

**Cold Bending
of Flat Rolled Steel Products**

DIN

6935

Qualitätsen von Flechterschlägen aus Stahl

Dimensions in mm

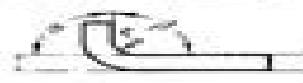
1. General

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 of 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
- > alpha: Bending angle
- > beta: Opening angle

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

For economic uniformity of reducing 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.

=	1	2	3,5	5	7	10	12	15	20	25	30	35	40	45	50	60	70	100
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These bending radii agree with the radii given according to DIN 290.

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 $\alpha \leq 170^\circ$. For bending angles $\alpha > 170^\circ$ the next higher value in the table should be used. e.g. for 0.8-1.2 plates with a thickness $t = 6$ mm one has to turn transverse to the rolling direction, the minimum permissible bending radius would be $R = 70$ mm for $\alpha \leq 170^\circ$ and $R = 12$ mm for $\alpha > 170^\circ$.

Table 1. Minimum permissible bending radius R

Steel grades with a guaranteed minimum tensile strength σ_u [N/mm 2]	For bending transverse and parallel to the rolling direction	Minimum permissible bending radius R for thicknesses t															
		below 1.0				1.0 to 1.5				1.5 to 2.0				2.0 to 2.5			
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
up to 290	transverse	1	1.5	2.5	3	4	5	6	7	8	10	12	14	16	18	20	25
	parallel	1	1.5	2.5	3	4	5	6	7	8	10	12	14	16	18	20	25
above 290 to 490	transverse	1	2	3	4	5	6	7	8	10	12	14	16	18	20	22	30
	parallel	1	2	3	4	5	6	7	8	10	12	14	16	18	20	22	30
above 490 to 640	transverse	1	2.5	4	5	6	7	8	10	12	14	16	18	20	22	25	35
	parallel	1	2.5	4	5	6	7	8	10	12	14	16	18	20	22	25	35

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 σ_u [N/mm 2]	Permissible variations for minimum bending radii R for thicknesses t		
	up to 1.0	above 1.0 to 5	above 5 to 10
up to 290	+ 10%	+ 5%	+ 3%
above 290 to 490	+ 10%	+ 5%	+ 3%
above 490 to 640	+ 5%	+ 3%	+ 2%

Continued on pages 2 to 4

Din6935

Olaf Fritzsche

Din6935:

Technisches Zeichnen ausschuß Zeichnungen im Deutschen Normenausschuß,2013-04-17 **Technisches Zeichnen** DIN Deutsches Institut für Normung e.V.,2013-03-09 *Einführung in die DIN-Normen* Martin Klein,2013-07-02 Das Buch f hrt 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 f r Studium und Praxis Damit stellt es f r 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 europ ischen und internationalen Normenwerk dargestellt *Technisches Zeichnen* (39., überarbeitete und aktualisierte Auflage) Prof Dr Andreas Fritz,2024-02-06 Der Hoischen Fritz bietet einen umfassenden berblick ber normgerechtes technisches Zeichnen darstellende Geometrie konstruktive Grundlagen und geometrische Produktspezifikation Das regelm ig neu aufgelegte Standardwerk begleitet seit Jahrzehnten Auszubildende Fortbildungsteilnehmer und Studierende als erprobtes Lehr und Arbeitsbuch Technikern und Ingenieuren in der Praxis dient es als bew hrtes Nachschlagewerk In der 39 Aufage wurde der Inhalt hinsichtlich neuer Normen aktualisiert und erweitert Neue Allgemeintoleranzen nach ISO 22081 und DIN 2769 neue Oberf chenspezifikation nach ISO 21920 Darstellungsnorm ISO 128 Spezifikation nicht formstabiler Bauteile nach ISO 10579 und Populationsspezifikation nach ISO 18391 *Einführung in die Fertigungstechnik* Ralf Förster,Anna Förster,2018-09-12 Dieses Lehrbuch f hrt Studierende ohne Grundpraktikum in der Industrie in die Grundlagen der Studieng nge Maschinenbau und Wirtschaftsingener Maschinenbau ein Es vermittelt das technische Vorgehen in der industriellen Fertigung sowie die Anwendung und Benennung der in der industriellen Praxis eingesetzten Techniken und Werkzeuge Dabei weisen die Autoren auch auf Fehlerm glichkeiten im Fertigungsprozess hin Das Buch ersetzt nicht die Standardlehrb cher der Fertigungstechnik vielmehr schlie t es die L cke zwischen der schulischen Ausbildung und einem technischen Studium und erleichtert Studierenden somit den bergang von der Schule an die Hochschule Studierende lernen die technische Fachsprache das Vokabular welches f r den Umgang mit den Technologien und mit Mitarbeitern im Betrieb ben tigt wird Angehenden Facharbeiter Technikern und Meistern bietet dieses Buch ebenfalls einen Einstieg in die Fertigungstechnik und ihre Fachterminologie **Blechumformung** Klaus Siegert,2015-04-30 Das Lehr und Fachbuch f hrt in die Grundlagen der Blechumformung ein und erl utert wie entsprechende Verfahren in die industrielle Fertigung integriert werden Ausgew hlte Verfahren wie z B das Falzen und Feinschneiden werden vergleichend dargestellt Als weitere Themen behandeln die Experten die Vorherbestimmbarkeit finaler Produkteigenschaften die Steigerung der Produktivit t und die Reduzierung der Fertigungskosten Dabei werden Prozesse diskutiert die bei sich ndernden Produkteingangsparametern f r eine konstante Produktg te sorgen **Grundlagen der Konstruktion** Werner Krause,2018-02-12 Konstruktion Das Grundlagen und

