

How to turn a 90-degree bend in a cable tray



Article Overview

A 90-degree bend in a cable tray can be made by marking, cutting, flattening the tray lips, bending carefully, and reinforcing with a gusset or using a bending machine.

Step-by-Step Method

1. Mark the Tray: Begin by measuring and marking the location where the 90-degree bend is required. Ensure the marks are precise to maintain alignment with the rest of the tray system .
2. Prepare the Tray Lips: For a flat 90-degree bend, remove part of the tray lip. Typically, remove 2/3 of the tray width, split evenly on both sides of the center line. Use a hand grinder or file carefully, wearing protective equipment .
3. Cut the Center Line: Make a cut along the center line of the tray at the bend point. Take care to prevent the tray from opening or deforming during this step .
4. Flatten the Tray Lip: Use a blunt object to flatten the tray lip at the bend point. This ensures the bend will be smooth and reduces stress on the metal .
5. Bend the Tray: Carefully bend the tray to 90 degrees. If using a bending machine, follow the machine's instructions to achieve a precise angle. For manual bending, a metal bar or crimping tool can help control the bend without damaging the tray .
6. Reinforce with a Gusset: Measure the distance between the internal edges of the bend. Cut a piece of tray to this size, remove one lip completely, and bolt it to the bend to reinforce the structure .
7. Alternative Method – Isosceles Triangle Technique: For bridge-style bends, draw perpendicular lines on the side rails, create isosceles triangles with a base length calculated as $L = 2 \times (\text{tray height} \times \sin 22.5^\circ)$, cut them out, and bend the tray to form two 45-degree bends that combine into a 90-degree elbow .
8. Final Assembly:...

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Assembly Guide

The assembly guide below will help the cable tray installer make the bends and others without difficulty even he had never installed

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