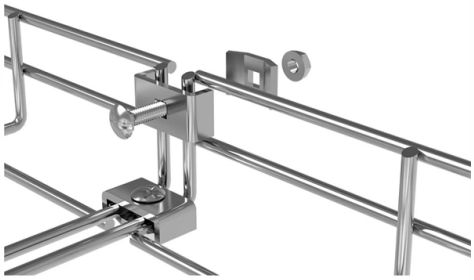
How to make a 90-degree horizontal bend in a cable tray



Overview

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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.

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• 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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