

HAEUSLER 4-ROLL PLATE BENDING MACHINE 6000x50T

(with 2 spare rolls)



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HAEUSLER
the forming factory



Hydraulic 4-Roller Plate Bending Machine

Technical Documentation

WO 132-N-006

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Duggingen, 23/05/2013

Dear Sirs

Best regards

Enclosures / Anlagen:

- 3 copies

File 1/1: Technical Documentation

VRM - CAPACITY CHART

VRM-hy 6000x45

TOP ROLLER Ø 500 MM

Yield point 240 N/mm²

6-10020-140025

PREBENDING

Plate width (Bmax) and edge setting factors (k) versus bending diameter (D) and plate thickness (S).

D =		580	600	700	800	900	1000	1200	1400	1600
S	17	Bmax= 1400	1450	1650	1830	1990	2140	2400	2620	2810
		K= 2.36	2.42	2.69	2.84	3.15	3.35	3.68	3.95	4.18
16	Bmax= 1610	1660	1890	2100	2290	2460	2760	3030	3250	3450
		K= 2.51	2.57	2.86	3.12	3.35	3.56	3.91	4.20	4.45
15	Bmax= 1860	1920	2190	2430	2660	2860	3220	3540	3810	4040
		K= 2.67	2.74	3.06	3.33	3.58	3.79	4.17	4.48	4.74
14	Bmax= 2180	2250	2570	2860	3130	3380	3820	4210	4550	4840
		K= 2.87	2.94	3.28	3.57	3.83	4.07	4.47	4.80	5.08
13	Bmax= 2500	2590	3070	3430	3760	4070	4630	5130	5580	5980
		K= 3.09	3.17	3.53	3.85	4.13	4.38	4.82	5.17	5.48
12	Bmax= 2830	2930	3540	4000	4480	4940	5600	6200	6750	7250
		K= 3.35	3.43	3.83	4.17	4.48	4.75	5.22	5.61	5.93
11	Bmax= 3160	3270	4000	4550	5030	5490	6260	6900	7500	8050
		K= 3.65	3.75	4.18	4.55	4.89	5.19	5.70	6.13	6.50
10	Bmax= 3500	3620	4500	5150	5630	6090	7000	7700	8350	8950
		K= 4.02	4.12	4.51	4.88	5.23	5.54	6.09	6.56	6.98
9	Bmax= 3850	4000	5000	5750	6230	6690	7700	8500	9200	9850
		K= 4.07	4.06	4.04	4.02	4.00	3.99	3.97	3.96	3.95
8	Bmax= 4200	4400	5500	6350	6830	7290	8400	9300	10000	10700
		K= 3.60	3.59	3.57	3.56	3.55	3.54	3.52	3.51	3.51
7	Bmax= 4550	4800	6000	7000	7500	7960	9200	10200	11000	11800
		K= 3.13	3.13	3.11	3.10	3.09	3.09	3.07	3.07	3.06
6	Bmax= 4900	5200	6500	7600	8200	8660	10000	11100	12000	12900
		K= 2.67	2.67	2.66	2.65	2.64	2.64	2.63	2.62	2.62

Example: Bending diameter D = 800 mm
 Plate thickness S = 9.00 mm
 Max. width of plate Bmax = 6000 mm
 Flat end X = k x S 4.02 x 9.00 = 36 mm

Rounding

Plate width (Bmax) versus bending diameter (D) and plate thickness (S).

D =		580	600	700	800	900	1000	1200	1400	1600
S	21	Bmax= 1030	1060	1210	1350	1470	1580	1770	1930	2070
		K= 1150	1190	1350	1500	1640	1760	1970	2150	2310
20	Bmax= 1290	1330	1500	1690	1840	1970	2230	2510	2750	2950
		K= 1460	1500	1710	1900	2080	2230	2510	2750	2950
19	Bmax= 1660	1710	1950	2170	2370	2550	2940	3320	3650	3930
		K= 1910	1970	2250	2500	2730	3040	3440	3800	4150
18	Bmax= 2210	2280	2610	2910	3190	3460	3900	4400	4900	5350
		K= 2210	2280	2610	2910	3190	3460	3900	4400	4900
17	Bmax= 2600	2690	3070	3450	3780	4090	4670	5250	5850	6350
		K= 2600	2690	3070	3450	3780	4090	4670	5250	5850
16	Bmax= 3110	3210	3700	4160	4580	4990	5600	6200	6800	7350
		K= 3110	3210	3700	4160	4580	4990	5600	6200	6800
15	Bmax= 3600	3730	4350	4900	5350	5750	6500	7200	7900	8550
		K= 3600	3730	4350	4900	5350	5750	6500	7200	7900
14	Bmax= 4170	4320	5050	5700	6150	6550	7400	8200	9000	9750
		K= 4170	4320	5050	5700	6150	6550	7400	8200	9000

VRM - CAPACITY CHART

VRM-hy 6000x45

6-10020-140025

TOP ROLLER Ø 500 MM

Yield point 400 N/mm²

PREBENDING

Plate width (Bmax) and edge setting factors (k) versus bending diameter (D) and plate thickness (S).

