

Force bending sheet

The force needed in bending tons per meter with material S- 355

V = v-gap width of the matrix (mm)

R = inner bending radius (mm)

A = edging sides minimum inside measure (mm)

| S = material thickness | | | | | | | | | | | | | | | | | | | | | | | | |
|------------------------|---------|---------|-----|-----|----|-----|----|----|----|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| V mm | R mm | A mm | 1 | 1.5 | 2 | 2.5 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 15 | 16 | 18 | 20 | 25 | 30 | 40 | 50 | 60 | |
| 10 | 1.5 | 6 | 7 | 15 | 27 | | | | | | | | | | | | | | | | | | | |
| 14 | 2 | 8.5 | 5 | 11 | 19 | 30 | | | | | | | | | | | | | | | | | | |
| 20 | 3 | 12 | 3.3 | 7 | 13 | 21 | 30 | 53 | | | | | | | | | | | | | | | | |
| 25 | 3.5 | 15 | 2.6 | 6 | 11 | 17 | 24 | 43 | 67 | | | | | | | | | | | | | | | |
| 30 | 4.5 | 19 | | 5 | 9 | 14 | 20 | 35 | 56 | 80 | | | | | | | | | | | | | | |
| 40 | 6 | 25 | | 4 | 7 | 10 | 15 | 27 | 42 | 60 | 108 | | | | | | | | | | | | | |
| 50 | 7 | 32 | | | 5 | 8 | 12 | 22 | 34 | 48 | 86 | 135 | | | | | | | | | | | | |
| 60 | 8 | 38 | | | | 7 | 10 | 18 | 28 | 40 | 72 | 112 | 162 | | | | | | | | | | | |
| 70 | 10 | 44 | | | | | 9 | 15 | 24 | 35 | 62 | 96 | 138 | 188 | | | | | | | | | | |
| 80 | 12 | 51 | | | | | 8 | 13 | 21 | 30 | 53 | 84 | 121 | 165 | 190 | | | | | | | | | |
| 90 | 15 | 56 | | | | | | 12 | 19 | 27 | 48 | 75 | 108 | 147 | 168 | 191 | | | | | | | | |
| 100 | 16 | 62 | | | | | | 11 | 17 | 24 | 43 | 67 | 97 | 132 | 151 | 172 | | | | | | | | |
| 120 | 18 | 73 | | | | | | | 14 | 20 | 36 | 56 | 80 | 110 | 126 | 144 | 182 | | | | | | | |
| 140 | 20 | 85 | | | | | | | 12 | 17 | 31 | 48 | 69 | 94 | 108 | 123 | 156 | 192 | | | | | | |
| 160 | 25 | 98 | | | | | | | | 15 | 27 | 42 | 61 | 82 | 95 | 108 | 136 | 168 | | | | | | |
| 180 | 27 | 112 | | | | | | | | | 24 | 37 | 54 | 73 | 84 | 96 | 121 | 150 | 234 | | | | | |
| 200 | 30 | 126 | | | | | | | | | 22 | 34 | 48 | 66 | 76 | 86 | 109 | 135 | 210 | | | | | |
| 225 | 32 | 143 | | | | | | | | | | 30 | 43 | 59 | 67 | 77 | 97 | 120 | 187 | | | | | |
| 250 | 36 | 161 | | | | | | | | | | 27 | 39 | 53 | 61 | 69 | 87 | 108 | 168 | 242 | | | | |
| 280 | 42 | 181 | | | | | | | | | | | 35 | 47 | 54 | 62 | 78 | 96 | 150 | 216 | | | | |
| 315 | 45 | 203 | | | | | | | | | | | | 32 | 44 | 51 | 57 | 73 | 90 | 140 | 202 | 325 | 450 | 600 |

Please contact us for further information



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