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web jan 26 2022 if the shop is using a v die to make the flange there is a minimum and maximum length that any flange can

be in general the flange needs to be at least 3 though we suggest 4 times longer than the thickness of the material for sheet metal that is 0.120 thick that means a minimum flange length of 0.480 long

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web nov 9 2012 more than one sheet metal bending formula press brake technicians can use various formulas to calculate bend functions for instance in this article we have used the following for outside setback $ossb$ tangent degree of bend angle 2 material thickness inside radius