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How to make a right-angle cable tray bend



Overview

The document provides instructions for forming various bends and joints in electrical trunking and cable trays.

Key Takeaways

A right-angle bend in a cable tray can be achieved using pre-fabricated bends, a cable tray bender, or manual bending techniques while ensuring proper preparation and adherence to bend radius guidelines.Pre-Fabricated Bends

The simplest and safest method is to use pre-manufactured 90-degree bends designed for the specific type and size of cable tray. These bends are engineered to maintain structural integrity and proper cable support, reducing the risk of damage during installation .

Manual Bending Techniques

If a pre-fabricated bend is not available, a manual bending method can be used:

• Inspection and Preparation: Check the tray for dents, cracks, or defects and clean it thoroughly to remove dirt or moisture .

• Marking: Measure and mark the exact location and angle of the bend to ensure accuracy.

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• Bending Tools: Use a metal bar or a cable tray bender. A three-point bending method or rolling method can be applied depending on the tray material and thickness .

• Execution: Gradually bend the tray to the desired 90-degree angle, ensuring the bend radius is within manufacturer or industry guidelines to prevent deformation or stress on the tray .

Using a Cable Tray Bender

A cable tray bender is specifically designed for creating smooth, precise bends:

• Available in manual, hydraulic, or electric versions.

• Select a bender appropriate for the tray's material and size.

• Follow the manufacturer's instructions to achieve a consistent 90-degree bend without compromising structural integrity .

Considerations for Bend Radius

• Maintain a minimum bend radius to avoid damaging the tray or cables.

• For ladder-type trays, gradual bends are preferred to reduce stress on cables and maintain proper cable support .

• Wire basket trays may require cutting or removing side wires to form a horizontal bend with the desired radius .

Safety and Best Practices

• Always wear personal protective equipment (PPE) such as gloves, safety goggles, and proper footwear .

• Ensure the tray is supported during bending to prevent accidental collapse or injury.

• Avoid using the tray as a ladder or support for personnel, as this can damage the tray and compromise safety . By following these methods, a right-angle bend can be safely and effectively created in a cable tray, whether using pre-fabricated components or manual bending techniques.

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How to create a 90° gusset bend (45°x2) cable tray

In the above example with 100mm tray you will need need to draw a centre line and mark 40mm on either side (80mm in total) for a

HOW TO BEND 3 V

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Putting a 90 degree bend into Cable Tray

He is going to show you how to use EzyStrut''s ET/ET3/ET5 Radius plate to create a 90

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The system is flexible and field-adaptable to manage cables throughout your project. The

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The first step is to mark out the tray (A). Construction of a flat 90° bend (A) The amount of tray lip to be removed is

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