

VRM - CAPACITY CHART

VRM-hy 3000x110/90 mm

TOP ROLLER DIAMETER 780 mm

Yield point 240 N/mm²

3 - 790544 - 183020

HOE

PREBENDING

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

Th	D =	900	1250	1500	1750	2000	2500	3000	3500	4000	4500
115	Bmax =	* 760	1030	1190	1320	1420	1590	1710	1810	1890	1950
	k =	1.20	1.20	1.33	1.44	1.51	1.65	1.74	1.82	1.89	1.93
110	Bmax =	840	1150	1320	1450	1570	1750	1880	1990	2070	2140
	k =	1.20	1.27	1.40	1.50	1.59	1.73	1.83	1.91	1.97	2.02
105	Bmax =	950	1280	1460	1610	1740	1930	2080	2190	2280	2360
	k =	1.20	1.33	1.47	1.58	1.67	1.81	1.92	2.00	2.07	2.12
100	Bmax =	1080	1440	1640	1800	1930	2140	2300	2430	2530	2610
	k =	1.20	1.41	1.55	1.67	1.76	1.90	2.02	2.11	2.18	2.23
95	Bmax =	1220	1620	1840	2010	2160	2390	2570	2700	2810	2900
	k =	1.21	1.49	1.64	1.76	1.86	2.01	2.13	2.22	2.29	2.35
90	Bmax =	1400	1840	2070	2270	2430	2680	2880	3000	3000	3000
	k =	1.30	1.59	1.74	1.87	1.97	2.13	2.25	2.33	2.31	2.30
85	Bmax =	1600	2090	2360	2570	2750	3000	3000	3000	3000	3000
	k =	1.38	1.69	1.86	1.98	2.09	2.24	2.21	2.19	2.18	2.16
80	Bmax =	1850	2400	2690	2930	3000	3000	3000	3000	3000	3000
	k =	1.48	1.81	1.98	2.11	2.14	2.10	2.07	2.05	2.04	2.03
75	Bmax =	2160	2770	3000	3000	3000	3000	3000	3000	3000	3000
	k =	1.60	1.94	2.05	2.02	1.99	1.96	1.94	1.92	1.91	1.90
70	Bmax =	2540	3000	3000	3000	3000	3000	3000	3000	3000	3000
	k =	1.73	1.94	1.90	1.87	1.85	1.82	1.80	1.79	1.78	1.77
65	Bmax =	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000
	k =	1.87	1.78	1.75	1.72	1.71	1.68	1.67	1.65	1.65	1.64
60	Bmax =	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000
	k =	1.71	1.63	1.60	1.58	1.57	1.54	1.53	1.52	1.51	1.51

EXAMPLE: Bending diameter
Plate thickness
Max. width of plate
Flat end $X = k \times Th =$

D = 1750 mm
Th = 75 mm
Bmax = 3000 mm
2.02 x 75 = 151.5 mm

ROUNDING

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

Th	D =	900	1250	1500	1750	2000	2500	3000	3500	4000	4500
130	Bmax =	* 1010	1210	1410	1570	1700	1920	2080	2210	2310	2390
125	Bmax =	* 1070	1330	1540	1720	1860	2090	2260	2400	2510	2590
120	Bmax =	* 1140	1470	1700	1880	2040	2280	2470	2610	2730	2820
115	Bmax =	* 1220	1630	1880	2070	2240	2500	2700	2860	2980	3000
110	Bmax =	1330	1810	2080	2290	2470	2760	2970	3000	3000	3000
105	Bmax =	1500	2030	2310	2540	2740	3000	3000	3000	3000	3000
100	Bmax =	1700	2270	2580	2840	3000	3000	3000	3000	3000	3000
95	Bmax =	1930	2560	2900	3000	3000	3000	3000	3000	3000	3000
90	Bmax =	2200	2900	3000	3000	3000	3000	3000	3000	3000	3000
85	Bmax =	2530	3000	3000	3000	3000	3000	3000	3000	3000	3000
80	Bmax =	2930	3000	3000	3000	3000	3000	3000	3000	3000	3000
75	Bmax =	3000	3000	3000	3000	3000	3000	3000	3000	3000	3000

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