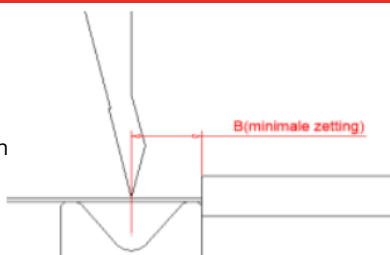


## Kantbank specificaties

| Materiaal<br>Staal (S235/S355) |             | Radius is bij benadering, het is een combinatie van plaatdikte en matrijs keuze.<br>Maximale lengte van de zetting in mm bij plaatdikte. |     |    |      |      |      |      |      |      |      |      |      |      |      |
|--------------------------------|-------------|------------------------------------------------------------------------------------------------------------------------------------------|-----|----|------|------|------|------|------|------|------|------|------|------|------|
| Matrijs                        | Matrijshoek | Radius                                                                                                                                   | B   | B2 | 1    | 1,5  | 2    | 3    | 4    | 5    | 6    | 8    | 10   | 12   | 15   |
| 6                              | 86          | 1,5                                                                                                                                      | 4   | 12 | 3000 |      |      |      |      |      |      |      |      |      |      |
| 8                              | 30          | 1,6                                                                                                                                      | 9,5 | 14 | 3000 |      |      |      |      |      |      |      |      |      |      |
| 10                             | 84          | 1,8                                                                                                                                      | 10  | 15 | 3000 | 3000 |      |      |      |      |      |      |      |      |      |
| 12                             | 30          | 2                                                                                                                                        | 12  | 15 | 3000 | 3000 | 3000 |      |      |      |      |      |      |      |      |
| 16                             | 84          | 3                                                                                                                                        | 16  | 25 |      | 3000 | 3000 |      |      |      |      |      |      |      |      |
| 20                             | 30          | 3,5                                                                                                                                      | 19  | 26 |      | 3000 | 3000 | 3000 |      |      |      |      |      |      |      |
| 24                             | 86          | 4                                                                                                                                        | 19  | 26 |      |      | 3000 | 3000 | 3000 |      |      |      |      |      |      |
| 30                             | 86          | 5                                                                                                                                        | 24  | 34 |      |      |      | 3000 | 3000 | 3000 |      |      |      |      |      |
| 40                             | 30          | 6                                                                                                                                        | 35  | 46 |      |      |      | 3000 | 3000 | 3000 | 3000 |      |      |      |      |
| 50                             | 86          | 9,5                                                                                                                                      | 42  | 56 |      |      |      |      | 3000 | 3000 | 3000 | 2200 |      |      |      |
| 60                             | 80          | 12                                                                                                                                       | 50  | 63 |      |      |      |      |      | 2000 | 2000 | 2000 | 1700 |      |      |
| 80                             | 80          | 13                                                                                                                                       | 62  | 82 |      |      |      |      |      |      | 3000 | 3000 | 2400 | 1600 |      |
| 120                            | 60          | 13                                                                                                                                       | 62  | 82 |      |      |      |      |      |      |      | 1000 | 1000 | 1000 | 1000 |
| Hemming/Pletten                |             | Minimale afstand in de tekening = 0,1 mm. Flenzen moeten vrij van elkaar getekend zijn.                                                  |     |    |      |      |      |      |      |      |      |      |      |      |      |
| SA 12.26                       |             | 2                                                                                                                                        | 12  | -  | 3000 | 2500 |      |      |      |      |      |      |      |      |      |

### B

Minimale afstand in mm vanaf hart van zetlijn tot buitenzijde werkstuk en gaten in het werkstuk



