

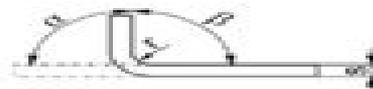
Cold bending DIN 6935 of flat steel products

30 April 2018 15:57

General

This method of calculation applies to bent parts of flat steel products for use in steel construction and in general mechanical engineering. When bending flat rolled steel, such as sheets, strips, wide flat steels, etc. is considered to take the rolling direction, because of better suitability for bending as possible transverse to the rolling direction to be bent.

Bending radius



r bending radius

a bending angle

b opening angle

The bending angle a can be between 0° and 180°.

The Thickness is in the rounding up about 20% lower.

To achieve uniform curves on bending rails, it is recommended that only bending radius be used for bending

to choose from the following series. The bold values are to be preferred.

r	1	1,2	1,6	2	2,5	3	4	5	6	8	10	12	16	20	25	28	32	36	40	45	50	63	80	100
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Table 1 gives the smallest permissible bending radius, which at certain sheet thicknesses and

Materials for the applicable bending machines can be selected. The specified values apply to bending angle $a \in 120^\circ$. For bending angles $a > 120^\circ$ insert the next higher table value.

e.g. would be when bending transverse to the rolling direction of sheets of QSt 42-2 with the thickness $s = 6$

mm the smallest permissible bending radius $r = 10$ mm for $a \in 120^\circ$ and $r = 12$ mm for a $< 120^\circ$.

Table 1: Smallest allowable bending radius r

Stahlsorten mit einer gewährleisteten Mindestzugfestigkeit N/mm ²	beim Biegen quer oder längs zur Walzrichtung	Kleinst zulässiger Bogenhalbmesser r für Dicke s														
		1	Über 1 bis 1,5	Über 1,5 bis 2,5	Über 2,5 bis 3	Über 3 bis 4	Über 4 bis 5	Über 5 bis 6	Über 6 bis 7	Über 7 bis 8	Über 8 bis 10	Über 10 bis 12	Über 12 bis 14	Über 14 bis 16	Über 16 bis 18	Über 18 bis 20
bis 390	quer	1	1,6	2,5	3	5	6	8	10	12	16	20	25	28	36	40
	längs	1	1,6	2,5	3	6	8	10	12	16	20	25	28	32	40	45
Über 390 bis 490	quer	1,2	2	3	4	5	8	10	12	16	20	25	28	32	40	45
	längs	1,2	2	3	4	6	10	12	16	20	25	32	36	40	45	50
Über 490 bis 640	quer	1,6	2,5	4	5	6	8	10	12	16	20	25	32	36	45	50
	längs	1,6	2,5	4	5	8	10	12	16	20	25	32	36	40	50	63

Calculation of the stretched lengths

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