

R_B = RADIUS OF BENT-UP FLANGE
 α_B = ANGLE OF BENT-UP FLANGE
 R_S = RADIUS OF SPRING-BACK FLANGE
 α_S = ANGLE OF SPRING-BACK FLANGE

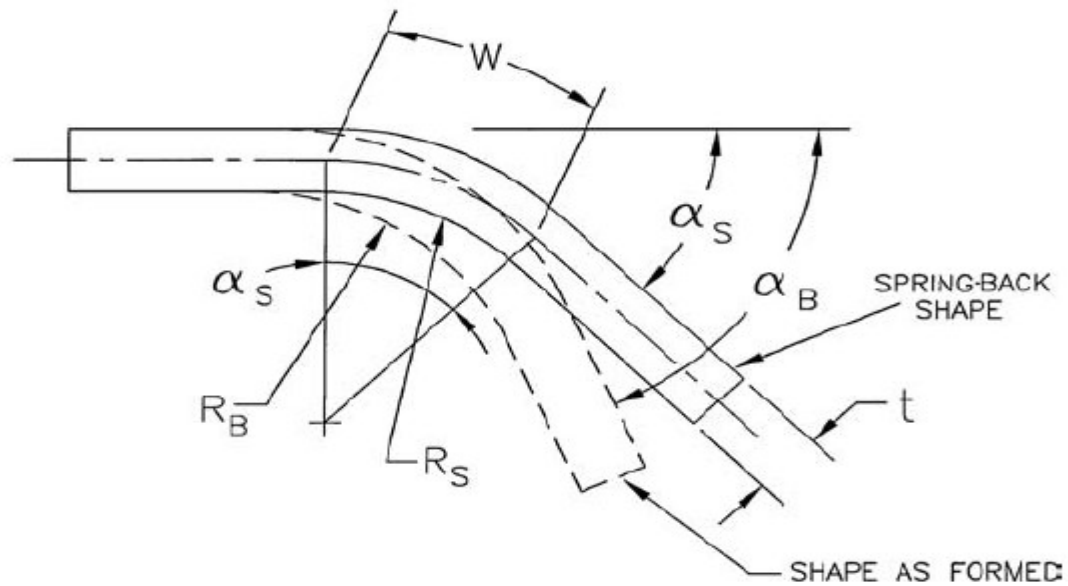


FIGURE 8-40 Springback.

Springback

Springback values for steel material

TABLE 8-8 Springback Values for Steel Material

Angle of the bend	Condition of material	Ratio R/t				
		1	2	4	6	10
30°	Annealed	1	1	3	4	7
30°	Hard	0	2	5	8	14
60°	Annealed	0	1	2	3	5
60°	Hard	0	1	3	5	8
90°	Annealed	0	0	1	2	4
90°	Hard	-1	0	2	3	7
120°	Annealed	-1	0	0	1	3
120°	Hard	-1	0	1	2	4

Source: Svatopluk Černoch, *Strojní technická příručka*, 1977. Reprinted with permission from SNTL Publishers, Prague, CZ.

(B)