

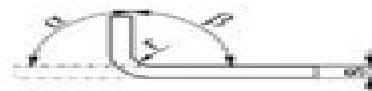
Cold bending DIN 6935 of flat steel products

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

α bending angle

b opening angle

The bending angle α 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
-----	---	-----	-----	---	-----	---	---	---	---	---	----	----	----	----	----	----	----	----	----	----	----	----	----	-----

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 $\alpha \in 120^\circ$. For bending angles $\alpha > 120^\circ$ 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 $\alpha \in 120^\circ$ and $r = 12$ mm for $\alpha < 120^\circ$.

Table 1: Smallest allowable bending radius r

Stahlsorten mit einer gewährleisteten Mindestzugfestigkeit R_{mmin}	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 360	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 360 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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**Bogdan III (voivode of Moldavia), Mihai
Costăchescu**

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Metal Forming Handbook Schuler GmbH, 2012-12-06 Following the long tradition of the Schuler Company the Metal Forming Handbook presents the scientific fundamentals of metal forming technology in a way which is both compact and easily understood Thus this book makes the theory and practice of this field accessible to teaching and practical implementation The first Schuler Metal Forming Handbook was published in 1930 The last edition of 1966 already revised four times was translated into a number of languages and met with resounding approval around the globe Over the last 30 years the field of forming technology has been radically changed by a number of innovations New forming techniques and extended product design possibilities have been developed and introduced This Metal Forming Handbook has been fundamentally revised to take account of these technological changes It is both a text book and a reference work whose initial chapters are concerned to provide a survey of the fundamental processes of forming technology and press design The book then goes on to provide an in depth study of the major fields of sheet metal forming cutting hydroforming and solid forming A large number of relevant calculations offers state of the art solutions in the field of metal forming technology In presenting technical explanations particular emphasis was placed on easily understandable graphic visualization All illustrations and diagrams were compiled using a standardized system of functionally oriented color codes with a view to aiding the reader's understanding

Manufacturing Processes 4 Fritz Klocke, 2014-07-08 This book provides essential information on metal forming utilizing a practical distinction between bulk and sheet metal forming In the field of bulk forming it examines processes of cold warm and hot bulk forming as well as rolling and in addition the process of thixoforming As for the field of sheet metal working on the one hand it deals with sheet metal forming processes deep drawing flange forming stretch drawing metal spinning and bending In terms of special processes the chapters on internal high pressure forming and high rate forming have been revised and refined On the other the book elucidates and presents the state of the art in sheet metal separation processes shearing and fineblanking Furthermore joining by forming has been added to the new edition as a new chapter describing mechanical methods for joining sheet metals The new chapter Basic Principles addresses both sheet metal and bulk forming in addition to metal physics plastomechanics and computational basics these points are complemented by the newly added topics of metallography and analysis materials and processes for testing and tribology and lubrication techniques The chapters are supplemented by an in depth description of modern numeric methods such as the finite element method All chapters have been updated and revised for the new edition and many practical examples from modern manufacturing processes have been added

Iron and steel. Quality standards 1. DIN Deutsches Institut für Normung e. V., 1993

The Magazine of Standards , 1958

Industrial Standardization , 1957

Technisches Zeichnen (39., überarbeitete und aktualisierte Auflage) Prof Dr Andreas Fritz, 2024-02-06 Der Hoischen Fritz bietet einen umfassenden Überblick über normgerechtes technisches Zeichnen darstellende Geometrie konstruktive

Grundlagen und geometrische Produktspezifikation Das regelmäßig neu aufgelegte Standardwerk begleitet seit Jahrzehnten Auszubildende Fortbildungsteilnehmer und Studierende als erprobtes Lehr- und Arbeitsbuch Technikern und Ingenieuren in der Praxis dient es als bewährtes Nachschlagewerk In der 39. Auflage wurde der Inhalt hinsichtlich neuer Normen aktualisiert und erweitert Neue Allgometoleranzen nach ISO 22081 und DIN 2769 neue Oberflächenspezifikation nach ISO 21920 Darstellungsnorm ISO 128 Spezifikation nicht formstabiler Bauteile nach ISO 10579 und Populationsspezifikation nach ISO 18391

Einführung in die DIN-Normen Martin Klein, 2013-07-02 Das Buch führt umfassend in die DIN-Normen und deren Anwendung ein Es gliedert sich nach fertigungstechnischen und funktionalen Gesichtspunkten der Normen bietet detaillierte Informationen und dient als Nachschlagewerk für Studium und Praxis Damit stellt es für die Schwerpunkte Maschinenbau und Elektrotechnik Informationen aus erster Hand bereit ohne die in Konstruktion und Fertigung nicht auszukommen ist Zu zahlreichen Normen werden thematisch zugeordnete Informationen und Hinweisen auf weitere den Stoff vertiefende Normen und Normungsliteratur gegeben und der Kontext zum europäischen und internationalen Normenwerk dargestellt **Klein**

Einführung in die DIN-Normen Martin Klein, 2013-03-09 Im DIN Deutsches Institut für Normung e. V. wird seit seiner Gründung im Jahr 1917 von den an der Normung interessierten Kreisen gemeinschaftlich die Vereinheitlichung von materiellen und immateriellen Gegenständen zum Nutzen der Allgemeinheit durchgeführt Die Ergebnisse dieser Arbeiten werden in Deutschen Normen festgelegt Normen fördern die Rationalisierung in Wirtschaft Technik Wissenschaft und Verwaltung Sie dienen darüber hinaus der Sicherheit von Menschen und Sachen dem Schutz der Umwelt sowie der Qualitätssicherung in allen Bereichen Internationale Normen öffnen der Wirtschaft neue Märkte und Handelshemmnisse werden abgebaut Die Normung ist in der Bundesrepublik Deutschland eine Aufgabe der Selbstverwaltung der an der Normung interessierten Kreise Das DIN ist der runde Tisch an dem sich Hersteller Handel Verbraucher Handwerk Dienstleistungsunternehmen Wissenschaft Staat technische Überwachung Arbeit jeder Mann der ein Interesse an der Normung hat zusammensetzen um geber Gewerkschaften den Stand der Technik zu ermitteln und unter Berücksichtigung neuer Erkenntnisse in Normen nieder der zentrale technische Regelsetzer in Deutschland Ihm obliegt die Aufgabe zuschreiben Das DIN ist die deutschen Interessen in der internationalen und der europäischen Normung zur Geltung zu bringen Die Wirtschaft und der Staat brauchen zur Stärkung des freien Welthandels harmonisierte Normen Magazine of Standards ,1958 **Iron and steel**

DIN Deutsches Institut für Normung e. V., 1993 **DIN Taschenbuch** DIN Deutsches Institut für Normung, 1963 *Aceros Comercial Sidero-Metalúrgica Velasco. Departamento Técnico*, 1968 World Translations Index ,1989 Standardizacija ,1956 **Stahl und Eisen** ,1976 **Feingeräte Technik** ,1952 **VDI-Zeitschrift** Verein Deutscher Ingenieure, 1959

Deutsche Bibliographie ,1967 *Bibliographie der Deutschen Bibliothek* Deutsche Bibliothek (Frankfurt am Main, Germany), 1967 1948 accompanied by Ergänzungsheft 1 2 Neuerscheinungen ausserhalb des Buchhandels **Documentele moldovenesti dela Bogdan voevod (1504-1517)** Bogdan III (voivode of Moldavia), Mihai Costăchescu, 1940

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