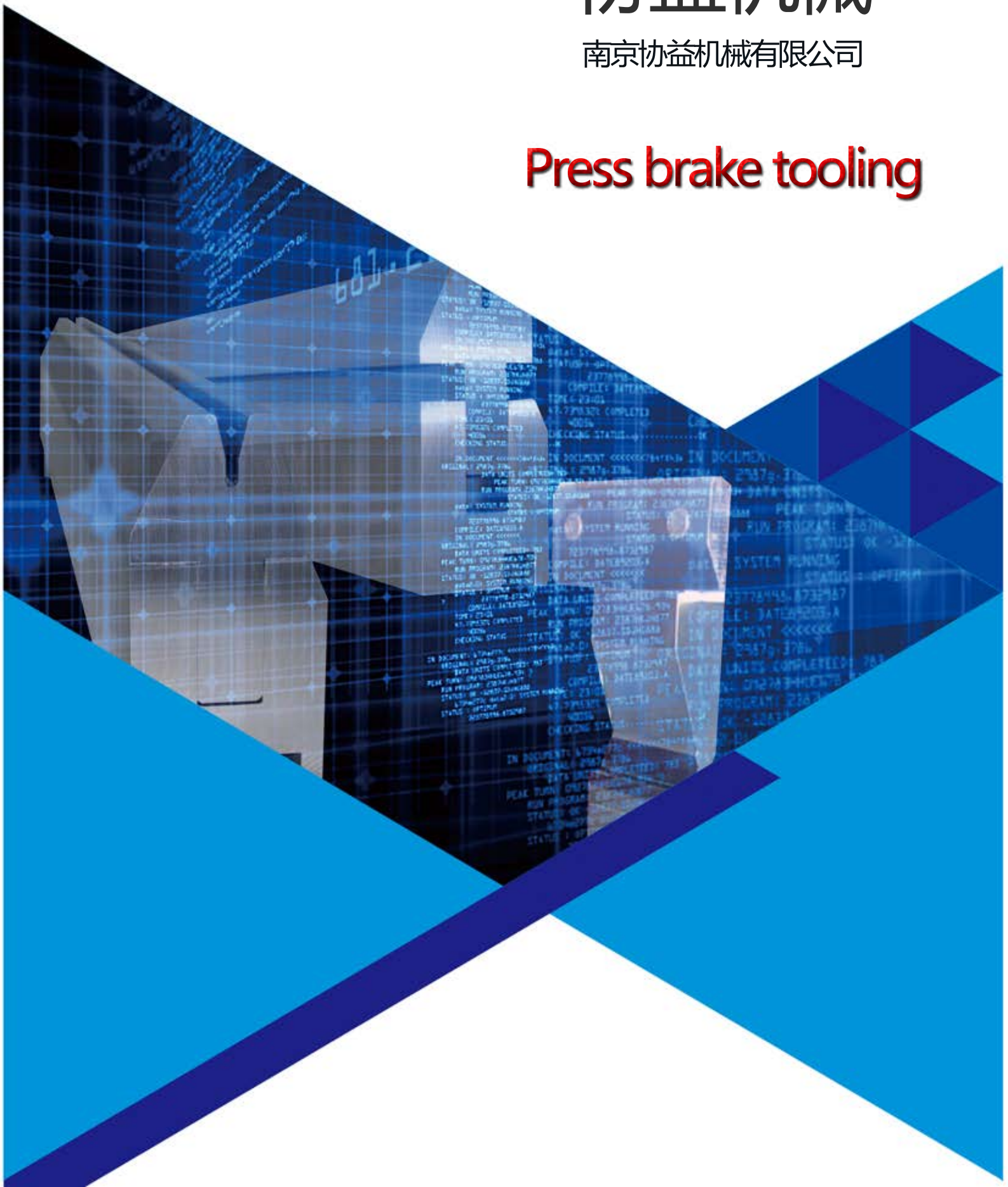


HARSLE[®]

协益机械

南京协益机械有限公司

Press brake tooling



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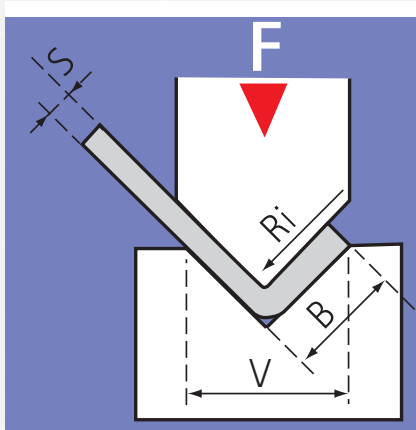
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Calcolo della forza di piega in aria

Calculation of force for air bending



$$F = \frac{S^2 \times 2 \times R}{1.4 \times V} = \dots \text{ ton/m}$$

S	Spessore lamiera - mm Thickness of the sheet - mm
V	Larghezza del V V-opening
F	Forza in T/m Force in T/m
B	Bordo minimo Shortest edge
Ri	Raggio interno Inside radius
R	Alluminio 20-25 kg/mm ² Alluminium 20-25 kg/mm ²
R	Acciaio dolce 40-45 kg/mm ² Mild steel 40-45 kg/mm ²
R	Inox 65-70 kg/mm ² Stainless steel 65-70 kg/mm ²

Relazione tra spessore lamiera e larghezza V
Sheet thickness/V-shape width ratio

S	Spessore lamiera - mm Sheet thickness - mm	0,5-2,5	3-8	9-10	12 o più 12 or more
V	Larghezza del V "V" width	6 S	8 S	10 S	12 S

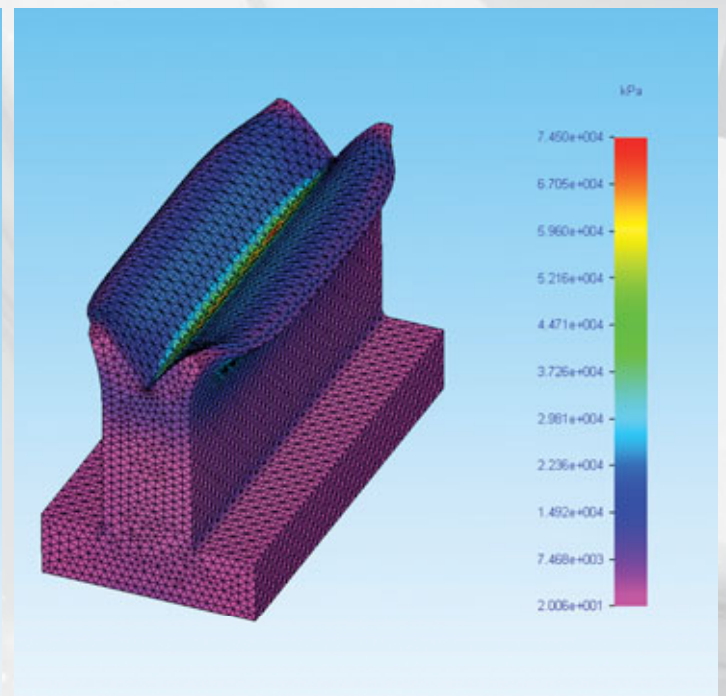
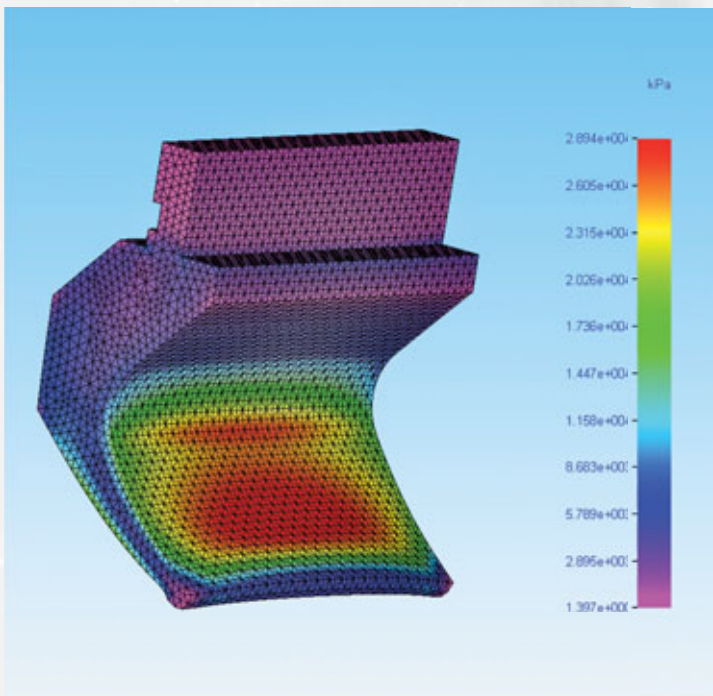


Tabella di piegatura in aria - Acciaio dolce / Air bending table - Mild Steel

S	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V	
	2,8	4	5	5,5	7	8,5	10	11	13,5	14	17,5	22	28	35	45	55	71	89	113	140	175	B	
	0,7	1	1,1	1,3	1,6	2	2,3	2,6	3	3,3	4	5	6,5	8	10	13	16	20	26	33	41	Ri	
mm																							
0,5	4	3																					
0,6	6	4	4	4																			
0,8		7	7	5	4																		
1		11	10	8	7	6																	
1,2			14	12	10	8	7	6															
1,5				20	17	15	13	11	10	9													
2						22	19	17	15	13	11												
2,5								28	25	22	18	14											
3									34	30	24	19	15										
3,2										34	27	22	17	14									
3,5											33	26	20	16	13								
4											43	34	27	21	17								
4,5												44	34	27	21								
5												52	42	33	26	21							
6													60	48	38	30	24						
8													107	85	68	53	43						
10															85	67	53	42					
12																	96	78	60	55			
15																	150	120	95	75			
20																		215	170	135	108		
25																					210	170	
30																						240	

F
t/m

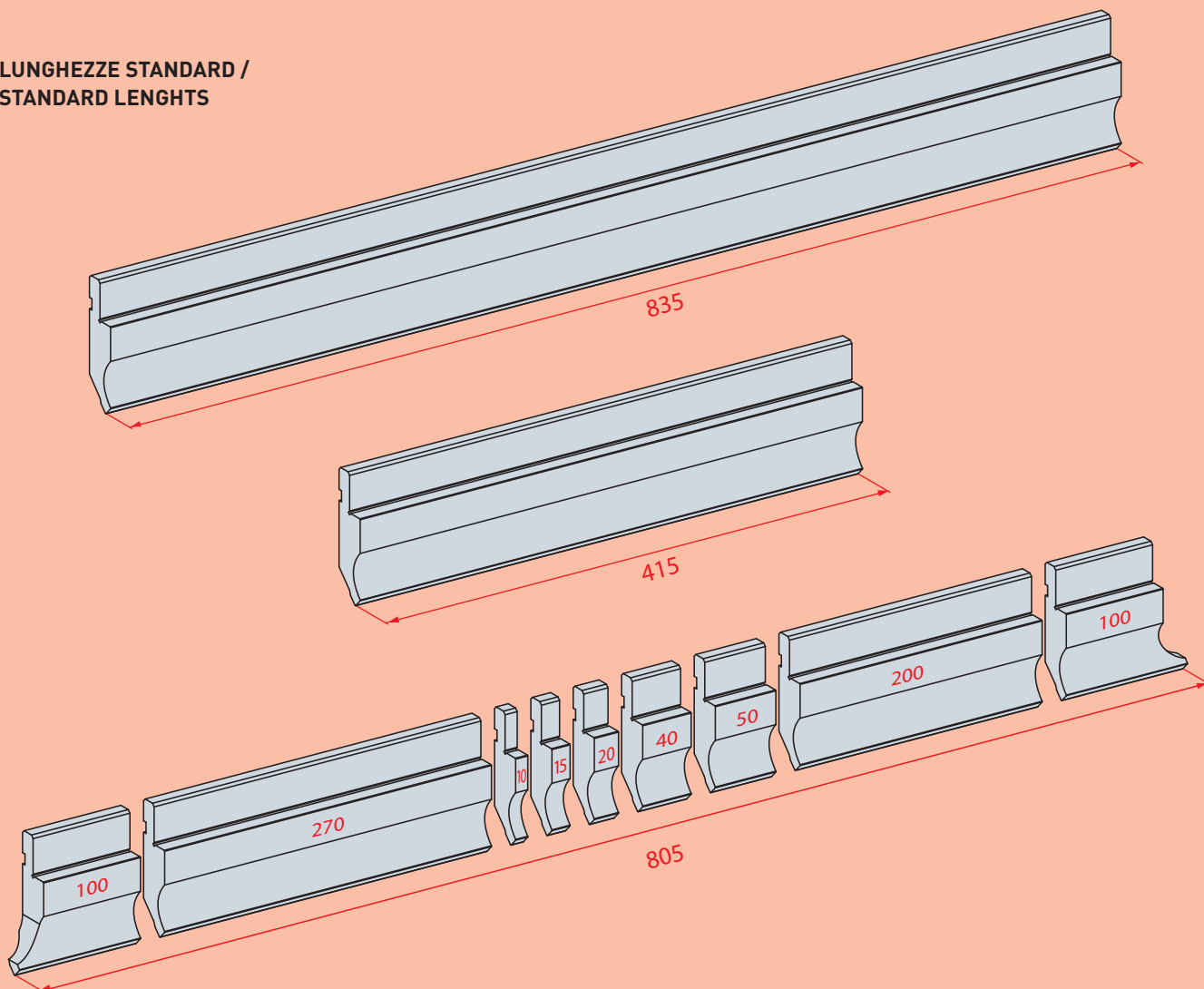
Tabella di piegatura in aria - Acciaio inox / Air bending table - Stainless Steel

S	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V	
	2,8	4	5	5,5	7	8,5	10	11	13,5	14	17,5	22	28	35	45	55	71	89	113	140	175	B	
	0,7	1	1,1	1,3	1,6	2	2,3	2,6	3	3,3	4	5	6,5	8	10	13	16	20	26	33	41	Ri	
mm																							
0,5	6	5																					
0,6	9	6	6	6																			
0,7	12	8	8	6	6																		
0,8		11	11	8	7																		
0,9		13	12	10	8	7																	
1		17	15	12	11	8																	
1,2			21	18	15	12	11	9															
1,5						20	17	15	13	12													
2						33	29	26	23	20	17												
2,5								39	35	30	25	19											
3									51	45	36	29	23										
4											65	51	41	32	26								
5												78	63	50	39	32							
6													90	72	57	45	36						
8															102	81	65	51					
10																129	101	80	63				
12																	144	117	90	83			
15																		180	141	114			
20																			250	208	167		
25																					315	255	
30																						360	

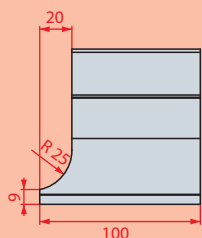
F
t/m

PUNZONI / PUNCHES

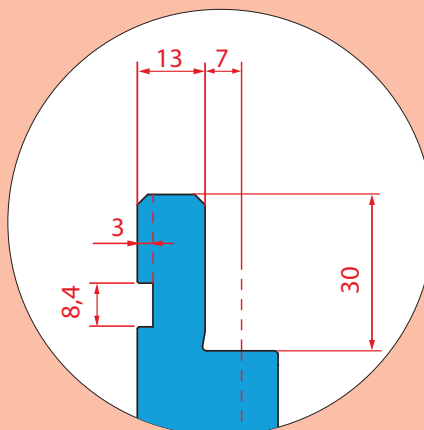
LUNGHEZZE STANDARD /
STANDARD LENGTHS



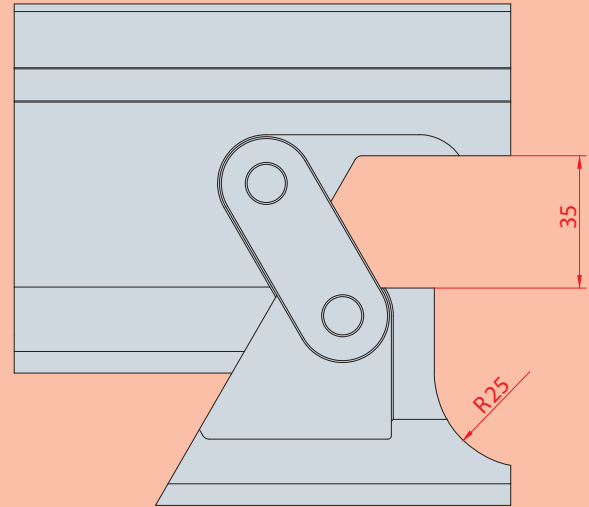
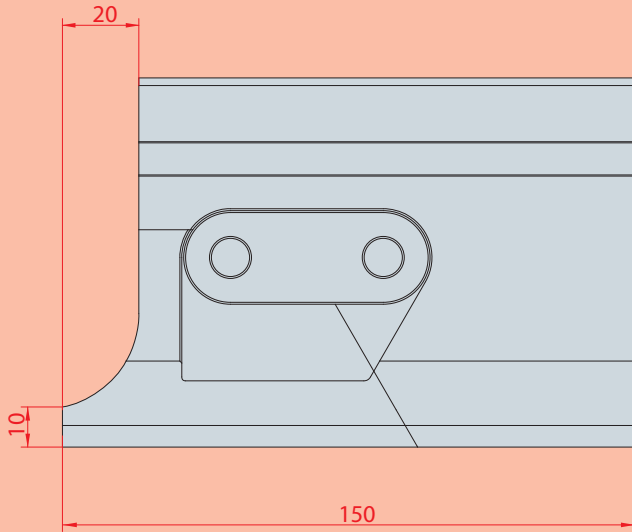
FRAZIONATURA STANDARD /
STANDARD SECTIONING



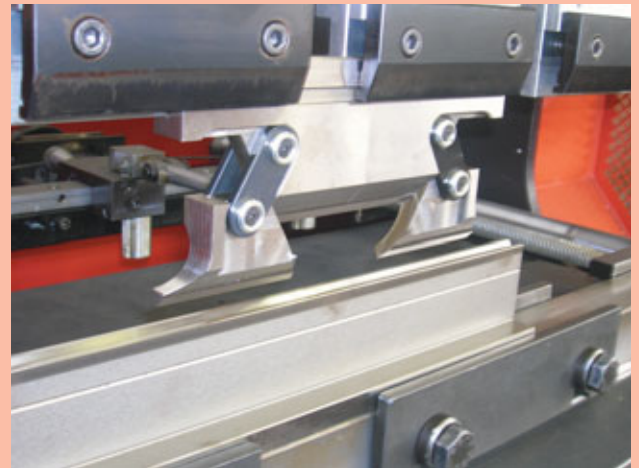
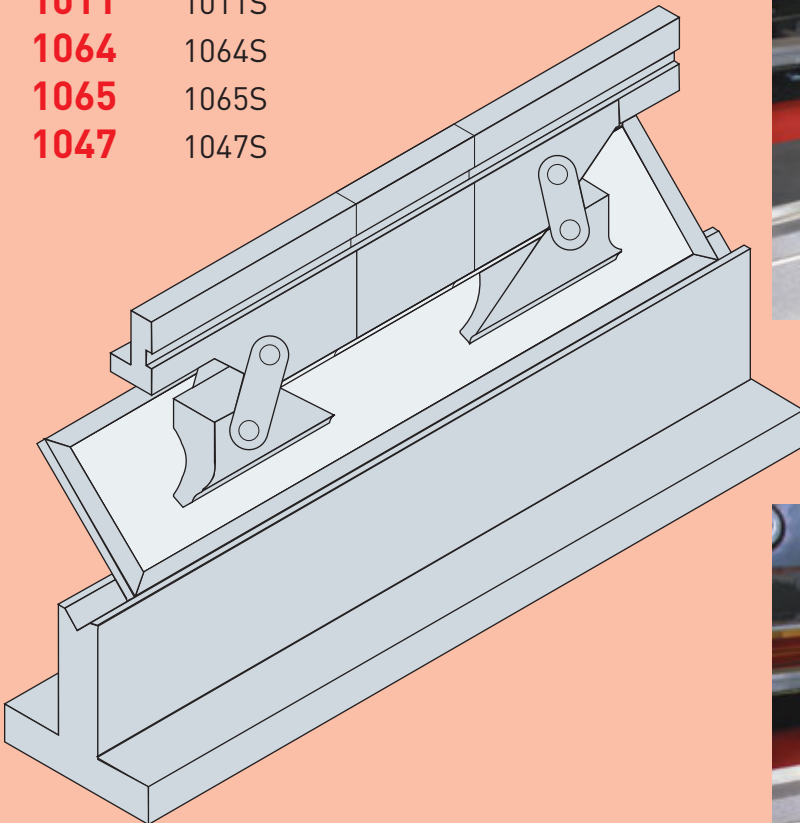
FRESATURA SCARPETTA
MILLING HORN



SCARPETTE MOBILI / MOVING HORNS

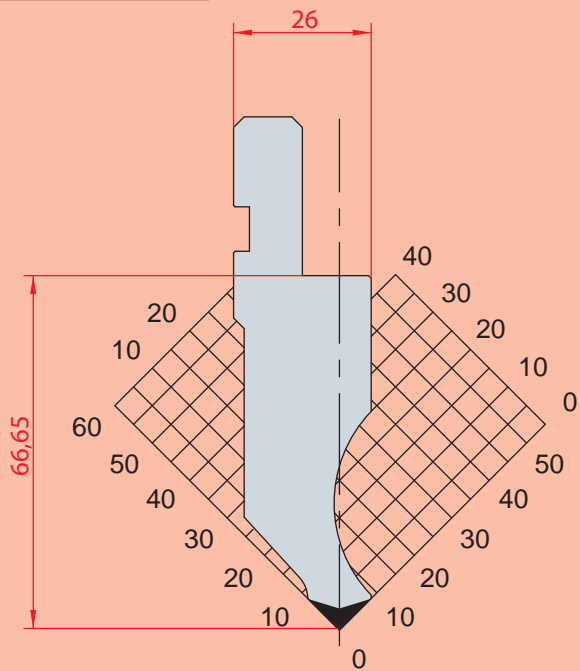


Punzone Punch	Scarpetta mobile Moving Horns
1010	1010S
1011	1011S
1064	1064S
1065	1065S
1047	1047S