Nachschlagewerk mit dem sagenhaften Preis Leitungsverh ltnis Das Buch vermittelt Studenten an Universit ten Hoch und Fachschulen die Grundlagen der Konstruktion von Produkten der Elektronik Elektrotechnik Feinwerktechnik und Mechatronik F r den Ingenieur ist es wegen der katalogartigen und reich illustrierten Darstellung ein hervorragendes Nachschlagewerk in der Praxis Das Buch enth lt Gestaltungsgrunds tze inklusive Toleranzen und Passungen Festigkeitslehre Festigkeitsnachweise Werkstoffkenngr en Elektrische Leitungsverbindungen Maschinenelemente wie Federn Achsen und Wellen Lager F hrungen Kupplungen Getriebe In einem Anhang zum Technischen Zeichnen werden die wichtigsten Richtlinien und Regeln zum Anfertigen von technischen Zeichnungen wie der Aufbau eines Zeichnungssatzes das Darstellen von K rpern die Ausf hrung von Einzelteilzeichnungen Schnittdarstellungen Grunds tze der Bema ung und die Gestaltung besonderer Elemente erl utert Dar ber hinaus werden der Aufbau und die zeichnerische Ausf hrung von Stromlaufpl nen sowie die Kennzeichnung wichtiger elektronischer Bauelemente gezeigt In der Neuauflage wurden alle Normen dem aktuellen Stand angepasst so u a zur Kennzeichnung der Oberfl chenrauheit zu Toleranzen und Passungen sowie zu Stirnradgetrieben der Feinwerktechnik

Leitfaden der DIN — Normen Klaus Günter Krieg,Wedo Heller,Gunter

Hunecke,2013-07-02 **Stampi e lavorazione della lamiera** Vittorio Ariosi,Claudio Marzi,1987 **Der Praktiker**,1982

Maschinenelemente 1 Gustav Niemann,Hans Winter,Bernd-Robert Höhn,Karsten Stahl,2019-09-23 In ihrem Buch Maschinenelemente Band 1 Konstruktion und Berechnung von Verbindungen Lagern Wellen bieten die Autoren Niemann Winter H hn und Stahl einen optimalen Gesamt berblick sowie umfassende Detailinformation zu allen relevanten Themen auf dem Gebiet der Maschinenelemente Arbeitsmethoden in der Maschinenkonstruktion Gestaltung und Formgebung Praktische Festigkeitsberechnung Leichtbau Werkstoffe W rmbehandlung und Oberfl chenbehandlung Allgemeines ber Normen Toleranzen Passungen und Oberfl chen Schwei verbindungen L t Kleb und kombinierte Maschinenverbindungen Nietverbindungen sowie Durchsetzf ge und Blechform Verbindungen Schraubenverbindungen und Gewinde Stift und Bolzenverbindungen Elastische Federn W lzpaarungen Maschinengelenke W lzlagerringe und Gleitlager Schmierung Schmierstoffe Reibung Verschleid und Korrosion Achsen und Wellen in Maschinen Welle Nabe Verbindungen Dichtverbindungen Das Maschinenelemente Buch eignet sich dank seines klaren Aufbaus zahlreichen anschaulichen Beispielen zu allen Berechnungen sowie einer umfangreichen Literaturliste optimal als a Lehrbuch f r Studenten aus dem Bereich Maschinenbau b Arbeitsbuch f r Konstrukteure und Entwickler Es gilt heute als Standardwerk und echter Klassiker f r das Fach Maschinenelemente Entdecken Sie das Lehrbuch Maschinenbau hier in 5 bearbeiteter und aktualisierter Auflage Alle Kapitel der 5 bearbeiteten Auflage des dreib ndigen Werks Maschinenelemente wurden auf den neuesten Stand der Technik gebracht Im Zuge der berarbeitung des Maschinenelemente Buchs haben die Autoren ebenfalls zahlreiche Gleichungen Diagramme und Beispielrechnungen korrigiert Somit ist sichergestellt dass Ingenieure und Mechaniker damit in der Praxis stets verl ssliche Berechnungen durchf hren Dar ber hinaus veranschaulichen rund 758 Abbildungen den Inhalt

optimal Hierdurch fungiert das Lehrbuch Maschinenelemente ebenfalls als wertvolles Nachschlagewerk f r Konstrukteure

