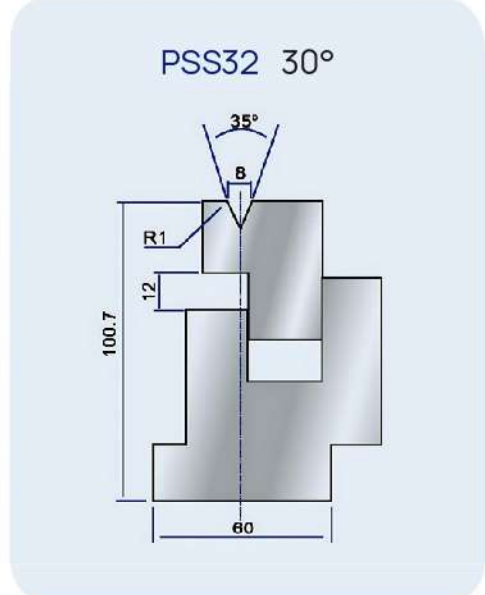
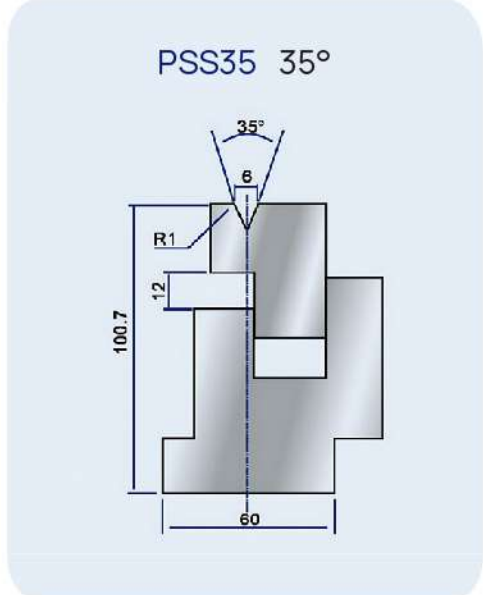
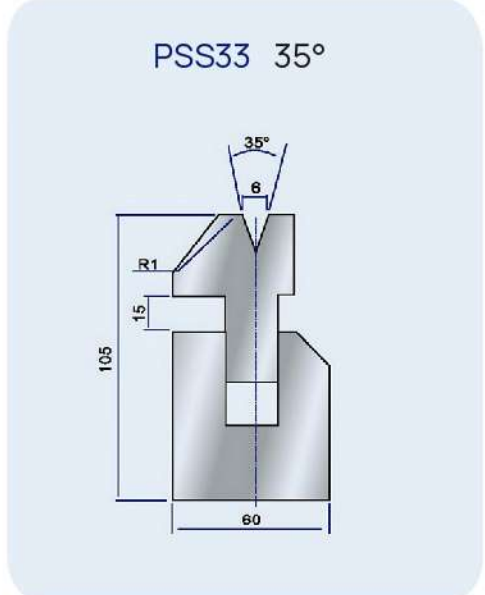
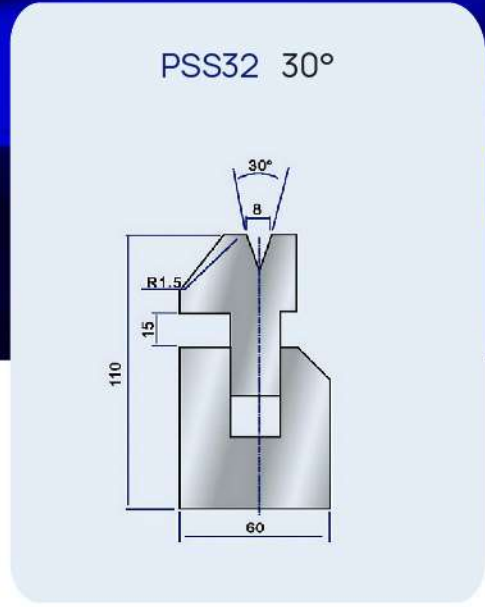
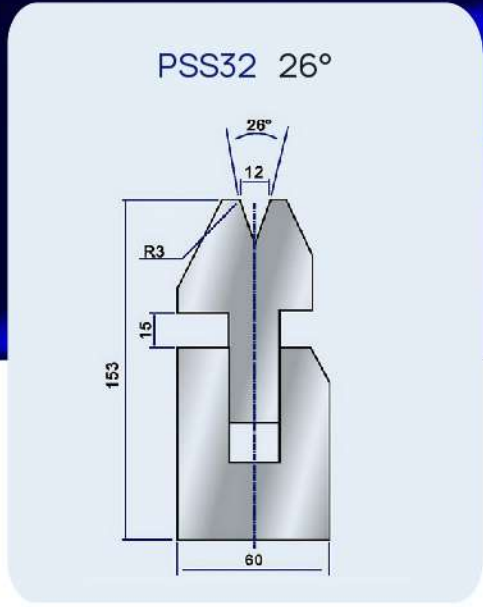
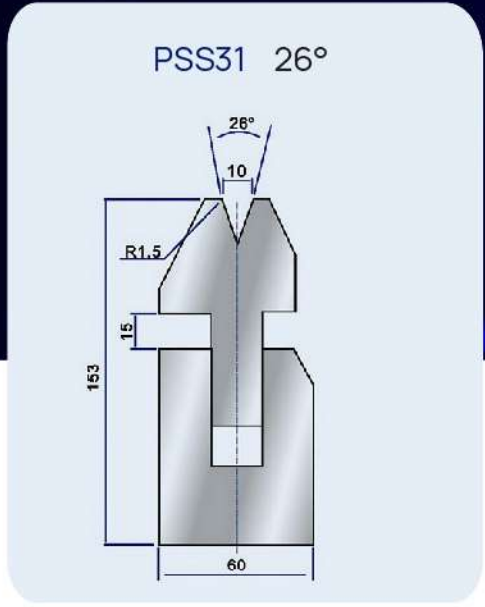
YM50
60°

