

Cold Bending
of Flat Rolled Steel Products

DIN
6935

Kaltbiegen von Flachhergesteigtem 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	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100	
	parallel	1	1,6	2,5	3	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	6	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	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

No guarantee can be given in respect of this translation

in all cases the latest German language version of the standard shall be taken as authority

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Technischer Redakteur
Hans G. Franke, Berlin

Din6935

Xiaolong Qi



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Technisches Zeichnen ausschluß 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 Auflage 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 Wirtschaftsingenieur 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 Fehlermöglichkeiten 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 Facharbeitern 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 Produktivität 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 Leitungsverhältnisse Das Buch vermittelt Studenten an Universitäten Hoch- und Fachschulen die Grundlagen der Konstruktion von Produkten der Elektronik Elektrotechnik Feinwerktechnik und Mechatronik Für den Ingenieur ist es wegen der katalogartigen und reich illustrierten Darstellung ein hervorragendes Nachschlagewerk in der Praxis Das Buch enthält Gestaltungsgrundsätze inklusive Toleranzen und Passungen Festigkeitslehre Festigkeitsnachweise Werkstoffkenngrößen Elektrische Leitungsverbindungen Maschinenelemente wie Federn Achsen und Wellen Lager Führungen 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 Körpern die Ausführung von Einzelteilzeichnungen Schnittdarstellungen Grundsätze der Bemaßung und die Gestaltung besonderer Elemente erläutert Darüber hinaus werden der Aufbau und die zeichnerische Ausführung von Stromlaufplänen sowie die Kennzeichnung wichtiger elektronischer Bauelemente gezeigt In der Neuauflage wurden alle Normen dem aktuellen Stand angepasst so auch zur Kennzeichnung der Oberflächenrauheit 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 Höhn und Stahl einen optimalen Gesamtüberblick sowie umfassende Detailinformation zu allen relevanten Themen auf dem Gebiet der Maschinenelemente Arbeitsmethoden in der Maschinenkonstruktion Gestaltung und Formgebung Praktische Festigkeitsberechnung Leichtbau Werkstoffe Wärmebehandlung und Oberflächenbehandlung Allgemeines über Normen Toleranzen Passungen und Oberflächen Schweißverbindungen Löt- und kombinierte Maschinenverbindungen Nietverbindungen sowie Durchsetzflange und Blechformverbindungen Schraubenverbindungen und Gewinde Stift- und Bolzenverbindungen Elastische Federn Wälzpaarungen Maschinenlager Wälzlager und Gleitlager Schmierung Schmierstoffe Reibung Verschleiß 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 Lehrbuch für Studenten aus dem Bereich Maschinenbau als Arbeitsbuch für Konstrukteure und Entwickler Es gilt heute als Standardwerk und echter Klassiker für das Fach Maschinenelemente Entdecken Sie das Lehrbuch Maschinenbau hier in 5 bearbeiteter und aktualisierter Auflage Alle Kapitel der 5 bearbeiteten Auflage des dreibändigen Werks Maschinenelemente wurden auf den neuesten Stand der Technik gebracht Im Zuge der Bearbeitung 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 verlässliche Berechnungen durchführen können Darüber hinaus veranschaulichen rund 758 Abbildungen den Inhalt

optimal Hierdurch fungiert das Lehrbuch Maschinenelemente ebenfalls als wertvolles Nachschlagewerk für 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 Umformverfahren eine besondere Bedeutung zu worunter das Biegen von V formigem Profil mittels eines zwischen den Gesenkaufgaben 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 tretenden Gefügeveränderungen im Werkstück für die zulässige Beanspruchung wichtig zumal hierbei sowohl das Blech mitunter Formänderungen und somit Verfestigungen bis zur Kaltbruchigkeit erleidet als auch Größe und Richtung der auftretenden Krieffe den Bau der Biegemaschine bestimmen In den folgenden Abschnitten werden einzelne Teilgebiete aus dem Arbeitsbereich des V Biegens näher untersucht 7 1 Ermittlung der Biegekraft des Rückfederungsverhaltens und des geringstzulässigen Verhältnisses beim Kaltbiegen Von verschiedenen technischen Überwachungsbehörden und Klassifikationsgesellschaften ist für das Kaltbiegen eine höchstzulässige Blechdicke unabhängig von der Krümmung vorgeschrieben Um die Haltlosigkeit einer solchen Vorschrift nachzuweisen ist es erforderlich an verschiedenen Blechen unterschiedlicher Dicke und Biegekrümmung also unterschiedlichen Verhältnissen die Grenze zu finden bis zu welcher eine Änderung des Ursprungsgefüges überhaupt nicht eintritt d h daß im engsten Bereich der Krümmung an der Innenfaser weder ein gestauchtes noch an der Außenfaser ein gestrecktes Gefüge wahrzunehmen ist 1 1 Versuchsgruppe 1 Zunächst wurde ein 15 mm dickes Festigkeits Stahlblech St 37 untersucht das in einem V Biege Gesenk einer Auflagenweite $w = 90$ mm mittels einer Freibiegestempelschiene einer unteren Rundung von $r = 10$ mm gebogen wurde

Kalt- und Warm-Biegen von plattierten Grobblechen 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 für 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 für das Werkstück geeigneten Werkstoff auszuwählen sowie die aus technologischer und aus wirtschaftlicher Sicht günstigste Fertigungsverfahren anhand der Vorgaben zu ermitteln Im Rahmen der Untersuchung werden die für die Fertigung erforderlichen Verfahren ausgewählt analysiert und ausgewertet Bezugnehmend auf die durchzuführenden 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 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, 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.

Fertigungsverfahren Wilfried König, 2013-03-14 Das Buch behandelt im einzelnen die Verfahren: Tiefziehen, Kragenziehen, Streckziehen, Drücken, Biegen und Schwenkbiegen mit Verfahrensprinzip, Verfahrensvarianten, Formänderungen, Prozeduren 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, Wasser-Abrasivstrahlschneiden.

Reviewing **Din6935**: Unlocking the Spellbinding Force of Linguistics

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