

JB

**INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

JB/T 5109-2001

Replacing JB/T 5109-1991

Process design specification for sheet metal bending

金属板料压弯工艺设计规范

(English Translation)

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1 Scope

This standard specifies technological parameters and specification for technological design of bending for sheet metal.

This standard is applicable to cold bending forming of sheet metal on the press machine.

2 Normative References

The following standards contain provisions which, through reference in this standard, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below.

GB/T 4863-1985 General Terminology of Machine-Building Technology

GB/T 13914-1992 Tolerance of Dimensions for Stampings

GB/T 13915-1992 Tolerance of Angles for Stampings

GB/T 13916-1992 Unnoted Tolerance of Shape and Position for Stampings

GB/T 15055-1994 Permissible Stamping Variations in Dimensions without Tolerance Indication

3.1.1 Marking of bending radius

In dimensioning of bending parts, fillet radius shall be indicated.

3.1.2 Minimum bending radius

The minimum bending radius is the fillet radius of bending parts when the outer fiber of workblank produces no crack.

The minimum bending radius is only applied when necessary, and the bending radius shall be appropriately increased in all other cases.