

Bending Pressure

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V	4	6	8	10	12	14	16	18	20	24	28	32	36	40	45	55	60	65	70	80	90	100	120			
b	2.8	4	5.5	7	8.5	10	11	12.5	14	17	20	22	25	28	31	38	42	46	49	58	63	70	85			
R	0.7	1	1.3	1.6	2	2.3	2.6	3	3.3	3.85	4.5	5	6	6.5	7	9	10	11	12	13	14	15	19			
S	0.5	40	30																							
	0.6	60	40	30	30																					
	0.8		70	50	40	30																				
	1		1.1	80	70	60																				
	1.2			120	100	80	70	60																		
	1.5				150	120	110	90	80																	
	2					220	190	170	150	130	110															
	2.5						250	220	200	170	150	130														
	3							330	290	250	210	180	160													
	3.5								400	330	290	250	220	200	180											
	4									470	370	330	290	260	230											
	4.5										470	410	370	330	300	240										
	5											510	450	400	360	300	270	250								
	6															520	430	390	360	340	300					
8																	700	640	600	520	460	420				
10																				810	720	650				
12																						950	780			
14																							1300	1100		

This Chart is calculated according to the plate of tensile strength $\sigma_b = 450 \text{ N/mm}^2$ and length $L = 1 \text{ m}$. the force can be got according to the proportion while different kind of plate and length to be bent.