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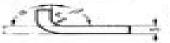
This Standard applies to bent components made from flat steel products for application in steel construction and general mechanical engineering.

For standards covering flat steel products, see page 4.

When bending flat rolled steel, such as sheets and plates, strips, wide flats sto., the rolling direction should be considered, since tending should if possible be carried out transsers 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 debursed at the bending location in order to prevent cracks from aprecing from the cut edges.

Respecting worth.



r Bending radius . Bending made Counting saging

The bending angle a may have any value be-tween 0° and 180°. The thickness is reduced by up to approx. 20 % in the rounded portion

To promote uniformity of radiusing on bending dies it is recommended that only bending radii from the series below should be chosen for bending purposes. The values printed in hold type same productions.

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	- 48	100	10,20	The state of	100	The second	 		Annual Control			Section 1				Contract of	The second	The second			The same of	and the second	the second	A company of the
100	- 31	- 1	10.00	10.00	- 2	25, 25, 1	 	100	160	181	1000	1.20	10.00	2000	200.00	1000	30.00	2000	44.00	1.00	1 15-45	186-29	PROPERTY.	4 TOTAL P
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These bending radii agree with the radiusing according to SES 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 a 120° the ment higher value in the Table should be used, e.g., if Q 34 82-2 plates with a thickness s - 6 mm are to be bent transverse to the rolling direction, the minimum permissible bending radius would be real and r - 12 mm for s > 120°.

Table 1. Hipiana permissible bending radius r

Steel grades	Door beautiting	Minimum permissible beading radius o for thicknesses a phorephore phorephore phorephore phorephore phore phore phore phore phore phore processes														
Section 18 has been been presented	to the mak- ing direction	1	1.5	2.5	100	7	*	2	4	-	5e 20	10	10 To	3.6	10	5.84 260
up to 380	Armareren	1	11,46	2.5	3.0	15	- 6	- 8	1.0	1.35	1.6	200	25	218	3-6	440
way to also	perchial	3	21,46	42.56	- 3	- 66	- 5	10	12	3.6	2010	255	28	3/2	4.0	-4.5
and the second second second	SPANNERSON.	31.30	2	3	4	- 6	. 19	10	3.2	3.6	20	225	2.8	3/2	4.0	4.5
above 390 to 490	perchibet	31,30		35	- 4	- 6	1.0	1.2	3.6	2.0	2.5	3/2	346	4/0	4.5	5900
and the second second second second	transverse	2.6	21.5		- 5	- 6	- 8	1.0	1.2	3.6	200	2.6	3.0	29-6	4.5	5-0
Marrie 450 to 640	perelitat	31,45	20,00	4	1.5	1.8	1.0	11.2	3.46	90	25	3.0	346	4/0	5-0	6535

Table 2 gives the permissible variations for the minimum bending radii, which must be reck-oned with regarding the various sheet and plate thicknesses and natorials.

Table 2. Permissible variations for minimum bending radii r

Steel grades with a guaranteed minimum temelia atrength	Permissible variations for minimum bending rods; r at thirknesses a								
N/mm²	No. 54 3	above 3 to 8	Above 8 to 20						
12 to 390	10,5		* 1.4						
share 390 to 490	* 0, 8	- 5.4	**						
share 490 to 640	• 1	**							

Continued on paper 2 to 4

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