

Capacity chart to :

- Prebending
- Rounding

1. Top roller diameter 910 mm / plate yield point 350 N/mm²

2. Top roller diameter 820 mm / plate yield point 350 N/mm²

3. Top roller diameter 740 mm / plate yield point 350 N/mm²

CAPACITY CHART

VRM-hy 3000x80mm

TOP ROLLER DIAMETER 910 mm

Yield point 350 N/mm²

3-1810830-167525

PREBENDING

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

D =	1890	1980	2070	2160	2250	2340	2430	2520	2610	2700
Th										
140	Bmax= 770 K= 1.10	300 1.11	820 1.13	340 1.15	860 1.16	380 1.17	900 1.18	910 1.19	930 1.20	940 1.21
135	Bmax= 340 K= 1.13	870 1.15	390 1.17	920 1.19	940 1.20	960 1.21	980 1.22	1000 1.23	1010 1.24	1030 1.25
130	Bmax= 930 K= 1.18	950 1.20	980 1.21	1010 1.23	1030 1.24	1050 1.26	1070 1.27	1090 1.28	1110 1.29	1120 1.29
125	Bmax= 1020 K= 1.22	1050 1.24	1080 1.26	1110 1.27	1140 1.29	1160 1.30	1180 1.31	1200 1.32	1220 1.33	1230 1.34
120	Bmax= 1130 K= 1.27	1170 1.29	1200 1.31	1230 1.32	1260 1.34	1280 1.35	1300 1.36	1320 1.37	1340 1.38	1360 1.39
115	Bmax= 1260 K= 1.32	1300 1.34	1340 1.36	1370 1.38	1400 1.39	1430 1.40	1450 1.41	1470 1.42	1490 1.43	1510 1.44
110	Bmax= 1420 K= 1.38	1460 1.40	1500 1.42	1530 1.43	1570 1.45	1600 1.46	1620 1.47	1650 1.48	1670 1.48	1690 1.49
105	Bmax= 1600 K= 1.44	1650 1.46	1700 1.48	1740 1.49	1770 1.51	1800 1.52	1830 1.53	1860 1.54	1880 1.54	1900 1.55
100	Bmax= 1840 K= 1.50	1890 1.52	1940 1.54	1980 1.56	2020 1.57	2060 1.58	2090 1.59	2120 1.60	2150 1.60	2170 1.61
95	Bmax= 2130 K= 1.57	2190 1.59	2250 1.61	2300 1.62	2350 1.64	2390 1.65	2430 1.65	2460 1.66	2490 1.66	2510 1.67
90	Bmax= 2510 K= 1.65	2590 1.67	2660 1.68	2730 1.70	2780 1.71	2830 1.71	2870 1.72	2910 1.72	2940 1.72	2960 1.72
85	Bmax= 3000 K= 1.70	3000 1.69	3000 1.68	3000 1.67	3000 1.66	3000 1.66	3000 1.65	3000 1.64	3000 1.63	3000 1.63

EXAMPLE : Bending diameter D = 2160 mm
 Plate thickness Th = 100.0 mm
 Max. width of plate Bmax = 1980 mm
 Flat end X = k x Th = 1.56 x 100.0 = 156 mm

ROUNDING

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

D =	1890	1980	2070	2160	2250	2340	2430	2520	2610	2700
Th										
150	Bmax= 920	950	980	1000	1030	1050	1070	1090	1110	1120
145	Bmax= 1000	1030	1060	1090	1120	1140	1160	1180	1200	1220
140	Bmax= 1100	1130	1160	1190	1220	1250	1270	1290	1310	1330
135	Bmax= 1200	1240	1280	1310	1340	1370	1390	1410	1430	1450
130	Bmax= 1330	1370	1410	1440	1480	1500	1530	1550	1570	1590
125	Bmax= 1470	1520	1560	1600	1630	1660	1690	1720	1740	1760
120	Bmax= 1650	1700	1740	1780	1820	1850	1880	1910	1930	1950
115	Bmax= 1850	1910	1960	2010	2050	2080	2120	2140	2170	2190
110	Bmax= 2110	2170	2230	2280	2330	2370	2400	2430	2450	2470
105	Bmax= 2430	2510	2570	2630	2690	2730	2770	2800	2820	2840
100	Bmax= 2870	2960	3000	3000	3000	3000	3000	3000	3000	3000
99	Bmax= 3000	3000	3000	3000	3000	3000	3000	3000	3000	3000