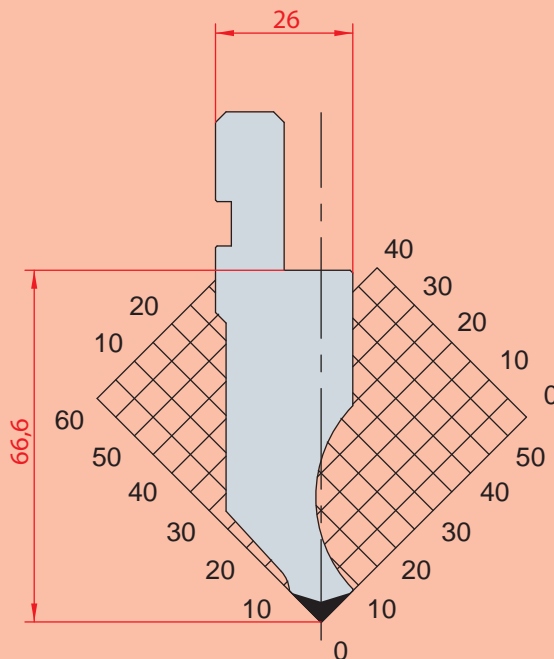
PUNZONI - 90° / PUNCHES - 90°

- C45 bonificato /quenched
- 42CrMo4
- C45



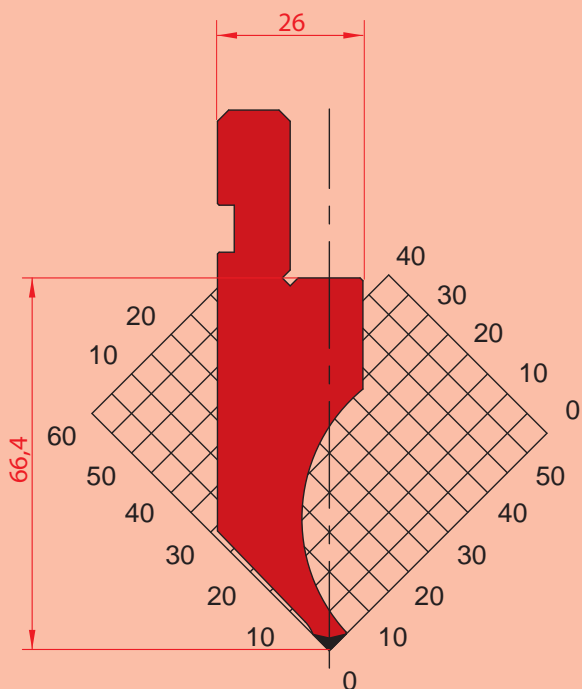
1010

$\alpha=90^\circ$ R=0.8 H=66.65 Max T/m=100



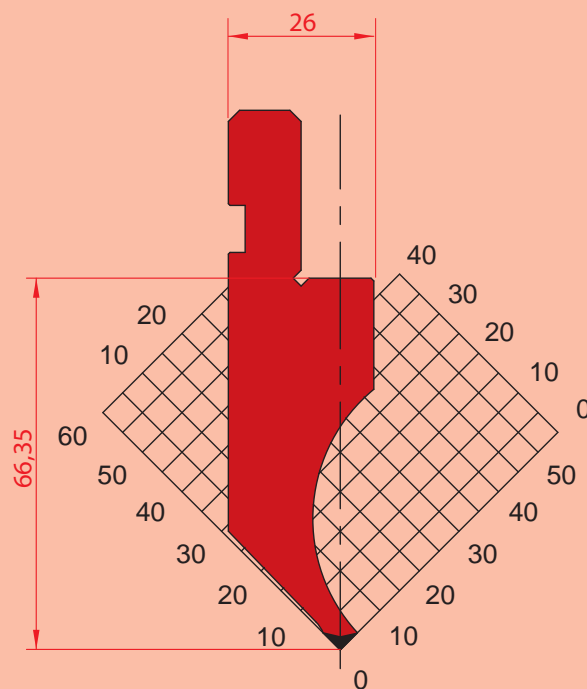
1064

$\alpha=90^\circ$ R=0.25 H=66.60 Max T/m=100



1048

$\alpha=90^\circ$ R=0.6 H=66.40 Max T/m=35

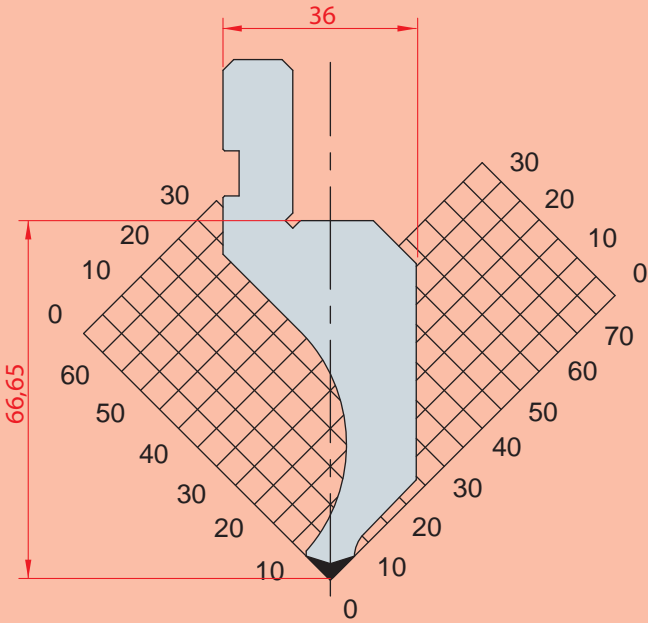


1263

$\alpha=90^\circ$ R=0.25 H=66.35 Max T/m=35

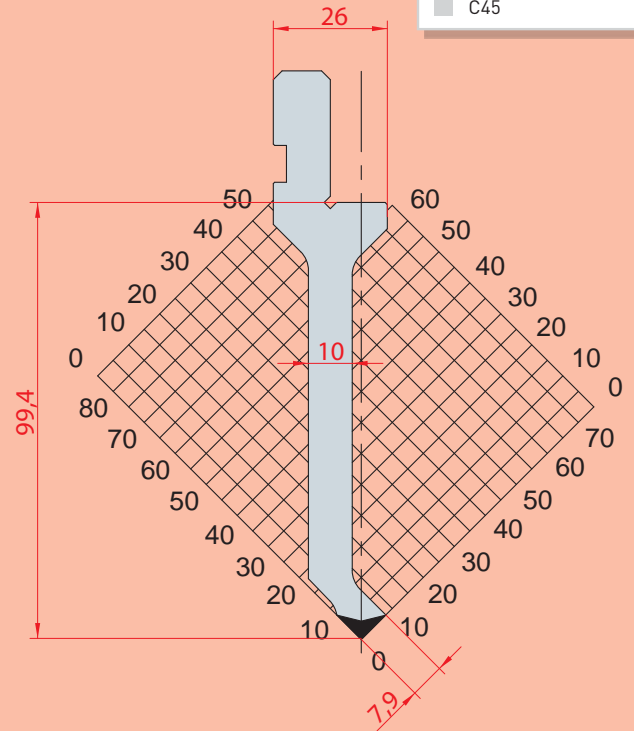
PUNZONI - 90° / PUNCHES - 90°

■ C45 bonificato /quenched
■ 42CrMo4
■ C45



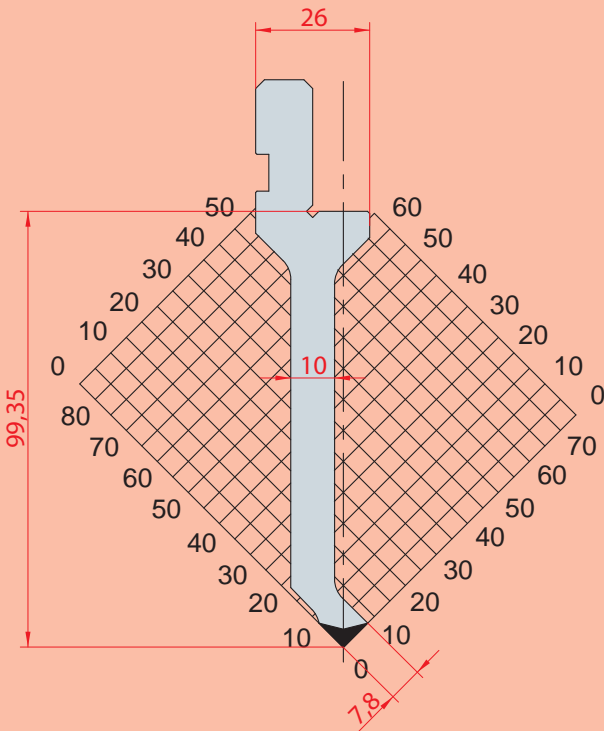
1080

$\alpha=90^\circ$ R=0.8 H=66.65 Max T/m=60



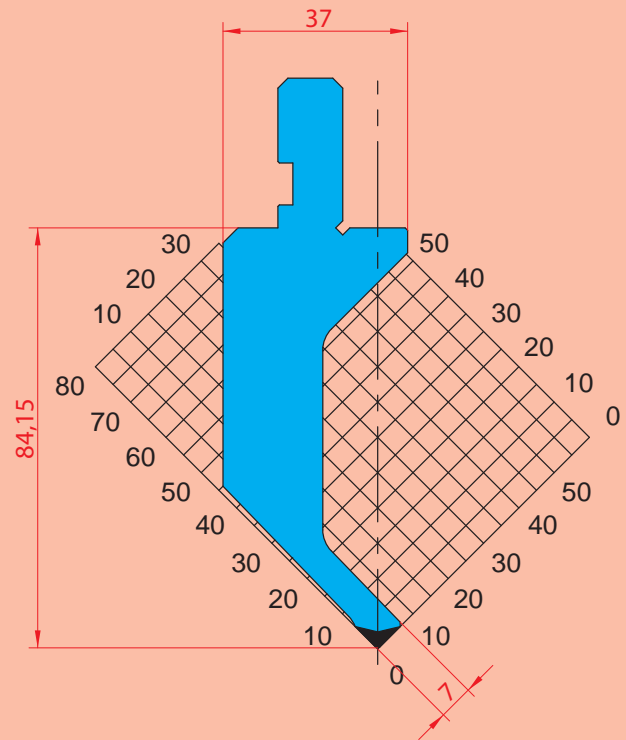
1028

$\alpha=90^\circ$ R=0.6 H=99.40 Max T/m=50



1261

$\alpha=90^\circ$ R=0.25 H=99.35 Max T/m=50

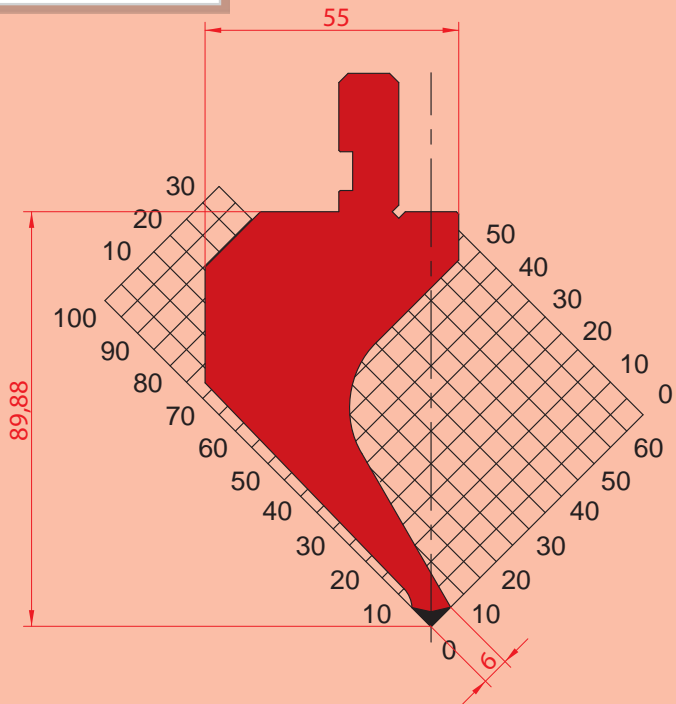


1019

$\alpha=90^\circ$ R=0.6 H=84.15 Max T/m=20

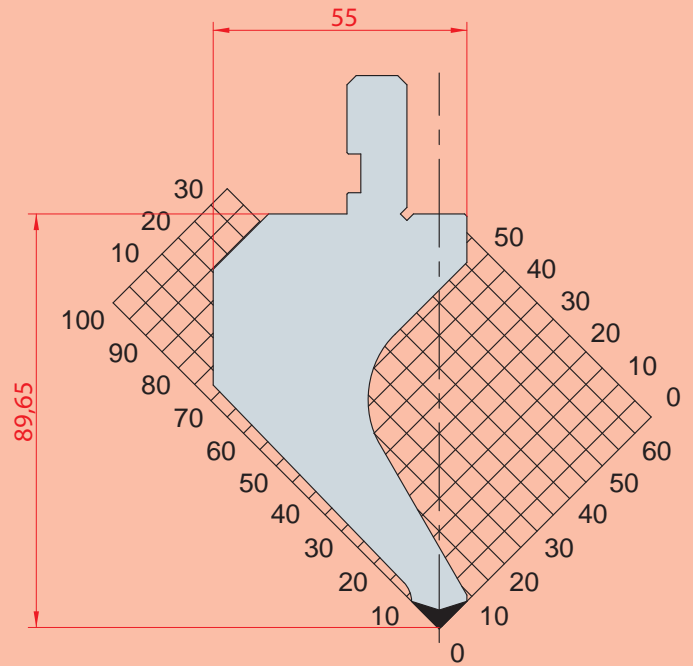
PUNZONI - 90° / PUNCHES - 90°

- C45 bonificato /quenched
- 42CrMo4
- C45



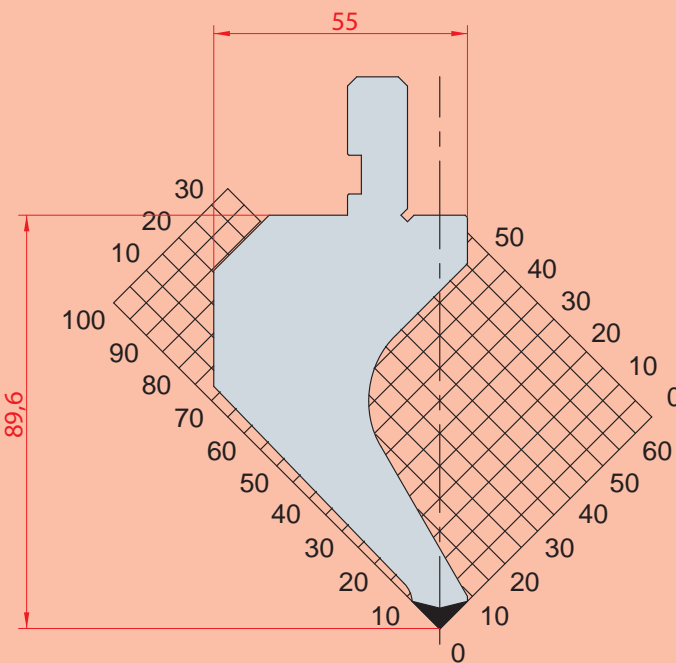
1176

$\alpha=90^\circ$ R=0.25 H=89.88 Max T/m=50



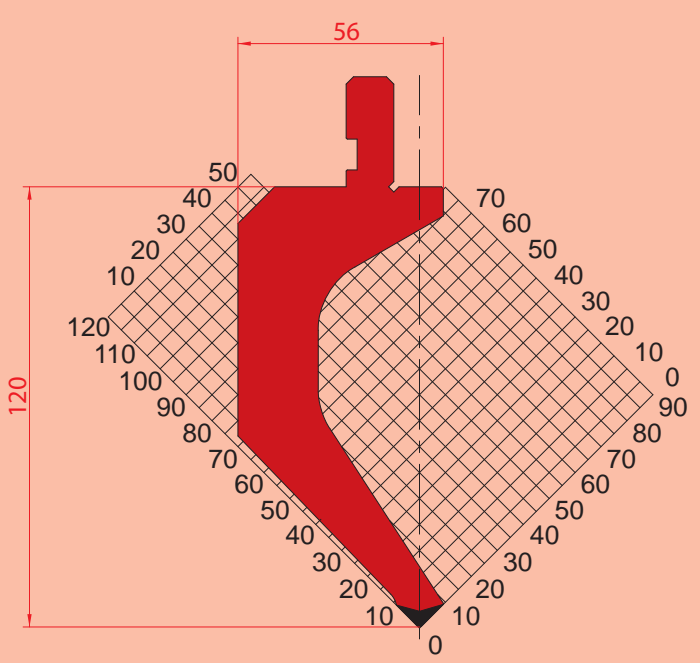
1013

$\alpha=90^\circ$ R=0.8 H=89.65 Max T/m=60



1265

$\alpha=90^\circ$ R=0.25 H=89.60 Max T/m=60

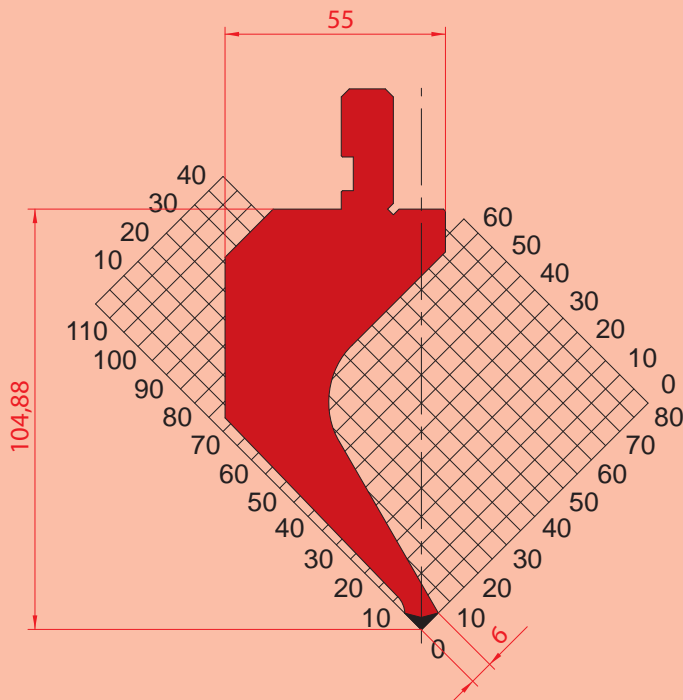


1060

$\alpha=90^\circ$ R=0.8 H=120.00 Max T/m=50

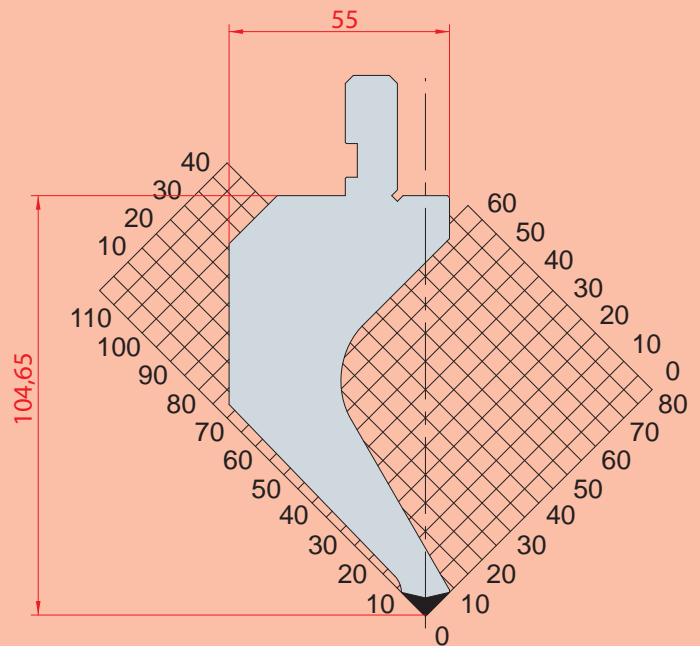
PUNZONI - 90° / PUNCHES 90°

- C45 bonificato /quenched
- 42CrMo4
- C45



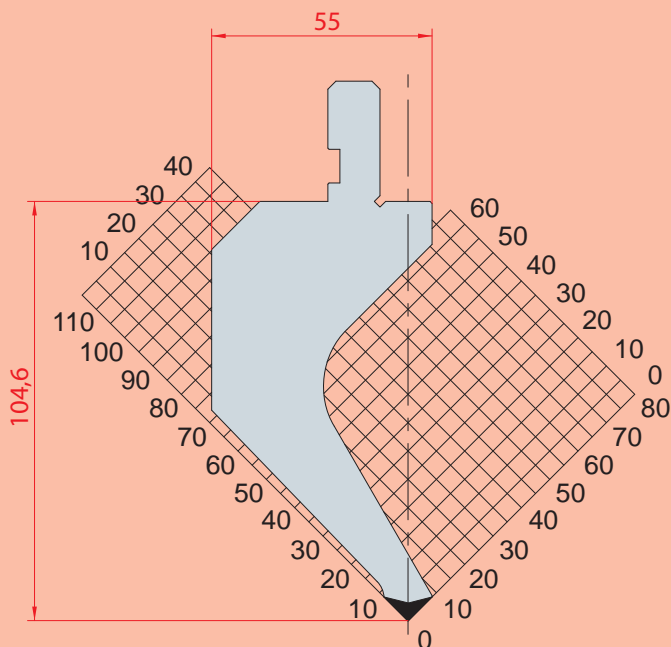
1174

$\alpha=90^\circ$ R=0.25 H=104.88 Max T/m=50



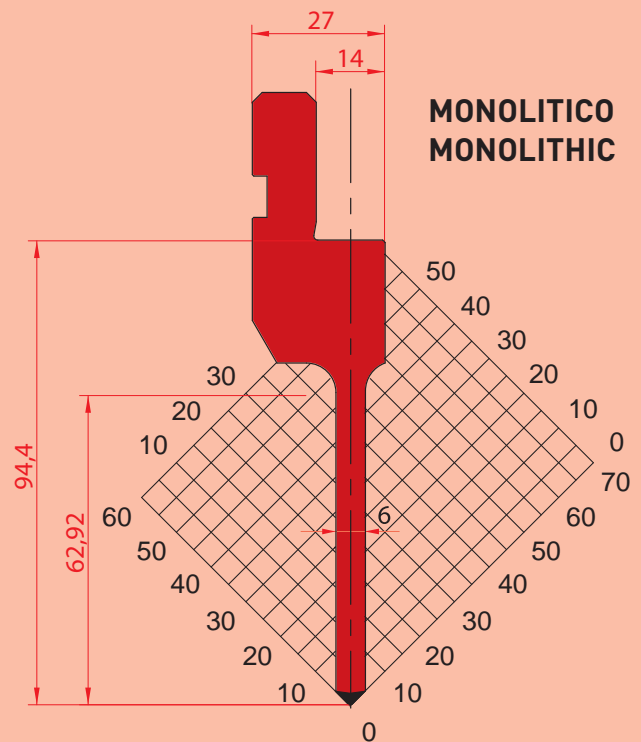
1016

$\alpha=90^\circ$ R=0.8 H=104.65 Max T/m=50



1267

$\alpha=90^\circ$ R=0.25 H=104.60 Max T/m=50

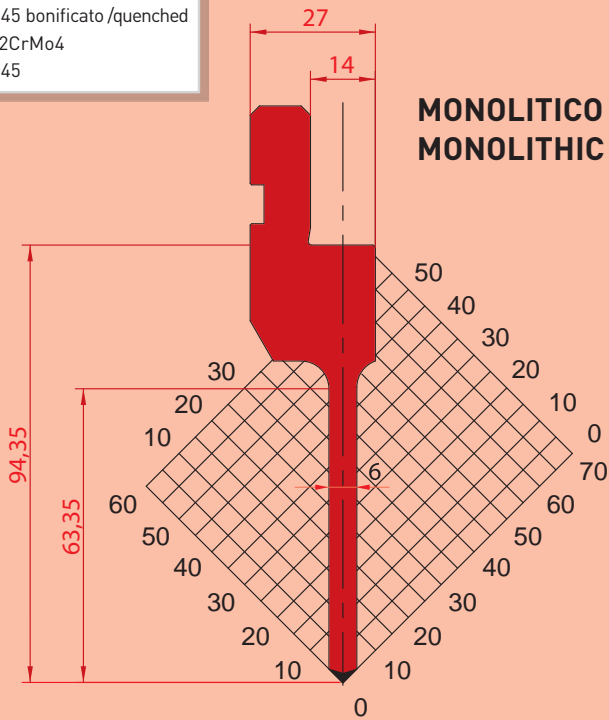


1083

$\alpha=90^\circ$ R=0.6 H=94.40 Max T/m=50

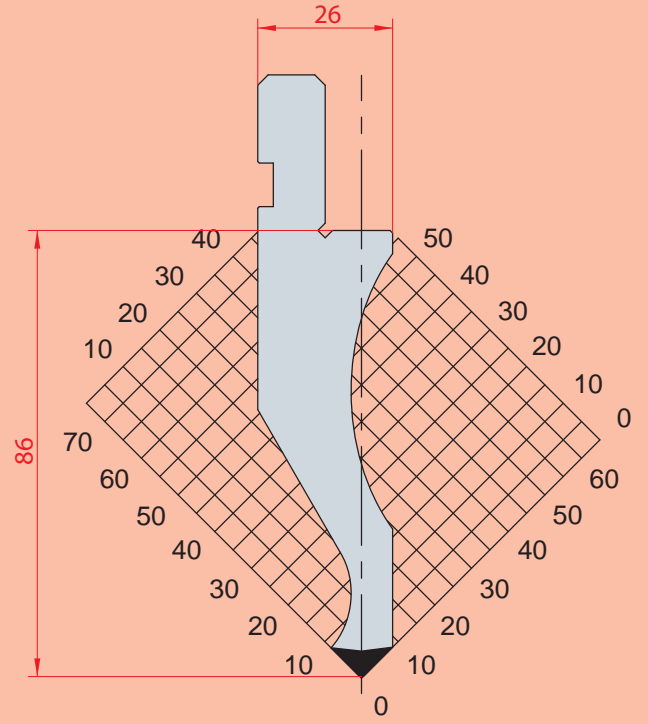
PUNZONI - 90° / PUNCHES - 90°

- C45 bonificato /quenched
- 42CrMo4
- C45



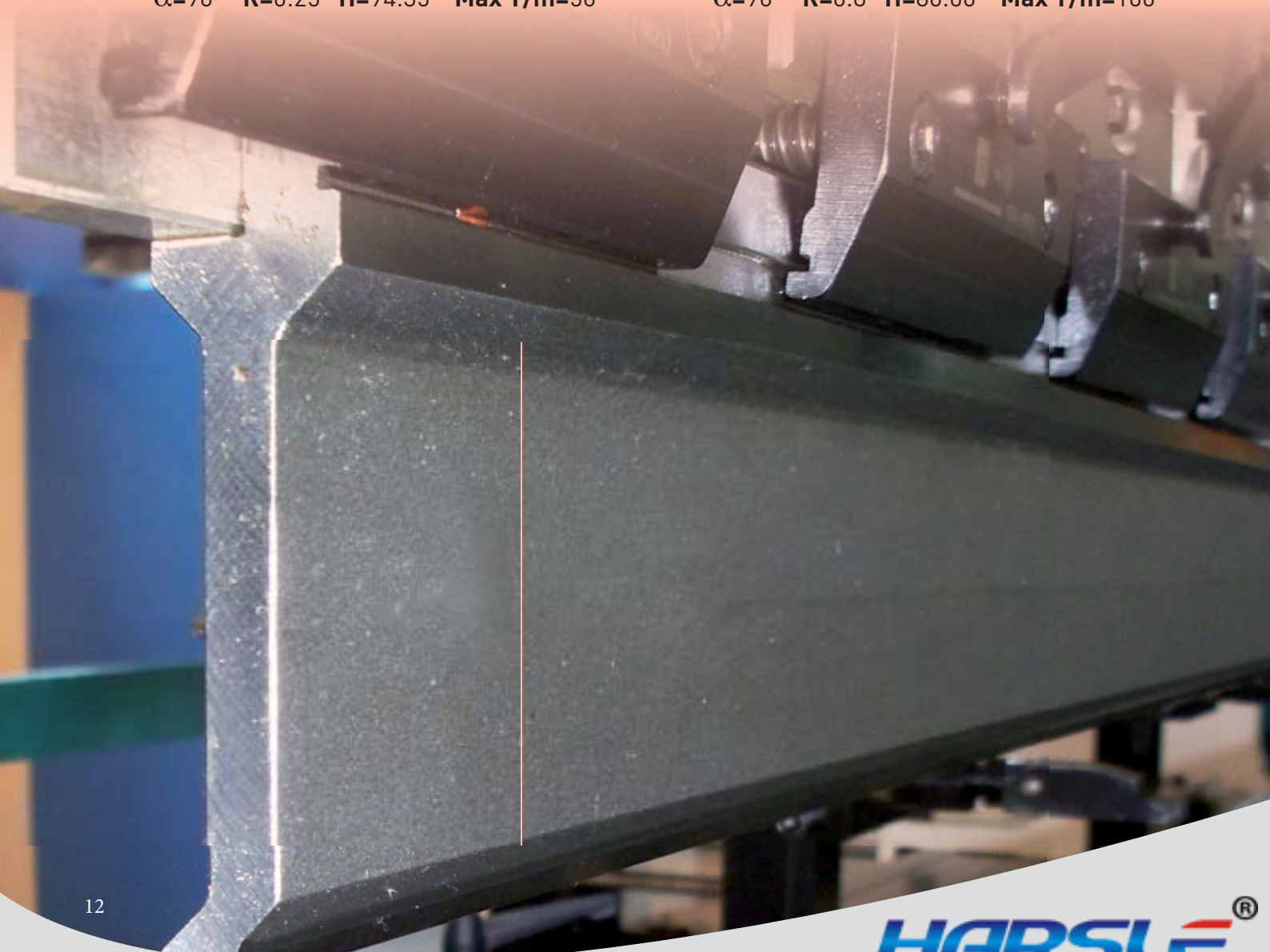
1269

$\alpha=90^\circ$ R=0.25 H=94.35 Max T/m=50



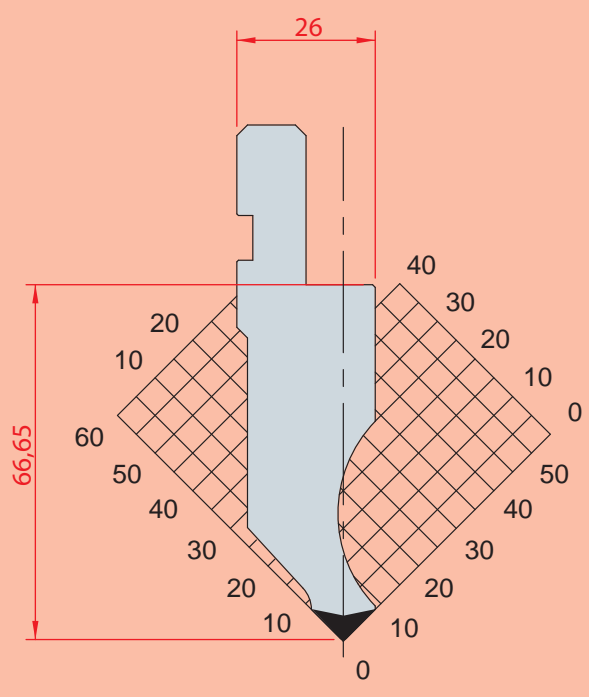
1021

$\alpha=90^\circ$ R=0.8 H=86.00 Max T/m=100



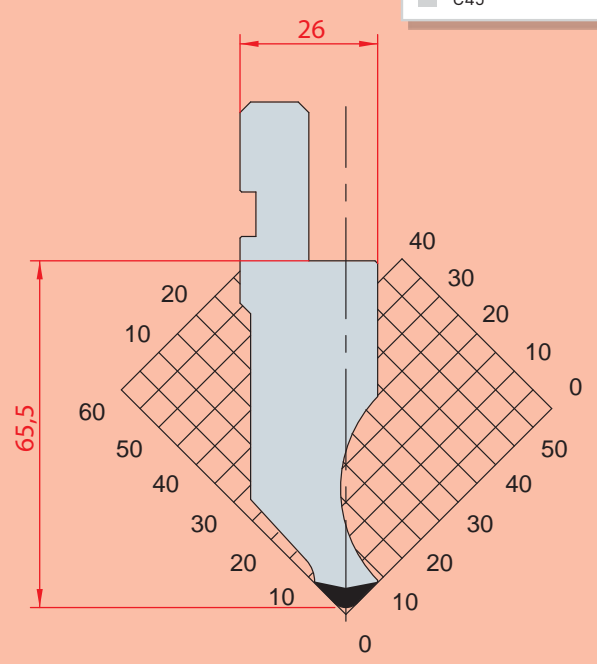
PUNZONI - 88° / PUNCHES 88°

■	C45 bonificato /quenched
■	42CrMo4
■	C45



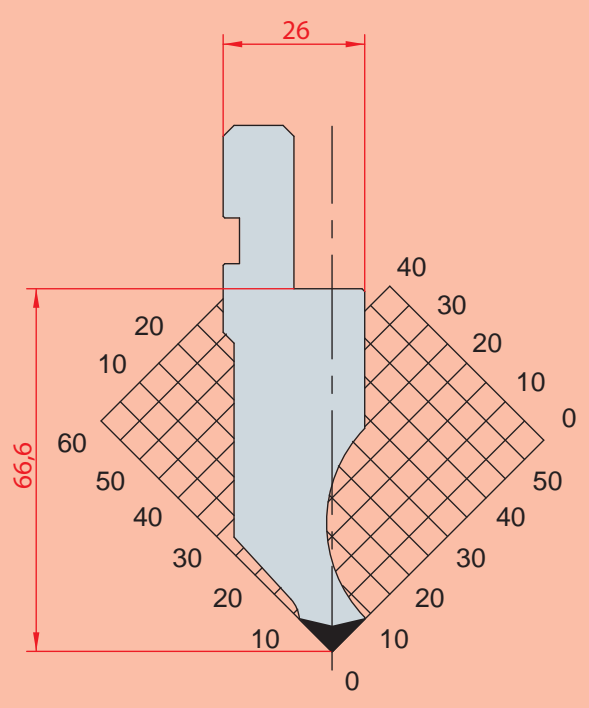
1011

$\alpha=88^\circ$ R=0.8 H=66.65 Max T/m=100



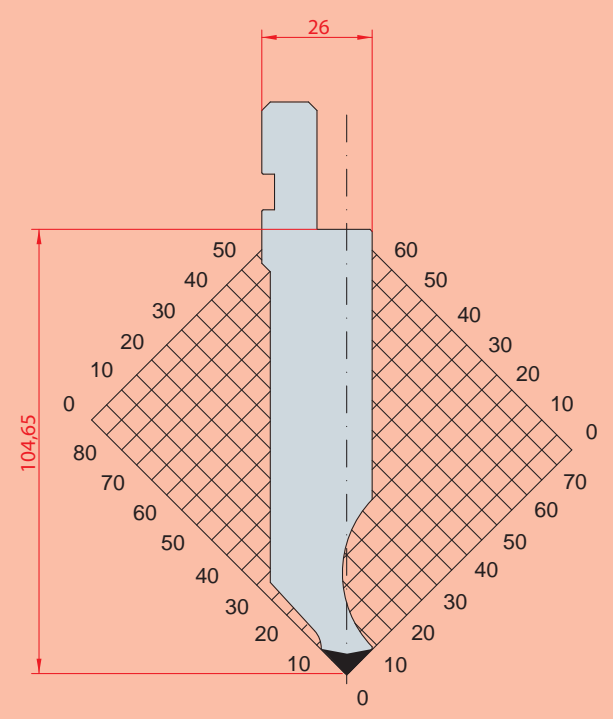
1012

$\alpha=88^\circ$ R=3 H=65.50 Max T/m=100



1065

$\alpha=88^\circ$ R=0.25 H=66.60 Max T/m=100

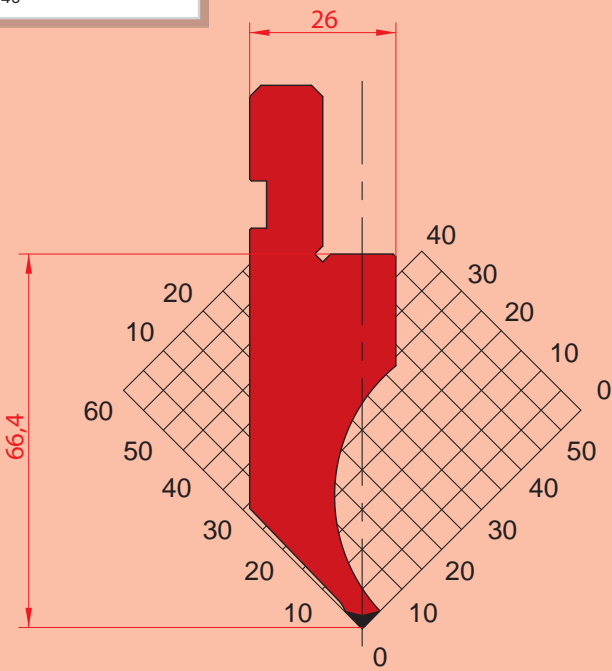


1063

$\alpha=88^\circ$ R=0.8 H=104.65 Max T/m=100

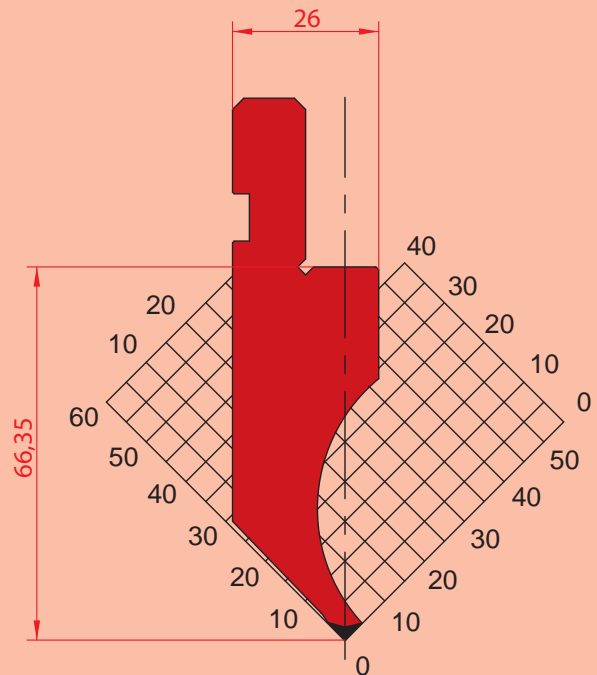
PUNZONI - 88° / PUNCHES 88°

- C45 bonificato /quenched
- 42CrMo4
- C45



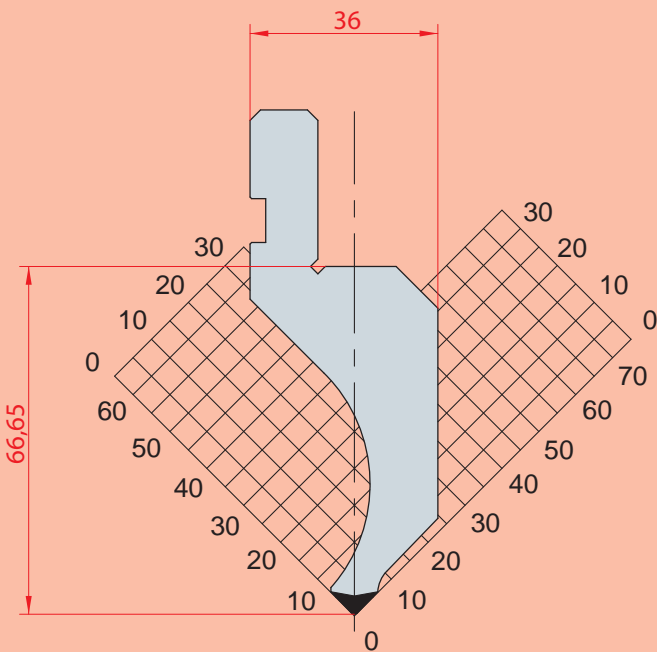
1049

$\alpha=88^\circ$ R=0.6 H=66.40 Max T/m=35



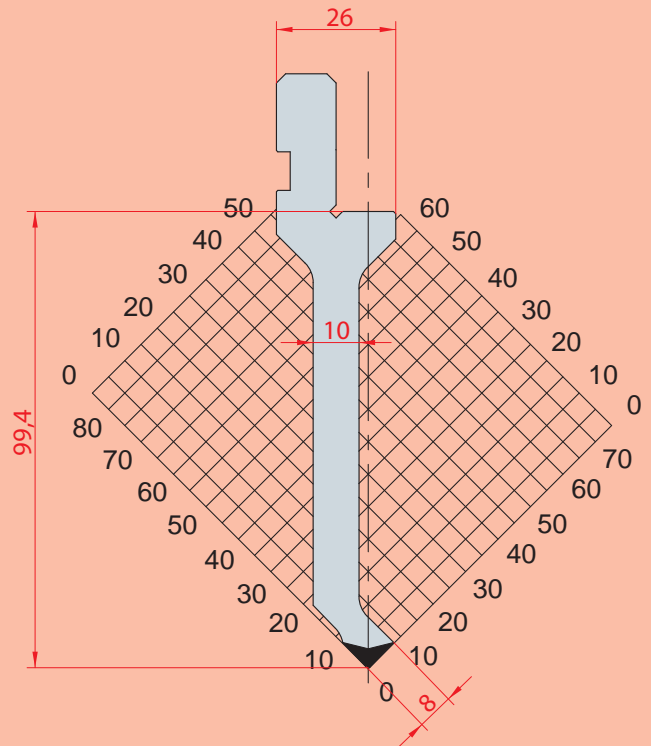
1264

$\alpha=88^\circ$ R=0.25 H=66.35 Max T/m=35



1081

$\alpha=88^\circ$ R=0.8 H=66.65 Max T/m=60

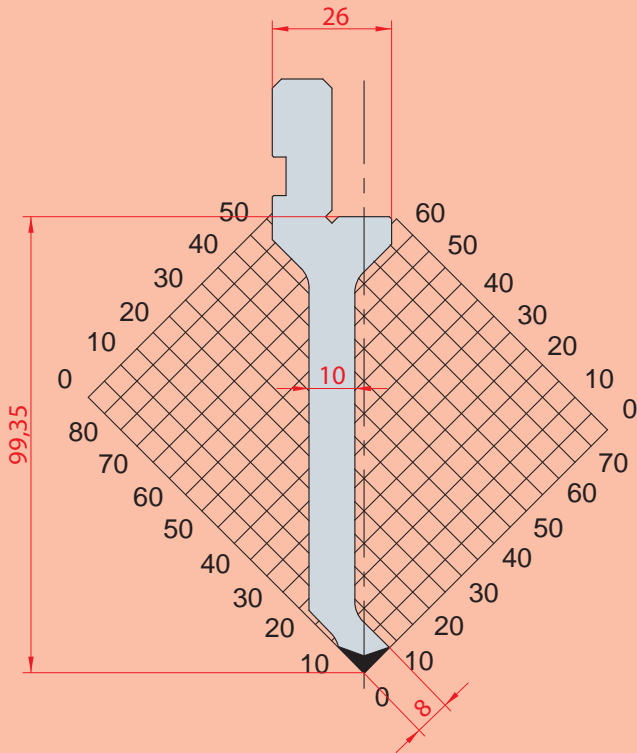


1029

$\alpha=88^\circ$ R=0.6 H=99.40 Max T/m=50

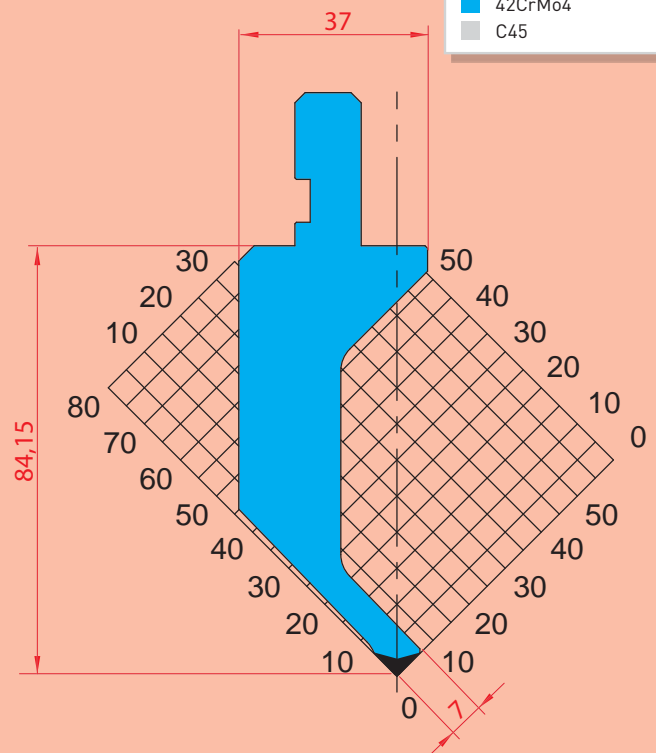
PUNZONI - 88° / PUNCHES 88°

■ C45 bonificato /quenched
 ■ 42CrMo4
 ■ C45



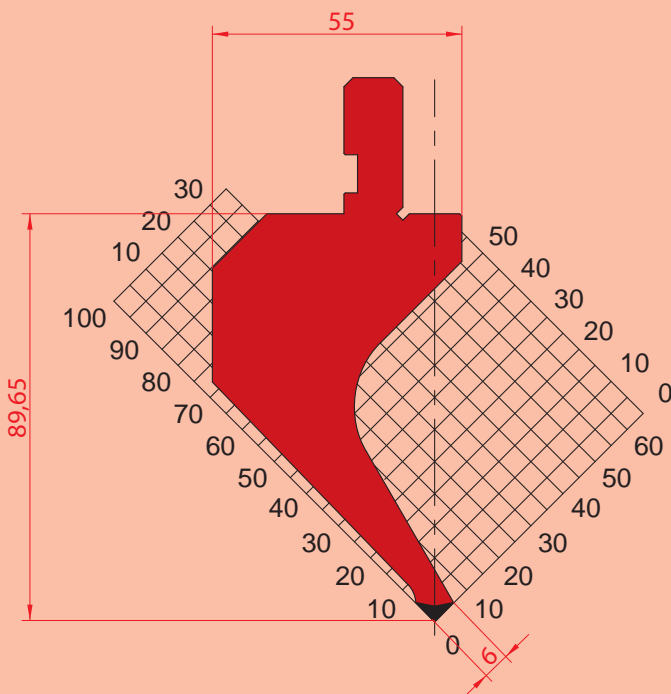
1262

$\alpha=88^\circ$ R=0.25 H=99.35 Max T/m=50



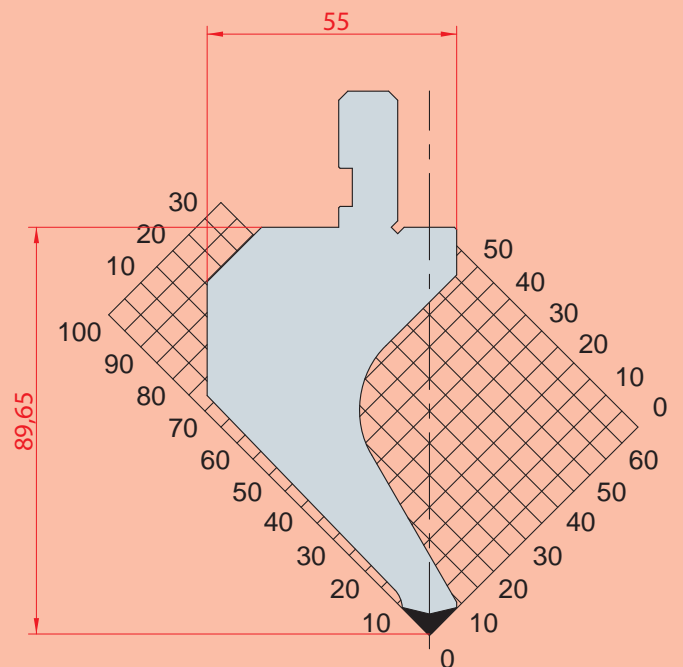
1020

$\alpha=88^\circ$ R=0.6 H=84.15 Max T/m=20



1175

$\alpha=88^\circ$ R=0.8 H=89.65 Max T/m=50

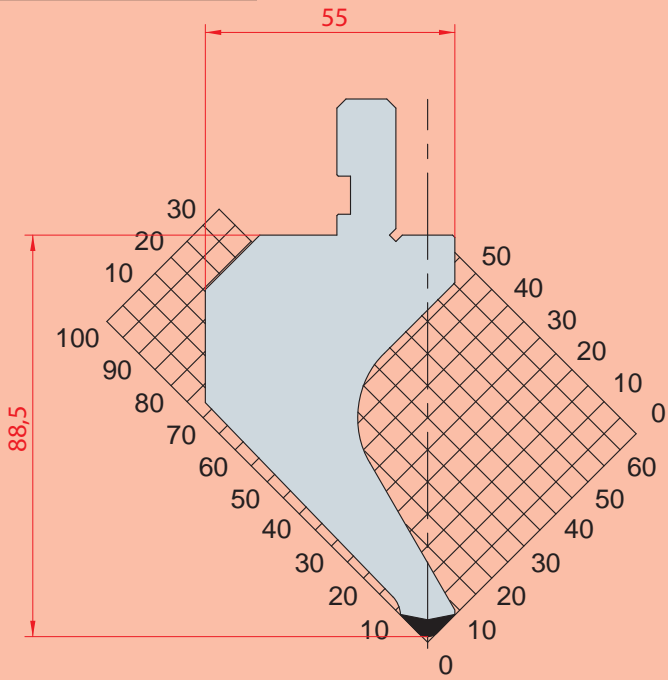


1014

$\alpha=88^\circ$ R=0.8 H=89.65 Max T/m=60

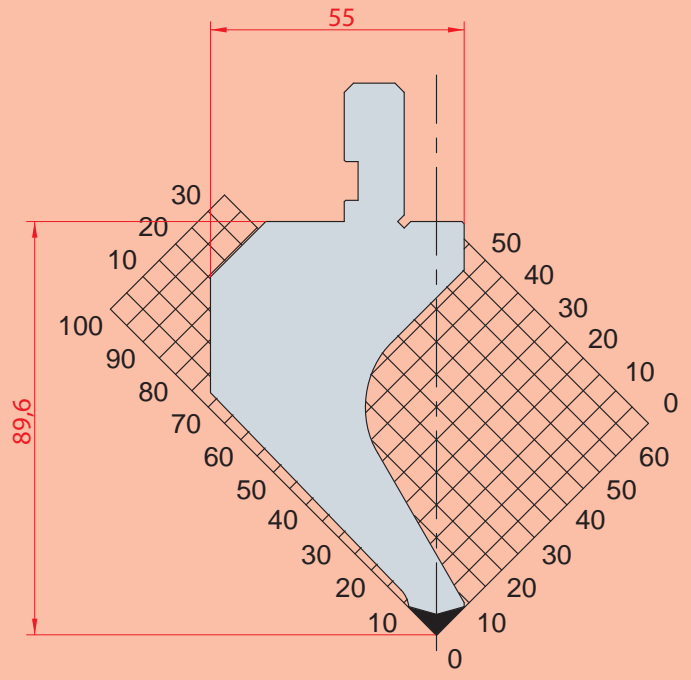
PUNZONI - 88° / PUNCHES 88°

- C45 bonificato /quenched
- 42CrMo4
- C45



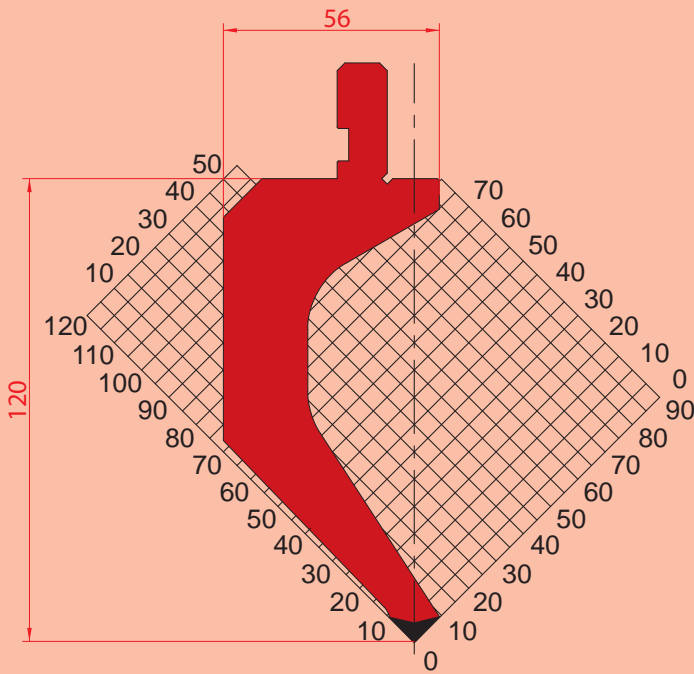
1015

$\alpha=88^\circ$ R=3 H=88.50 Max T/m=60



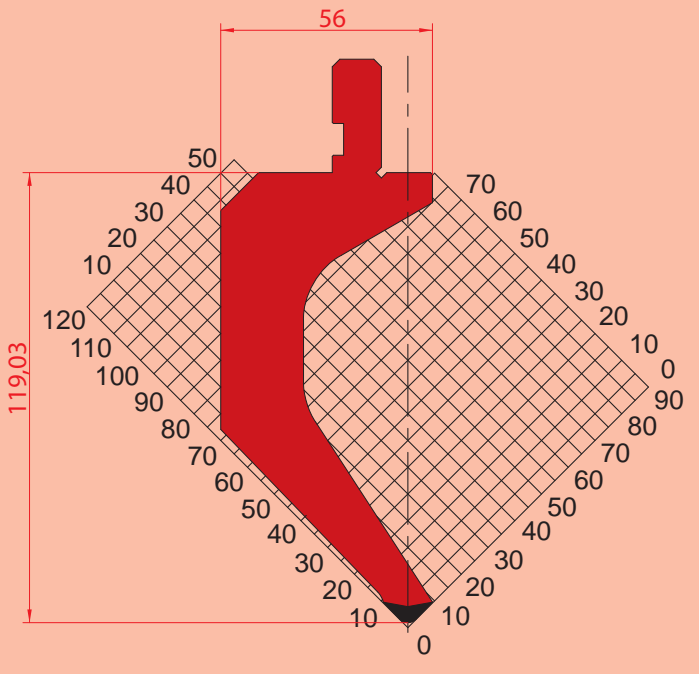
1266

$\alpha=88^\circ$ R=0.25 H=89.60 Max T/m=60



1061

$\alpha=88^\circ$ R=0.8 H=120.00 Max T/m=50

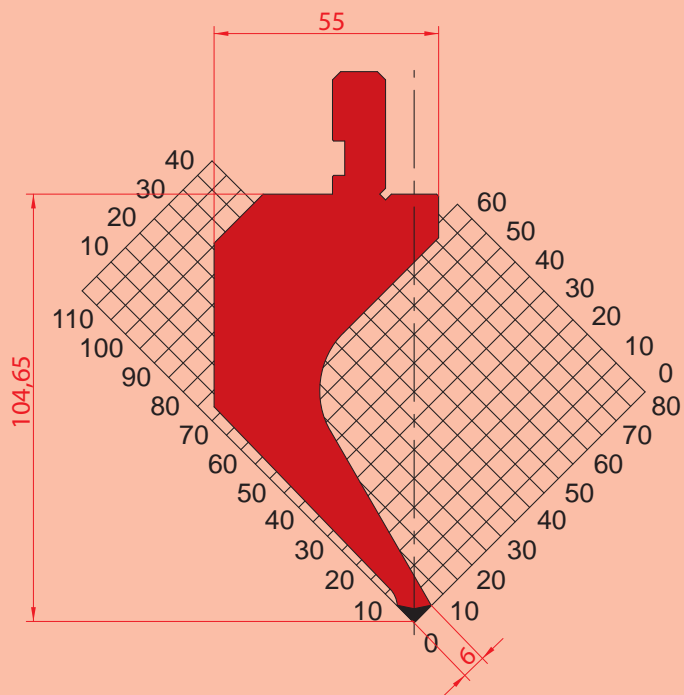


1062

$\alpha=88^\circ$ R=3 H=119.03 Max T/m=50

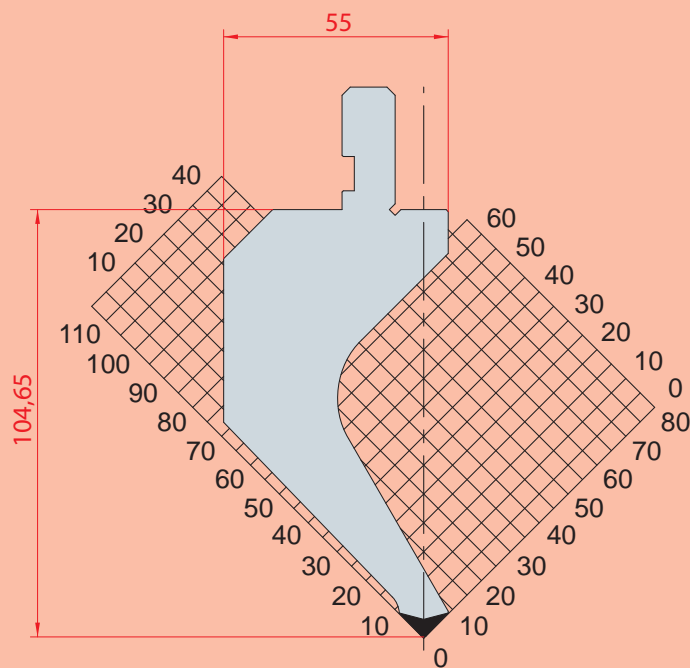
PUNZONI - 88° / PUNCHES 88°

- C45 bonificato /quenched
- 42CrMo4
- C45



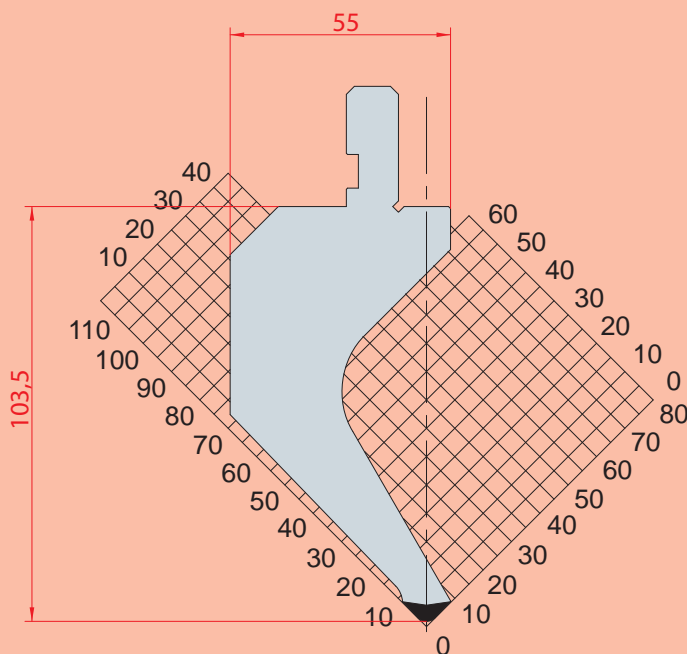
1173

$\alpha=88^\circ$ R=0.8 H=104.65 Max T/m=50



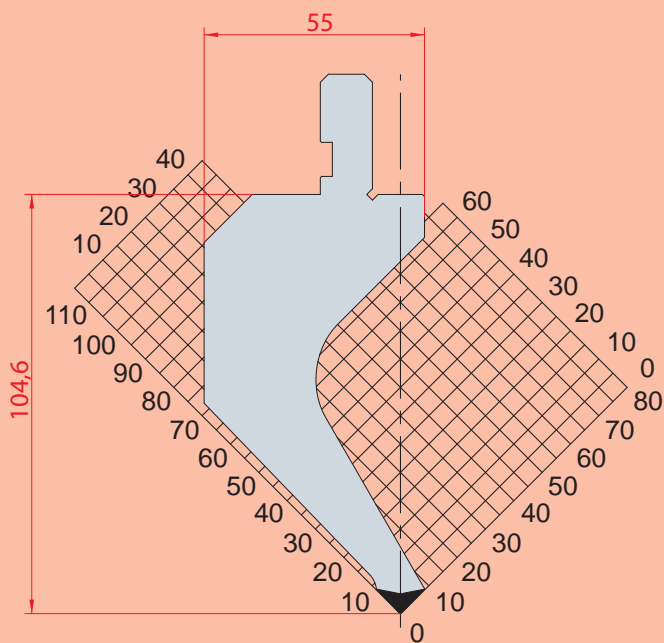
1017

$\alpha=88^\circ$ R=0.8 H=104.65 Max T/m=50



1018

$\alpha=88^\circ$ R=3 H=103.50 Max T/m=50

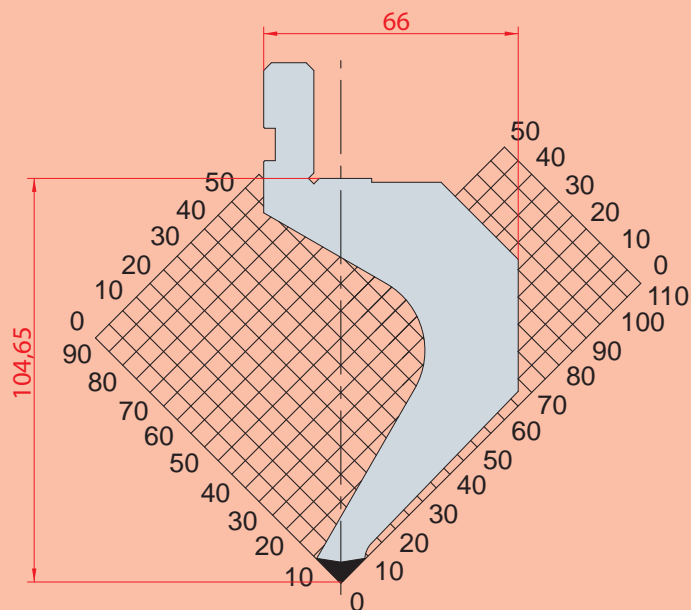


1268

$\alpha=88^\circ$ R=0.25 H=104.60 Max T/m=50

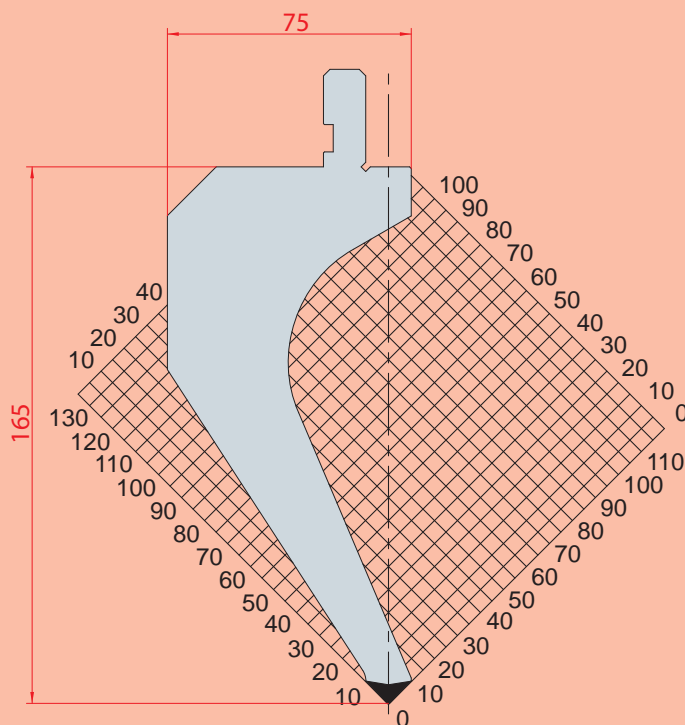
PUNZONI - 88° / PUNCHES 88°

- C45 bonificato /quenched
- 42CrMo4
- C45



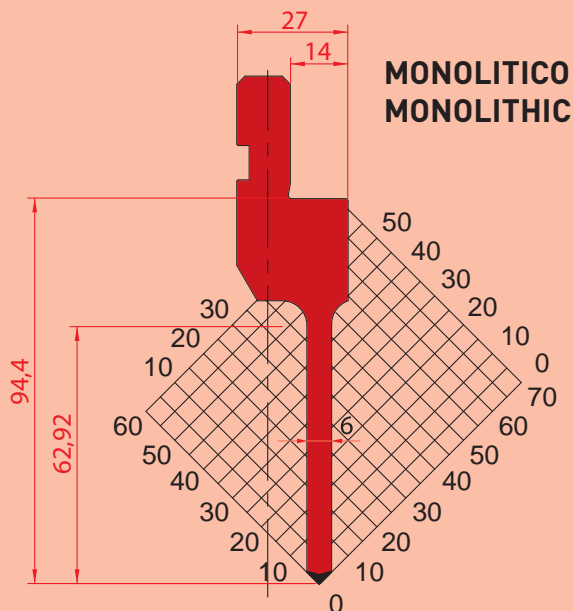
1082

$\alpha=88^\circ$ R=0.8 H=104.65 Max T/m=45



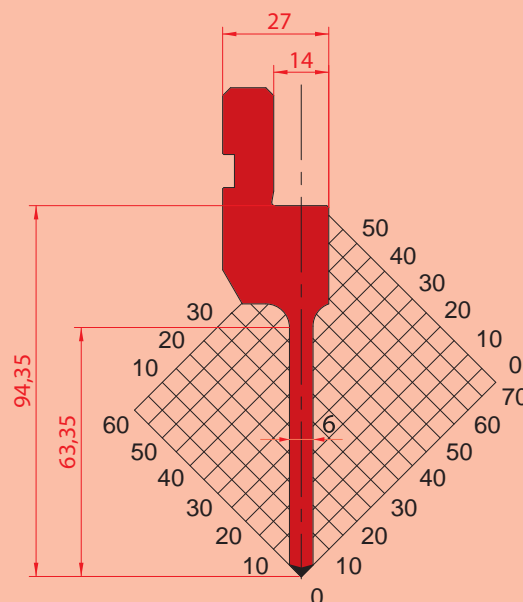
1031

$\alpha=88^\circ$ R=0.8 H=165.00 Max T/m=60



1084

$\alpha=88^\circ$ R=0.6 H=94.40 Max T/m=50

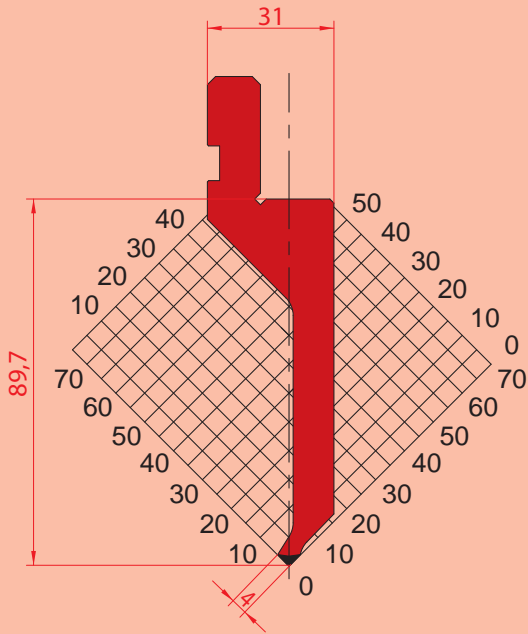


1270

$\alpha=88^\circ$ R=0.25 H=94.35 Max T/m=50

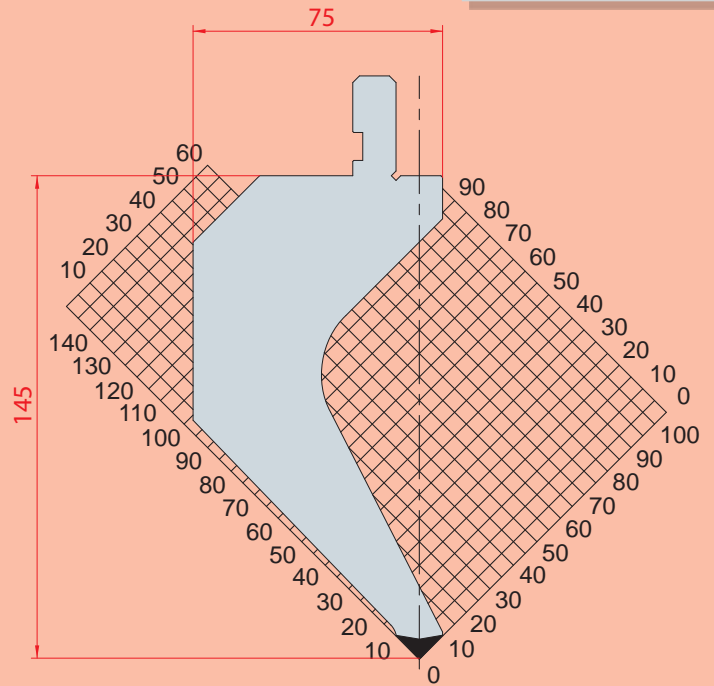
PUNZONI - 88° / PUNCHES 88°

- C45 bonificato /quenched
- 42CrMo4
- C45



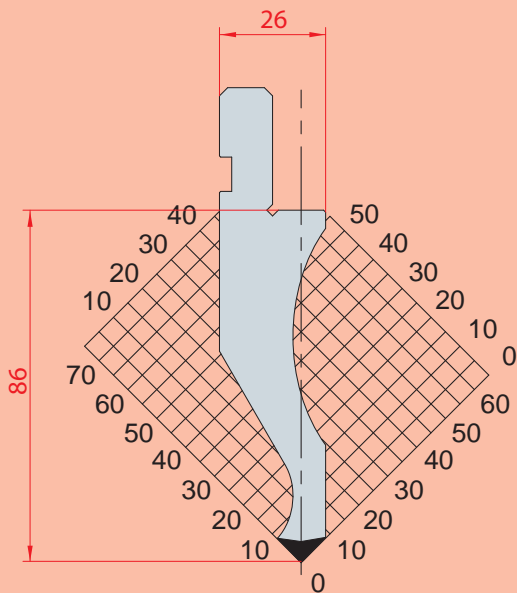
1290

$\alpha=88^\circ$ R=0.6 H=89.70 Max T/m=30



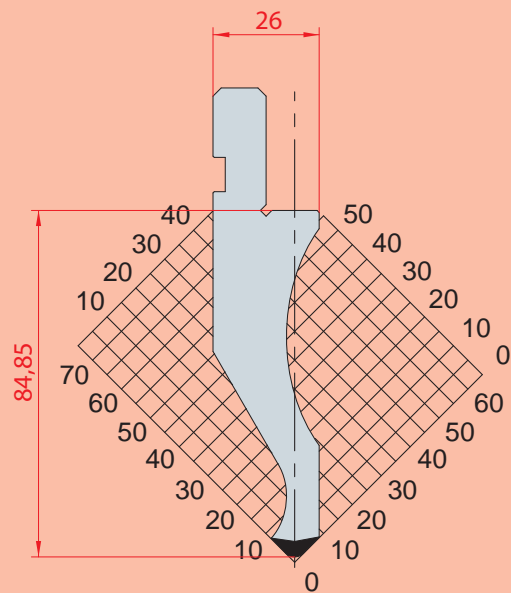
1030

$\alpha=88^\circ$ R=0.8 H=145.00 Max T/m=80



1022

$\alpha=88^\circ$ R=0.8 H=86.00 Max T/m=100

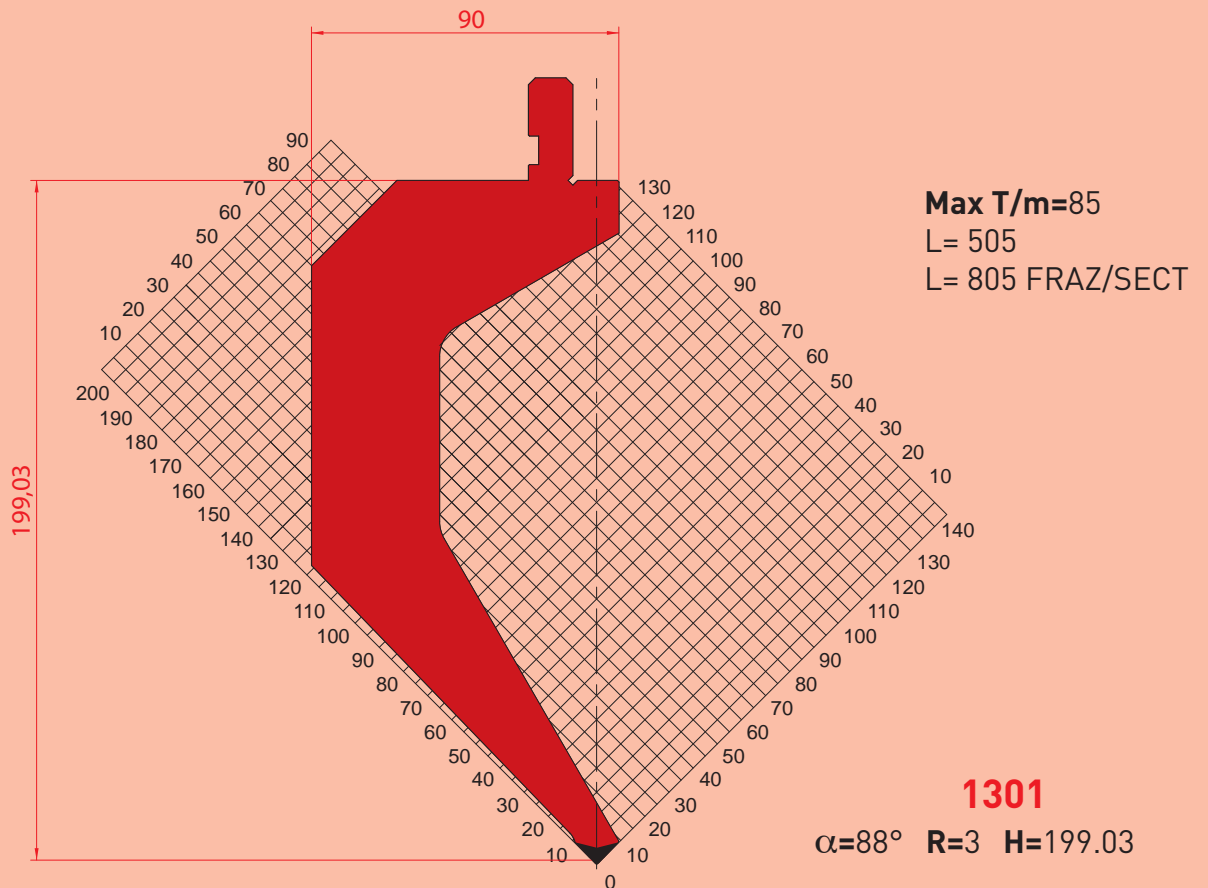
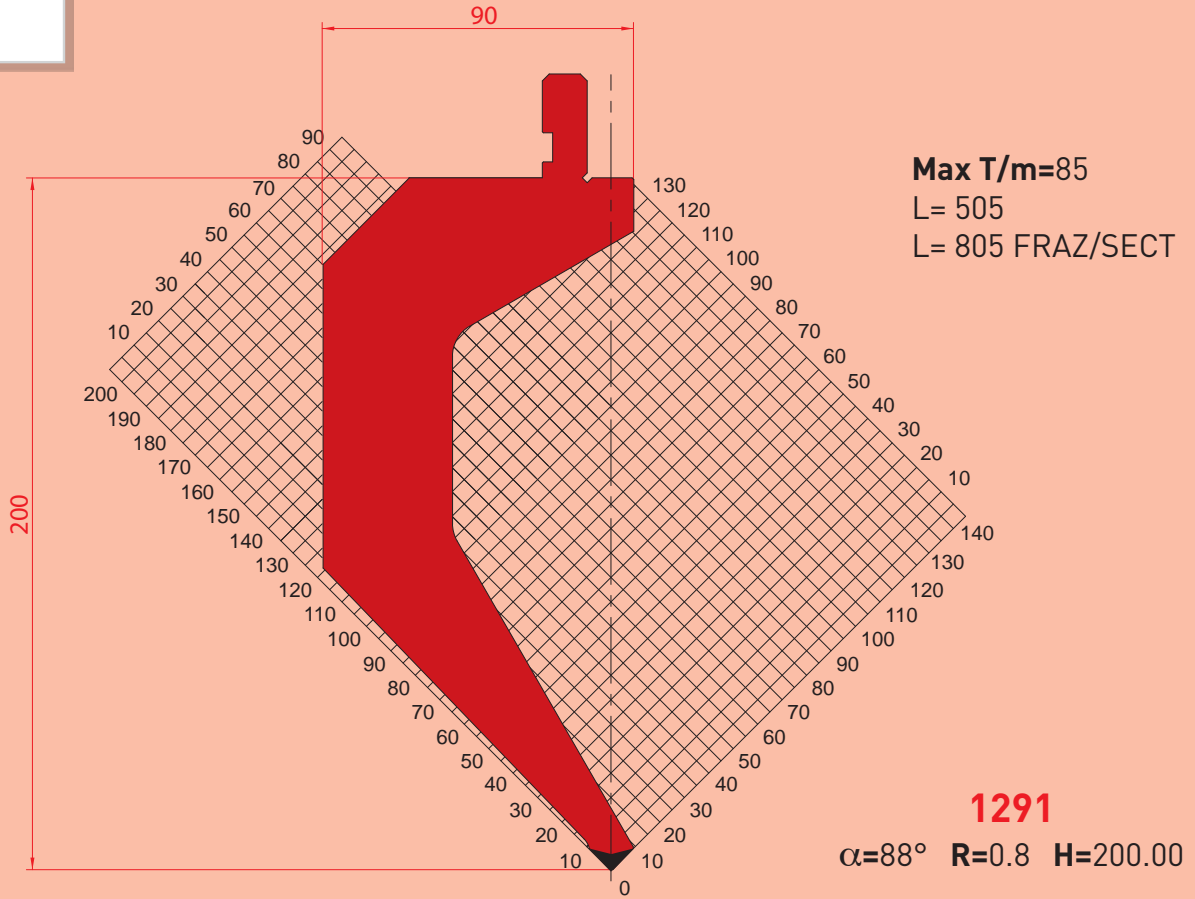


1023

$\alpha=88^\circ$ R=3 H=84.85 Max T/m=100

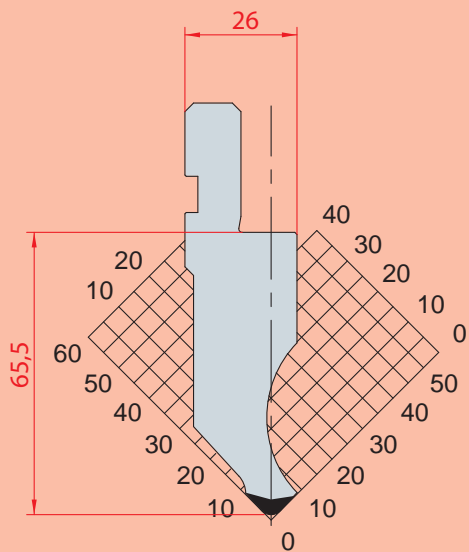
PUNZONI - 88° / PUNCHES 88°

- C45 bonificato /quenched
- 42CrMo4
- C45



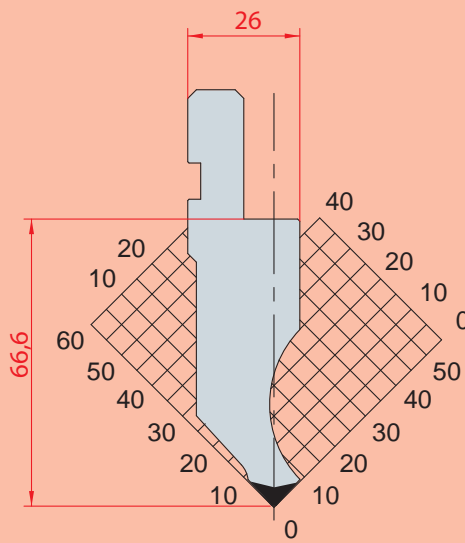
PUNZONI - 85° / PUNCHES - 85°

■	C45 bonificato /quenched
■	42CrMo4
■	C45



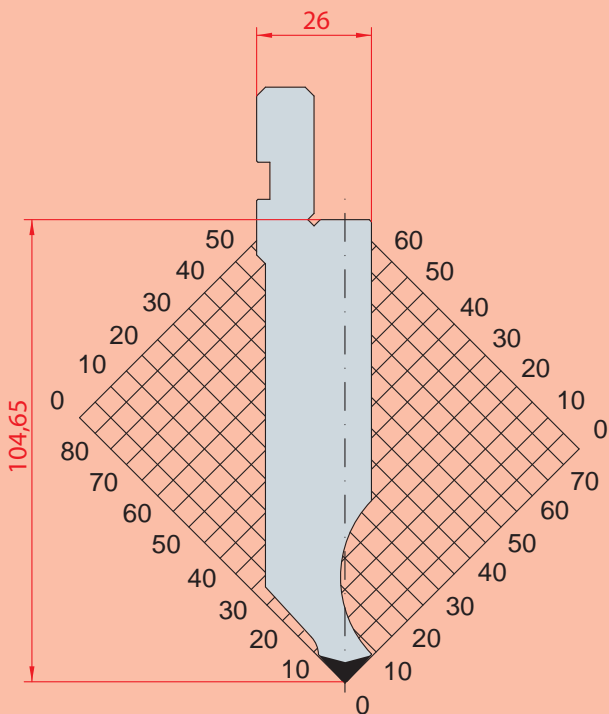
1177

$\alpha=85^\circ$ R=3 H=65.50 Max T/m=100



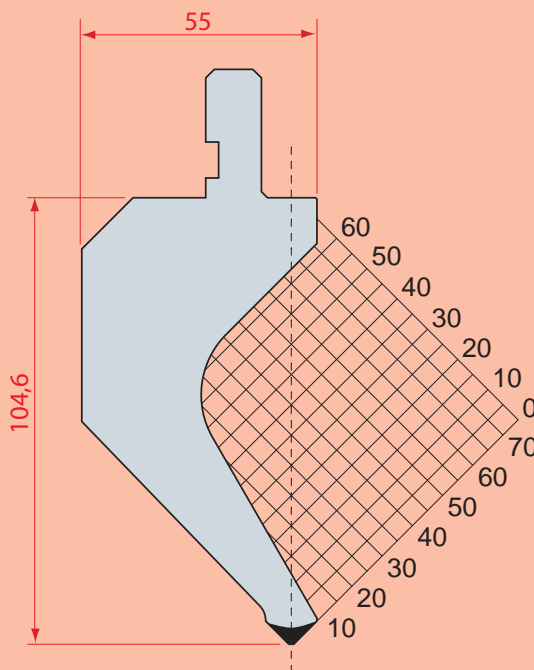
1260

$\alpha=85^\circ$ R=0.8 H=66.60 Max T/m=100



1281

$\alpha=85^\circ$ R=0.8 H=104.65 Max T/m=100

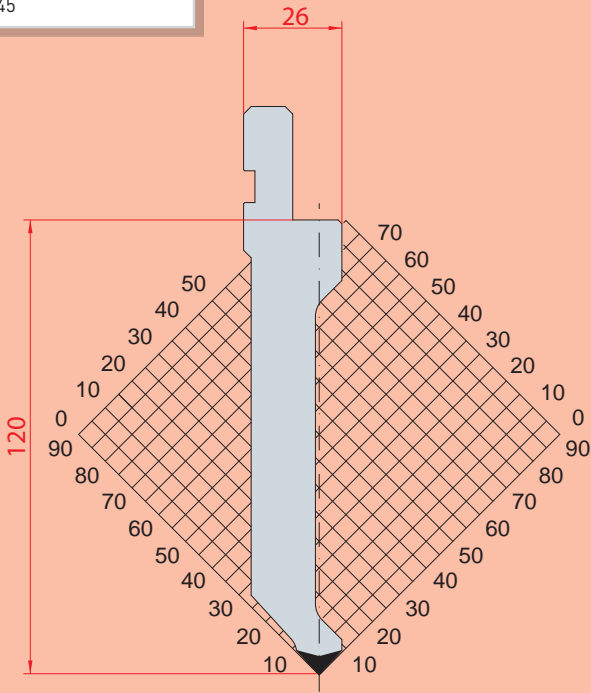


1172

$\alpha=85^\circ$ R=0.8 H= 104.6 Max T/m=50

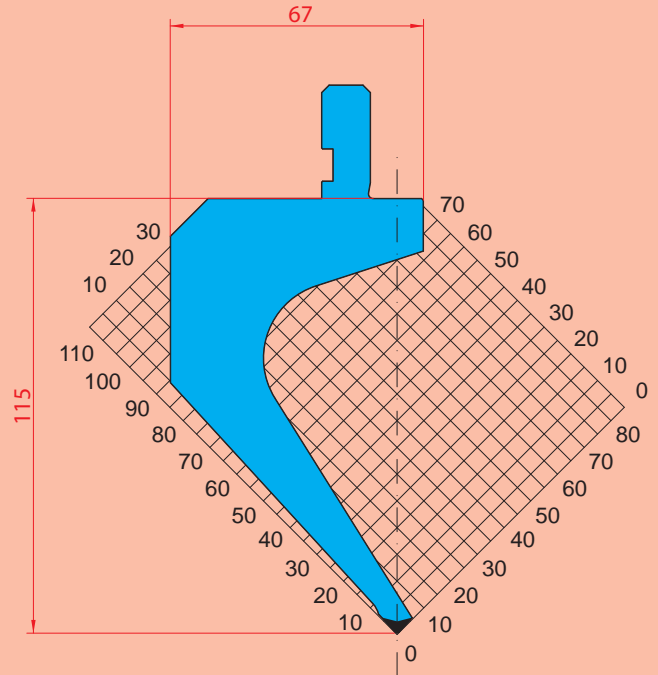
PUNZONI - 85° / PUNCHES 85°

- C45 bonificato /quenched
- 42CrMo4
- C45



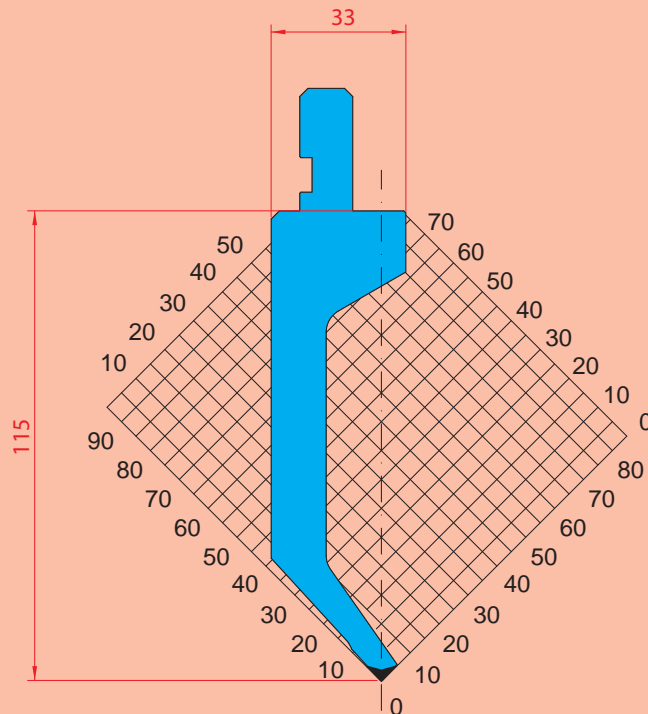
1309

$\alpha=85^\circ$ R=0.8 H=120.00 Max T/m=70



1310

$\alpha=85^\circ$ R=0.8 H=115.00 Max T/m=35

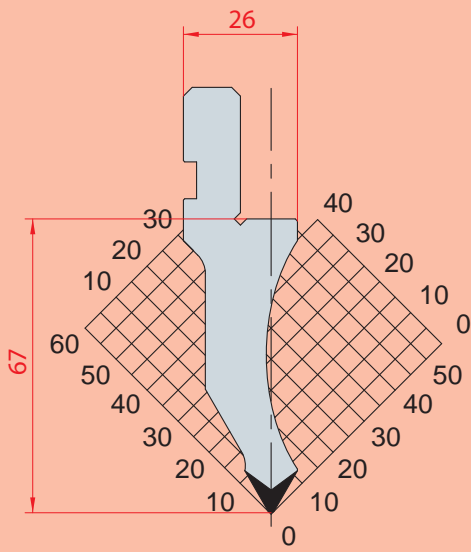


1312

$\alpha=85^\circ$ R=0.6 H=115.00 Max T/m=20

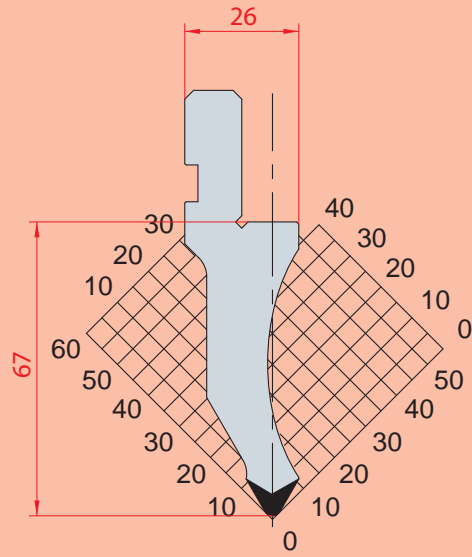
PUNZONI - 60° / PUNCHES - 60°

■	C45 bonificato /quenched
■	42CrMo4
■	C45



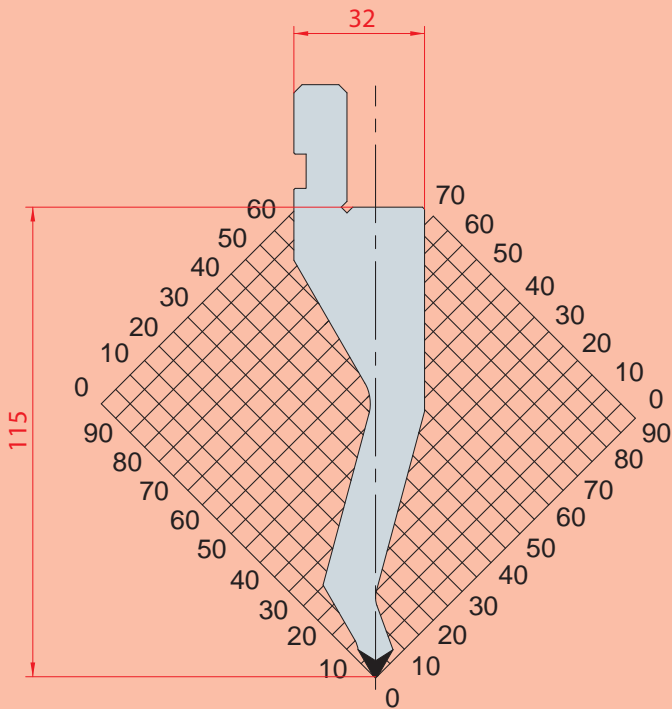
1026

$\alpha=60^\circ$ R=0.8 H=67.00 Max T/m=80



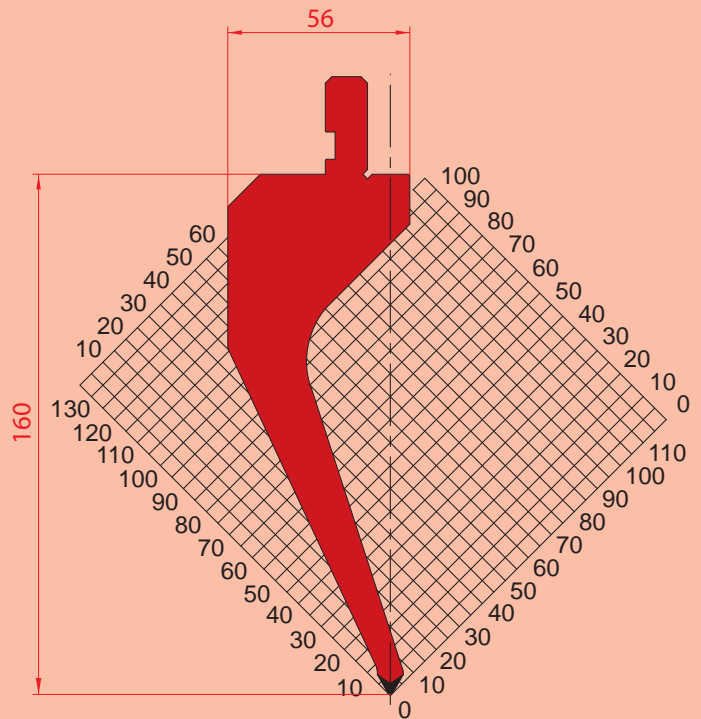
1027

$\alpha=60^\circ$ R=2 H=67.00 Max T/m=80



1191

$\alpha=60^\circ$ R=0.8 H=115.00 Max T/m=60

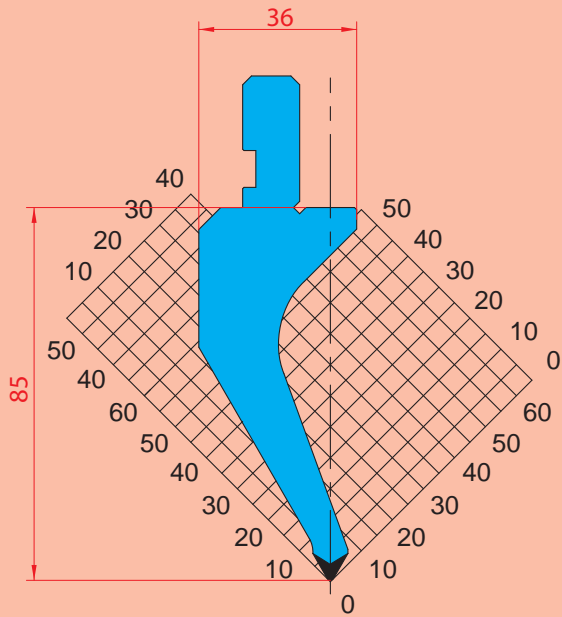


1190

$\alpha=60^\circ$ R=0.8 H=160.00 Max T/m=40

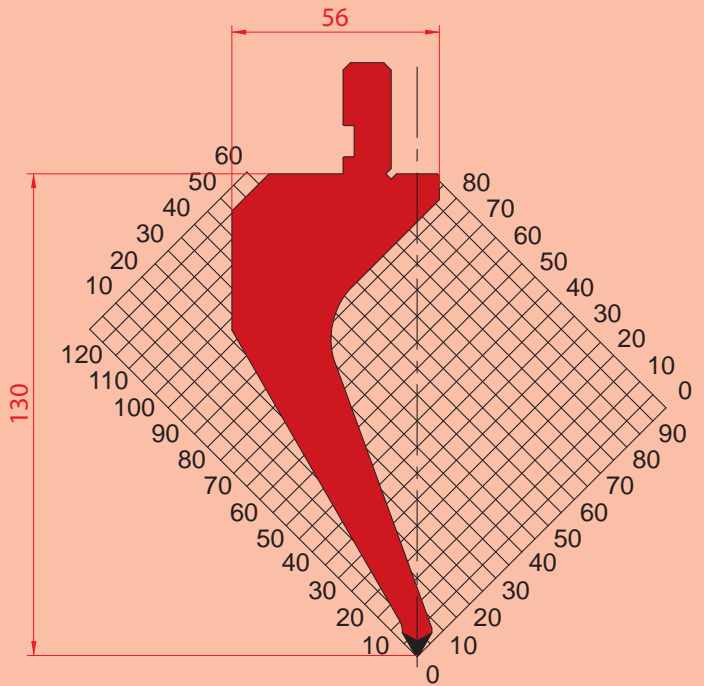
PUNZONI - 60° / PUNCHES - 60°

- C45 bonificato /quenched
- 42CrMo4
- C45



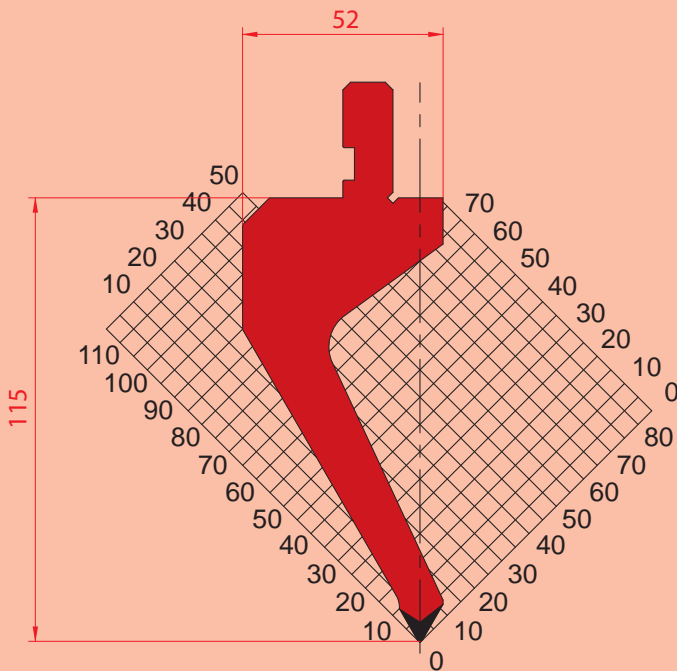
1162

$\alpha=60^\circ$ R=0.8 H=85.00 Max T/m=40



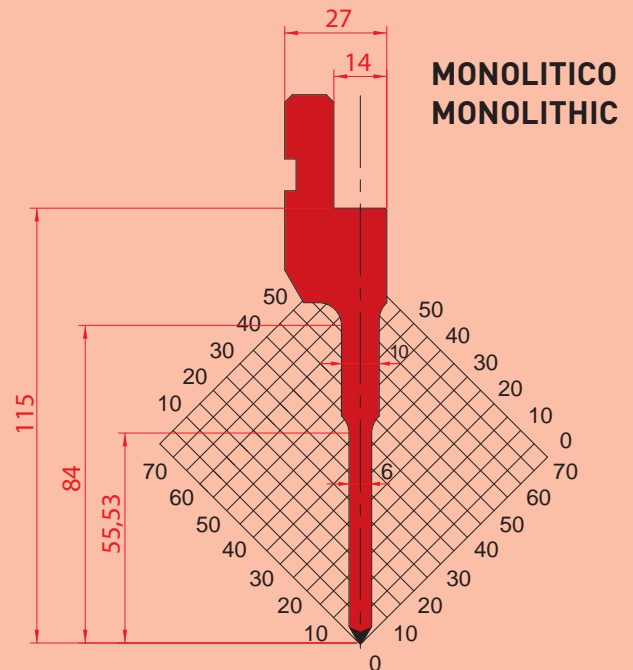
1163

$\alpha=60^\circ$ R=0.8 H=130.00 Max T/m=40



1272

$\alpha=60^\circ$ R=0.8 H=115.00 Max T/m=40

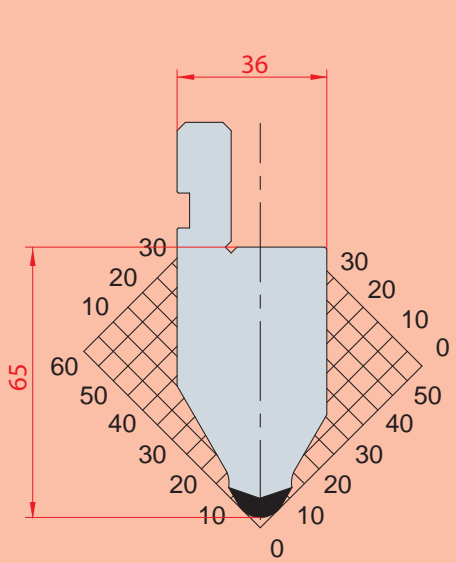


1271

$\alpha=60^\circ$ R=0.8 H=115.00 Max T/m=50

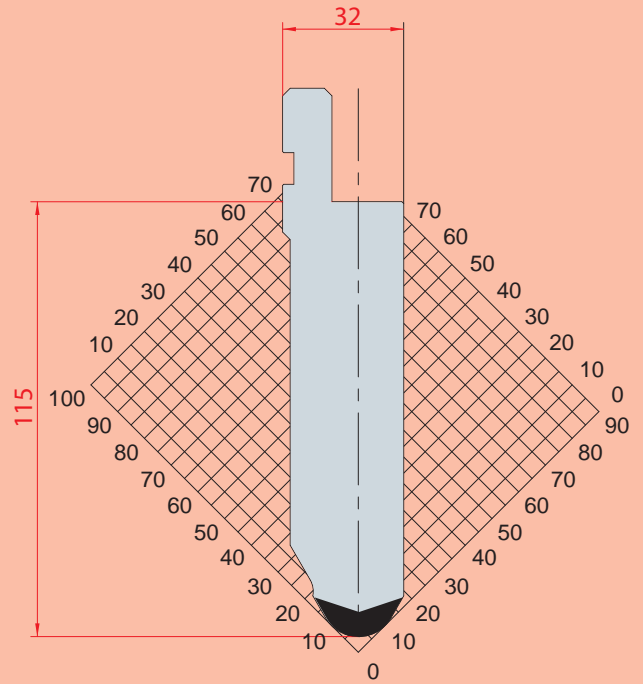
PUNZONI - 60° / PUNCHES - 60°

■ C45 bonificato /quenched
■ 42CrMo4
■ C45



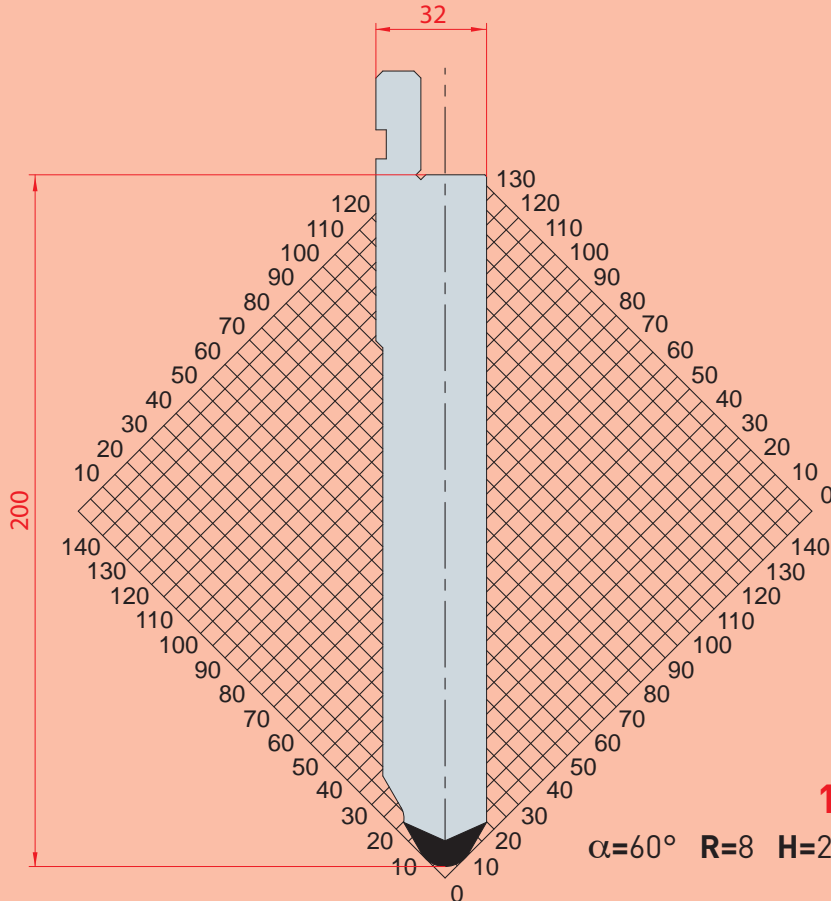
1032

$\alpha=60^\circ$ R=6 H=65.00 Max T/m=120



1283

$\alpha=60^\circ$ R=10 H=115.00 Max T/m=150

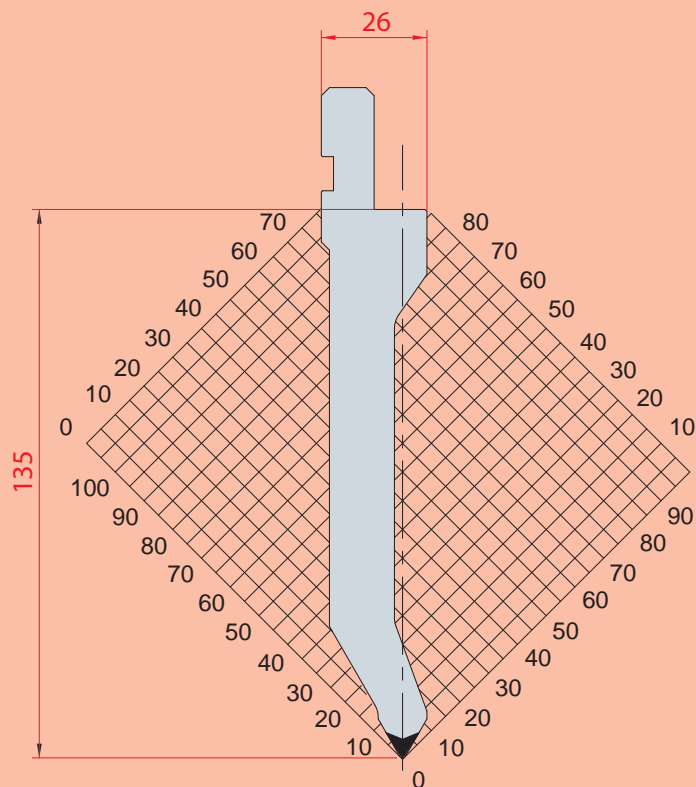


1293

$\alpha=60^\circ$ R=8 H=200.00 Max T/m=150

PUNZONI - 60° / PUNCHES - 60°

- C45 bonificato /quenched
- 42CrMo4
- C45



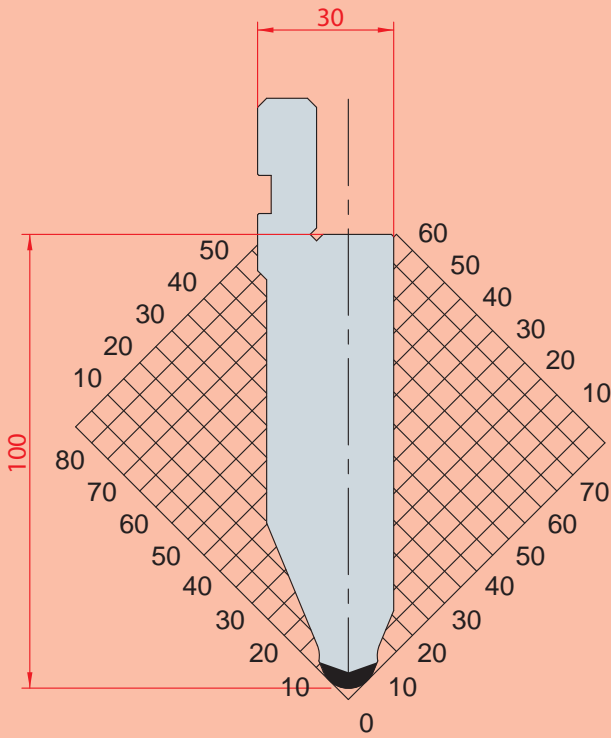
1284

$\alpha=60^\circ$ R=0.8 H=135.00 Max T/m=70



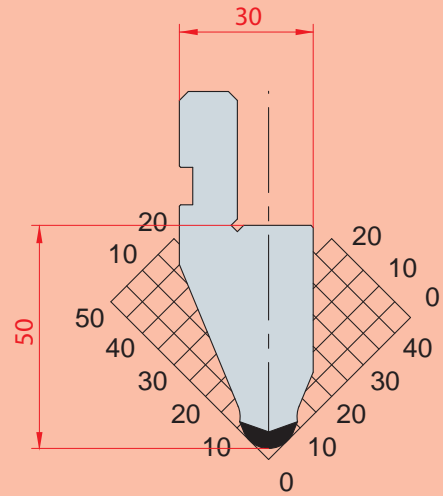
PUNZONI - 45° / PUNCHES - 45°

■	C45 bonificato /quenched
■	42CrMo4
■	C45



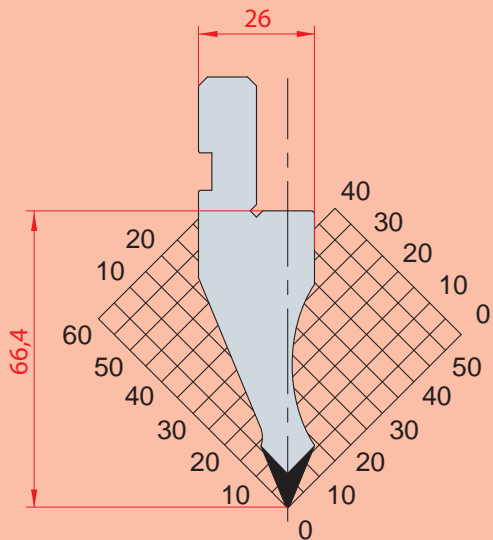
1053

$\alpha=45^\circ$ R=6 H=100.00 Max T/m=100



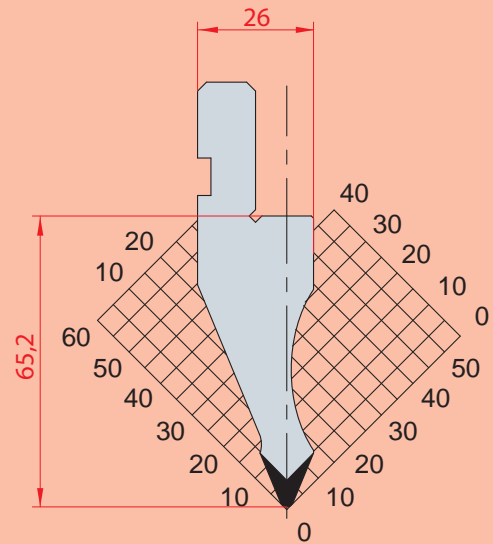
1054

$\alpha=45^\circ$ R=6 H=50.00 Max T/m=100



1024

$\alpha=45^\circ$ R=0.5 H=66.40 Max T/m=80

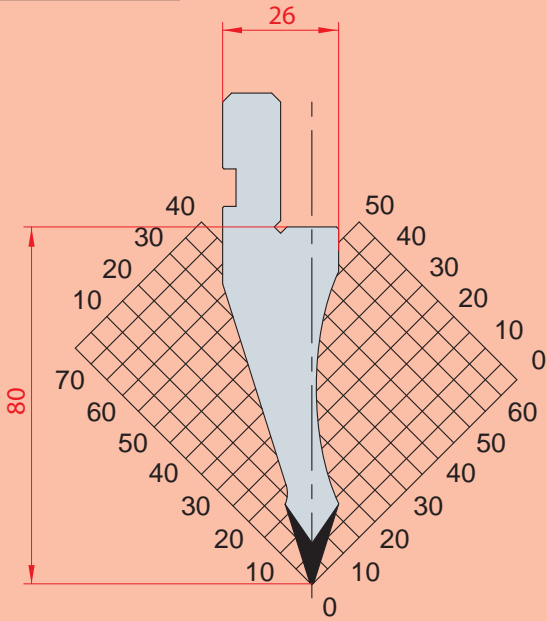


1025

$\alpha=45^\circ$ R=1.5 H=65.20 Max T/m=80

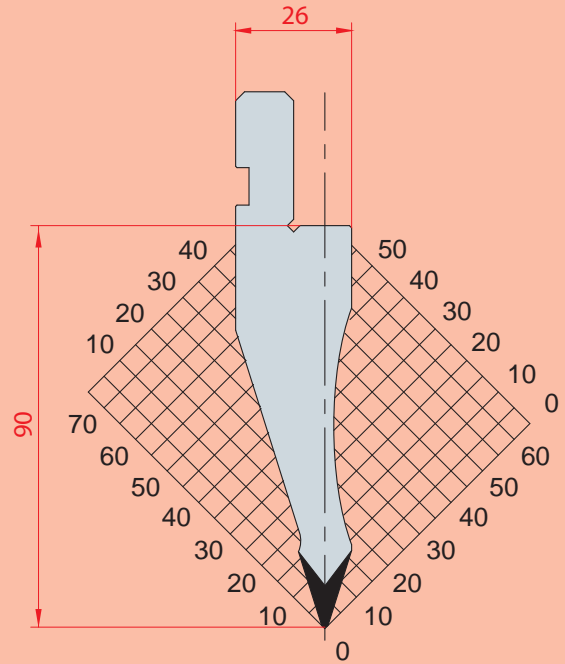
PUNZONI - 35° / PUNCHES - 35°

- C45 bonificato /quenched
- 42CrMo4
- C45



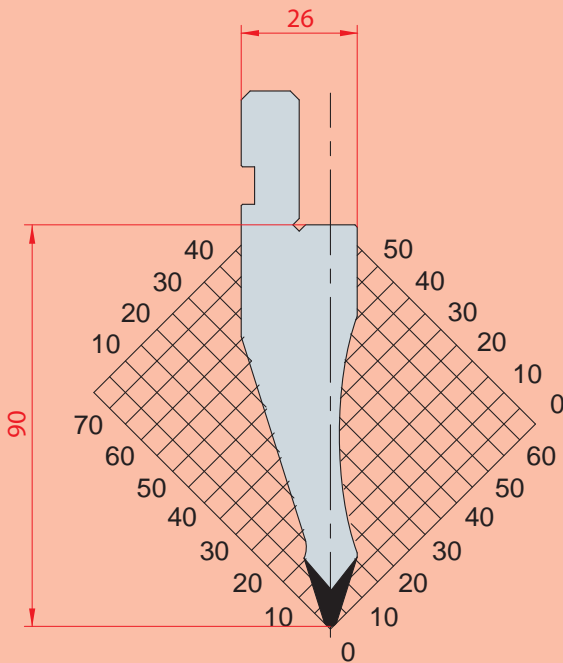
1035

$\alpha=35^\circ$ R=0.5 H=80.00 Max T/m=70



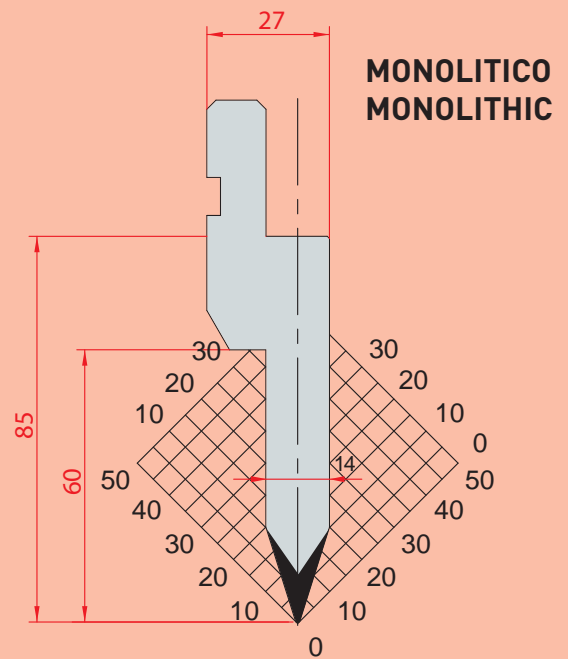
1047

$\alpha=35^\circ$ R=0.8 H=90.00 Max T/m=70



1282

$\alpha=35^\circ$ R=1.5 H=90.00 Max T/m=70

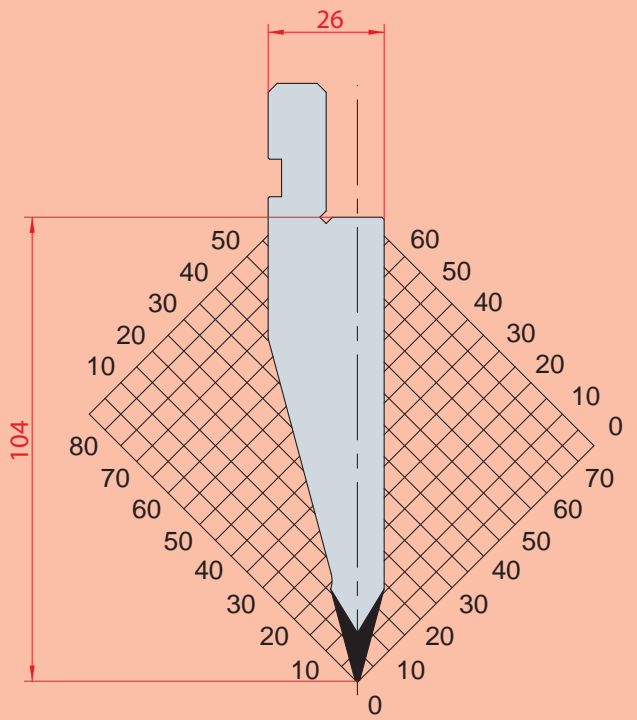


1034

$\alpha=35^\circ$ P=0.8 H=85.00 Max T/m=100

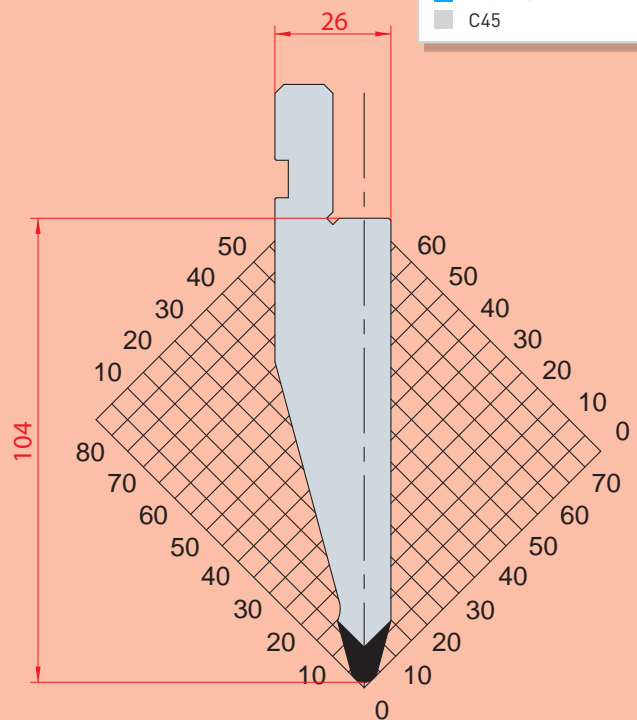
PUNZONI - 30° / PUNCHES - 30°

■ C45 bonificato /quenched
■ 42CrMo4
■ C45



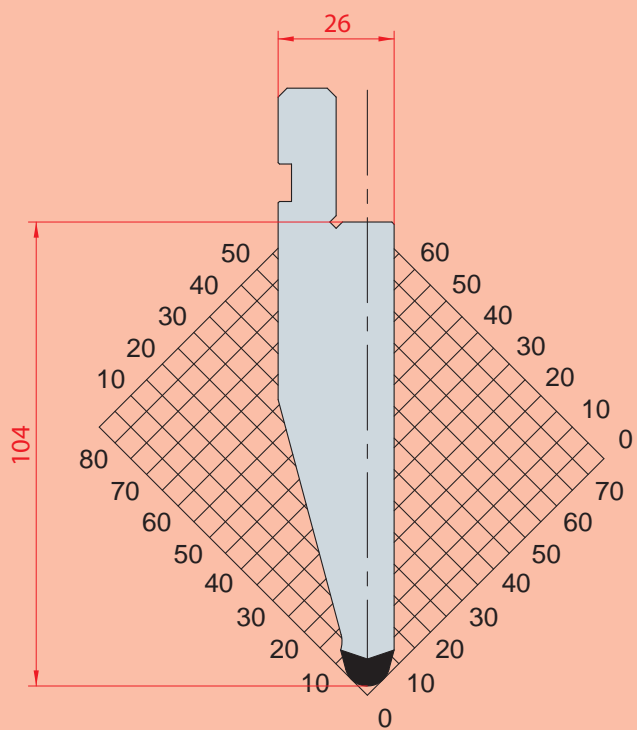
1193

$\alpha=30^\circ$ R=0.6 H=104.00 Max T/m=100



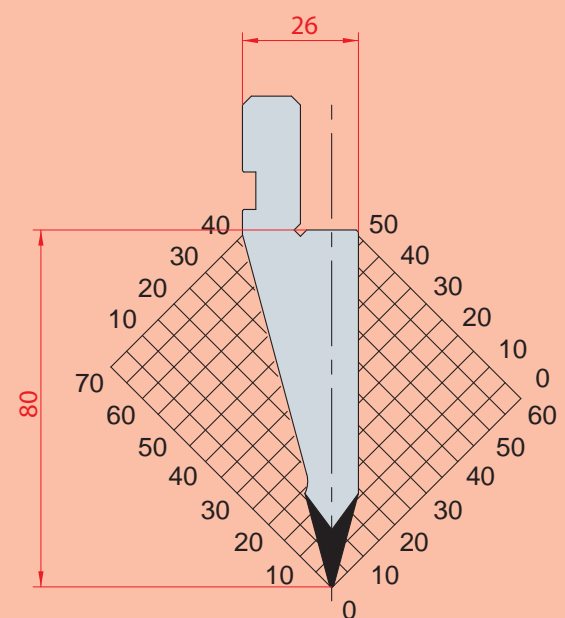
1289

$\alpha=30^\circ$ R=3 H=104.00 Max T/m=100



1194

$\alpha=30^\circ$ R=5 H=104.00 Max T/m=100

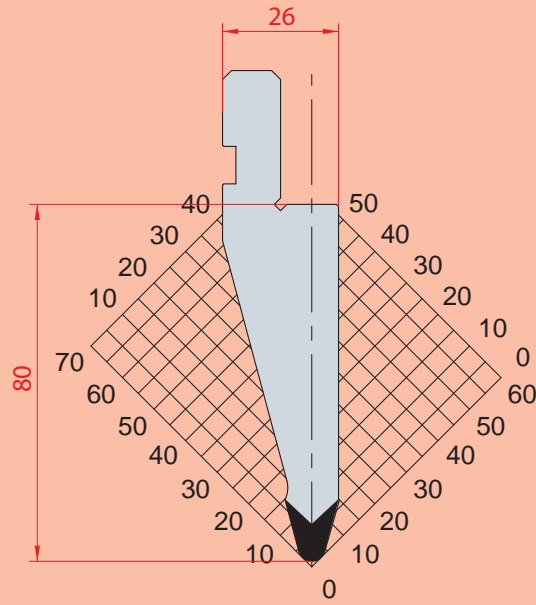


1056

$\alpha=30^\circ$ R=0.5 H=80.00 Max T/m=100

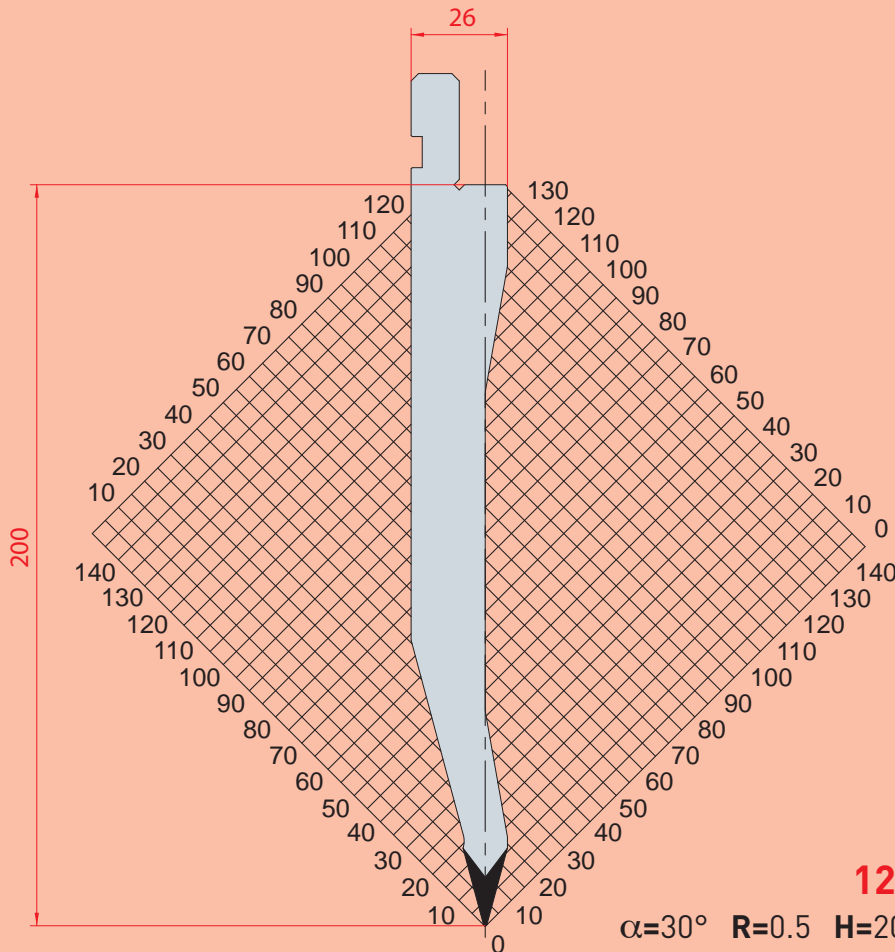
PUNZONI - 30° / PUNCHES - 30°

- C45 bonificato /quenched
- 42CrMo4
- C45



1057

$\alpha=30^\circ$ R=3 H=80.00 Max T/m=100



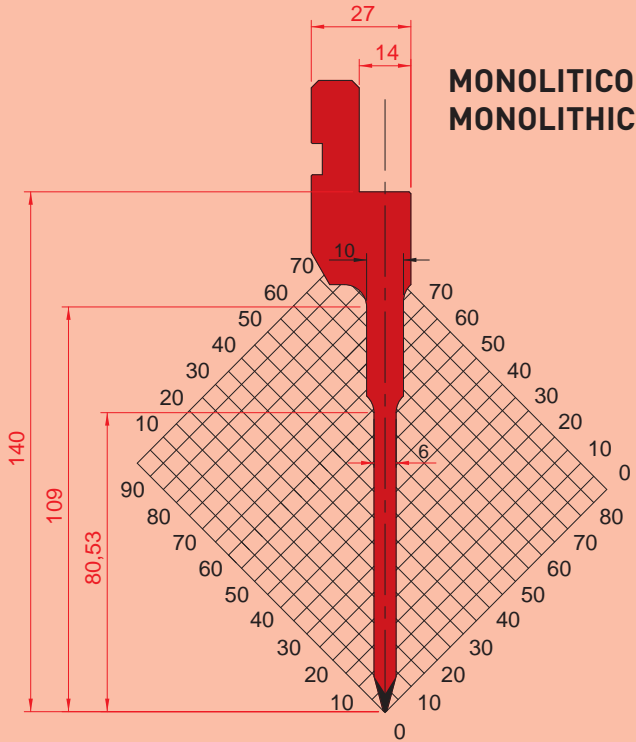
1292

$\alpha=30^\circ$ R=0.5 H=200.00 Max T/m=50

PUNZONI - 30° / PUNCHES - 30°

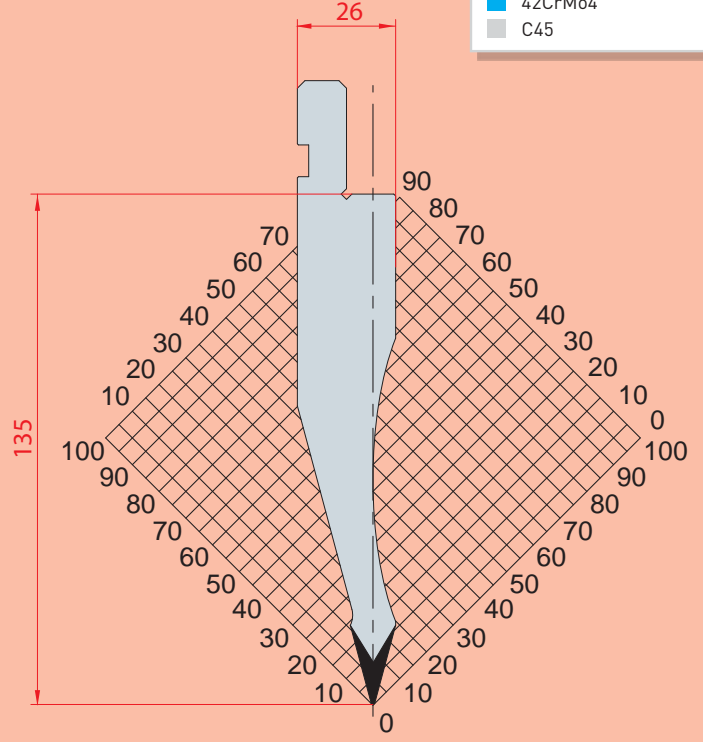
■	C45 bonificato /quenched
■	42CrMo4
■	C45