D =		600	700	800	900	1000	1200	1400	1600
S									
15	Bmax=	1110	1260	1390	1510	1620	1810	1970	2110
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
14	Bmax=	1120	1270	1400	1520	1630	1820	1980	2120
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
13	Bmax=	1130	1280	1410	1530	1640	1830	1990	2130
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
12	Bmax=	1140	1290	1420	1540	1650	1840	2000	2140
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
11	Bmax=	1150	1300	1430	1550	1660	1850	2010	2150
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
10	Bmax=	1160	1310	1440	1560	1670	1860	2020	2160
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
9	Bmax=	1170	1320	1450	1570	1680	1870	2030	2170
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
8	Bmax=	1180	1330	1460	1580	1690	1880	2040	2180
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
7	Bmax=	1190	1340	1470	1590	1700	1890	2050	2190
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
6	Bmax=	1200	1350	1480	1600	1710	1900	2060	2200
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
5	Bmax=	1210	1360	1490	1610	1720	1910	2070	2210
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90
4	Bmax=	1220	1370	1500	1620	1730	1920	2080	2220
	K=	2.94	2.93	2.92	2.92	2.91	2.91	2.90	2.90

Example: Bending diameter D = 900 mm
 Plate thickness S = 7.00 mm
 Max. width of plate Bmax = 6000 mm
 Flat end X = k x S 5.15 x 7.00 = 36 mm

Rounding

Plate width (Bmax) versus bending diameter (D) and plate thickness (S).

D =		600	700	800	900	1000	1200	1400	1600
S									
10	Bmax=	780	890	980	1060	1140	1270	1390	1480
11	Bmax=	880	1000	1100	1200	1280	1430	1560	1670
12	Bmax=	990	1130	1250	1360	1460	1630	1770	1890
13	Bmax=	1140	1290	1430	1550	1670	1860	2030	2170
14	Bmax=	1310	1490	1650	1790	1920	2150	2350	2510
15	Bmax=	1530	1740	1920	2090	2250	2520	2750	2950
16	Bmax=	1800	2050	2280	2480	2670	3000	3280	3530
17	Bmax=	2170	2470	2750	3000	3230	3640	4000	4310
18	Bmax=	2650	3030	3380	3710	4010	4550	5030	5460
19	Bmax=	3330	3840	4300	4740	5160	5950	6600	7000
20	Bmax=	4350	5070	5760	6400	6900	8000	8800	9400
21	Bmax=	6000	6900	7800	8600	9300	10800	11900	12700

VRM - CAPACITY CHART

VRM-hy 6000x45

TOP ROLLER Ø 680 MM

Yield point 360 N/mm²

6-300100-149025

PREBENDING

Plate width (Bmax) and edge setting factors (k) versus bending diameter (D) and plate thickness (S).

D =	800	900	1000	1200	1400	1600	1800	2000
S								
40.0	Bmax= 900	990	1070	1210	1330	1440	1530	1610
	k= 1.094	1.009	0.922	0.845	0.764	0.680	0.594	0.506
37.5	Bmax= 940	1040	1120	1260	1380	1490	1580	1660
	k= 1.077	0.993	0.906	0.829	0.748	0.664	0.578	0.491
35.0	Bmax= 980	1080	1160	1300	1420	1530	1620	1700
	k= 1.060	0.977	0.889	0.812	0.731	0.647	0.561	0.474
32.5	Bmax= 1020	1120	1200	1340	1460	1570	1660	1740
	k= 1.043	0.960	0.872	0.795	0.714	0.630	0.544	0.457
30.0	Bmax= 1060	1160	1240	1380	1500	1610	1700	1780
	k= 1.026	0.943	0.855	0.778	0.697	0.613	0.527	0.440
27.5	Bmax= 1100	1200	1280	1420	1540	1650	1740	1820
	k= 1.009	0.926	0.838	0.761	0.680	0.596	0.510	0.423
25.0	Bmax= 1140	1240	1320	1460	1580	1690	1780	1860
	k= 0.992	0.909	0.821	0.744	0.663	0.579	0.493	0.406
22.5	Bmax= 1180	1280	1360	1500	1620	1730	1820	1900
	k= 0.975	0.892	0.804	0.727	0.646	0.562	0.476	0.389
20.0	Bmax= 1220	1320	1400	1540	1660	1770	1860	1940
	k= 0.958	0.875	0.787	0.710	0.629	0.545	0.459	0.372
17.5	Bmax= 1260	1360	1440	1580	1700	1810	1900	1980
	k= 0.941	0.858	0.770	0.693	0.612	0.528	0.442	0.355
15.0	Bmax= 1300	1400	1480	1620	1740	1850	1940	2020
	k= 0.924	0.841	0.753	0.676	0.595	0.511	0.425	0.338
12.5	Bmax= 1340	1440	1520	1660	1780	1890	1980	2060
	k= 0.907	0.824	0.736	0.659	0.578	0.494	0.408	0.321

