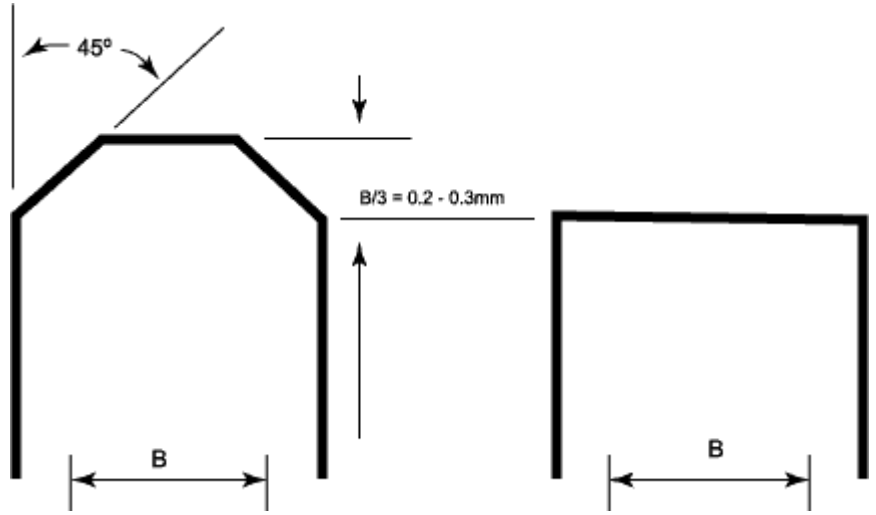
Recommendations for folding

Recommendations for drilling, punching and cutting

CUTTING	Copper-Clad Aluminium (CCA) busbar can be cut using methods that apply to aluminium. Grinding of cut saw to a trapezoidal shape gives good results and deburring is not necessary. Cutting speed: 50-90 m/sec Lubricant and coolant white spirit.
DRILLING	Recommended drill characteristics: Drill cutting angle Cutting speed: 50m/min Cutting tool angle:135º-140 Helix angle: 45º Lubricant and coolant white spirit.
PUNCHING	The punching tool should be designed in the same way as for use with flat copper bars. It is important that the die should give adequate support as near as possible to the shearing edge.



BENDING	N.B. Above factors are for bending normal to the plane. For edge bending the forming tool radius should be multiples of the width w.				
	Recommended radius of forming tool				
	Thickness t	Width w	≤90º	90º-120º	>120º
	t ≤ 3	25 – 10	1t	1t	1t
	3 < t ≤ 5	16 – 60	1t	2t	4t
	5 < t ≤ 6,3	12 – 50	1t	2t	4t
		50 – 120	2t	3t	4t
	6,3 < t ≤ 10	10 – 120	2t	3t	4t
	10 < t ≤ 15	40 – 120	2t	3t	4t