

V-SERIES BLACK SPECIFICATIONS

Model	Material Thickness inch [mm]	Min. Outside Flange inch [mm]	Ton/FT	Min. Angle	Punch Tip Required to Achieve Angle	Max OR Radius @ Min. Angle inch [mm]	Max OR Radius @ 90° inch [mm]	Tonnage Cap/FT	T/M	kn/M
1	.018 [.45]	.118 [3.0]	1.8	34°	0.054	.125 [3.17]	.175 [4.45]	34	112	1100
	.020 [.50]		1.8		0.052					
	.024 [.60]		2.0		0.047					
	.030 [.80]		2.5		0.042					
	.036 [.90]		3.3		0.036					
	.040 [1.0]	.153 [3.9]	4.0	0.031						
	.048 [1.2]		5.8							
2	.074 [1.9]	.335 [8.5]	7	42°	0.122	.216 [5.5]	.354 [9.0]	50	168	1650
	.105 [2.9]	.347 [8.8]	13		0.112					
	.118 [3.0]	.366 [9.3]	15		0.099					
	.126 [3.2]		20	0.091						
	.135 [3.4]		22	55°	0.082					
3	.157 [4.0]	.886 [22.5]	9	65°	0.078	.453 [11.5]	.500 [12.7]	60	204	2000
	.187 [4.75]		26		0.094					
	.250 [6.35]		28		0.125					

Inserts for Model 1 and 2: HRC 45; Inserts for Model 3: HRC 58-60 Consume 60% of the insert when bending to prevent insert damage.

V OPENING AND SHOULDER RADIUS DIMENSIONS

Model	Shoulder Radius inch [mm]	Desired Angle	Theoretical V Metric	Theoretical V Imperial
1	.040 [1.0]	90°	7.2	0.283
		34°	6.5	0.256
2	.051 [1.3]	90°	13.9	0.547
		42°	13.3	0.524
3	.236 [6.0]	90°	33.0	1.299
		65°	31.4	1.236