Example: Bending diameter D = 1200 mm
 Plate thickness S = 20.0 mm
 Max. width of plate Bmax = 6000 mm
 Flat end X = k x S 4.54 x 20.0 = 91 mm

Rounding

Plate width (Bmax) versus bending diameter (D) and plate thickness (S).

D =	800	900	1000	1200	1400	1600	1800	2000
S								
17.5	Bmax= 780	860	940	1070	1180	1280	1360	1430
	k= 0.990	0.906	0.818	0.741	0.660	0.576	0.490	0.403
15.0	Bmax= 820	900	980	1110	1220	1320	1400	1470
	k= 0.973	0.889	0.801	0.724	0.643	0.559	0.473	0.386
12.5	Bmax= 860	940	1020	1150	1260	1360	1440	1510
	k= 0.956	0.872	0.784	0.707	0.626	0.542	0.456	0.369
10.0	Bmax= 900	980	1060	1190	1300	1400	1480	1550
	k= 0.939	0.855	0.767	0.690	0.609	0.525	0.439	0.352
7.5	Bmax= 940	1020	1100	1230	1340	1440	1520	1590
	k= 0.922	0.838	0.750	0.673	0.592	0.508	0.422	0.335
5.0	Bmax= 980	1060	1140	1270	1380	1480	1560	1630
	k= 0.905	0.821	0.733	0.656	0.575	0.491	0.405	0.318
2.5	Bmax= 1020	1100	1180	1310	1420	1520	1600	1670
	k= 0.888	0.804	0.716	0.639	0.558	0.474	0.388	0.301

VRM - CAPACITY CHART

VRM-hy 6000x45

TOP ROLLER Ø 850 MM

Yield point 240 N/mm²

6-754370-157525

PREBENDING

Plate width (Bmax) and edge setting factors (k) versus bending diameter (D) and plate thickness (S).