MASCHINENFABRIK CHR. HAEUSLER AG

CAPACITY CHART

VRM-hy 3000x80mm

TOP ROLLER DIAMETER 910 mm

Yield point 350 N/mm²

3-1810830-167525

PREBENDING

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

D =	990	1080	1170	1260	1350	1440	1530	1620	1710	1800
Th										
110	Bmax= 780 K= 1.02	870 1.07	950 1.12	1020 1.16	1090 1.20	1150 1.24	1210 1.27	1270 1.30	1320 1.33	1370 1.36
105	Bmax= 890 K= 1.07	990 1.12	1070 1.17	1160 1.22	1230 1.26	1310 1.30	1370 1.33	1440 1.36	1500 1.39	1550 1.42
100	Bmax= 1020 K= 1.12	1130 1.18	1230 1.23	1320 1.28	1410 1.32	1490 1.36	1570 1.40	1640 1.43	1710 1.46	1780 1.48
95	Bmax= 1180 K= 1.18	1300 1.24	1420 1.30	1530 1.35	1630 1.39	1730 1.43	1820 1.47	1900 1.50	1980 1.53	2060 1.55
90	Bmax= 1380 K= 1.25	1520 1.31	1660 1.37	1790 1.42	1910 1.46	2030 1.51	2140 1.54	2240 1.57	2340 1.60	2430 1.63
85	Bmax= 1630 K= 1.32	1800 1.39	1970 1.45	2130 1.50	2280 1.55	2430 1.59	2570 1.62	2710 1.66	2840 1.68	2960 1.71
80	Bmax= 1970 K= 1.40	2180 1.47	2400 1.53	2610 1.59	2830 1.63	3000 1.66	3000 1.64	3000 1.63	3000 1.61	3000 1.60
75	Bmax= 2440 K= 1.49	2750 1.56	3000 1.61	3000 1.58	3000 1.56	3000 1.54	3000 1.52	3000 1.51	3000 1.50	3000 1.49
70	Bmax= 3000 K= 1.54	3000 1.50	3000 1.48	3000 1.46	3000 1.44	3000 1.42	3000 1.41	3000 1.39	3000 1.38	3000 1.37
65	Bmax= 3000 K= 1.40	3000 1.37	3000 1.35	3000 1.33	3000 1.32	3000 1.30	3000 1.29	3000 1.28	3000 1.27	3000 1.26
60	Bmax= 3000 K= 1.27	3000 1.25	3000 1.23	3000 1.21	3000 1.20	3000 1.19	3000 1.18	3000 1.17	3000 1.16	3000 1.16
55	Bmax= 3000 K= 1.14	3000 1.13	3000 1.11	3000 1.10	3000 1.09	3000 1.08	3000 1.07	3000 1.06	3000 1.06	3000 1.05

EXAMPLE : Bending diameter D = 1260 mm
 Plate thickness Th = 70.0 mm
 Max. width of plate Bmax = 3000 mm
 Flat end X = k x Th = 1.46 x 70.0 = 102 mm

