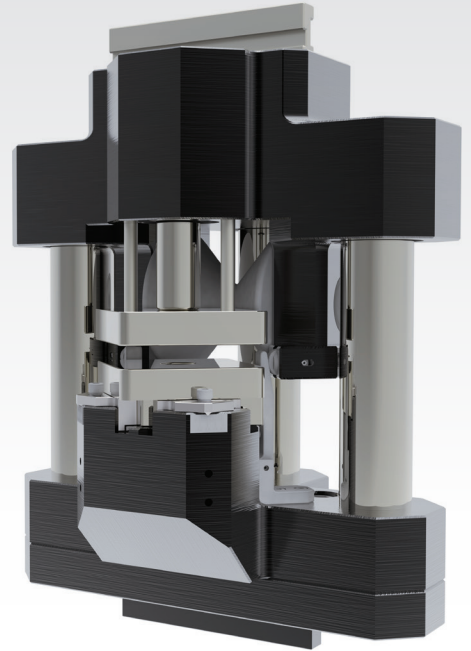
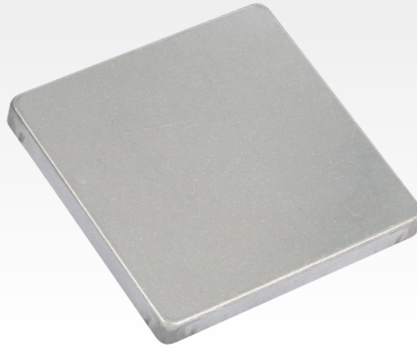
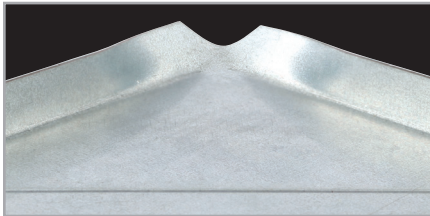


GOING ROUND THE BEND?

To make a four sided tray or door, the sides would traditionally be folded, the corners welded and the joint ground, to produce an acceptable finish. This process is time consuming, costly and requires a certain skill set. The Corner Former from Wilson Tool International allows you to use your existing press brake to bend up the corners, form the corners and then crop the edges to leave a clean, finished look without the need for welding, grinding and finishing.



3 SIMPLE STEPS TO A FINISHED CORNER



Step 1: Bend with Flare

All four corners are bent like any other part except your standard die will have an engineered relief to achieve an intentionally flared bend at the ends.



Step 2: Corner Former

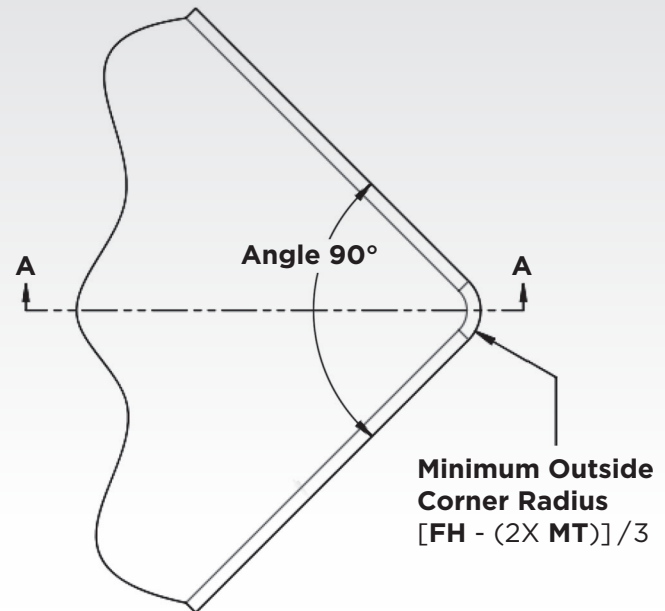
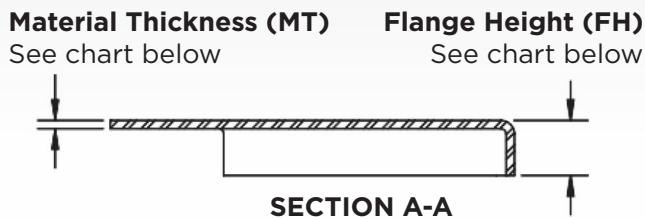
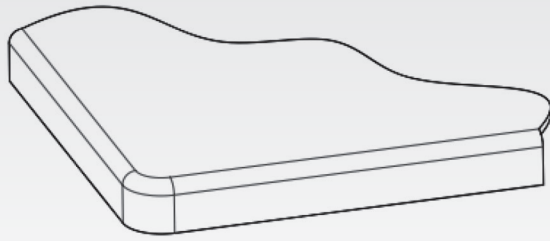
After the engineered flare, the part is moved to the corner forming step to roll the edge. You now have a complete corner with extra material that needs to be trimmed.



Step 3: Corner Cropper/Trim

In a quick and simple one-hit action, the corner cropper cuts the extra material flush to the edges of the tray or door. You have now made your part in one handling with little or no additional post processing needed.

CORNER FORMER APPLICATION GUIDELINES



MATERIAL	THICKNESS (MT)		ANGLE	CORNER OR		BEND OR		FLANGE HEIGHT (FH)	CYCLE TIME PER 4 CORNERS
	MIN	MAX		MIN	MAX	MIN	MAX		
AL (SOFT & 1/2 HARD)	0.5mm	.118 [3]	90° Only	3X MT	25mm	2X MT	15mm	See Chart Below*	Approximately 80 Seconds
MS		.079 [2]							
SS		.059 [1.5]							

Maximum Flange Height by Material Type and Thickness

GAUGE	INCH [MM]	COLD ROLLED		HOT ROLLED		STAINLESS		AL 3003		AL 5052	
		MAX	X MT	MAX	X MT	MAX	X MT	MAX	X MT	MAX	X MT
22	.030 [.76]	.357 [9]	11.9	.394 [10]	13.1	.32 [8]	10.5				
20	.036 [.91]	.48 [12]	13.2	.51 [13]	14.3	.4 [10]	11	.36 [9]	9.9		
18	.048 [1.21]	.7 [17]	14.1	.630 [16]	13.2	.56 [14]	11.6	.63 [16]	13.2	.43 [10.9]	9
16	.060 [1.52]	.828 [21]	13.8	.789 [20]	13.2	.71 [18]	11.9	.79 [20]	13.2	.06 [15.2]	10
14	.074 [1.9]	1.0 [25]	13.2	.9 [24]	12.7			1.01 [25]	13.7	.074 [19.0]	10
13	.090 [2.28]							.984 [25]	11	.90 [22.8]	10
12	.105 [2.66]							.984 [25]	9.4	.95 [23.9]	9
11	.120 [3.04]							.984 [25]	8.2	1.08 [27.4]	9
10	.135 [3.42]									1.22 [30.8]	9

Regardless of material type and thickness, the tool could not form a flange taller than .984 [25].

For more information, visit wilsontool.com/CornerFormer, call our tooling technicians at 800.445.4518 or contact your sales engineer.

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