

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
 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	4	5	6	8	10	12	16	20	25	32	40	45	50	63	80	100
	parallel	1	1,6	2,5	3	4	5	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	5	6	8	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	6	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

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Verfahrenstechnische Normen
DIN 6935

Din6935

Gerhard Oehler



Din6935:

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 Siebert,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
 Leitungsverh ltnis Das Buch vermittelt Studenten an Universit ten Hoch und Fachschulen die Grundlagen der Konstruktion
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 katalogartigen und reich illustrierten Darstellg 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 rmebehandlung 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 Maschinenlager W lzlager und Gleitlager Schmierung Schmierstoffe Reibung Verschlei 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
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 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 hrenk nnen Dar

ber 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 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 auftretenden 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 n so 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 n so 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 Überwachungsarbeit, 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 nieder der zentrale technische Regelsetzer in Deutschland. Ihm obliegt die Aufgabe, 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, Prozkripten 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.

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Table of Contents Din6935

1. Understanding the eBook Din6935
 - The Rise of Digital Reading Din6935
 - Advantages of eBooks Over Traditional Books
2. Identifying Din6935
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Din6935
 - User-Friendly Interface
4. Exploring eBook Recommendations from Din6935
 - Personalized Recommendations
 - Din6935 User Reviews and Ratings
 - Din6935 and Bestseller Lists
5. Accessing Din6935 Free and Paid eBooks

- Din6935 Public Domain eBooks
- Din6935 eBook Subscription Services
- Din6935 Budget-Friendly Options
- 6. Navigating Din6935 eBook Formats
 - ePub, PDF, MOBI, and More
 - Din6935 Compatibility with Devices
 - Din6935 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Din6935
 - Highlighting and Note-Taking Din6935
 - Interactive Elements Din6935
- 8. Staying Engaged with Din6935
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Din6935
- 9. Balancing eBooks and Physical Books Din6935
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Din6935
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Din6935
 - Setting Reading Goals Din6935
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Din6935
 - Fact-Checking eBook Content of Din6935
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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