ROUNDING

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

D =	990	1080	1170	1260	1350	1440	1530	1620	1710	1800
Th										
135	Bmax= 700*	700	770	840	900	960	1020	1070	1120	1160
130	Bmax= 740*	780	860	930	1000	1070	1130	1180	1230	1280
125	Bmax= 790*	870	960	1040	1110	1190	1250	1310	1370	1420
120	Bmax= 880	980	1070	1160	1250	1330	1400	1470	1530	1590
115	Bmax= 990	1110	1210	1310	1410	1490	1580	1650	1730	1790
110	Bmax= 1130	1260	1380	1490	1600	1700	1790	1880	1960	2040
105	Bmax= 1300	1440	1580	1710	1830	1950	2060	2160	2260	2350
100	Bmax= 1500	1670	1830	1980	2130	2270	2410	2530	2650	2760
95	Bmax= 1760	1960	2150	2350	2530	2710	2890	3000	3000	3000
90	Bmax= 2100	2350	2600	2860	3000	3000	3000	3000	3000	3000
85	Bmax= 2570	2920	3000	3000	3000	3000	3000	3000	3000	3000
82	Bmax= 3000	3000	3000	3000	3000	3000	3000	3000	3000	3000

* Bmax and K calculated with D= 8 xTh !

MASCHINENFABRIK CHR. HAEUSLER AG

CAPACITY CHART

VRM-hy 3000x80mm

TOP ROLLER DIAMETER 820 mm

Yield point 350 N/mm²

3-1480370-163025

PREBENDING

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

	D =	900	990	1080	1170	1260	1350	1440	1530	1620	1710
Th											
105	Bmax=	330	370	420	460	500	530	570	600	630	650
	K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
100	Bmax=	380	430	480	530	570	610	650	680	710	740
	K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
95	Bmax=	440	500	560	610	660	700	740	780	810	850
	K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
90	Bmax=	520	590	650	710	760	810	860	900	940	970
	K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
85	Bmax=	620	690	760	830	890	950	1000	1050	1090	1120
	K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.02	1.04
80	Bmax=	730	820	910	980	1050	1120	1170	1220	1260	1300
	K=	1.00	1.00	1.00	1.00	1.00	1.01	1.04	1.06	1.08	1.10
75	Bmax=	890	990	1090	1180	1250	1320	1380	1440	1490	1530
	K=	1.00	1.00	1.00	1.00	1.04	1.07	1.10	1.13	1.15	1.17
70	Bmax=	1080	1210	1310	1410	1500	1580	1650	1720	1780	1840
	K=	1.00	1.00	1.03	1.07	1.11	1.14	1.17	1.20	1.22	1.24
65	Bmax=	1340	1480	1610	1730	1840	1940	2030	2120	2190	2260
	K=	1.00	1.06	1.11	1.15	1.19	1.22	1.25	1.28	1.30	1.32
60	Bmax=	1680	1860	2020	2180	2330	2470	2600	2710	2820	2910
	K=	1.09	1.14	1.20	1.24	1.28	1.31	1.34	1.37	1.39	1.40
55	Bmax=	2190	2440	2690	2930	3000	3000	3000	3000	3000	3000
	K=	1.18	1.24	1.30	1.34	1.34	1.33	1.32	1.31	1.30	1.29
50	Bmax=	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000
	K=	1.27	1.25	1.23	1.22	1.20	1.19	1.18	1.18	1.17	1.16

EXAMPLE : Bending diameter D = 1170 mm
 Plate thickness Th = 65.0 mm
 Max. width of plate Bmax = 1730 mm
 Flat end X = k x Th = 1.15 x 65.0 = 75 mm

ROUNDING

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

	D =	900	990	1080	1170	1260	1350	1440	1530	1620	1710
Th											
110	Bmax=	410	460	500	550	580	620	650	690	710	740
105	Bmax=	460	520	570	610	660	700	730	770	800	830
100	Bmax=	530	590	640	700	740	790	830	860	900	930
95	Bmax=	610	670	740	790	850	890	940	980	1020	1050
90	Bmax=	700	780	850	910	970	1030	1080	1120	1160	1200
85	Bmax=	810	900	980	1050	1120	1190	1240	1300	1340	1390
80	Bmax=	960	1060	1150	1240	1310	1390	1450	1520	1570	1620
75	Bmax=	1140	1260	1370	1470	1560	1650	1730	1800	1860	1920
70	Bmax=	1380	1520	1650	1780	1890	2000	2100	2190	2270	2340
65	Bmax=	1700	1880	2050	2220	2370	2510	2640	2760	2860	2950
60	Bmax=	2170	2420	2670	2910	3000	3000	3000	3000	3000	3000
55	Bmax=	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000

