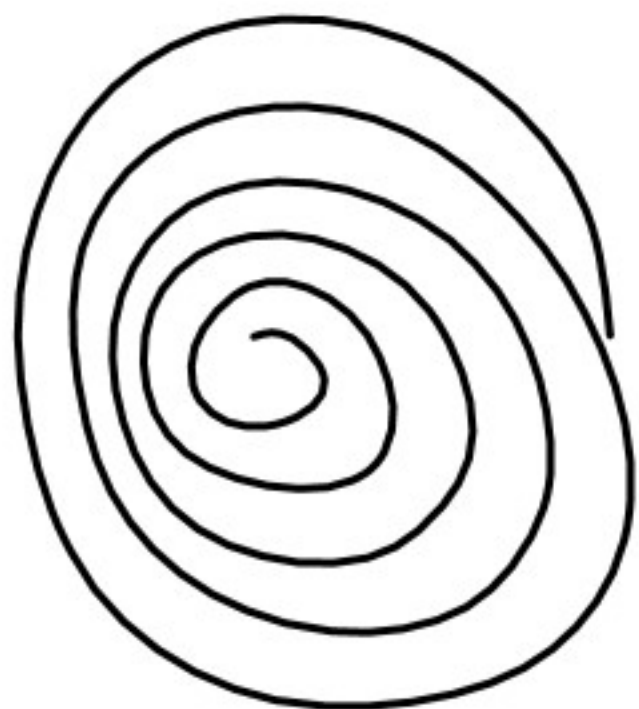


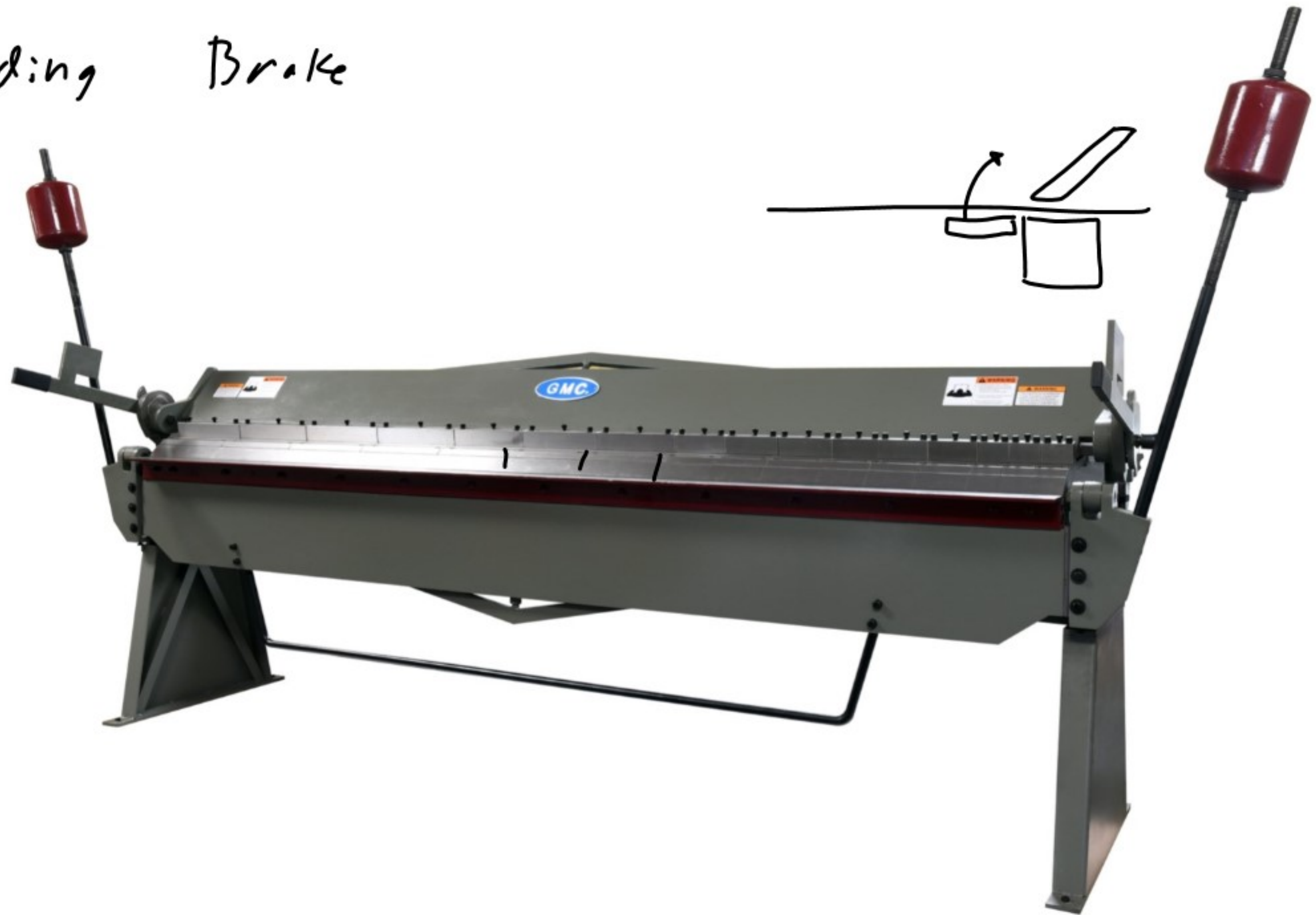
Sheet Metal

YISHANG
OEM ODM

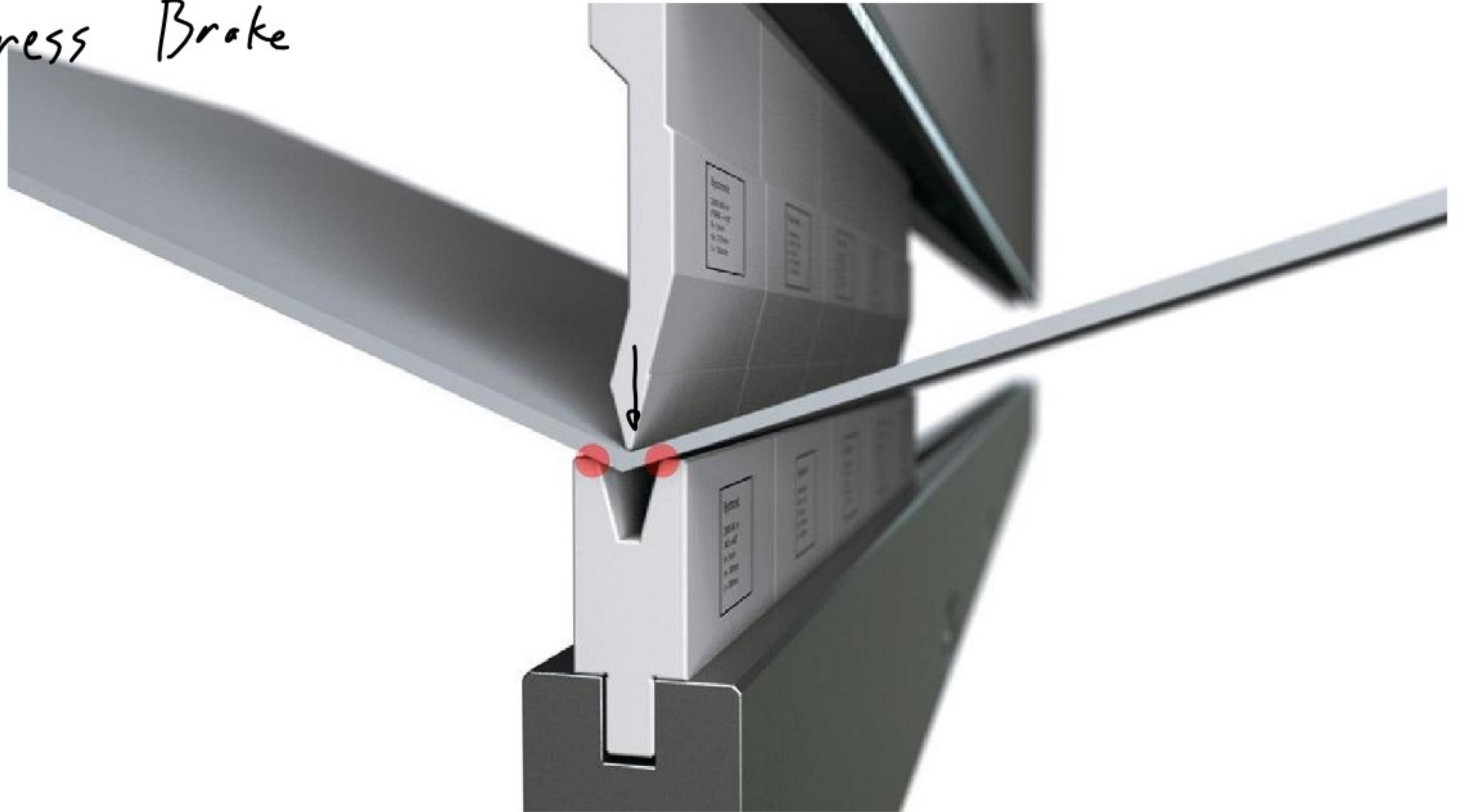




