

Cold Bending
of Flat Rolled Steel Products

DIN
6935

Umformung von Flachhergestaltungs aus Stahl

Dimensions in mm

1. General

This Standard applies to bent components made from flat steel products for application in steel construction and general mechanical engineering.

For standards covering flat steel products, see page 4.

When bending flat rolled steel, such as sheets and plates, strips, wide flats etc., the rolling direction should be considered, since bending should if possible be carried out transverse to the rolling direction owing to the greater suitability to bending offered.

The bending suitability of the rolled steel shall be agreed with the manufacturer's works when ordering. To guarantee the bending suitability the rolled surface must be in satisfactory condition and the sheared edges must be straight. Furthermore, in the case of flat rolled steel, sheared edges on the outside of a bend must be deburred at the bending location in order to prevent cracks from spreading from the cut edges.

2. Bending radii



- r Bending radius
- α Bending angle
- β Opening angle

The bending angle α may have any value between 0° and 180° . The thickness s is reduced by up to approx. 20 % in the rounded portion.

To promote uniformity of processing on bending dies it is recommended that only bending radii from the series below should be chosen for bending purposes. The values **indicated in bold type** are preferred.

r	1	1,2	1,6	2	2,5	3	4	5	6	8	10	12	16	20	25	30	32	36	40	45	50	63	80	100
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These bending radii agree with the radiusing according to DIN 250.

Table 1 gives the minimum permissible bending radii which may be chosen for given sheet and plate thicknesses and materials for the bending machines applicable. The indicated values apply to bending angles $\alpha \leq 120^\circ$. For bending angles $\alpha > 120^\circ$ the next higher value in the Table should be used, e.g., 15 or 20 for 10-2 plates with a thickness $s = 0$ mm are to be bent transverse to the rolling direction, the minimum permissible bending radius would be $r = 10$ mm for $\alpha \leq 120^\circ$ and $r = 15$ mm for $\alpha > 120^\circ$.

Table 1. Minimum permissible bending radius r

Steel grades with a guaranteed minimum tensile strength $R_{m, \min}$ in N/mm ²	For bending transverse and parallel to the rolling direction	Minimum permissible bending radius r for thicknesses s																						
		above 0 to 1		above 1 to 2		above 2 to 3		above 3 to 4		above 4 to 5		above 5 to 6		above 6 to 10		above 10 to 15		above 15 to 20						
		1	1,5	2,0	3	4	5	6	7	8	10	12	14	16	20	25	30	32	36	40				
up to 300	transverse	1	1,5	2,5	3	4	5	6	8	10	12	16	20	25	30	32	36	40	45	50	60	80	100	150
	parallel	1	1,5	2,5	3	4	5	6	8	10	12	16	20	25	30	32	36	40	45	50	60	80	100	150
above 300 to 400	transverse	1,5	2	3	4	5	6	8	10	12	16	20	25	30	32	36	40	45	50	60	80	100	150	200
	parallel	1,5	2	3	4	5	6	8	10	12	16	20	25	30	32	36	40	45	50	60	80	100	150	200
above 400 to 640	transverse	1,5	2,5	4	5	6	8	10	12	16	20	25	30	32	36	40	45	50	60	80	100	150	200	300
	parallel	1,5	2,5	4	5	6	8	10	12	16	20	25	30	32	36	40	45	50	60	80	100	150	200	300

Table 2 gives the permissible variations for the minimum bending radii, which must be reckoned with regarding the various sheet and plate thicknesses and materials.

Table 2. Permissible variations for minimum bending radii r

Steel grades with a guaranteed minimum tensile strength $R_{m, \min}$ in N/mm ²	Permissible variations for minimum bending radii r as thicknesses s		
	up to 3	above 3 to 6	above 6 to 20
up to 300	+2%	+2	+1,5
above 300 to 400	+2	+1,5	+2
above 400 to 640	+1	+2	+2

Continued on pages 2 to 4

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