MASCHINENFABRIK CHR. HAEUSLER AG

CAPACITY CHART

VRM-hy 3000x80mm

TOP ROLLER DIAMETER 820 mm

Yield point 350 N/mm²

3-1430370-163025

PREBENDING

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

D =	1800	1890	1980	2070	2160	2250	2340	2430	2520	2610
Th										
110 Bmax=	600	620	640	650	670	680	700	710	720	730
K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
105 Bmax=	630	700	720	740	750	770	780	790	800	810
K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
100 Bmax=	770	790	810	830	850	870	880	890	900	910
K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
95 Bmax=	880	900	930	950	970	980	1000	1010	1020	1030
K=	1.00	1.00	1.00	1.00	1.00	1.01	1.02	1.02	1.03	1.03
90 Bmax=	1010	1030	1060	1080	1100	1110	1120	1140	1150	1160
K=	1.00	1.02	1.03	1.04	1.05	1.06	1.06	1.07	1.07	1.08
85 Bmax=	1160	1180	1210	1230	1250	1270	1290	1300	1310	1320
K=	1.05	1.07	1.08	1.09	1.10	1.11	1.12	1.12	1.12	1.13
80 Bmax=	1340	1370	1400	1430	1450	1470	1490	1500	1510	1520
K=	1.12	1.13	1.14	1.15	1.16	1.17	1.17	1.18	1.18	1.18
75 Bmax=	1580	1610	1650	1670	1700	1720	1740	1750	1760	1770
K=	1.13	1.20	1.21	1.22	1.22	1.23	1.23	1.24	1.24	1.24
70 Bmax=	1890	1930	1970	2000	2030	2050	2070	2080	2090	2100
K=	1.25	1.27	1.28	1.29	1.29	1.30	1.30	1.30	1.30	1.30
65 Bmax=	2320	2370	2420	2450	2480	2500	2530	2550	2560	2570
K=	1.33	1.34	1.35	1.36	1.36	1.36	1.37	1.38	1.38	1.38
60 Bmax=	2690	2740	2790	2820	2850	2880	2900	2930	2950	2960
K=	1.41	1.41	1.40	1.40	1.39	1.38	1.38	1.38	1.37	1.37
55 Bmax=	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000
K=	1.29	1.33	1.27	1.27	1.26	1.26	1.26	1.25	1.25	1.25

EXAMPLE : Bending diameter D = 2070 mm
 Plate thickness Th = 70.0 mm
 Max. width of plate Bmax = 2000 mm
 Flat end X = k x Th = 1.29 x 70.0 = 90 mm

ROUNDING

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

D =	1800	1890	1980	2070	2160	2250	2340	2430	2520	2610
120 Bmax=	620	640	660	670	690	700	710	720	730	740
115 Bmax=	690	710	720	740	760	770	780	790	800	810
110 Bmax=	760	780	800	820	840	850	860	880	890	900
105 Bmax=	850	880	900	920	940	950	960	970	980	990
100 Bmax=	960	980	1010	1030	1040	1060	1070	1090	1100	1110
95 Bmax=	1080	1110	1140	1160	1180	1190	1210	1220	1230	1240
90 Bmax=	1240	1270	1290	1320	1340	1360	1370	1380	1390	1400
85 Bmax=	1420	1460	1490	1510	1540	1560	1570	1580	1590	1600
80 Bmax=	1660	1700	1730	1760	1790	1810	1820	1830	1840	1850
75 Bmax=	1970	2020	2050	2080	2110	2130	2140	2150	2160	2160
70 Bmax=	2400	2450	2490	2520	2550	2570	2580	2580	2590	2590
65 Bmax=	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000