V	A	R	S	Rf/P	T/M
50	60°	5.0	70	15	100



AMADA HEMMING DIE

EUROPEAN HEMMING DIE



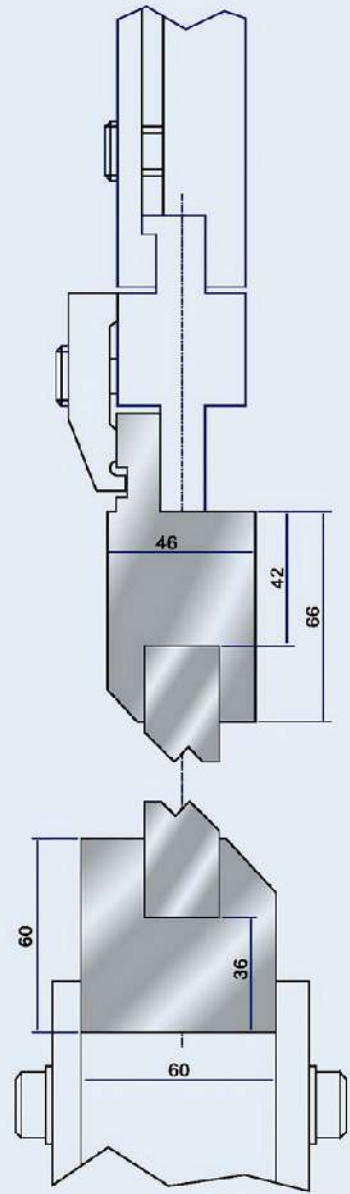
Smm	Amm	Ton/M	2XS	Ton/M
0.6	3	9	1.2	23
0.8	3	12	1.6	32
1	3.5	15	2	40
1.25	3.5	17	2.5	50
1.5	4.6	22	3	63
2	5.5	30	4	80
2.5	6.5	55	5	90
3	8	70	6	100

Smm	Amm	Ton/M	2XS	Ton/M
0.6	3	15	1.2	35
0.8	3	20	1.6	50
1	3.5	25	2	60
1.25	3.5	26	2.5	80
1.5	4.6	38	3	95
2	5.5	50	4	130

