

## Plate bending

Kersten Europe rolls plates of ferrous and non-ferrous metals into dishes, cylinders and cones. Where specific demands are made regarding the durability, corrosion and heat resistance of the material, we process special alloys such as Creusabro, Hardox, Duplex, Inconel and cladding materials. We are also qualified to carry out various welding processes, including OP welding. The rolled shells or scale divisions can subsequently be assembled and welded to industrial standards.

### Rolling Capacities: Maximum cylinder length per plate thickness in mm - material quality S235.

Plate thickness	2-5	6	8	10	12	14	15	18	20	23	30	35	40	45	50	55	60	70	80	90	100	
190	1000	700	500	350	300																	
200	1000	700	500	350	300																	
225	1500	1000	700	500	400																	
250	2000	2000	1100	700	500	350	300	200														
275	2000	2000	1100	700	500	350	300	200														
300	2500	2000	1100	700	500	350	300	200														
320	2500	2500	2500	2500	2000	1450	1250	900	700													
350	2500	2500	2500	2500	2000	1450	1250	900	700													
375	2500	2500	2500	2500	2000	1450	1250	900	700													
390	2500	2500	2500	2500	2500	2500	2500	1600	1300	1000	550	400	300	250								
425	2500	2500	2500	2500	2500	2500	2500	1600	1300	1000	550	400	300	250								
450	3500	3500	3500	3500	3500	3500	3500	2400	1950	1450	850	600	450	350	300	250						
500	3500	3500	3500	3500	3500	3500	3500	2500	2000	1550	900	650	500	400	300	250						
550	3500	3500	3500	3500	3500	3500	3500	2600	2100	1600	950	700	500	400	300	250						
575	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2500	2000	1500	1250	1000	850	650				
600	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2500	2000	1500	1250	1000	850	650				
650	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2500	2000	1500	1250	1000	850	650				
700	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2500	2000	1500	1250	1000	850	650				
750	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2500				
800	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2500				
850	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2500				
900	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2600				
950	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2600				
1000	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2600	2000			
1250	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2600	2000			
1500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2700	2100	1600		
2000	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2800	2100	1700	1400	
2500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	2900	2200	1700	1400	
3000	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3000	2300	1800	1500	
3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3500	3100	2400	1900	1500	

Thicker or smaller diameter? We can press it with our 2400T Power Press up to 150 mm over 3,3 m width.



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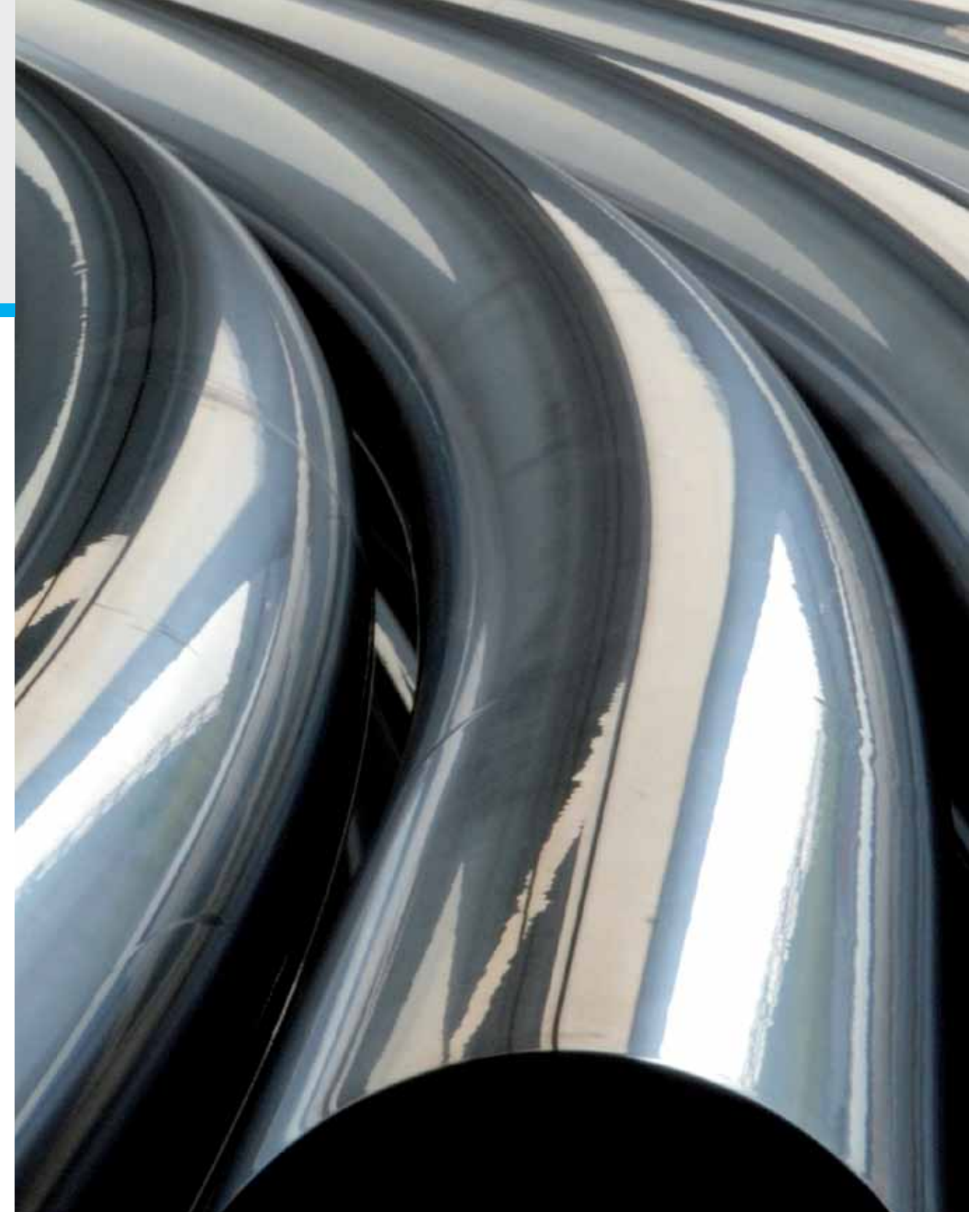
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## KERSTEN EUROPE: ACHIEVING MORE WITH BENDING TECHNOLOGY