MASCHINENFABRIK CHR. HAEUSLER AG

CAPACITY CHART

VRM-hy 3000x80mm

TOP ROLLER DIAMETER 740 mm

Yield point 350 N/mm²

3-1050335-159025

PREBENDING

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

	D =	810	900	990	1080	1170	1260	1350	1440	1530	1620
Th											
100	Bmax=	290	340	380	430	470	500	540	570	590	620
	K=	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.03	1.05
95	Bmax=	340	390	440	490	540	580	610	640	670	700
	K=	1.00	1.00	1.00	1.00	1.00	1.00	1.02	1.05	1.08	1.11
90	Bmax=	400	460	520	570	620	660	700	730	760	790
	K=	1.00	1.00	1.00	1.00	1.01	1.05	1.08	1.11	1.14	1.16
85	Bmax=	470	540	610	670	720	760	800	840	880	910
	K=	1.00	1.00	1.00	1.02	1.07	1.11	1.14	1.17	1.20	1.23
80	Bmax=	560	650	720	780	830	880	930	970	1010	1050
	K=	1.00	1.00	1.04	1.09	1.13	1.17	1.21	1.25	1.27	1.30
75	Bmax=	680	770	840	910	980	1040	1090	1140	1190	1230
	K=	1.00	1.05	1.11	1.16	1.21	1.25	1.29	1.32	1.35	1.38
70	Bmax=	820	920	1010	1090	1160	1240	1300	1360	1410	1460
	K=	1.05	1.12	1.18	1.24	1.29	1.34	1.38	1.41	1.44	1.47
65	Bmax=	1000	1110	1220	1320	1410	1500	1580	1650	1710	1770
	K=	1.13	1.21	1.27	1.33	1.39	1.43	1.48	1.51	1.54	1.57
60	Bmax=	1240	1380	1510	1640	1760	1860	1960	2050	2140	2210
	K=	1.23	1.31	1.38	1.44	1.50	1.55	1.59	1.62	1.66	1.68
55	Bmax=	1570	1760	1940	2110	2270	2420	2550	2680	2800	2900
	K=	1.34	1.42	1.50	1.56	1.62	1.67	1.71	1.75	1.78	1.80
50	Bmax=	2080	2360	2630	2900	3000	3000	3000	3000	3000	3000
	K=	1.47	1.56	1.64	1.70	1.71	1.70	1.68	1.67	1.66	1.65
45	Bmax=	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000
	K=	1.61	1.58	1.56	1.54	1.52	1.51	1.50	1.49	1.48	1.47

EXAMPLE : Bending diameter D = 1080 mm
 Plate thickness Th = 60.0 mm
 Max. width of plate Bmax = 1640 mm
 Flat end $X = k \times Th = 1.44 \times 60.0 = 86 \text{ mm}$

ROUNDING

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

	D =	810	900	990	1080	1170	1260	1350	1440	1530	1620
Th											
105	Bmax=	380*	410	460	500	540	580	620	650	680	700
100	Bmax=	410	470	520	570	610	660	690	730	760	790
95	Bmax=	470	540	600	650	700	750	790	830	860	890
90	Bmax=	550	620	680	750	800	850	900	940	980	1020
85	Bmax=	640	720	790	860	930	980	1040	1090	1130	1170
80	Bmax=	750	840	930	1010	1080	1150	1210	1270	1320	1360
75	Bmax=	890	1000	1100	1190	1280	1360	1430	1500	1560	1610
70	Bmax=	1070	1200	1320	1430	1540	1630	1720	1800	1870	1930
65	Bmax=	1310	1470	1620	1760	1890	2010	2120	2220	2310	2390
60	Bmax=	1650	1850	2050	2230	2410	2580	2730	2870	2990	3000
55	Bmax=	2150	2440	2730	3000	3000	3000	3000	3000	3000	3000
50	Bmax=	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000

* Bmax and K calculated with $D = 8 \times Th$!

MASCHINENFABRIK CHR. HAEUSLER AG

CAPACITY CHART

VRM-hy 3000x80mm

TOP ROLLER DIAMETER 740 mm

Yield point 350 N/mm²

3-1050335-159025

PREBENDING

Plate width (B_{max}) and edge setting factors (k) versus bending diameter (D) and plate thickness (Th).