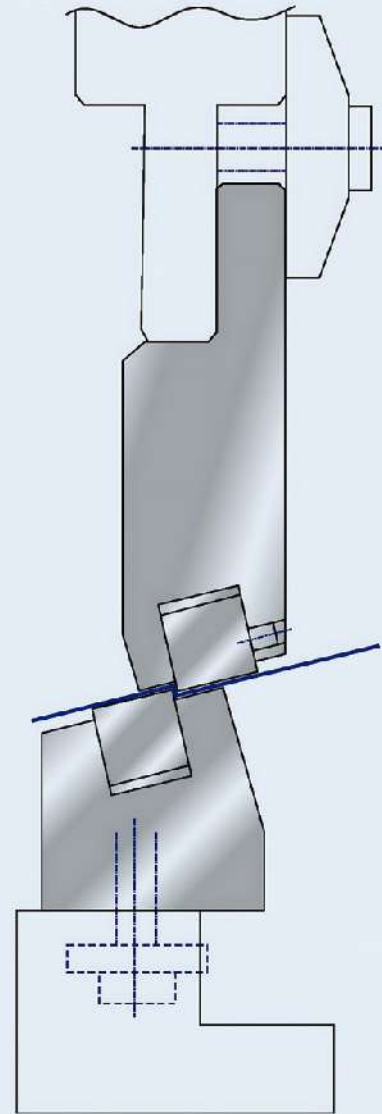
JOGGLE Z TOOLING

RADIUS TOOLING

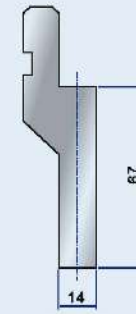
DC01



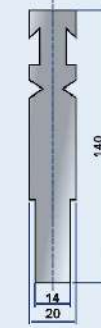
DC02



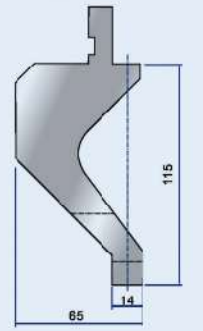
LB01



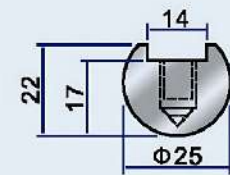
LB02



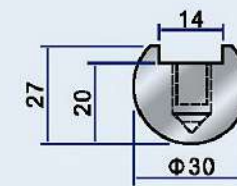
LB03



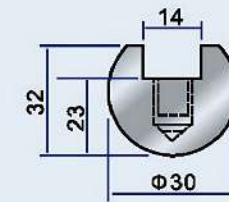
LTR12.5



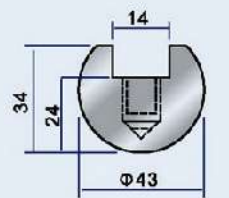
LTR15



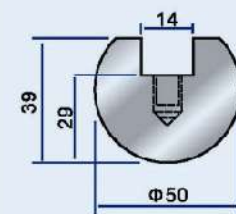
LTR17.5



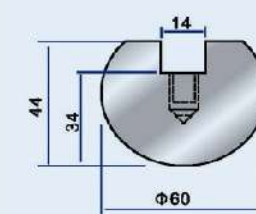
LTR20



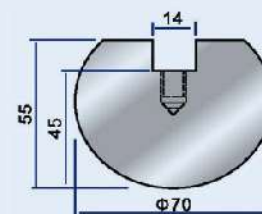
LTR25



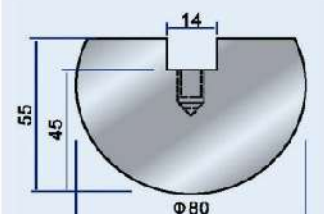
LTR30



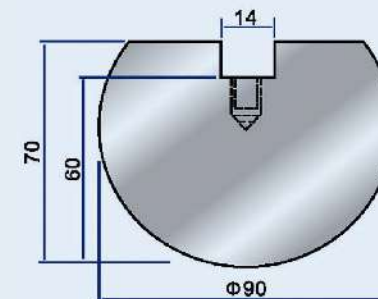
LTR35



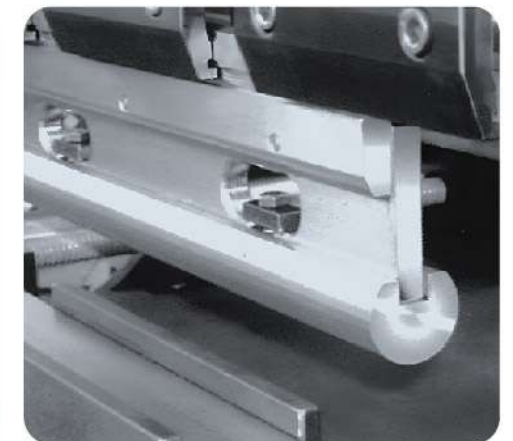
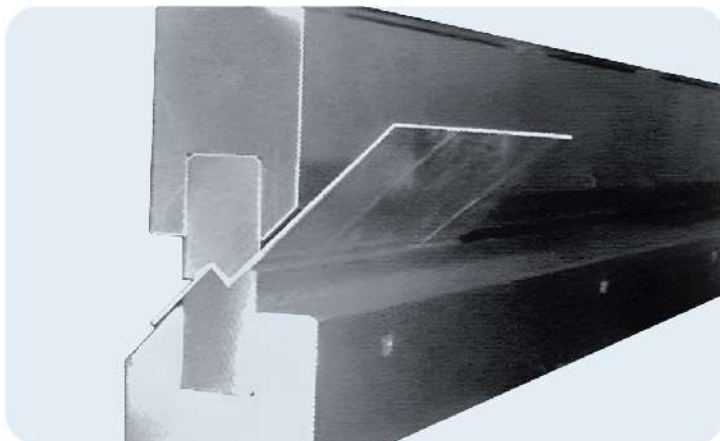
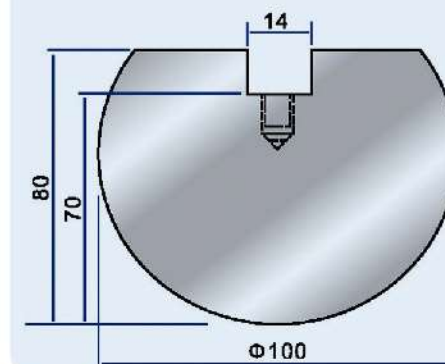
LTR40