**MONOLITICO
MONOLITHIC**



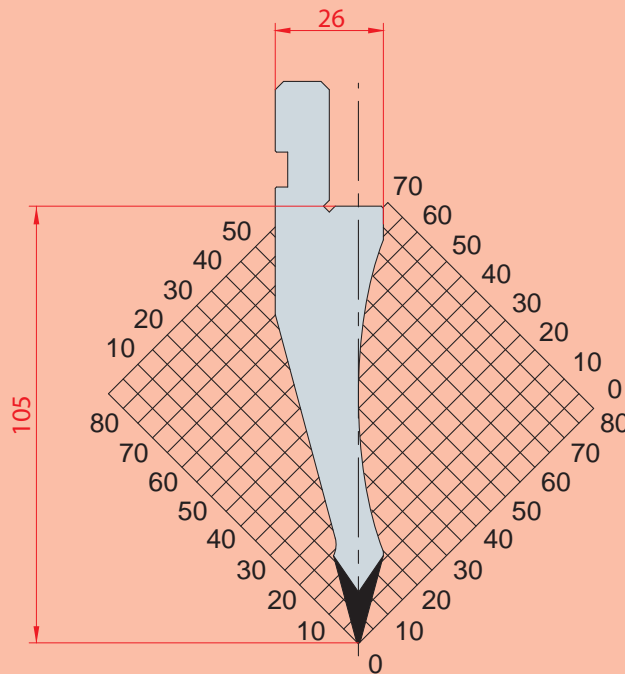
1086

$\alpha=30^\circ$ R=0.6 H=140.00 Max T/m=40



1052

$\alpha=30^\circ$ R=0.5 H=135.00 Max T/m=50

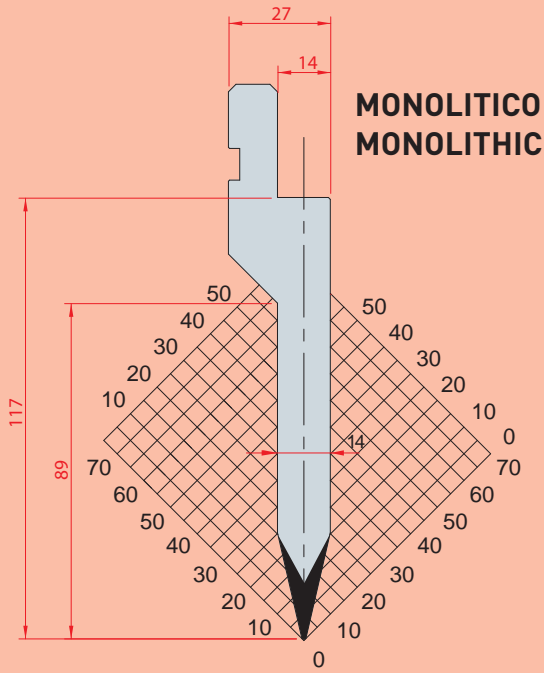


1055

$\alpha=30^\circ$ R=0.5 H=105.00 Max T/m=50

PUNZONI - 26° / PUNCHES - 26°

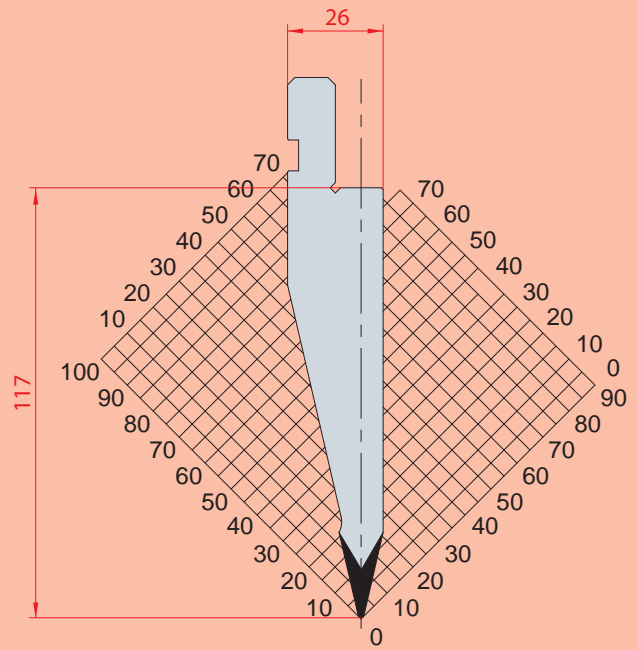
- C45 bonificato /quenched
- 42CrMo4
- C45



**MONOLITICO
MONOLITHIC**

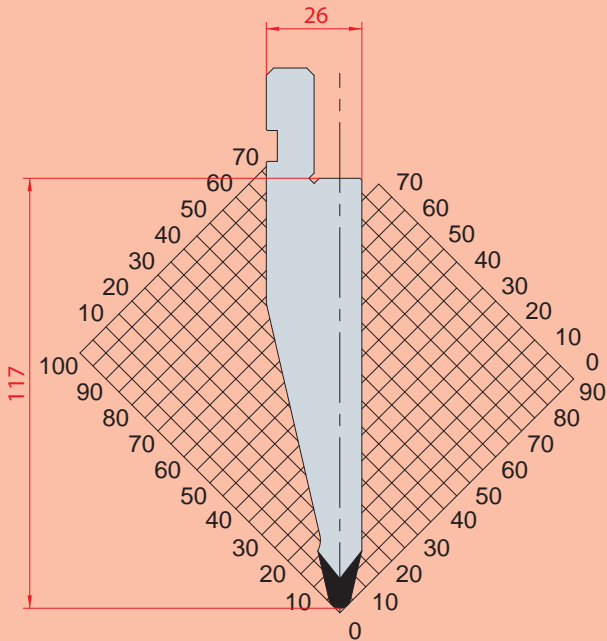
1033

$\alpha=26^\circ$ P=1 H=117.00 Max T/m=100



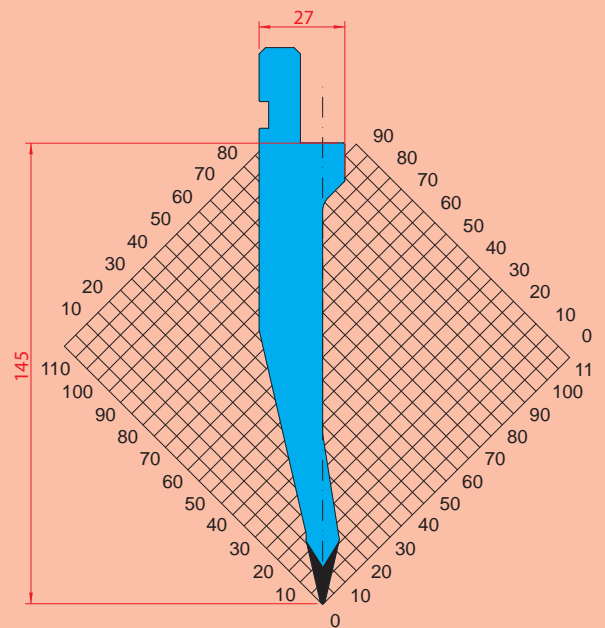
1178

$\alpha=26^\circ$ R=0.8 H=117.00 Max T/m=100



1192

$\alpha=26^\circ$ R=3 H=117.00 Max T/m=100



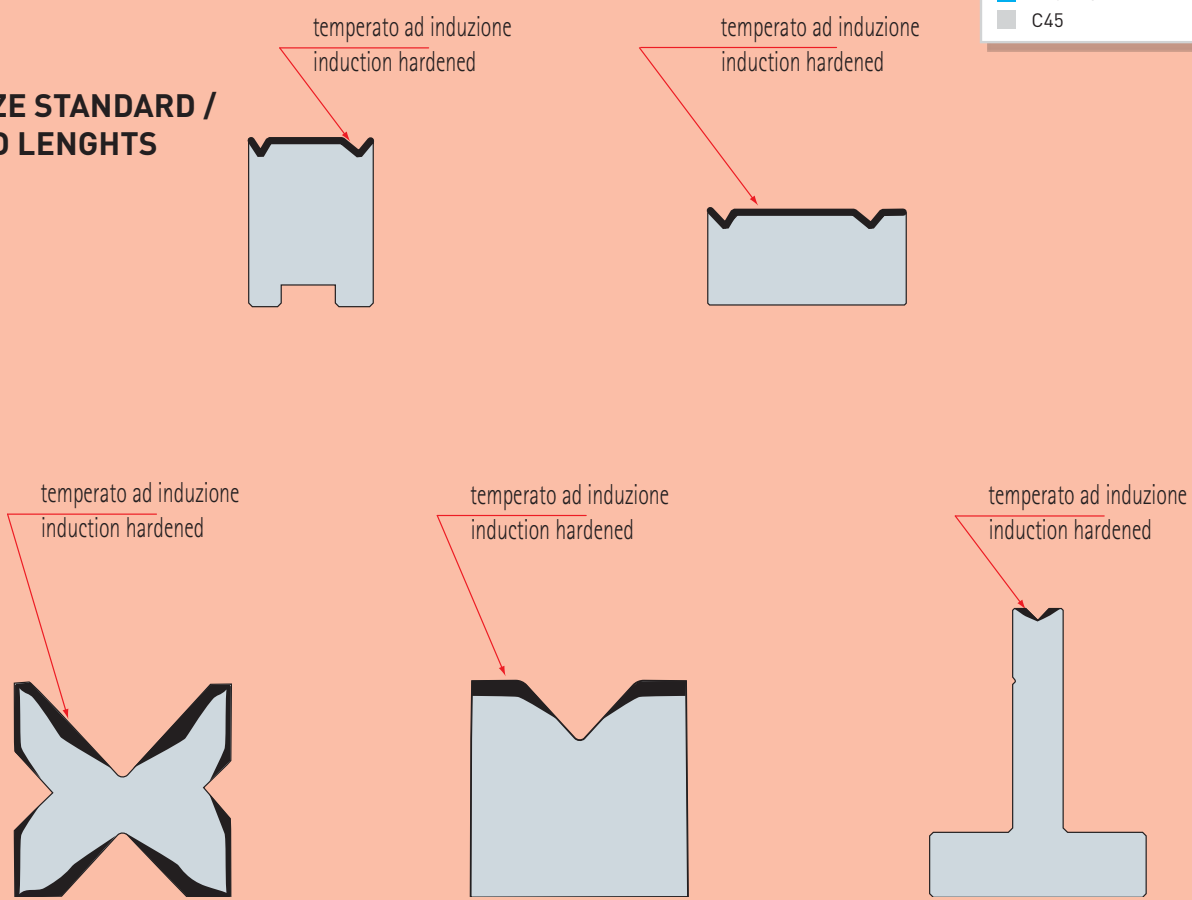
1311

$\alpha=26^\circ$ R=0.8 H=145.00 Max T/m=100

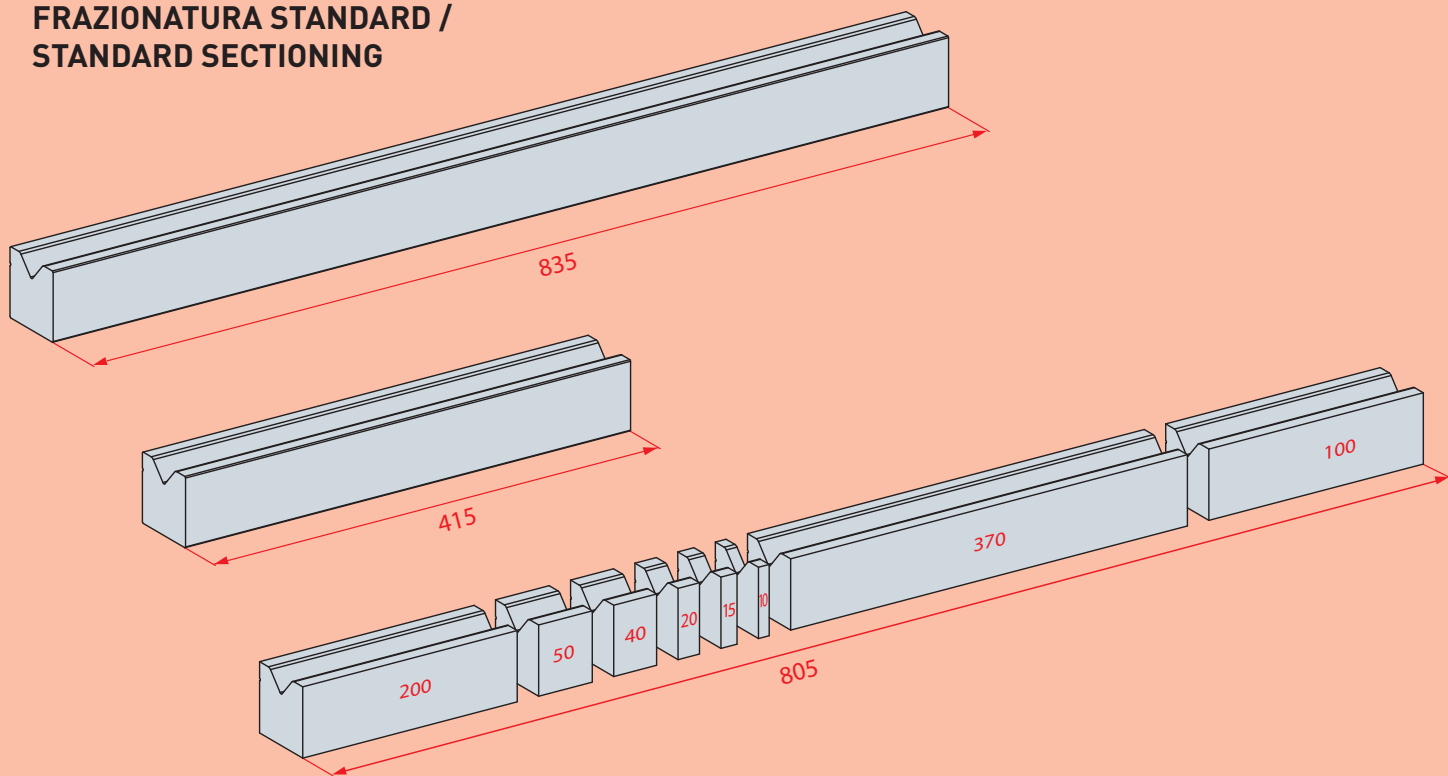
MATRICI / DIES

- C45 bonificato /quenched
- 42CrMo4
- C45

LUNGHEZZE STANDARD /
STANDARD LENGTHS

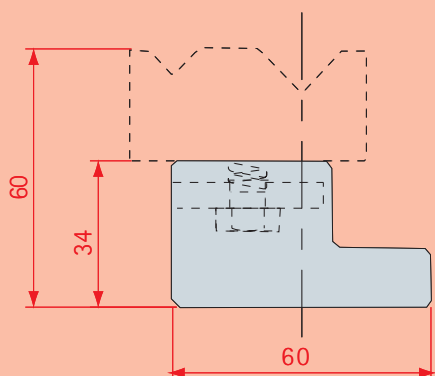


FRAZIONATURA STANDARD /
STANDARD SECTIONING

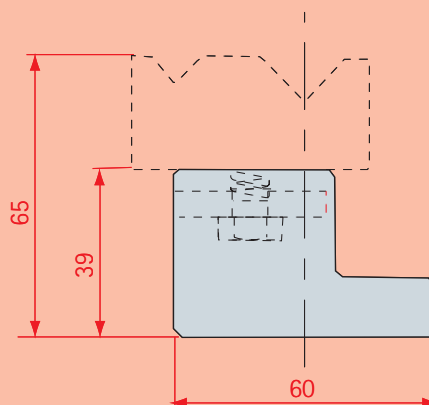


RIALZI PER MATRICI 2V / DIE HOLDER FOR 2V DIES

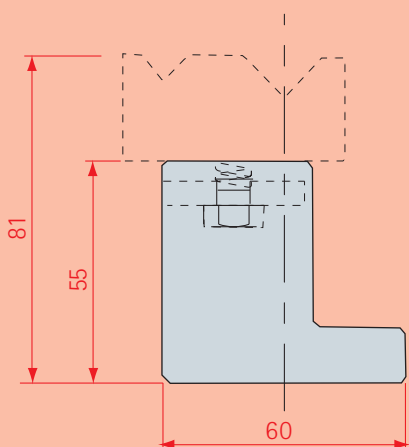
- C45 bonificato /quenched
- 42CrMo4
- C45



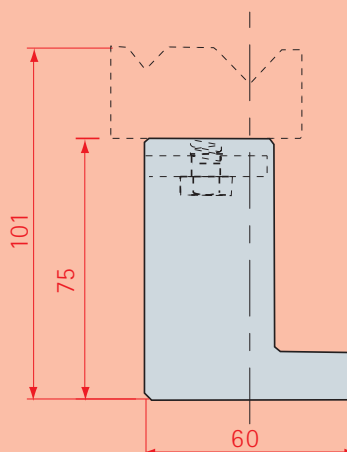
2018



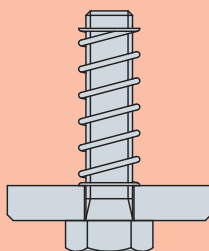
2039



2019



2035

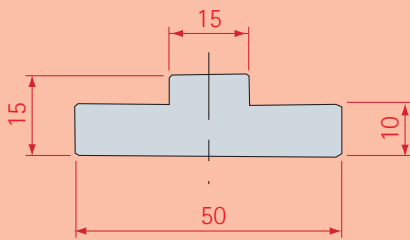


4277

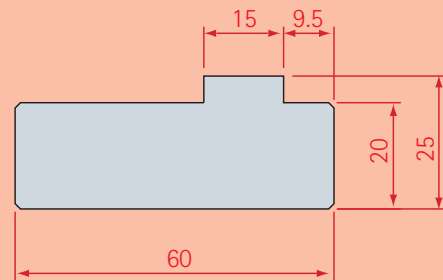
**MOLLA + RONDELLA + VITE
 SPRING + WASCHER + SCREW**

RIALZI PER MATRICI AUTOCENTRANTI / DIE HOLDER FOR CENTERING DIES

- C45 bonificato /quenched
- 42CrMo4
- C45

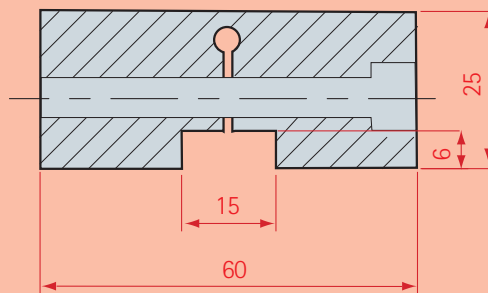


2058



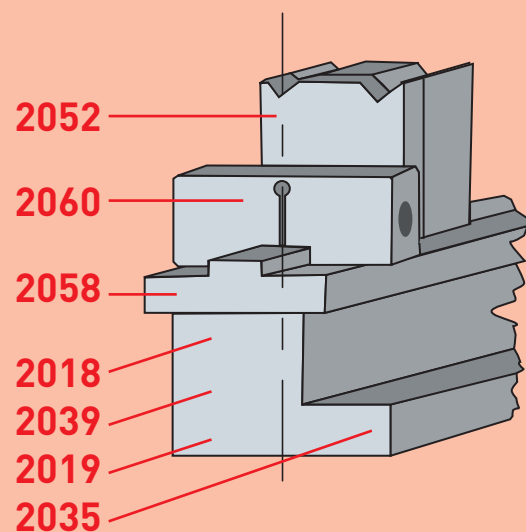
2059

FERMO PER MATRICI AUTOCENTRANTI / FIXED BAR FOR SELF CENTERING DIES



2060

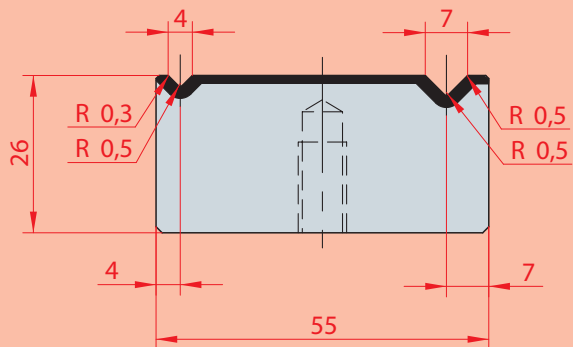
ESEMPIO DI MONTAGGIO / FITTING EXAMPLE



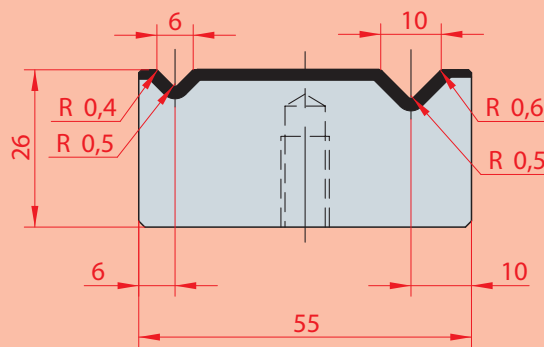
MATRICI - 2V / 2V DIES

90°

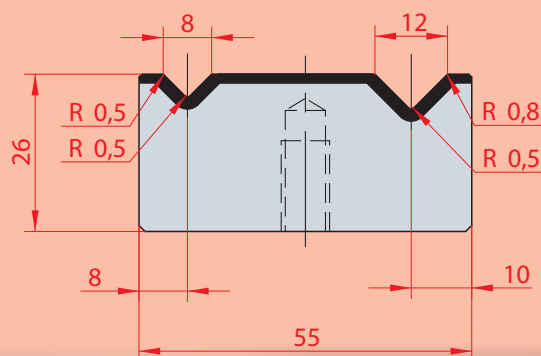
- C45 bonificato /quenched
- 42CrMo4
- C45



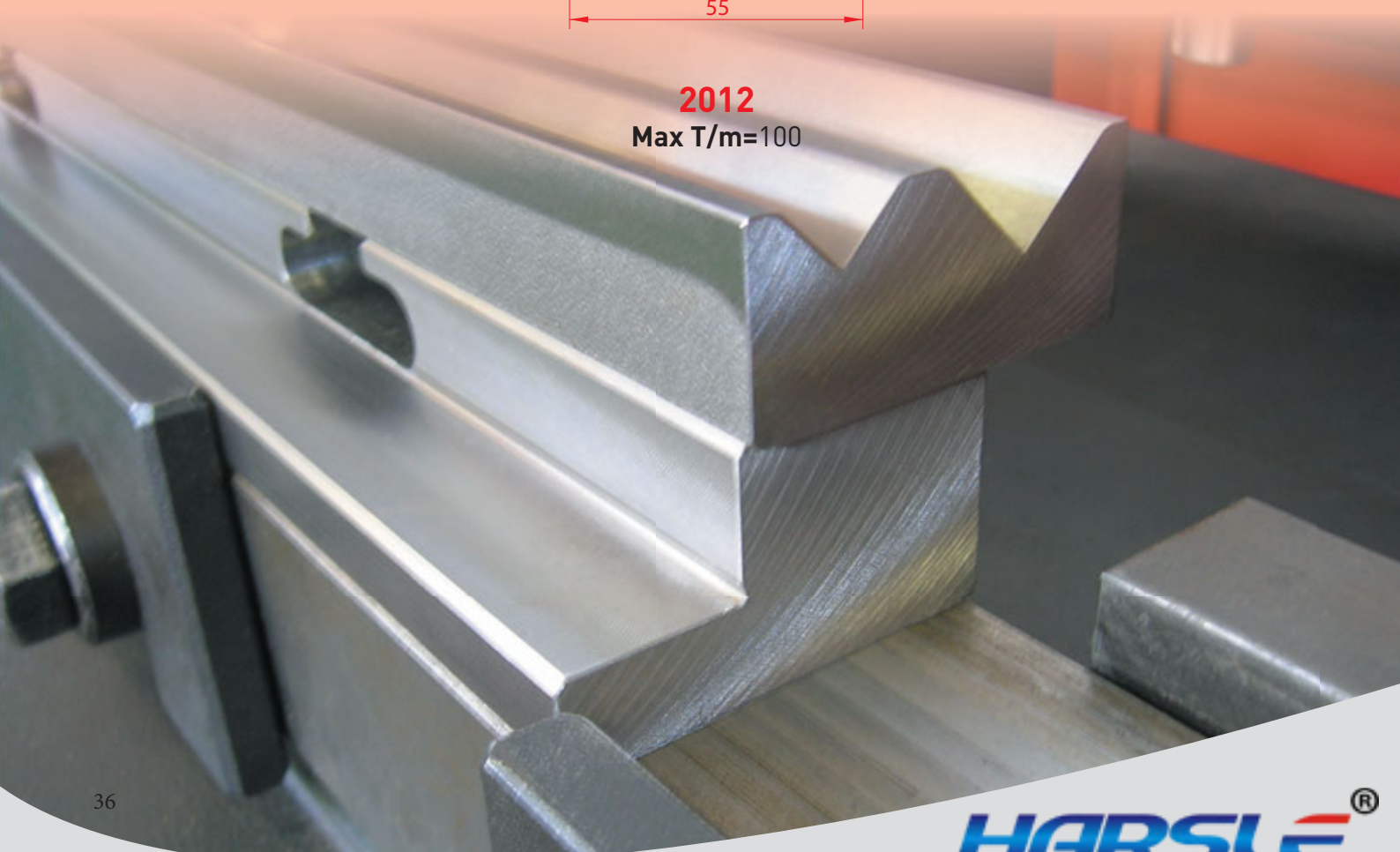
2010
Max T/m=100



2011
Max T/m=100



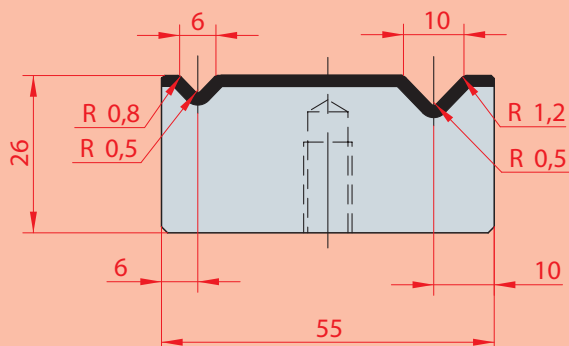
2012
Max T/m=100



MATRICI - 2V / 2V DIES

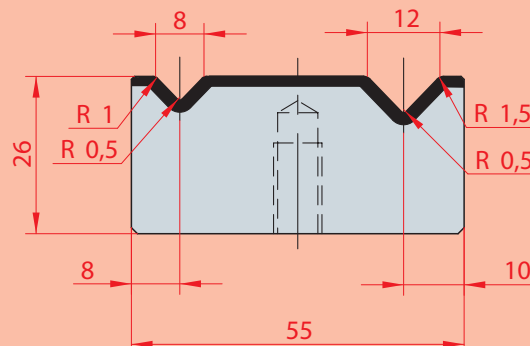
- C45 bonificato /quenched
- 42CrMo4
- C45

88°



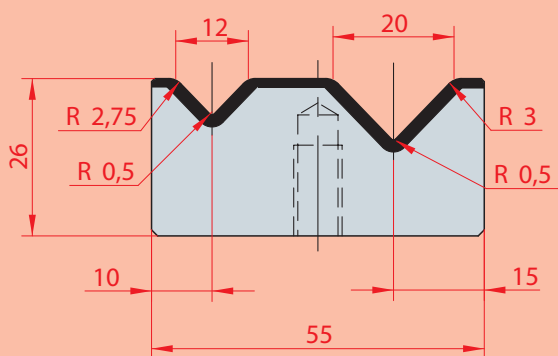
2046
Max T/m=100

88°



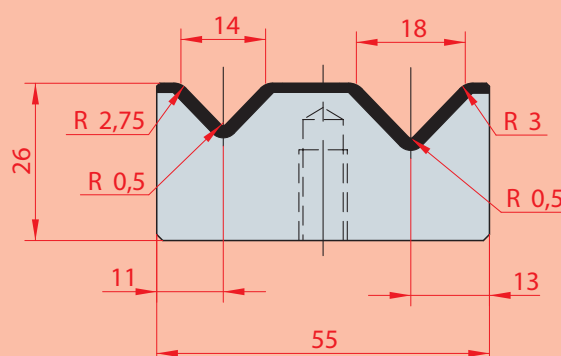
2041
Max T/m=100

88°



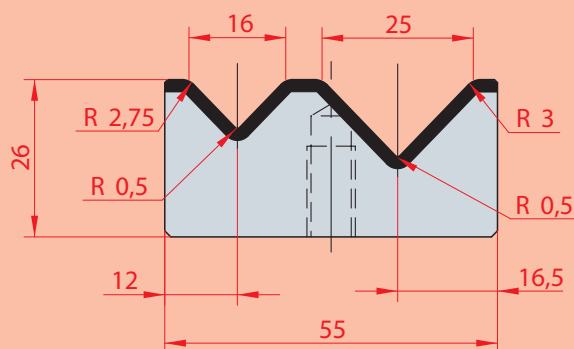
2013
Max T/m=100

88°



2032
Max T/m=100

88°

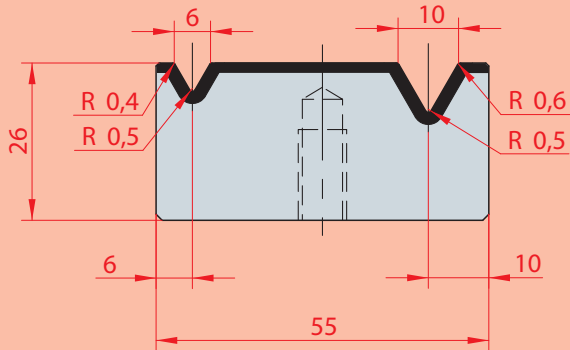


2014
Max T/m=100

MATRICI - 2V / 2V DIES

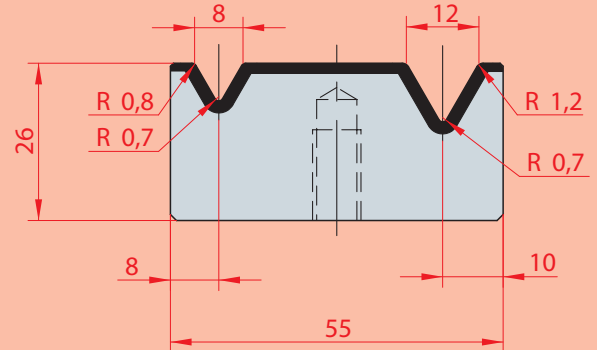
- C45 bonificato /quenched
- 42CrMo4
- C45

60°



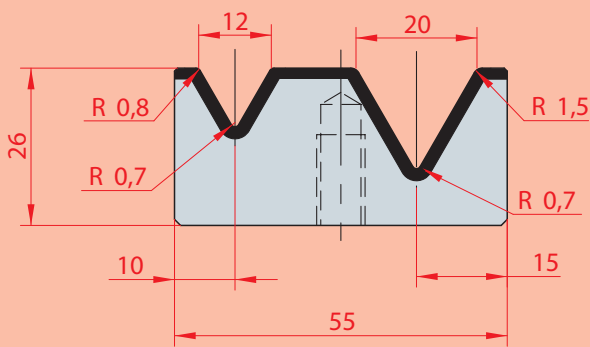
2015
Max T/m=60

60°



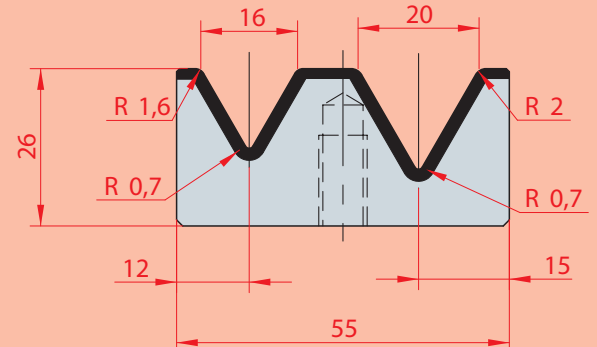
2016
Max T/m=60

60°



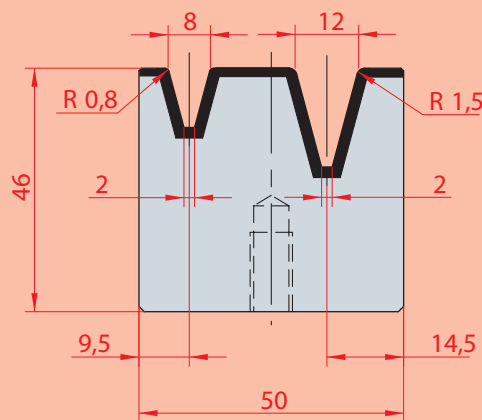
2033
Max T/m=60

60°



2017
Max T/m=60

30°

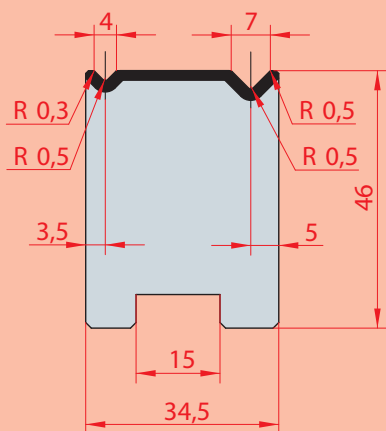


2047
Max T/m=40

MATRICI - 2V AUTOCENTRANTI / 2V SELF CENTERING DIES

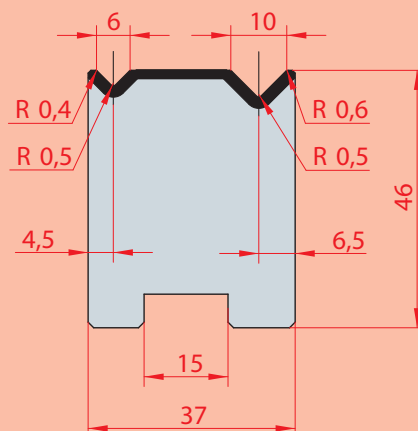
- C45 bonificato /quenched
- 42CrMo4
- C45

90°



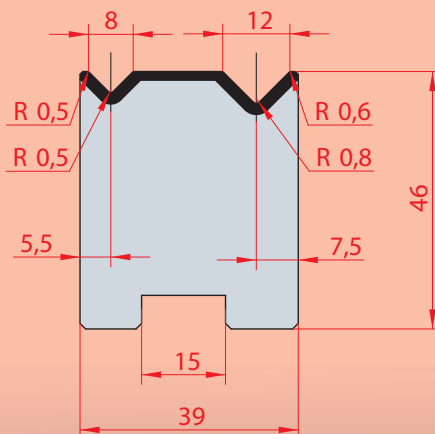
2048
Max T/m=80

90°

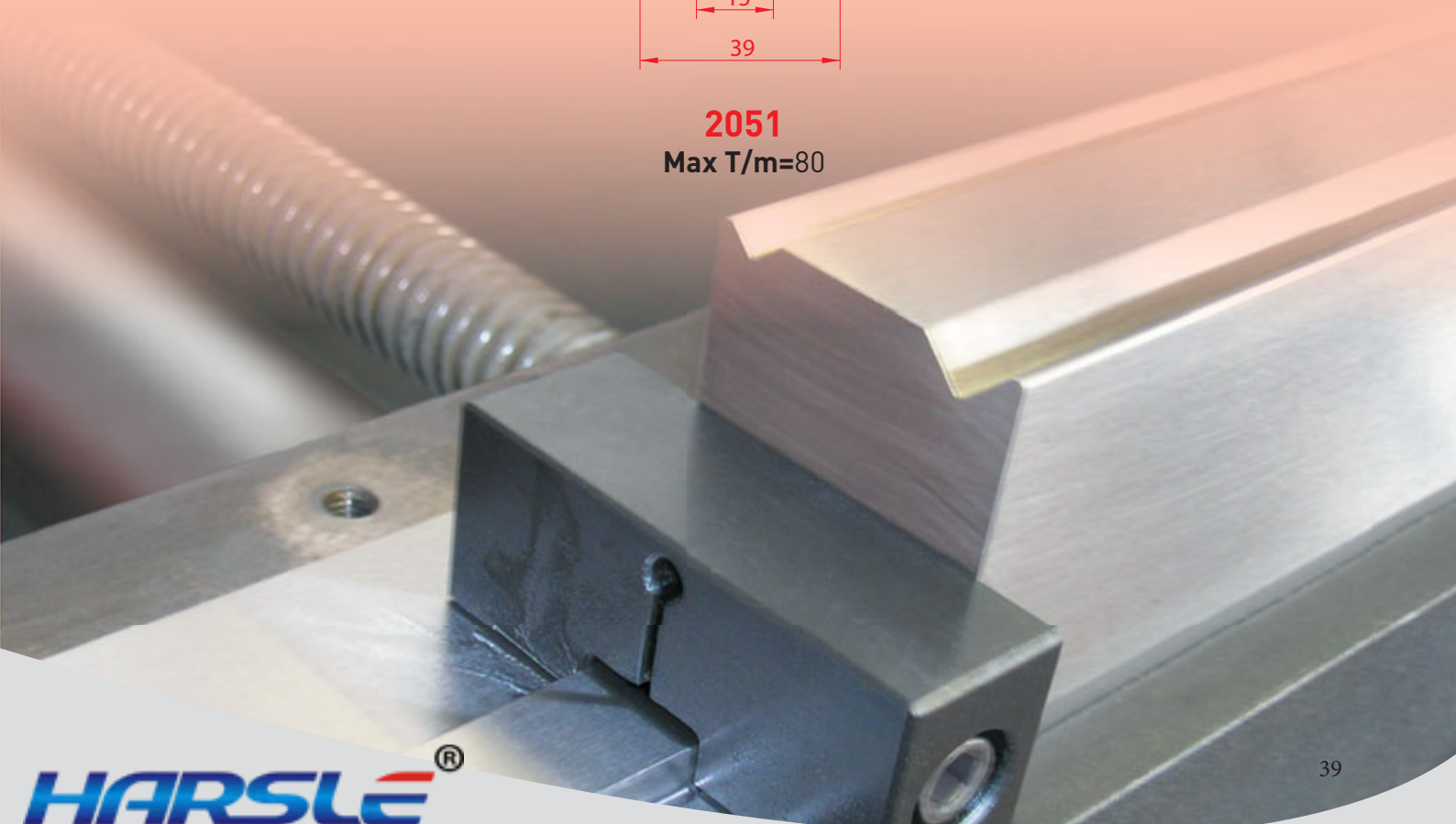


2049
Max T/m=80

90°

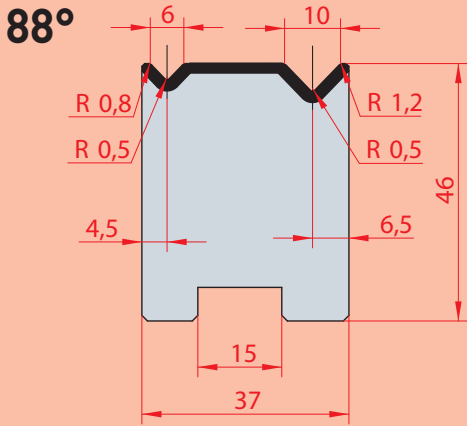


2051
Max T/m=80

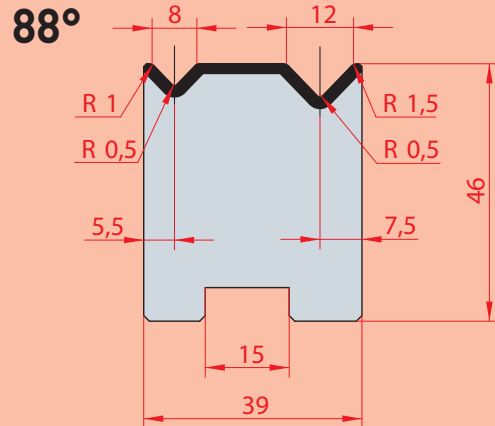


MATRICI - 2V AUTOCENTRANTI / 2V SELF CENTERING DIES

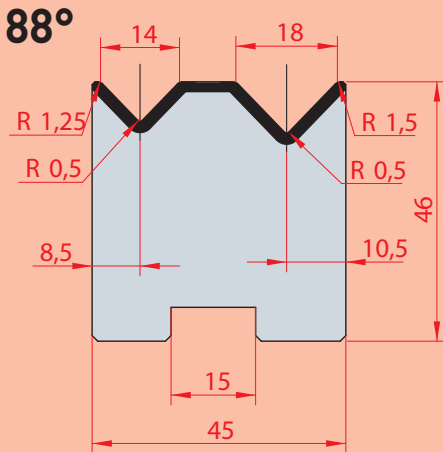
- C45 bonificato /quenched
- 42CrMo4
- C45



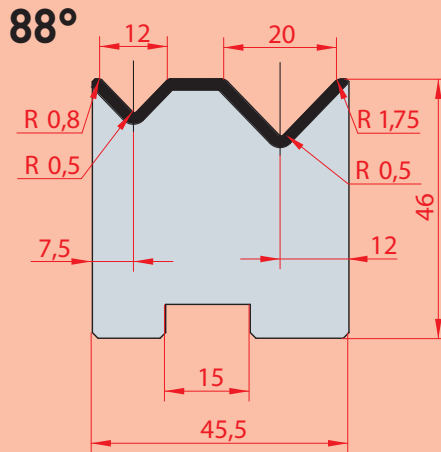
2050
Max T/m=80



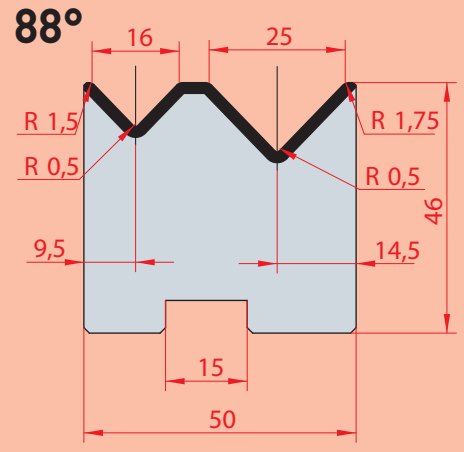
2052
Max T/m=80



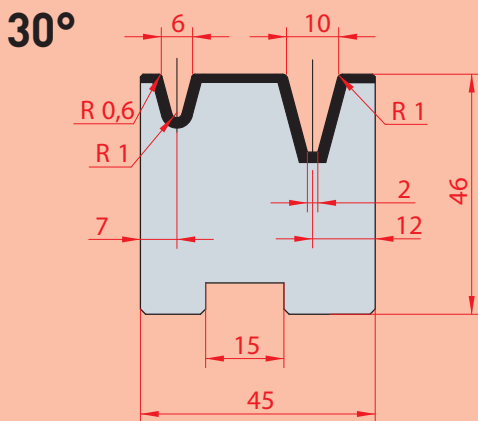
2053
Max T/m=80



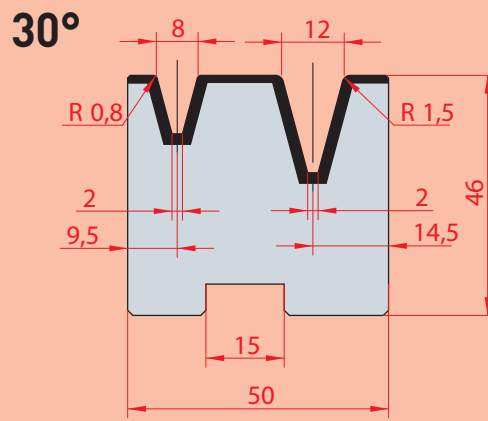
2054
Max T/m=80



2055
Max T/m=80



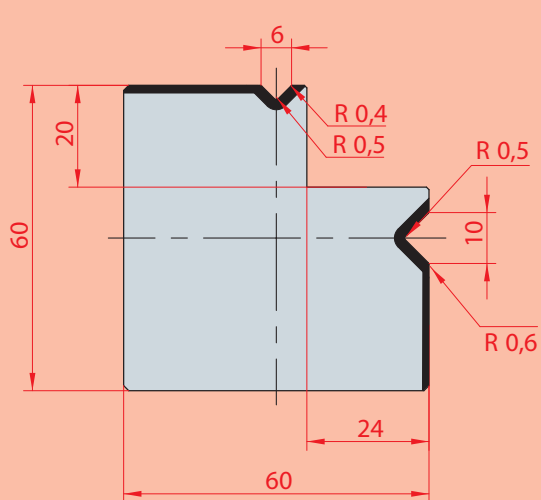
2057
Max T/m=40



2056
Max T/m=40

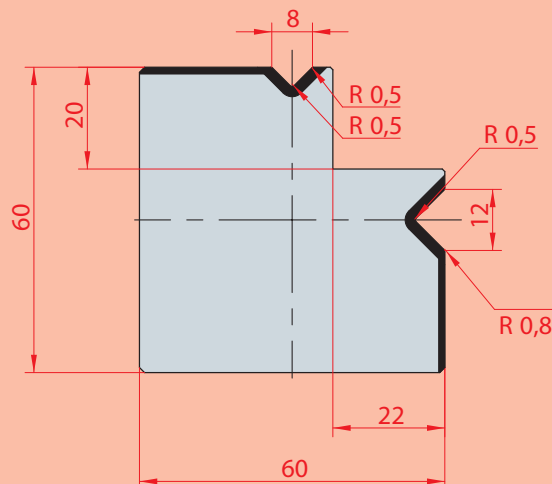
MATRICI 2V L / 2V L DIES

- C45 bonificato /quenched
- 42CrMo4
- C45



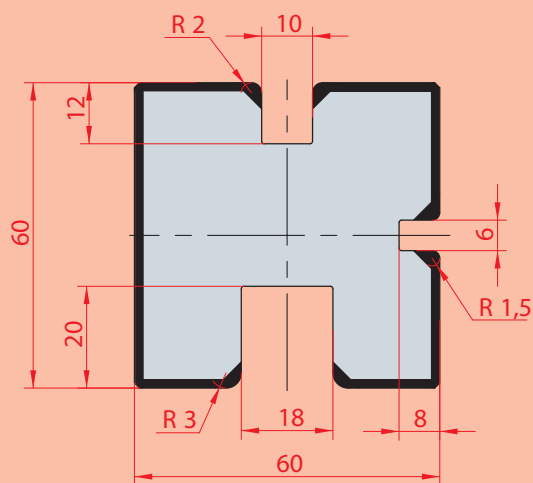
2028
Max T/m=80

90°



2029
Max T/m=80

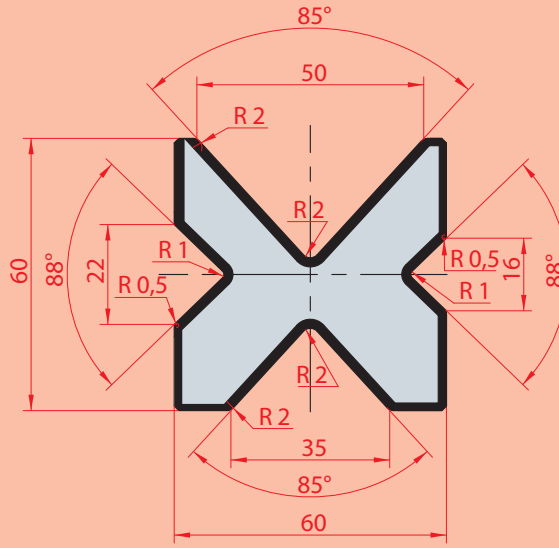
MATRICI 3U / 3U DIES



2031
Max T/m=100

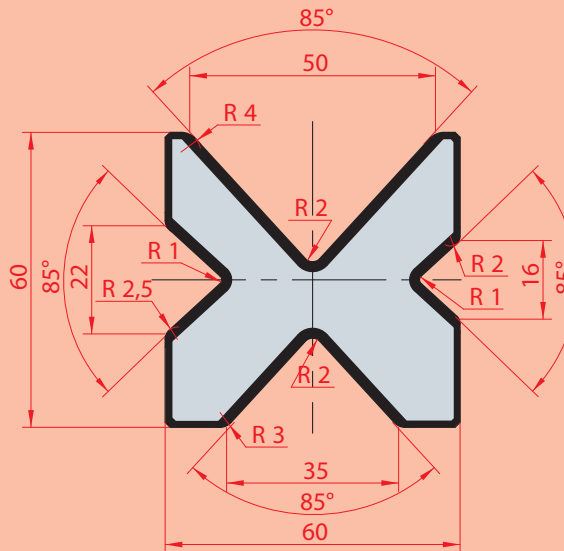
MATRICI - 4V / 4V DIES

- C45 bonificato /quenched
- 42CrMo4
- C45



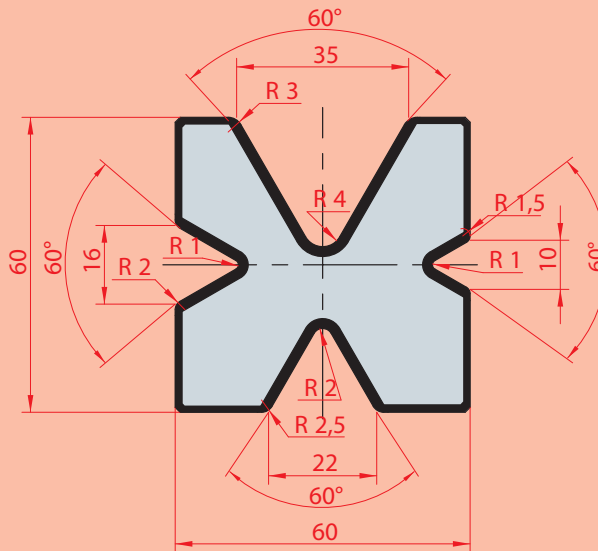
85° - 88°

2030
Max T/m=80



85°

2067
Max T/m=80

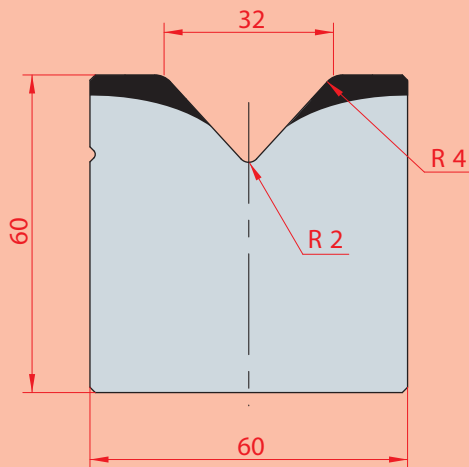


60°

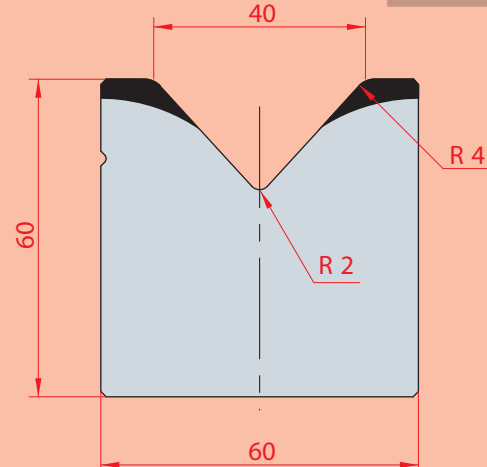
2034
Max T/m=60

MATRICI 1V - 85° / SINGLE DIES - 85°

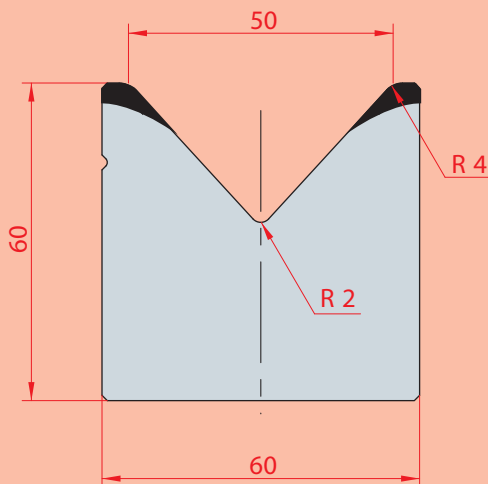
- C45 bonificato /quenched
- 42CrMo4
- C45



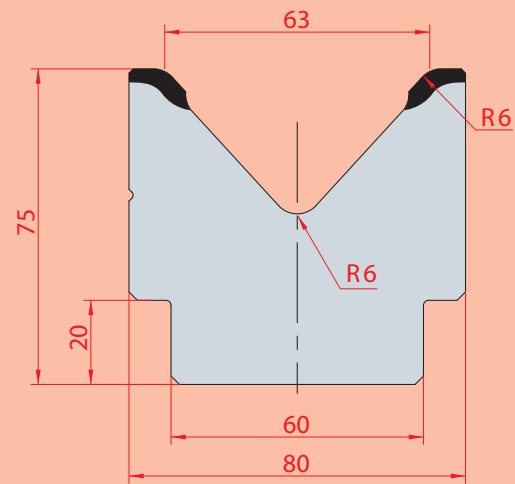
2020
Max T/m=100



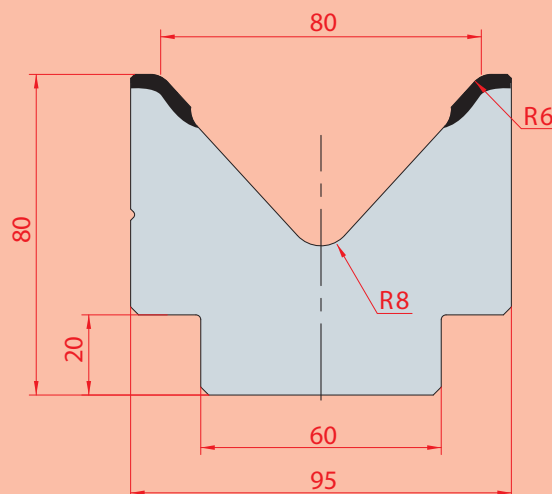
2021
Max T/m=100



2022
Max T/m=80



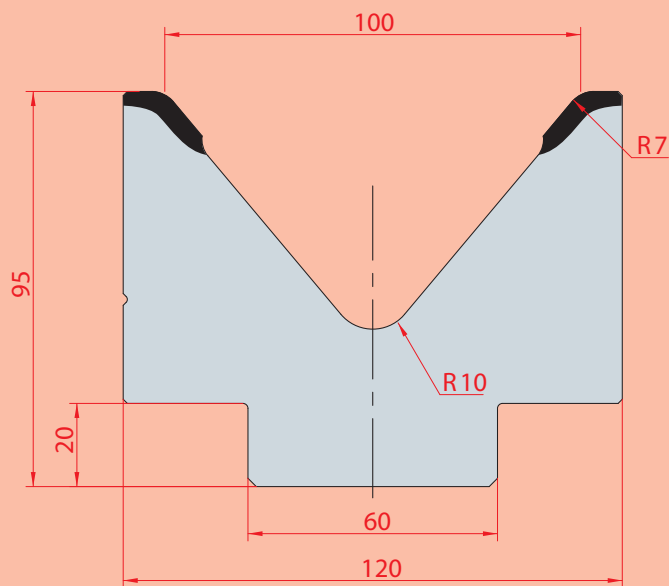
2023
Max T/m=100



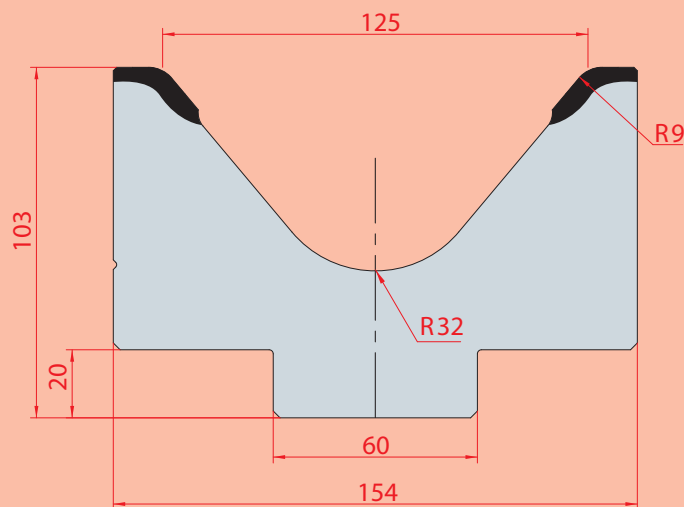
2024
Max T/m=100

MATRICI 1V - 80° / SINGLE DIES - 80°

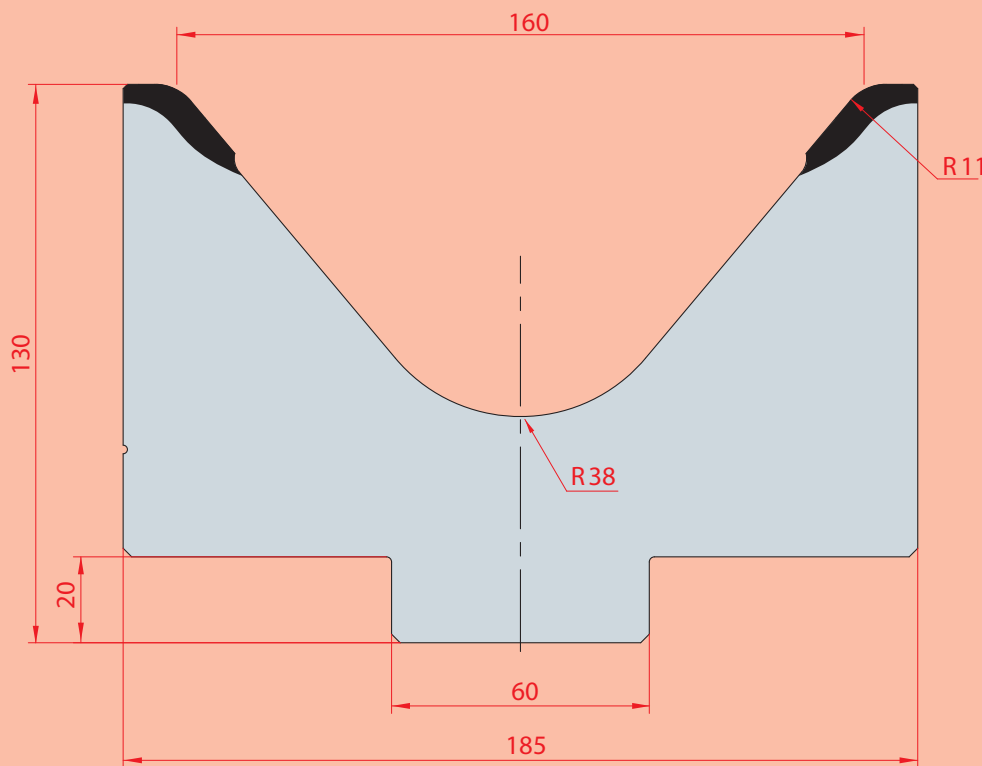
- C45 bonificato /quenched
- 42CrMo4
- C45



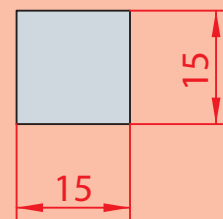
2025
Max T/m=120



2026
Max T/m=120



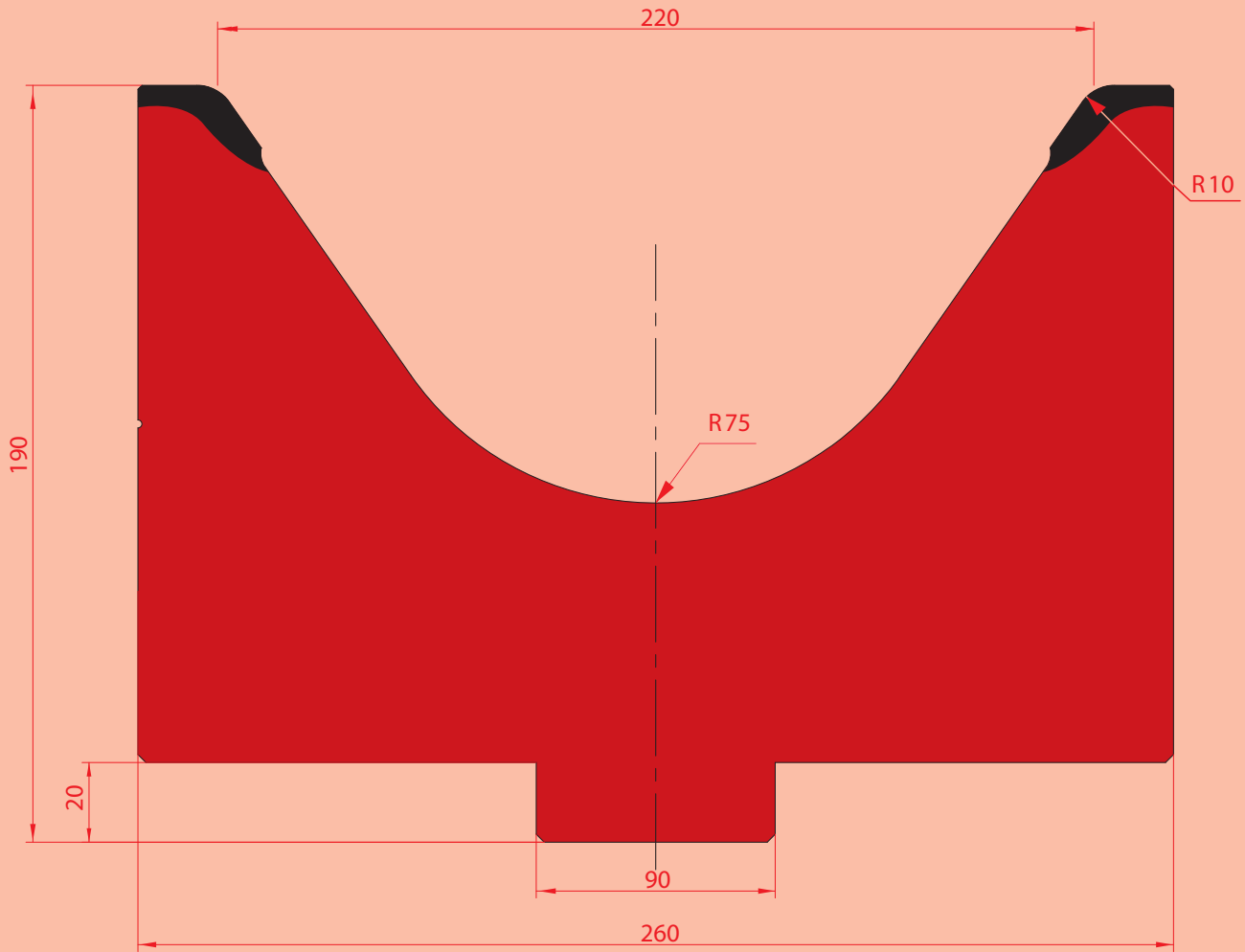
2027
Max T/m=120



8106
TRAFILATI 15X15
DRAWNS PRODUCT
15X15

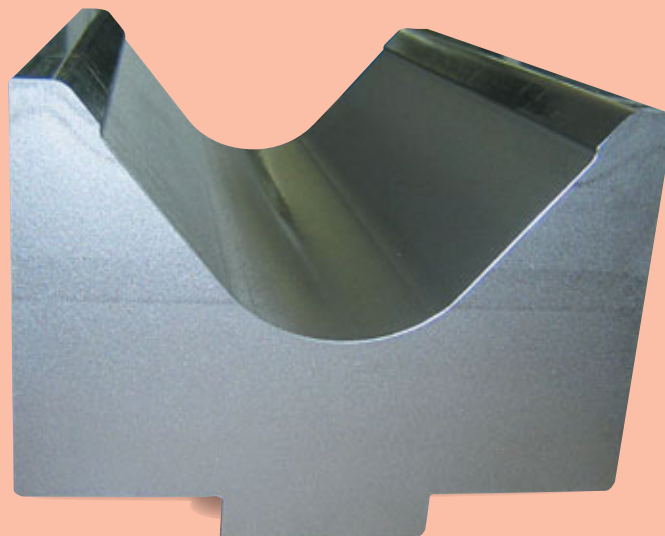
MATRICI 1V - 70° / SINGLE DIES - 70°

- C45 bonificato /quenched
- 42CrMo4
- C45



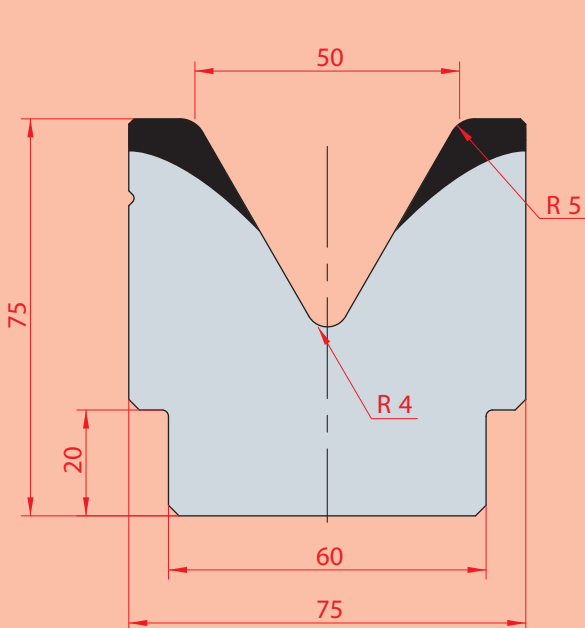
7290
Max T/m=200

L= 505
L= 805 FRAZ/SECT

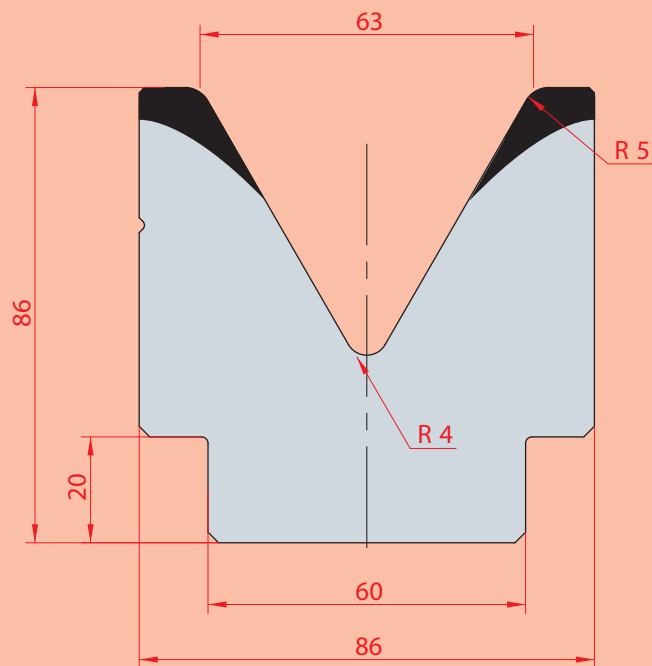


MATRICI 1V - 60° / SINGLE DIES - 60°

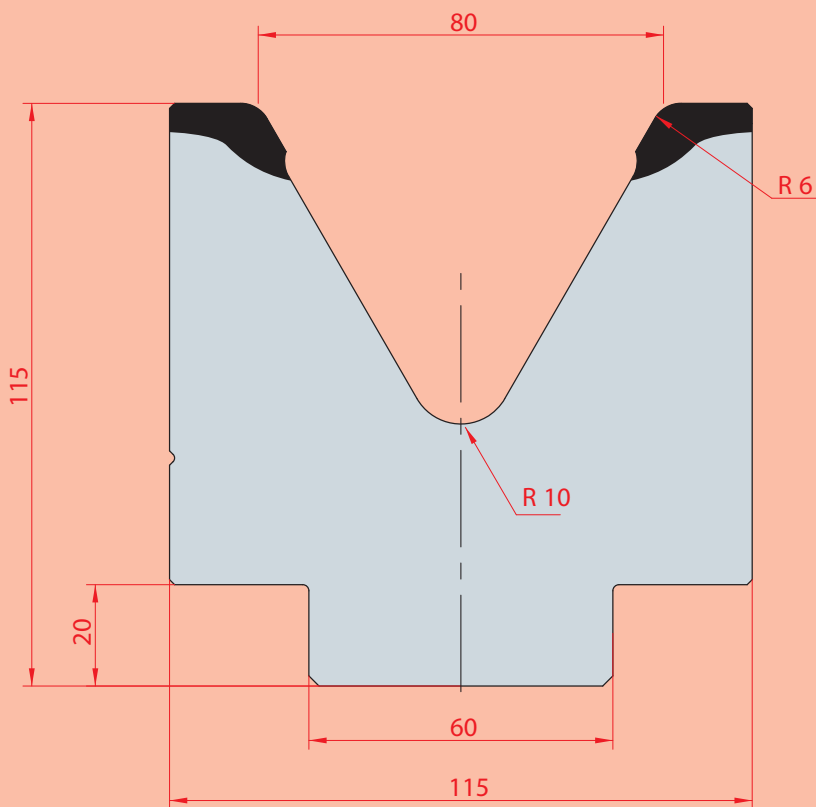
- C45 bonificato /quenched
- 42CrMo4
- C45



2082
Max T/m=100



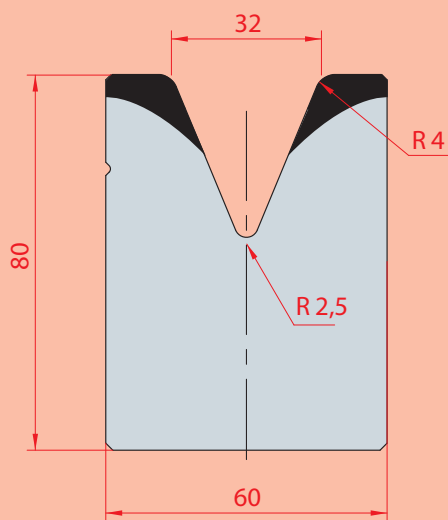
2083
Max T/m=100



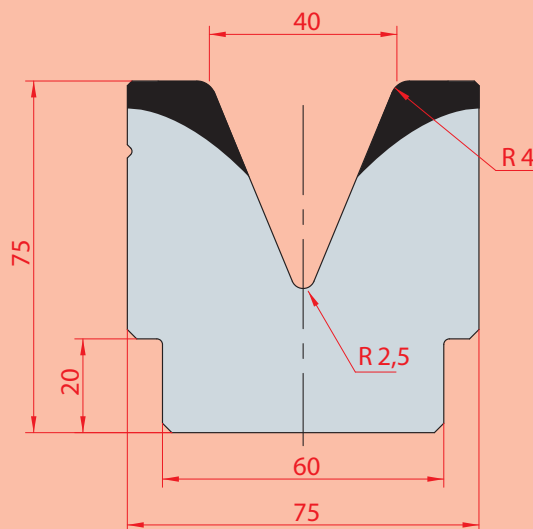
2089
Max T/m=100

MATRICI 1V - 45° / SINGLE DIES - 45°

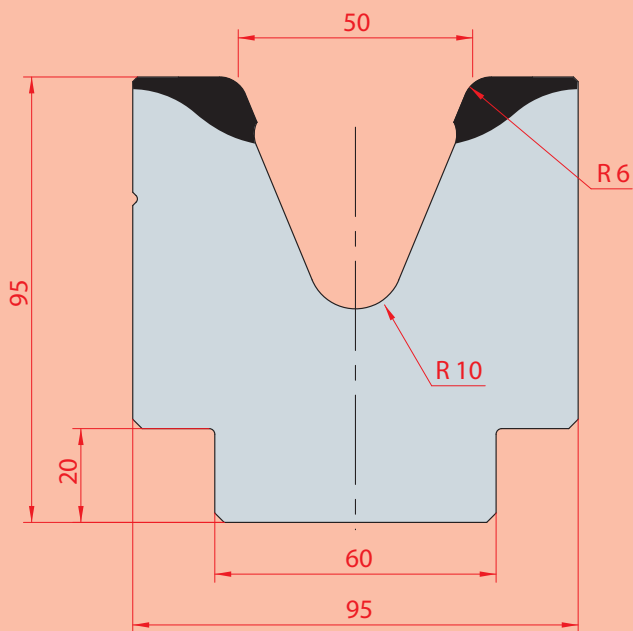
- C45 bonificato /quenched
- 42CrMo4
- C45



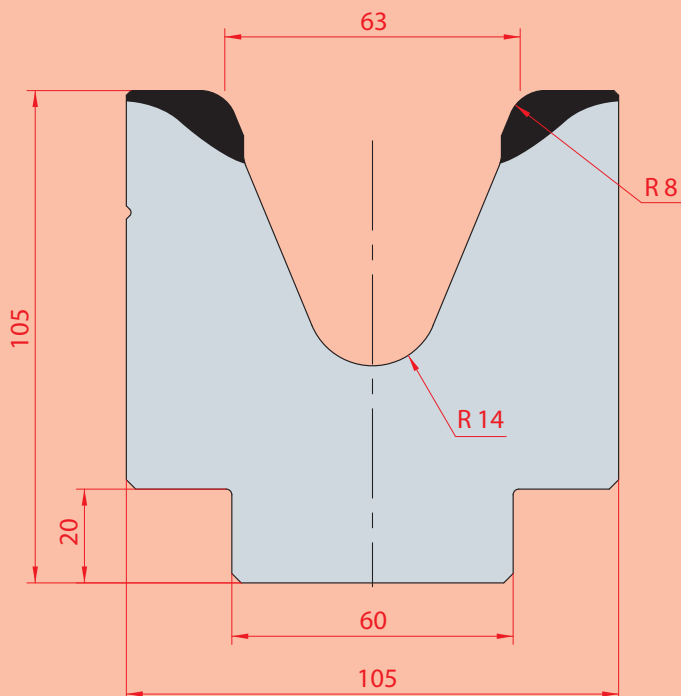
2088
Max T/m=100



2081
Max T/m=100



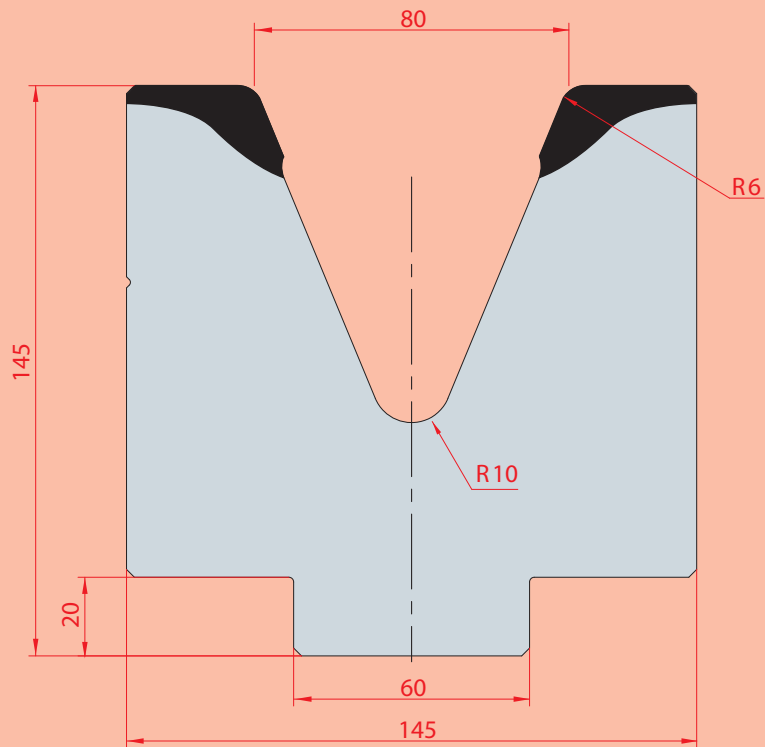
2118
Max T/m=100



2117
Max T/m=100

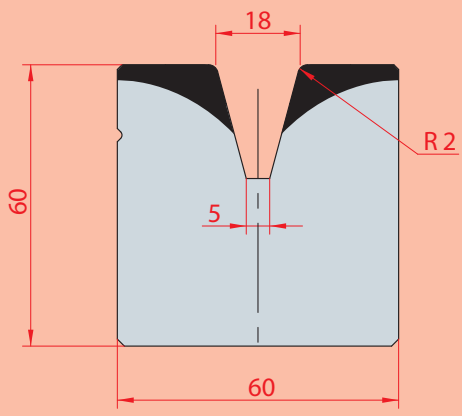
MATRICI 1V - 45° / SINGLE DIES - 45°

- C45 bonificato /quenched
- 42CrMo4
- C45

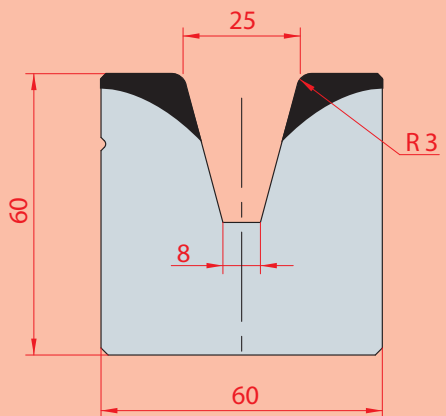


2084
Max T/m=100

MATRICI 1V - 30° / SINGLE DIES - 30°



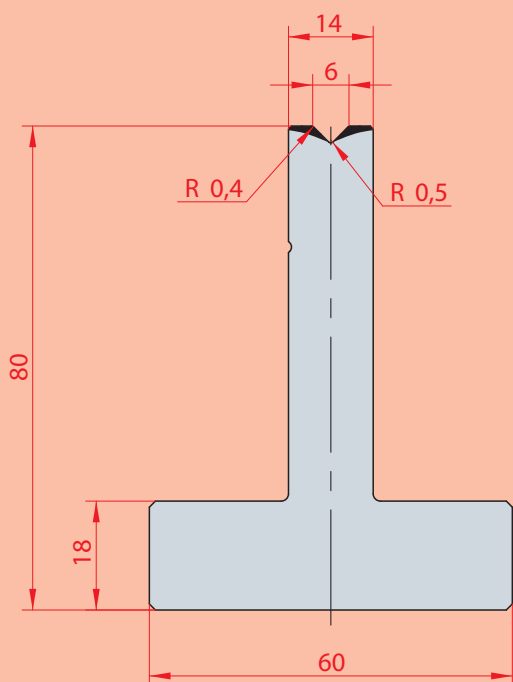
2086
Max T/m=100



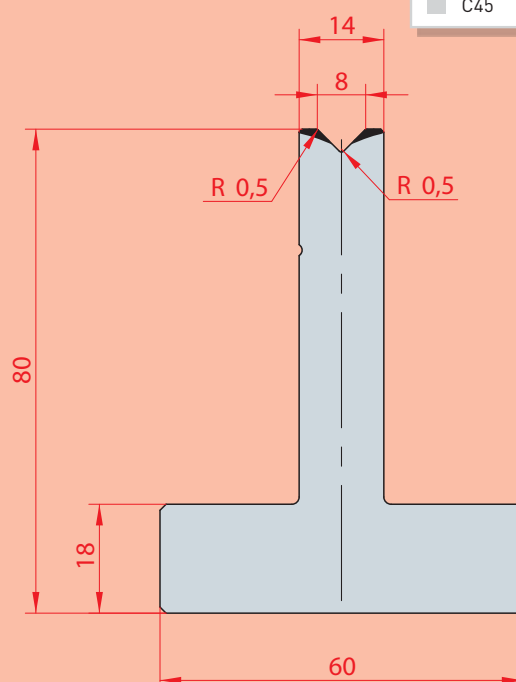
2087
Max T/m=100

MATRICI T H80 - 90° / T DIES H80 - 90°

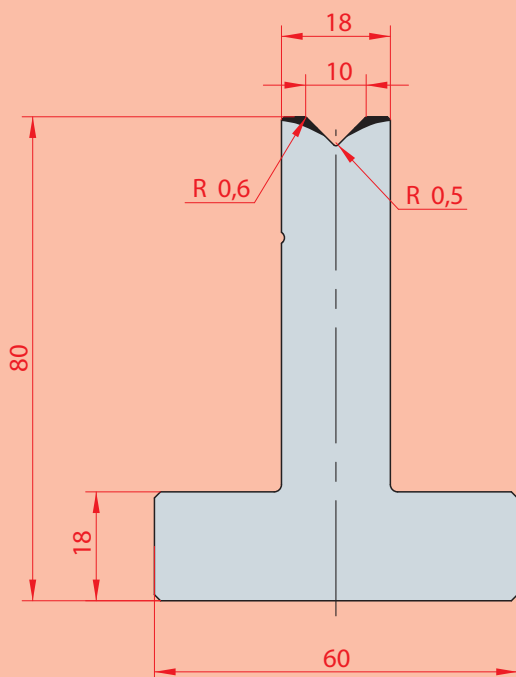
- C45 bonificato /quenched
- 42CrMo4
- C45



