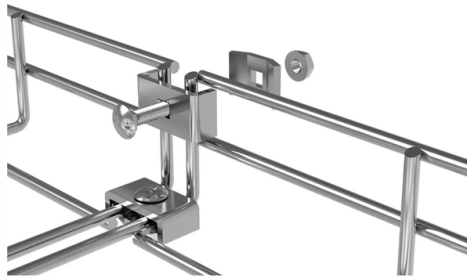


How to make a 90-degree horizontal bend in a cable tray



Overview

Bending Cable Tray You can buy a manufactured 90 degree bend or make one on a cable tray bending machine but in this video I show Make a 90 Bend in Electri.

Key Takeaways

A 90-degree horizontal bend in a cable tray can be achieved using either pre-fabricated horizontal elbows or by fabricating a bend from a straight tray section, ensuring proper bend radius and structural support. Using Pre-Fabricated Horizontal Elbows

Pre-fabricated 90-degree horizontal elbows are available for ladder and I-beam cable tray systems. These fittings are designed to maintain cable organization, support, and ventilation while allowing a smooth directional change. They come in various materials such as galvanized steel, stainless steel, or aluminum, and are compatible with different NEMA classes and tray sizes. Installation typically involves bolting the elbow to the existing tray using splice plates and hardware included with the fitting.

Fabricating a 90-Degree Bend

If a pre-fabricated fitting is not used, a straight tray section can be converted into a 90-degree bend through a mitered or fabricated method:

- **Mark the Center Line:** Determine the bend location and draw a line across the tray base.
- **Cut 45-Degree Angles:** Measure and mark 45-degree cuts on both sides of the center line, corresponding to the tray width.

- **Cut Side Channels:** Cut the tray flanges at the 45-degree angles, stopping at the base.
- **V-Notch the Base:** Remove V-shaped sections from the base to allow the sides to close together.
- **Bend the Tray:** Bend the tray at the center point so the V-cuts close, forming a 90-degree angle.
- **Secure the Joint:** Drill holes through overlapping sides and fasten with bolts, washers, and nuts. Additional bracing or connecting plates may be used for larger trays.
- **Finish the Surface:** Apply cold galvanizing spray to exposed metal to prevent corrosion .

Technical Considerations

- **Bend Radius:** Ensure the internal radius of the bend meets the minimum bend requirement of the cables to prevent damage .
- **Material and Load:** Choose a material and thickness suitable for the cable load and environmental conditions.
- **Ventilation:** Ladder-type trays allow airflow to prevent overheating of cables.
- **Alignment:** Ensure the bend aligns with the overall tray layout to maintain a professional and safe installation. By following these methods, you can achieve a reliable and structurally sound 90-degree horizontal bend in your cable tray system, whether using pre-fabricated fittings or fabricating the bend on-site.

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