LTR45

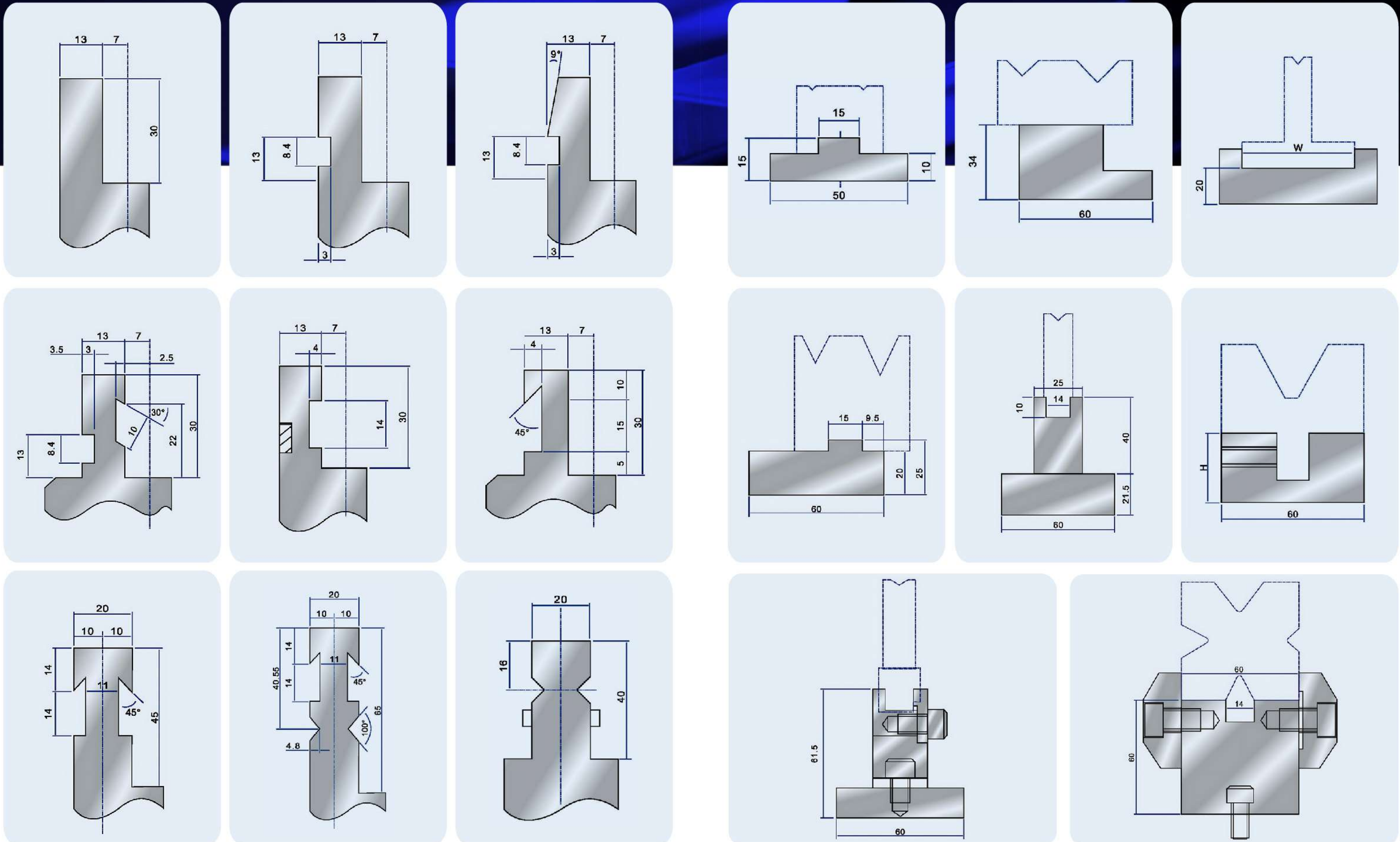


LB02



MOLDING RACK

DIE RAIL



STANDARD PRESS BRAKE PUNCH

STANDARD PRESS BRAKE DIE

LG01
30°

R	T/M
0.5	60
0.8	60
1.0	60

LG02
30°

R	T/M
0.5	60
0.8	60
1.0	60

LG03
88°

R	T/M
0.5	80
0.8	80
1.0	80

LG04
88°

R	T/M
0.5	80
0.8	80
1.0	80

LG05
88°

R	T/M
0.5	120
0.8	120
1.0	120

LG06
88°

R	T/M
0.5	60
0.8	60
1.0	60

LB01

LB02

LB03

LB04

LB05

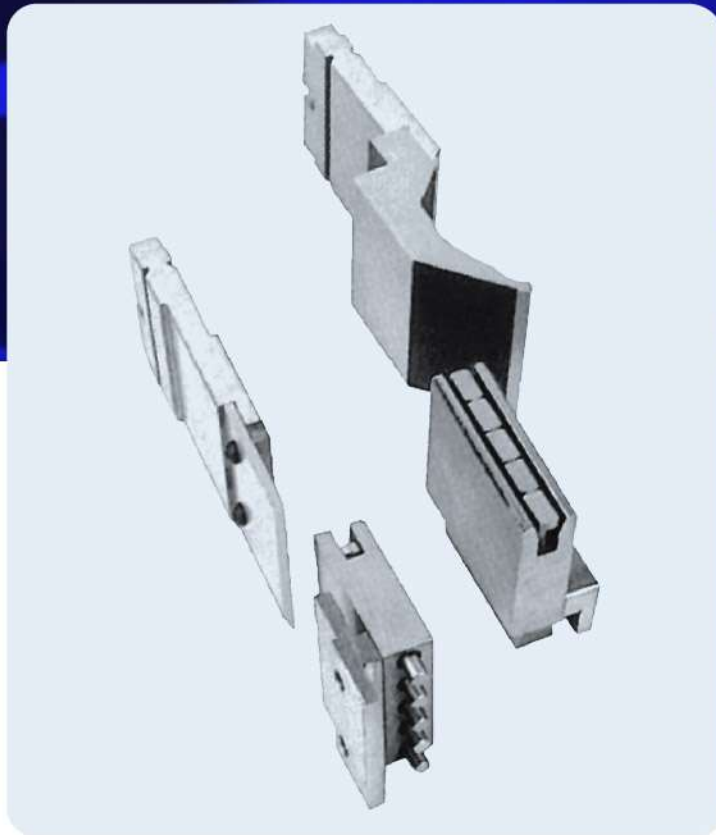
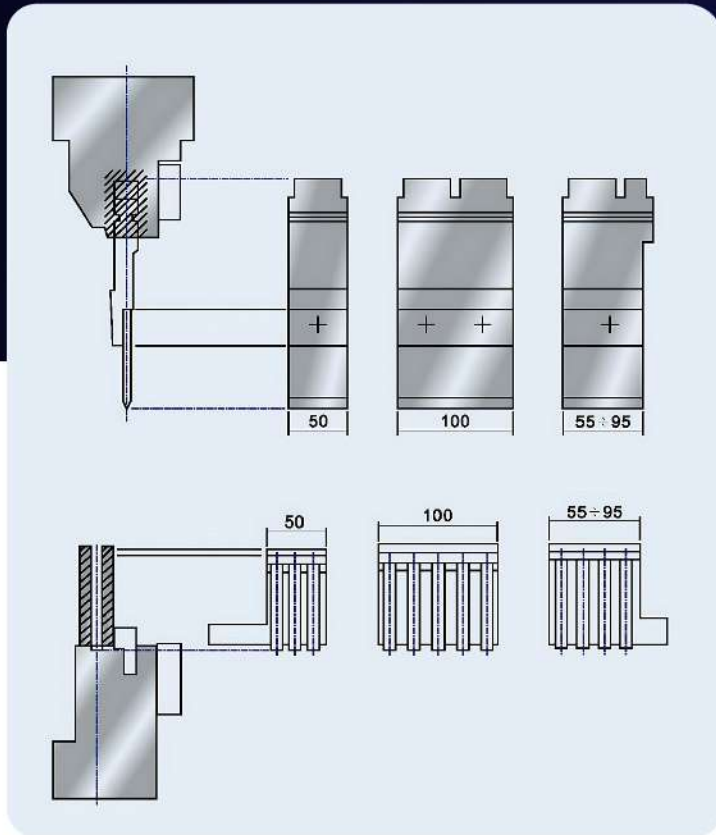
LB06

