

Cold Bending
of Flat Rolled Steel Products

DIN
6935

Kaltbiegen von Flachherzeugnissen 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 redressing on bending dies it is recommended that only bending radii from the series below should be chosen for bending purposes. The values **printed in bold type** are preferred.

r	1	1,2	1,6	2	2,5	3	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100
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These bending radii agree with the redressing 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., if Q 235 A2-B plates with a thickness $s = 6$ 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 $r = 12$ mm for $\alpha > 120^\circ$.

Table 1. Minimum permissible bending radius r

Steel grades with a guaranteed minimum tensile strength $R_{m}/\text{N/mm}^2$	For bending transverse and parallel to the rolling direction	Minimum permissible bending radius r for thicknesses s																			
		above 1 to 1,5		above 1,5 to 2,5		above 2,5 to 4		above 4 to 6		above 6 to 8		above 8 to 10		above 10 to 12		above 12 to 16		above 16 to 20		above 20 to 25	
		1	1,5	2,5	3	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100
up to 300	transverse	1	1,6	2,5	3	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100
	parallel	1	1,6	2,5	3	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100
above 300 to 400	transverse	1,2	2	3	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100	
	parallel	1,2	2	3	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100	
above 400 to 640	transverse	1,6	2,5	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100		
	parallel	1,6	2,5	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100		

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 $R_{m}/\text{N/mm}^2$	Permissible variations for minimum bending radii r at thicknesses s		
	up to 3	above 3 to 6	above 6 to 20
up to 300	+0,5 0	+1 0	+1,5 0
above 300 to 400	+0,5 0	+1,5 0	+2 0
above 400 to 640	+1 0	+2 0	+3 0

Continued on pages 2 to 4

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Normen
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Table of Contents Din 6935 K Factor Chold Hol

1. Understanding the eBook Din 6935 K Factor Chold Hol
 - The Rise of Digital Reading Din 6935 K Factor Chold Hol
 - Advantages of eBooks Over Traditional Books
2. Identifying Din 6935 K Factor Chold Hol
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Din 6935 K Factor Chold Hol
 - User-Friendly Interface
4. Exploring eBook Recommendations from Din 6935 K Factor Chold Hol
 - Personalized Recommendations
 - Din 6935 K Factor Chold Hol User Reviews and Ratings
 - Din 6935 K Factor Chold Hol and Bestseller Lists
5. Accessing Din 6935 K Factor Chold Hol Free and Paid eBooks
 - Din 6935 K Factor Chold Hol Public Domain eBooks

- Din 6935 K Factor Chold Hol eBook Subscription Services
- Din 6935 K Factor Chold Hol Budget-Friendly Options
- 6. Navigating Din 6935 K Factor Chold Hol eBook Formats
 - ePub, PDF, MOBI, and More
 - Din 6935 K Factor Chold Hol Compatibility with Devices
 - Din 6935 K Factor Chold Hol Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Din 6935 K Factor Chold Hol
 - Highlighting and Note-Taking Din 6935 K Factor Chold Hol
 - Interactive Elements Din 6935 K Factor Chold Hol
- 8. Staying Engaged with Din 6935 K Factor Chold Hol
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Din 6935 K Factor Chold Hol
- 9. Balancing eBooks and Physical Books Din 6935 K Factor Chold Hol
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Din 6935 K Factor Chold Hol
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Din 6935 K Factor Chold Hol
 - Setting Reading Goals Din 6935 K Factor Chold Hol
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Din 6935 K Factor Chold Hol
 - Fact-Checking eBook Content of Din 6935 K Factor Chold Hol
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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