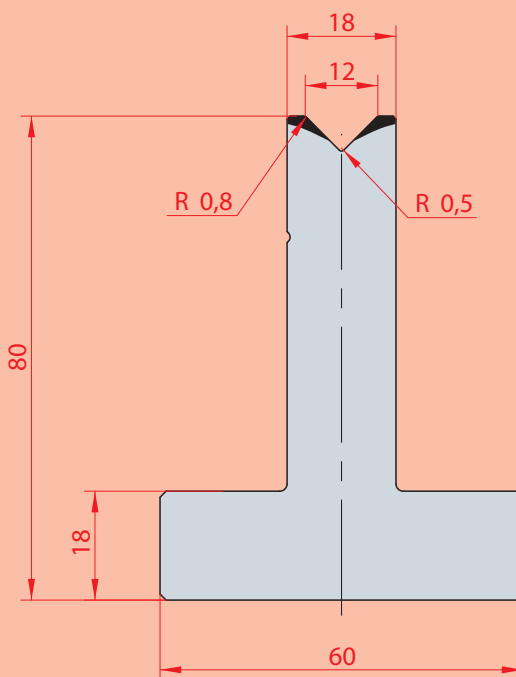
3010
Max T/m=100



3011
Max T/m=100



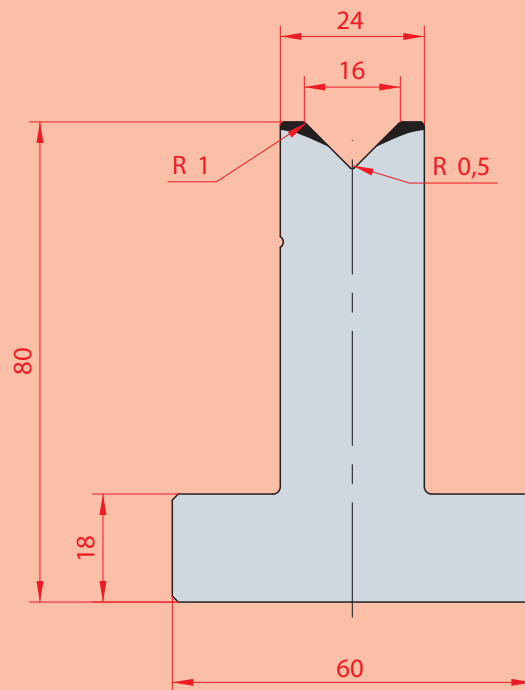
3012
Max T/m=100



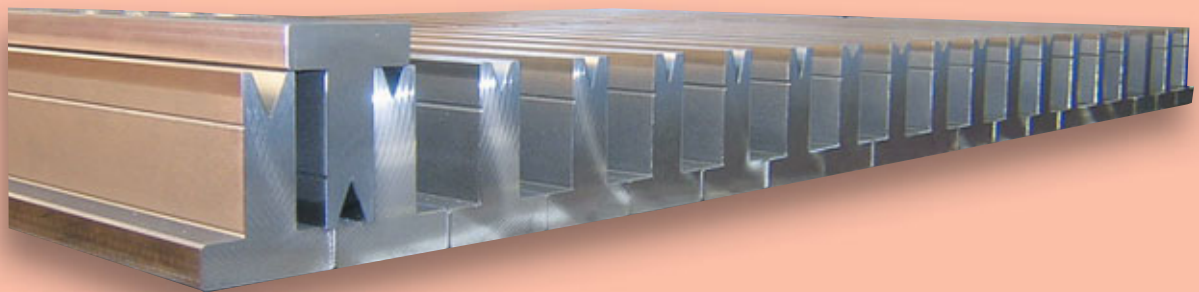
3013
Max T/m=100

MATRICI T H80 - 90° / T DIES H80 - 90°

- C45 bonificato /quenched
- 42CrMo4
- C45

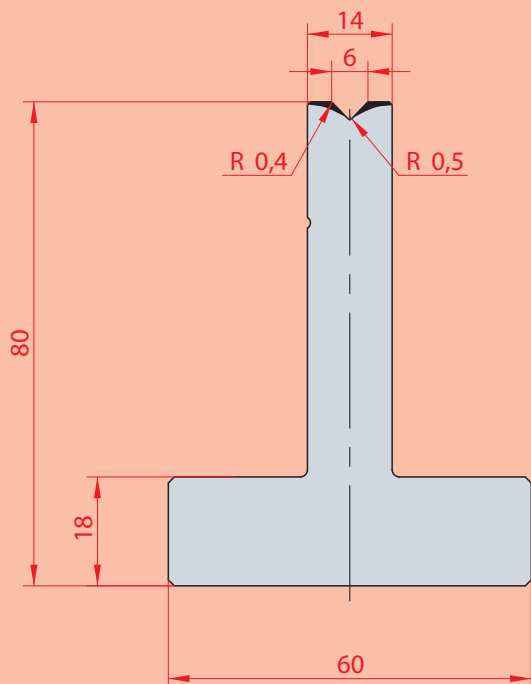


3014
Max T/m=100

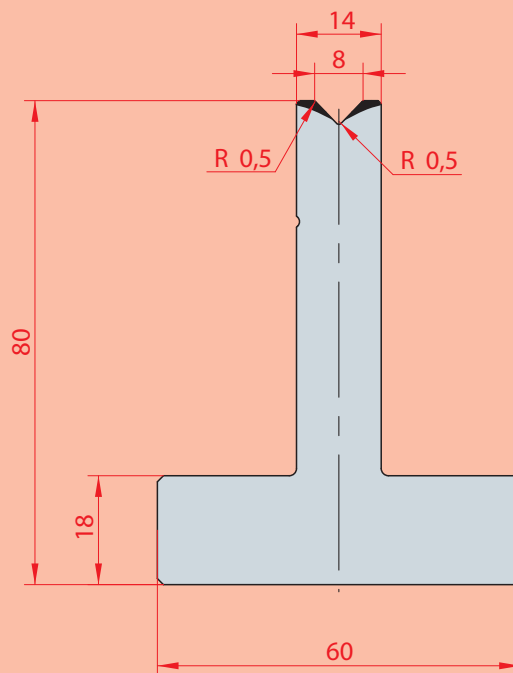


MATRICI T H80 - 88° / T DIES H80 - 88°

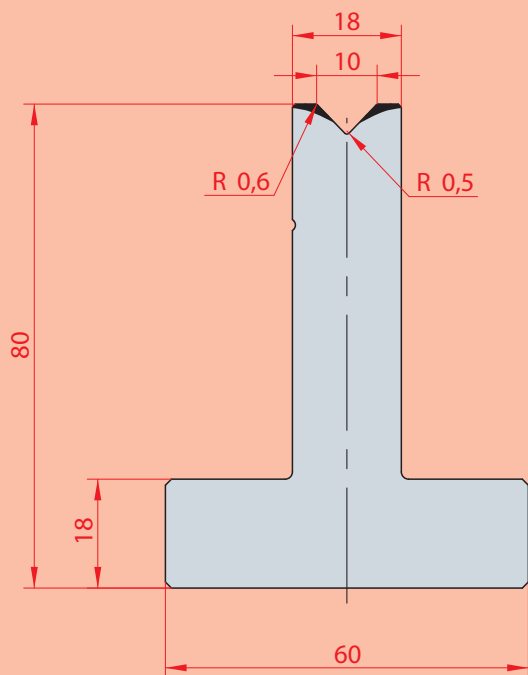
- C45 bonificato /quenched
- 42CrMo4
- C45



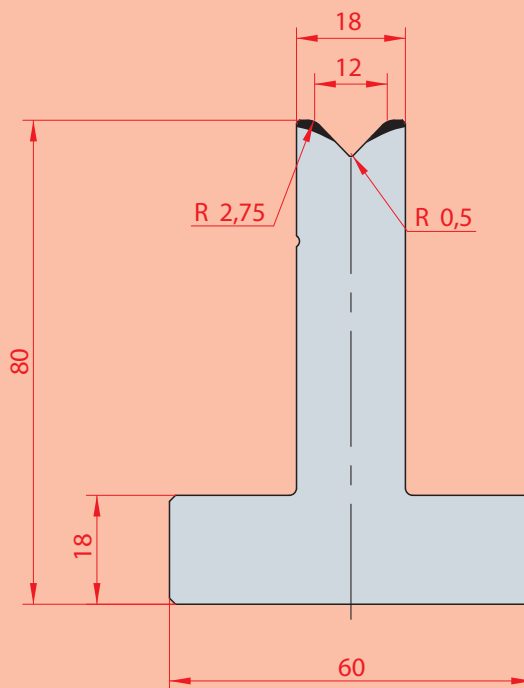
3080
Max T/m=100



3081
Max T/m=100



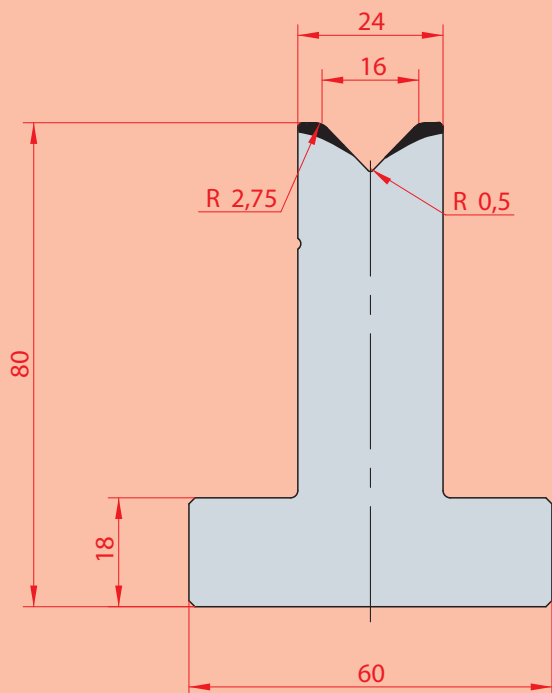
3082
Max T/m=100



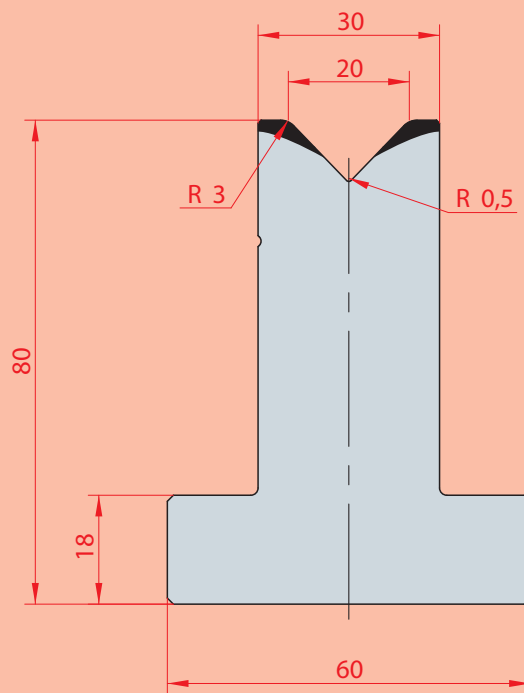
3015
Max T/m=100

MATRICI T H80 - 88° / T DIES H80 - 88°

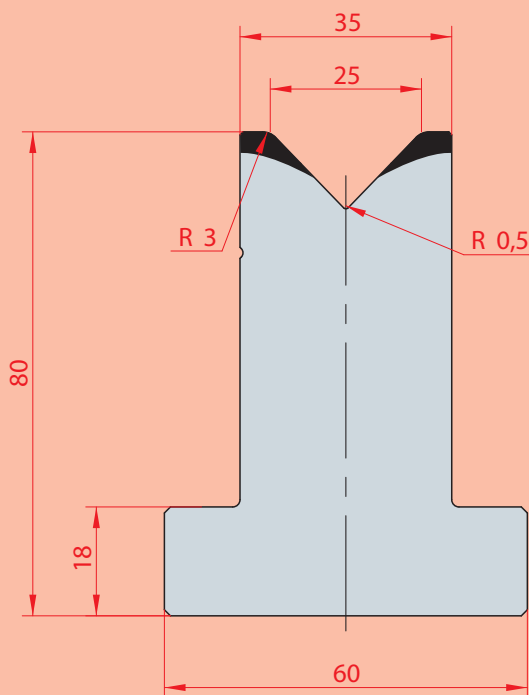
- C45 bonificato /quenched
- 42CrMo4
- C45



3016
Max T/m=100



3017
Max T/m=100

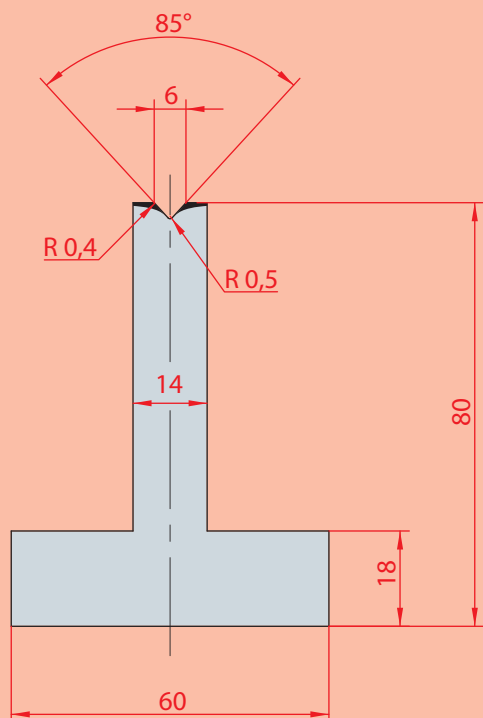


3018
Max T/m=100

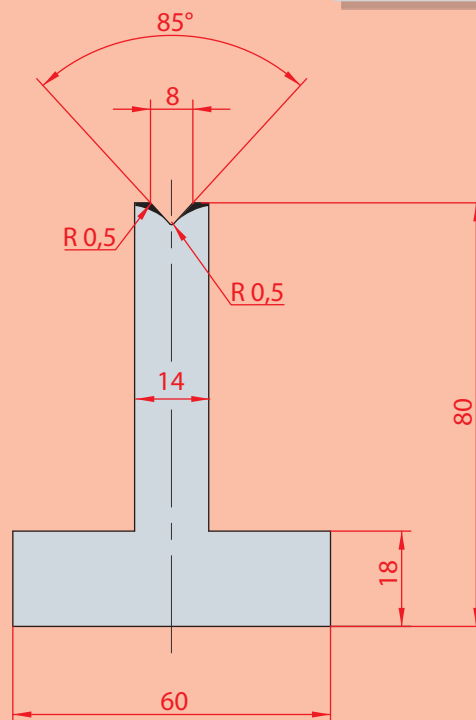
MATRICI T H80 - 85° / T DIES H80 - 85°

NEW

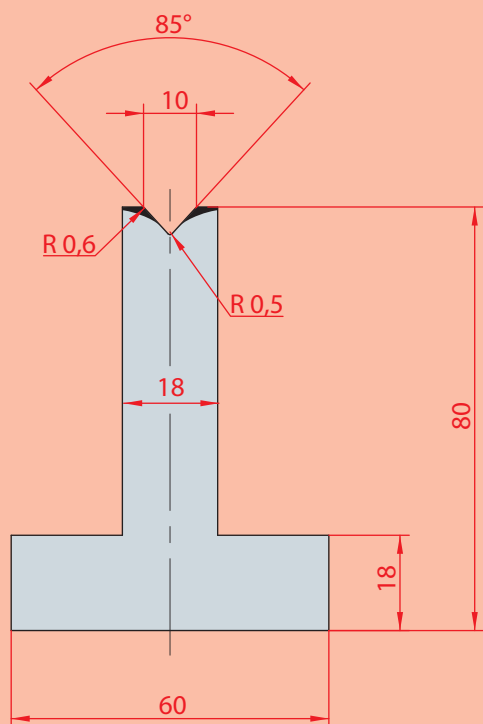
- C45 bonificato /quenched
- 42CrMo4
- C45



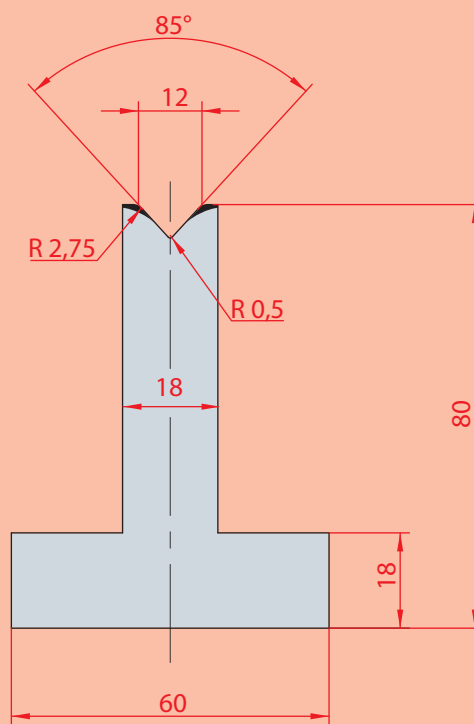
3086
Max T/m=100



3087
Max T/m=100



3088
Max T/m=100

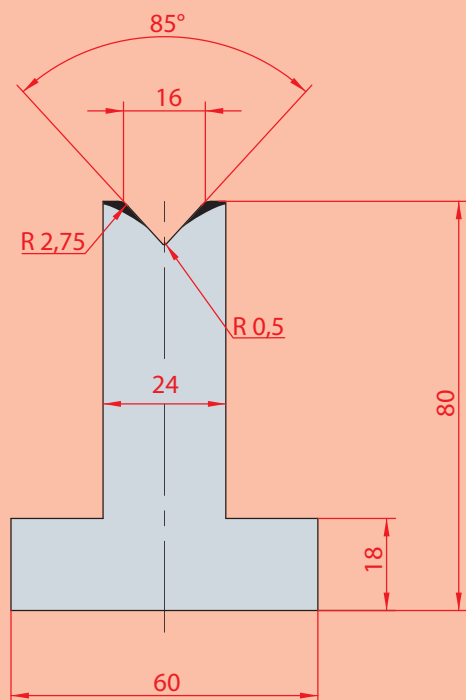


3089
Max T/m=100

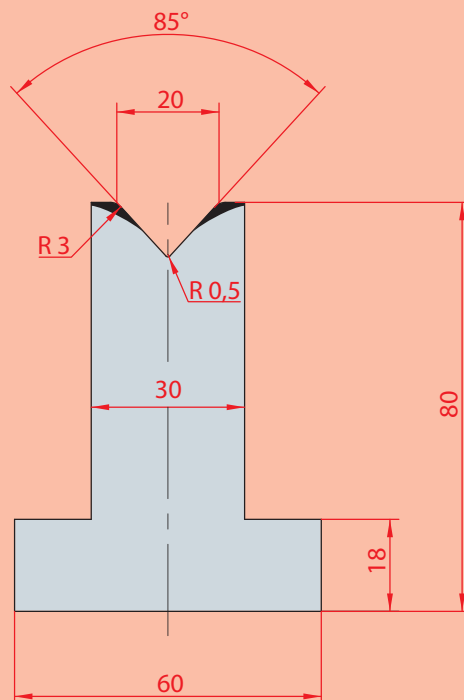
MATRICI T H80 - 85° / T DIES H80 - 85°

NEW

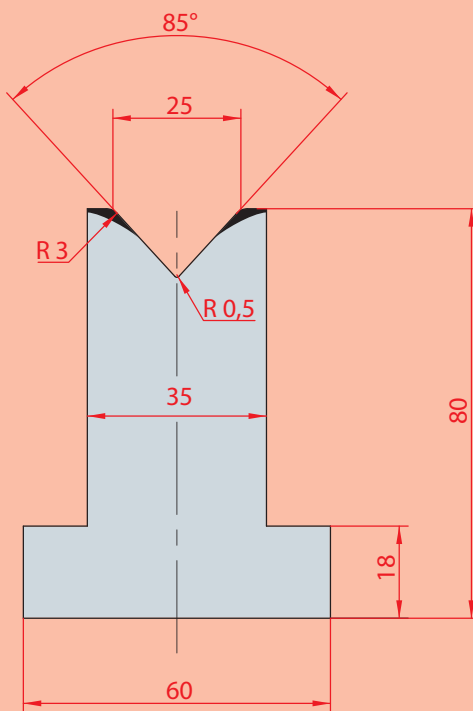
- C45 bonificato /quenched
- 42CrMo4
- C45



3090
Max T/m=100



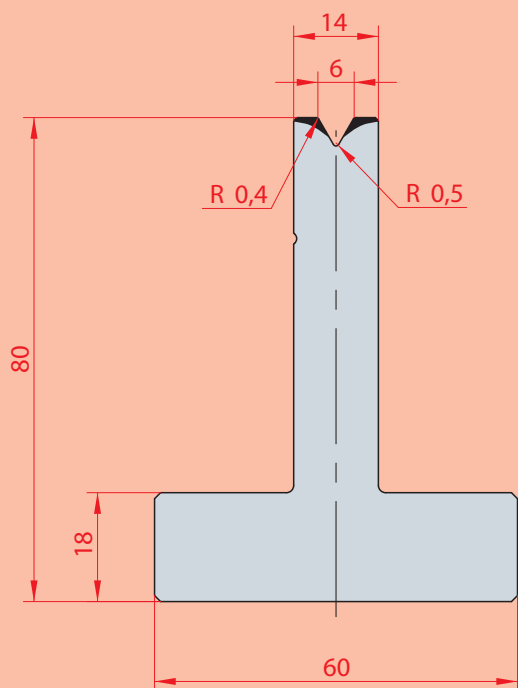
3091
Max T/m=100



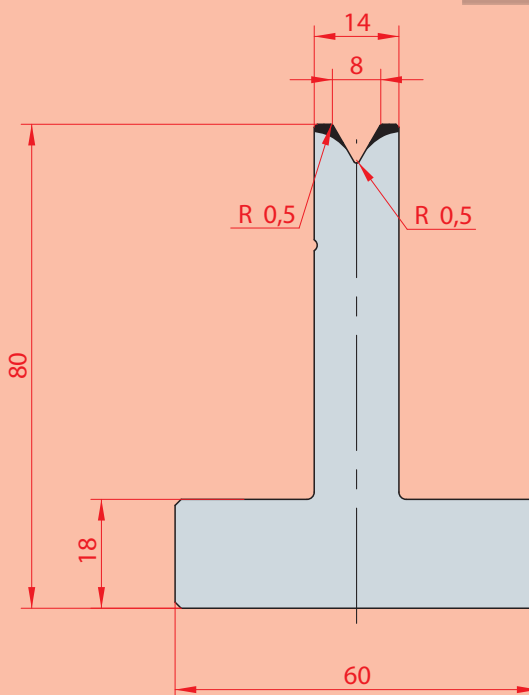
3092
Max T/m=100

MATRICI T H80 - 60° / T DIES H80 - 60°

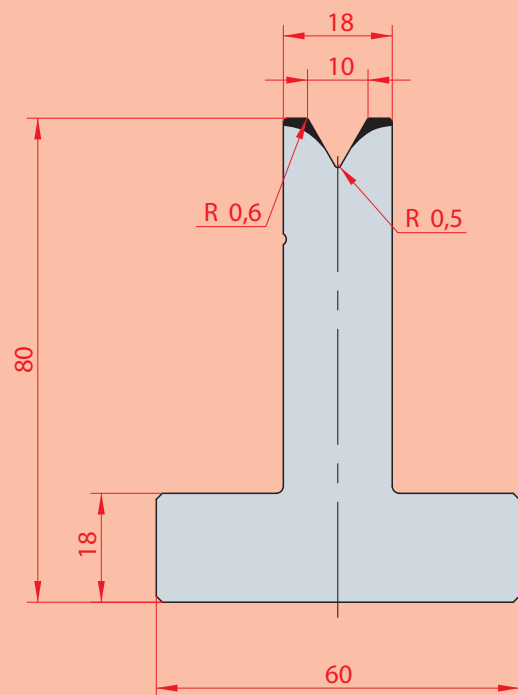
- C45 bonificato /quenched
- 42CrMo4
- C45



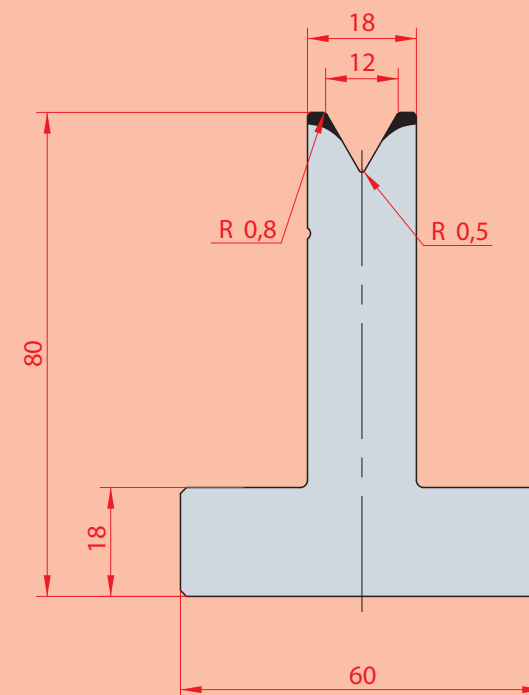
3019
Max T/m=60



3020
Max T/m=60



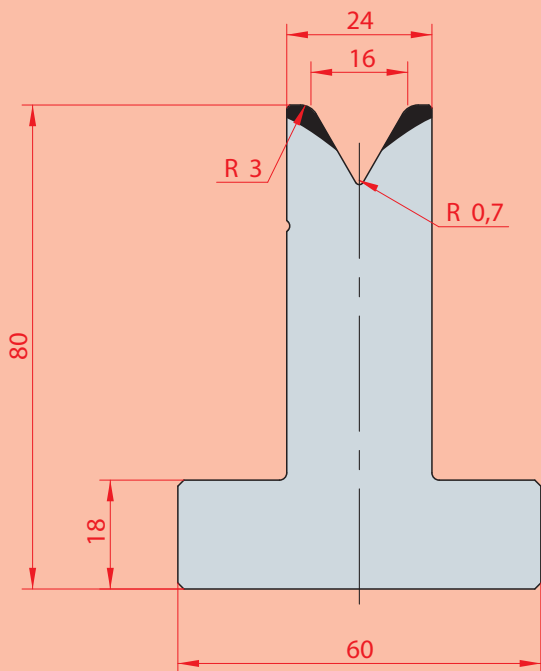
3021
Max T/m=60



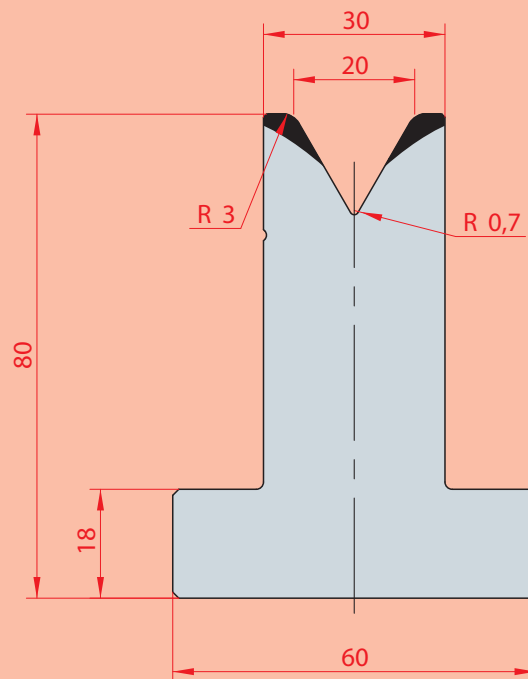
3022
Max T/m=75

MATRICI T H80 - 60° / T DIES H80 - 60°

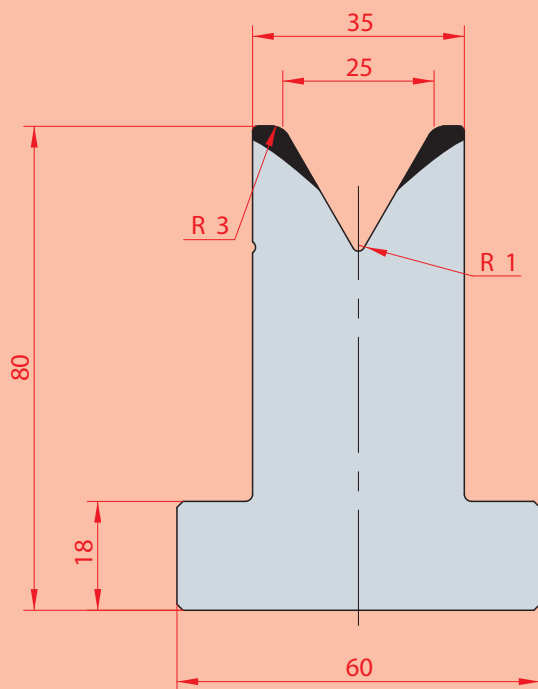
- C45 bonificato /quenched
- 42CrMo4
- C45



3023
Max T/m=70



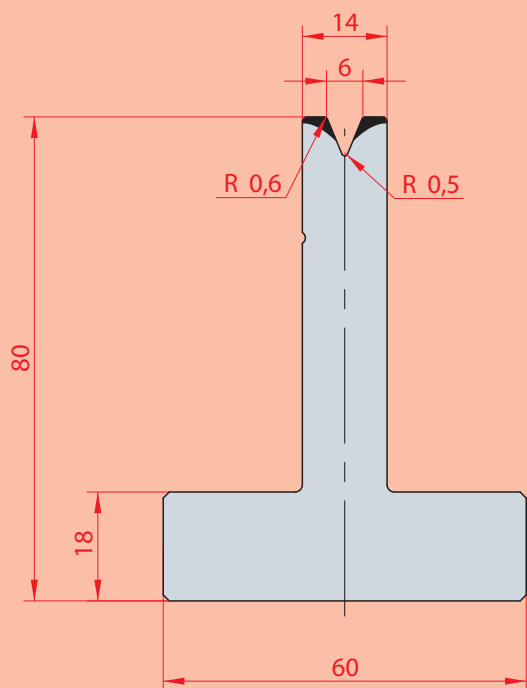
3024
Max T/m=65



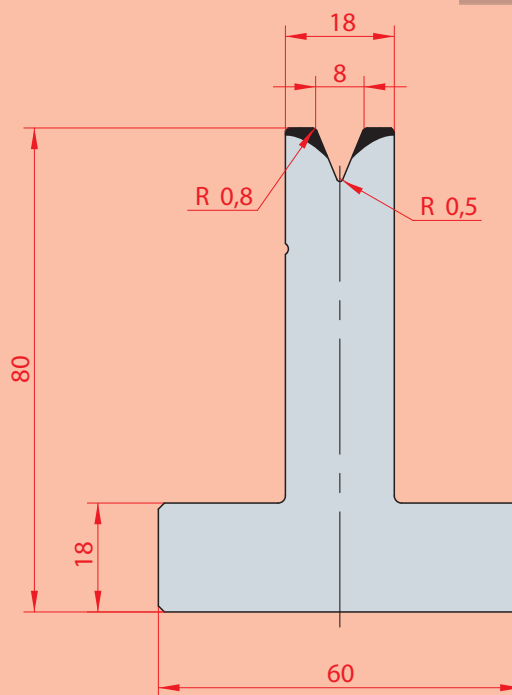
3025
Max T/m=60

MATRICI T H80 - 45° / T DIES H80 - 45°

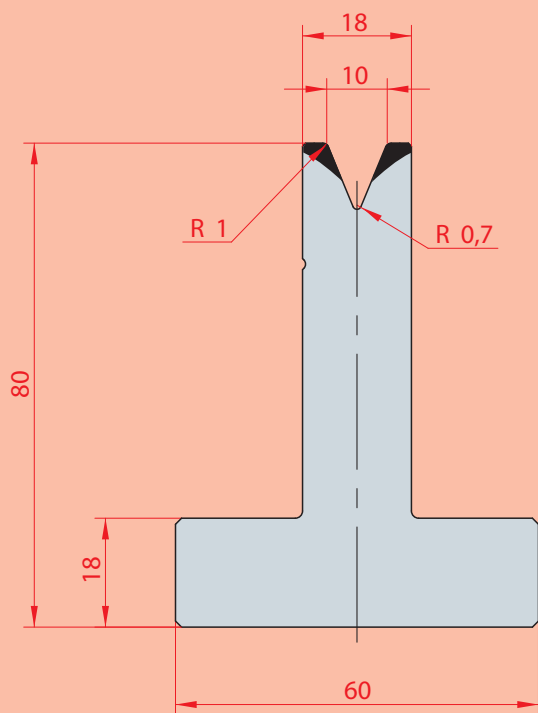
- C45 bonificato /quenched
- 42CrMo4
- C45



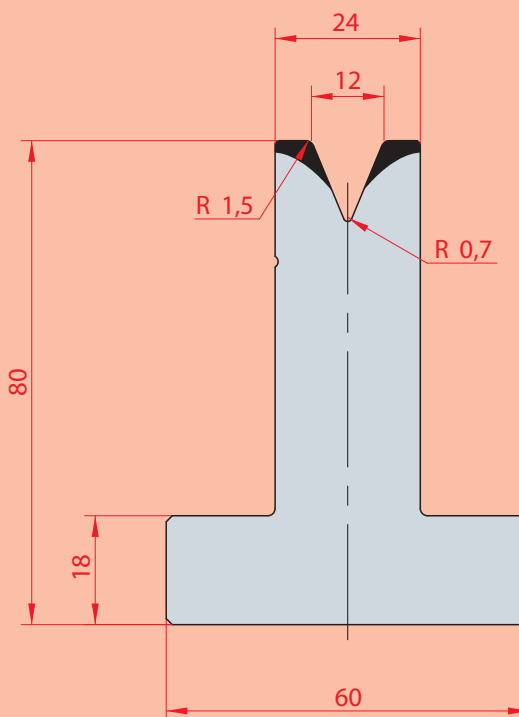
3026
Max T/m=50



3027
Max T/m=50



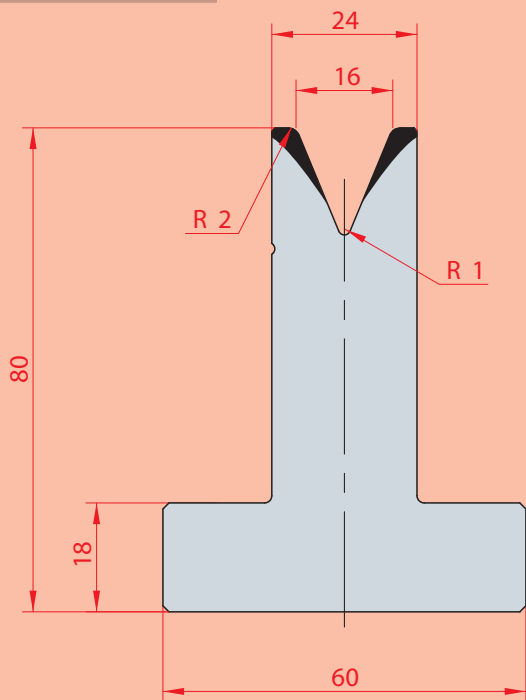
3028
Max T/m=50



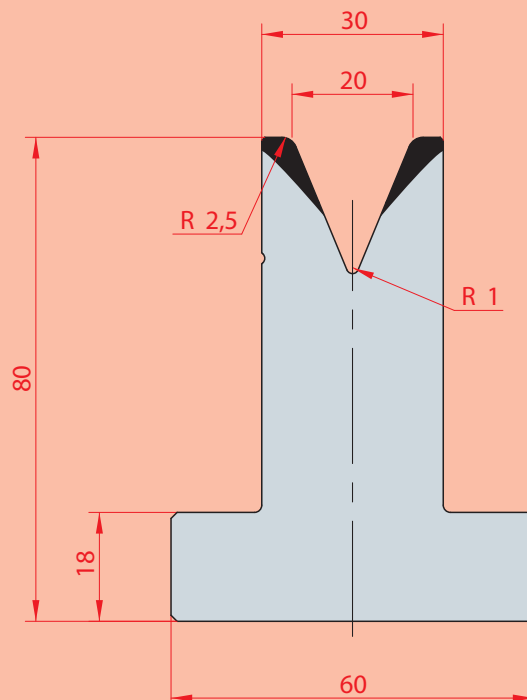
3029
Max T/m=50

MATRICI T H80 - 45° / T DIES H80 - 45°

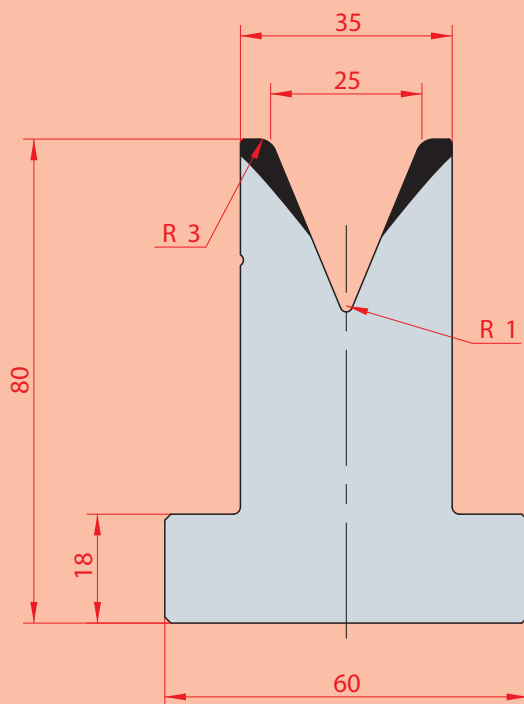
- C45 bonificato /quenched
- 42CrMo4
- C45



3030
Max T/m=50



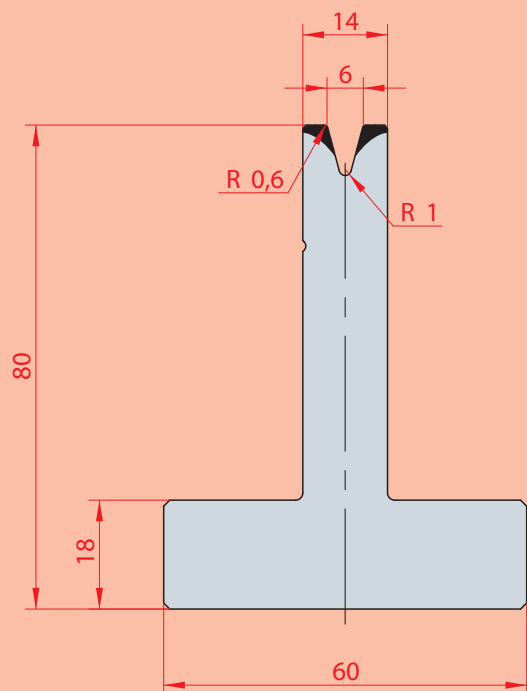
3031
Max T/m=50



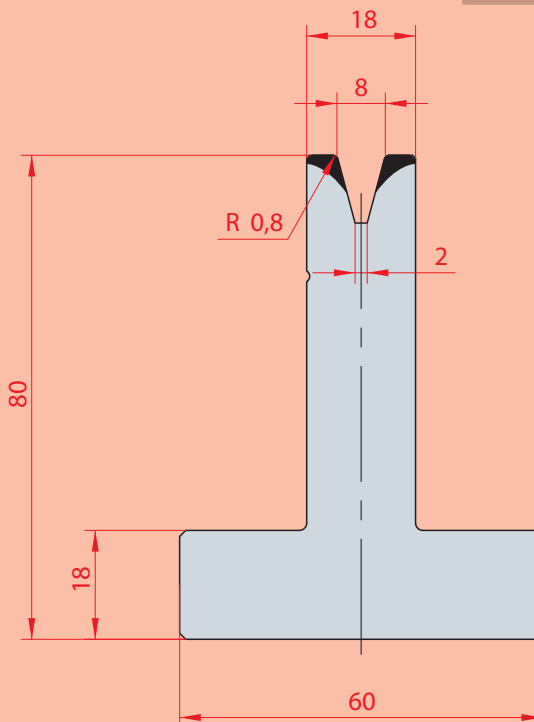
3032
Max T/m=50

MATRICI T H80 - 30° / T DIES H80 - 30°

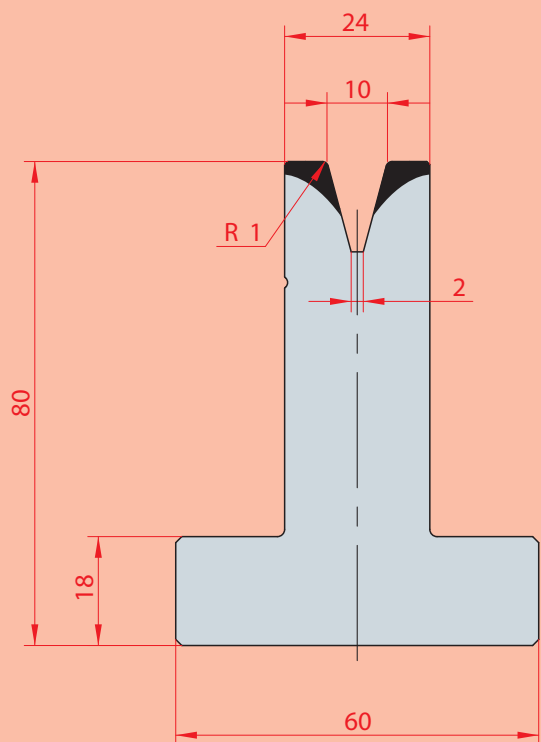
- C45 bonificato /quenched
- 42CrMo4
- C45



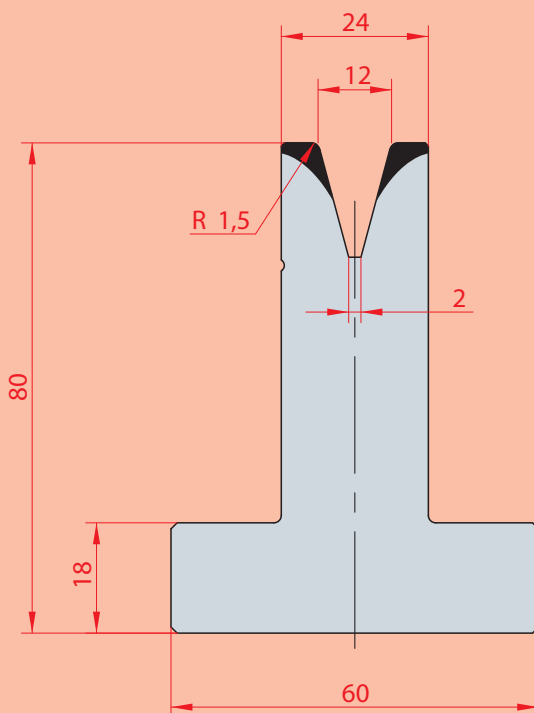
3042
Max T/m=35



3043
Max T/m=40



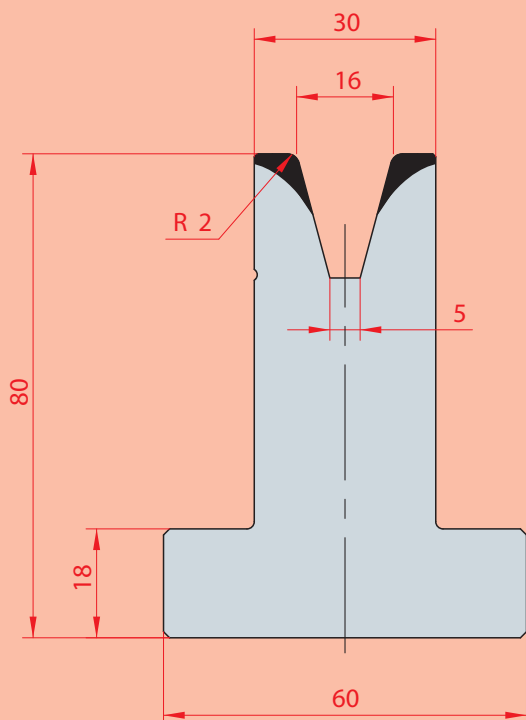
3044
Max T/m=50



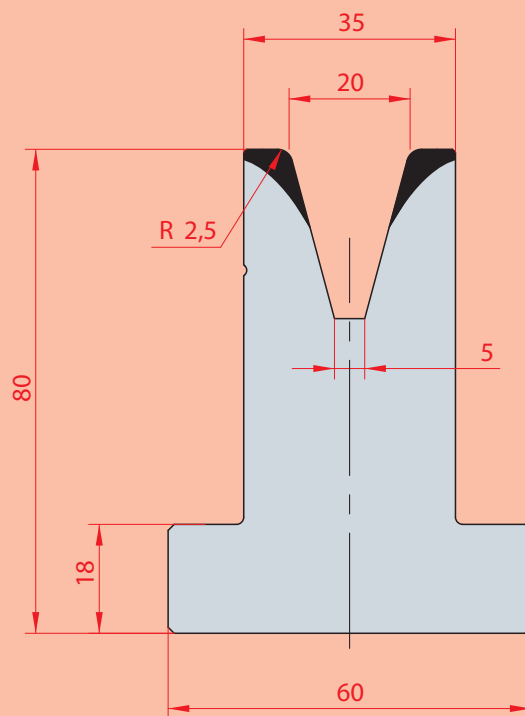
3045
Max T/m=50

MATRICI T H80 - 30° / T DIES H80 - 30°

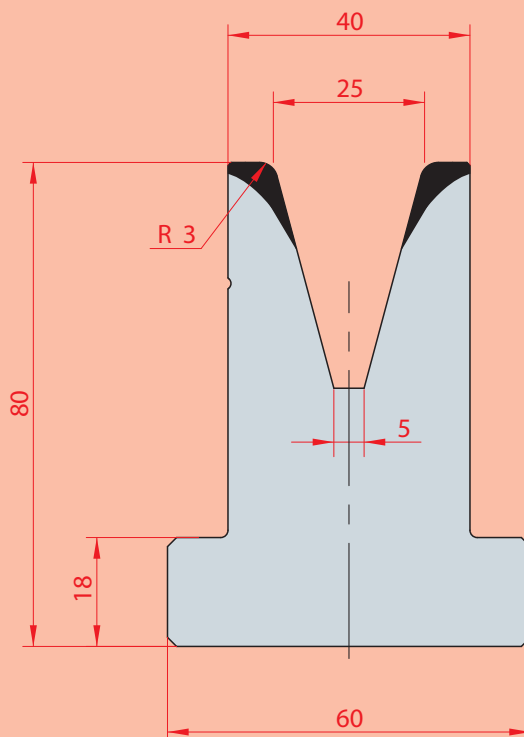
- C45 bonificato /quenched
- 42CrMo4
- C45



3046
Max T/m=50



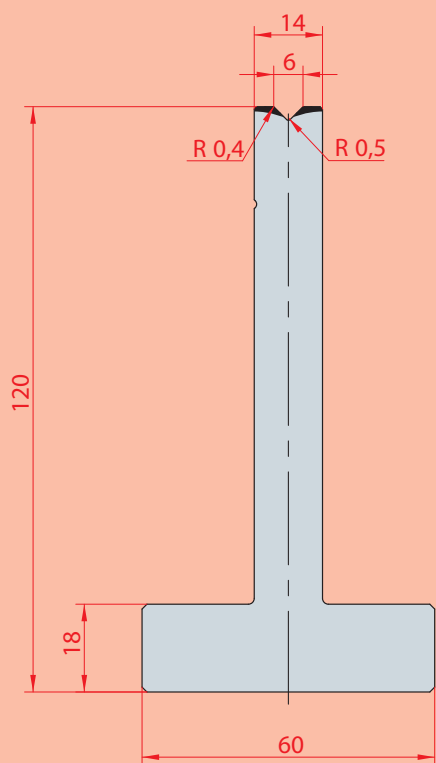
3047
Max T/m=55



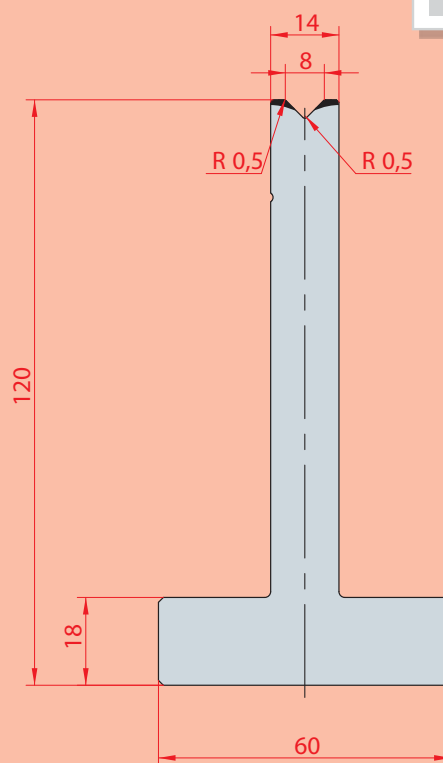
3048
Max T/m=55

MATRICI T H120 - 90° / T DIES H120 - 90°

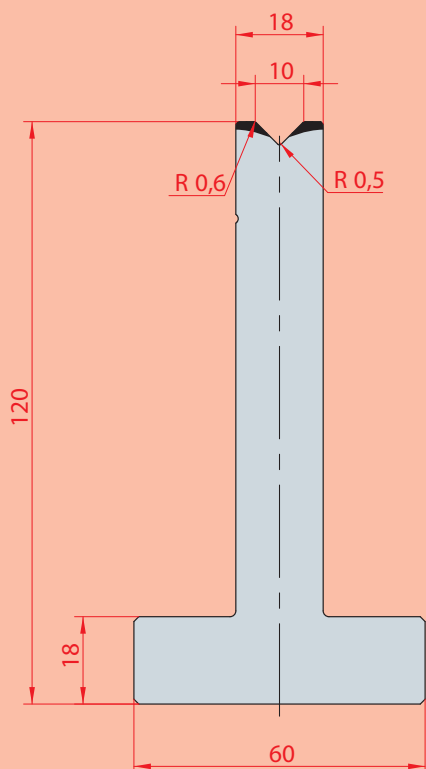
- C45 bonificato /quenched
- 42CrMo4
- C45



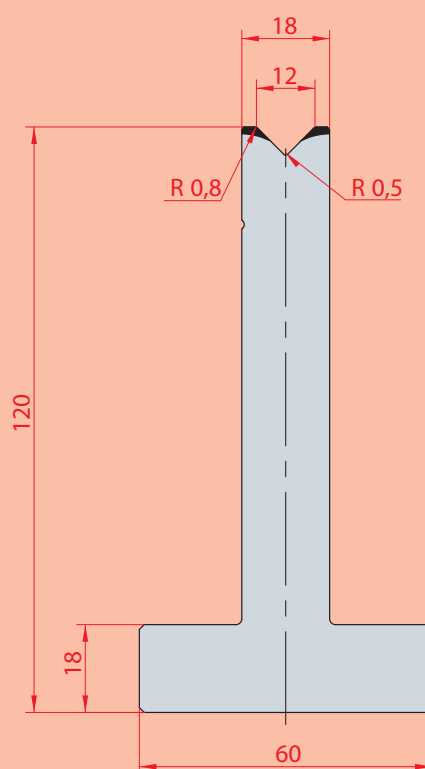
3050
Max T/m=100



3051
Max T/m=100



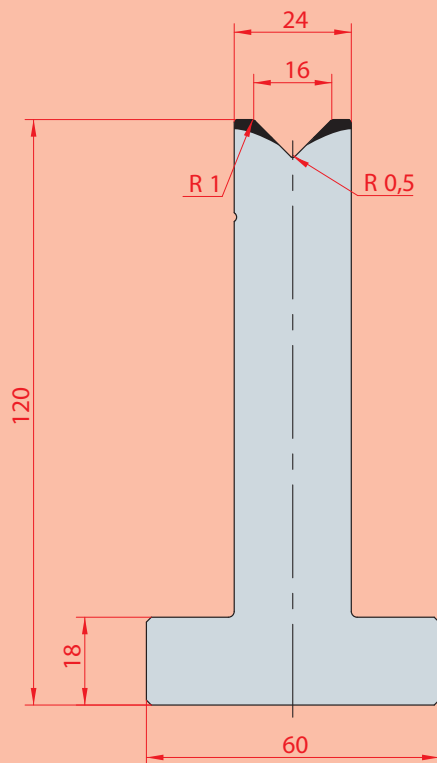
3052
Max T/m=100



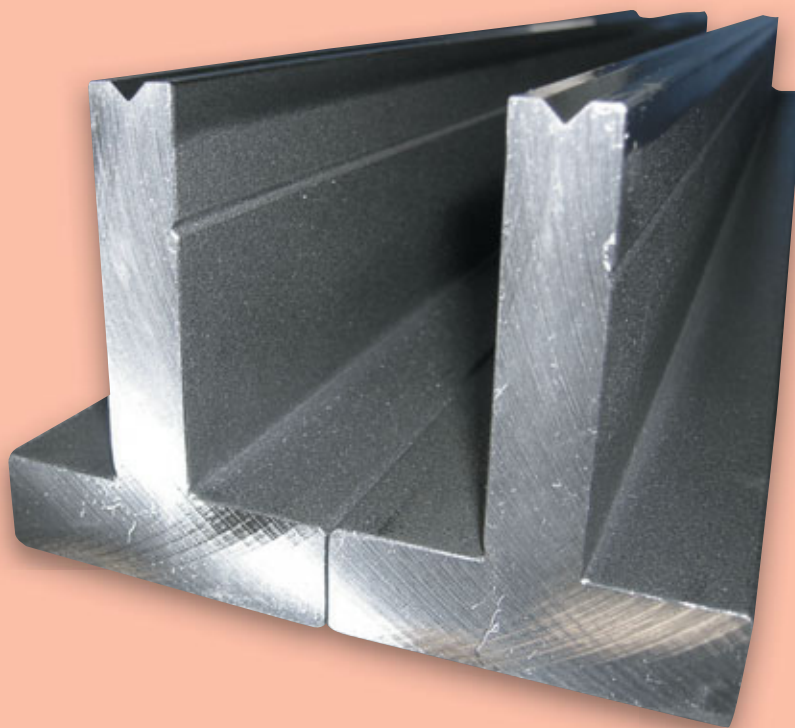
3053
Max T/m=100

MATRICI T H120 - 90° / T DIES H120 - 90°

- C45 bonificato /quenched
- 42CrMo4
- C45

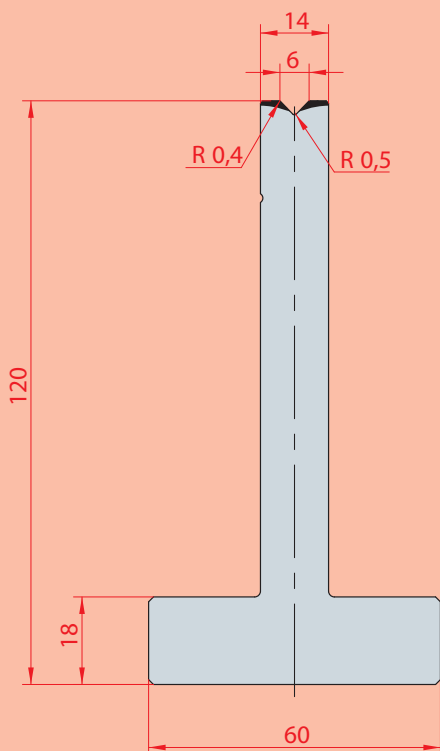


3054
Max T/m=100

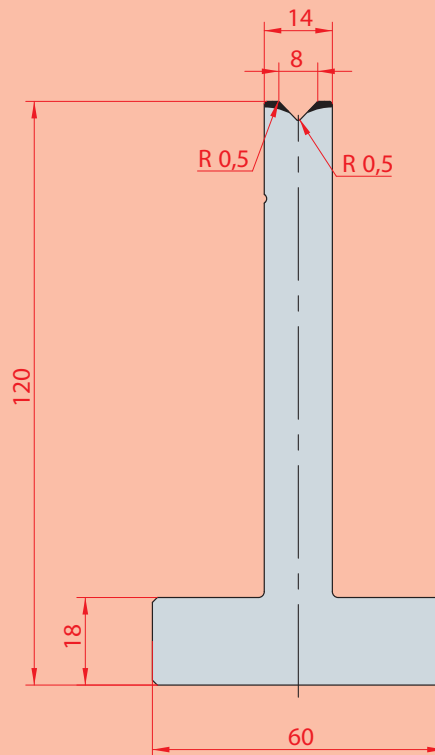


MATRICI T H120 - 88° / T DIES H120 - 88°

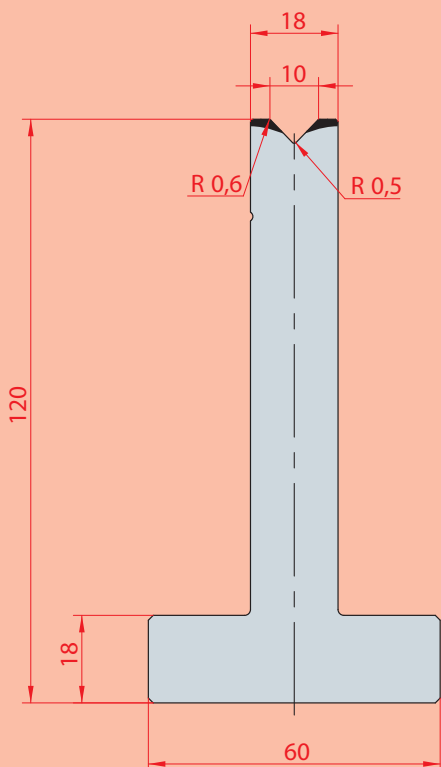
- C45 bonificato /quenched
- 42CrMo4
- C45



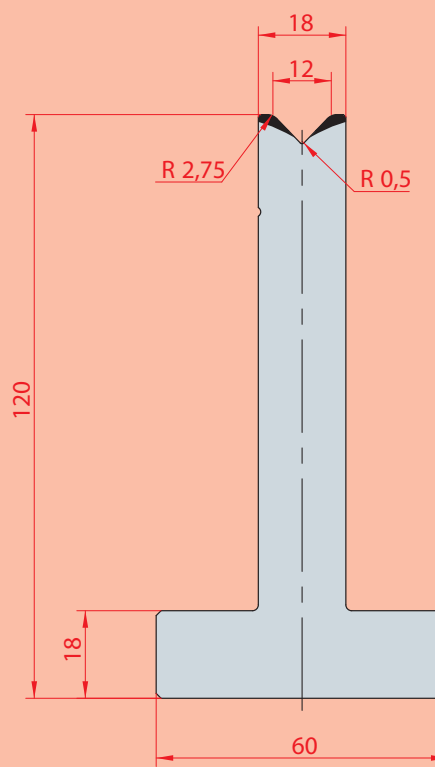
3083
Max T/m=100



3084
Max T/m=100



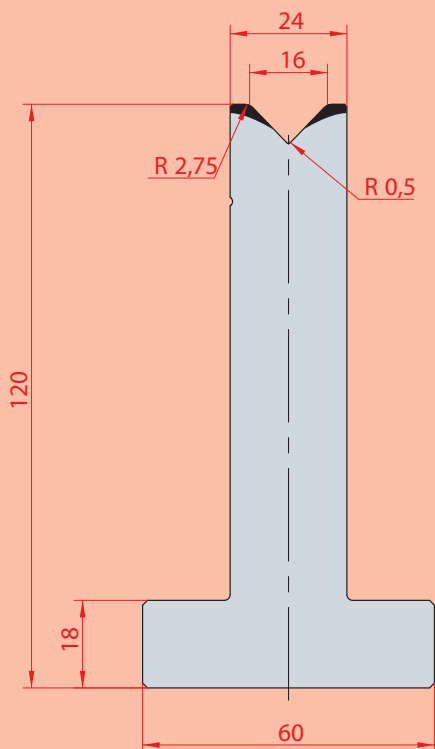
3085
Max T/m=100



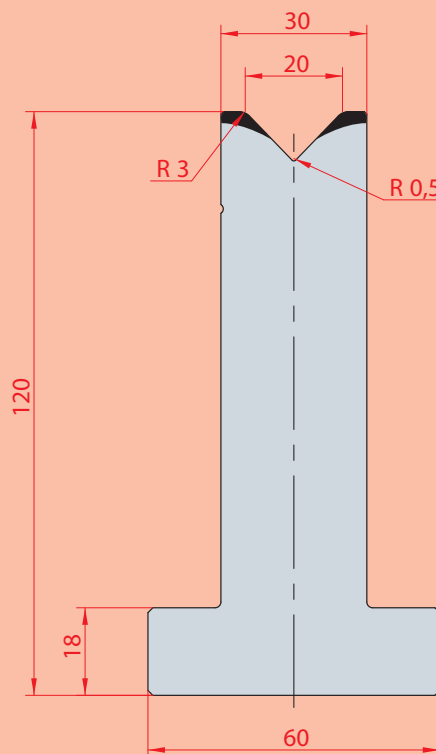
3055
Max T/m=100

MATRICI T H120 - 88° / T DIES H120 - 88°

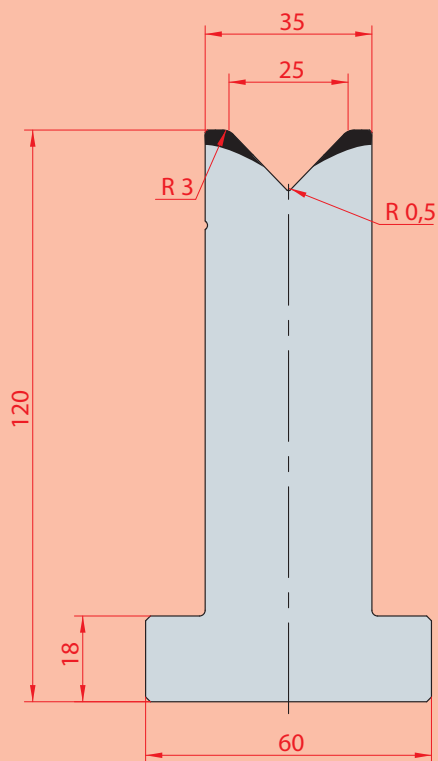
- C45 bonificato /quenched
- 42CrMo4
- C45



3056
Max T/m=100



3057
Max T/m=100

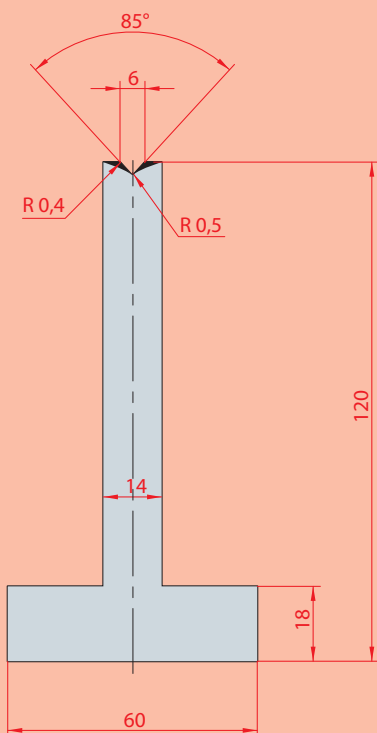


3058
Max T/m=100

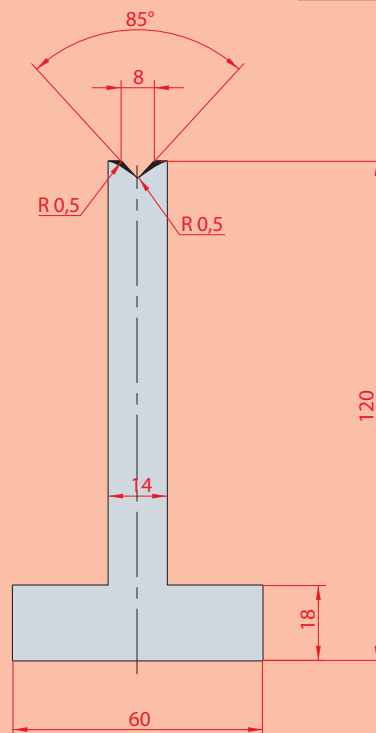
MATRICI T H120 - 85° / T DIES H120 - 85°

NEW

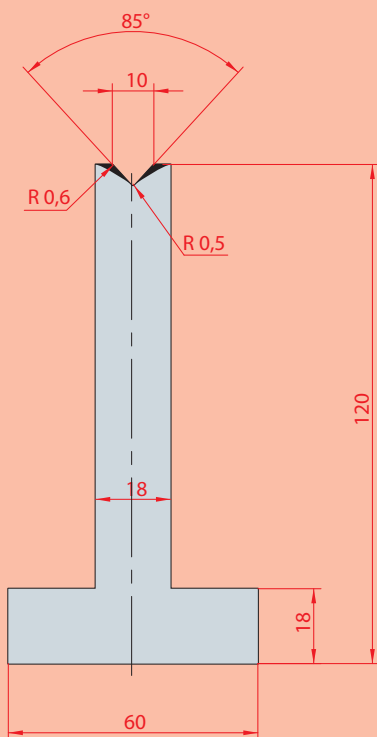
- C45 bonificato /quenched
- 42CrMo4
- C45



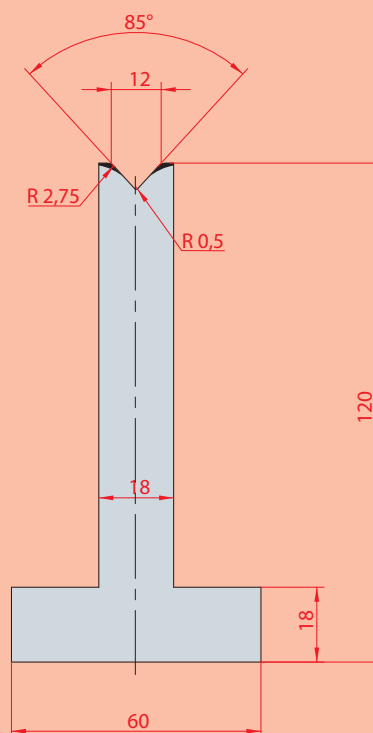
3093
Max T/m=100



3094
Max T/m=100



3095
Max T/m=100

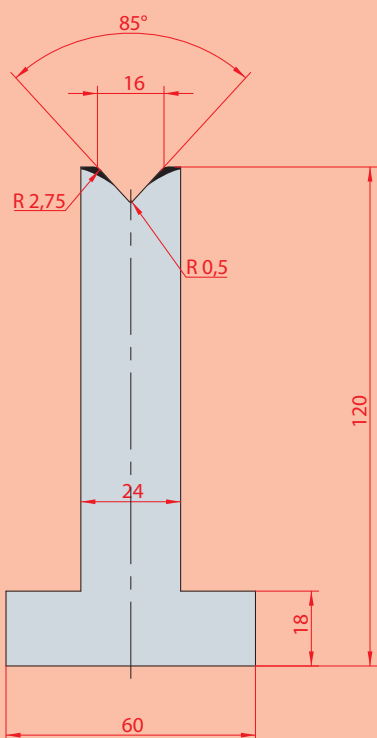


3096
Max T/m=100

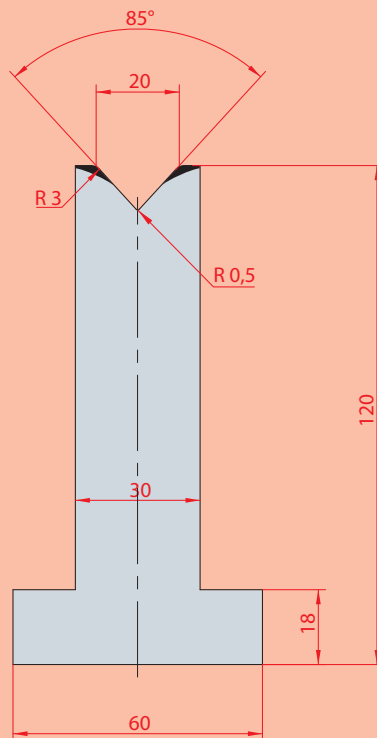
MATRICI T H120 - 85° / T DIES H120 - 85°

NEW

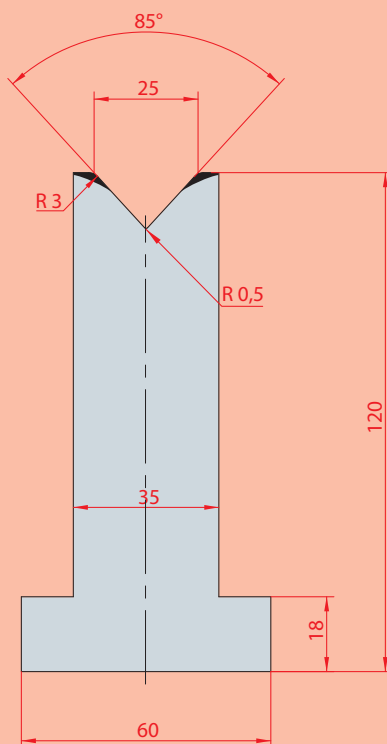
- C45 bonificato /quenched
- 42CrMo4
- C45



3097
Max T/m=100



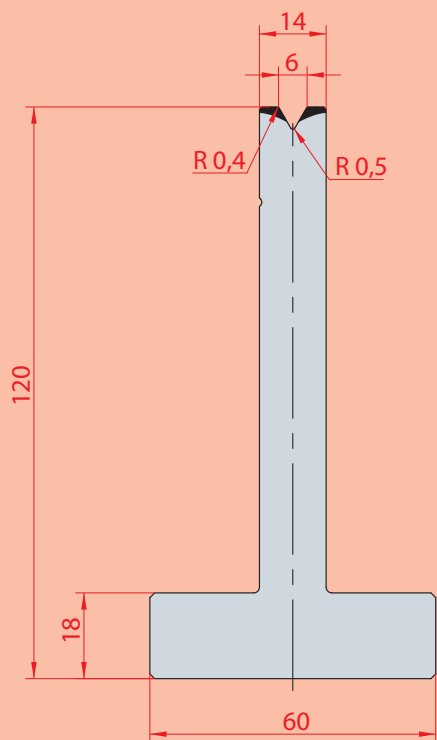
3098
Max T/m=100



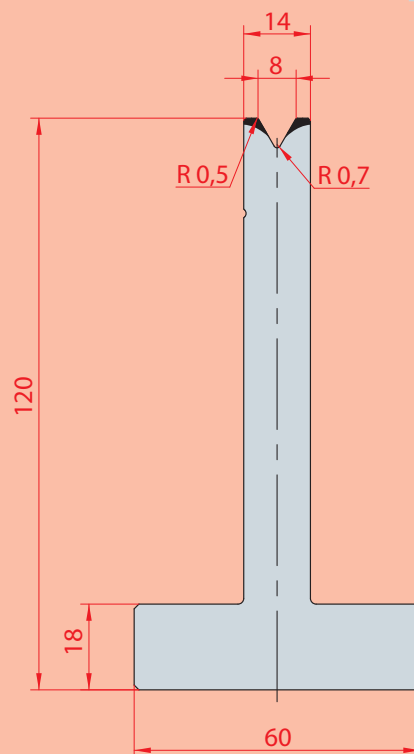
3099
Max T/m=100

MATRICI T H120 - 60° / T DIES H120 - 60°

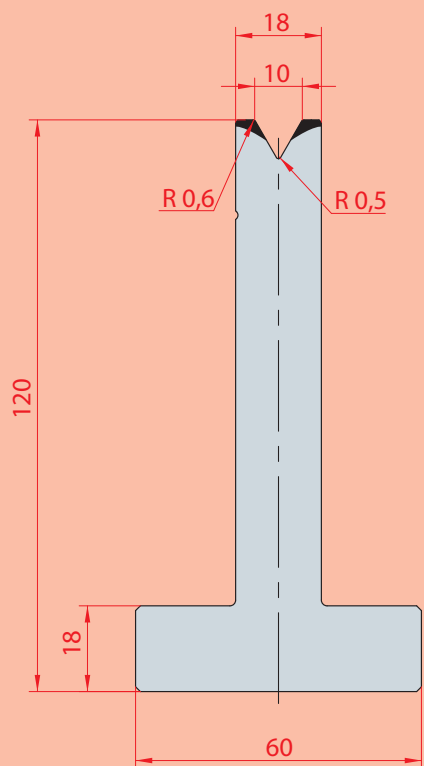
- C45 bonificato /quenched
- 42CrMo4
- C45