D =	950	1000	1500	2000	2500	3000	3500	4000	4500	5000
S										
90	Bmax= 820 K= 1.26	Bmax= 860 K= 1.30	Bmax= 1170 K= 1.55	Bmax= 1340 K= 1.67	Bmax= 1410 K= 1.71	Bmax= 1420 K= 1.68	Bmax= 1460 K= 1.70	Bmax= 1530 K= 1.76	Bmax= 1580 K= 1.80	Bmax= 1630 K= 1.84
85	Bmax= 950 K= 1.34	Bmax= 990 K= 1.38	Bmax= 1340 K= 1.64	Bmax= 1520 K= 1.76	Bmax= 1590 K= 1.79	Bmax= 1590 K= 1.75	Bmax= 1630 K= 1.77	Bmax= 1700 K= 1.83	Bmax= 1760 K= 1.87	Bmax= 1810 K= 1.91
80	Bmax= 1100 K= 1.42	Bmax= 1150 K= 1.46	Bmax= 1540 K= 1.74	Bmax= 1730 K= 1.85	Bmax= 1800 K= 1.87	Bmax= 1790 K= 1.83	Bmax= 1830 K= 1.85	Bmax= 1910 K= 1.90	Bmax= 1980 K= 1.95	Bmax= 2030 K= 1.99
75	Bmax= 1260 K= 1.50	Bmax= 1320 K= 1.54	Bmax= 1780 K= 1.84	Bmax= 1990 K= 1.96	Bmax= 2060 K= 1.97	Bmax= 2030 K= 1.91	Bmax= 2070 K= 1.93	Bmax= 2160 K= 1.98	Bmax= 2230 K= 2.03	Bmax= 2290 K= 2.07
70	Bmax= 1520 K= 1.58	Bmax= 1590 K= 1.62	Bmax= 2080 K= 1.96	Bmax= 2310 K= 2.07	Bmax= 2370 K= 2.07	Bmax= 2320 K= 2.00	Bmax= 2360 K= 2.01	Bmax= 2460 K= 2.07	Bmax= 2540 K= 2.12	Bmax= 2610 K= 2.16
65	Bmax= 1830 K= 1.66	Bmax= 1900 K= 1.70	Bmax= 2470 K= 2.10	Bmax= 2720 K= 2.20	Bmax= 2760 K= 2.19	Bmax= 2680 K= 2.10	Bmax= 2710 K= 2.11	Bmax= 2820 K= 2.16	Bmax= 2920 K= 2.21	Bmax= 3000 K= 2.26
60	Bmax= 2220 K= 1.74	Bmax= 2310 K= 1.79	Bmax= 2970 K= 2.25	Bmax= 3240 K= 2.35	Bmax= 3250 K= 2.31	Bmax= 3120 K= 2.20	Bmax= 3150 K= 2.21	Bmax= 3280 K= 2.26	Bmax= 3390 K= 2.31	Bmax= 3480 K= 2.36
55	Bmax= 2750 K= 1.82	Bmax= 2870 K= 1.87	Bmax= 3650 K= 2.43	Bmax= 3930 K= 2.50	Bmax= 3900 K= 2.44	Bmax= 3690 K= 2.31	Bmax= 3710 K= 2.30	Bmax= 3860 K= 2.36	Bmax= 3990 K= 2.41	Bmax= 4100 K= 2.46
50	Bmax= 3500 K= 1.90	Bmax= 3640 K= 1.94	Bmax= 4610 K= 2.63	Bmax= 4890 K= 2.68	Bmax= 4760 K= 2.58	Bmax= 4430 K= 2.42	Bmax= 4430 K= 2.40	Bmax= 4620 K= 2.46	Bmax= 4770 K= 2.51	Bmax= 4900 K= 2.56
45	Bmax= 4620 K= 2.25	Bmax= 4810 K= 2.30	Bmax= 6000 K= 2.83	Bmax= 6000 K= 2.76	Bmax= 5980 K= 2.71	Bmax= 5440 K= 2.52	Bmax= 5400 K= 2.49	Bmax= 5630 K= 2.55	Bmax= 5820 K= 2.60	Bmax= 6000 K= 2.64
40	Bmax= 6000 K= 2.48	Bmax= 6000 K= 2.54	Bmax= 6000 K= 3.00	Bmax= 6000 K= 2.93	Bmax= 6000 K= 2.87	Bmax= 6000 K= 2.78	Bmax= 6000 K= 2.74	Bmax= 6000 K= 2.80	Bmax= 6000 K= 2.85	Bmax= 6000 K= 2.90
35	Bmax= 6000 K= 2.61	Bmax= 6000 K= 2.66	Bmax= 6000 K= 3.15	Bmax= 6000 K= 3.08	Bmax= 6000 K= 3.02	Bmax= 6000 K= 2.93	Bmax= 6000 K= 2.89	Bmax= 6000 K= 2.95	Bmax= 6000 K= 3.00	Bmax= 6000 K= 3.05

Example: Bending diameter D = 2000 mm
 Plate thickness S = 50.0 mm
 Max. width of plate Bmax = 4980 mm
 Flat end X = k x S 2.68 x 50.0 = 134 mm

Rounding

Plate width (Bmax) versus bending diameter (D) and plate thickness (S).

