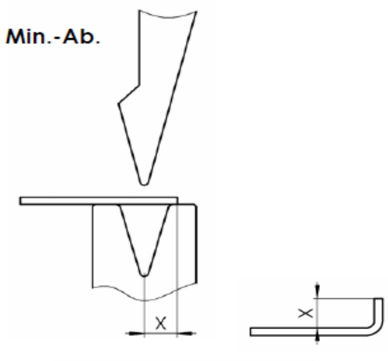
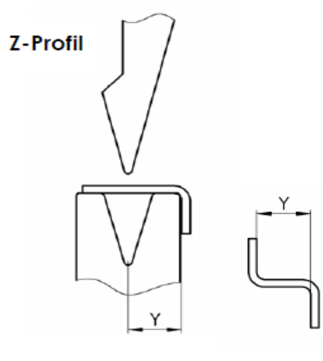
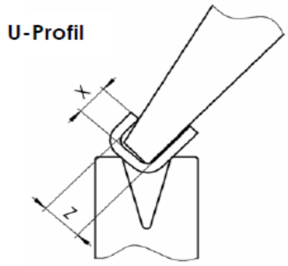
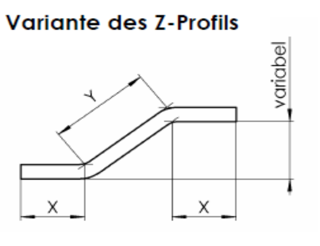
Material		Matrize	Biegezugabe	max. Länge	min. Ab. X	Z-Prof. Y	U-Prof Z	min. Ø A
Stahlblech	1mm	V 8 - 30°	0.00	4000 mm	6	7.5	10.5	6
Stahlblech	1mm	V 10 - 60°	0.00	4000 mm	7	30.5	10.5	7
Stahlblech	1.5mm	V 12 - 30°	0.50	4000 mm	8	12.5	10.5	8
Stahlblech	2mm	V 12 - 30°	0.50	4000 mm	8	12.5	10.5	8
Stahlblech	2.5mm	V 16 - 60°	0.50	4000 mm	10	30.5	10.5	10
Stahlblech	3mm	V 20 - 30°	0.50	4000 mm	12	18	15	12
Stahlblech	4mm	V 22 - 60°	1.00	4000 mm	13	30.5	17	13
Stahlblech	4mm	V 30 - 80°	0.50	4000 mm	17	45.5	21	17
Stahlblech	5mm	V 30 - 80°	1.00	4000 mm	17	45.5	22	17
Stahlblech	5mm	V 35 - 60°	1.00	4000 mm	20	30.5	24.5	19.5
Stahlblech	6mm	V 45 - 80°	1.50	4000 mm	25	45.5	31	24.5
Stahlblech	8mm	V 45 - 80°	2.25	2500 mm	25	45.5	33	24.5
Stahlblech	8mm	V 60 - 80°	2.00	3000 mm	32	45.5	40	32
Stahlblech	10mm	V 60 - 80°	2.50	2000 mm	32	45.5	42	32
Stahlblech	12mm	V 80 - 85°	3.00	1000 mm	43	48	55	42
Stahlblech	12mm	V 125 - 80°	3.00	1000 mm	70	78	78	68
Stahlblech	15mm	V 125 - 80°	4.00	1000 mm	70	78	81	68
Stahl-Tränen	3/4.5mm	V 30 - 80°	0.50	4000 mm	17	45.5	22	17
Stahl-Tränen	5/6.5mm	V 45 - 80°	1.00	4000 mm	25	45.5	31	24.5
Alublech	1mm	V 8 - 30°	0.00	4000 mm	6	7.5	10.5	6
Alublech	1mm	V 10 - 60°	0.50	4000 mm	7	30.5	10.5	7
Alublech	1.5mm	V 12 - 30°	0.50	4000 mm	8	12.5	10.5	8
Alublech	2mm	V 12 - 30°	0.50	4000 mm	8	12.5	10.5	8
Alublech	2mm	V 16 - 60°	0.80	4000 mm	10	30.5	12	10
Alublech	2.5mm	V16 - 60°	0.50	4000 mm	10	30.5	12.5	10
Alublech	3mm	V 20 - 30°	1.00	4000 mm	12	18	15	12
Alublech	4mm	V 22 - 60°	1.50	4000 mm	13	30.5	17	13
Alublech	5mm	V 30 - 80°	2.00	4000 mm	17	45.5	22	17
Alublech	6mm	V 45 - 80°	2.00	4000 mm	25	45.5	31	24.5
Alublech	8mm	V 60 - 80°	3.00	3000 mm	32	45.5	40	32
Alu-Warzen	3/4.5mm	V 20 - 30°	1.00	4000 mm	12	18	15	12
Alu-Warzen	5/6.5mm	V 30 - 80°	2.00	4000 mm	17	45.5	22	17
CNS-Blech	1mm	V 8 - 30°	0.00	4000 mm	6	7.5	10.5	6
CNS-Blech	1mm	V 10 - 60°	0.00	4000 mm	7	30.5	10.5	7
CNS-Blech	1.5mm	V 12 - 30°	0.00	4000 mm	8	12.5	10.5	8
CNS-Blech	2mm	V 12 - 30°	0.00	4000 mm	8	12.5	10.5	8
CNS-Blech	2.5mm	V16 - 60°	0.00	4000 mm	10	30.5	12.5	10
CNS-Blech	3mm	V 20 - 30°	0.00	4000 mm	12	18	15	12
CNS-Blech	4mm	V 30 - 80°	0.50	4000 mm	17	45.5	21	17
CNS-Blech	5mm	V 35 - 60°	0.50	4000 mm	20	30.5	24.5	19.5
CNS-Blech	6mm	V 45 - 80°	1.00	4000 mm	25	45.5	31	24.5
CNS-Blech	8mm	V 60 - 80°	3.00	3000 mm	32	45.5	40	32
CNS-Tränen	3/4.5mm	V 30 - 80°	0.50	4000 mm	17	45.5	22	17
CNS-Blech	5/6.5mm	V 45 - 80°	1.00	4000 mm	25	45.5	31	24.5