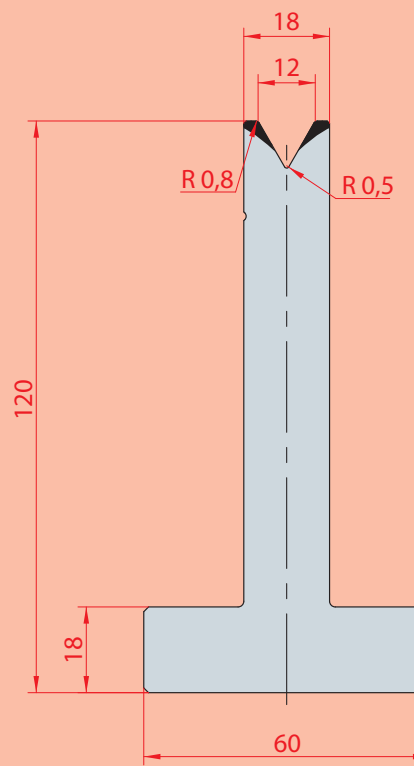
3059
Max T/m=60



3060
Max T/m=60



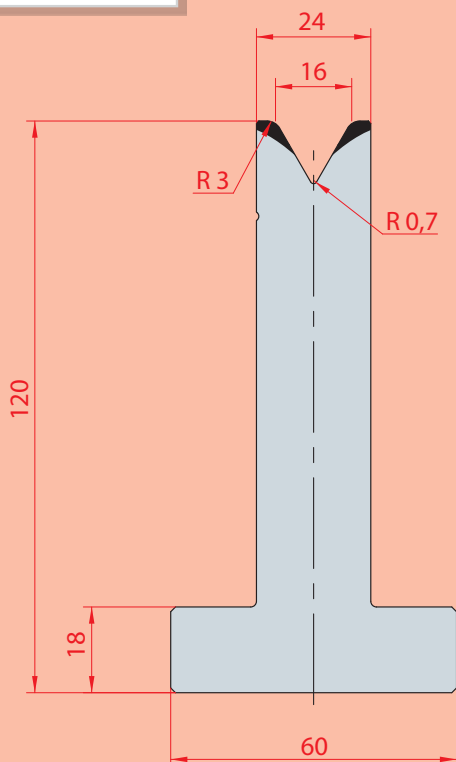
3061
Max T/m=60



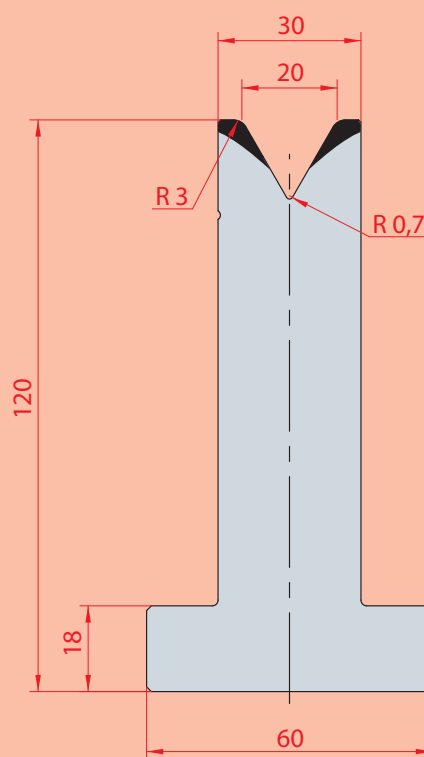
3062
Max T/m=75

MATRICI T H120 - 60° / T DIES H120 - 60°

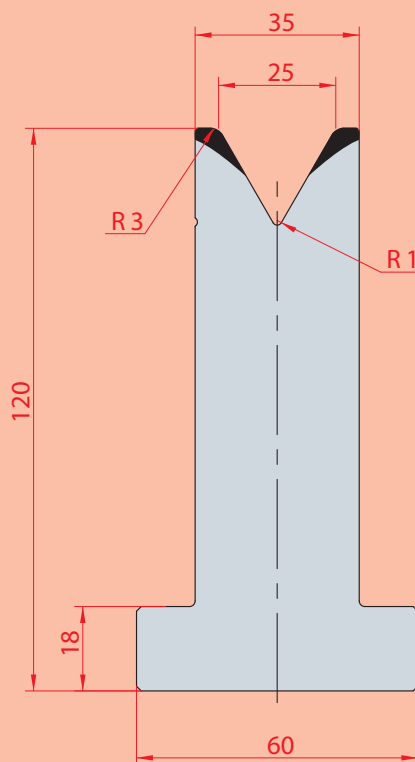
- C45 bonificato /quenched
- 42CrMo4
- C45



3063
Max T/m=70



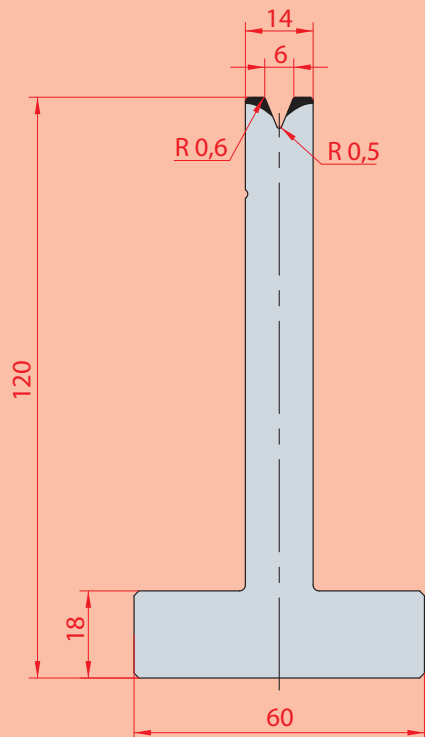
3064
Max T/m=65



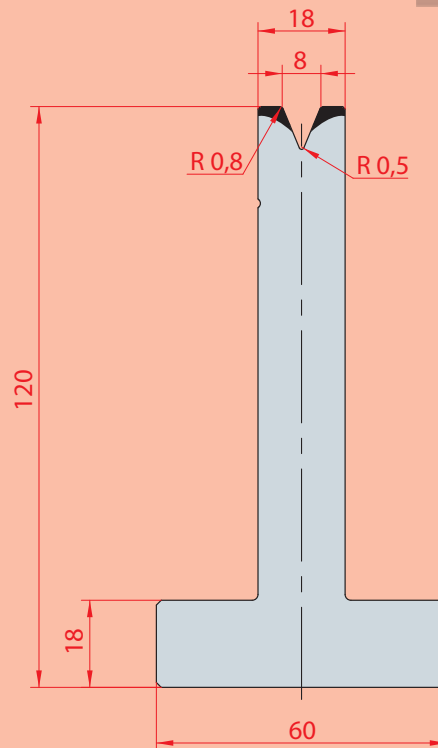
3065
Max T/m=60

MATRICI T H120 - 45° / T DIES H120 - 45°

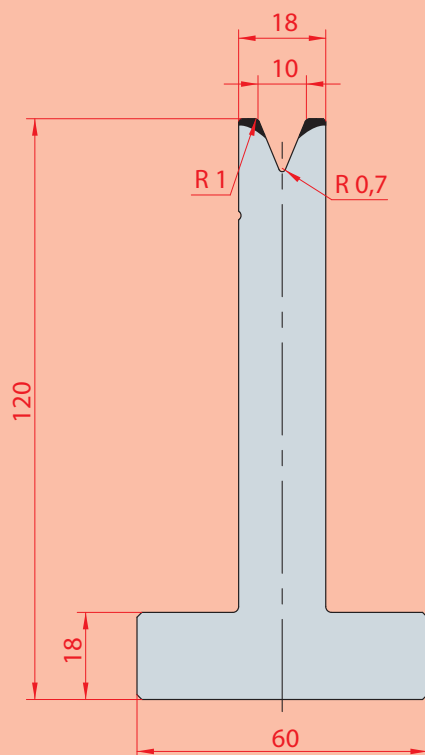
- C45 bonificato /quenched
- 42CrMo4
- C45



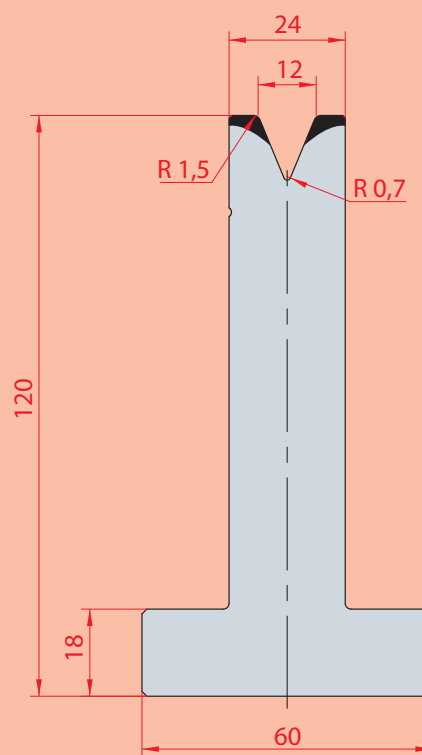
3066
Max T/m=50



3067
Max T/m=50



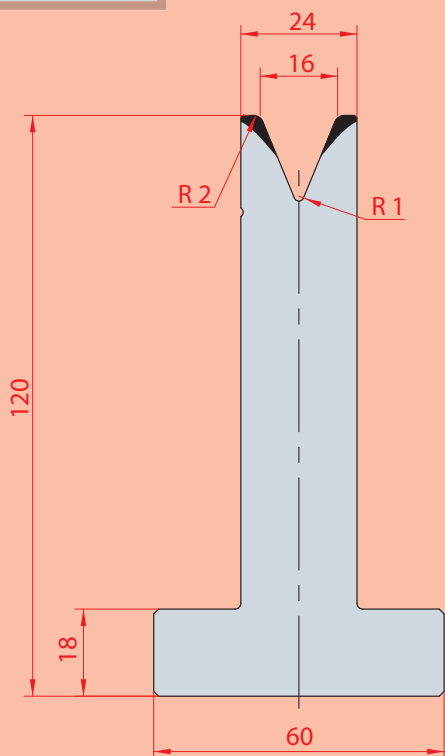
3068
Max T/m=50



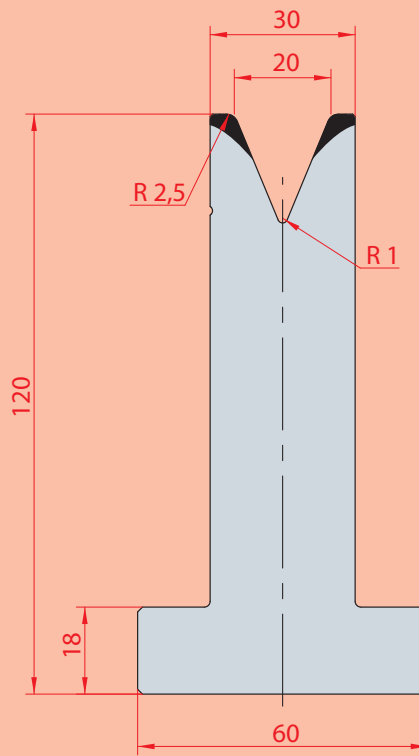
3069
Max T/m=50

MATRICI T H120 - 45° / T DIES H120 - 45°

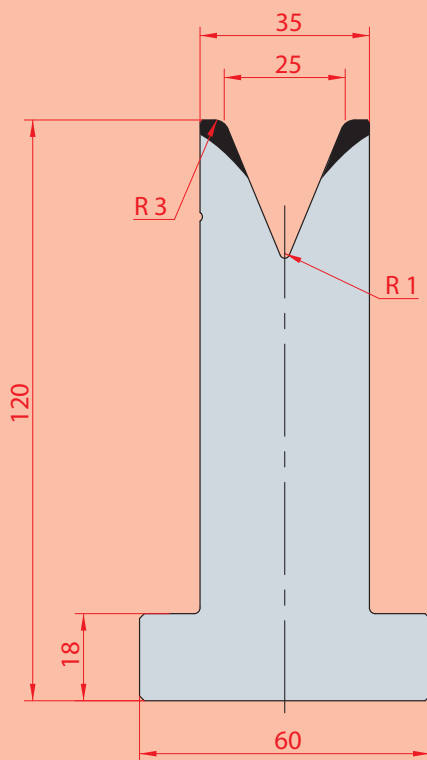
- C45 bonificato /quenched
- 42CrMo4
- C45



3070
Max T/m=50



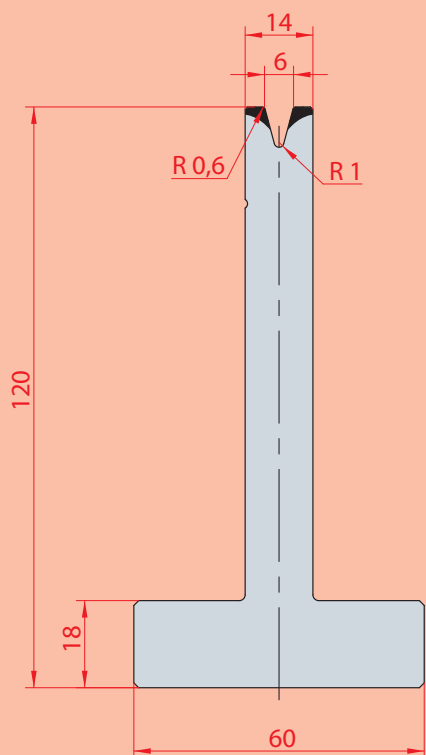
3071
Max T/m=50



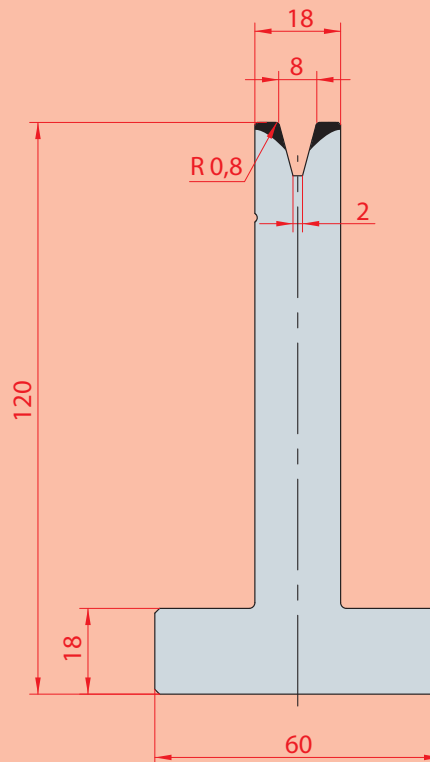
3072
Max T/m=50

MATRICI T H120 - 30° / T DIES H120 - 30°

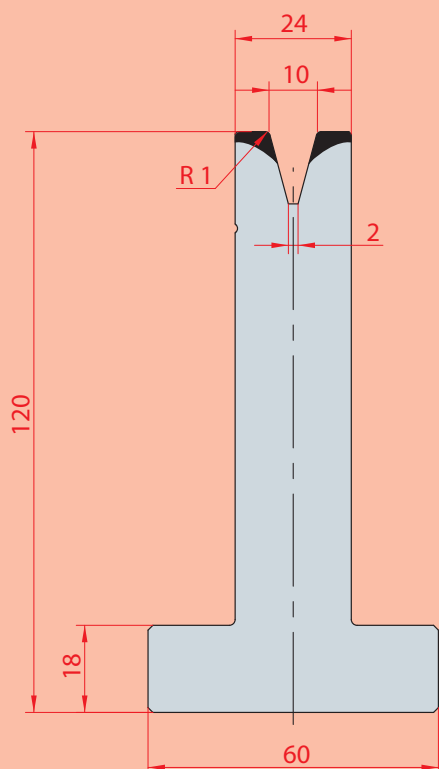
- C45 bonificato /quenched
- 42CrMo4
- C45



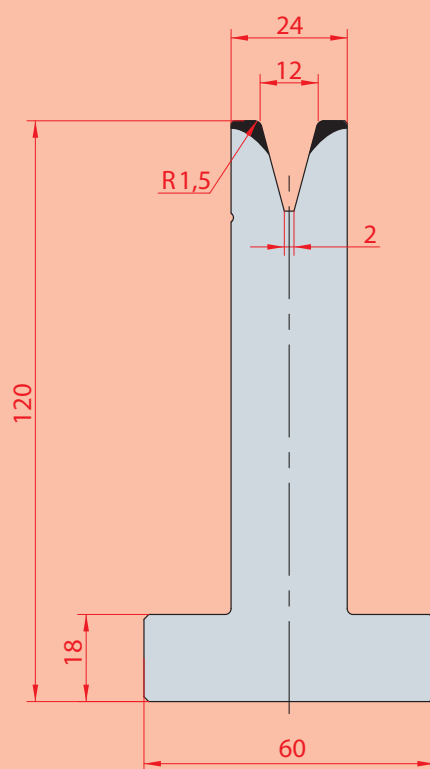
3073
Max T/m=35



3074
Max T/m=40



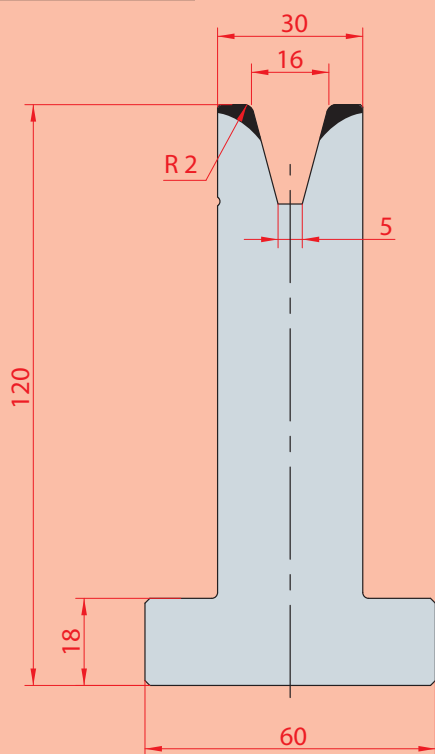
3075
Max T/m=50



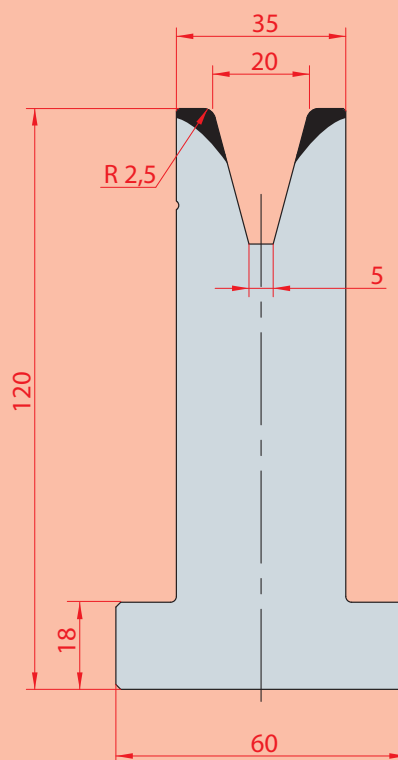
3076
Max T/m=50

MATRICI T H120 - 30° / T DIES H120 - 30°

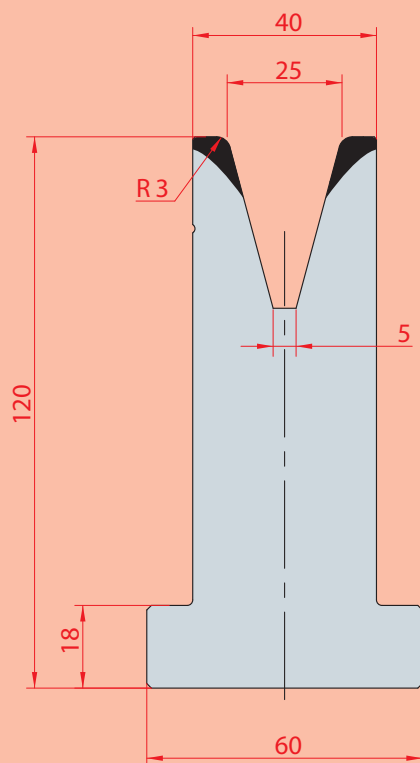
- C45 bonificato /quenched
- 42CrMo4
- C45



3077
Max T/m=50



3078
Max T/m=55



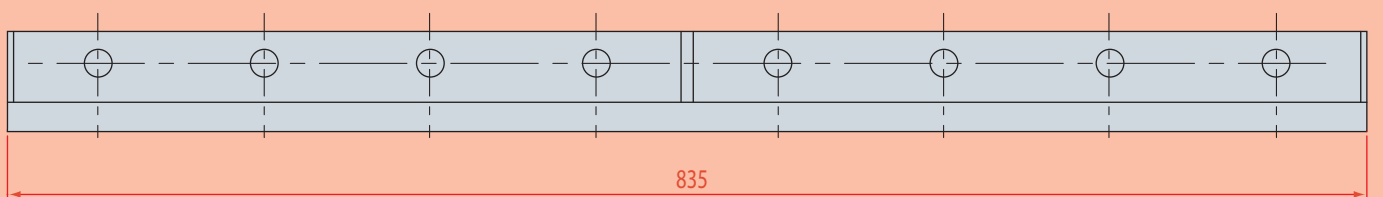
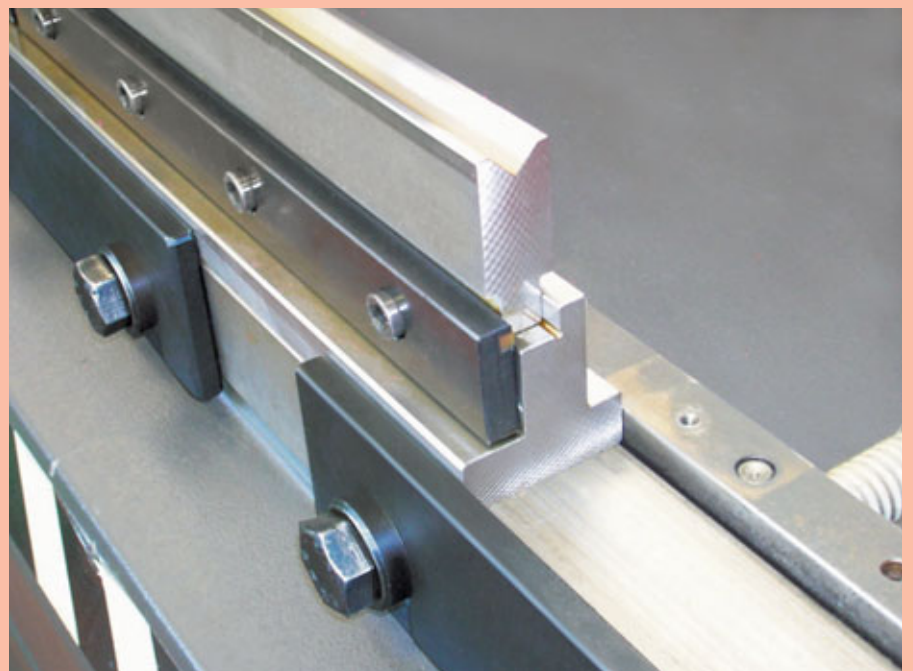
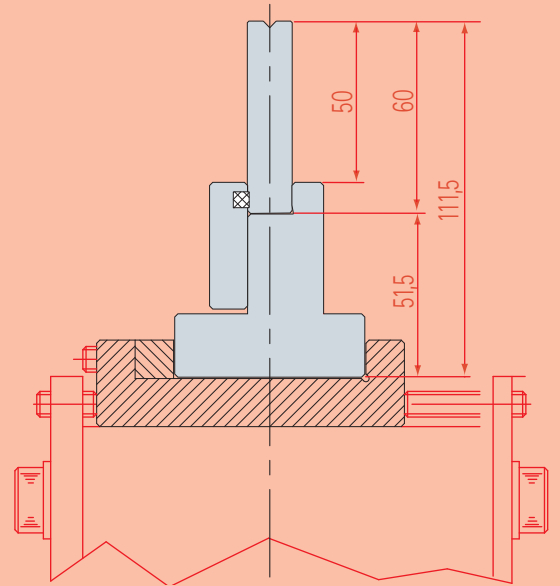
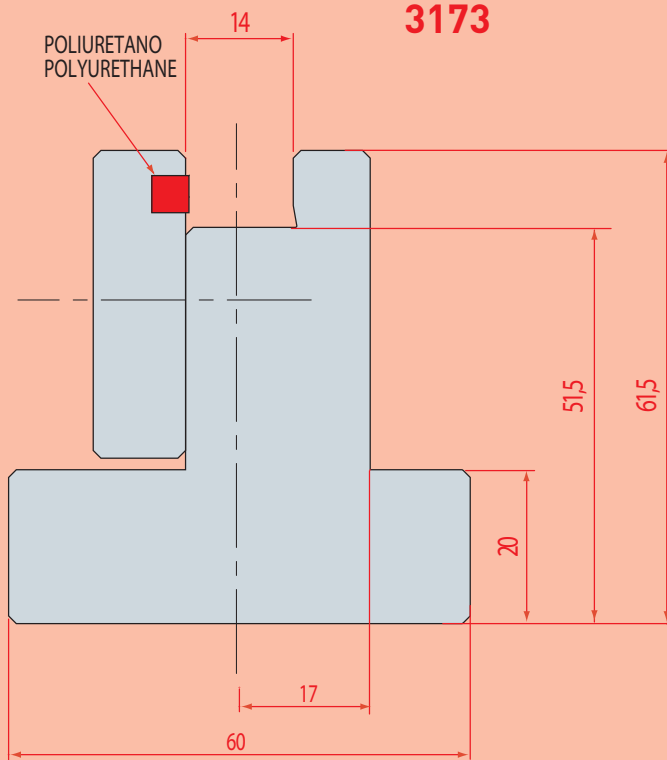
3079
Max T/m=50

SUPPORTO PER INSERTI MATRICI / DIES INSERT HOLDER

- C45 bonificato /quenched
- 42CrMo4
- C45

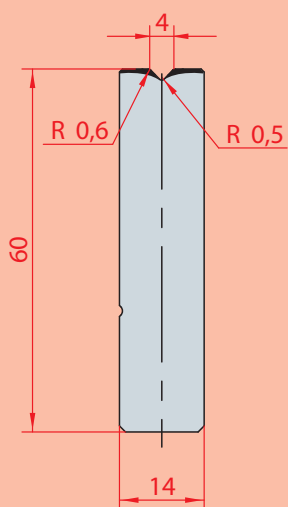
Esempio di montaggio /
Fitting example

3173

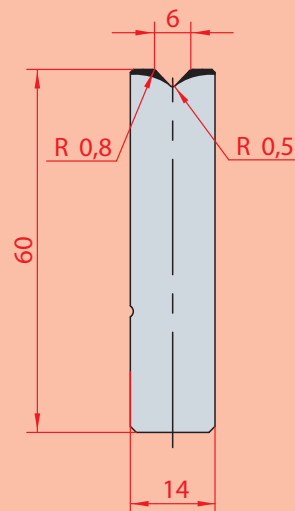


INSERTI MATRICE - 88° / DIES INSERT - 88°

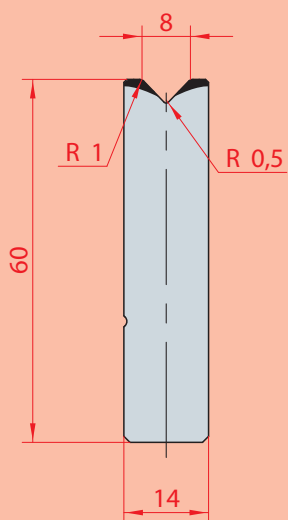
- C45 bonificato /quenched
- 42CrMo4
- C45



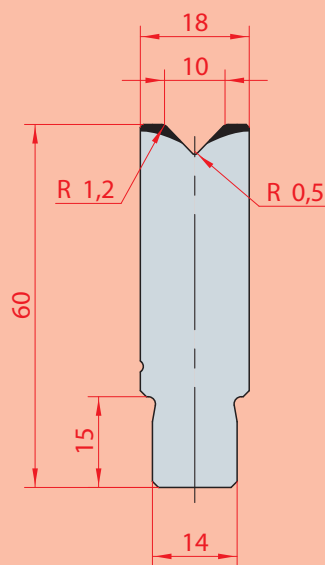
3158
Max T/m=100



3159
Max T/m=100



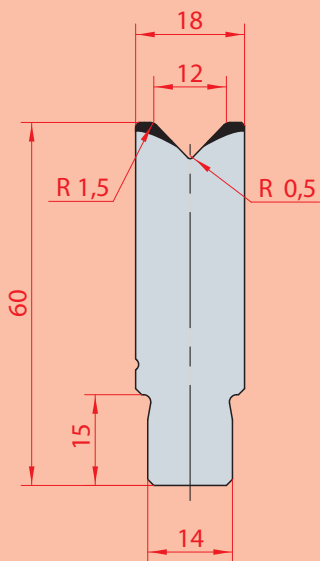
3160
Max T/m=100



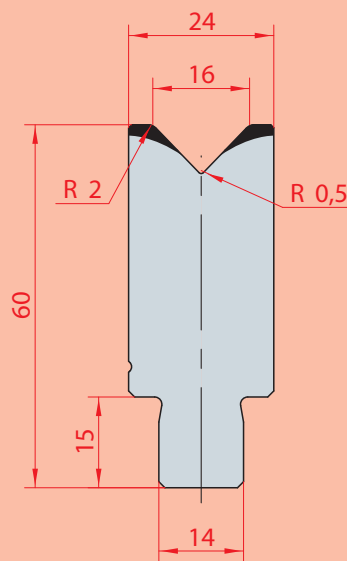
3161
Max T/m=100

INSERTI MATRICE - 88° / DIES INSERT - 88°

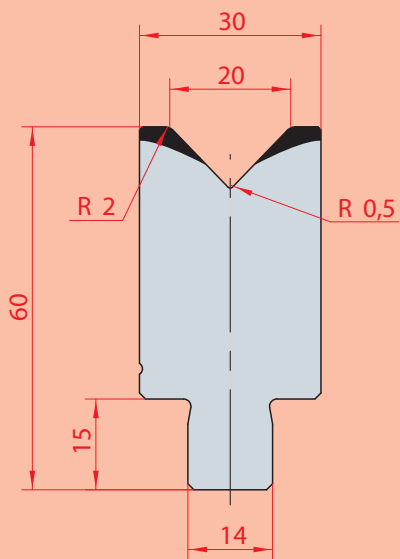
- C45 bonificato /quenched
- 42CrMo4
- C45



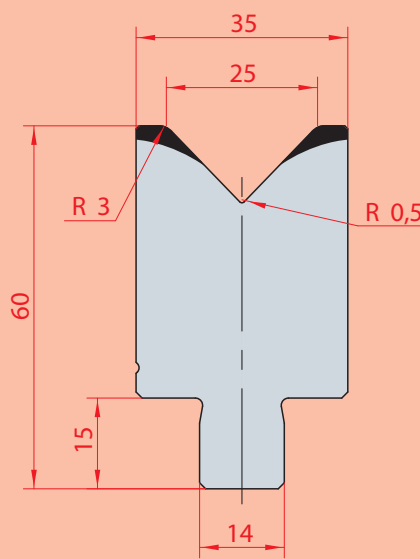
3162
Max T/m=100



3163
Max T/m=100



3164
Max T/m=100

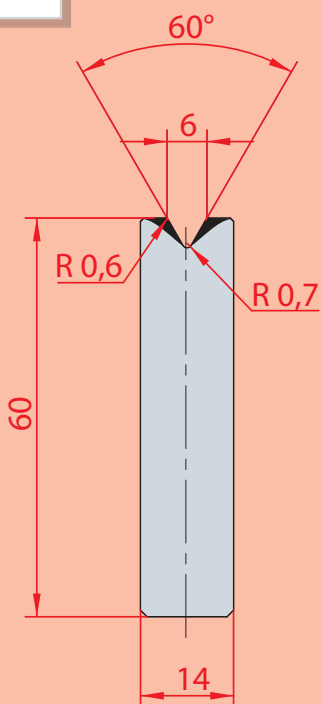


3165
Max T/m=100

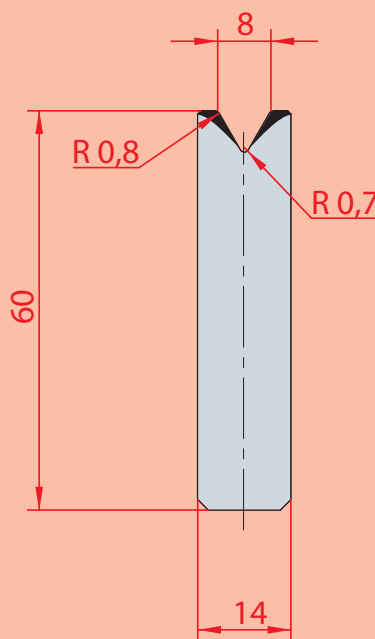
INSERTI MATRICE - 60° / DIES INSERT 60°

NEW

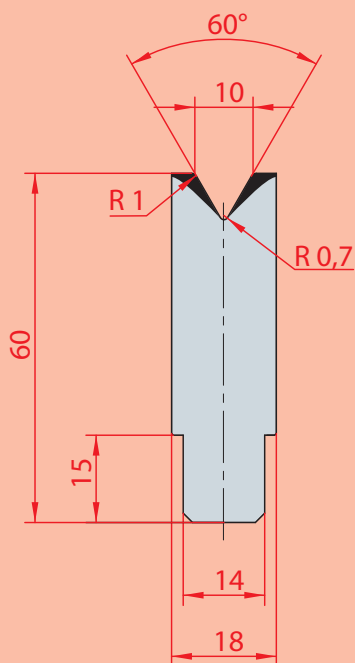
- C45 bonificato /quenched
- 42CrMo4
- C45



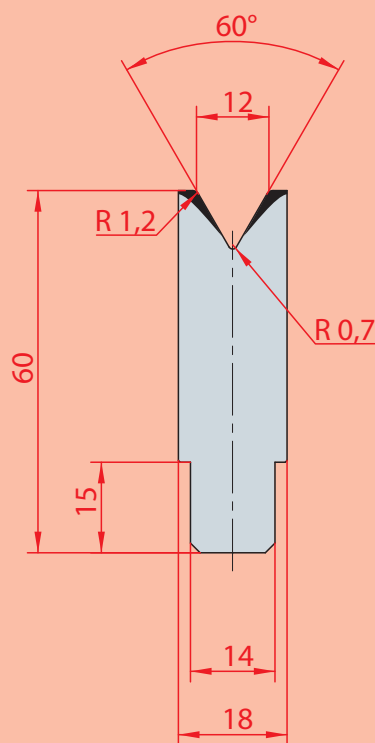
3193
Max T/m=100



3194
Max T/m=100



3195
Max T/m=100

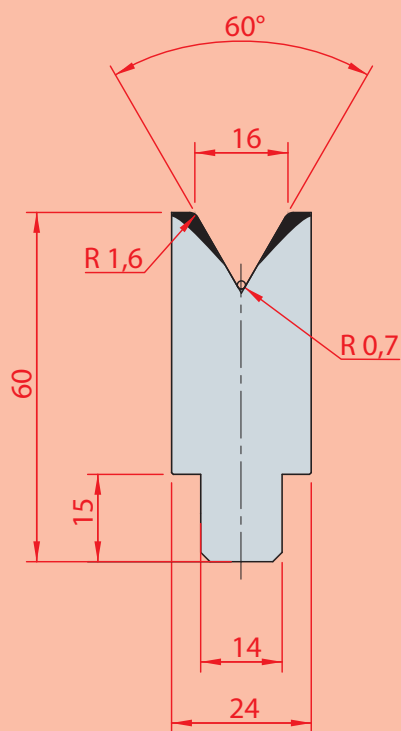


3196
Max T/m=100

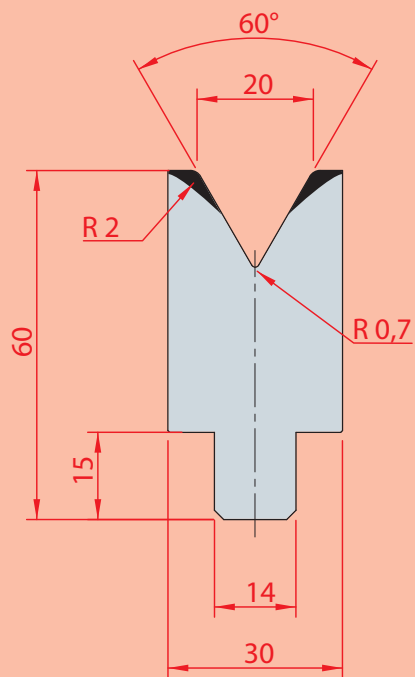
INSERTI MATRICE - 60° / DIES INSERT 60°

NEW

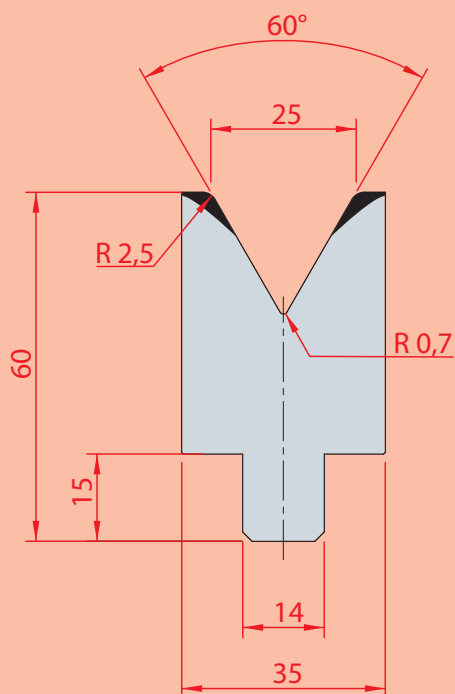
- C45 bonificato /quenched
- 42CrMo4
- C45



3197
Max T/m=100



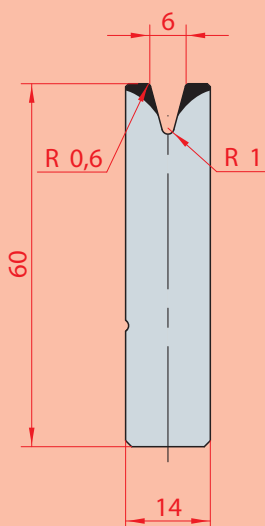
3198
Max T/m=100



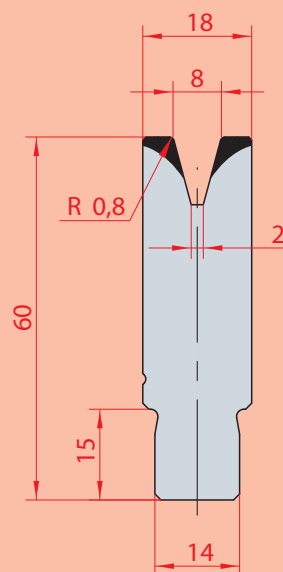
3199
Max T/m=100

INSERTI MATRICE - 30° / DIES INSERT - 30°

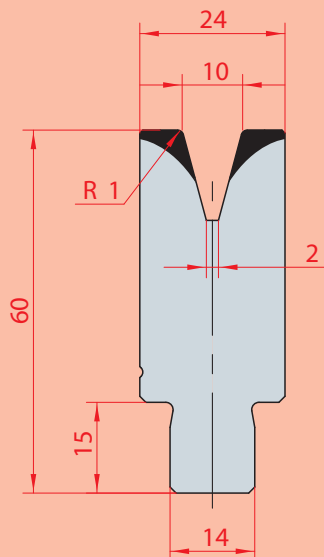
- C45 bonificato /quenched
- 42CrMo4
- C45



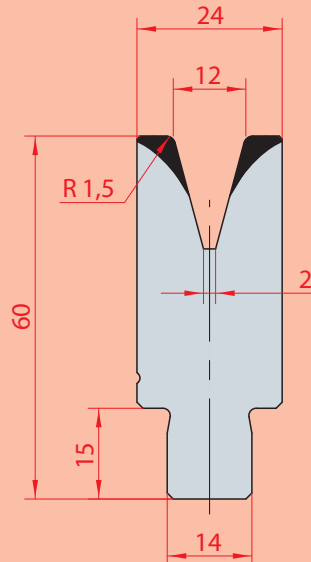
3166
Max T/m=35



3167
Max T/m=40



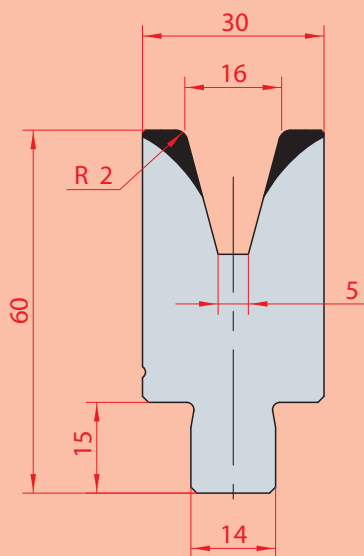
3168
Max T/m=50



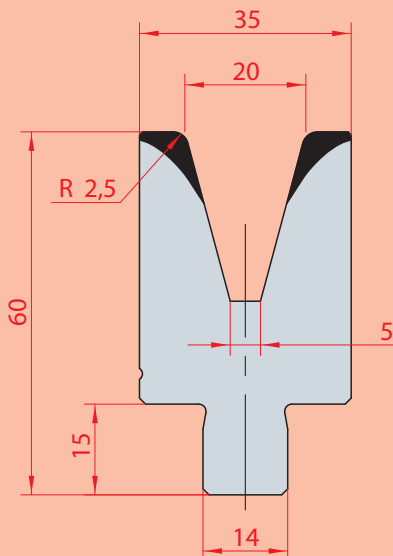
3169
Max T/m=50

INSERTI MATRICE - 30° / DIES INSERT - 30°

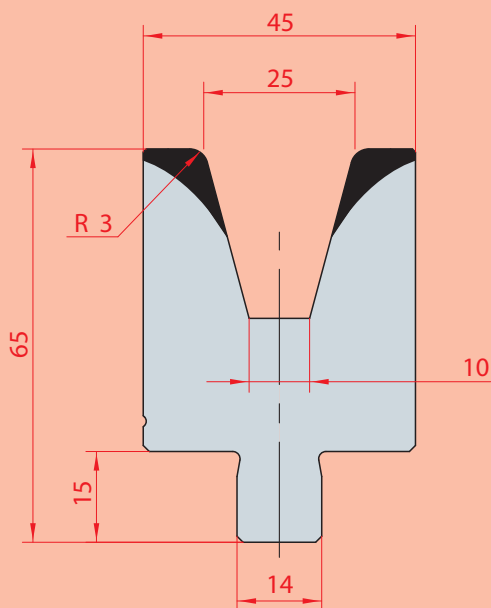
- C45 bonificato /quenched
- 42CrMo4
- C45



3170
Max T/m=50



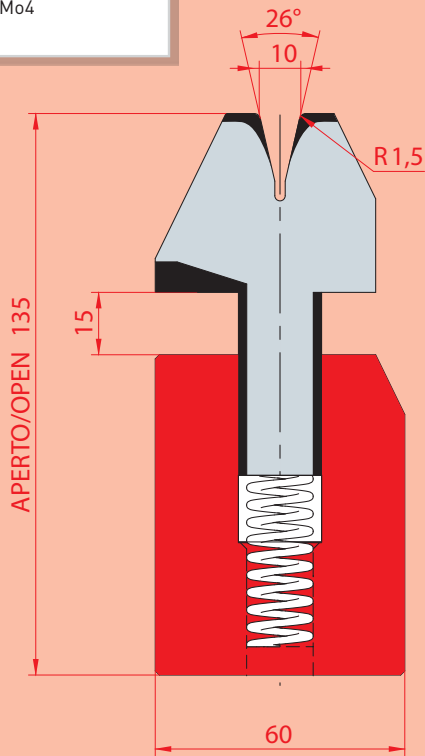
3171
Max T/m=55



3172
Max T/m=55

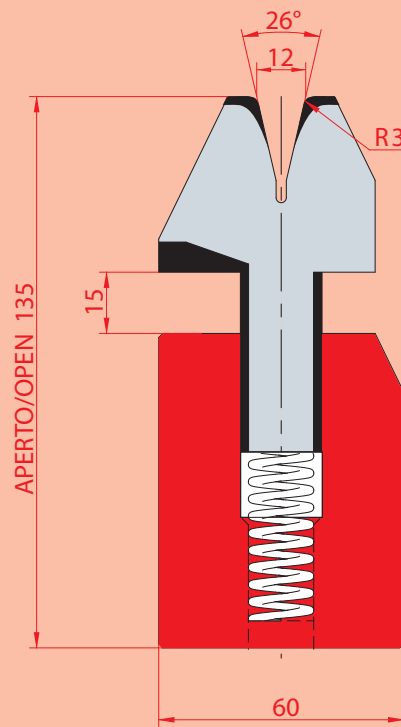
PIEGASCHIACCIA / FLATTENING-HEMMINGS TOOLS

- C45 bonificato /quenched
- 42CrMo4
- C45



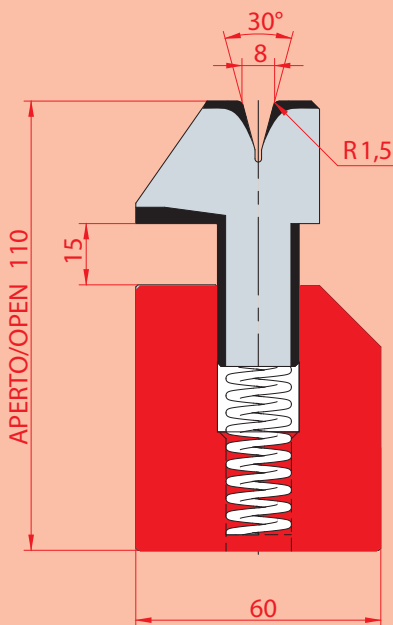
3038

Spessore: da 15/10 a 25/10 **Max T/m=100**
Sheet thickness= from 1,5 to 2,5 mm



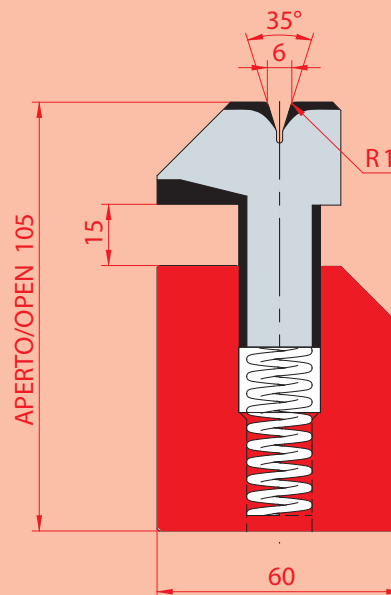
3040

Spessore: da 15/10 a 30/10 **Max T/m=100**
Sheet thickness= from 1,5 to 3,0 mm



3041

Spessore: max 15/10 **Max T/m=80**
Sheet thickness= max 1,5 mm

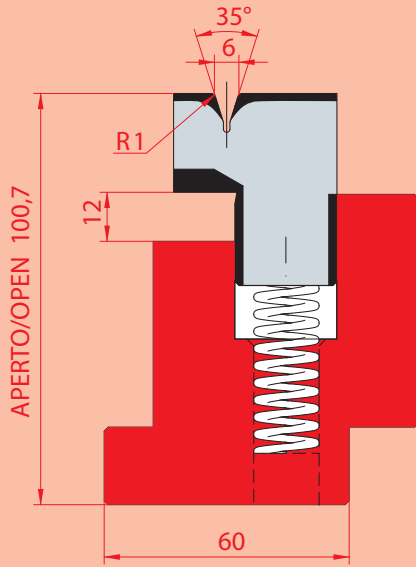


3039

Spessore: max 10/10 **Max T/m=80**
Sheet thickness= max 1,0 mm

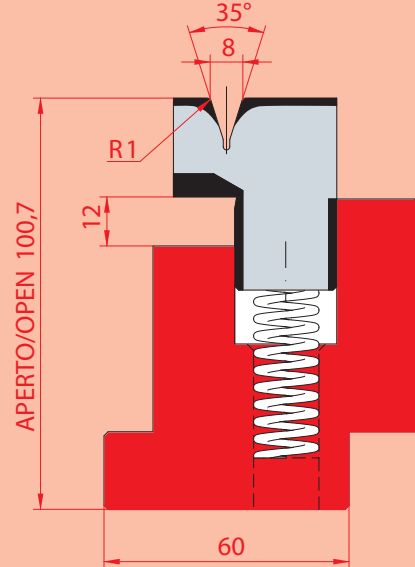
PIEGASCHIACCIA / FLATTENING-HEMMINGS TOOLS

■ C45 bonificato /quenched
 ■ 42CrMo4
 ■ C45



3037/6

Spessore: max 10/10 Max T/m=60
Sheet thickness= max 1,0 mm



3037/8

Spessore: max 12/10 Max T/m=60
Sheet thickness= max 1,2 mm

Tabella di piegatura / Bending chart

Ferro normale R.45 Kg/mm^q / Mild Steel R.45 Kg/mm^q

S mm	A mm	Ton /M	2xS	Ton /M
0,6	3	9	1,2	23
0,8	3	12	1,6	32
1	3,5	15	2	40
1,25	3,5	17	2,5	50
1,5	4,6	22	3	63
2	5,5	30	4	80
2,5	6,5	55	5	90
3	8	70	6	100

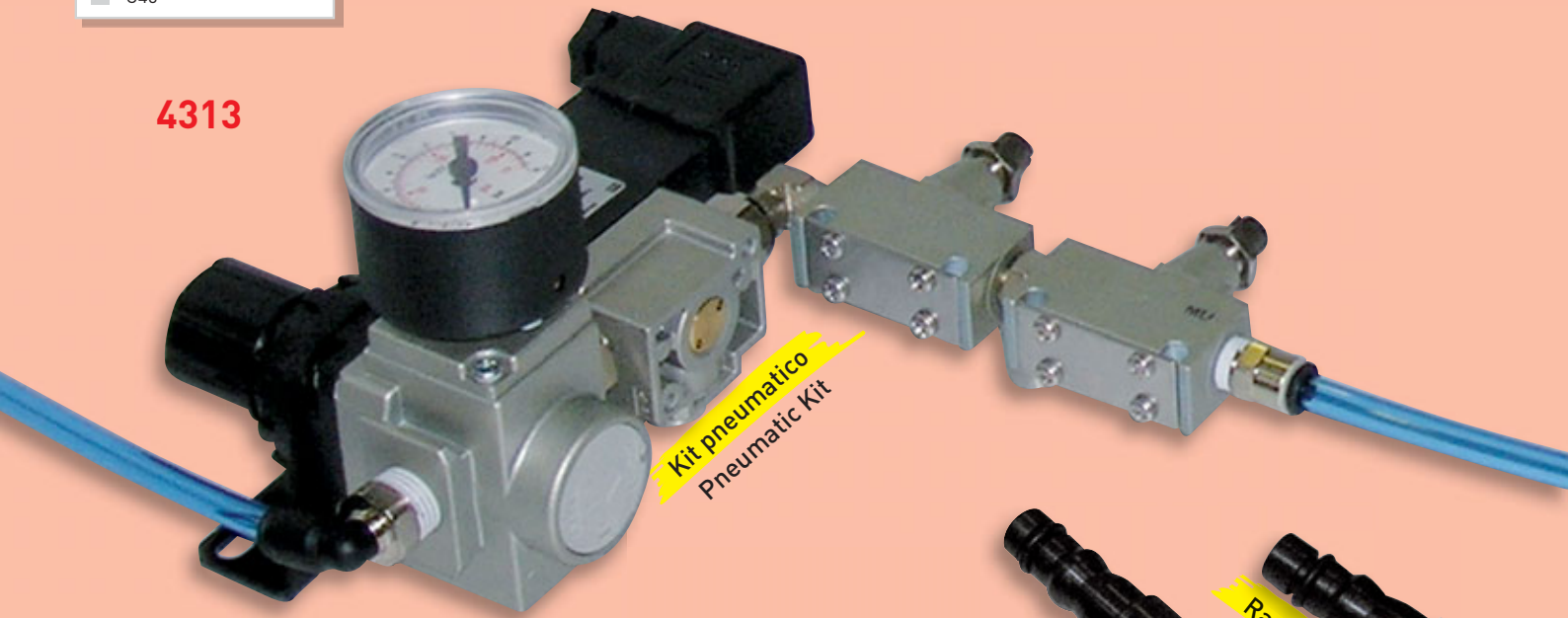
Inox R.70 Kg/mm^q / Stainless Steel R.70 Kg/mm^q

S mm	A mm	Ton /M	2xS	Ton /M
0,6	3	15	1,2	35
0,8	3	20	1,6	50
1	3,5	25	2	60
1,25	3,5	26	2,5	80
1,5	4,6	38	3	95
2	5,5	50	4	130

PIEGASCHIACCIA PNEUMATICI / FLATTENING HEMMING TOOLS PNEUMATIC

- C45 bonificato /quenched
- 42CrMo4
- C45

4313



Kit pneumatico
Pneumatic Kit



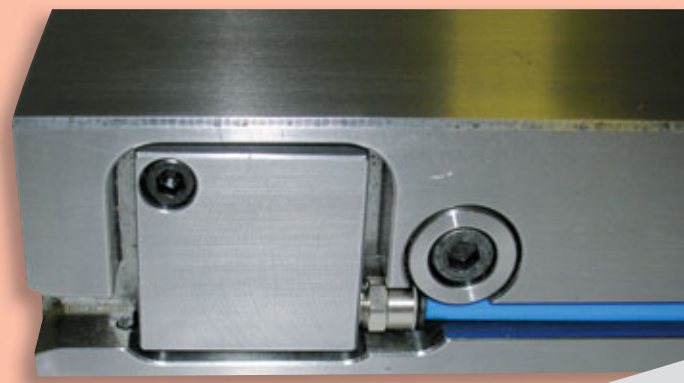
Raccordo d'ingresso
Fitting

Raccordo intermedio
Connection Fitting

Raccordo finale
Output fitting



	V	A	R	H aperto/open	Max T/M
3038 PN	10	26°	1,5	135	100
3039 PN	6	35°	1	105	80
3040 PN	12	26°	3	135	100
3041 PN	8	30°	1,5	110	80



PIEGASCHIACCIA / FLATTENING-HEMMING TOOLS

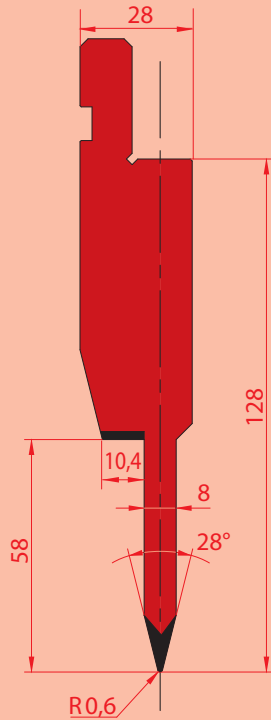
835-415 Frazionato (Bonificato) / Sectioned (Quenched)

- C45 bonificato /quenched
- 42CrMo4
- C45

1195

Max T/m=80

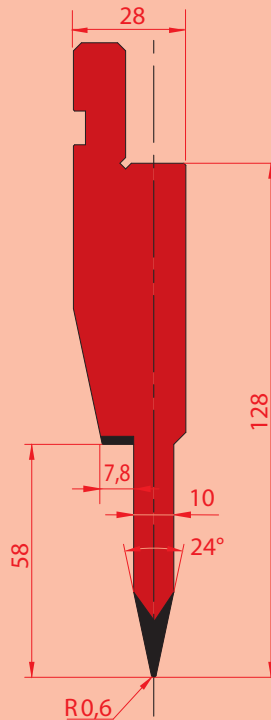
spessore max di lamiera (ferro normale) 1,2 mm
max sheet thickness mild steel 1,2 mm



1196

Max T/m=80

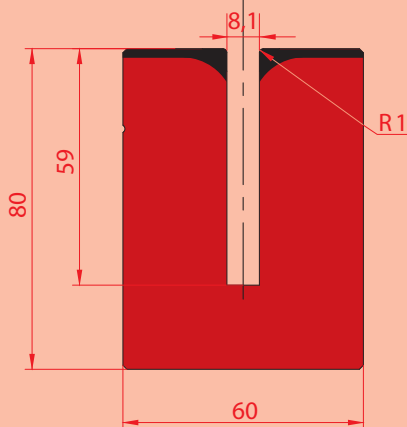
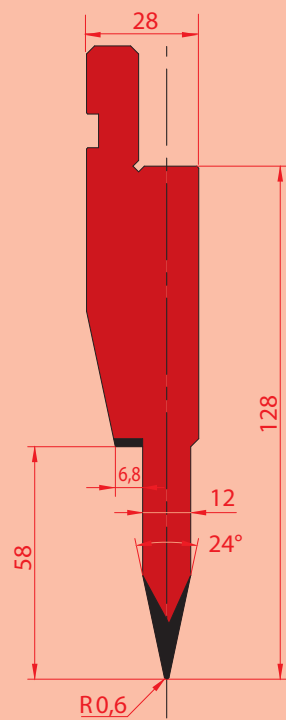
spessore max di lamiera (ferro normale) 1,5 mm
max sheet thickness mild steel 1,5 mm



1197

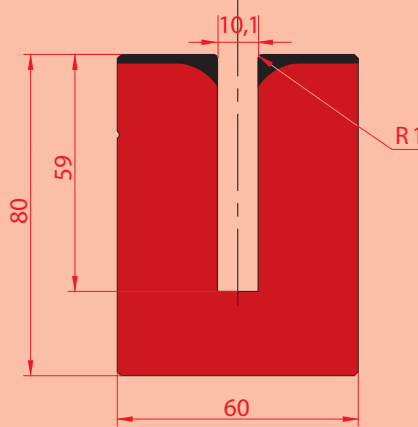
Max T/m=80

spessore max di lamiera (ferro normale) 1,5 mm
max sheet thickness mild steel 1,5 mm



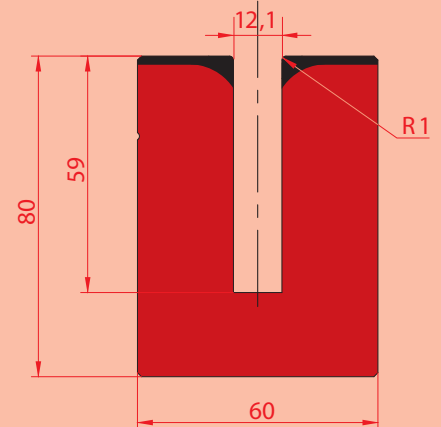
3176

Max T/m=50



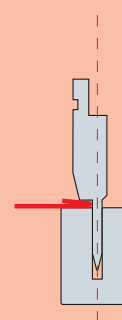
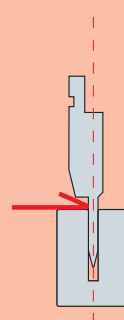
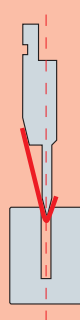
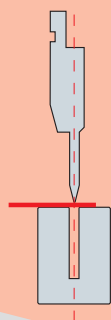
3177

Max T/m=50



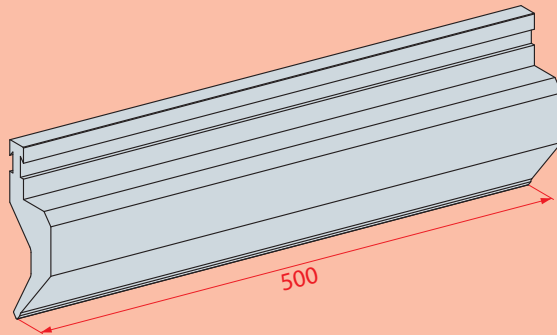
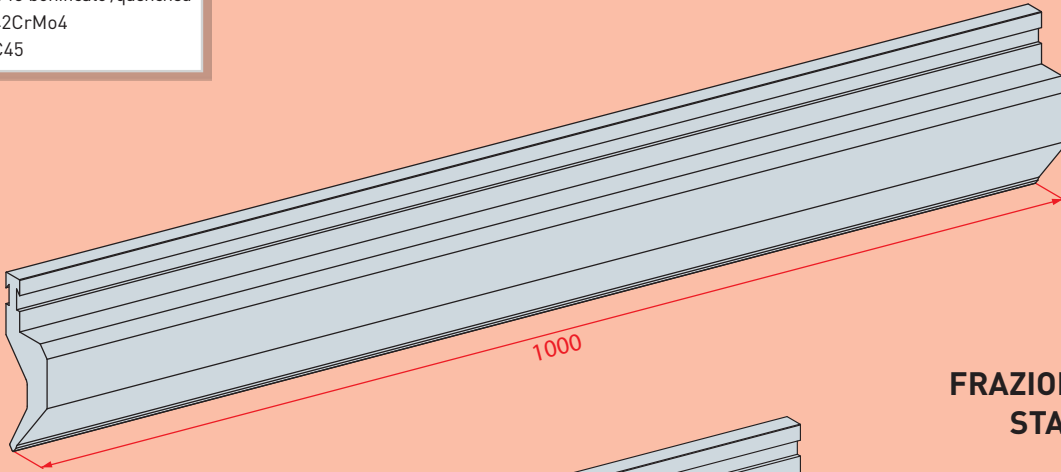
3178

Max T/m=50

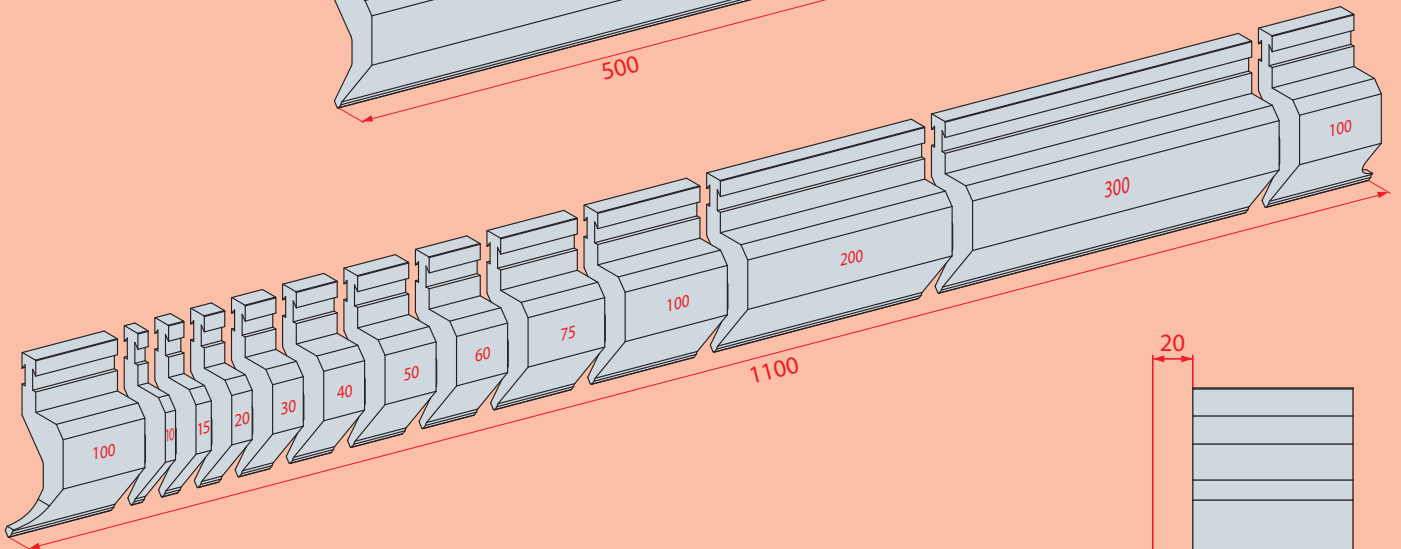


PUNZONI/PUNCHES

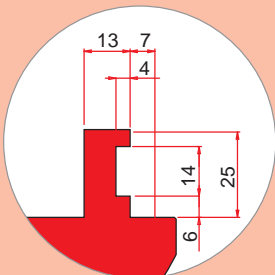
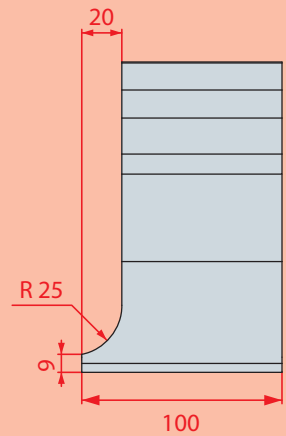
- C45 bonificato /quenched
- 42CrMo4
- C45



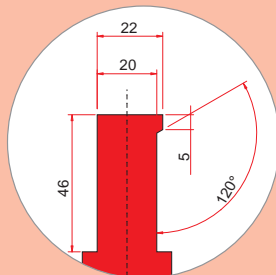
FRAZIONATURA STANDARD/
STANDARD SECTIONING



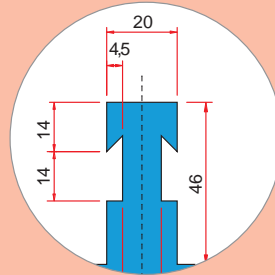
FRESATURA SCARPETTA
MILLING HORN



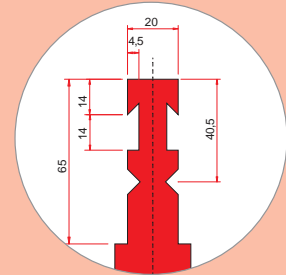
EURO BEYELER
pagina / page 87



BEYELER S
pagina / page 89



EURO BEYELER R
pagina / page 90

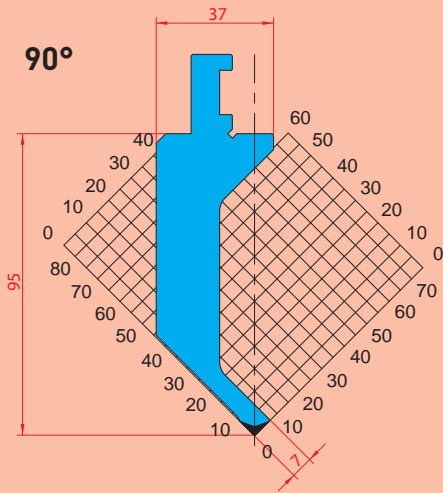


BEYELER RF-A
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PUNZONI FUORI PRODUZIONE / OUT OF PRODUCTION PUNCHES

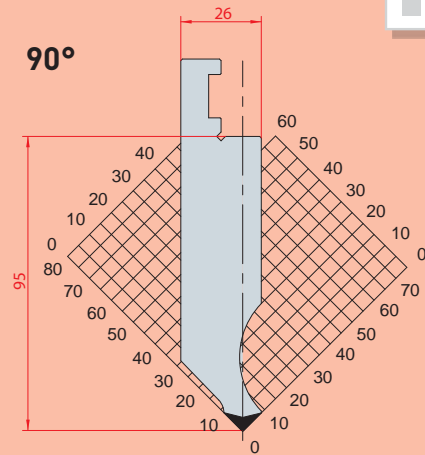
disponibili su richiesta / available on request

- C45 bonificato /quenched
- 42CrMo4
- C45



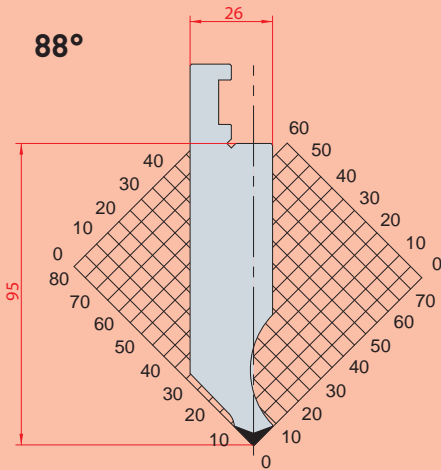
1201

$\alpha=90^\circ$ R=0.6 H=95.00 Max T/m=20



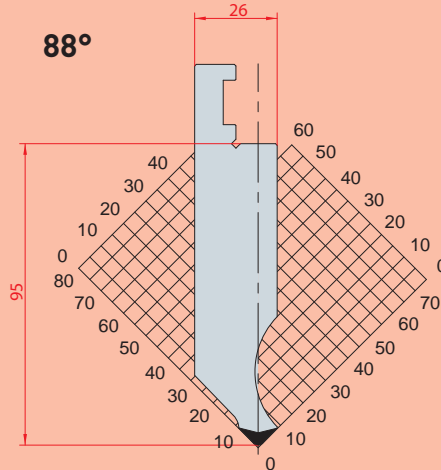
1202

$\alpha=90^\circ$ R=0.8 H=95.00 Max T/m=100



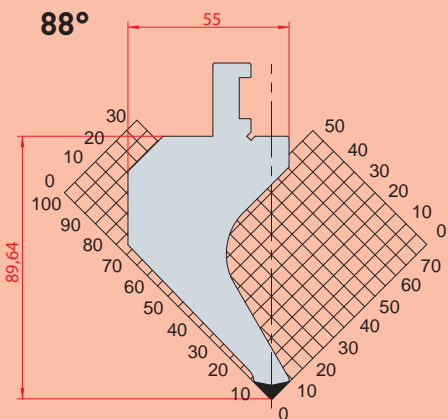
1203

$\alpha=88^\circ$ R=0.8 H=95.00 Max T/m=100



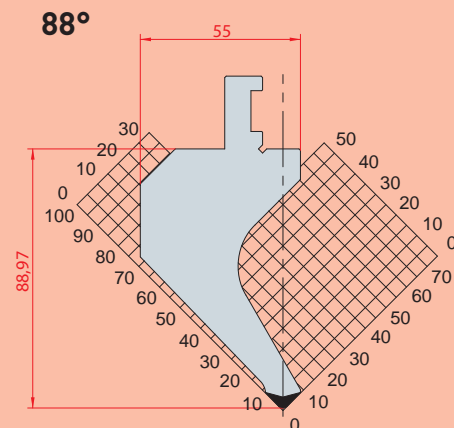
1204

$\alpha=88^\circ$ R=2 H=95.00 Max T/m=100



1205

$\alpha=88^\circ$ R=0.8 H=89.64 Max T/m=60



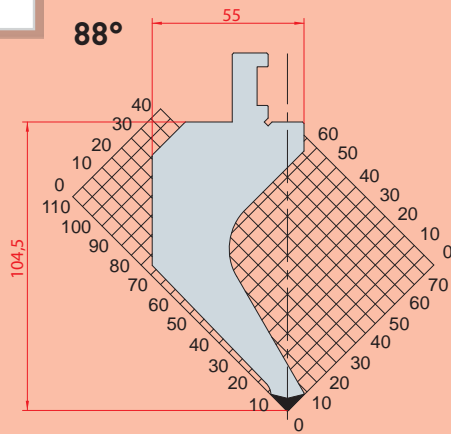
1206

$\alpha=88^\circ$ R=2 H=88.97 Max T/m=60

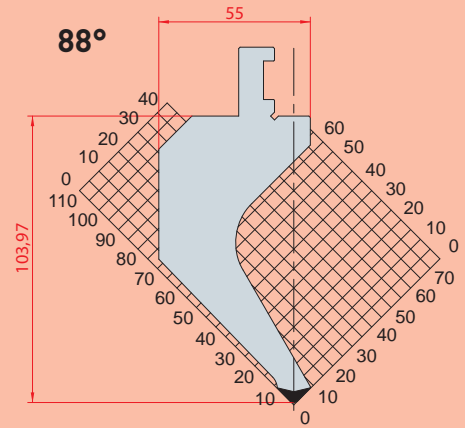
PUNZONI FUORI PRODUZIONE / OUT OF PRODUCTION PUNCHES

disponibili su richiesta / available on request

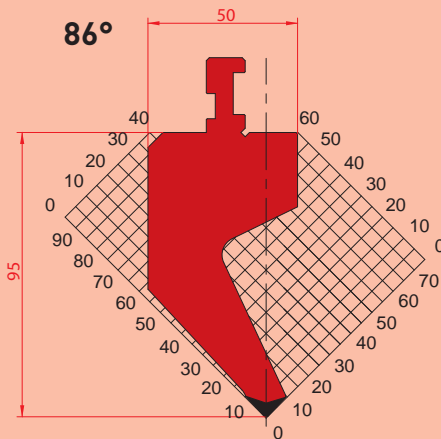
- C45 bonificato /quenched
- 42CrMo4
- C45



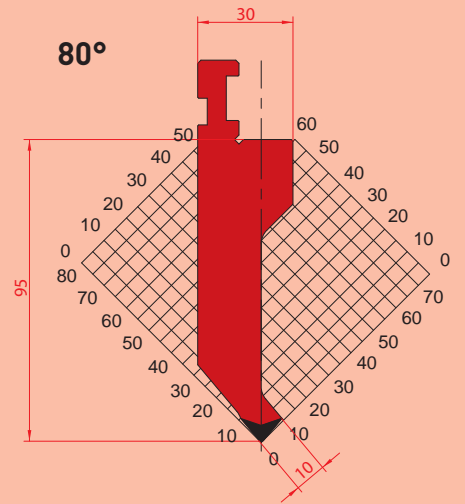
1207
 $\alpha=88^\circ$ R=0.8 H=104.50 Max T/m=50



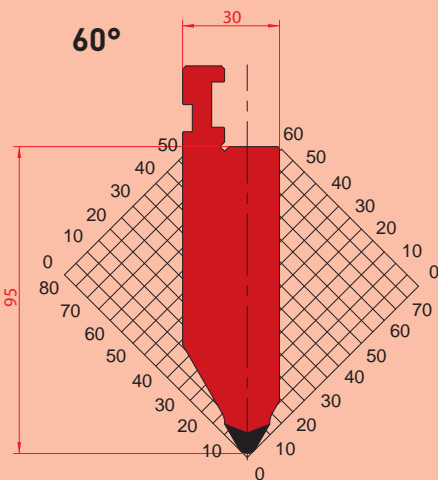
1208
 $\alpha=88^\circ$ R=2 H=103.97 Max T/m=50



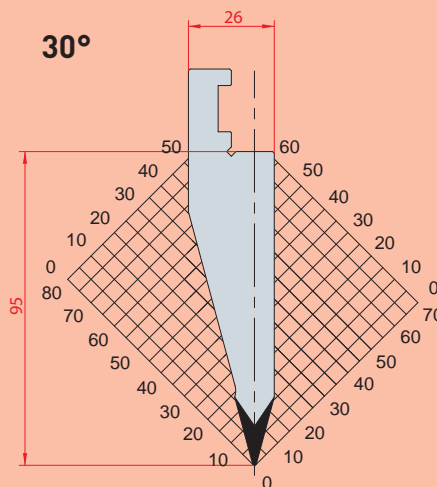
1285
 $\alpha=86^\circ$ R=1 H=95.00 Max T/m=100



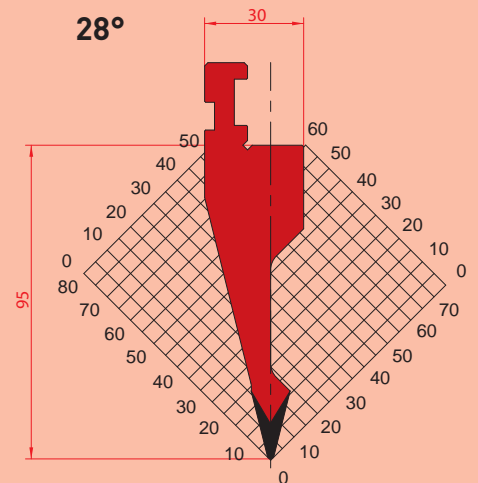
1286
 $\alpha=80^\circ$ R=1 H=95.00 Max T/m=100