D =	950	1000	1500	2000	2500	3000	3500	4000	4500	5000
S										
100	Bmax= 900	Bmax= 950	Bmax= 1300	Bmax= 1480	Bmax= 1550	Bmax= 1530	Bmax= 1570	Bmax= 1640	Bmax= 1700	Bmax= 1750
90	Bmax= 1020	Bmax= 1080	Bmax= 1460	Bmax= 1650	Bmax= 1720	Bmax= 1690	Bmax= 1730	Bmax= 1810	Bmax= 1870	Bmax= 1930
85	Bmax= 1170	Bmax= 1230	Bmax= 1660	Bmax= 1860	Bmax= 1910	Bmax= 1880	Bmax= 1910	Bmax= 2000	Bmax= 2070	Bmax= 2130
80	Bmax= 1350	Bmax= 1420	Bmax= 1890	Bmax= 2100	Bmax= 2150	Bmax= 2090	Bmax= 2120	Bmax= 2220	Bmax= 2290	Bmax= 2360
75	Bmax= 1580	Bmax= 1650	Bmax= 2170	Bmax= 2400	Bmax= 2430	Bmax= 2350	Bmax= 2370	Bmax= 2480	Bmax= 2560	Bmax= 2630
70	Bmax= 1850	Bmax= 1930	Bmax= 2520	Bmax= 2760	Bmax= 2770	Bmax= 2650	Bmax= 2670	Bmax= 2790	Bmax= 2880	Bmax= 2960
65	Bmax= 2200	Bmax= 2290	Bmax= 2960	Bmax= 3200	Bmax= 3180	Bmax= 3010	Bmax= 3030	Bmax= 3160	Bmax= 3260	Bmax= 3350
60	Bmax= 2640	Bmax= 2760	Bmax= 3530	Bmax= 3770	Bmax= 3690	Bmax= 3460	Bmax= 3460	Bmax= 3610	Bmax= 3730	Bmax= 3830
55	Bmax= 3240	Bmax= 3380	Bmax= 4280	Bmax= 4510	Bmax= 4340	Bmax= 4010	Bmax= 4000	Bmax= 4160	Bmax= 4300	Bmax= 4420
50	Bmax= 4070	Bmax= 4240	Bmax= 5320	Bmax= 5500	Bmax= 5190	Bmax= 4710	Bmax= 4670	Bmax= 4860	Bmax= 5020	Bmax= 5160
45	Bmax= 5290	Bmax= 5520	Bmax= 6000	Bmax= 6000	Bmax= 6000	Bmax= 5620	Bmax= 5530	Bmax= 5760	Bmax= 5950	Bmax= 6000
40	Bmax= 6000	Bmax= 6000	Bmax= 6000	Bmax= 6000	Bmax= 6000	Bmax= 6000	Bmax= 5970	Bmax= 6000	Bmax= 6000	Bmax= 6000

VRM - CAPACITY CHART

VRM-hy 6000x45

TOP ROLLER Ø 850 MM

Yield point 400 N/mm²

6-754370-157525

PREBENDING

Plate width (Bmax) and edge setting factors (k) versus bending diameter (D) and plate thickness (S).

