



Benda Method Specifications

	Ultra-small Diam.	Small Diam.	Medium Diam.	Large Diam.
Manufacturable inner diam.	$\varphi 50$ to 150	$\Phi 130$ to 200	$\Phi 200$ to 550	$\Phi 300$ to 2000
Thickness t	5.5 t to 28.0 t	19.0t to 34.0t	5.5t to 19.0t	5.5t to 50.0 t
Width W	Max. $t \times W = 408$ Example: $24.5t \times 16W$	$8.0W$ to $16.0W$	$19.0t \times 41.0W$	$23.8W$ to $39.0W$
				
Number of processes	8	8	8	6 to 7
Yield	97%	92%	94%	94%
Types of metals with actual bending results	SCr415H SCr420H	S25C	SS400 S20C to S50C SUJ2	S45C S48C
Main products	Transmission parts, etc.	Clutch hub	Ring gears and bearings for automobiles, agricultural machines, outboard engines	Ring gears for construction machines and ships