

Cold Bending  
of Flat Rolled Steel Products

DIN  
6935

Kaltbiegen von Flachherzeugnissen aus Stahl

Dimensions in mm

1 General

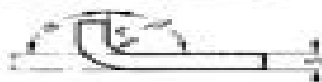
This standard applies to bent components made from flat steel products for application in steel construction and general mechanical engineering.

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  
 $\alpha$  Bending angle  
 $\beta$  Opening angle

The bending angle  $\alpha$  may have any value between  $0^\circ$  and  $180^\circ$ . 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 $R_{m, \min}$ in N/mm <sup>2</sup>	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 $R_{m, \min}$ in N/mm <sup>2</sup>	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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