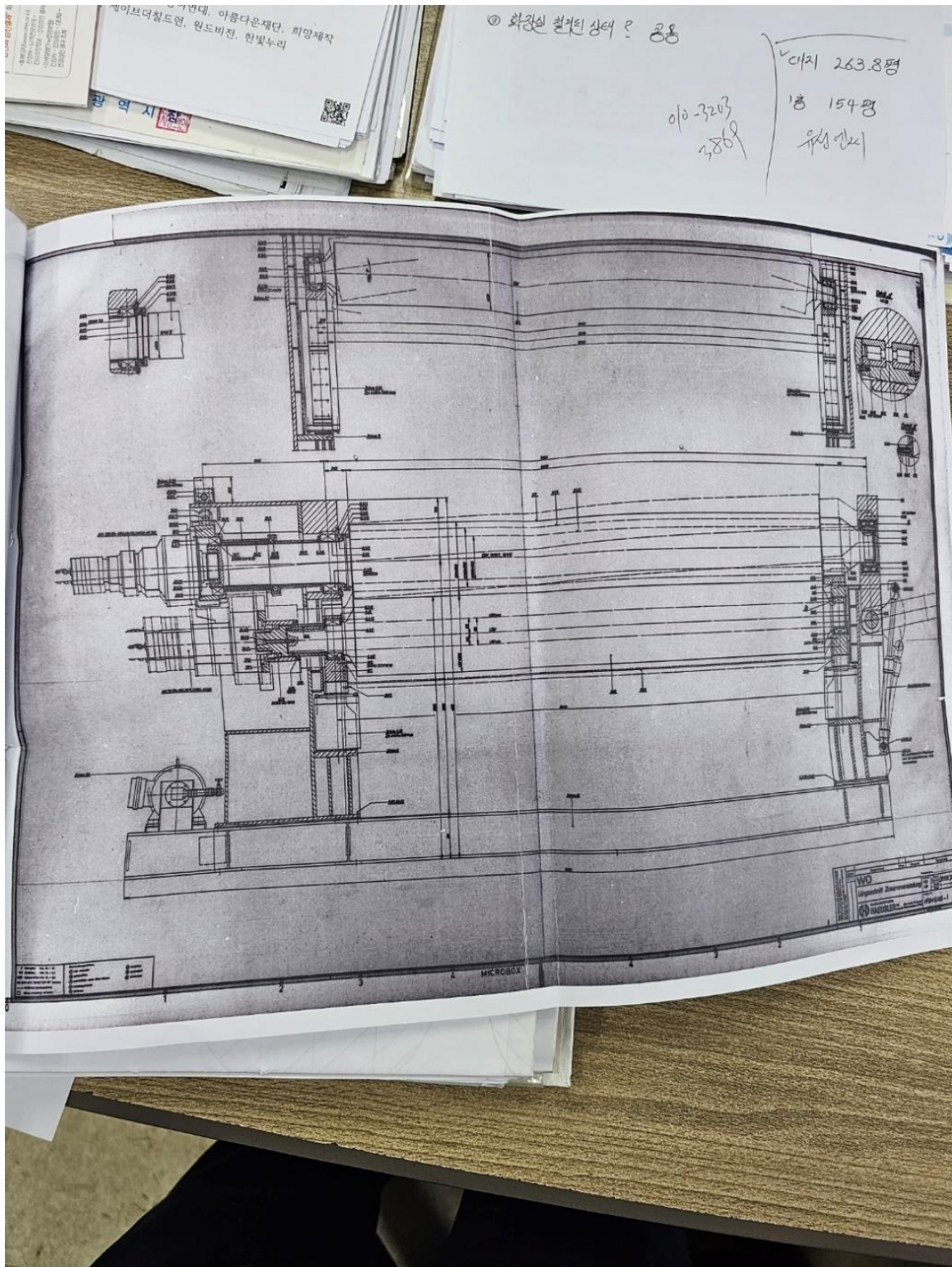
D =	1000	1500	2000	2500	3000	3500	4000	4500	5000
S									
85	Bmax= 590 K= 1.68	Bmax= 810 K= 1.68	Bmax= 930 K= 1.68	Bmax= 1000 K= 1.68	Bmax= 1030 K= 1.68	Bmax= 1070 K= 1.68	Bmax= 1110 K= 1.68	Bmax= 1150 K= 1.68	Bmax= 1190 K= 1.68
80	Bmax= 600 K= 1.68	Bmax= 820 K= 1.68	Bmax= 940 K= 1.68	Bmax= 1010 K= 1.68	Bmax= 1040 K= 1.68	Bmax= 1080 K= 1.68	Bmax= 1120 K= 1.68	Bmax= 1160 K= 1.68	Bmax= 1200 K= 1.68
75	Bmax= 610 K= 1.68	Bmax= 830 K= 1.68	Bmax= 950 K= 1.68	Bmax= 1020 K= 1.68	Bmax= 1050 K= 1.68	Bmax= 1090 K= 1.68	Bmax= 1130 K= 1.68	Bmax= 1170 K= 1.68	Bmax= 1210 K= 1.68
70	Bmax= 620 K= 1.68	Bmax= 840 K= 1.68	Bmax= 960 K= 1.68	Bmax= 1030 K= 1.68	Bmax= 1060 K= 1.68	Bmax= 1100 K= 1.68	Bmax= 1140 K= 1.68	Bmax= 1180 K= 1.68	Bmax= 1220 K= 1.68
65	Bmax= 630 K= 1.68	Bmax= 850 K= 1.68	Bmax= 970 K= 1.68	Bmax= 1040 K= 1.68	Bmax= 1070 K= 1.68	Bmax= 1110 K= 1.68	Bmax= 1150 K= 1.68	Bmax= 1190 K= 1.68	Bmax= 1230 K= 1.68
60	Bmax= 640 K= 1.68	Bmax= 860 K= 1.68	Bmax= 980 K= 1.68	Bmax= 1050 K= 1.68	Bmax= 1080 K= 1.68	Bmax= 1120 K= 1.68	Bmax= 1160 K= 1.68	Bmax= 1200 K= 1.68	Bmax= 1240 K= 1.68
55	Bmax= 650 K= 1.68	Bmax= 870 K= 1.68	Bmax= 990 K= 1.68	Bmax= 1060 K= 1.68	Bmax= 1090 K= 1.68	Bmax= 1130 K= 1.68	Bmax= 1170 K= 1.68	Bmax= 1210 K= 1.68	Bmax= 1250 K= 1.68
50	Bmax= 660 K= 1.68	Bmax= 880 K= 1.68	Bmax= 1000 K= 1.68	Bmax= 1070 K= 1.68	Bmax= 1100 K= 1.68	Bmax= 1140 K= 1.68	Bmax= 1180 K= 1.68	Bmax= 1220 K= 1.68	Bmax= 1260 K= 1.68
45	Bmax= 670 K= 1.68	Bmax= 890 K= 1.68	Bmax= 1010 K= 1.68	Bmax= 1080 K= 1.68	Bmax= 1110 K= 1.68	Bmax= 1150 K= 1.68	Bmax= 1190 K= 1.68	Bmax= 1230 K= 1.68	Bmax= 1270 K= 1.68
40	Bmax= 680 K= 1.68	Bmax= 900 K= 1.68	Bmax= 1020 K= 1.68	Bmax= 1090 K= 1.68	Bmax= 1120 K= 1.68	Bmax= 1160 K= 1.68	Bmax= 1200 K= 1.68	Bmax= 1240 K= 1.68	Bmax= 1280 K= 1.68
35	Bmax= 690 K= 1.68	Bmax= 910 K= 1.68	Bmax= 1030 K= 1.68	Bmax= 1100 K= 1.68	Bmax= 1130 K= 1.68	Bmax= 1170 K= 1.68	Bmax= 1210 K= 1.68	Bmax= 1250 K= 1.68	Bmax= 1290 K= 1.68
30	Bmax= 700 K= 1.68	Bmax= 920 K= 1.68	Bmax= 1040 K= 1.68	Bmax= 1110 K= 1.68	Bmax= 1140 K= 1.68	Bmax= 1180 K= 1.68	Bmax= 1220 K= 1.68	Bmax= 1260 K= 1.68	Bmax= 1300 K= 1.68