LB07

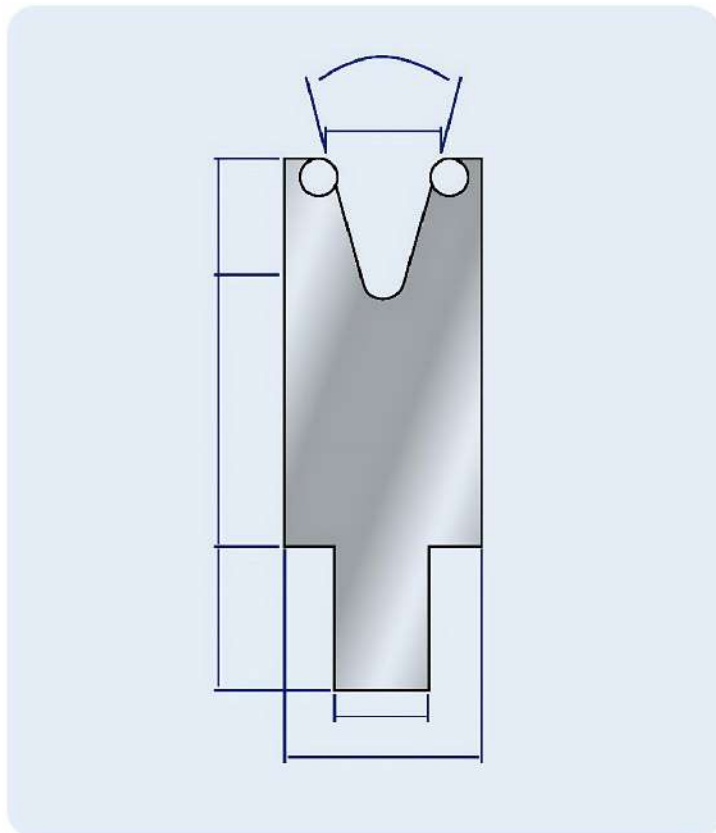
LB08

LB09

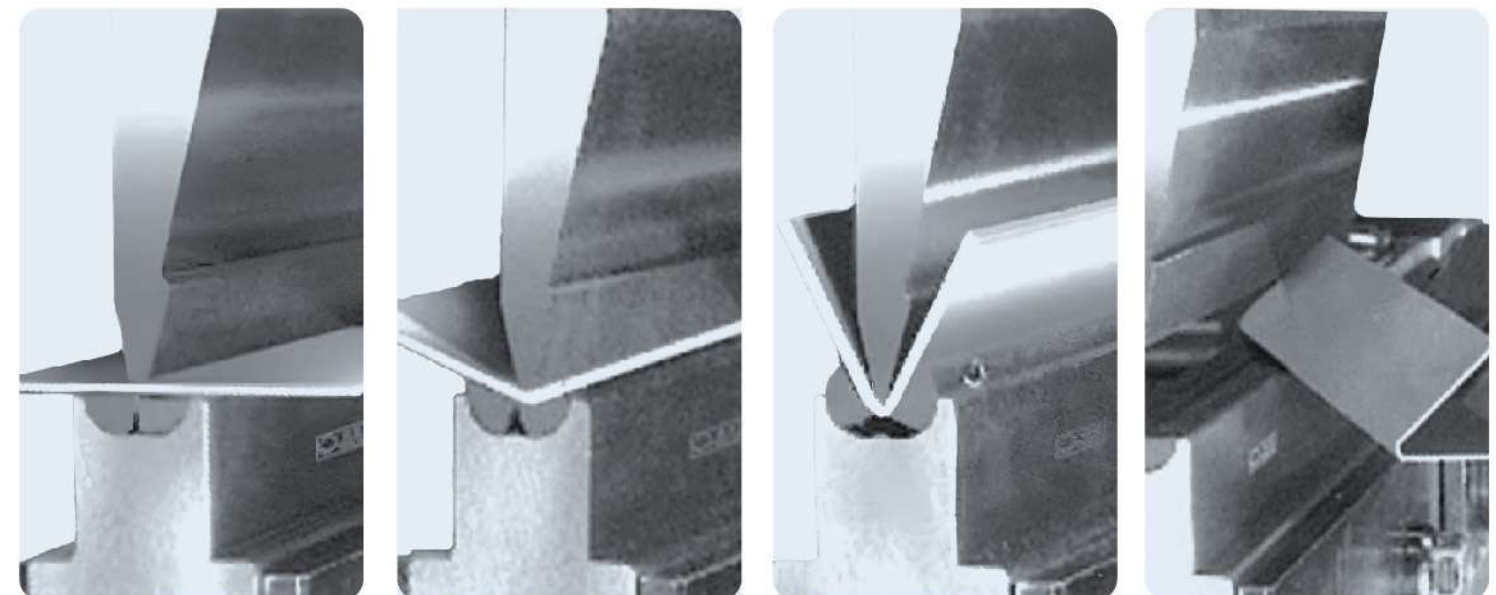