1287
 $\alpha=60^\circ$ R=3 H=95.00 Max T/m=100



1209
 $\alpha=30^\circ$ R=0.6 H=95.00 Max T/m=100

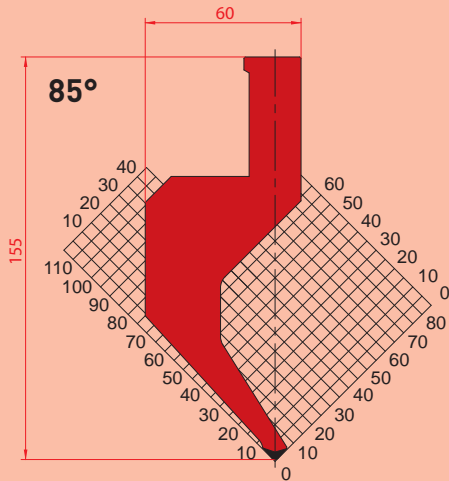


1288
 $\alpha=28^\circ$ R=1 H=95.00 Max T/m=70

PUNZONI FUORI PRODUZIONE / OUT OF PRODUCTION PUNCHES

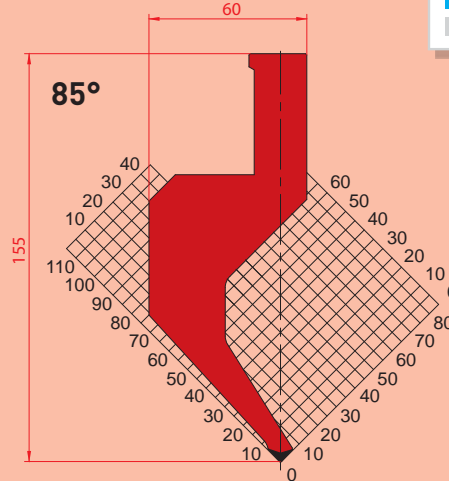
disponibili su richiesta / available on request

- C45 bonificato /quenched
- 42CrMo4
- C45



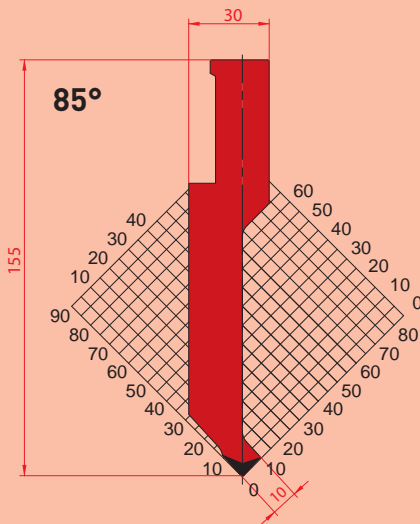
1210

$\alpha=85^\circ$ R=1.5 H=155.00 Max T/m=50



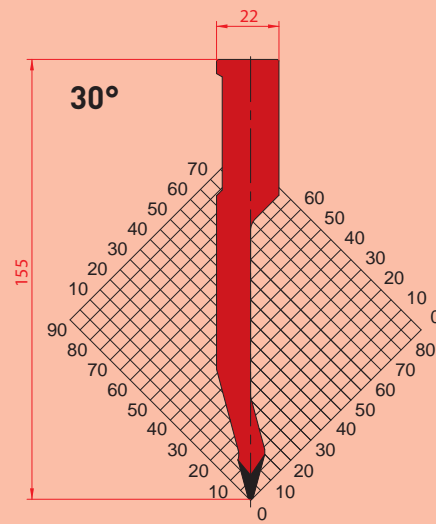
1211

$\alpha=85^\circ$ R=0.8 H=155.00 Max T/m=50



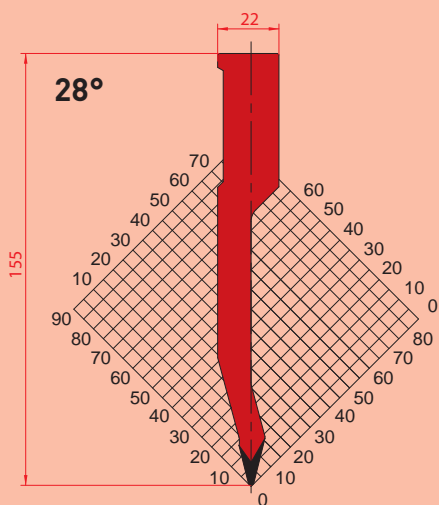
1212

$\alpha=85^\circ$ R=1 H=155.00 Max T/m=100



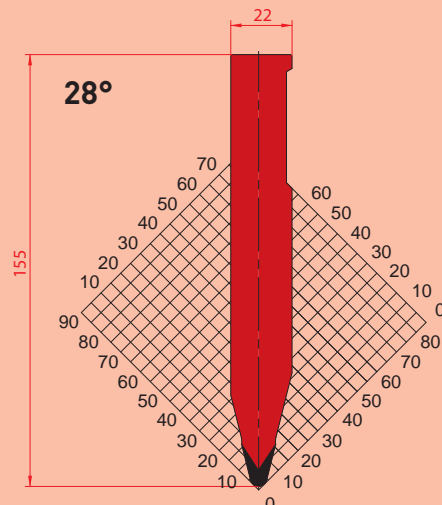
1213

$\alpha=30^\circ$ R=1 H=155.00 Max T/m=80



1214

$\alpha=28^\circ$ R=1 H=155.00 Max T/m=80

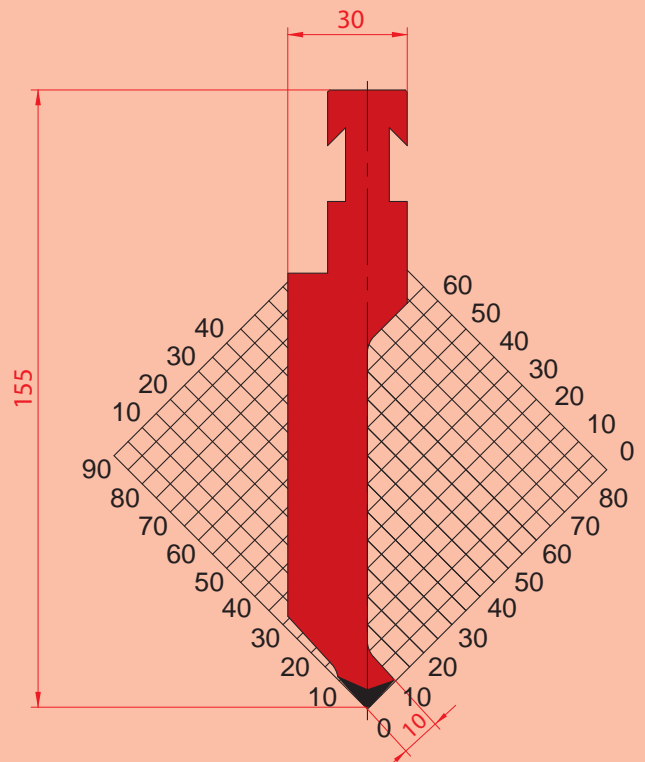
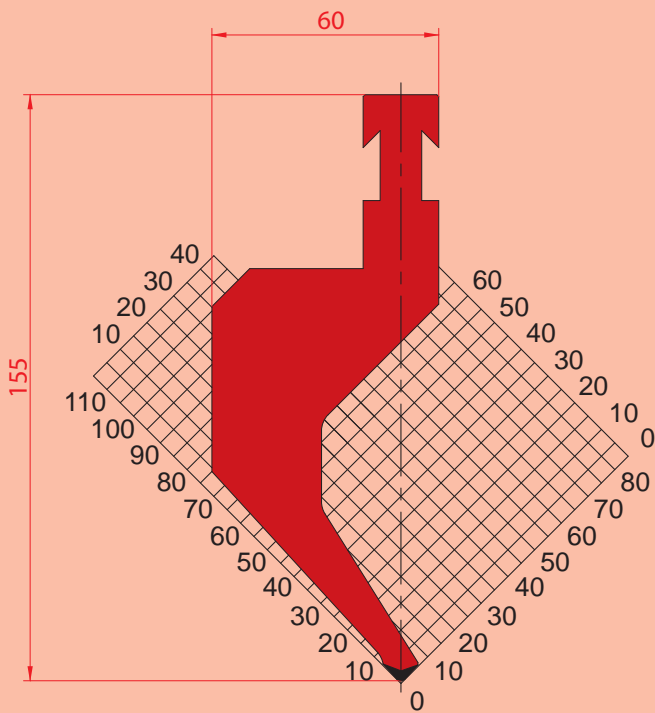
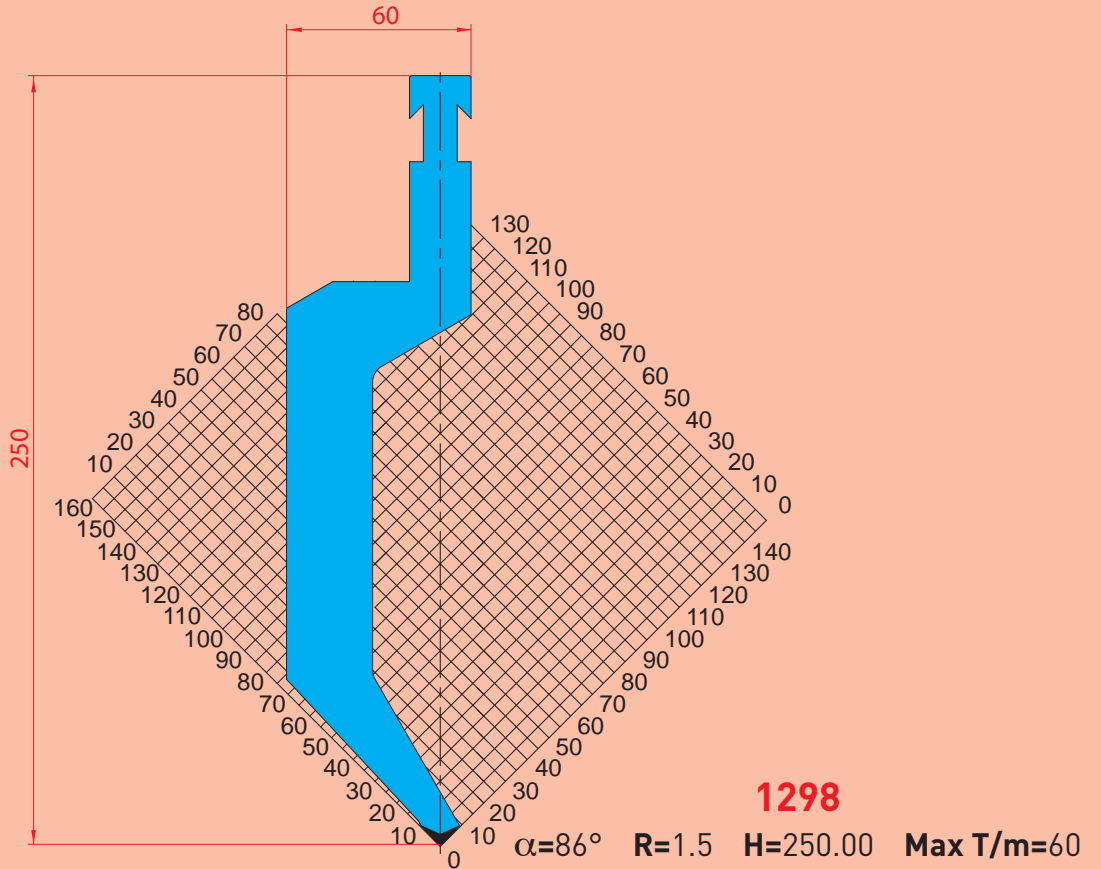


1215

$\alpha=28^\circ$ R=3 H=155.00 Max T/m=100

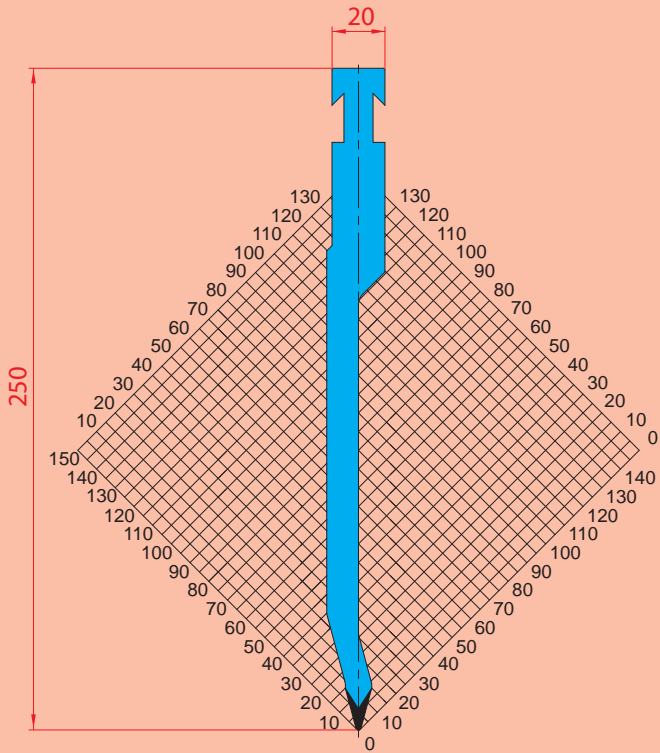
PUNZONI - 86° / PUNCHES - 86°

- C45 bonificato /quenched
- 42CrMo4
- C45



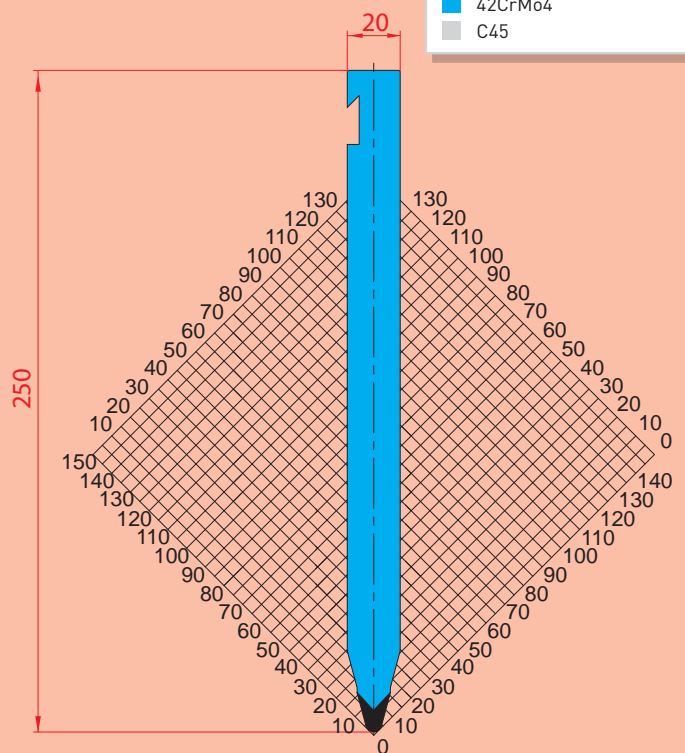
PUNZONI - 30° / PUNCHES - 30°

■ C45 bonificato /quenched
 ■ 42CrMo4
 ■ C45



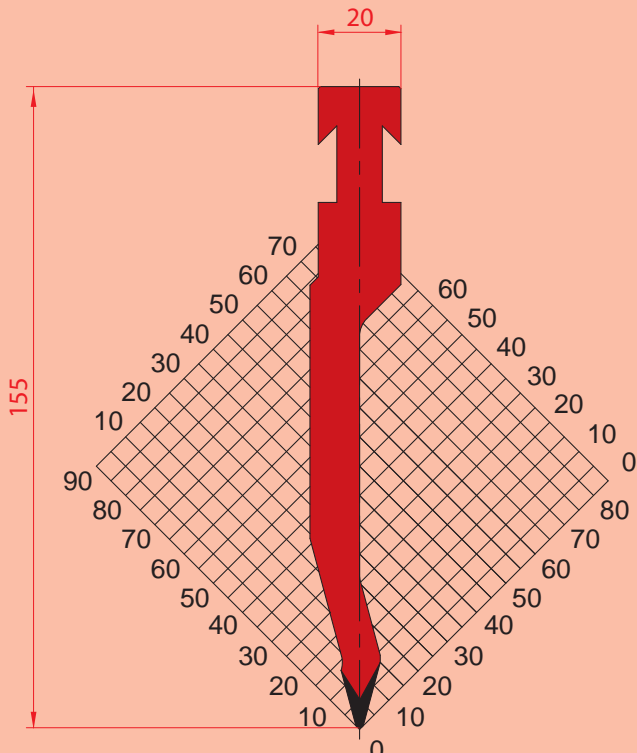
1299

$\alpha=30^\circ$ R=1 H=250.00 Max T/m=80



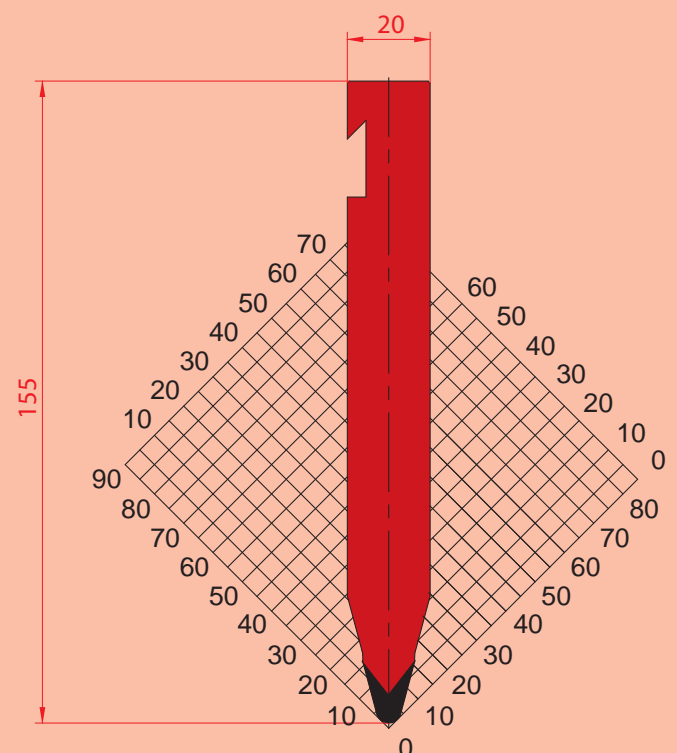
1300

$\alpha=30^\circ$ R=3 H=250.00 Max T/m=120



1220

$\alpha=30^\circ$ R=1 H=155.00 Max T/m=80

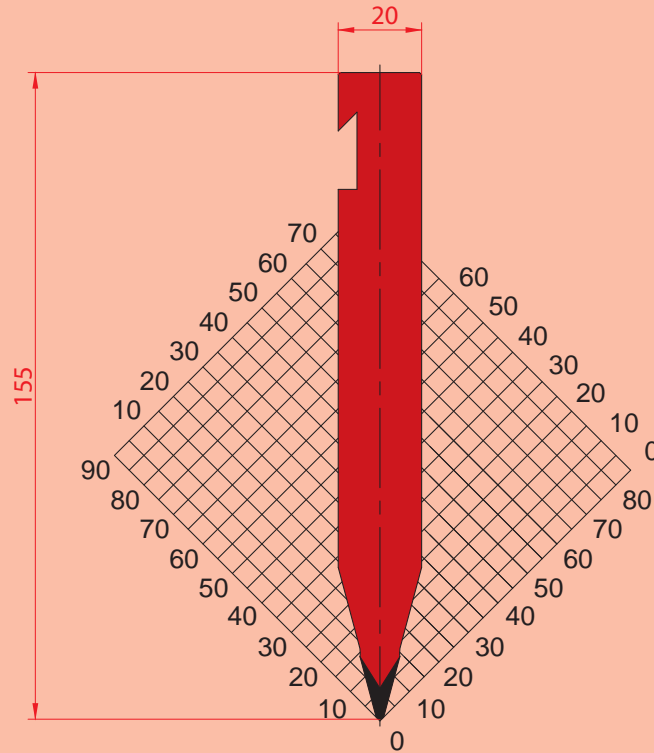


1225

$\alpha=30^\circ$ R=3 H=155.00 Max T/m=100

PUNZONI - 30° / PUNCHES - 30°

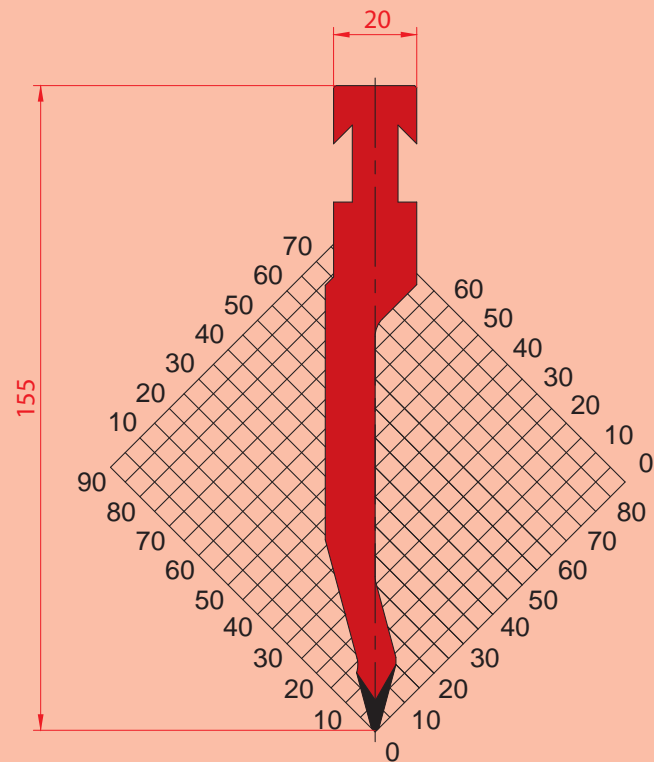
- C45 bonificato /quenched
- 42CrMo4
- C45



1226

$\alpha=30^\circ$ R=1 H=155.00 Max T/m=100

PUNZONI - 28° / PUNCHES - 28°

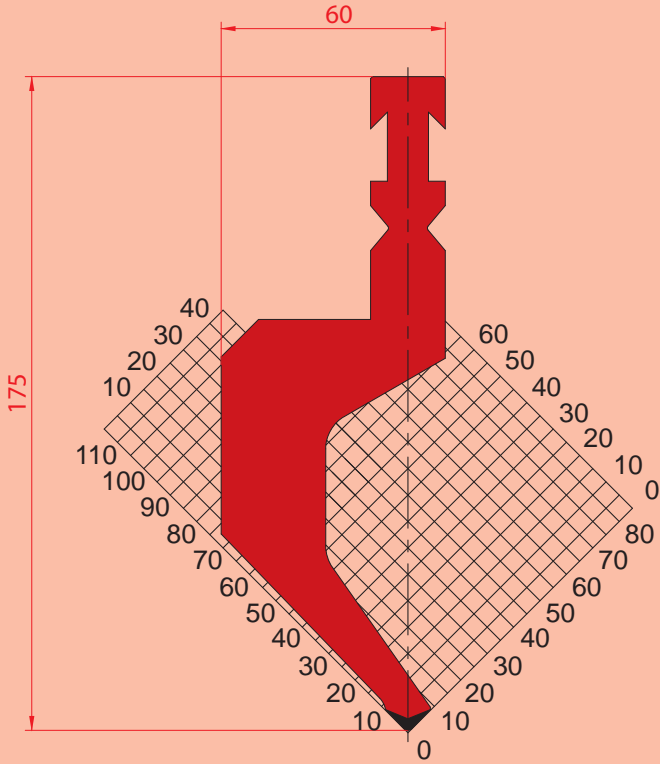


1221

$\alpha=28^\circ$ R=1 H=155.00 Max T/m=80

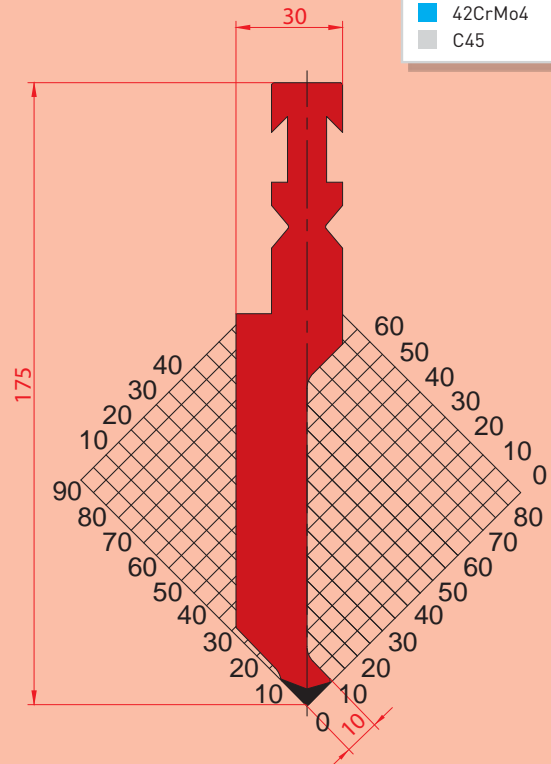
PUNZONI - 88° / PUNCHES - 88°

■	C45 bonificato /quenched
■	42CrMo4
■	C45



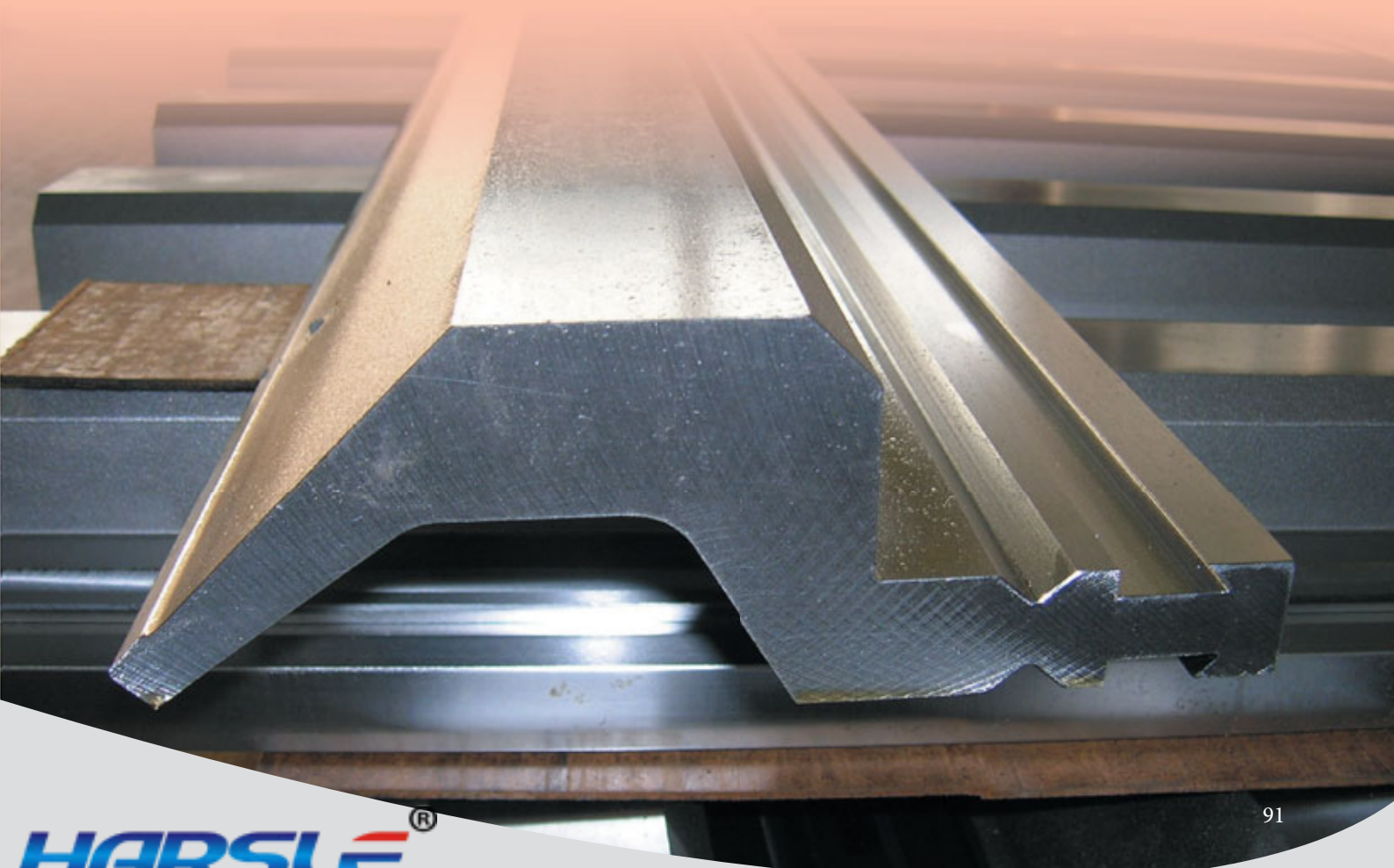
1227

$\alpha=88^\circ$ R=1.5 H=175.00 Max T/m=50



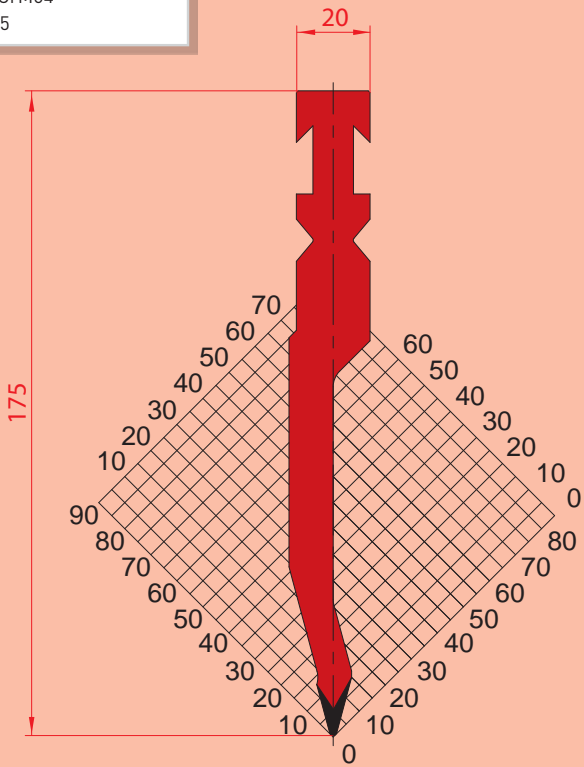
1229

$\alpha=88^\circ$ R=1 H=175.00 Max T/m=100



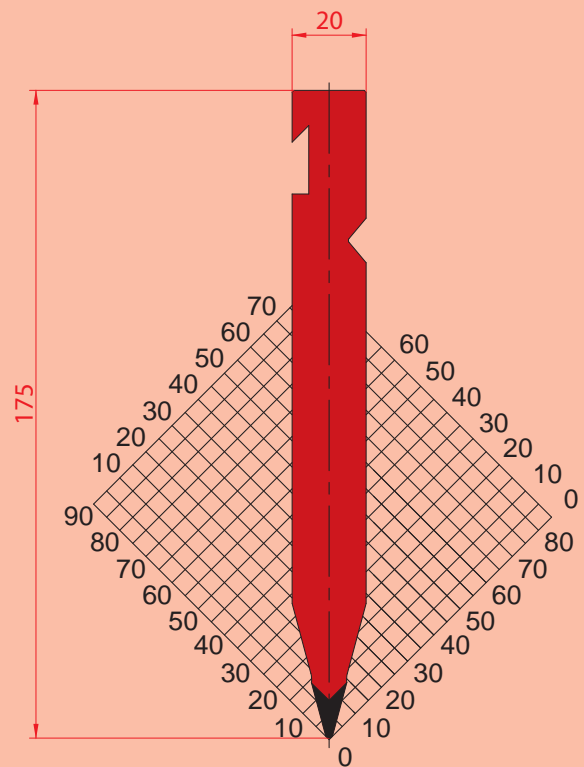
PUNZONI - 30° / PUNCHES - 30°

- C45 bonificato /quenched
- 42CrMo4
- C45



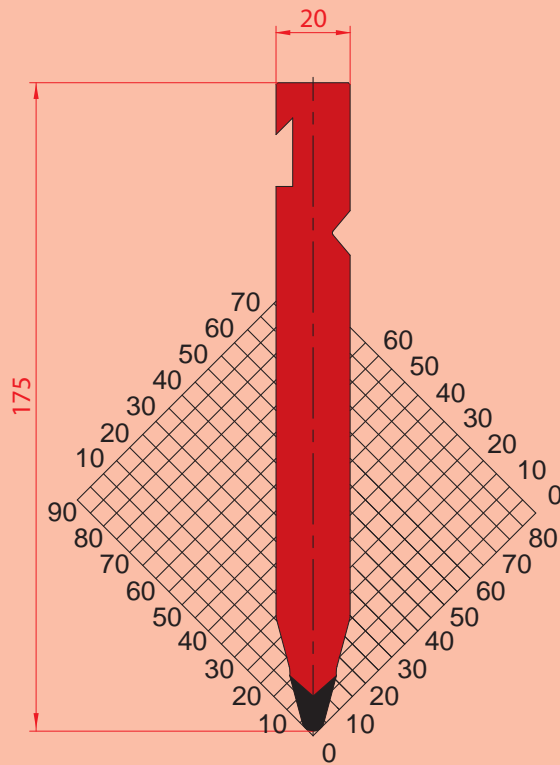
1230

$\alpha=30^\circ$ R=1 H=175.00 Max T/m=80



1232

$\alpha=30^\circ$ R=1 H=175.00 Max T/m=100

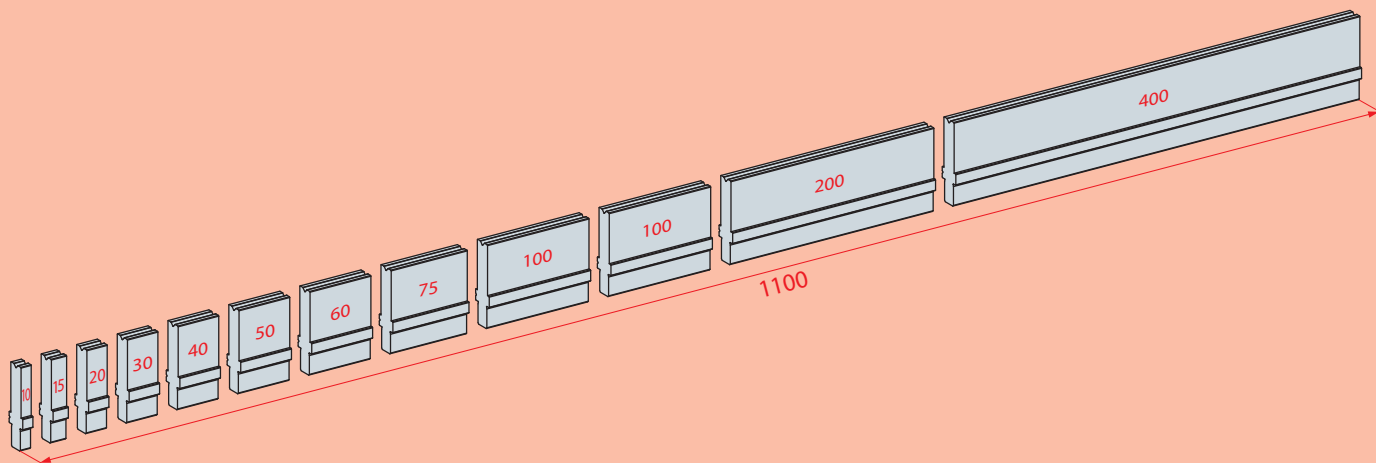
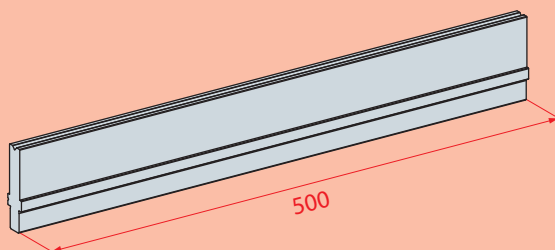
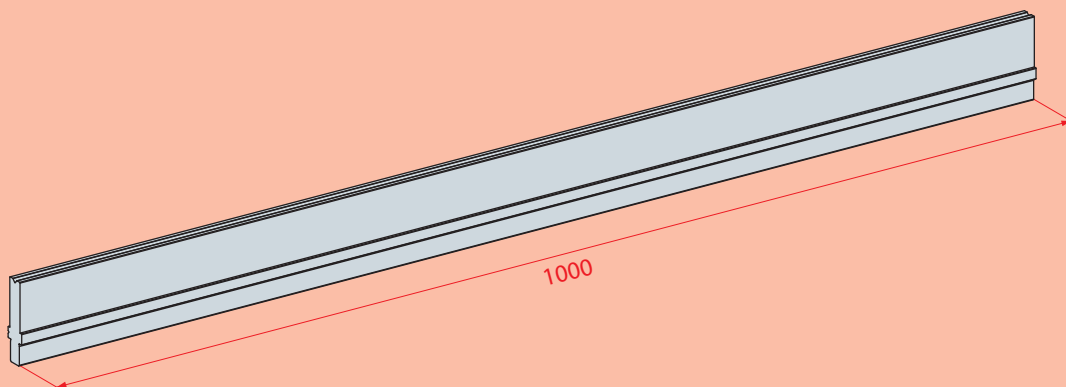


1231

$\alpha=30^\circ$ R=3 H=175.00 Max T/m=100

MATRICI/DIES

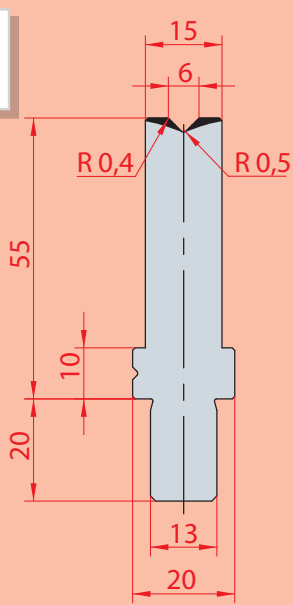
- C45 bonificato /quenched
- 42CrMo4
- C45



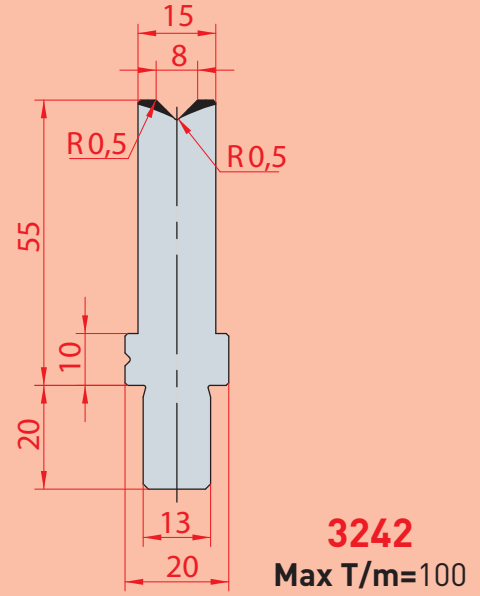
FRAZIONATURA STANDARD/
STANDARD SECTIONING

MATRICI 1V - 88° / SINGLE V DIE - 88°

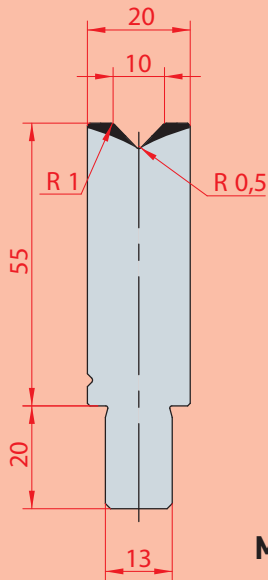
- C45 bonificato /quenched
- 42CrMo4
- C45



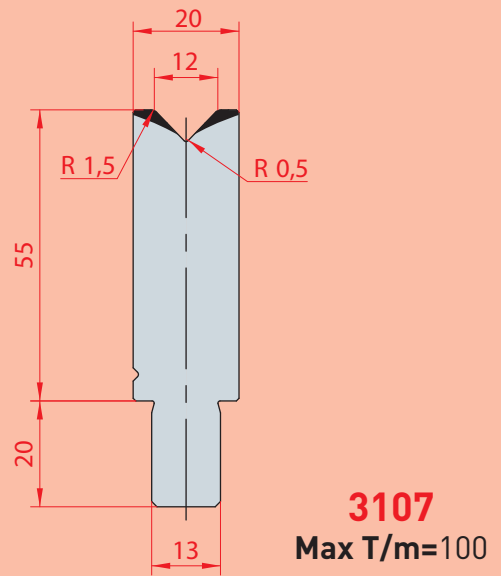
3241
Max T/m=100



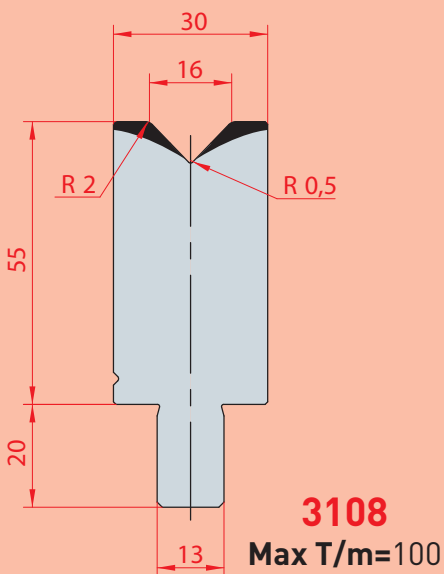
3242
Max T/m=100



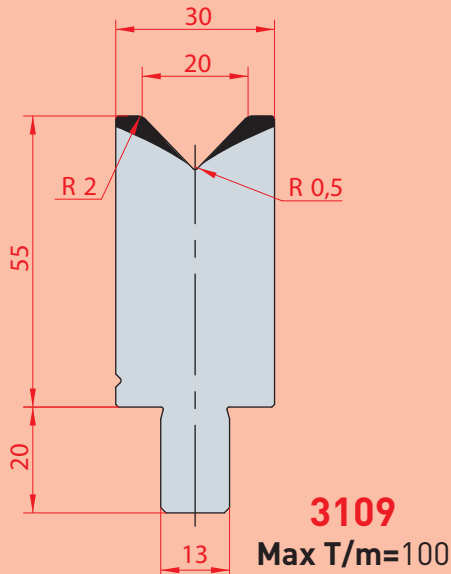
3106
Max T/m=100



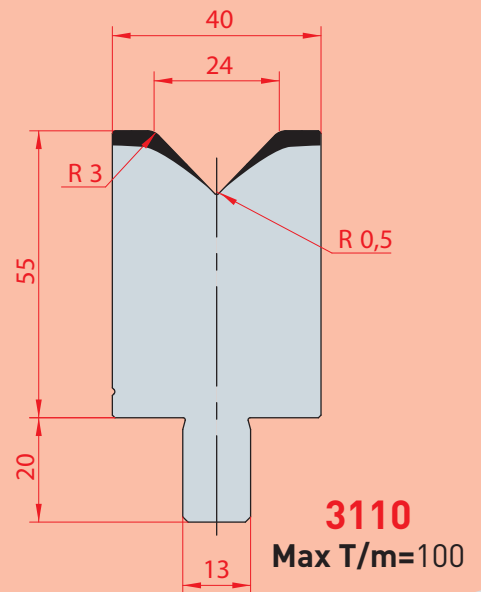
3107
Max T/m=100



3108
Max T/m=100



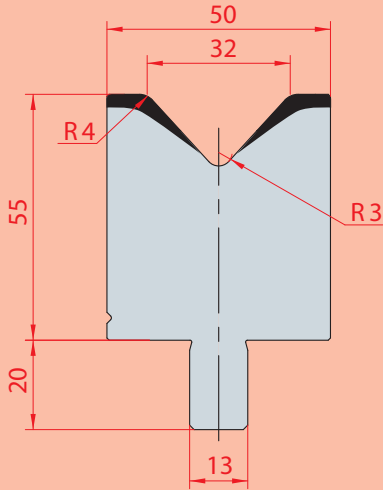
3109
Max T/m=100



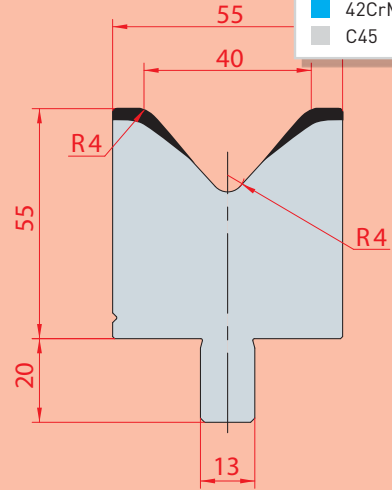
3110
Max T/m=100

MATRICI 1V - 85° / SINGLE V DIE - 85°

■	C45 bonificato /quenched
■	42CrMo4
■	C45

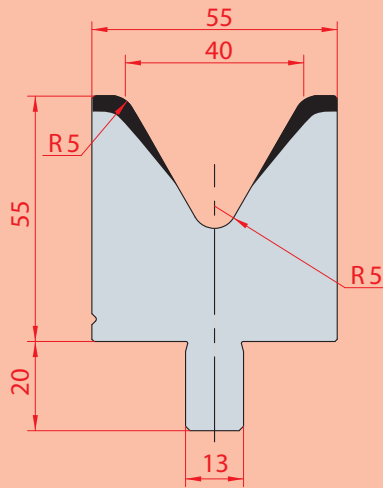


3111
Max T/m=100

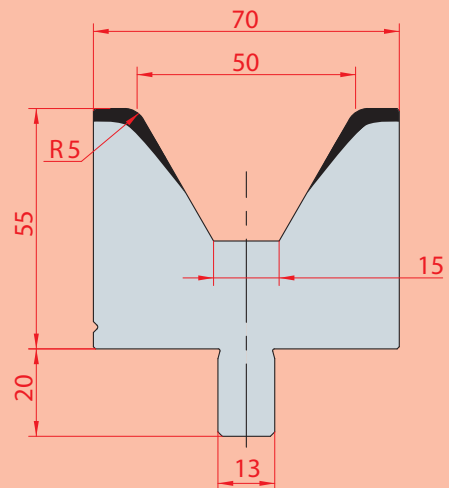


3112
Max T/m=100

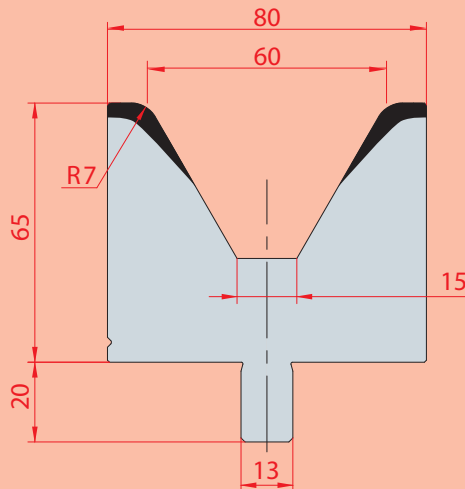
MATRICI 1V - 60° / SINGLE V DIE - 60°



3113
Max T/m=100



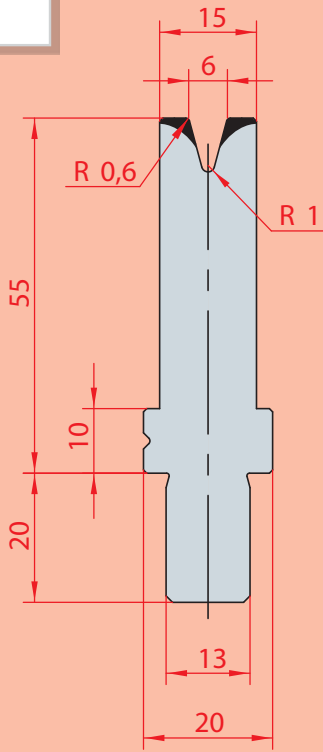
3179
Max T/m=100



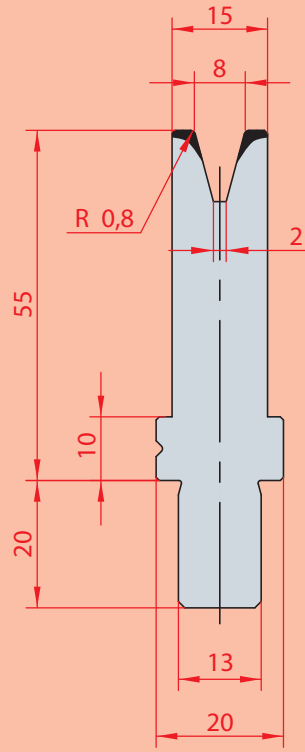
3114
Max T/m=100

MATRICI 1V - 30° / SINGLE V DIE - 30°

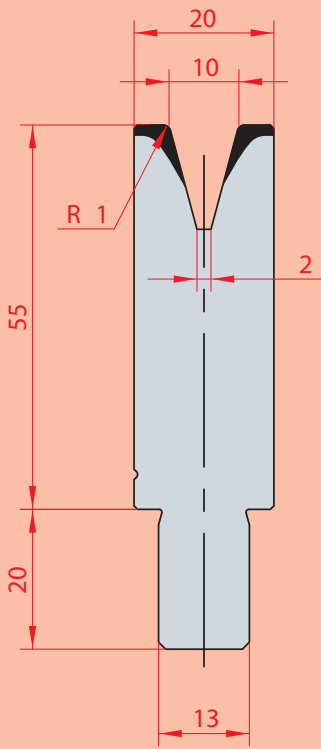
- C45 bonificato /quenched
- 42CrMo4
- C45



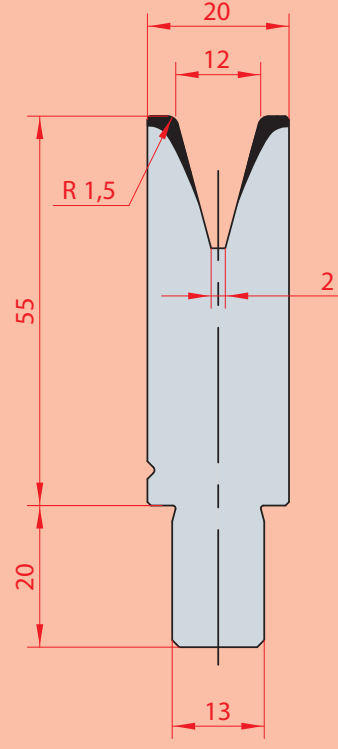
3115
Max T/m=35



3116
Max T/m=40



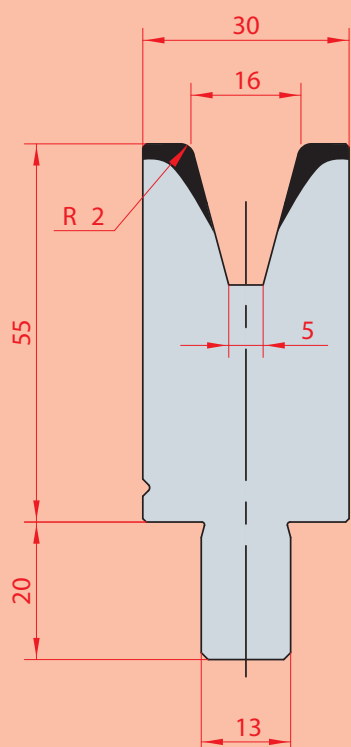
3117
Max T/m=50



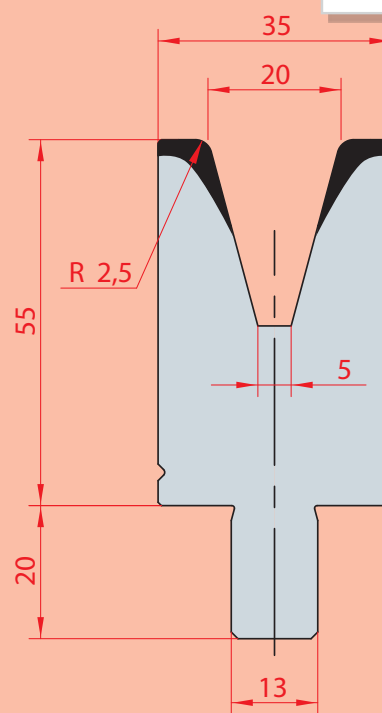
3118
Max T/m=40

MATRICI 1V - 30° / SINGLE V DIE - 30°

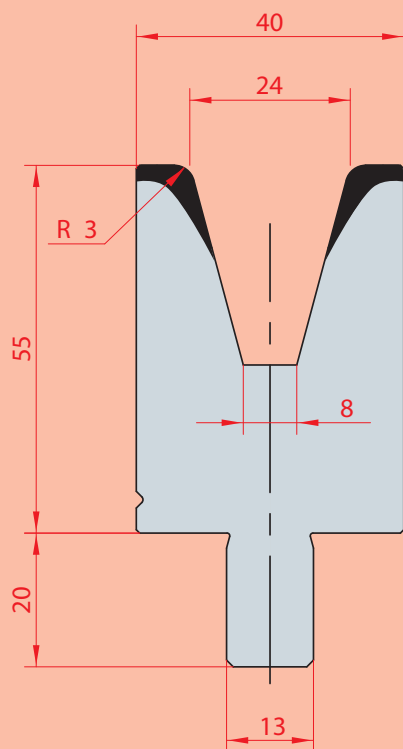
- C45 bonificato /quenched
- 42CrMo4
- C45



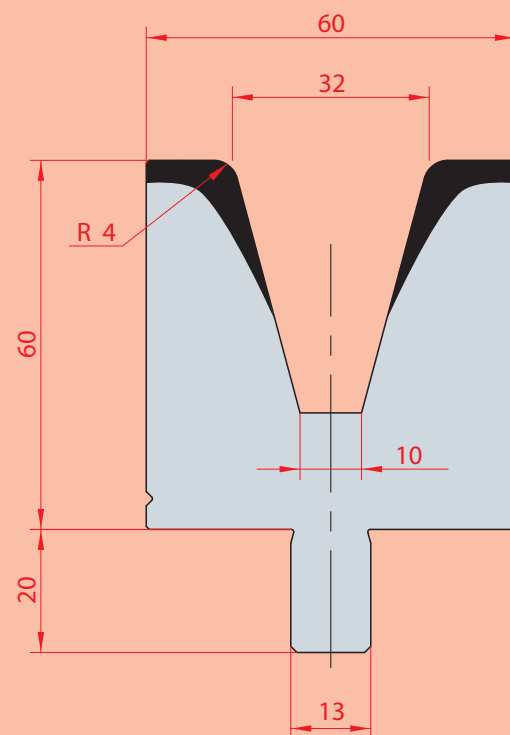
3119
Max T/m=50



3120
Max T/m=55



3121
Max T/m=65



3122
Max T/m=65

PIEGASCHIACCIA / FLATTENING-HEMMING TOOLS

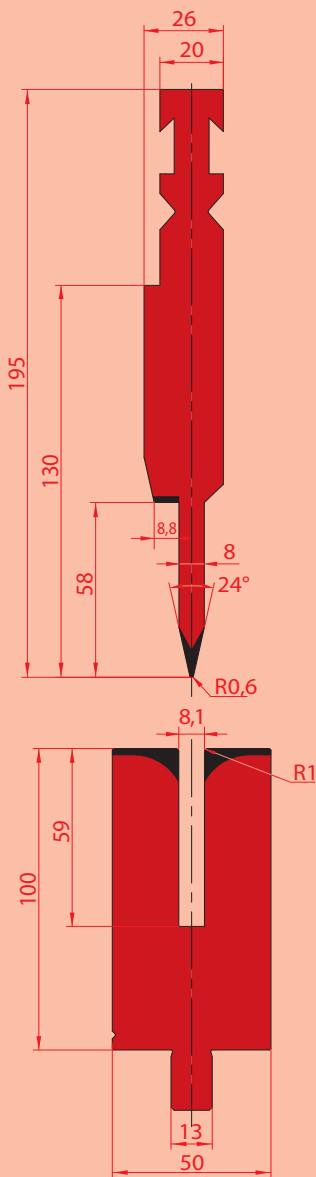
- C45 bonificato /quenched
- 42CrMo4
- C45

500-550 Frazionato (Bonificato) / Sectioned (Quenched)

1252

Max T/m=80

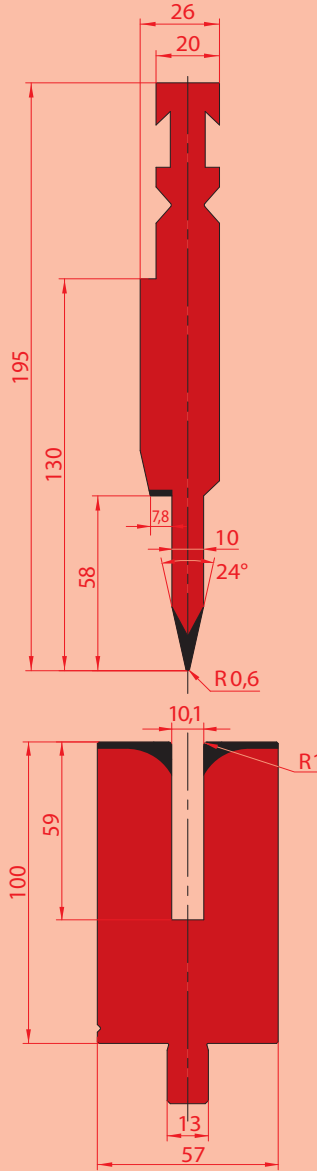
spessore max di lamiera (ferro normale) 1,2 mm
max sheet thickness mild steel 1,2 mm



1253

Max T/m=80

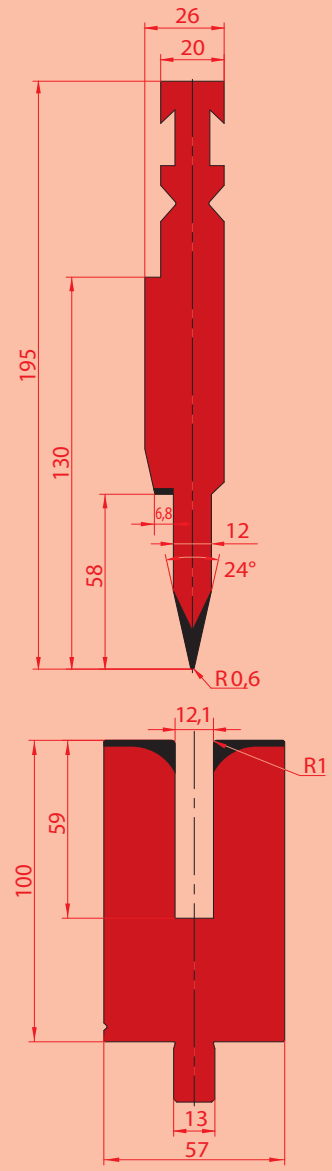
spessore max di lamiera (ferro normale) 1,5 mm
max sheet thickness mild steel 1,5 mm



1254

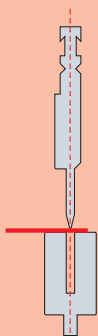
Max T/m=80

spessore max di lamiera (ferro normale) 1,5 mm
max sheet thickness mild steel 1,5 mm



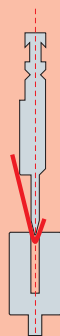
3157

Max T/m=50



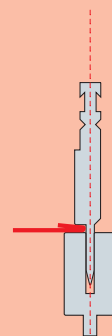
3174

Max T/m=50



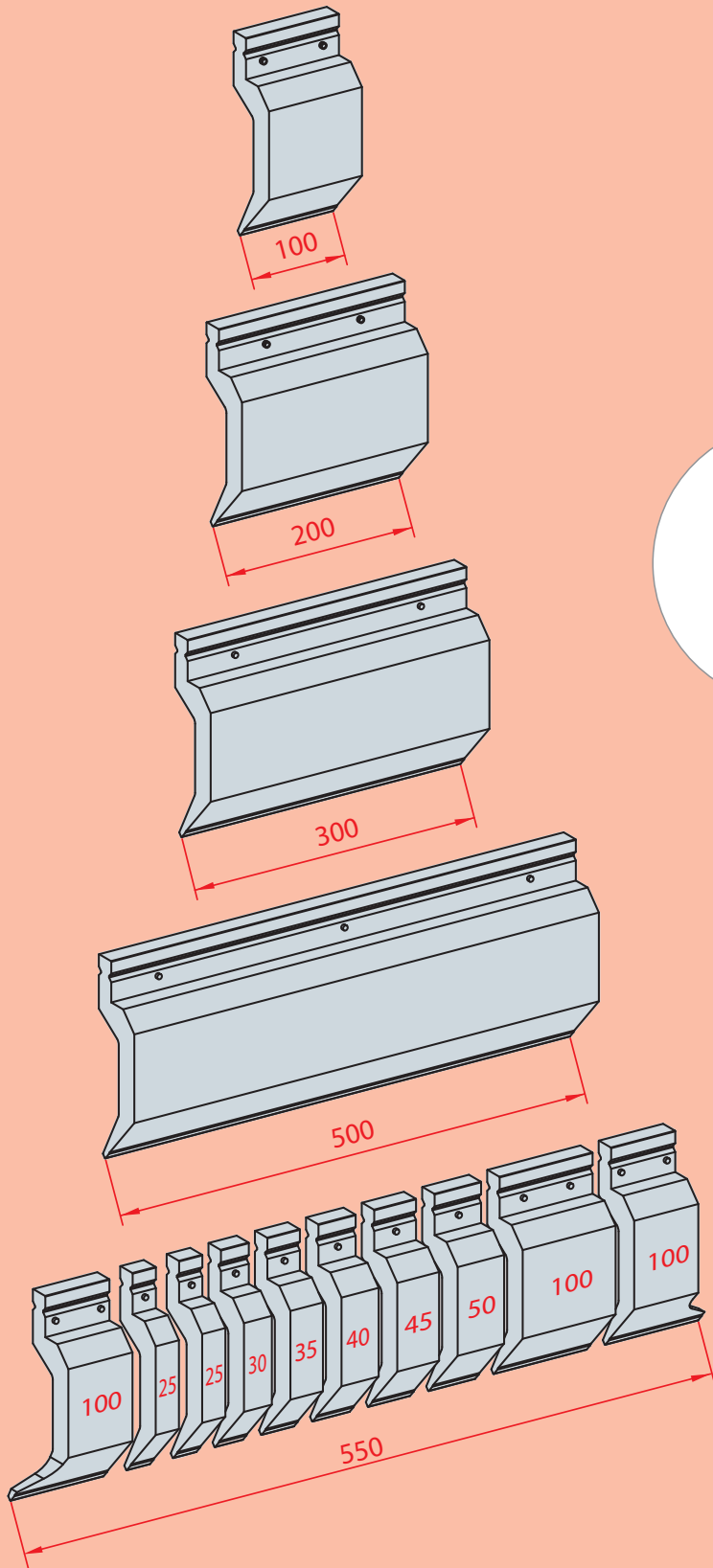
3175

Max T/m=50

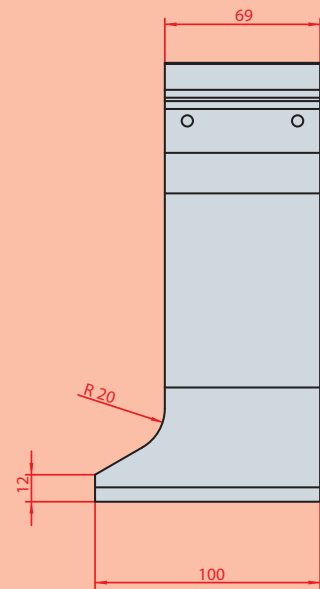
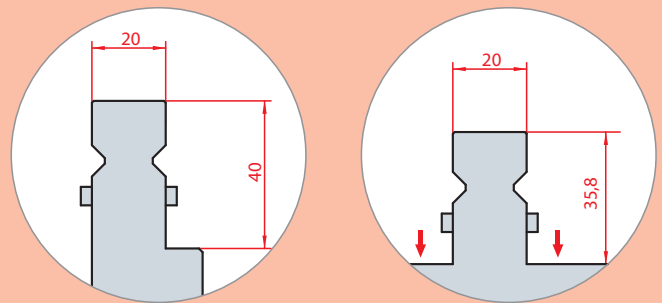


PUNZONI /PUNCHES

- C45 bonificato /quenched
- 42CrMo4
- C45



FRAZIONATURA STANDARD/ STANDARD SECTIONING




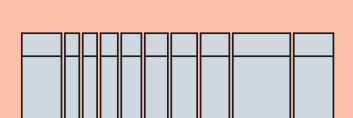
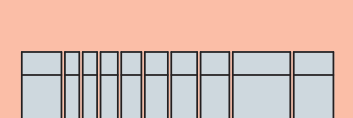
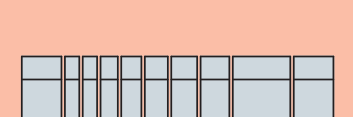
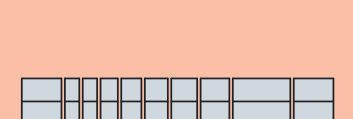


FRESATURA SCARPETTA MILLING HORN

PUNZONI /PUNCHES

- C45 bonificato /quenched
- 42CrMo4
- C45

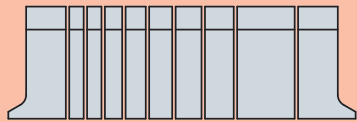
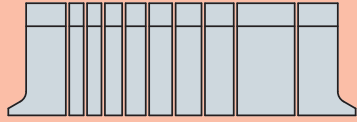
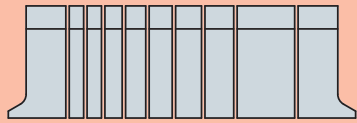

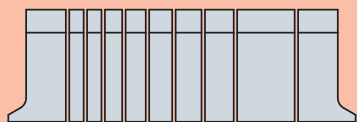

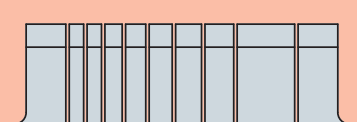
PER PUNZONI: / FOR PUNCHES:
1233 - 1234 - 1235 - 1236 - 1237 - 1238
1295 - 1302 - 1308 - 1313 - 1314

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1 X 300							
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1 X 200							
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2 X 500							
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1 X 200							
1 X 300							
3 X 500							
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1 X 200							
1 X 300							
4 X 500							
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1 X 300							
6 X 500							

PUNZONI / PUNCHES

■	C45 bonificato /quenched
■	42CrMo4
■	C45

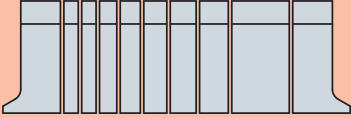
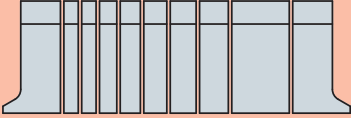
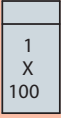
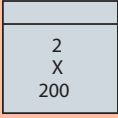

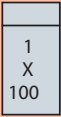
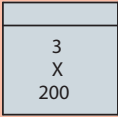

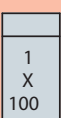
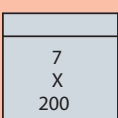
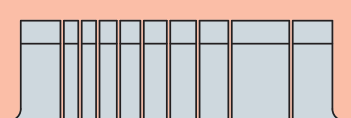
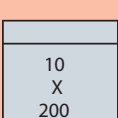
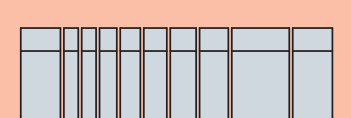

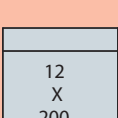
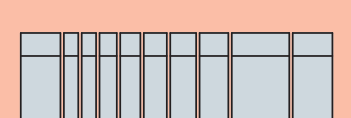

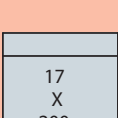
**PER PUNZONI: / FOR PUNCHES:
1294 - 1303**

			550						
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X									
200									
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300									
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X									
200									
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X									
300									
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3									
X									
200									
3									
X									
300									
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X									
200									
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X									
300									
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200									
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300									
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7									
X									
200									
7									
X									
300									

PUNZONI /PUNCHES

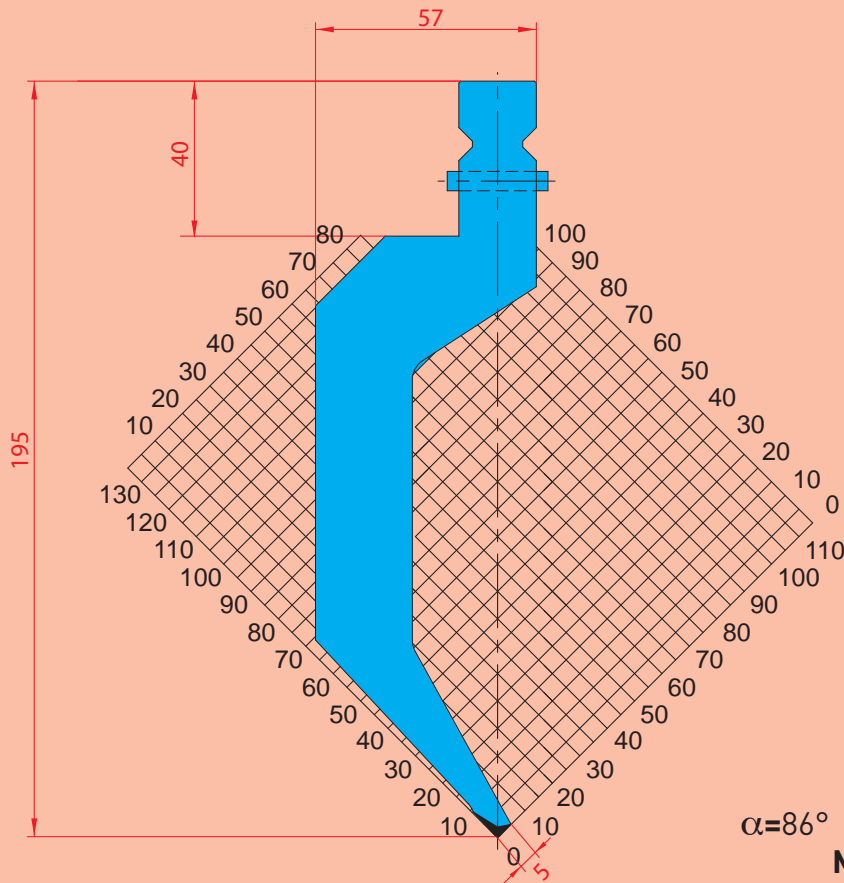
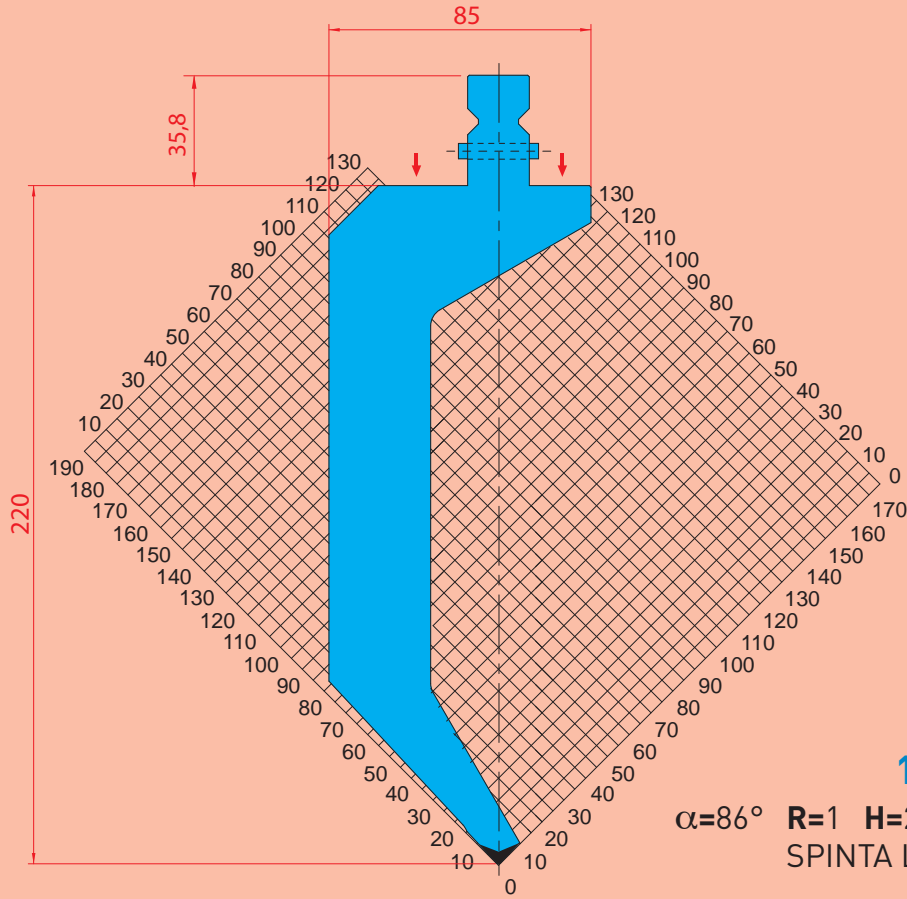
- C45 bonificato /quenched
- 42CrMo4
- C45