D =	1710	1800	1890	1980	1270	2160	2250	2340	2430	2520
Th										
105	B _{max} = 570 K = 1.02	590 1.04	600 1.06	620 1.08	440 1.00	650 1.10	660 1.11	670 1.12	680 1.13	680 1.14
100	B _{max} = 640 K = 1.07	660 1.09	680 1.11	690 1.13	510 1.00	720 1.15	730 1.16	740 1.17	750 1.18	760 1.19
95	B _{max} = 720 K = 1.13	740 1.15	760 1.16	780 1.18	580 1.00	810 1.21	820 1.22	830 1.22	840 1.23	850 1.24
90	B _{max} = 870 K = 1.19	840 1.21	860 1.22	880 1.24	670 1.05	920 1.27	930 1.28	940 1.28	950 1.29	960 1.30
85	B _{max} = 940 K = 1.25	960 1.27	990 1.29	1010 1.31	770 1.11	1040 1.33	1060 1.34	1070 1.35	1080 1.35	1090 1.36
80	B _{max} = 1080 K = 1.32	1110 1.34	1140 1.36	1160 1.38	890 1.18	1200 1.40	1220 1.41	1230 1.42	1240 1.42	1250 1.43
75	B _{max} = 1270 K = 1.40	1300 1.43	1330 1.44	1360 1.46	1040 1.26	1400 1.48	1420 1.49	1430 1.50	1440 1.50	1450 1.50
70	B _{max} = 1500 K = 1.49	1540 1.51	1580 1.53	1610 1.55	1240 1.34	1650 1.57	1670 1.57	1690 1.58	1700 1.58	1710 1.59
65	B _{max} = 1820 K = 1.59	1870 1.61	1910 1.63	1940 1.64	1510 1.44	2000 1.66	2010 1.66	2030 1.67	2040 1.67	2050 1.67
60	B _{max} = 2270 K = 1.70	2330 1.72	2380 1.74	2430 1.75	1830 1.55	2470 1.76	2490 1.76	2510 1.76	2510 1.76	2510 1.75
55	B _{max} = 2990 K = 1.82	3000 1.81	3000 1.80	3000 1.80	2430 1.68	3000 1.78	3000 1.78	3000 1.77	3000 1.77	3000 1.76
50	B _{max} = 3000 K = 1.84	3000 1.63	3000 1.63	3000 1.62	3000 1.70	3000 1.61	3000 1.60	3000 1.60	3000 1.60	3000 1.60

EXAMPLE : Bending diameter D = 1980 mm
 Plate thickness Th = 65.0 mm
 Max. width of plate B_{max} = 1940 mm
 Flat end X = k x Th = 1.64 x 65.0 = 107 mm

ROUNDING

Plate width (B_{max}) versus bending diameter (D) and plate thickness (Th).

D =	1710	1800	1890	1980	1270	2160	2250	2340	2430	2520
115	B _{max} = 590	610	620	640	470	670	680	690	700	710
110	B _{max} = 650	670	690	710	520	740	750	760	770	780
105	B _{max} = 730	750	770	790	590	820	830	850	860	880
100	B _{max} = 820	840	860	880	660	920	930	940	950	960
95	B _{max} = 920	950	970	1000	750	1030	1050	1060	1070	1080
90	B _{max} = 1050	1080	1110	1130	860	1170	1190	1200	1210	1220
85	B _{max} = 1210	1240	1270	1300	990	1340	1350	1370	1380	1390
80	B _{max} = 1410	1440	1470	1500	1160	1550	1560	1580	1590	1600
75	B _{max} = 1660	1700	1730	1760	1370	1810	1830	1840	1850	1860
70	B _{max} = 1990	2040	2080	2110	1640	2160	2180	2190	2190	2200
65	B _{max} = 2460	2510	2560	2600	2020	2650	2660	2670	2670	2680
60	B _{max} = 3000	3000	3000	3000	2450	3000	3000	3000	3000	3000

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