OVER TIME KERSTEN EUROPE HAS EVOLVED FROM A PURE BENDING SERVICE INTO AN ALL-ROUND PARTNER. BESIDES ENGINEERING AND BENDING WE ALSO PROVIDE VARIOUS ADDITIONAL PROCESSES. WE CAN FURTHER PROCESS BENT PRODUCTS, AND POSSIBLY APPLY SURFACE TREATMENTS. THIS COST SAVING, ALL-UNDER-ONE-ROOF SERVICE GUARANTEES HIGH QUALITY PRODUCTS.



## Profile bending

The cold bending of standard and client-specific profiles in ferrous and non-ferrous alloys.

- The complete series of standard construction profiles – varying from UNP 80 to and including HEA 1000.
- The bending of various dimensions of pipe and tube profile with small radii.
- The rolling of client-specific framed or roller shaped profiles.
- 3D bending, with radius and pitch, of both light and heavy profiles, for constructions including staircases and rollercoaster rails.
- Application of our bent profiles in sectors including: steel architectural construction, infrastructure, machine building, and the petrochemical and offshore sector.

## Plate bending

The cold bending of plate material in ferrous and non-ferrous alloys.

- The production of cylinders, dishes and cones.
- Plate thicknesses vary from 0.5 mm to 100 mm.
- The maximum roller width is 3500 mm.
- We also process special alloys (such as Creusabro, Hardox, Duplex, Inconel and clad materials) if special demands are stipulated for the durability and the corrosion and heat resistance of the material.
- The bending of various special shapes, such as concentric and eccentric cones, extensions, column plating and corner segments.

## Aluminium bending

The cold bending of standard and client-specific aluminium profiles.

- CNC bending of aluminium extrusion profiles in standard alloys (EN-AW6063) and special alloys (including EN-AW7020).
- The bending of large extrusion profiles with a diameter of 800 mm maximum.
- Experience in the bending of standard system profiles from prominent suppliers.
- Specialist in the bending of profiles with several radii or 3D bent profiles.
- Application of our bent profiles in sectors including train construction, the automobile and construction industry, wall building and the medical sector.

For a more detailed overview of our capacity and the services we provide please visit [www.kersteneurope.com](http://www.kersteneurope.com)

## Profile bending

	Profile bending capacity		Dimension	Min. radius (internal)	Extra length per side
UNP strong axis (x-x)		Min Max	30 400	200 4000	250 1600
UNP weak axis (y-y)		Min Max	30 400	100 450	150 600
UNP weak axis (y-y)		Min Max	30 400	100 500	150 600
INP strong axis (x-x)		Min Max	80 600	300 7500	250 1750
INP weak axis (y-y)		Min Max	80 600	150 750	100 1000
IPE strong axis (x-x)		Min Max	80 600	350 7500	300 1750
IPE weak axis (y-y)		Min Max	80 600	150 2500	100 1500
½ IPE/INP		Min Max	80 600	150 2000	300 1000

	Profile bending capacity		Dimension	Min. radius (internal)	Extra length per side
½ IPE/INP		Min Max	80 600	150 2000	300 1000
HEA strong axis (x-x)		Min Max	100 800	500 15.000	500 1600
HEA weak axis (y-y)		Min Max	100 1000	450 1500	300 1500
HEB strong axis (x-x)		Min Max	100 800	550 1800	800 1600
HEB weak axis (y-y)		Min Max	100 1000	400 1200	300 1500
HEM strong axis (x-x)		Min Max	100 700	600 25.000	800 1500
HEM weak axis (y-y)		Min Max	100 1000	500 1500	300 1600
Equal sided corner		Min Max	20x20x3 250x250x24	100 5000	100 1500
Equal sided corner		Min Max	20x20x3 250x250x24	150 5000	100 1500
Equal sided corner		Min Max	20x20x3 250x250x24	100 5000	300 1500
Equal sided corner		Min Max	20x20x3 250x250x24	150 5000	300 1500
Unequal sided corner		Min Max	30x20x3 250x90x10	150 1000	300 1000
Unequal sided corner		Min Max	30x20x3 250x90x10	150 800	300 1000
Unequal sided corner		Min Max	30x20x3 250x90x10	100 600	300 1000
Unequal sided corner		Min Max	30x20x3 250x90x10	150 600	300 1000
T-section		Min Max	20x20x3 140x140x15	150 750	150 450
T-section		Min Max	20x20x3 140x140x15	150 700	150 450
T-section		Min Max	20x20x3 140x140x15	150 750	150 450
Rectangular box section strong axis (x-x)		Min Max	20x10x1.5 450x250x12,5	200 8000	150 1500
Rectangular box section weak axis (y-y)		Min Max	20x10x1.5 450x250x16	150 3000	150 1500
Square box section		Min Max	15x15x2 400x400x20	200 8000	150 1500
Tube		Min Max	13.5x2.35 610x25	100 Variant?	120 Phone/email us
Flat/bar strong axis (x-x)		Min Max	12x3 400x30	150 2000	150 1500
Flat/bar weak axis (y-y)		Min Max	12x3 500x30	100 250	150 500
Large square		Min Max	6 200	150 750	150 1500
Large tube		Min Max	6 200	100 2000	150 1500