Bending Brake



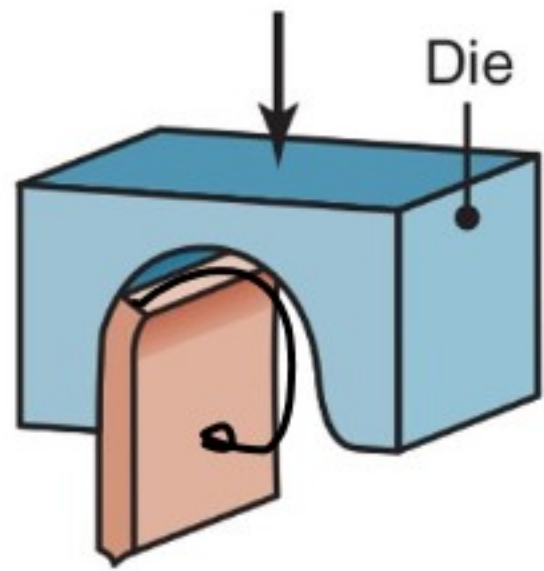
Press Brake



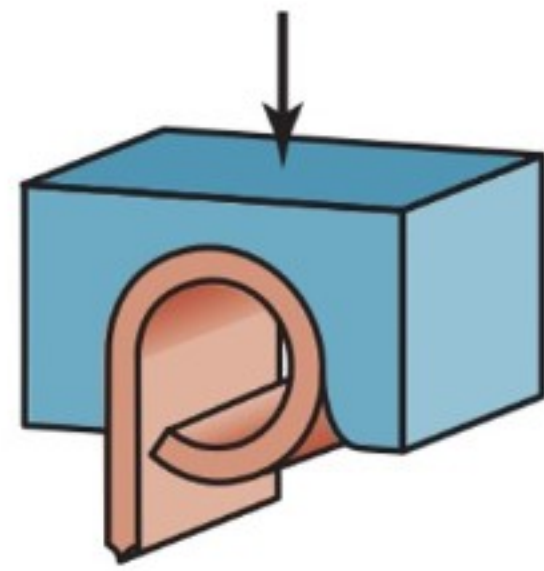