**PER PUNZONI:
FOR PUNCHES: 1315**

			550
			1050
			1250
			2050
			2550
			3050
			4050

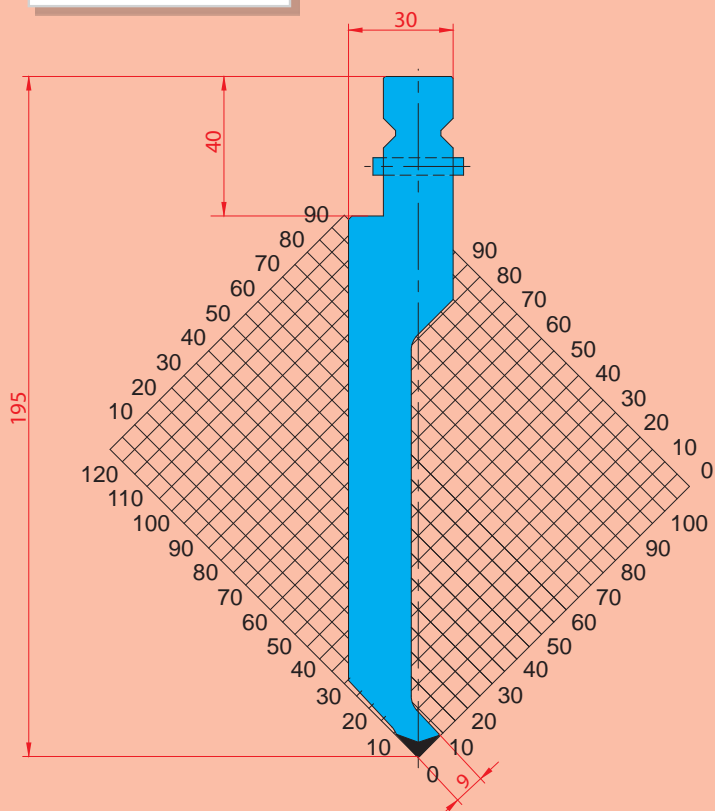
PUNZONI - 86° / PUNCHES - 86°

- C45 bonificato /quenched
- 42CrMo4
- C45



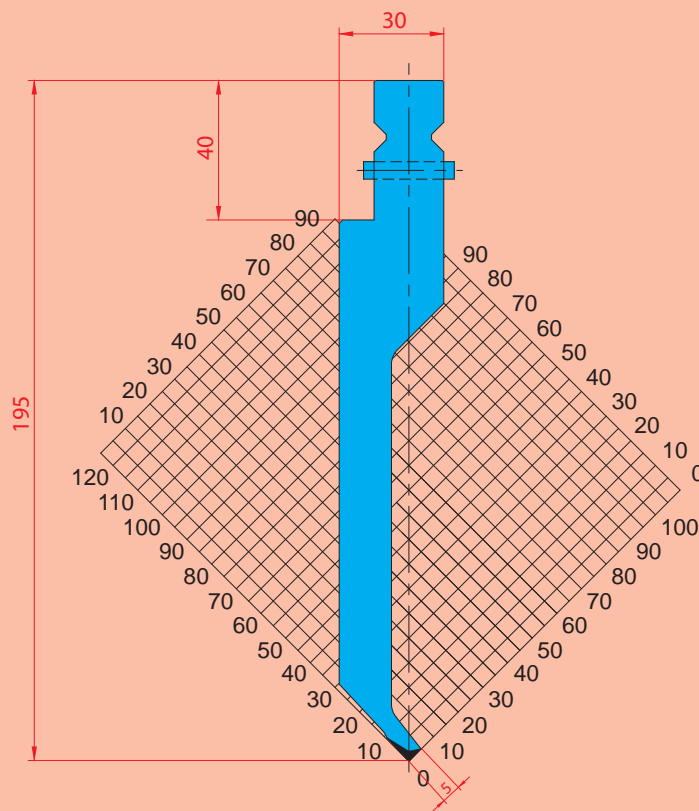
PUNZONI - 86° / PUNCHES - 86°

- C45 bonificato /quenched
- 42CrMo4
- C45



1235

$\alpha=86^\circ$ R=0.8 H=195.00
Max T/m=100



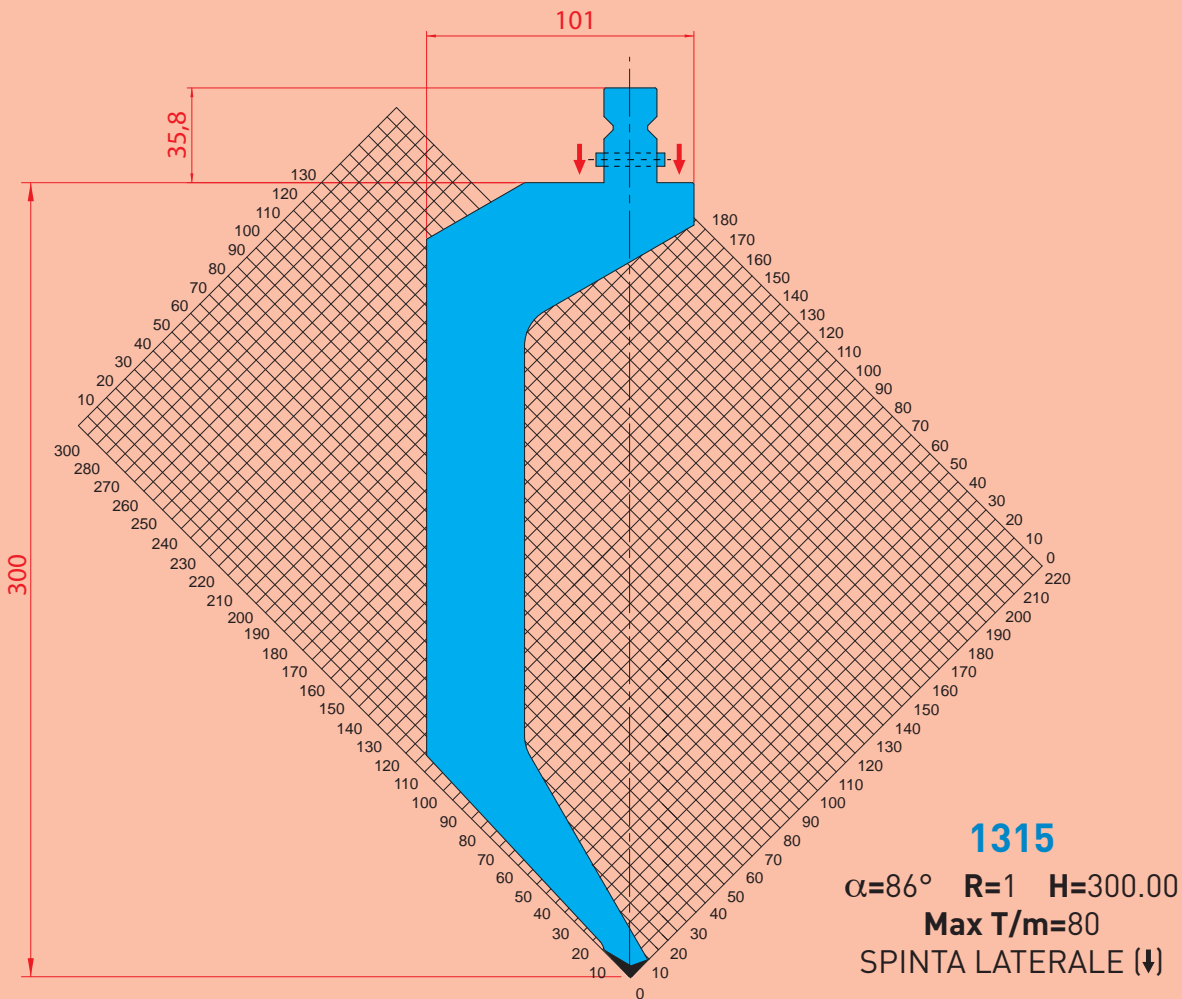
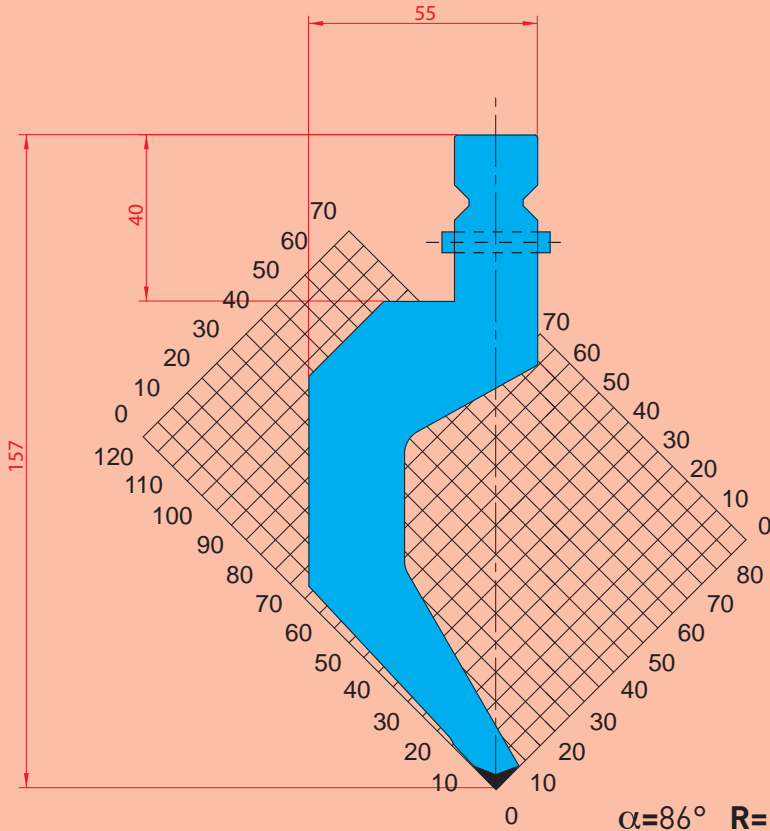
1234

$\alpha=86^\circ$ R=0.6 H=195.00
Max T/m=30



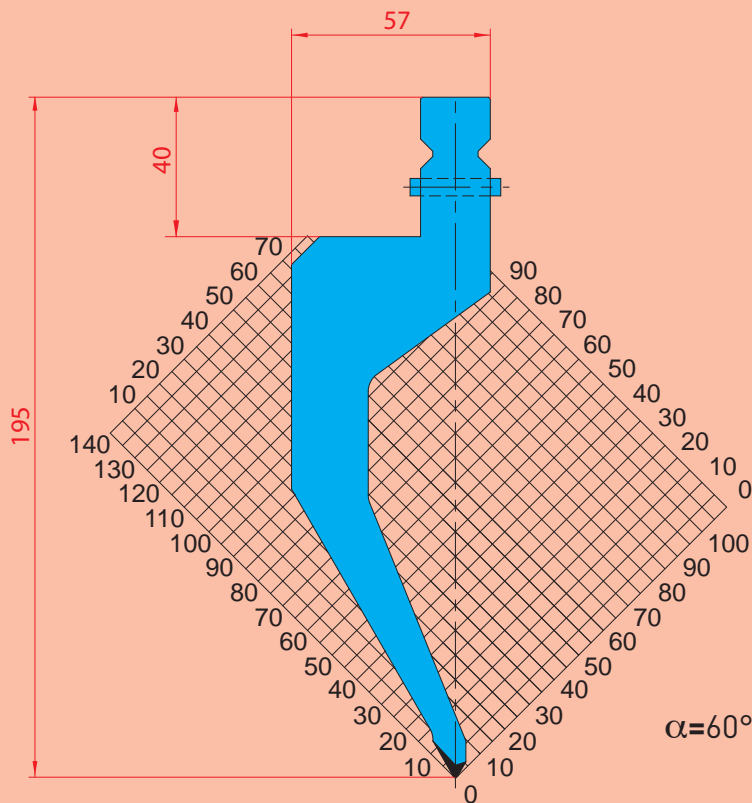
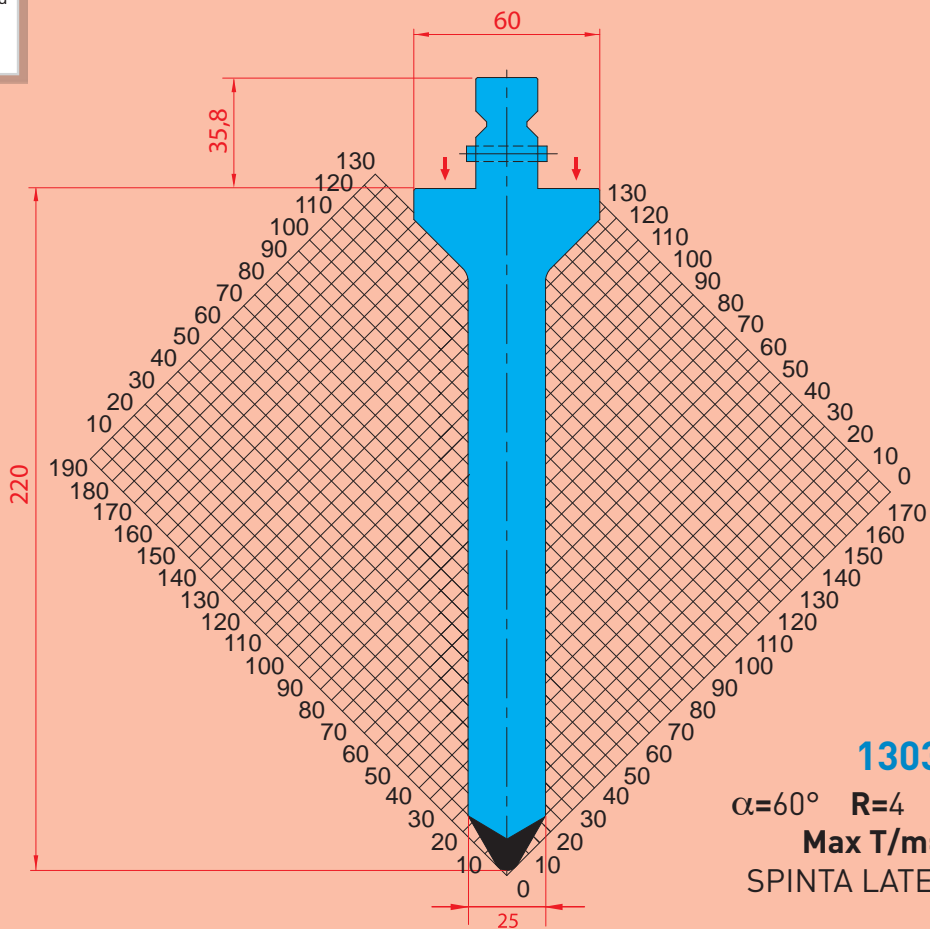
PUNZONI - 86° / PUNCHES - 86°

- C45 bonificato /quenched
- 42CrMo4
- C45



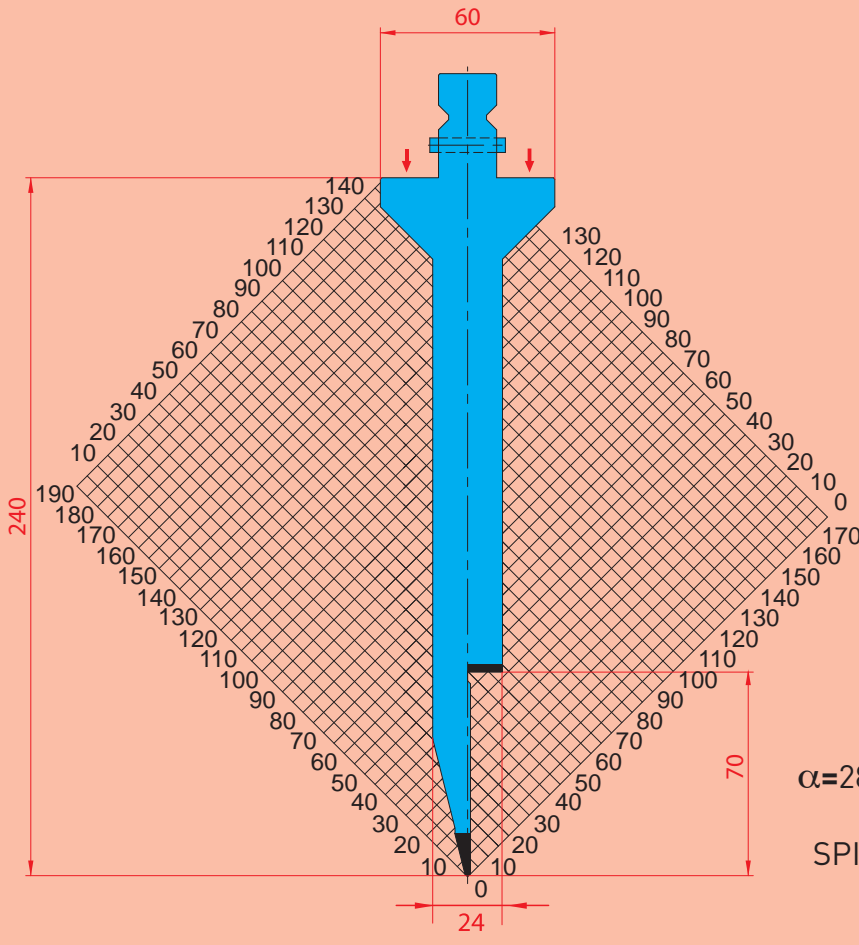
PUNZONI - 60° / PUNCHES - 60°

- C45 bonificato /quenched
- 42CrMo4
- C45

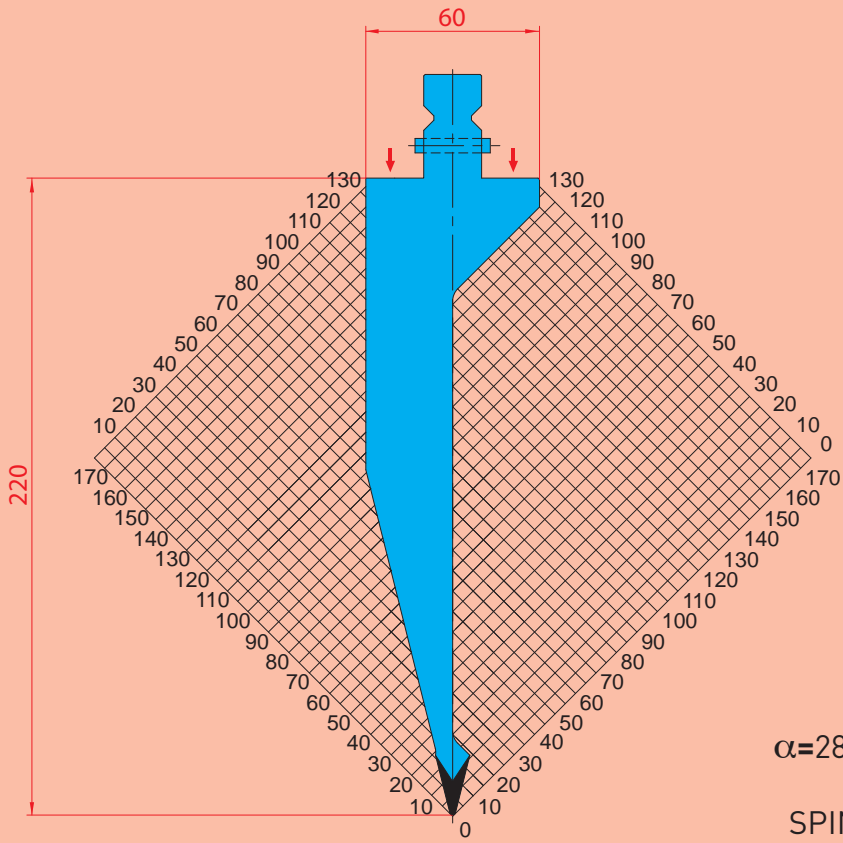


PUNZONI - 28° / PUNCHES - 28°

■	C45 bonificato /quenched
■	42CrMo4
■	C45



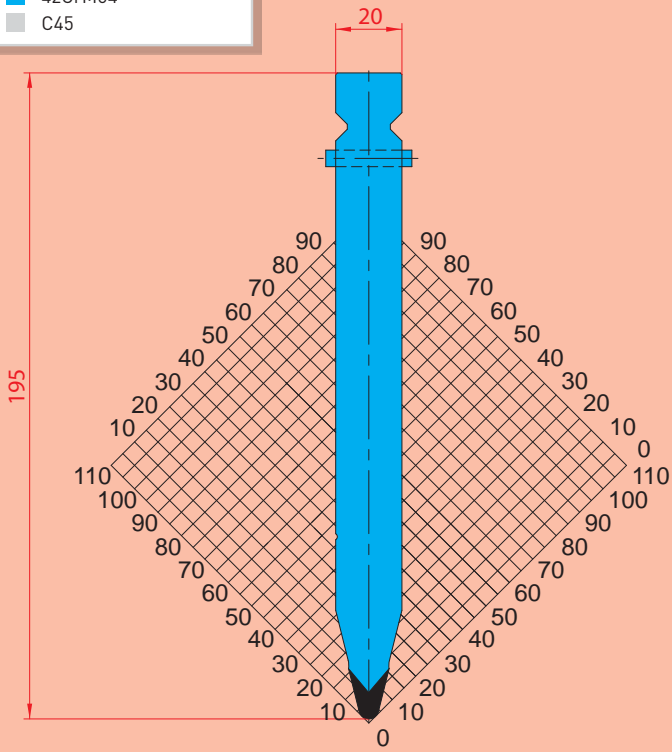
1295
 $\alpha=28^\circ$ R=1 H=240.00
 Max T/m=40
 SPINTA LATERALE (↓)



1302
 $\alpha=28^\circ$ R=1 H=220.00
 Max T/m=80
 SPINTA LATERALE (↓)

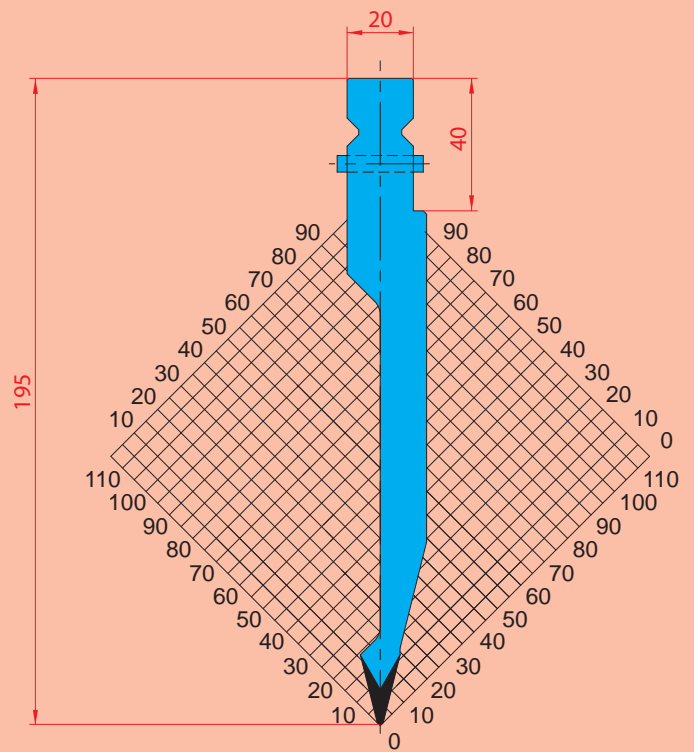
PUNZONI - 28° / PUNCHES - 28°

- C45 bonificato /quenched
- 42CrMo4
- C45



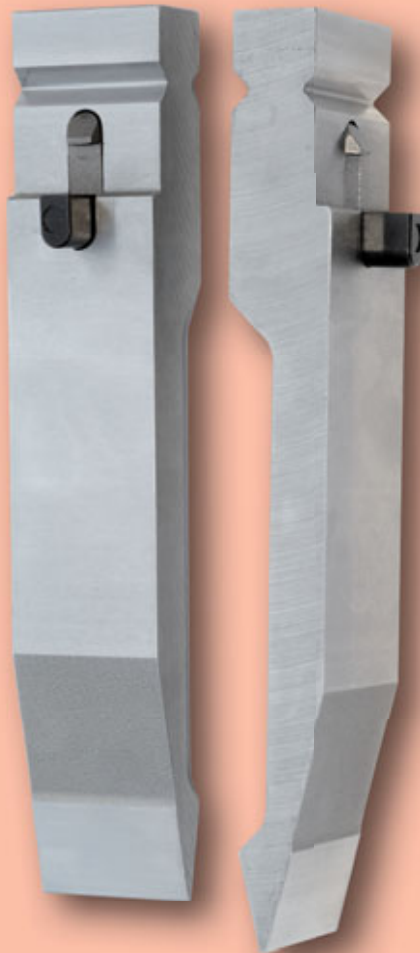
1237

$\alpha=28^\circ$ R=3 H=195.00
Max T/m=100



1238

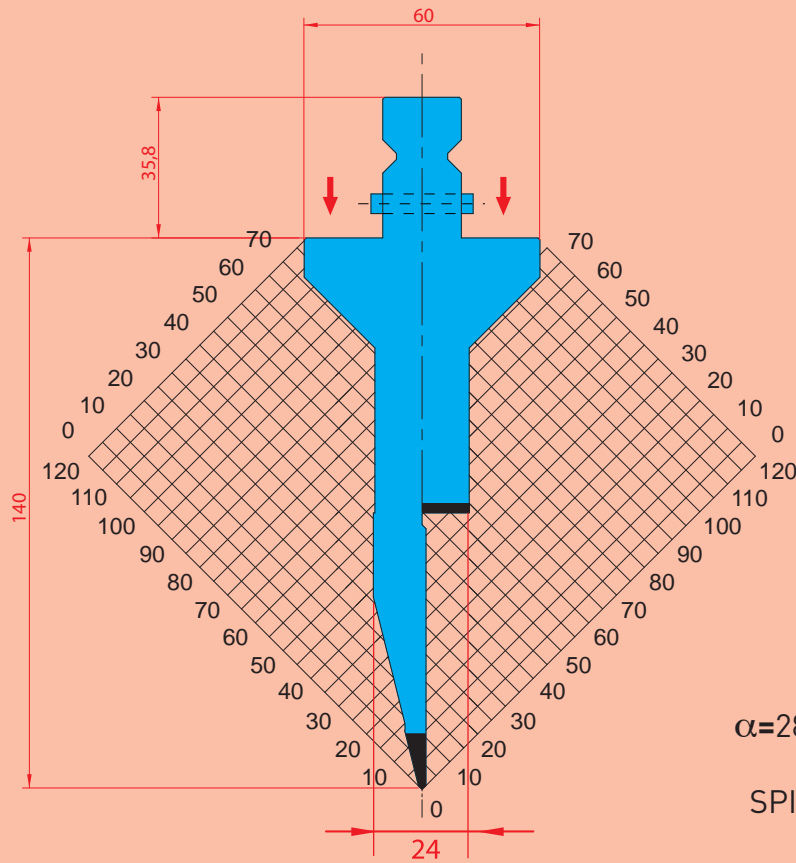
$\alpha=28^\circ$ R=1 H=195.00
Max T/m=80



PUNZONI - 28° / PUNCHES - 28°

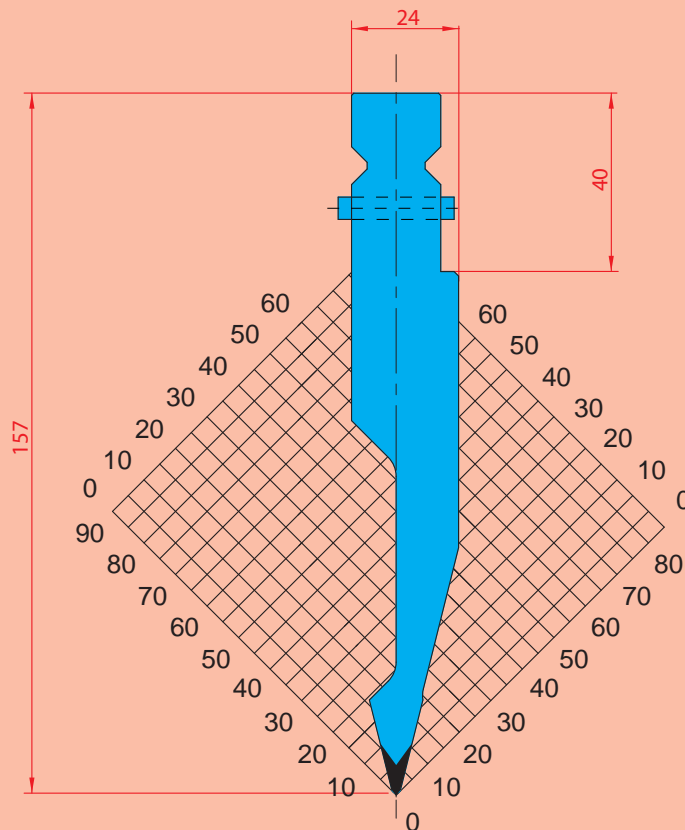
NEW

- C45 bonificato /quenched
- 42CrMo4
- C45



1308

$\alpha=28^\circ$ R=1 H=140.00
Max T/m=40
 SPINTA LATERALE (↓)



1313

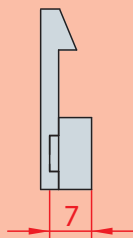
$\alpha=28^\circ$ R=1 H=157.00
Max T/m=80
 SPINTA LATERALE (↓)

PULSANTI / SAFETY PUSH BUTTON

- C45 bonificato /quenched
- 42CrMo4
- C45

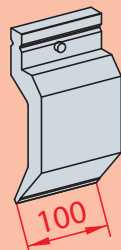
8210

FRESATURA PULSANTE
MILLING FOR SAFETY
PUSH BUTTON



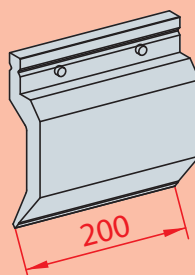
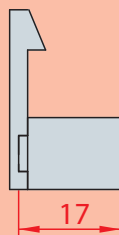
8211

codici / code
-1237 -1240



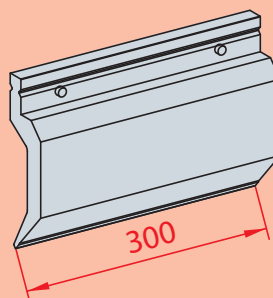
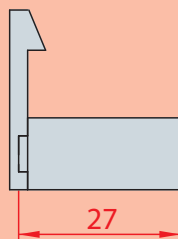
8212

codici / code
-1234 -1235
-1238 -1249
-1250 -1251
-1213



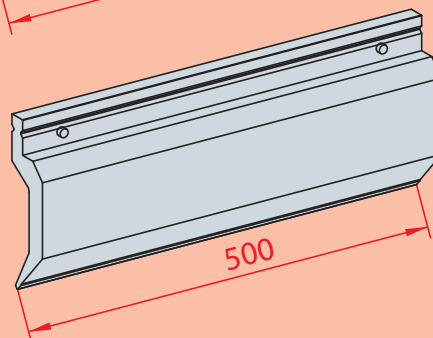
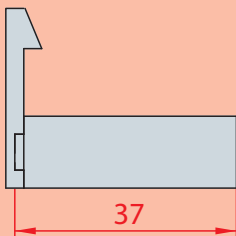
8213

codici / code
-1295-1302
-1303-1308



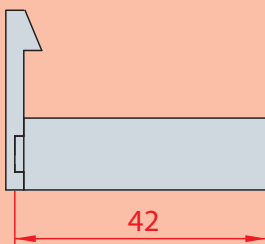
8214

codici / code
- 1233-1314



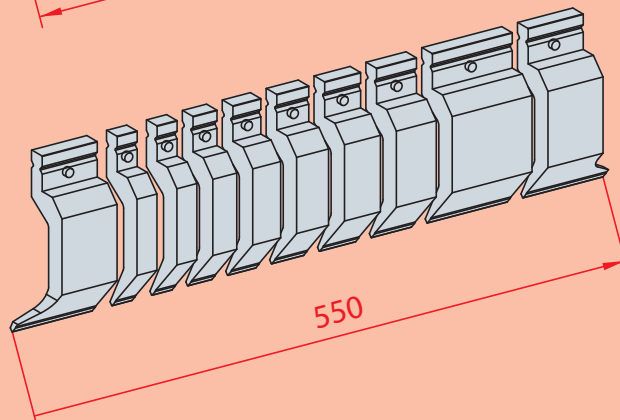
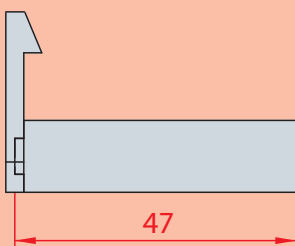
8215

codici / code
- 1236



8216

codici / code
- 1294



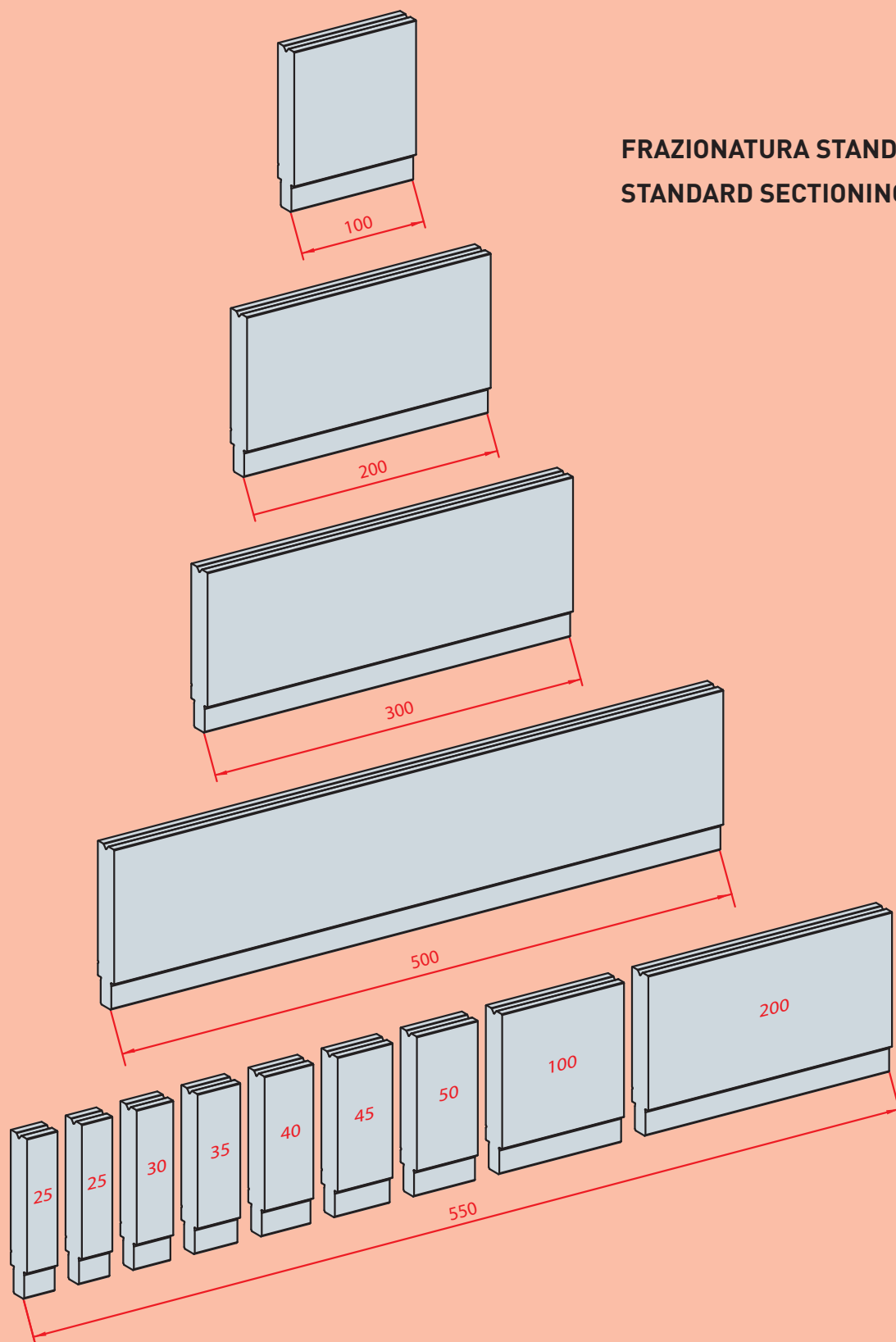
PULSANTI / SAFETY PUSH BUTTON



MATRICI / DIES

- C45 bonificato /quenched
- 42CrMo4
- C45

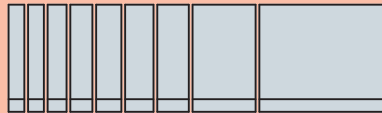
FRAZIONATURA STANDARD/
STANDARD SECTIONING



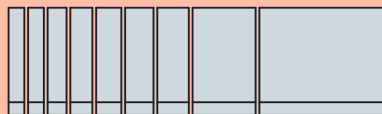
MATRICI / DIES

■ C45 bonificato /quenched
■ 42CrMo4
■ C45

**PER MATRICI / FOR DIES:
3135 - 3222 - 3223 - 3224**



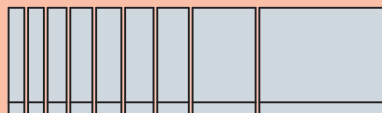
550



1
X
100

2
X
200

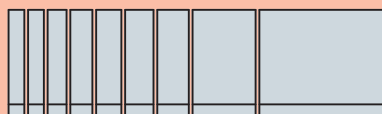
1050



3
X
100

2
X
200

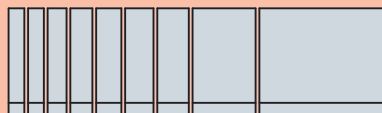
1250



5
X
100

5
X
200

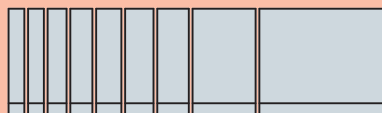
2050



6
X
100

7
X
200

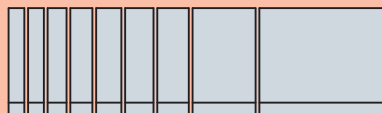
2550



7
X
100

9
X
200

3050



9
X
100

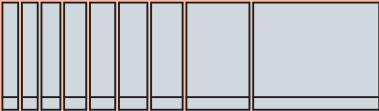
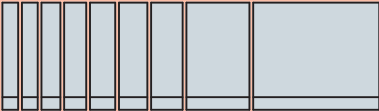
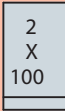
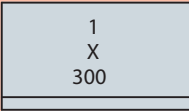
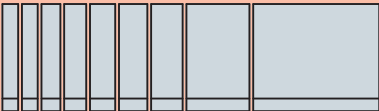
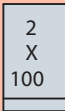
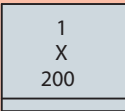
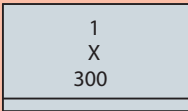
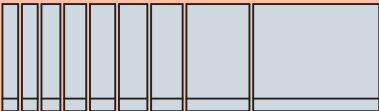
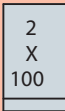
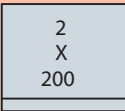
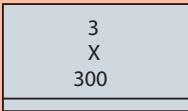
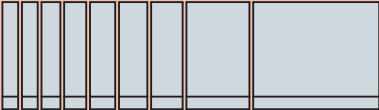
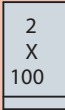
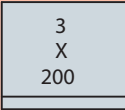
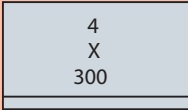
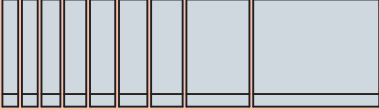
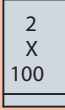
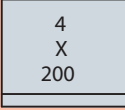
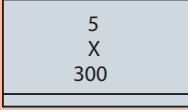
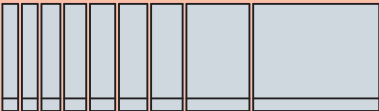
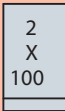
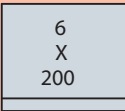
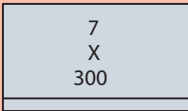
13
X
200

4050

MATRICI / DIES

- C45 bonificato /quenched
- 42CrMo4
- C45

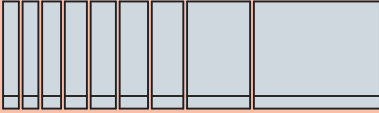
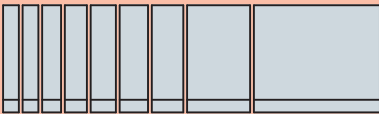
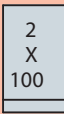
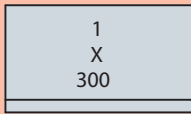
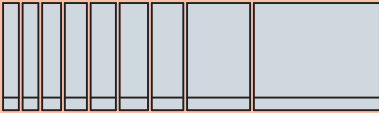
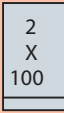
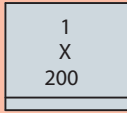
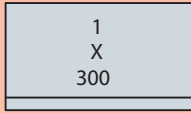
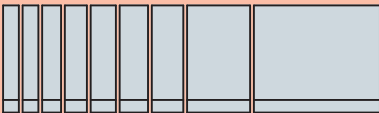
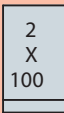
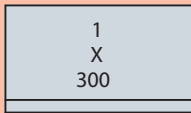
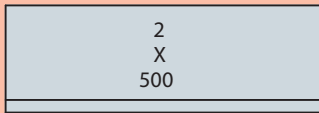
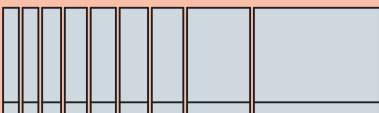
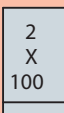
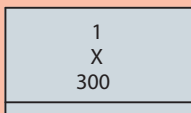
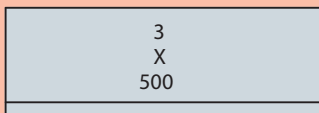
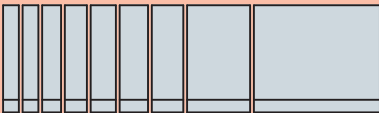
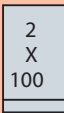
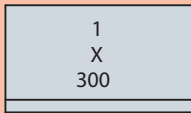
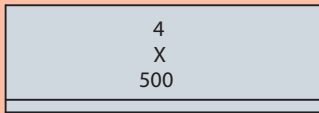
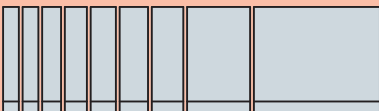
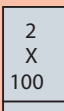
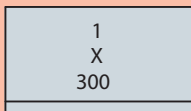
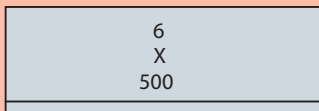
PER MATRICI / FOR DIES: 3218 - 3219 - 3220 - 3221 - 3132 - 3133 - 3134

				550
				1050
				1250
				2050
				2550
				3050
				4050

MATRICI / DIES

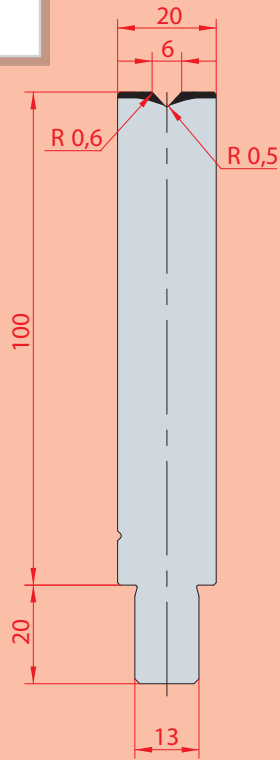
- C45 bonificato /quenched
- 42CrMo4
- C45

**PER TUTTI GLI ALTRI TIPI DI MATRICI
FOR ALL OTHERS TYPE OF DIES**

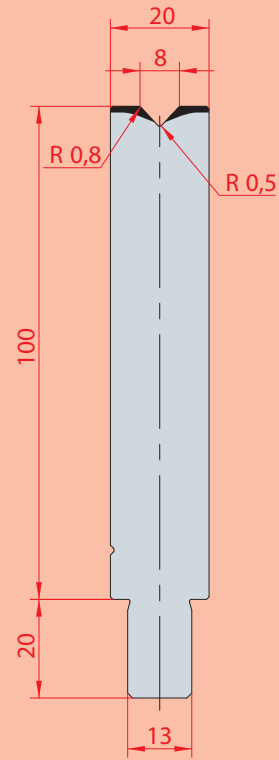
					550
					1050
					1250
					2050
					2550
					3050
					4050

MATRICI 1V H100 - 86° / SINGLE V DIES H100 - 86°

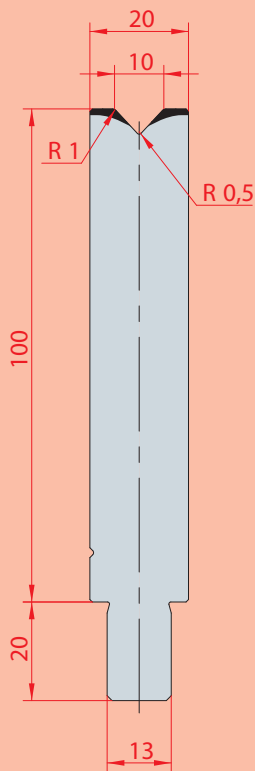
- C45 bonificato /quenched
- 42CrMo4
- C45



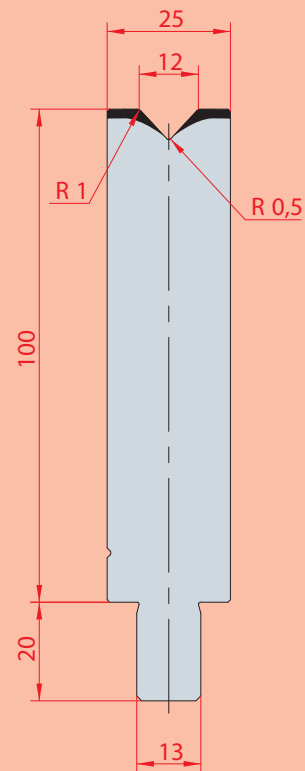
3123
Max T/m=100



3124
Max T/m=100



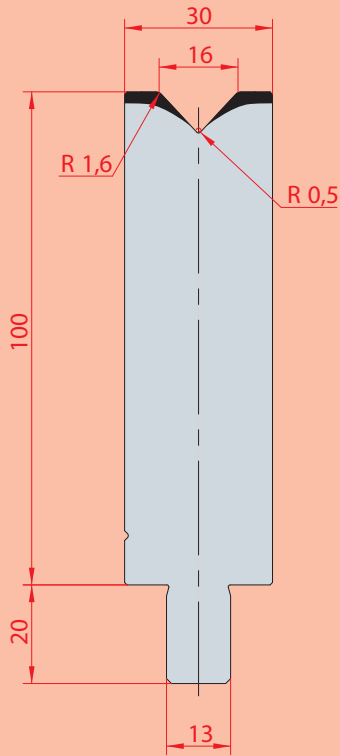
3125
Max T/m=100



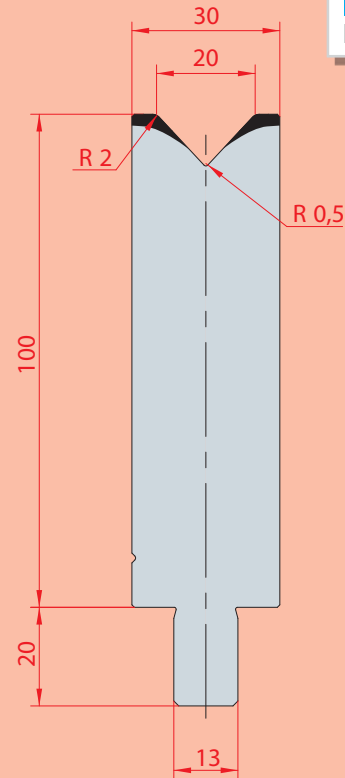
3126
Max T/m=100

MATRICI 1V H100 - 86° / SINGLE V DIES H100 - 86°

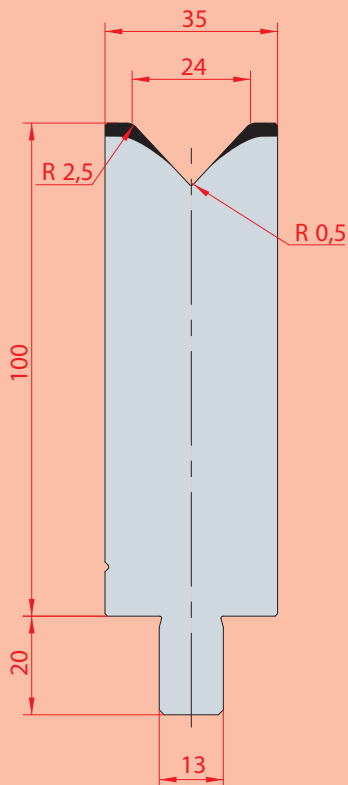
- C45 bonificato /quenched
- 42CrMo4
- C45



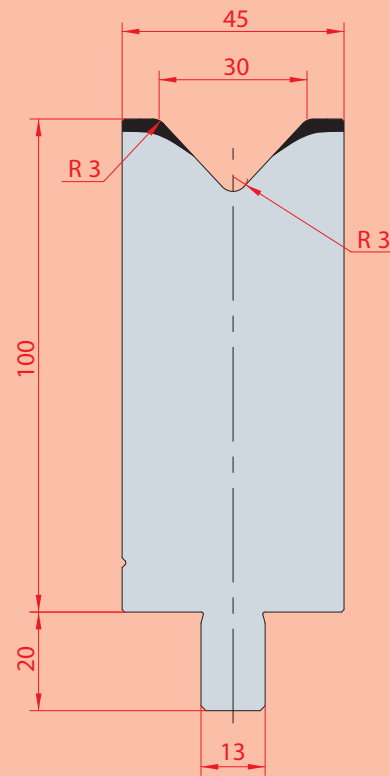
3127
Max T/m=100



3128
Max T/m=100



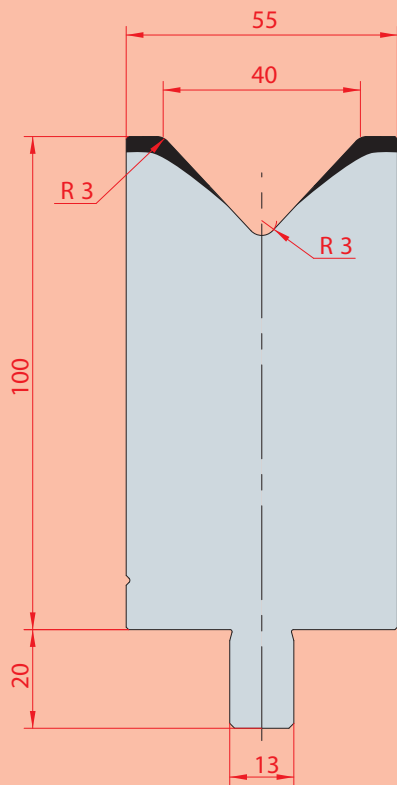
3129
Max T/m=100



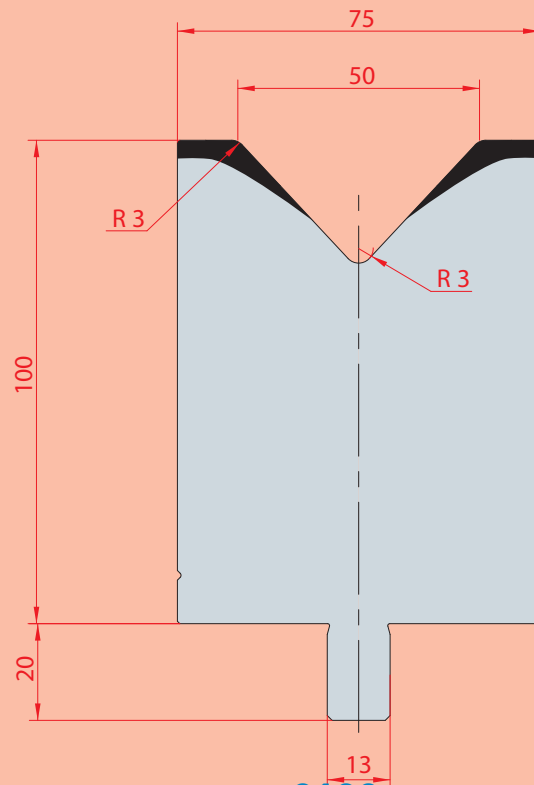
3130
Max T/m=100

MATRICI 1V H100 - 86° / SINGLE V DIES H100 - 86°

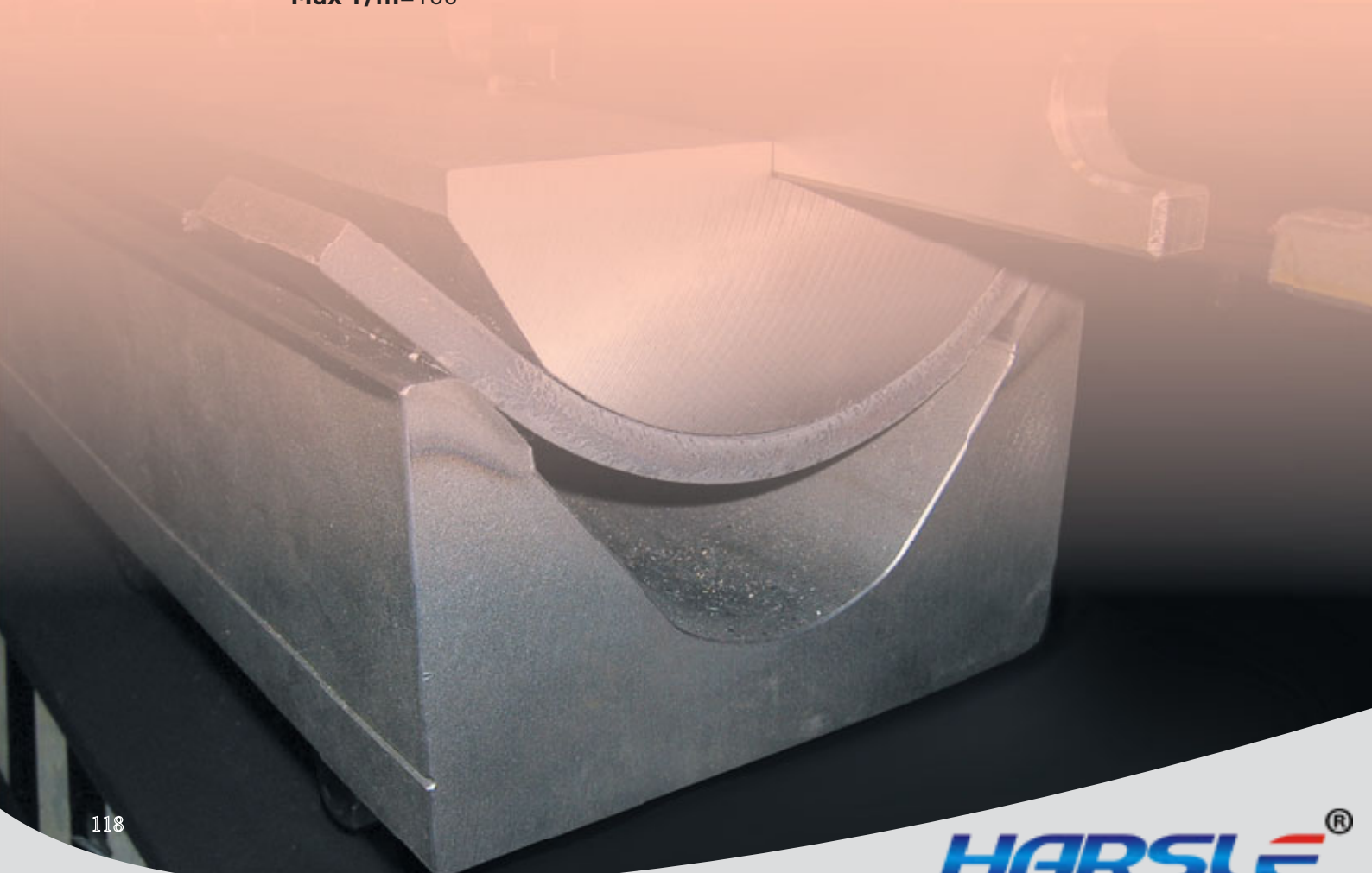
- C45 bonificato /quenched
- 42CrMo4
- C45



3131
Max T/m=100

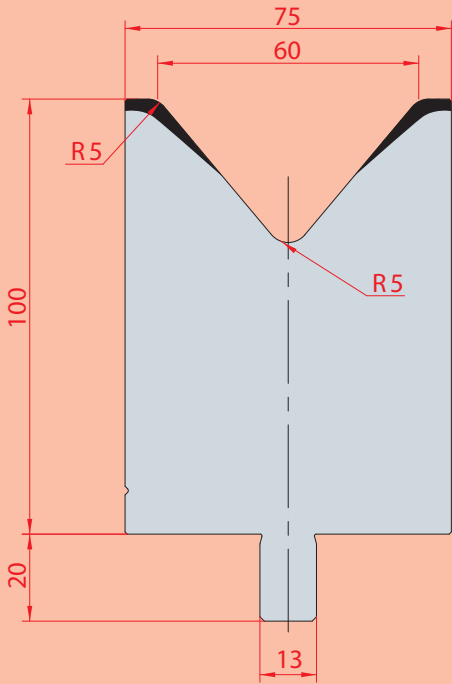


3132
Max T/m=100

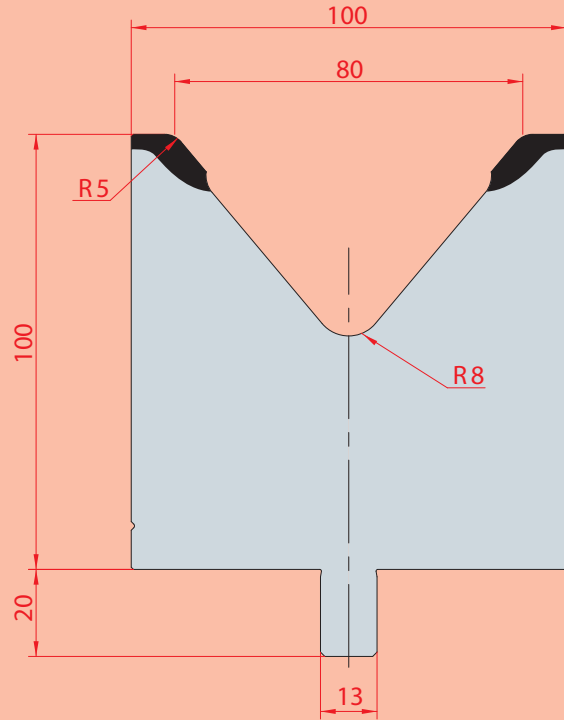


MATRICI 1V H100 - 80° / SINGLE V DIE H100 - 80°

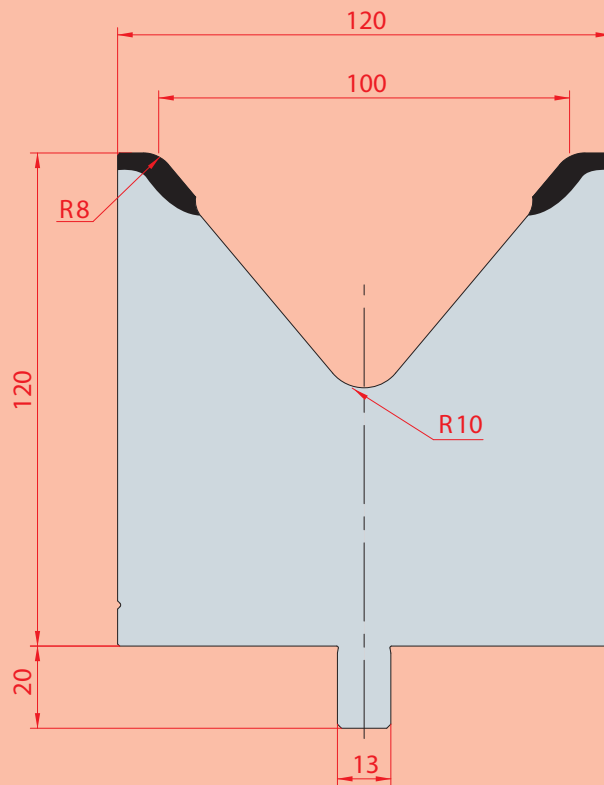
- C45 bonificato /quenched
- 42CrMo4
- C45



3133
Max T/m=100



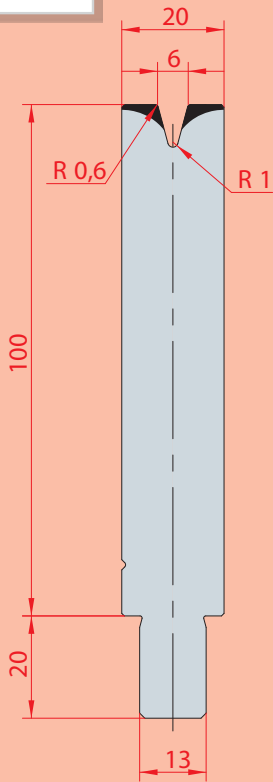
3134
Max T/m=100



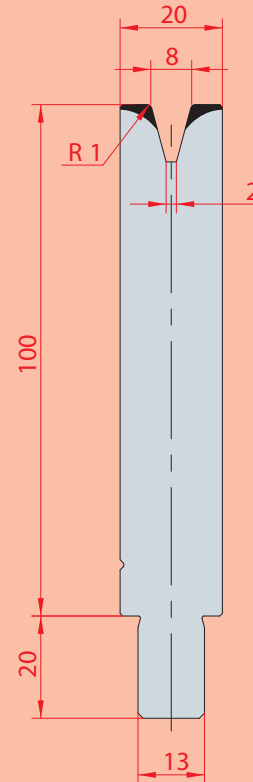
3135
Max T/m=100

MATRICI 1V H100 - 30° / SINGLE V DIE H100 - 30°

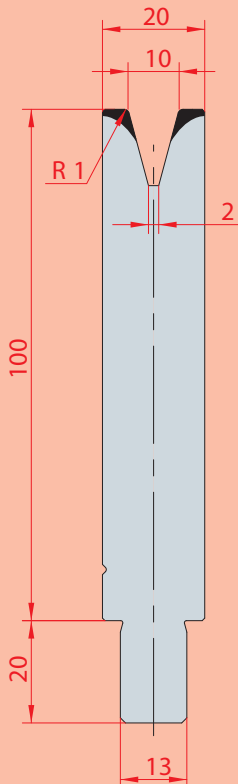
- C45 bonificato /quenched
- 42CrMo4
- C45



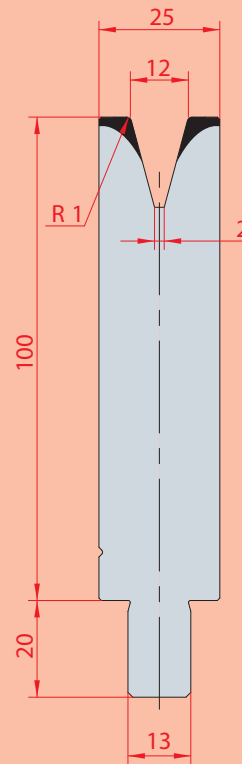
3136
Max T/m=50



3137
Max T/m=40



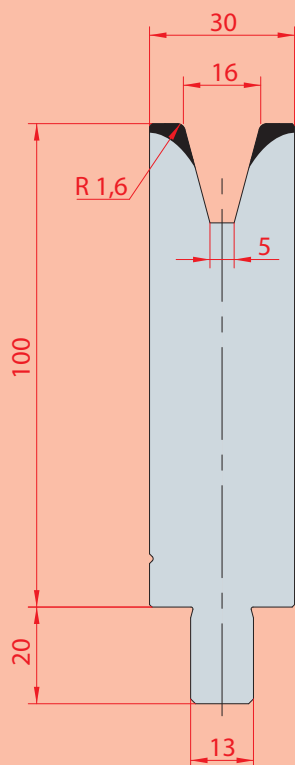
3138
Max T/m=40



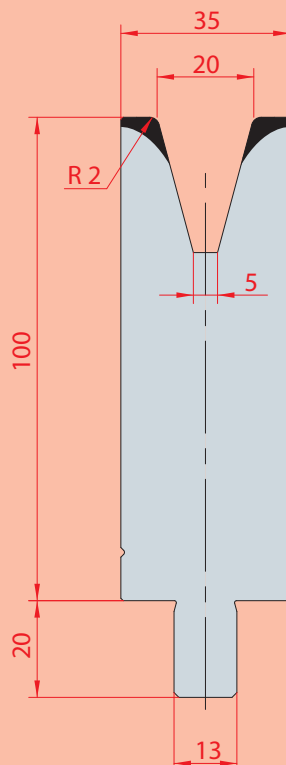
3139
Max T/m=50

MATRICI 1V H100 - 30° / SINGLE V DIE H100 - 30°

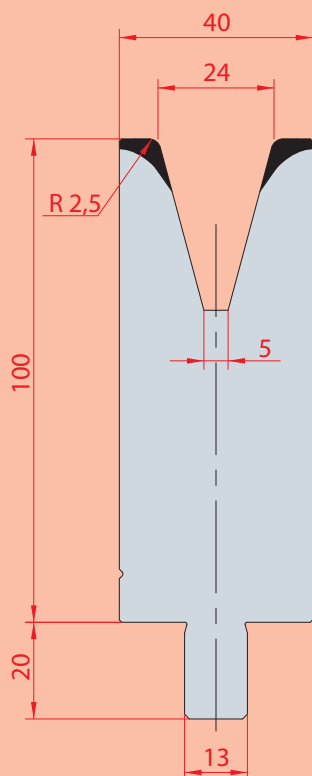
- C45 bonificato /quenched
- 42CrMo4
- C45



3140
Max T/m=45



3141
Max T/m=50

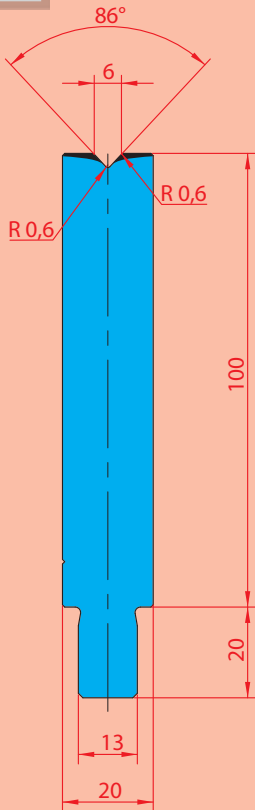


3142
Max T/m=50

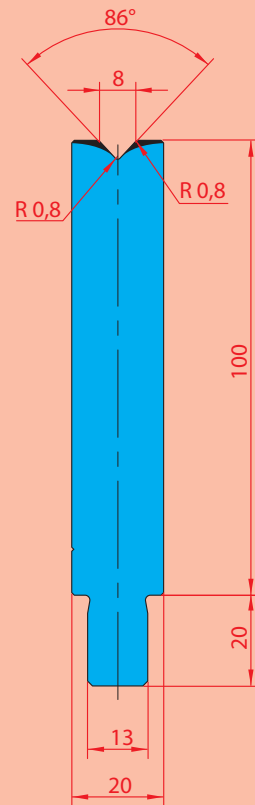
MATRICI 1V H100 - 86° / SINGLE V DIE H100 - 86°

NEW

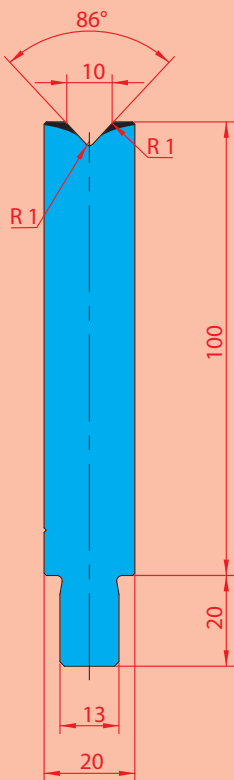
- C45 bonificato /quenched
- 42CrMo4
- C45



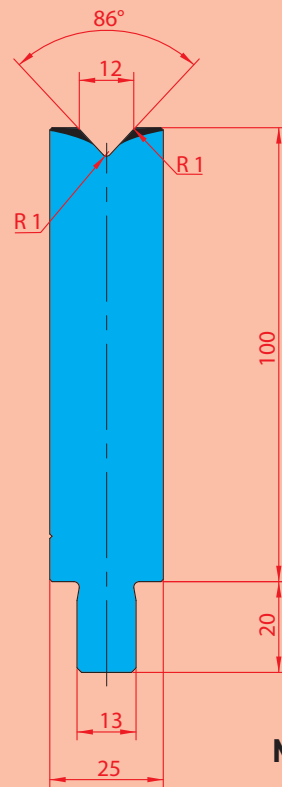
3200
Max T/m=100



3201
Max T/m=100



3202
Max T/m=100

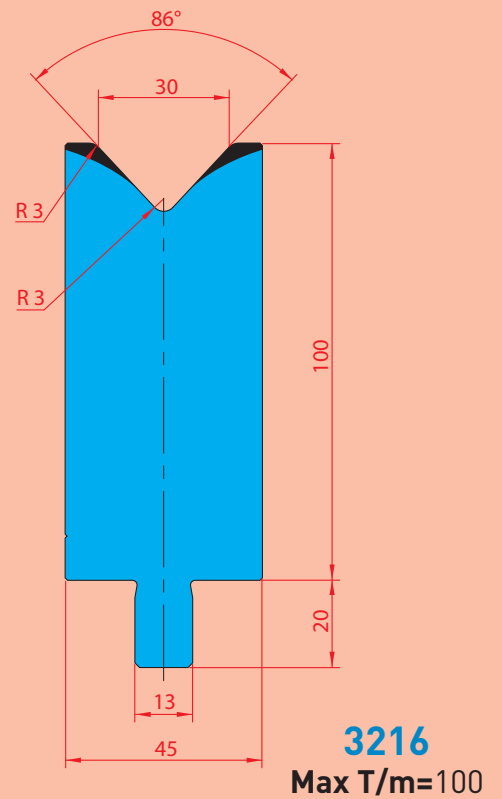
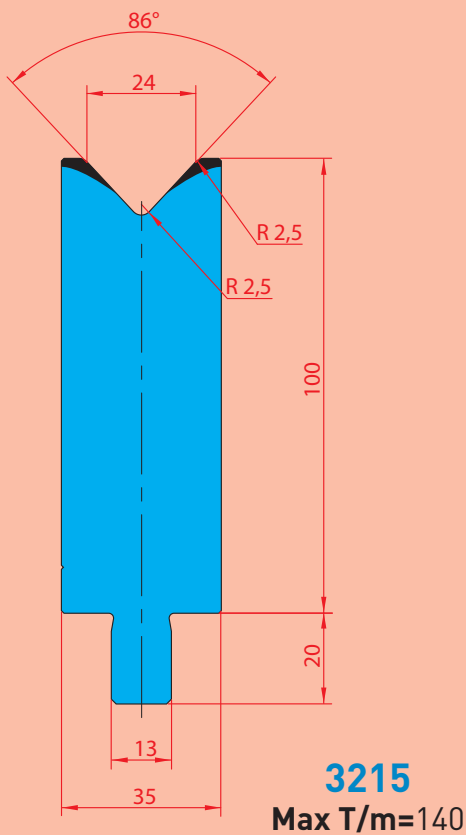
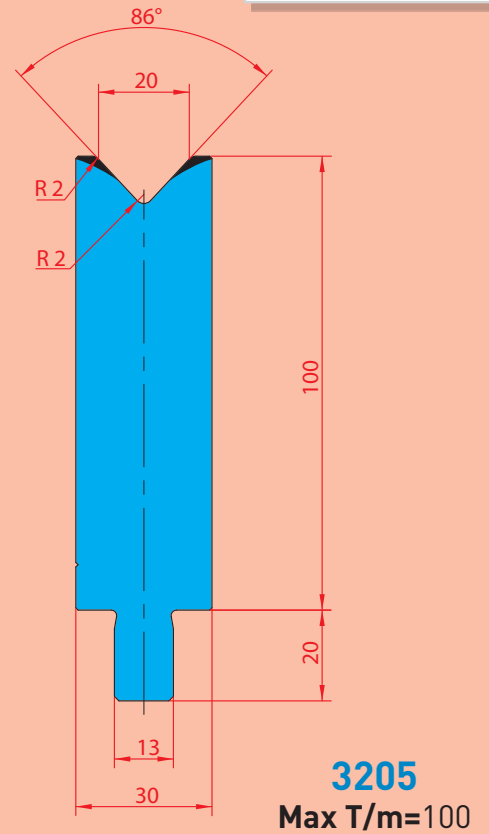
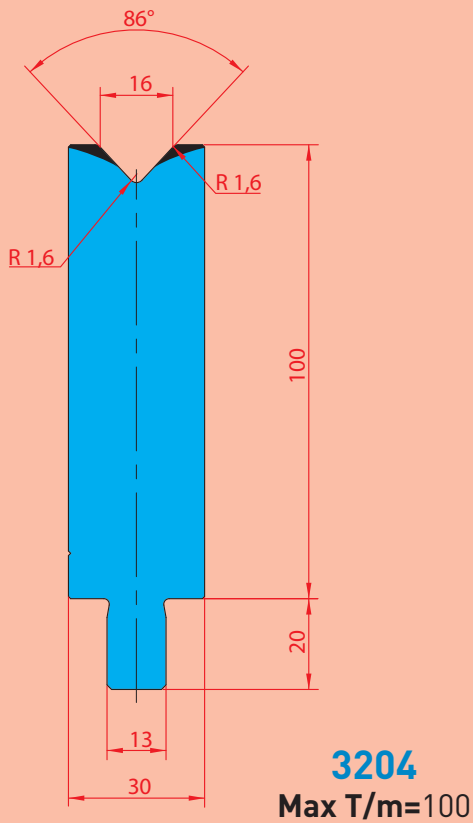


3203
Max T/m=100

MATRICI 1V H100 - 86° / SINGLE V DIE H100 - 86°

NEW

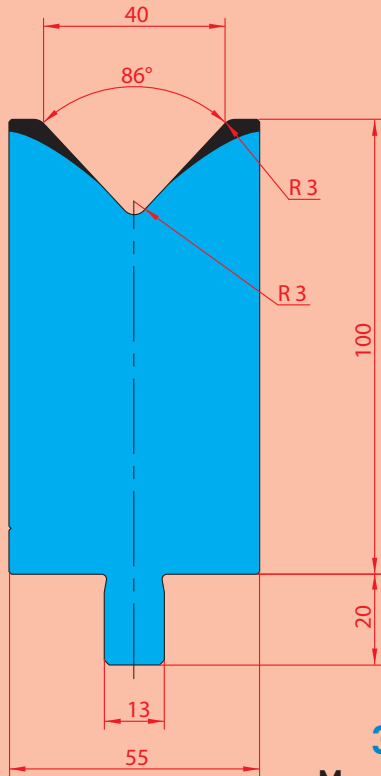
- C45 bonificato /quenched
- 42CrMo4
- C45



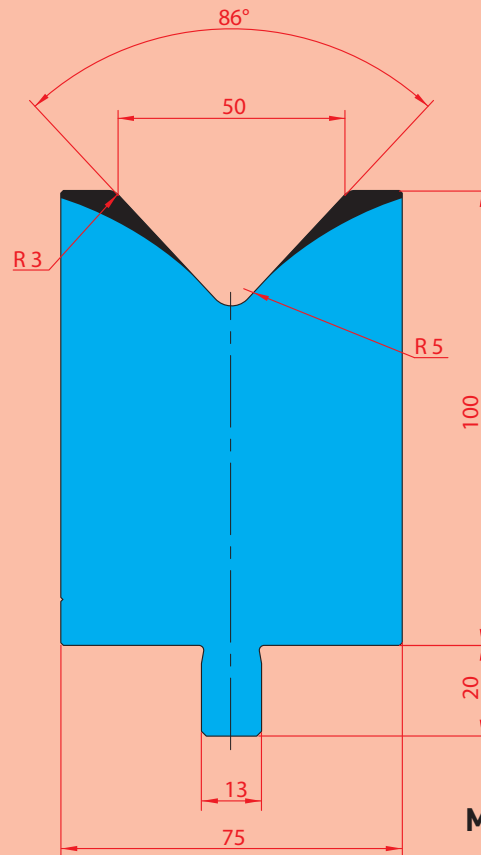
MATRICI 1V H100 - 86° / SINGLE V DIE H100 - 86°