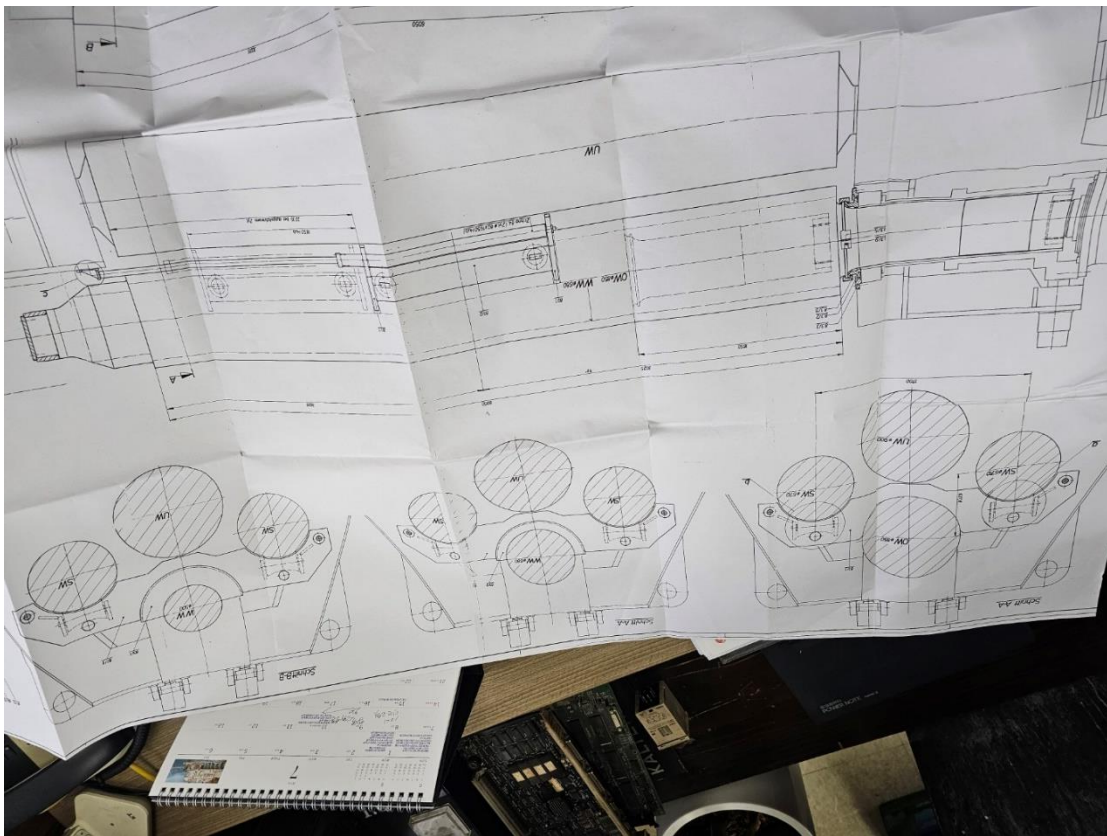
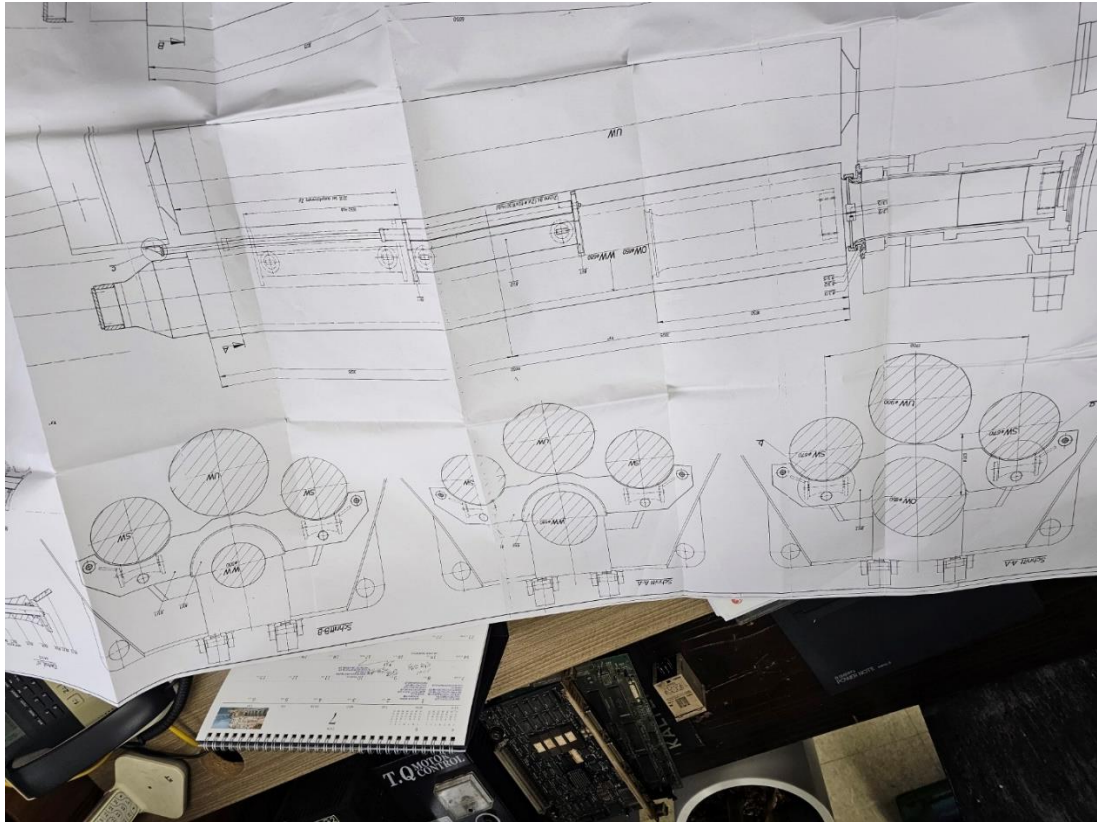
Example: Bending diameter D = 2500 mm
 Plate thickness S = 45.0 mm
 Max. width of plate Bmax = 3780 mm
 Flat end X = k x S 3.21 x 45.0 = 144 mm