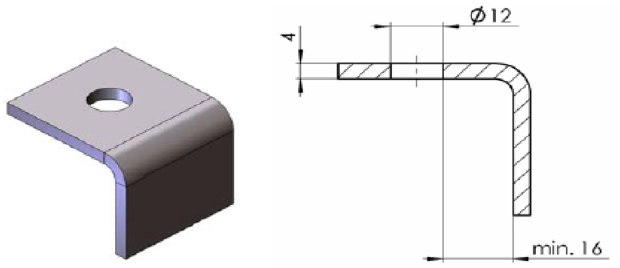




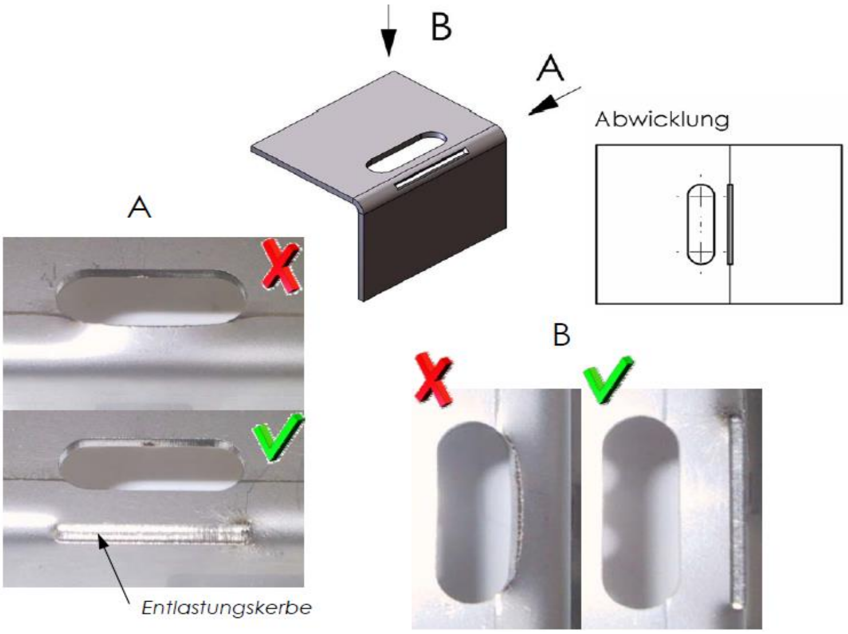




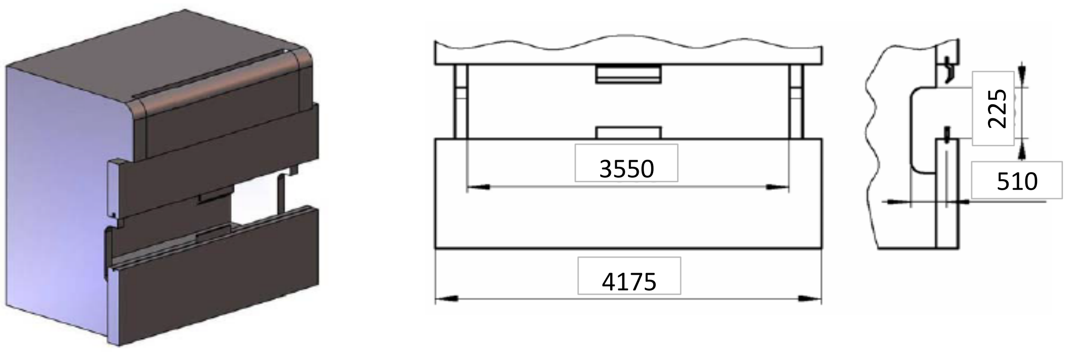
Lochabstände von Biegekante:



Vorteil von Entlastungsschlitz:



Abmessung Maschine / Ständer:



Vorgabe Biegeangaben von Oberli Schlosserei AG

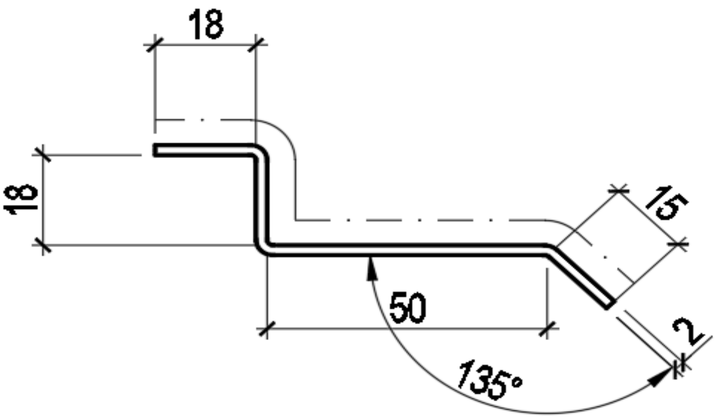
— · — · — · — · — · — · — · — · — · — · — · — · —

Biegelinie Strichpunkt = Stempel von oben

— —

Biegelinie Gestrichelt = Stempel von unten

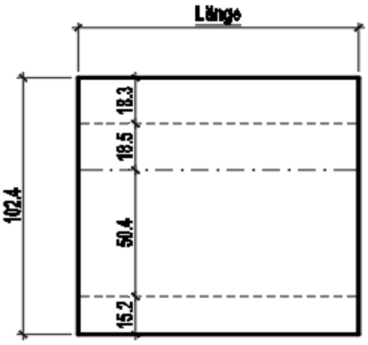
Vorgabe Vermassung:



- ☐ Innenmasse
- ☐ Biegewinkel
- ☐ Material
- ☐ Sichtseite — · — · —

Abwicklung:

Immer Folie oben = Sichtseite



1x Pos. 01
Alublech 2mm

Laser:
CNS = Folie oben
Alu = Folie unten
Warzen / Tränen = unten
Duettblech = Tränen oben

Materialbezeichnungen:
Stahlblech (decapiert)
Schwarzblech
Alublech
Eloxblech
Alu–Warzenblech
Alu–Duettblech
CNS–Blech (1.4301 / 1.4404)
CNS–Blech geschliffen
CNS–Tränenblech

Für Sie da...

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