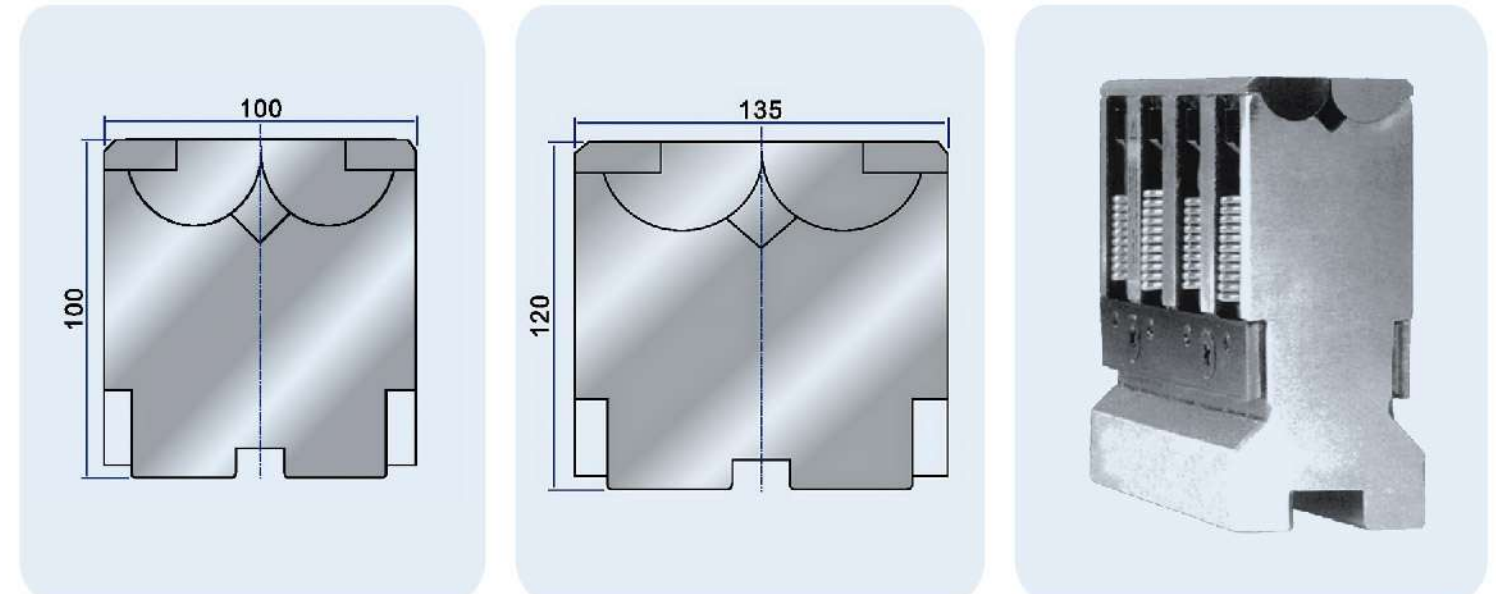
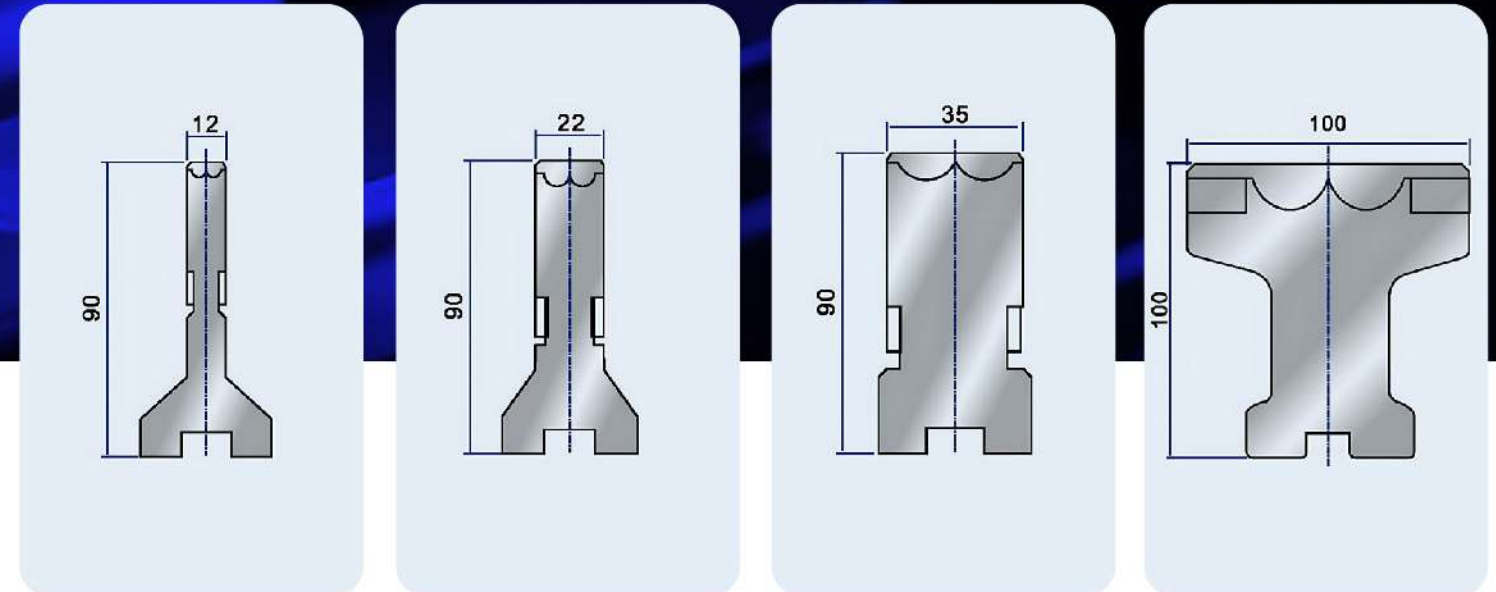
THREE POINT TOOLING



