

d	Wire diameter	0.15	mm		R _m	Tensile strength of drawn wire	3,600.0	MPa	
R	Bending radius of gear head	0.30	mm		Re	Yield point ratio Re/R _m	90%		
Ampl	Amplitude of structured wire	0.17	mm		Re	Yield strength of drawn wire	3,240.0	MPa	
Wavelength	Wavelength of structured wire	3.10	mm		E	Modulus of elasticity of drawn wire	195,000.0	MPa	
alpha of structure	Bending angle of structure	0.10924079	rad		Ad	Area of semicircle	0.008836	mm ²	
ε _{structure}	Required elongation of outer fiber of structure	20.0%				Area of plastic elongation	0.007995	mm ²	10%
ε _F	Elongation at yield point	1.7%							
ε _P	Plastic elongation for structure	18.3%			R _{ea}	Residual stress of outer fiber	1,500.0	MPa	
a	Distance from center line to yield point	5.61	μm		a _{rs}	Depth of residual stress of outer fiber	3.0	μm	
ε _E	Forced elongation after load removal	3.3%			R _{ei}	Residual stress at wire core	-128.9	MPa	
					ε _N	Elongation of outer fiber due to residual stress	0.8%		
ε _{AF}	Residual elongation of outer fibers of structure	-1.6%			ε _N	Elongation at wire core due to residual stress	-0.1%		
ε _a	Residual elongation at maximum tension at a	-1.5%							
b	Distance from edge to residual stress=0	-35.36	μm		F _N	Tensile force during structuring	8	N	
					σ _N	Normal tension during structuring	452.7	MPa	
					ε _N	Elongation due to normal tension	0.2%		

Fig. 1