

Hart steel bar up to 100x10 mm
with a strength of up to max.
of 370 N/mm²

Biege-Tabelle Bending table

出力需求表

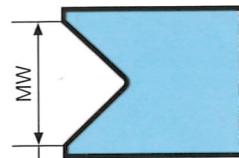
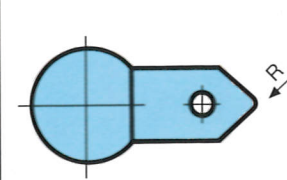
Arbeitskraft in kN bei einer Materialfestigkeit von 420 N/mm²

Force in kN for a material of tensile strength 420 N/mm²

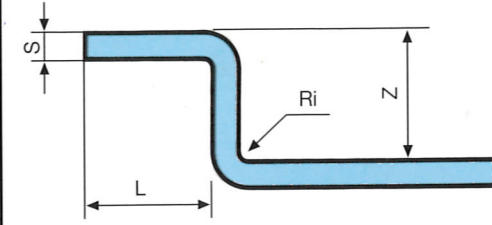
IV
8-10 mm 軟鋼用

Prismaöffnung Vee-block opening	6-8 S	MW 18	MW 30	MW 45	MW 65	MW 85	MW 125	MW 240
Schenkellänge Length of leg	L	12	20	30	40	50	75	150
Kröpfung Offset	Z	13	24	36	50	72	110	250
Material Dimension		Ri ≈ 1	Ri ≈ 4	Ri ≈ 6	Ri ≈ 10	Ri ≈ 12	Ri ≈ 20	Ri ≈ 30
100/3	R = 1	40						
100/4	R = 1	73						
100/5	R = 1		60					
100/6	R = 1		93	63				
100/8	R = 1			121	73	60		
100/10	R = 5				130	75		
100/12	R = 10					147	95	
100/15	R = 10						114	
100/18	R = 10						173	
100/20	R = 10						250	
100/24	R = 10							151
100/30	R = 10							236
100/40	R = 10							398
100/50	R = 10							656

Zeichenerklärung Symbols



Prismaöffnung 6-8 S
Vee-block opening



Bestimmung der Biegedaten für 160/18 Determination of bending data for 160/18

Arbeitskraft = 1,6 x 173 kN
Force

= 277 kN

Biegestempel
Bending punch

R = 10 mm

Prisma
Vee-block

MW = 125 mm

Kleinste Schenkellänge
Minimum leg length

L = 75 mm

Kleinste Kröpfung
Minimum offset

Z = 110 mm

Radius innen
Inside radius

Ri ≈ 20 mm

for 160
x 出力 173 kN
= 277 kN

flat steel bar up to 100x10 mm
with a strength of up to max.
of 370 N/mm²

Biege-Tabelle Bending table

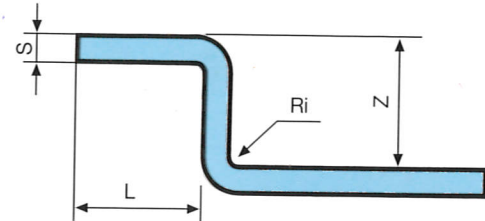
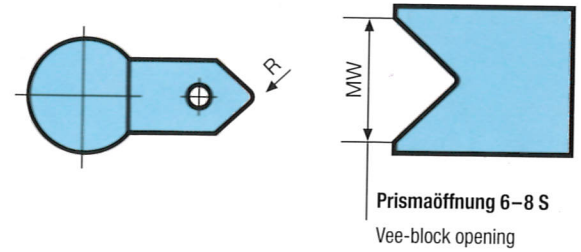
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Force in kN for a material of tensile strength 420 N/mm²

IV
8-10 吨级用

Zeichenerklärung Symbols



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Determination of bending data for 160/18

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全程表内

for W160
x 出力 277 kN
= 277 kN