SCRATCH RESISTANCE DIE



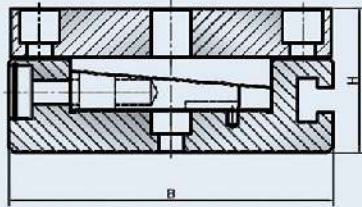
STANDARD RESISTANCE DIE



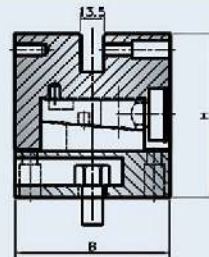
PRESS BRAKE CROWNING TABLE

HORIZONTAL CROWNING

BGT-A1

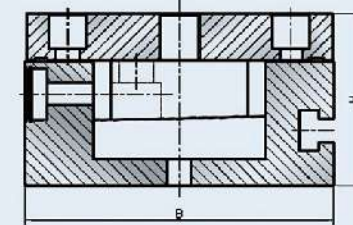


BGT-A2

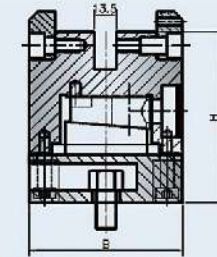


BIDIRECTIONAL CROWNING

BGT-C1



BGT-C2



Technical specifications (mm)				Adjustment	Product Mode
L	B	H	Maximum compensation value		
2500	180	80	1.0	Manual	BGT-2500x180x80/A1
3200					BGT-3200x180x80/A1
4000					BGT-4000x180x80/A1
2500	200	80			BGT-2500x200x80/A1
3200					BGT-3200x200x80/A1
4000					BGT-4000x200x80/A1
2500	220	80			BGT-2500x220x80/A1
3200					BGT-3200x220x80/A1
4000					BGT-4000x220x80/A1
3200	240	85	1.2	BGT-3200x240x85/A1	
4000			2.0	BGT-4000x240x85/A1	
6000			2.0	BGT-6000x240x85/A1	
3200	280	90	1.2	BGT-3200x280x90/A1	
4000			2.0	BGT-4000x280x90/A1	
6000			2.0	BGT-6000x280x90/A1	

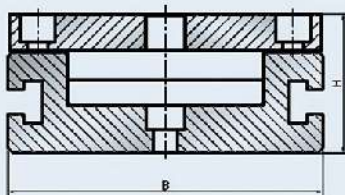
Technical specifications (mm)				Adjustment	Product Mode
L	B	H	Maximum compensation value		
1050	95	90	1.0	Manual	BGT-1050x95x90/A2
1250					BGT-1250x95x90/A2
1500					BGT-1500x95x90/A2
2050					BGT-2050x95x90/A2
2570					BGT-2570x95x90/A2
3100					BGT-3100x95x90/A2
4100					BGT-4100x95x90/A2

Technical specifications (mm)			Maximum compensation value		Adjustment	Product Mode
L	B	H	Horizontal	Vertical		
2500	180	100	2.0	0.5	Manual+ Manual & Manual+ Motor	BGT-2500x180x100/C1
3200						BGT-3200x180x100/C1
4000						BGT-4000x180x100/C1
2500	200	100				BGT-2500x200x100/C1
3200						BGT-3200x200x100/C1
4000						BGT-4000x200x100/C1
2500	220	100				BGT-2500x220x100/C1
3200						BGT-3200x220x100/C1
4000						BGT-4000x220x100/C1
3200	240	110	BGT-3200x240x100/C1			
4000			BGT-4000x240x100/C1			
6000			BGT-6000x240x100/C1			
3200	280	110	BGT-3200x280x100/C1			
4000			BGT-4000x280x100/C1			
6000			BGT-6000x280x100/C1			

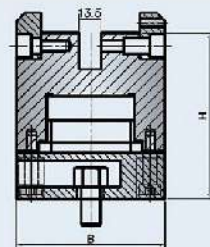
Technical specifications (mm)			Maximum compensation value		Adjustment	Product Mode
L	B	H	Horizontal	Vertical		
1050	95	100	2.0	0.5	Manual+ Manual & Manual+ Motor	BGT-1050x90x100/C2
2050						BGT-2050x90x100/C2
2570						BGT-2570x90x100/C2
3100						BGT-3100x90x100/C2
4100						BGT-4100x90x100/C2

