

The invention relates to working of metals by pressure, in particular to the production of bent profiles with elements of double thickness. A method includes multipass bending of the flat elements of the bend in the rolls of roll-forming machine, making of bending point with a radius equal to $(7-15)S$ in the area of bending at $0-90^\circ$ with subsequent decrease to 0 in the area of bending at $90^\circ-180^\circ$.