GASPARINI X-PRESS 420



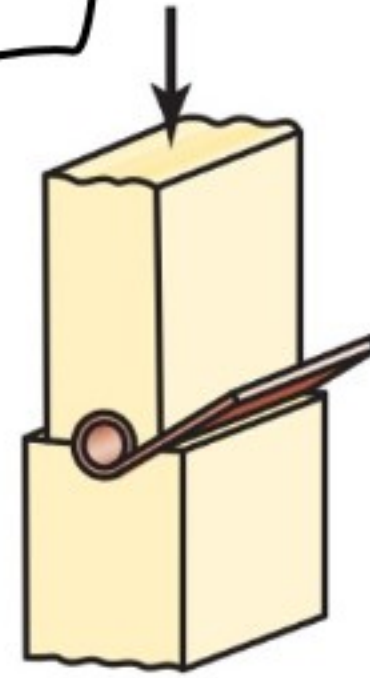
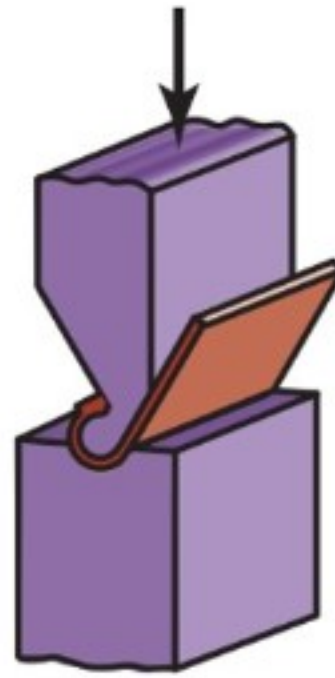


1.



Formed bead

2.



