

TETRA - CAPACITY CHART

ROLLmeister TETRA 105

TOP ROLL DIAMETER 260 mm

 Yield point 360 N/mm²

2 - 3816 - 49025 -360

MM

PREBENDING

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

Th	D =	400	600	800	1000	1250	1500	1750	2000	2500	3000
18	Bmax =	350	440	500	540	570	590	610	630	650	670
	k =	1.77	2.15	2.40	2.57	2.69	2.77	2.85	2.94	3.02	3.10
17	Bmax =	400	500	560	600	640	670	690	710	730	750
	k =	1.90	2.30	2.53	2.69	2.85	2.97	3.04	3.12	3.20	3.28
16	Bmax =	460	560	630	680	720	760	780	800	820	840
	k =	2.04	2.41	2.67	2.86	3.01	3.16	3.23	3.31	3.38	3.45
15	Bmax =	520	650	720	780	830	860	890	910	940	960
	k =	2.15	2.62	2.86	3.07	3.25	3.35	3.46	3.52	3.63	3.70
14	Bmax =	610	750	830	900	950	990	1020	1040	1080	1100
	k =	2.34	2.81	3.07	3.30	3.46	3.59	3.69	3.76	3.89	3.95
13	Bmax =	710	870	970	1040	1100	1150	1180	1210	1250	1280
	k =	2.52	3.01	3.32	3.53	3.72	3.87	3.96	4.05	4.18	4.27
12	Bmax =	840	1030	1140	1230	1300	1350	1390	1420	1470	1500
	k =	2.73	3.28	3.59	3.85	4.05	4.19	4.30	4.39	4.53	4.61
11	Bmax =	1010	1230	1370	1460	1550	1610	1660	1690	1750	1780
	k =	3.00	3.58	3.94	4.18	4.41	4.57	4.70	4.78	4.94	5.01
10	Bmax =	1230	1500	1660	1770	1880	1950	2000	2000	2000	2000
	k =	3.30	3.95	4.33	4.59	4.86	5.03	5.14	5.14	5.13	5.12
9	Bmax =	1540	1860	2000	2000	2000	2000	2000	2000	2000	2000
	k =	3.70	4.39	4.69	4.66	4.64	4.63	4.62	4.62	4.61	4.60
8	Bmax =	1960	2000	2000	2000	2000	2000	2000	2000	2000	2000
	k =	4.16	4.18	4.15	4.14	4.12	4.11	4.11	4.10	4.09	4.09
7	Bmax =	2000	2000	2000	2000	2000	2000	2000	2000	2000	2000
	k =	3.69	3.65	3.62	3.61	3.60	3.59	3.59	3.58	3.58	3.58

EXAMPLE: Bending diameter $D = 1000 \text{ mm}$
 Plate thickness $Th = 10 \text{ mm}$
 Max. width of plate $Bmax = 1770 \text{ mm}$
 Flat end $X = k \times Th = 4.59 \times 10 = 45.9 \text{ mm}$

ROUNDING

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

Th	D =	400	600	800	1000	1250	1500	1750	2000	2500	3000
19	Bmax =	410	510	580	630	670	700	720	740	760	780
18	Bmax =	460	580	650	700	750	780	800	820	850	870
17	Bmax =	520	650	730	790	840	870	900	920	950	980
16	Bmax =	600	740	830	890	950	990	1020	1040	1080	1100
15	Bmax =	690	850	950	1020	1080	1120	1160	1190	1230	1250
14	Bmax =	790	980	1090	1170	1240	1290	1330	1360	1410	1440
13	Bmax =	930	1140	1270	1360	1440	1500	1550	1580	1630	1670
12	Bmax =	1100	1340	1500	1600	1700	1770	1820	1860	1920	1960
11	Bmax =	1320	1610	1790	1910	2000	2000	2000	2000	2000	2000
10	Bmax =	1610	1960	2000	2000	2000	2000	2000	2000	2000	2000
9	Bmax =	2000	2000	2000	2000	2000	2000	2000	2000	2000	2000
8	Bmax =	2000	2000	2000	2000	2000	2000	2000	2000	2000	2000

HAEUSLER AG DUGGINGEN

 02.09.2016
 TETRA 105-360.xls

3.6/10Ds180DIm0a195c275Sz240f0.843FB1