Industrie-Anzeiger ,1969 Untersuchungen über das V-Biegen von Blechen Gerhard Oehler,2013-04-17 Bei der Bearbeitung von Blechen kommt dem V Biegen unter den Umform verfahren eine besondere Bedeutung zu worunter das Biegen von V formigem Profil mittels eines zwischen den Gesenkauflagen mit seiner Spitze auftreffenden Stempels verstanden wird im Gegensatz zum U Biegen Z Biegen und anderen Biegeprofilformen Daher ist die Kenntnis des Biegevorganges und der dabei auf trenden Gefugeveranderungen im Werkstuck fur die zulassige Beanspruchung wichtig zumal hierbei sowohl das Blech mitunter Formanderungen und somit Verfestigungen bis zur Kaltbruchigkeit erleidet als auch GroBe und Richtung der auftretenden Kriifte den Bau der Biegemaschine bestimmen In den folgenden Abschnitten werden einzelne Teilgebiete aus dem Arbeitsbereich des V Biegens naher untersucht 7 1 Ermittlung der Biegekraft des Riickfederungsverhaltens und des geringstuHissigen n so Verhältnisses beim Kaltbiegen Von verschiedenen technischen Oberwachungsbehorden und Klassifikations gesellschaften ist flir das Kaltbiegen eine hochstzulassige Blechdicke unabhängig von der Krümmung vorgeschrieben Urn die Haltlosigkeit einer solchen Vorschrift nachzuweisen ist es erforderlich an verschiedenen Blechen unterschiedlicher Dicke und Biegekrümmung also unterschiedlichen ri so Verhältnissen die Grenze zu finden bis zu welcher eine Anderung des Ursprungsgefuges überhaupt nicht eintritt d h daB im engsten Bereich der Krümmung an der Innenfaser weder ein gestauchtes noch an der Außenfaser ein gestrecktes Gefuge wahrzunehmen ist 1 1 Versuchsgruppe 1 Zunachst wurde ein 15 mm dickes Festigkeits Stahlblech St 37 untersucht das in einem V Biege Gesenk einer Auflagenweite w 90 mm mittels einer Frei biegestempelschiene einer unteren Rundung von r 10 mm gebogen wurde **Kalt- und Warm-Biegen von plattierte Groblechen im U-Gesenk** Max Vater,2013-03-09

Iron and steel DIN Deutsches Institut für Normung e. V.,1993 **Manuale di lavorazione della lamiera** R. Suzzani,2004 **DIN Taschenbuch** DIN Deutsches Institut für Normung,1963 **Technologische Betrachtung zur Vorgehensweise der Fertigung eines Fahrzeugquerstabilisators** Olaf Fritzsche,2012-04-10 Studienarbeit aus dem Jahr 2010 im Fachbereich Ingenieurwissenschaften Fahrzeugtechnik Note 1 3 Richard Hartmann Schule Berufliches Schulzentrum f r Technik III Sprache Deutsch Abstract In dieser Technikerarbeit wird auf die Vorgehensweise der Fertigung eines Fahrzeugquerstabilisators eingegangen welcher unter Abhandlung technologischer und wirtschaftlicher Aspekte gefertigt werden soll Ziel dieser Arbeit ist die technologische Betrachtung zur Vorgehensweise der Fertigung eines Fahrzeugquerstabilisators unter Berücksichtigung verschiedener Fertigungsverfahren Es gilt einen f r das Werkst ck geeigneten Werkstoff auszuwählen sowie die aus technologischer und aus wirtschaftlicher Sicht günstigste Fertigungsvariante anhand der Vorgaben zu ermitteln Im Rahmen der Untersuchung werden die f r die Fertigung erforderlichen Verfahren ausgewählt analysiert und ausgewertet Bezugnehmend auf die durchzuf hrenden Analysen und Auswertungen werden Hinweise zur Auswahl geeigneter Werkzeugmaschinen und Vorrichtungen gegeben sowie erforderliche Voraussetzungen

genannt *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 fordern die Rationalisierung in Wirtschaft, Technik, Wissenschaft und Verwaltung. Sie dienen darüber hinaus der Sicherheit von Menschen und Sachen, dem Schutz der Umwelt sowie der Qualitäts sicherung in allen Bereichen. Internationale Normen öffnen der Wirtschaft neue Märkte und Handelschancen. Mängel 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 Berwachung, Arbeit und jedermann der ein Interesse an der Normung hat zusammensetzen um geber Gewerkschaften den Stand der Technik zu ermitteln und unter Berücksichtigung neuer Erkenntnisse in Normen niedergeschrieben zu schreiben. 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.

Fertigungsverfahren Wilfried König, 2013-03-14 Das Buch behandelt im einzelnen die Verfahren Tiefziehen, Kragenziehen, Streckziehen, Drücken, Biegen und Schwenkbiegen mit Verfahrensprinzip, Verfahrensvarianten, Formänderungen, Prozessarten und Fertigungsbeispiele. Es schließt sich eine Beschreibung von Sonderverfahren der Blechumformung an die sich mit den Verfahren Innenhochdruckumformung, Superplastisches Umformen, Formgebung mit dem Laser und der schnellen magnetischen Umformung befassen. Weitere Themen: Trennen, Verfahren des konventionellen Schneidens, Genauschneidverfahren, Feinschneiden, Laserstrahlschneiden, Wasserabrasivstrahlschneiden.

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