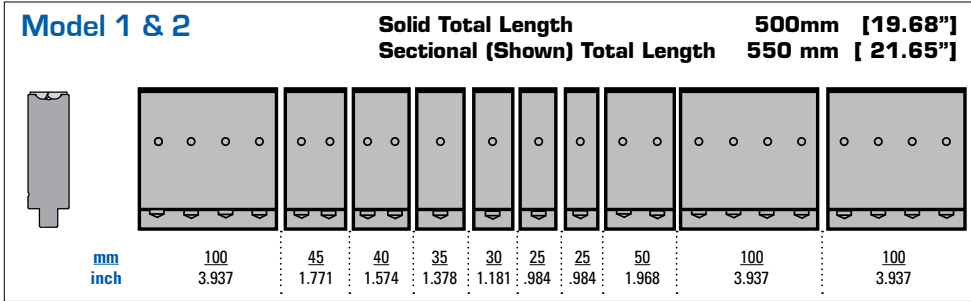


V-SERIES BLACK DATA CHART

	Material Thickness	Min. Outside Flange	Ton/FT	IR to Achieve Min Angle	Min. Angle	Effective V @ Min. Angle	Max OR Radius @ Min. Angle	Effective V @ 90°	Max OR Radius @ 90°	Shoulder Radius All Angles	Max Tons/ FT	Max Tons/ M	Max kN/ M
MODEL 1 MAX. .059" [1.5 mm]	.45 mm .018"	3.0 mm .118"	1.8	0.054	34°	6.5 mm 2.56"	3.17 mm .125"	7.2 mm .283"	4.45 mm .175"	1.0 mm .039"	34	112	1100
	.50 mm .020"		1.8	0.052									
	.60 mm .024"		2.0	0.047									
	.80 mm .030"		2.5	0.042									
	.90 mm .036"		3.3	0.036									
	1.0 mm .040"	3.9 mm .153"	4.0	0.031									
	1.2 mm .048"		5.8										
	1.5 mm .059"		9										
MODEL 2 MAX. .135" [3.43 mm]	1.9 mm .074"	8.5 mm .335"	7	0.122	42°	13.3 mm .524"	5.5 mm .216"	13.9 mm .547"	9.0 mm .354"	1.3 mm .051"	50	168	1650
	2.9 mm .105"	8.8 mm .347"	13	0.112									
	3.0 mm .118"	9.3 mm .366"	15	0.099									
	3.2 mm .126"		20	0.091									
	3.4 mm .135"		22	0.082									
MODEL 3 MAX. .250" [6.35 mm]	4.0 mm .157"	22.5 mm .886"	9	0.078	65°	31.4 mm 1.236"	11.5 mm .453"	33 mm 1.299"	20.2 mm .797"	6 mm .236"	60 *	204	2000
	4.75 mm .187"		26	0.094									
	6.35 mm .250"		28	0.125									

Consume 60% of the insert when bending to prevent insert damage.



* Make sure the tonnage produced is safe with the application and machine. VERY high tonnage could damage the lower beam.

