

Bending Schedules

IronMaster PROJECTS will cut and bend the bar according to the bending schedules supplied by the customer. All bending schedules should refer to the standard Shape Codes as per the table shown:

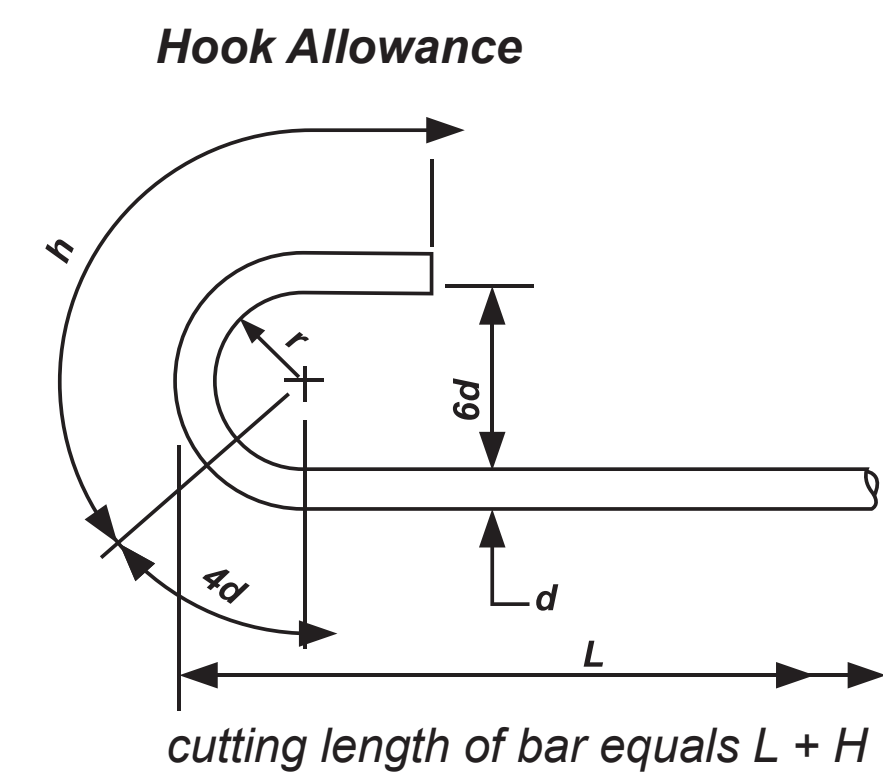
SANS 282: Edition 6

NOTE 1: Use shape code 99 for all other shapes. A dimensioned sketch of the shape shall be given in the bending schedule.
NOTE 2: Radii of all bends are standard unless is given in the bending schedule.
NOTE 3: All dimensions are external (outside) dimensions.

Cutting & Bending Tolerances

Critical radii

Nominal size of bar (mm)	Critical radius (m)
8	2.5
10	3
12	3.5
16	5
20	7
25	17
32	43



Any radius that is less than the critical radius stated, should be bent by mechanical process otherwise it should be bent on site during installation.

Method of forming	Length	Tolerance (mm)
Cutting	Straight lengths (including reinforcement for subsequent bending)	± 25
	Bending	
	1000mm	± 5
	1000 ... 2000mm	+5
		-10
	2000mm	+5
		-25

Minimum hook, bend and radius allowances for high yield stress steel bars and cold worked steel bars that comply with SANS 920

Nominal size of bar d	6	8	10	12	16	20	25	32	40
Hook allowance h	100	100	120	160	200	240	300	400	480
Bend allowance n	100	100	100	100	120	140	180	220	260
Radius r	18	24	30	36	48	60	75	96	120

Installation / Steel Fixing

Co-ordination of deliveries in conjunction with an agreed programme is undertaken by IronMaster PROJECTS's competent team of contract management and fixing services to meet customer installation requirements.

FOR MORE INFORMATION, PLEASE CONTACT US HERE

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