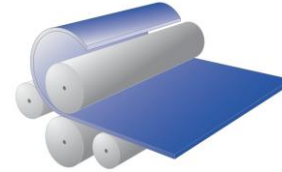


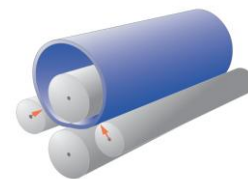
Pre-bending



3.6/10DS1100D1m0a1555c1725Sz260f0.811FB1

example:	bending diameter:	d =	1'600 mm
Beispiel:	wall thickness:	t =	170 mm
	max. plate width:	w_max =	3'500 mm
	flat end $x = k \cdot t$	k = 1.20	x = 204 mm

Rounding

[illegible]

Pre-bending

plate width (w_{max}) and flat end factor (k) in relation to inside diameter (d) and wall thickness (t)

example:	bending diameter:	d =	1'600 mm
Beispiel:	wall thickness:	t =	150 mm
	max. plate width:	w_max =	3'500 mm
	flat end $x = k \cdot t$	k = 1.34	x = 201 mm

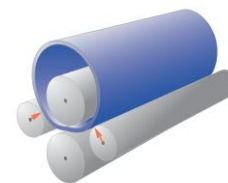
Rounding

A diagram showing a blue cylindrical shell with a white core. Red arrows point from the core towards the shell, indicating the rounding process.[illegible]

Pre-bending

3.6/10DS1100D1m0a1555c1725Sz260f0.811FB1

Rounding

[illegible]