

Rinbiegen/Wendelbiegen/Freiformbiegen  
 ab 5xD, abhängig von Material, Güte und Wandung

 Rev. Stand:  
**2017-03-09**

Rohraußendurchmesser Da [mm]	Dornbiegen Radius Mitte Rm [mm]	Dornbiegen Spannzangenlänge [mm] kleinster Abstand zwischen 2 Bögen	Kombinationsbiegen (Dorn + Ring/Wendel/Freiform)	Freiformbiegen	Ringbiegen	Wendelbiegen
6,0	19	30			X	X
6,0	24	30			X	X
6,0	34	30			X	X
6,0	44	30			X	X
6,0	49	30			X	X
8,0	22	30			X	X
8,0	24	30			X	X
8,0	40	30			X	X
10,0	16	30			X	X
10,0	20	30			X	X
10,0	30	30			X	X
10,0	34	30			X	X
10,0	40	30			X	X
10,0				X	X	X
12,0	23	30			X	X
12,0	35	30			X	X
12,0	40	30			X	X
14,0	40	50			X	X
15,0	30	35			X	X
15,0	40	55			X	X
16,0	40	55				
18,0	56	85				
20,0	67	85			X	X
20,0	80	50	X	X	X	X
21,3	50	55	X	X	X	X
21,3	57	75		X	X	X
22,0	40	60				
22,0	50	80				
22,0	56	55	X	X	X	X
22,0	67	85			X	X
25,0	50	65	X	X	X	X
25,0	80	80			X	X
25,0	150	85			X	X
26,9	54	65	X	X	X	X
30,0	50	60			X	X
30,0	52	90	X	X	X	X
30,0	61	65			X	X
30,0	80	65			X	X
30,0	100	185			X	X
30,0	112	65			X	X
33,7	48	65			X	X
33,7	59	75	X	X	X	X
33,7	68	70			X	X

33,7	80	70			X	X
33,7	100	70			X	X
35,0	65	80	X	X	X	X
35,0	80	80			X	X
35,0	150	85	X	X	X	X
38,0					X	X
40,0	60	100	X	X	X	X
40,0	80	90			X	X
42,4	74	95	X	X	X	X
42,4	100	90			X	X
42,4	118	160			X	X
48,3	85	120	X	X	X	X
54,0	135	130				
60,0	110	155				
60,3	135	160			X	X
76,1					X	
88,9					X	
108,0					X	
114,0					X	
159,0					X	
168,0					X	
219,0					X	