VERTICAL CROWNING

BGT-B1



BGT-B2



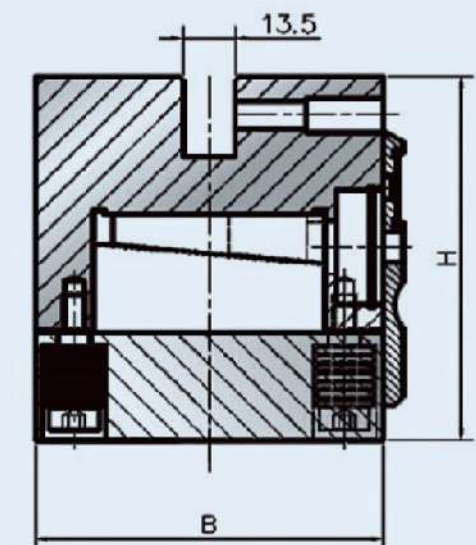
Technical specifications (mm)				Adjustment	Product Mode
L	B	H	Maximum compensation value		
2500	180	100	2.0	Manual & Motor	BGT-2500x180x100/B1
3200					BGT-3200x180x100/B1
4000					BGT-4000x180x100/B1
2500	200	100			BGT-2500x200x100/B1
3200					BGT-3200x200x100/B1
4000					BGT-4000x200x100/B1
2500	220	100			BGT-2500x220x100/B1
3200					BGT-3200x220x100/B1
4000					BGT-4000x220x100/B1
3200	240	100	BGT-3200x240x100/B1		
4000			BGT-4000x240x100/B1		
6000			BGT-6000x240x100/B1		
3200	280	100	BGT-3200x280x100/B1		
4000			BGT-4000x280x100/B1		
6000			BGT-6000x280x100/B1		

Technical specifications (mm)				Adjustment	Product Mode
L	B	H	Maximum compensation value		
1050	95	90	2.0	Manual & Motor	BGT-1050x95x90/B2
1250					BGT-1250x95x90/B2
1500					BGT-1500x95x90/B2
2050					BGT-2050x95x90/B2
2570					BGT-2570x95x90/B2
3100					BGT-3100x95x90/B2
4100					BGT-4100x95x90/B2

HIGH PRECISION BIDIRECTIONAL CROWNING

Technical specifications (mm)			Maximum compensation value		Adjustment	Product Mode
L	B	H	Horizontal	Vertical		
2050	90	95	1.33	0.44	Manual+ Manual & Manual+ Motor	BGT-2050x90x95/D
2570			1.55	0.44		BGT-2570x90x95/D
3100			1.85	0.44		BGT-3100x90x95/D
4100			2.00	0.44		BGT-4100x90x95/D

BGT-D1

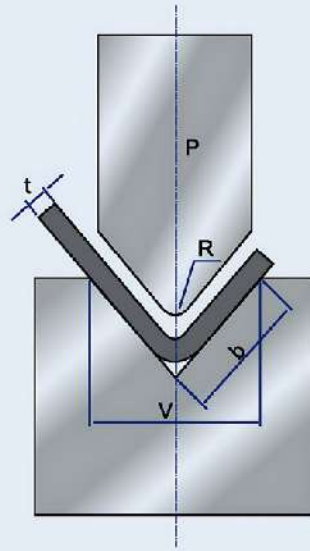


BENDING CHART

Please check the diagram after alab thick ness and bending inner radius being decided.

- 1.It can be seen that the pressure at every meter when bending materials;
- 2.The V-groove width(V) of bottom mold while bending;
- 3.The shortest-length(b) arising while bending.

Note: The following diagram shows the corresponding Vgeneral width of the mold with general thickness.

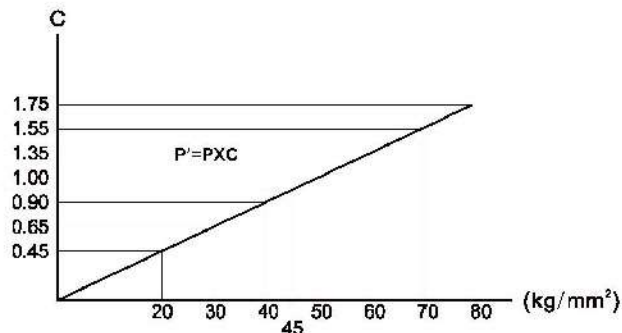


T	0.5~2.6	3.0~8	9~10	12 or higher
V	6t	8t	10t	12t

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V		
mm	0.7	1.0	1.1	1.3	1.6	2.0	2.3	2.6	3.0	3.3	4.0	5.0	6.5	8.0	10	13	16	20	26	33	41	R		
0.5	4	2																						
0.6	6	4	4	4																				
0.8		7	7	5	4																			
1.0		11	10	8	7	6																		
1.2			14	12	10	8	7	6																
1.4				15	13	11	10	9	8															
1.6					17	15	13	11	10	9														
2.0						22	19	17	15	13	11													
2.3							25	23	21	19	17	15	12											
2.6								28	25	22	18	14												
3.0									34	30	24	19	15											
3.2										34	27	22	17	14										
3.5											33	26	20	16	13									
4.0											43	34	27	21	17									
4.5												44	34	27	21									
5.0													52	42	33	26	21							
6.0														60	48	38	30	24						
7.0																52	41	33	26					
9.0																	67	54	43					
10																		85	67	53	42			
12																			96	78	60	55		
16																				136	107	86		
19																					150	125	100	
22																						160	130	
25																							210	170
30																								240

t : Board material thickness (tensile strength = 45-50kg/mm²)
 P: Necessary pressure per metre (Ton/m)
 R: Bending inner radius
 b: Shortest-length
 V: The V-groove width of bottom mold

Aluminum = 30kg/mm² P = P (gauge) × 0.65
 Stainless Steel = 70kg/mm² P = P (gauge) × 1.6



SHEARING MACHINE BLADE