Bend Radius	Condition	
Material	Soft	Hard
Aluminum alloys	0	6T
Beryllium copper	0	4T
Brass (low-leaded)	0	2T
Magnesium	5T	13T
Steels		
Austenitic stainless	0.5T	6T
Low-carbon, low-alloy, and HSLA	0.5T	4T
Titanium	0.7T	3T
Titanium alloys	2.6T	4T

Bending Strain

$$\epsilon = \frac{1}{\frac{2R}{T} + 1}$$

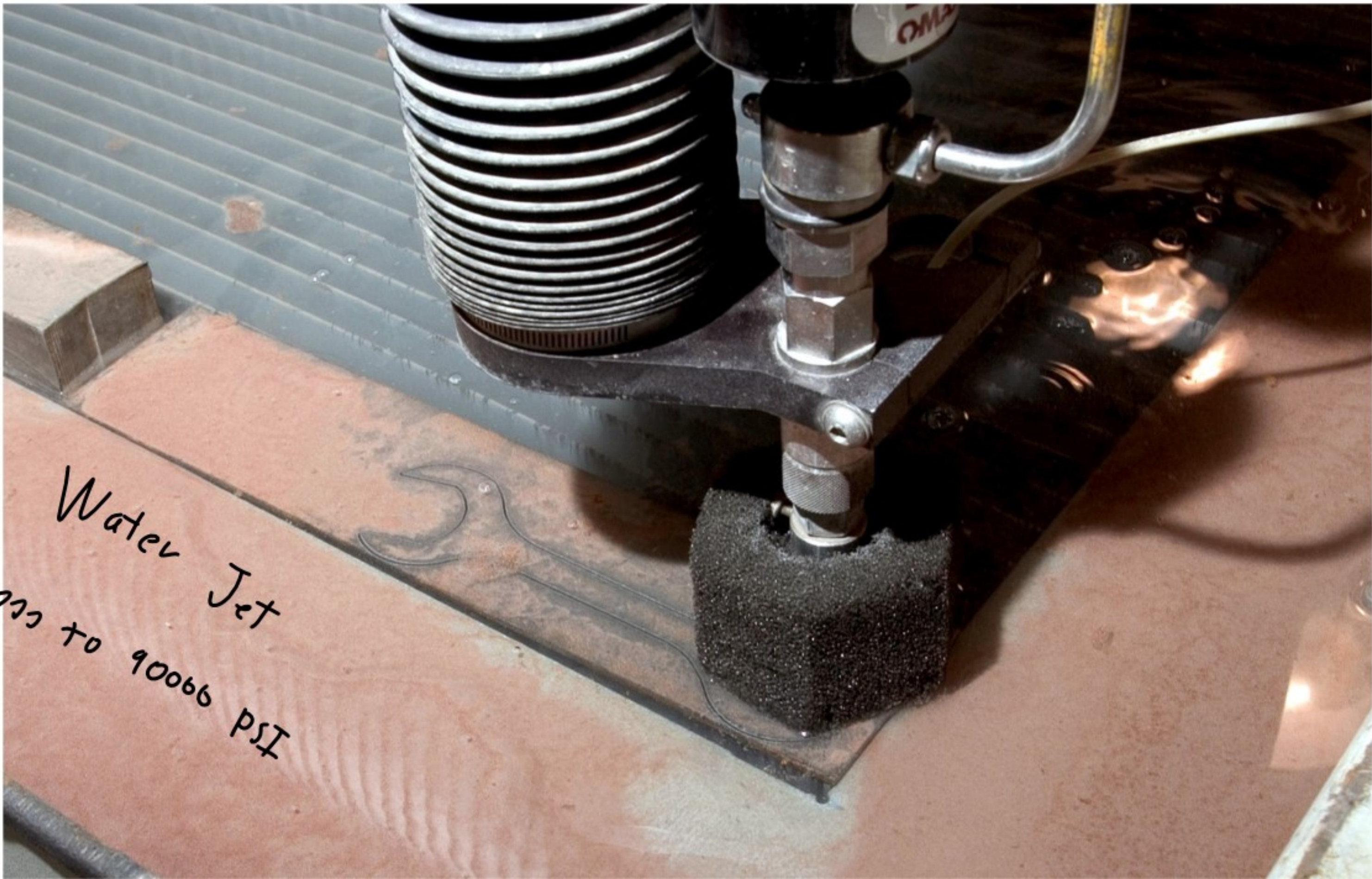
ϵ strain
 R bend radius
 T sheet thickness

Shear



Stamping





Water Jet
50000 to 90000 PSI

Plasma Cutting

25000 °C





Laser Cutting

500 w
4000 w

5mm steel
22 mm

- ▶ Press Brake (https://youtu.be/_hzkGkkoGDI)
- ▶ Press Brake (<https://youtu.be/BodjtkH1htU>)
- ▶ Bending Brake (<https://youtu.be/K-CIZahbY58>)
- ▶ Sheet Metal Stamping (<https://youtu.be/5CuJjSk4U38?t=6>)
- ▶ Water Jet Cutting (<https://youtu.be/3yV-uJHla58?t=1521>)
- ▶ Plasma Cutting (<https://youtu.be/S6QND5GmWpA?t=45>)
- ▶ Laser Cutting (<https://youtu.be/r5vsUta5lmo?t=691>)

