

TETRA-CAPACITY CHART

ROLLmeister TETRA 105

TOP ROLL DIAMETER 260 mm

Yield point 240 N/mm²

2 - 3816 - 49025 -240
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
20	Bmax =	420	530	600	650	690	720	740	760	790	810
	k =	1.59	1.93	2.15	2.30	2.42	2.51	2.57	2.63	2.72	2.78
19	Bmax =	470	590	670	720	770	800	830	850	880	900
	k =	1.68	2.03	2.27	2.41	2.56	2.65	2.73	2.79	2.88	2.94
18	Bmax =	530	660	750	800	850	890	920	940	980	1000
	k =	1.79	2.15	2.40	2.54	2.67	2.78	2.87	2.92	3.03	3.09
17	Bmax =	600	750	840	900	960	1000	1030	1060	1090	1120
	k =	1.90	2.30	2.53	2.69	2.85	2.95	3.03	3.11	3.19	3.26
16	Bmax =	690	850	950	1020	1090	1130	1170	1200	1240	1260
	k =	2.04	2.44	2.69	2.86	3.04	3.13	3.23	3.31	3.41	3.45
15	Bmax =	790	970	1090	1170	1240	1290	1330	1360	1410	1440
	k =	2.18	2.60	2.88	3.07	3.23	3.35	3.44	3.51	3.63	3.70
14	Bmax =	910	1120	1250	1340	1420	1480	1530	1560	1620	1650
	k =	2.33	2.79	3.08	3.27	3.45	3.58	3.69	3.76	3.89	3.95
13	Bmax =	1070	1310	1460	1560	1660	1720	1770	1810	1870	1920
	k =	2.53	3.02	3.33	3.53	3.74	3.86	3.96	4.04	4.16	4.27
12	Bmax =	1260	1540	1720	1840	1950	2000	2000	2000	2000	2000
	k =	2.73	3.27	3.61	3.84	4.05	4.14	4.13	4.12	4.11	4.10
11	Bmax =	1520	1840	2000	2000	2000	2000	2000	2000	2000	2000
	k =	3.01	3.57	3.84	3.82	3.80	3.79	3.78	3.77	3.76	3.76
10	Bmax =	1850	2000	2000	2000	2000	2000	2000	2000	2000	2000
	k =	3.31	3.51	3.48	3.46	3.45	3.44	3.43	3.42	3.42	3.41
9	Bmax =	2000	2000	2000	2000	2000	2000	2000	2000	2000	2000
	k =	3.20	3.15	3.12	3.11	3.10	3.09	3.08	3.08	3.07	3.07

EXAMPLE:	Bending diameter	D =	1000 mm
	Plate thickness	Th =	12 mm
	Max. width of plate	Bmax =	1840 mm
	Flat end $X = k \times Th =$	$3.84 \times 12 =$	46.08 mm

ROUNDING

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

[illegible]

HAEUSLER AG DUGGINGEN

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TETRA 105-240.xls

3.6/10Ds180DIm0a195c275Sz240f0.843FB1