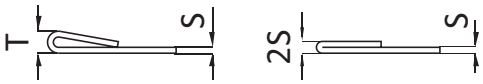
Presskrafttabelle für Umfalzarbeiten - Bending Scheme

S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	9	3	23	1,2
0,8	12	3	32	1,6
1,0	15	3,5	40	2,0
1,25	17	3,5	50	2,5
1,5	22	4,6	63	3,0
2,0	30	5,5	80	4,0
2,5	55	6,5	90	5,0
3,0	70	8,0	100	6,0

Material: R = 400 N/mm² (St)

S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	15	3	35	1,2
0,8	20	3	50	1,6
1,0	25	3,5	60	2,0
1,25	26	3,5	80	2,5
1,5	38	4,6	95	3,0
2,0	50	5,5	130	4,0

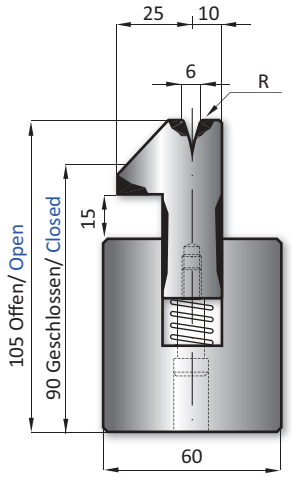
Material: R = 700 N/mm² (VA)



	α	R	T/mt	Mt
20.264	35°	1.00	60	III

415 mm

835 mm

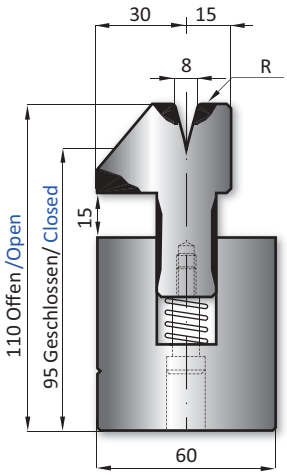


35°

	α	R	T/mt	Mt
20.303	30°	1.50	80	III

415 mm

835 mm

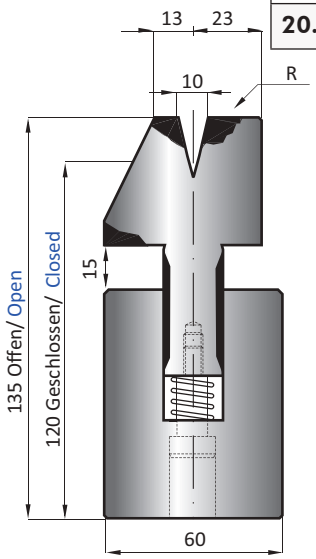


30°

	α	R	T/mt	Mt
20.231	26°	1.50	100	III

415 mm

835 mm

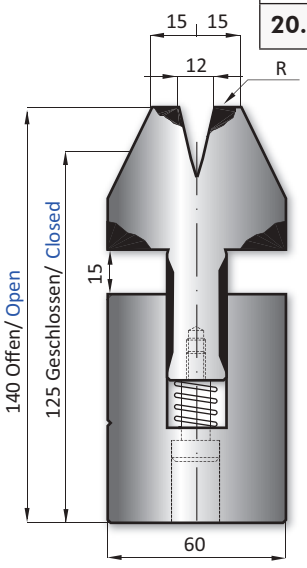


26°

	α	R	T/mt	Mt
20.305	26°	3.00	100	III

415 mm

835 mm



26°