



LAG MACHINE TOOLS

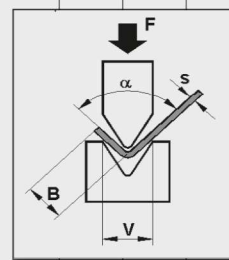
- ITALY DEALER -



Forza essenziale alla piegatura (in ton/metro)
Bending force necessary (in tons/metre)

R	B	V	S (mm)																		
			0.5	0,6	0,8	1	1,2	1,5	2	2,5	3	4	5	6	8	10	12	15	20	25	30
0.5	3	4	4 ₇	6 ₁₀	12 ₂₀																
0.7	3.5	5	3 ₅	5 ₈	9 ₁₅	15 ₂₅															
0.8	4.0	6	2 ₄	3 ₆	7 ₁₂	11 ₁₉	18 ₃₀														
1.0	5.5	8		2 ₄	5 ₈	8 ₁₃	12 ₂₁	21 ₃₅													
1.3	6.5	10			4 ₆	6 ₁₀	9 ₁₅	15 ₂₆	30 ₅₀												
1.5	8.0	12				5 ₈	7 ₁₂	12 ₂₀	23 ₃₈	39 ₆₆											
2	2.4	16					5 ₈	8 ₁₃	16 ₂₆	27 ₄₅	41 ₇₁										
2.5	3.0	20						6 ₁₀	12 ₁₉	20 ₃₃	31 ₅₂	60 ₁₀₁									
3.2	3.7	25							9 ₁₅	14 ₂₄	23 ₃₈	44 ₇₃	76 ₁₂₆								
4.4	4.8	32								11 ₁₈	16 ₂₇	32 ₅₃	54 ₉₀	85 ₁₄₂							
5	6.0	40									12 ₂₁	23 ₃₈	39 ₆₆	62 ₁₀₃	121 ₂₀₂						
6.5	7.5	50										18 ₃₀	29 ₄₈	45 ₇₆	88 ₁₄₇	151 ₂₅₂					
8	9.4	63											22 ₃₇	33 ₅₅	70 ₁₁₇	109 ₁₈₂	173 ₂₈₈				
10	12.0	80												25 ₄₂	46 ₇₇	79 ₁₃₁	124 ₂₀₇	213 ₃₅₄			
12	15.0	100													35 ₅₉	58 ₉₆	91 ₁₅₁	155 ₂₅₈	302 ₅₀₄		
15	18.7	125														44 ₇₄	66 ₁₁₀	113 ₁₈₉	220 ₃₆₇	378 ₆₃₀	
20	24.0	160															50 ₈₃	81 ₁₃₅	158 ₂₆₃	269 ₄₄₈	425 ₇₀₉
25	30.0	200																62 ₁₀₄	115 ₁₉₂	197 ₃₂₈	310 ₅₁₇
37	37.5	250																	89 ₁₄₈	144 ₂₄₀	227 ₃₇₈
45	45.0	300																		120 ₂₀₀	173 ₂₈₈

The diagram illustrates a V-groove geometry. A downward force F is applied to the top of a block. The groove is defined by two inclined surfaces meeting at a central angle α . The width of the top surface is labeled B , and the depth of the groove is labeled V . The side angle of the groove is labeled S .



R=42 da N/mm² - R=70 da N/mm²