Rounding

Plate width (Bmax) versus bending diameter (D) and plate thickness (S).

Plate width (Bmax) versus Dmax										
	D =	1000	1500	2000	2500	3000	3500	4000	4500	5000
S										
85	Bmax=	730	1000	1150	1220	1240	1280	1340	1390	1430
80	Bmax=	840	1140	1300	1380	1390	1430	1500	1550	1590
75	Bmax=	980	1310	1480	1560	1570	1610	1680	1740	1790
70	Bmax=	1140	1510	1710	1780	1780	1820	1900	1970	2020
65	Bmax=	1350	1770	1980	2050	2040	2080	2170	2240	2300
60	Bmax=	1610	2090	2330	2390	2350	2400	2500	2580	2650
55	Bmax=	1950	2520	2770	2820	2750	2790	2910	3000	3080
50	Bmax=	2400	3080	3360	3380	3260	3290	3430	3540	3640
45	Bmax=	3040	3860	4170	4140	3930	3950	4110	4250	4360
40	Bmax=	3970	5020	5330	5190	4830	4830	5030	5200	5340
35	Bmax=	5460	6000	6000	6000	6000	6000	6000	6000	6000
30	Bmax=	6000	6000	6000	6000	6000	6000	6000	6000	6000





- DETAILS GIVEN IN GOOD FAITH BUT WITHOUT GUARANTEE -

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