### B2

Minimale afstand in mm tussen meerdere zettingen

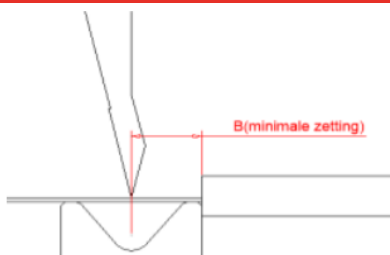


## Kantbank specificaties

| Materiaal<br>RVS (304/316) |             | Radius is bij benadering, het is een combinatie van plaatdikte en matrijs keuze.<br>Maximale lengte van de zetting in mm bij plaatdikte. |     |    |      |      |      |      |      |      |      |      |      |      |      |
|----------------------------|-------------|------------------------------------------------------------------------------------------------------------------------------------------|-----|----|------|------|------|------|------|------|------|------|------|------|------|
| Matrijs                    | Matrijshoek | Radius                                                                                                                                   | B   | B2 | 1    | 1,5  | 2    | 3    | 4    | 5    | 6    | 8    | 10   | 12   | 15   |
| 6                          | 86          | 1,5                                                                                                                                      | 4   | 12 | 3000 |      |      |      |      |      |      |      |      |      |      |
| 8                          | 30          | 1,6                                                                                                                                      | 9,5 | 14 | 3000 |      |      |      |      |      |      |      |      |      |      |
| 10                         | 84          | 1,8                                                                                                                                      | 10  | 15 | 3000 | 3000 |      |      |      |      |      |      |      |      |      |
| 12                         | 30          | 2                                                                                                                                        | 12  | 15 | 3000 | 3000 | 3000 |      |      |      |      |      |      |      |      |
| 16                         | 84          | 3                                                                                                                                        | 16  | 25 |      | 3000 | 3000 |      |      |      |      |      |      |      |      |
| 20                         | 30          | 3,5                                                                                                                                      | 19  | 26 |      | 3000 | 3000 | 3000 |      |      |      |      |      |      |      |
| 24                         | 86          | 4                                                                                                                                        | 19  | 26 |      |      | 3000 | 3000 | 3000 |      |      |      |      |      |      |
| 30                         | 86          | 5                                                                                                                                        | 24  | 34 |      |      |      | 3000 | 3000 | 3000 |      |      |      |      |      |
| 40                         | 30          | 6                                                                                                                                        | 35  | 46 |      |      |      | 3000 | 3000 | 3000 | 2600 |      |      |      |      |
| 50                         | 86          | 9,5                                                                                                                                      | 42  | 56 |      |      |      |      | 3000 | 3000 | 3000 | 1500 |      |      |      |
| 60                         | 80          | 12                                                                                                                                       | 50  | 63 |      |      |      |      |      | 2000 | 2000 | 2000 | 1200 |      |      |
| 80                         | 80          | 13                                                                                                                                       | 62  | 82 |      |      |      |      |      |      | 3000 | 2600 | 1650 | 1100 |      |
| 120                        | 60          | 13                                                                                                                                       | 62  | 82 |      |      |      |      |      |      |      | 1000 | 1000 | 1000 | 1000 |
| Hemming/Pletten            |             | Minimale afstand in de tekening = 0,1 mm. Flenzen moeten vrij van elkaar getekend zijn.                                                  |     |    |      |      |      |      |      |      |      |      |      |      |      |
| SA 12.26                   |             | 2                                                                                                                                        | 12  | -  | 3000 | 2500 |      |      |      |      |      |      |      |      |      |

### B

Minimale afstand in mm vanaf hart van zetlijn tot buitenzijde werkstuk



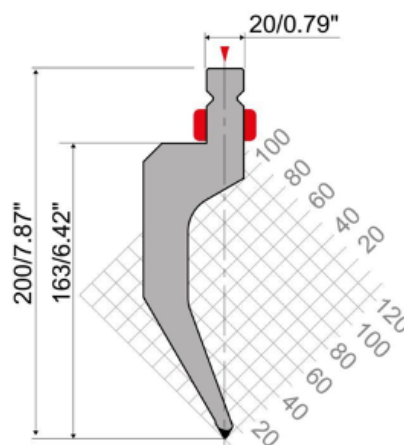
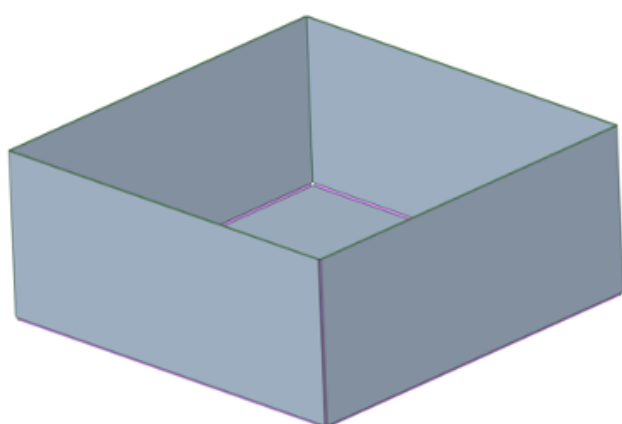
### B2

Minimale afstand in mm tussen meerdere zettingen



## Kantbank specificaties

**Maximale bakhoogte = 170 mm**

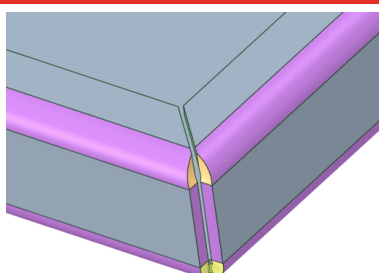


**Minimale afstand tot zetlijn om vervorming gaten te voorkomen**



| Matrijs | Afstand |
|---------|---------|
| V08     | 8       |
| V10     | 9       |
| V12     | 10      |
| V16     | 12      |
| V20     | 15      |
| V24     | 18      |
| V30     | 21      |
| V40     | 28      |
| V50     | 31      |
| V60     | 39      |
| V80     | 49      |

**Minimale ruimte tussen 2 zettingen**



|                 |        |
|-----------------|--------|
| Tot en met 3 mm | 0,5 mm |
| Van 4 t/m 6 mm  | 1,0 mm |
| Van 7 t/m 10 mm | 1,5 mm |