- C45 bonificato /quenched
- 42CrMo4
- C45

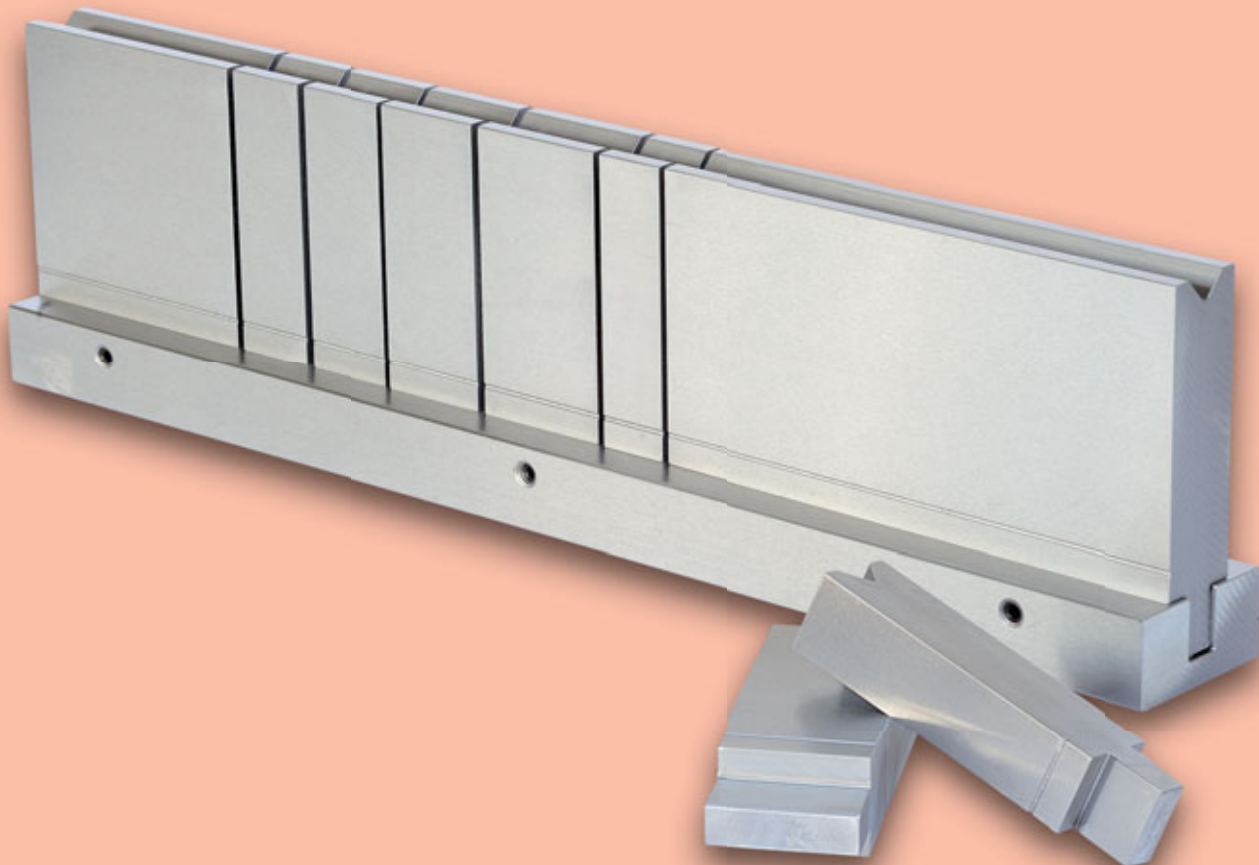
NEW



3217
Max T/m=120



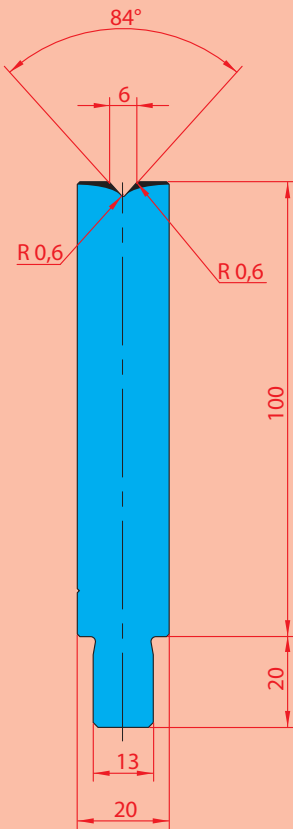
3218
Max T/m=150



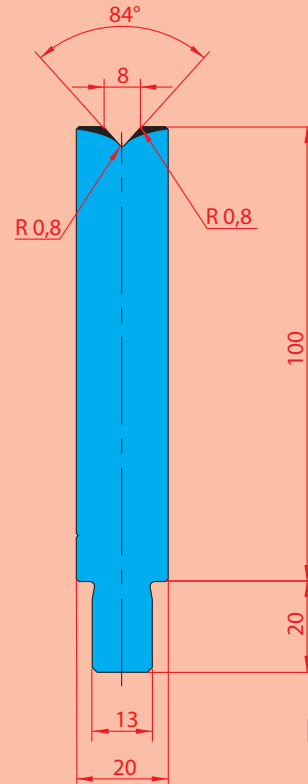
MATRICI 1V H100 - 84° / SINGLE V DIE H100 - 84°

NEW

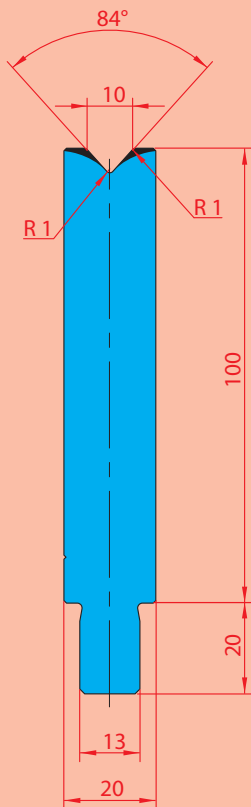
- C45 bonificato /quenched
- 42CrMo4
- C45



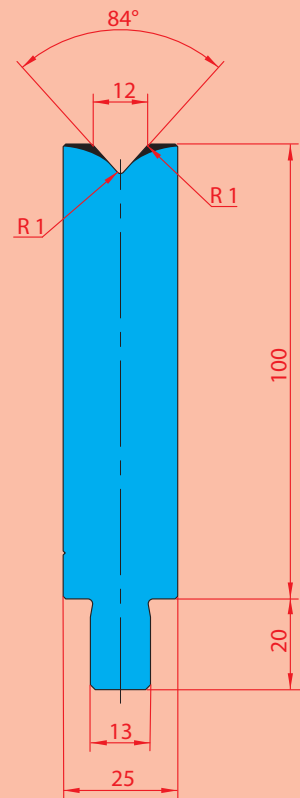
3225
Max T/m=130



3226
Max T/m=100



3227
Max T/m=100

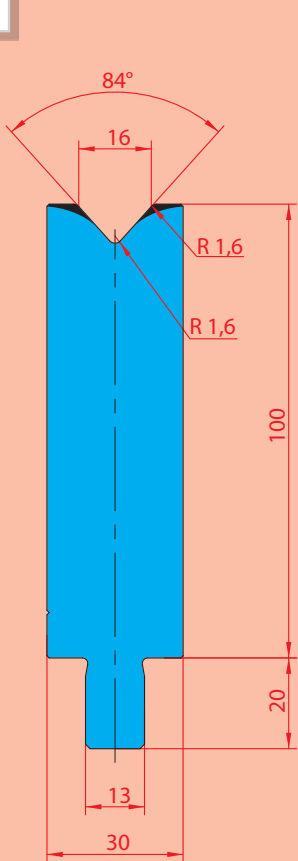


3228
Max T/m=100

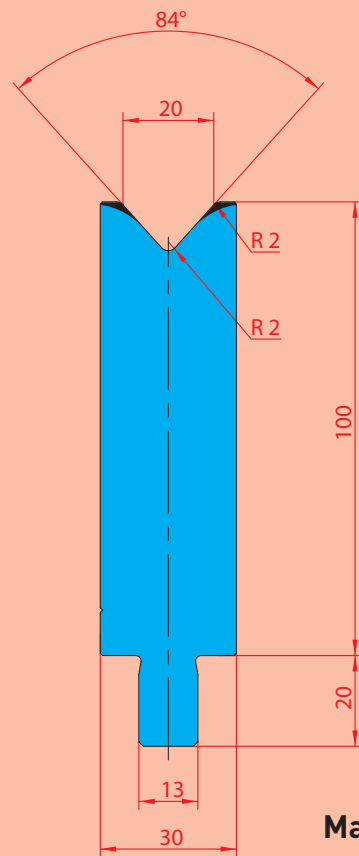
MATRICI 1V H100 - 84° / SINGLE V DIE H100 - 84°

- C45 bonificato /quenched
- 42CrMo4
- C45

NEW

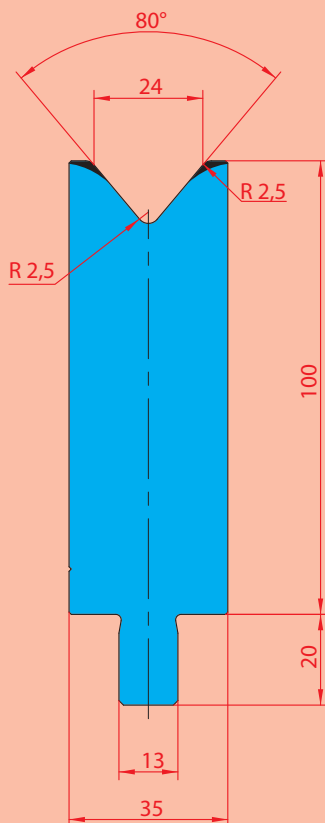


3229
Max T/m=100

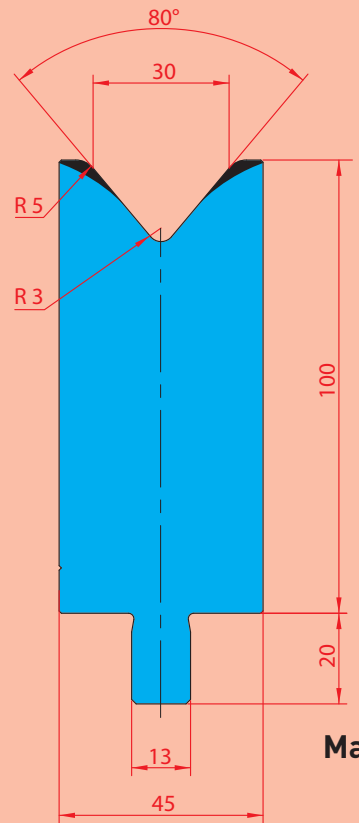


3230
Max T/m=100

MATRICI 1V H100 - 80° / SINGLE V DIE H100 - 80°



3231
Max T/m=120

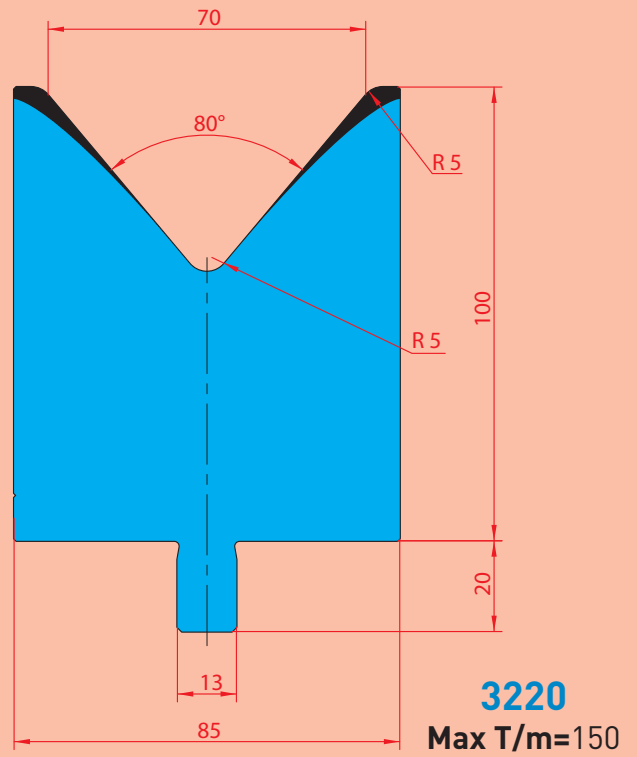
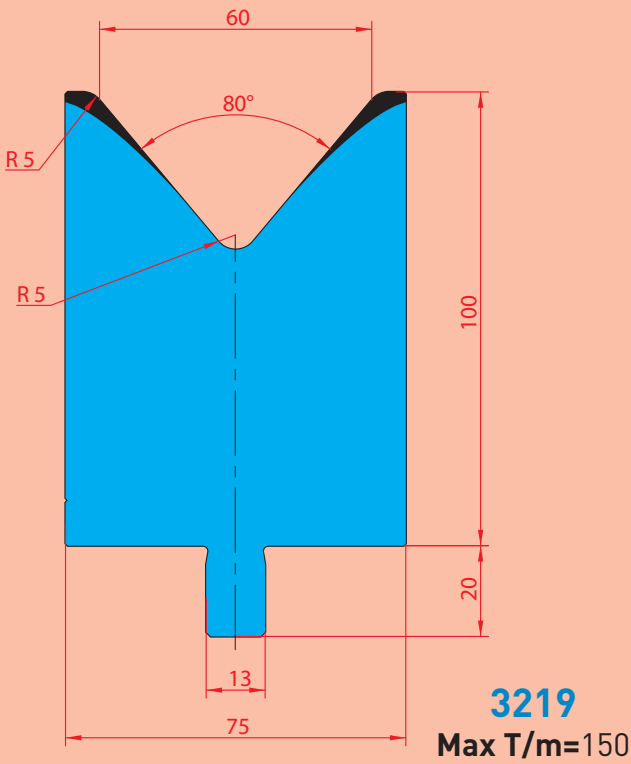
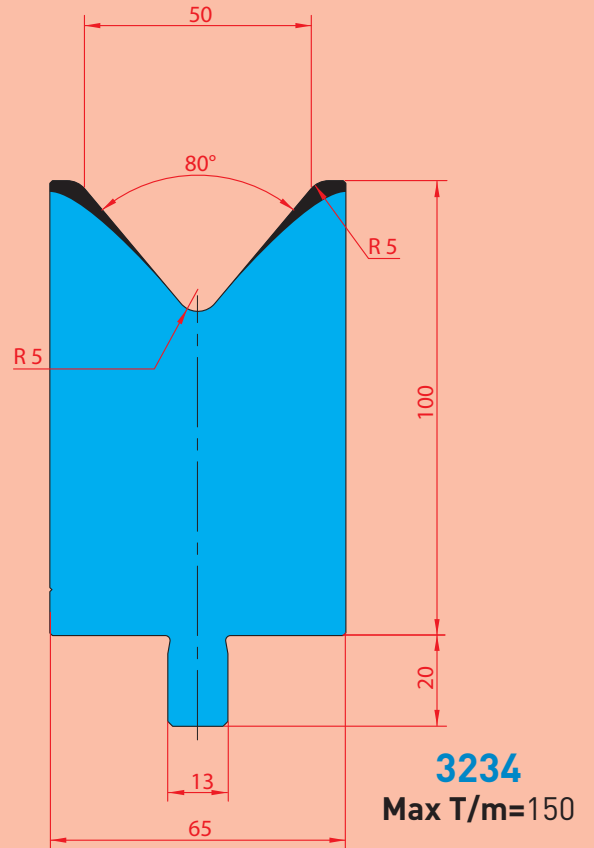
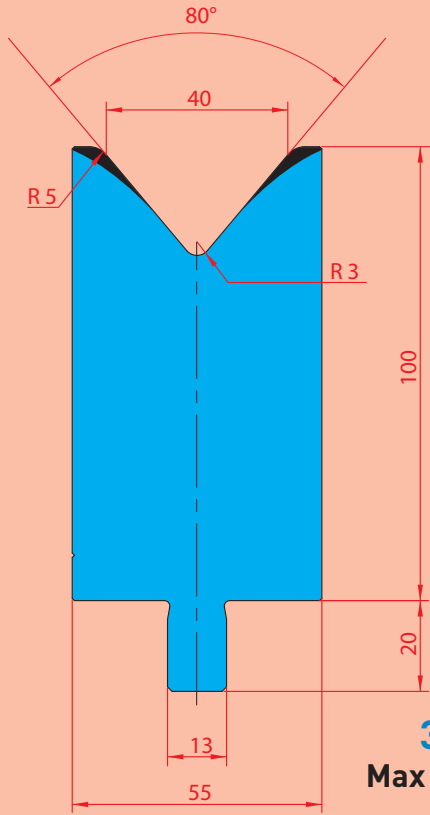


3232
Max T/m=120

MATRICI 1V H100 - 80° / SINGLE V DIE H100 - 80°

NEW

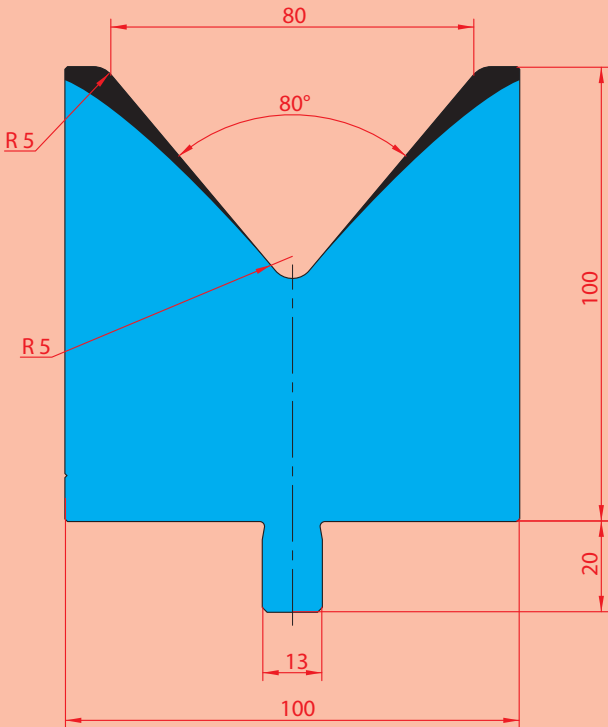
- C45 bonificato /quenched
- 42CrMo4
- C45



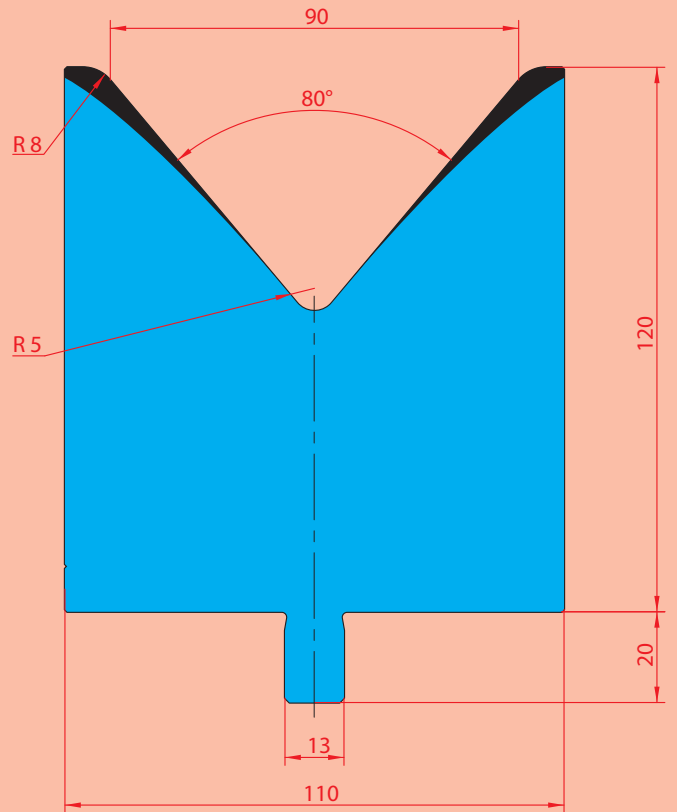
MATRICI 1V H100/120 - 80° / SINGLE V DIE H100/120 - 80°

NEW

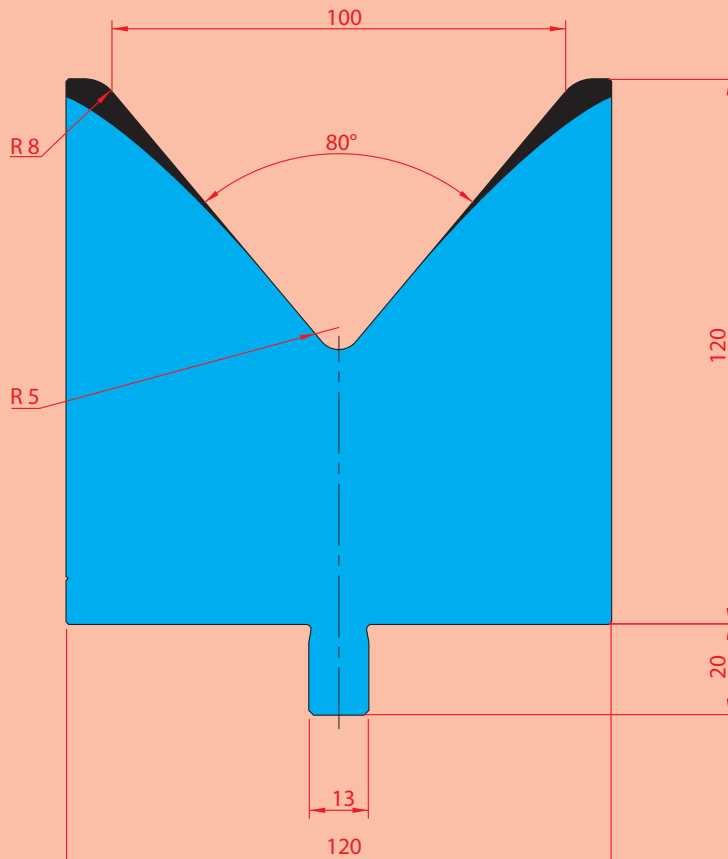
- C45 bonificato /quenched
- 42CrMo4
- C45



3221
Max T/m=150



3222
Max T/m=150

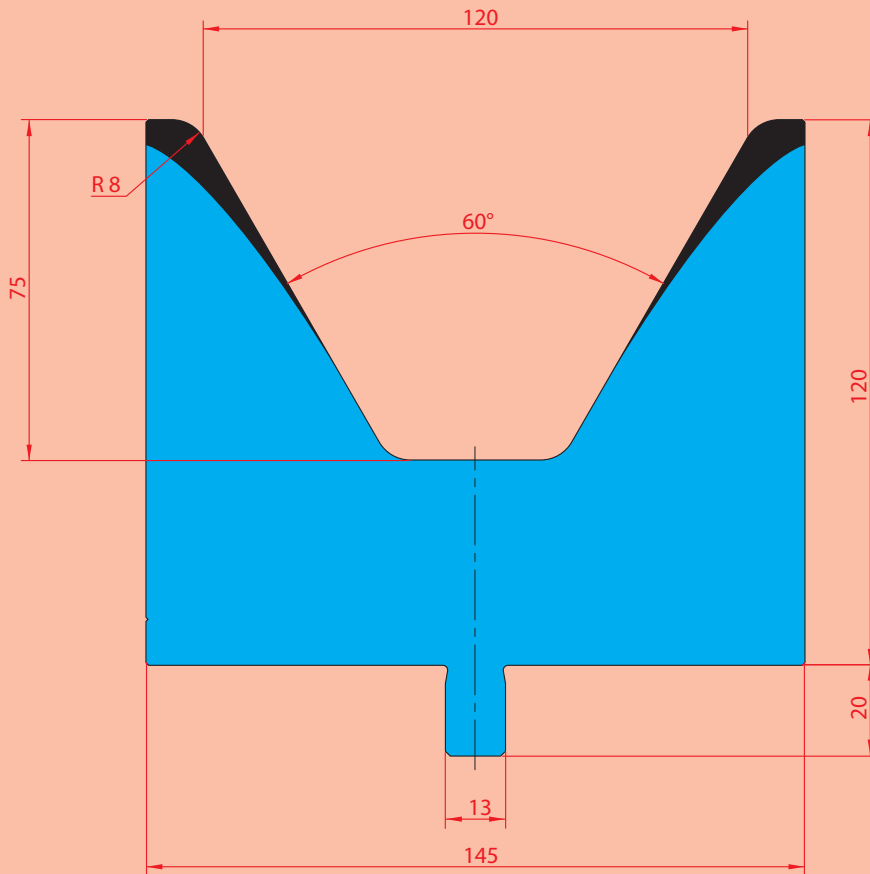


3223
Max T/m=150

MATRICI 1V H120 - 60° / SINGLE V DIE H120 - 60°

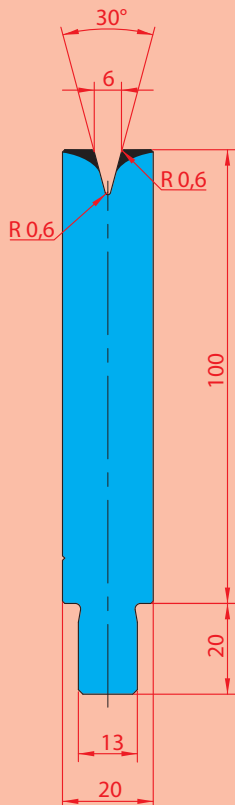
NEW

- C45 bonificato /quenched
- 42CrMo4
- C45

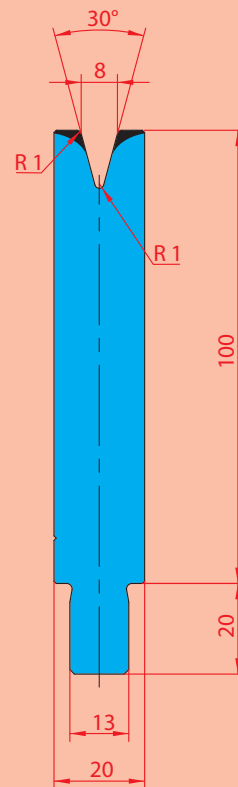


3224
Max T/m=160

MATRICI 1V H100 - 30° / SINGLE V DIE H100 - 30°



3206
Max T/m=60

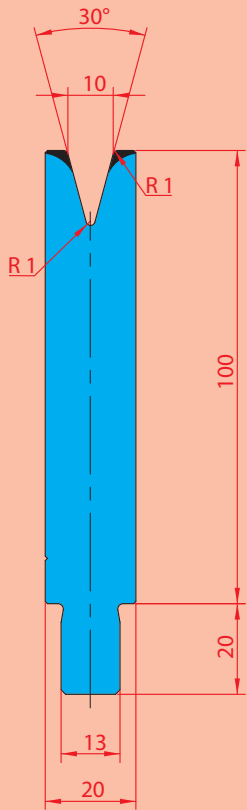


3207
Max T/m=50

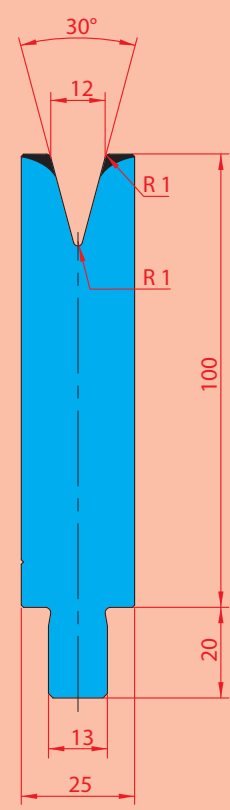
MATRICI 1V H100 - 30° / SINGLE V DIE H100 - 30°

NEW

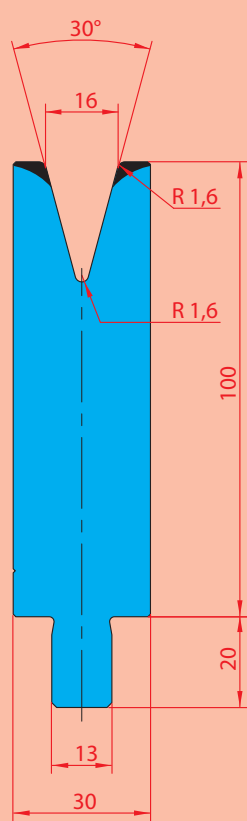
- C45 bonificato /quenched
- 42CrMo4
- C45



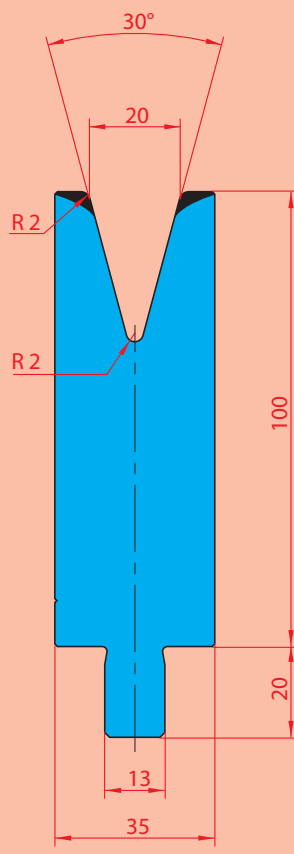
3208
Max T/m=50



3209
Max T/m=56



3210
Max T/m=68

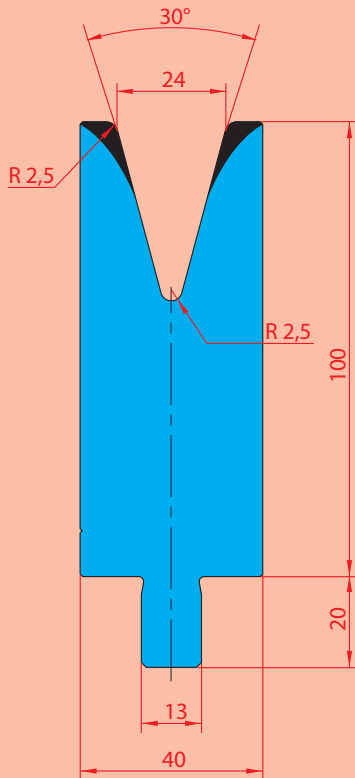


3211
Max T/m=50

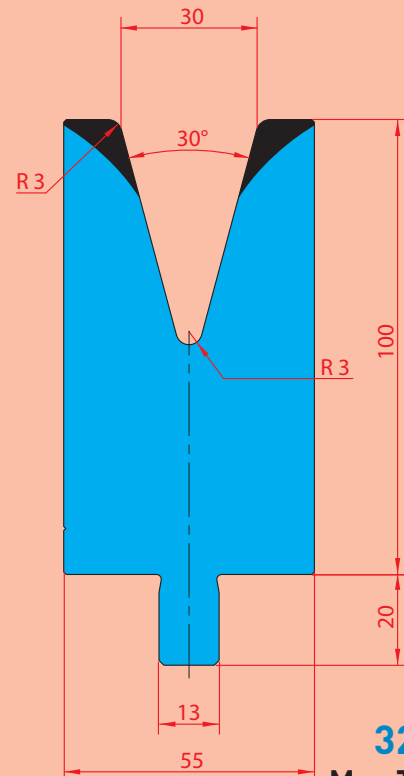
MATRICI 1V H100 - 30° / SINGLE V DIE H100 - 30°

NEW

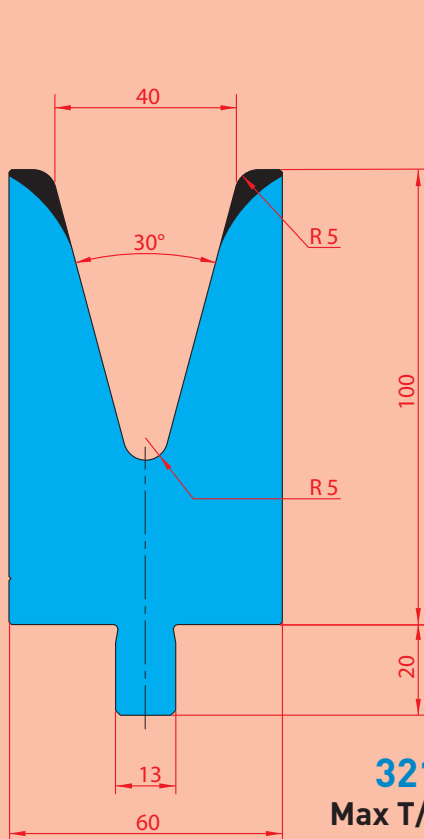
- C45 bonificato /quenched
- 42CrMo4
- C45



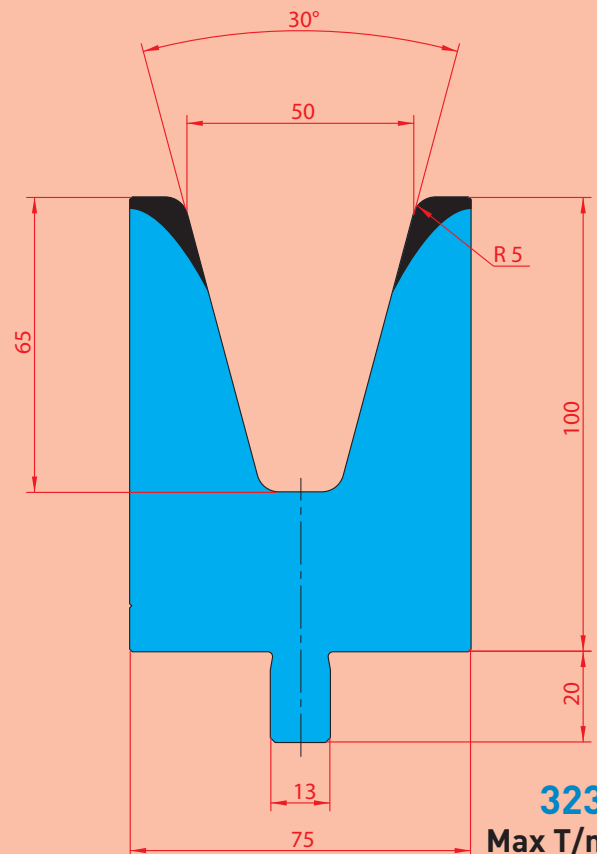
3212
Max T/m=55



3213
Max T/m=85



3214
Max T/m=73

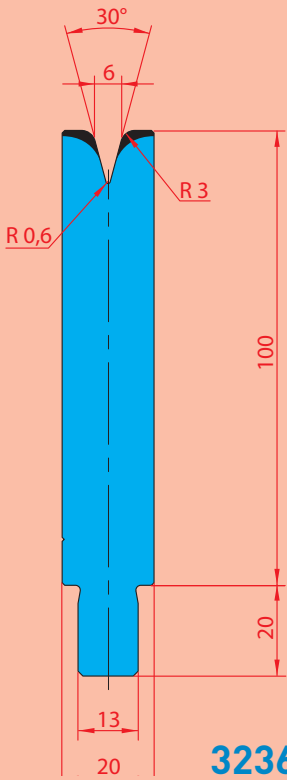


3235
Max T/m=100

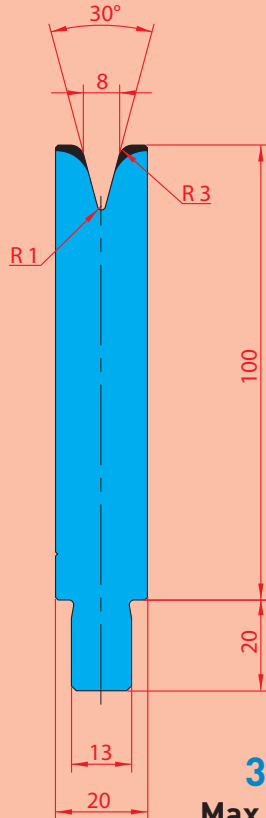
MATRICI 1V H100 - 30° R3 / SINGLE V DIE H100 - 30° R3

NEW

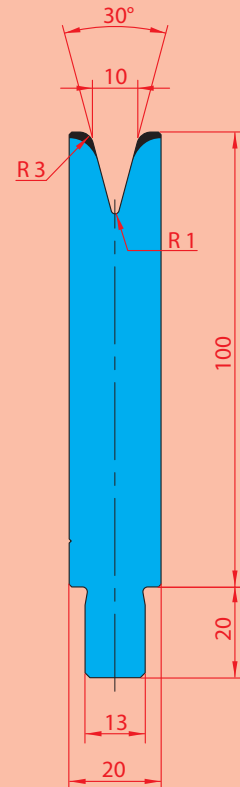
- C45 bonificato /quenched
- 42CrMo4
- C45



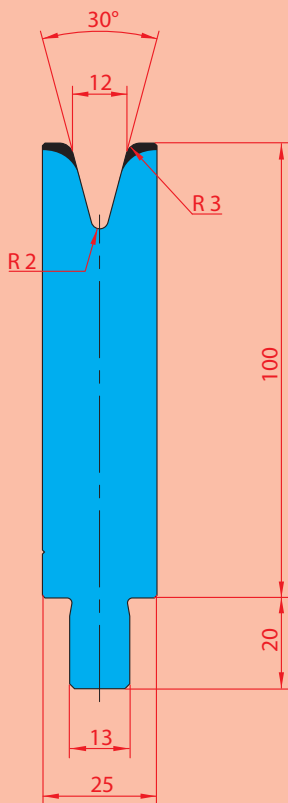
3236
Max T/m=45



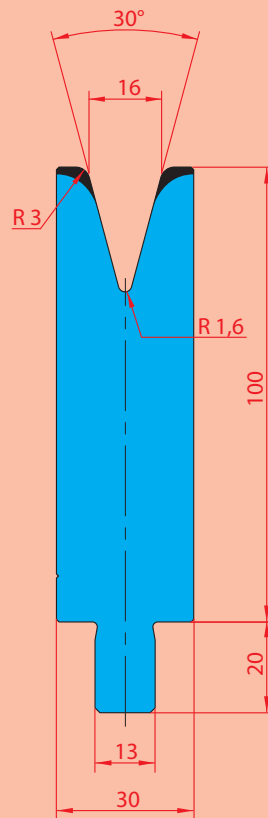
3237
Max T/m=40



3238
Max T/m=30



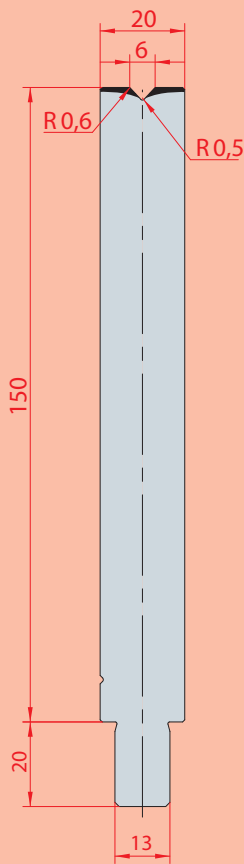
3239
Max T/m=40



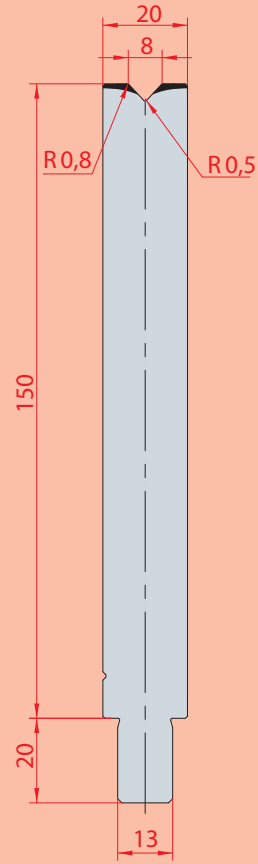
3240
Max T/m=40

MATRICI 1V H150 - 86° / SINGLE V DIE H150 - 86°

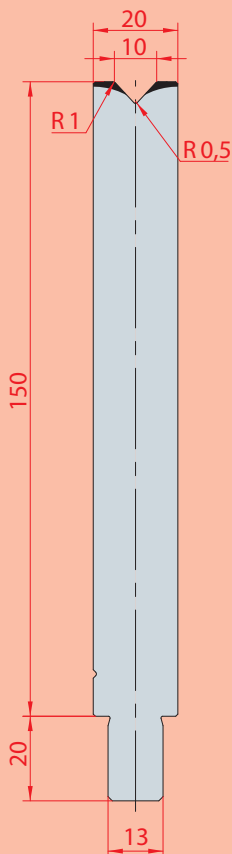
- C45 bonificato /quenched
- 42CrMo4
- C45



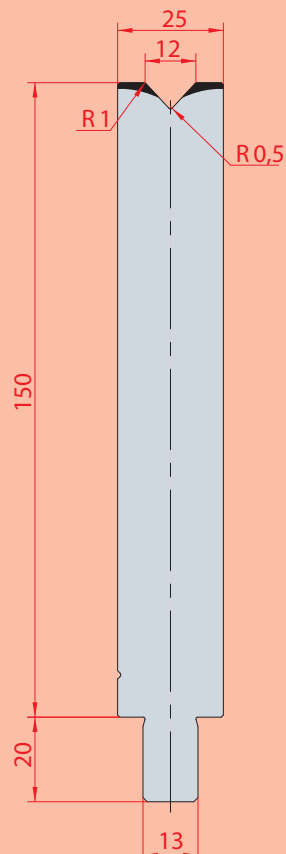
3143
Max T/m=100



3144
Max T/m=100



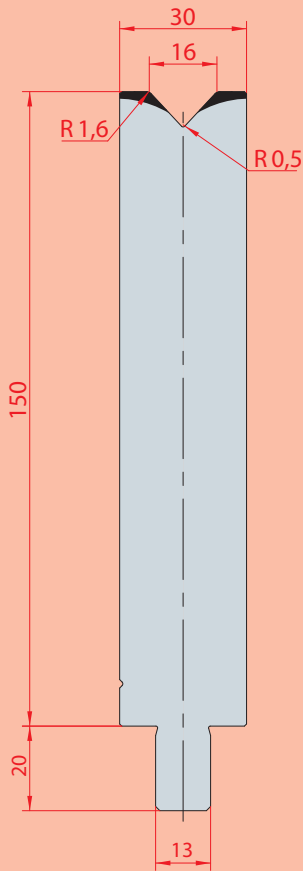
3145
Max T/m=100



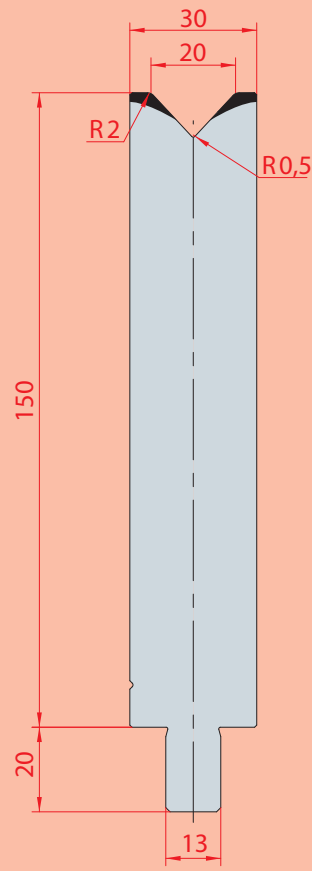
3146
Max T/m=100

MATRICI 1V H150 - 86° / SINGLE V DIE H150 - 86°

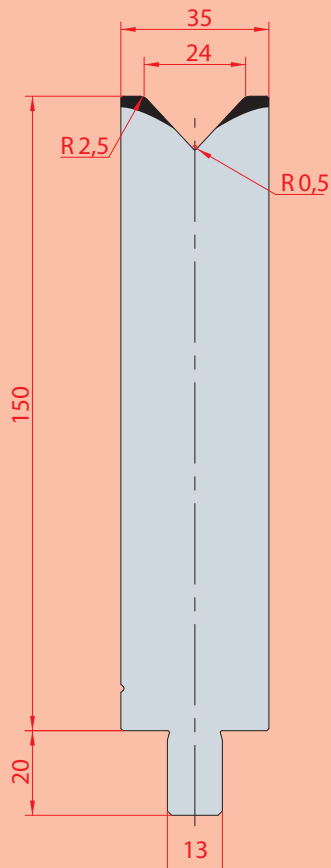
- C45 bonificato /quenched
- 42CrMo4
- C45



3147
Max T/m=100



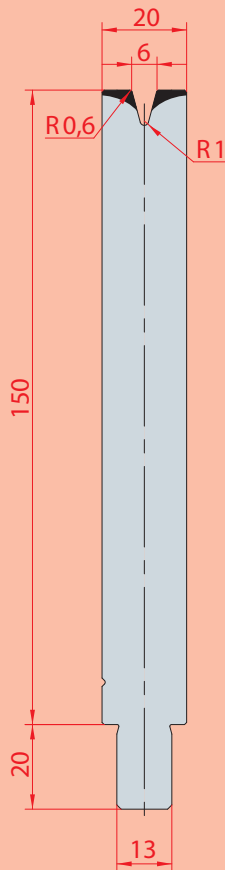
3148
Max T/m=100



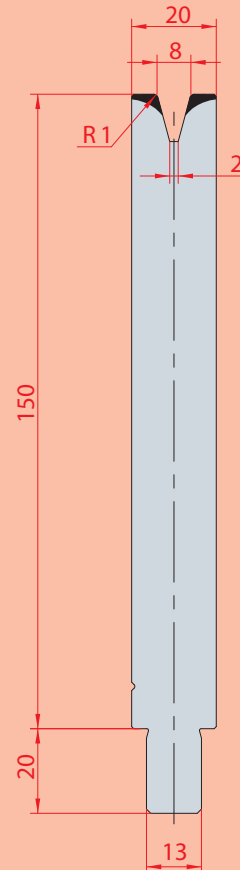
3149
Max T/m=100

MATRICI 1V H150 - 30° / SINGLE V DIE H150 - 30°

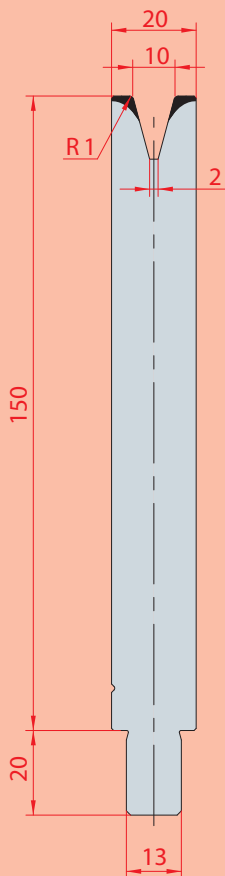
- C45 bonificato /quenched
- 42CrMo4
- C45



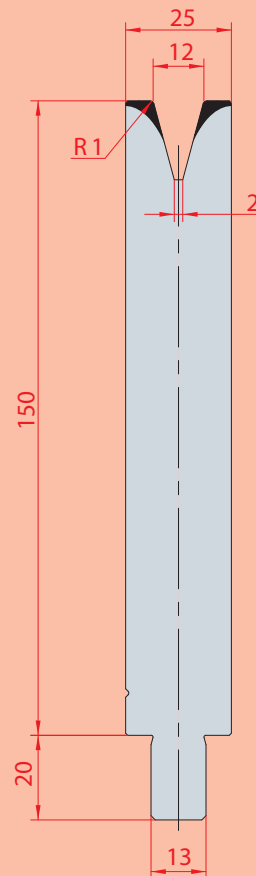
3150
Max T/m=50



3151
Max T/m=40



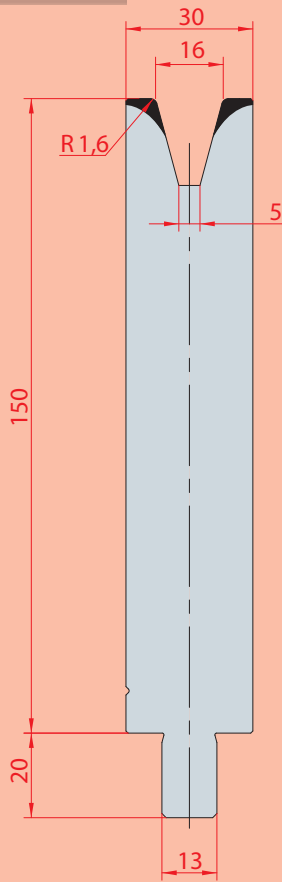
3152
Max T/m=40



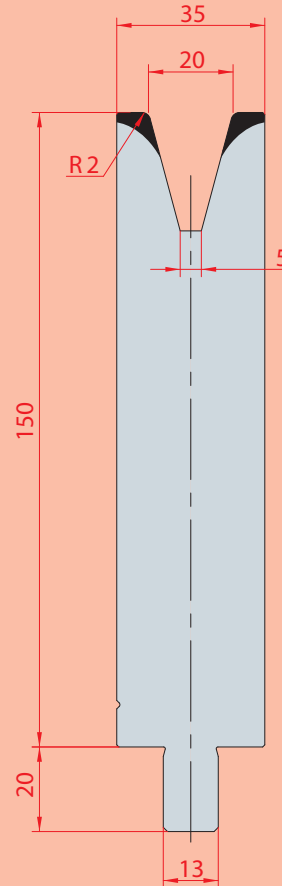
3153
Max T/m=50

MATRICI 1V H150 - 30° / SINGLE V DIE H150 - 30°

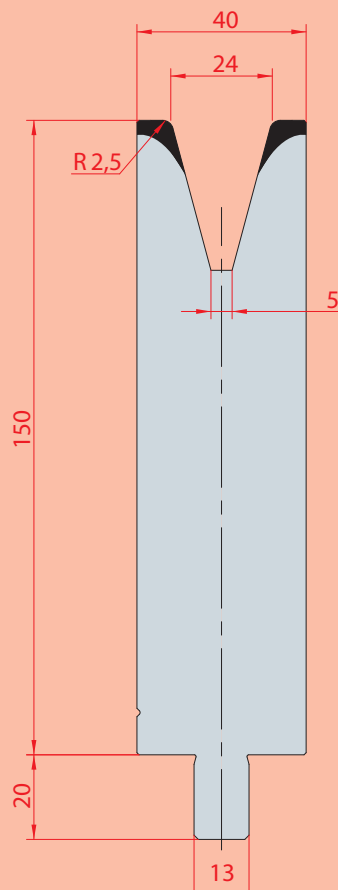
- C45 bonificato /quenched
- 42CrMo4
- C45



3154
Max T/m=45



3155
Max T/m=50



3156
Max T/m=50

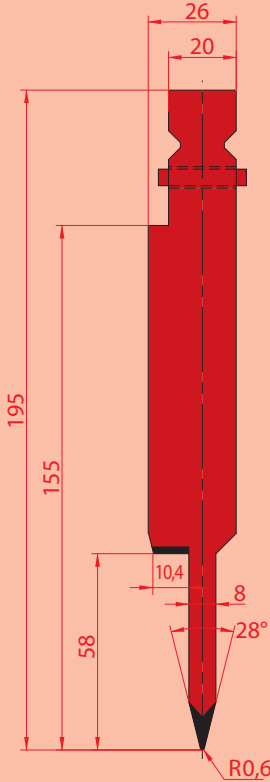
PIEGASCHIACCIA / FLATTENING-HEMMING TOOLS

■ C45 bonificato /quenched
■ 42CrMo4
■ C45

1249

Max T/m=80

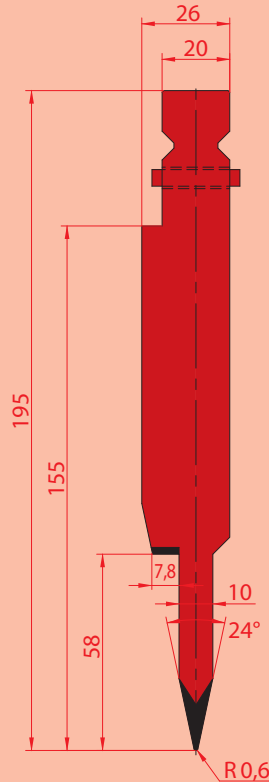
spessore max di lamiera (ferro normale) 1,2 mm
 max sheet thickness mild steel 1,2 mm



1250

Max T/m=80

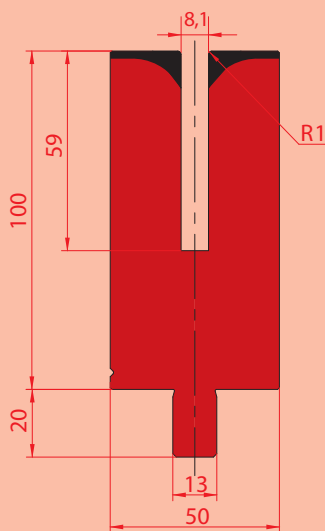
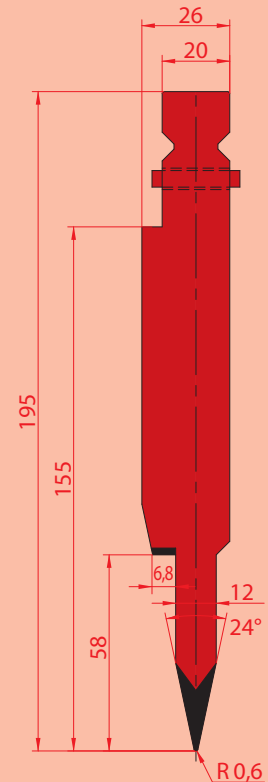
spessore max di lamiera (ferro normale) 1,5 mm
 max sheet thickness mild steel 1,5 mm



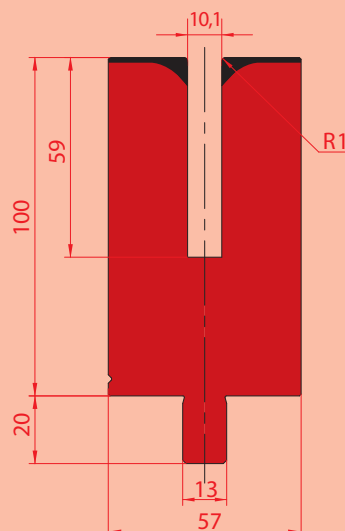
1251

Max T/m=80

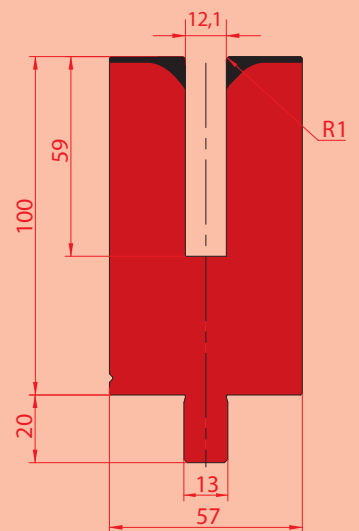
spessore max di lamiera (ferro normale) 1,5 mm
 max sheet thickness mild steel 1,5 mm



3157
Max T/m=50



3174
Max T/m=50



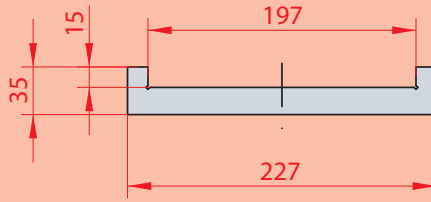
3175
Max T/m=50

CANALETTE / DIES HOLDER

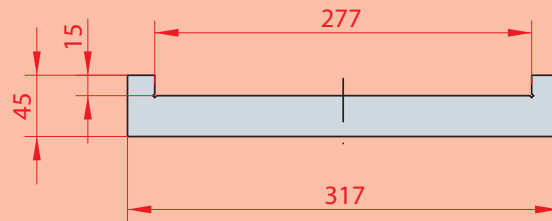
- C45 bonificato /quenched
- 42CrMo4
- C45

MODELLI PER MATRICI REGOLABILI MODELS FOR ADJUSTABLE DIES

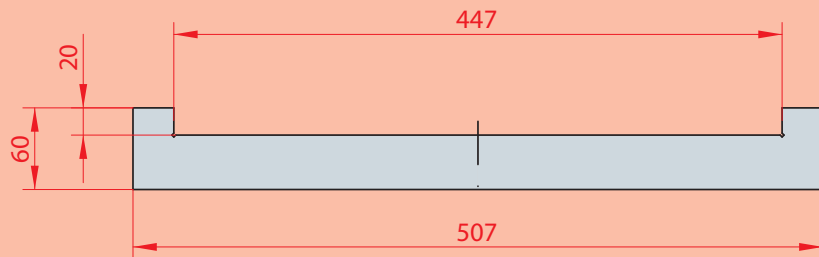
cod. 9015 1000 mm
per matrice/for die 3190



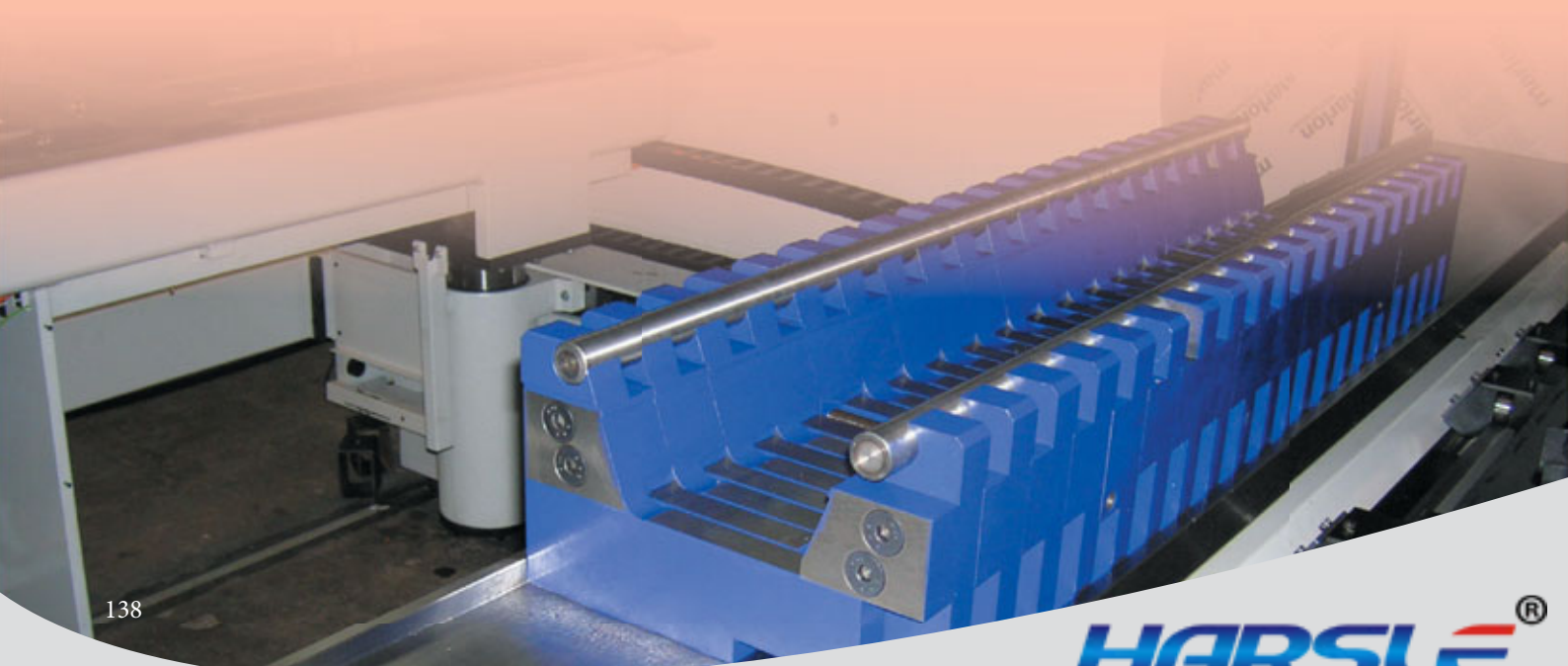
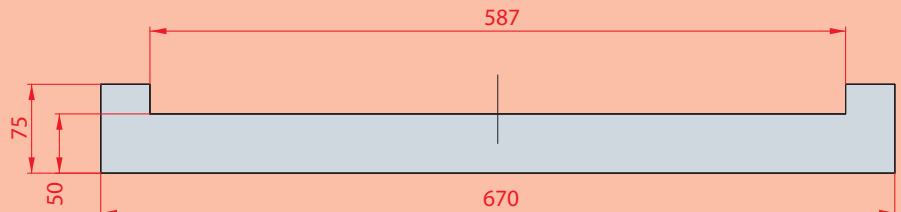
cod. 9016 1000 mm
per matrice/for die 3191



cod. 9014 1000 mm
per matrice/for die 3192

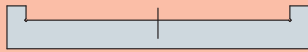


cod. 9017 1000 mm
per matrice/for die 3193

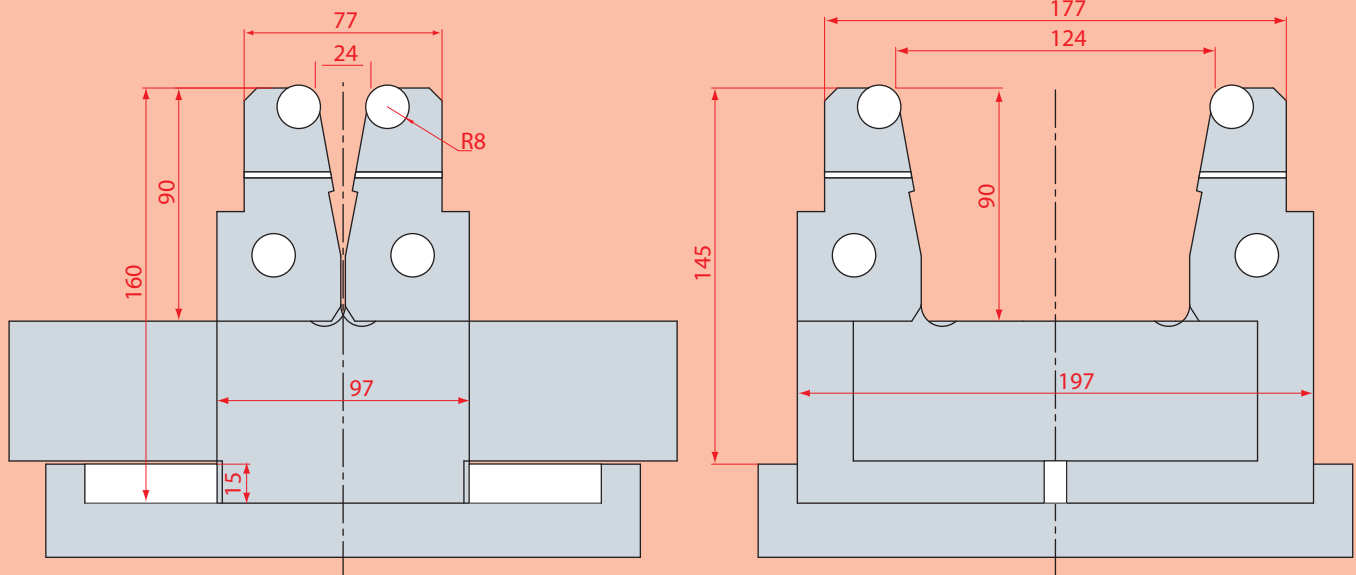


■ C45 bonificato /quenched
 ■ 42CrMo4
 ■ C45

Questa tipologia di matrici, richiedono sempre una canaletta speciale per ogni tipo
 This adjustable die needs a special die holder

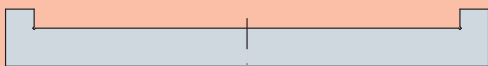


cod. 9015 (pag. 140)

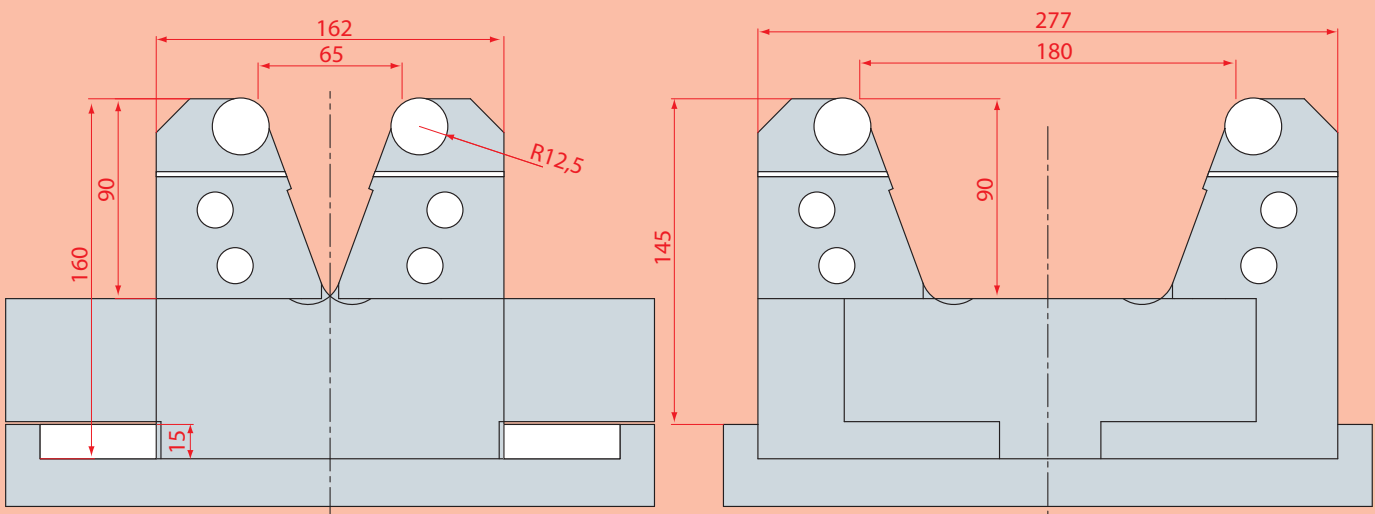


3190

Angolo di piega massima= 60° V= da 24 a 124 L=1000 Max=125 T/m a 90°
 Maximum bending angle = 60° V= from 24 to 124 L=1000 Max=125 T/m at 90°



cod. 9016 (pag. 140)



3191

Angolo di piega massima= 60° V=da 60 a 180 L=1000 Max=200 T/m a 90°
 Maximum bending angle = 60° V= from 60 to 180 L=1000 Max=200 T/m at 90°

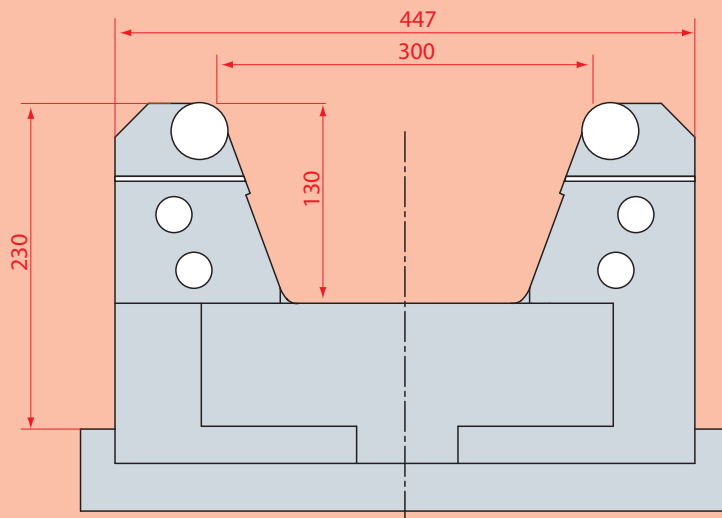
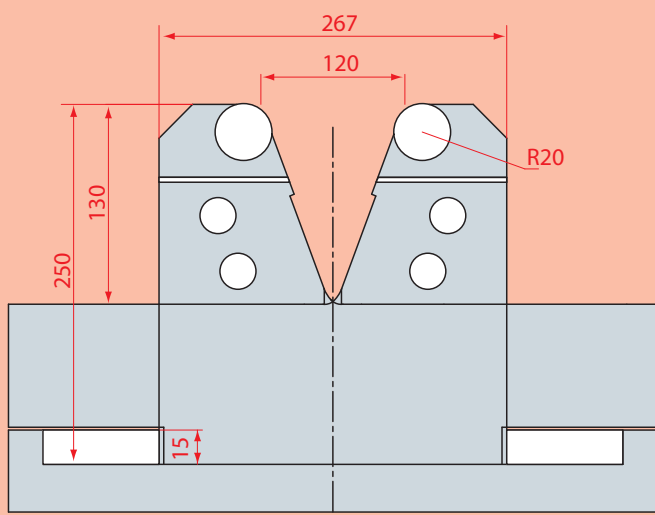
MATRICI REGOLABILI / ADJUSTABLE DIES

- C45 bonificato /quenched
- 42CrMo4
- C45

Questa tipologia di matrici, richiedono sempre una canaletta speciale per ogni tipo
This adjustable die needs a special die holder

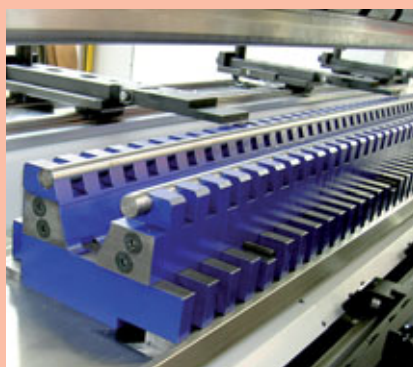


cod. 9014 (pag. 140)



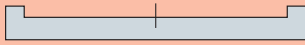
3192

Angolo di piega massima= 60° V=da 120 a 300 L=600 Max=400 T/m a 90°
Maximum bending angle = 60° V= from 120 to 300 L=600 Max=400 T/m at 90°

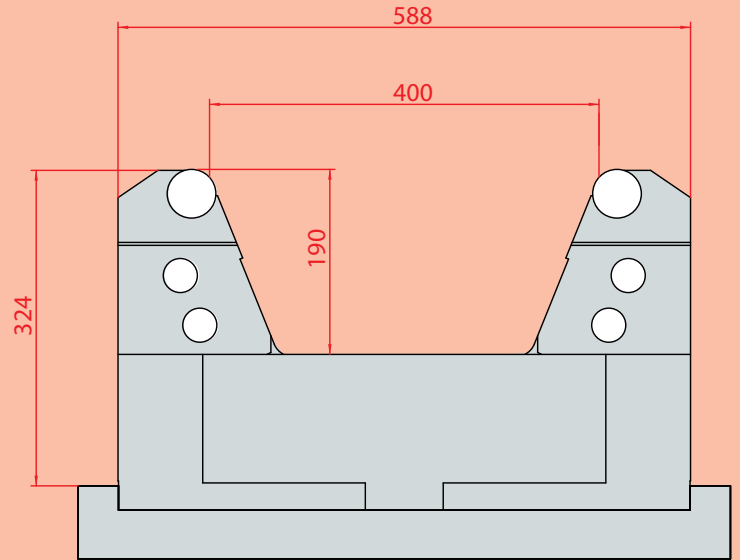
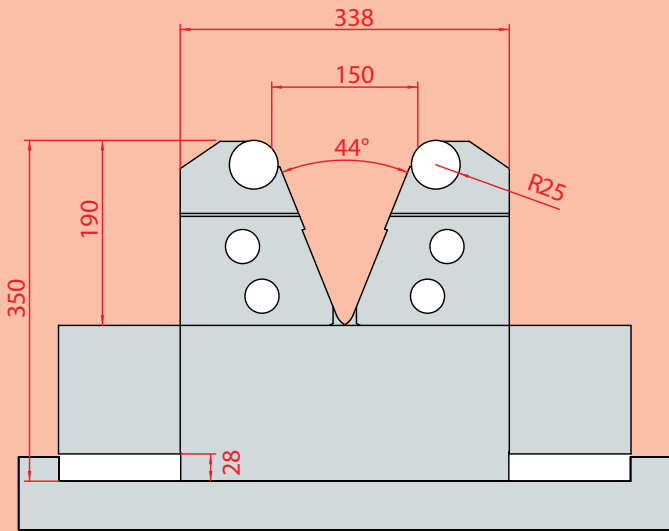


- C45 bonificato /quenched
- 42CrMo4
- C45

Questa tipologia di matrici, richiedono sempre una canaletta speciale per ogni tipo
 This adjustable die needs a special die holder

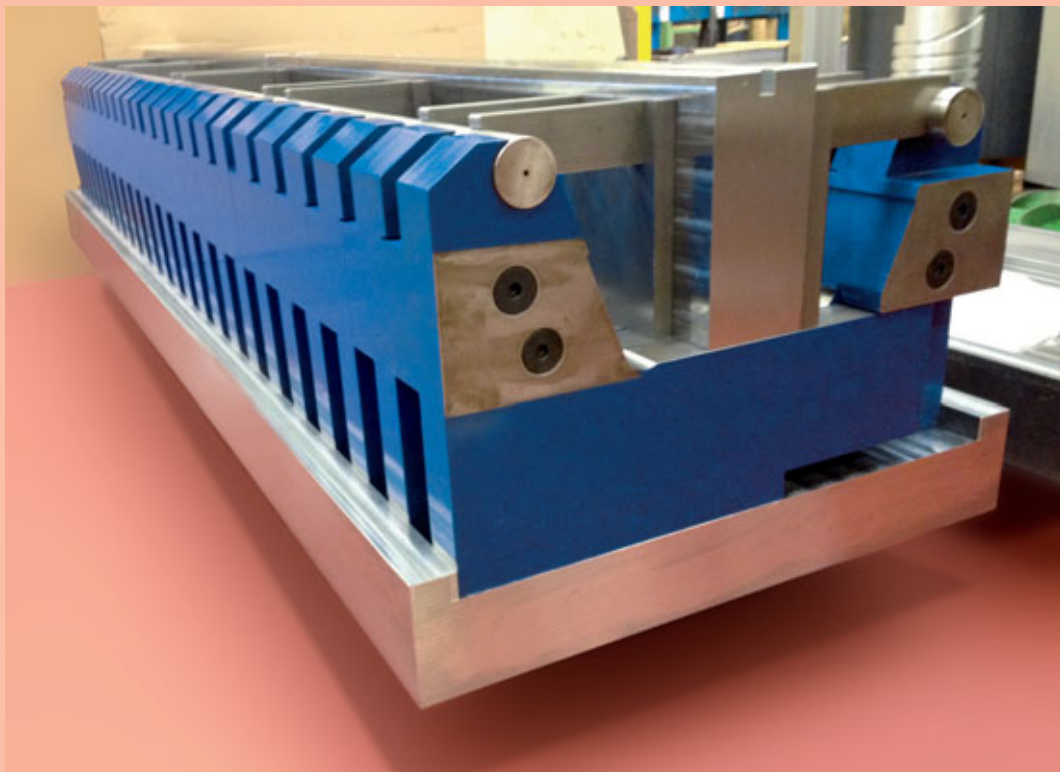


cod. 9017 (pag. 140)

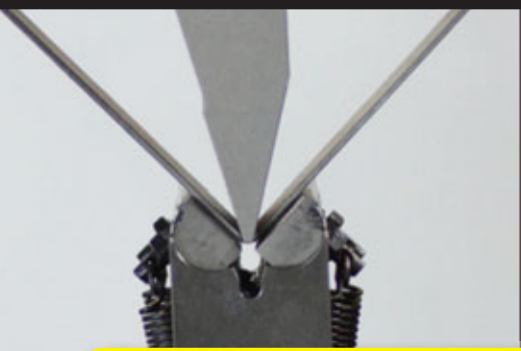


3243

Angolo di piega massima= 60° V=da 150 a 400 L=600 Max=400 T/m a 90°
 Maximum bending angle = 60° V= from 150 to 400 L=600 Max=400 T/m at 90°



ACTIVE BEND



NEW TECHNOLOGY FOR HIGH QUALITY RESULTS

Active Bend provides advantages that the standard dies can't perform:

- 40° acute bending
- narrow minimum edges
- no die marking (between sectioned pieces)
- no strain with perforated sheets



- ▶ no die mark bending
- ▶ 40° acute bending

NUOVA TECNOLOGIA PER RISULTATI DI ALTA QUALITÀ

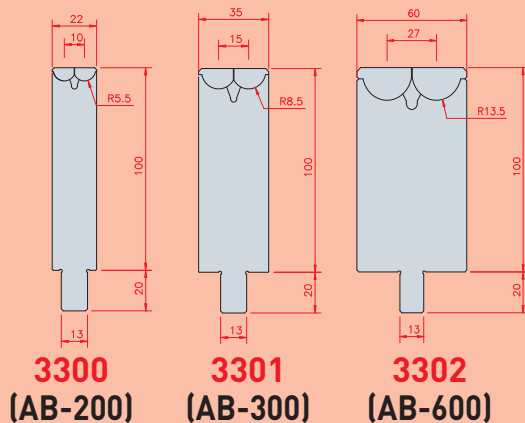
Active Bend garantisce prestazioni che le matrici standard non consentono:

- pieghe fino a 40°
- bordi minimi ridotti
- nessuna marcatura (nemmeno tra i frazionati)
- piegare lamiere forate senza deformazione

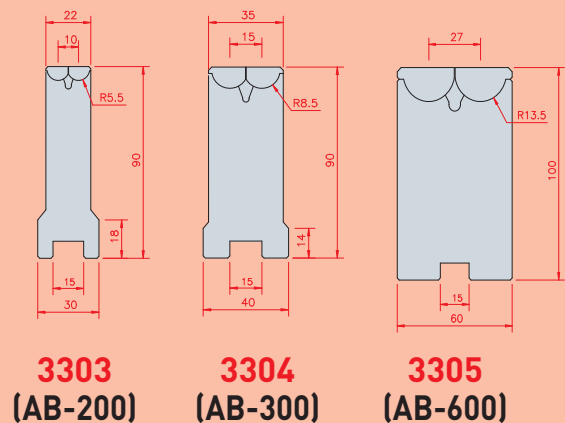


- ▶ nessuna marcatura
- ▶ pieghe fino a 40°

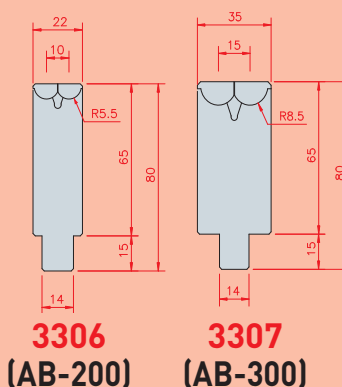
WILA-TRUMPF



AMADA-PROMECAM RAIL



AMADA-PROMECAM



MODELLO / MODEL	LUNGHEZZA / LENGTH (mm)
AB200	50
	100
	200
	15, 20, 25, 30
AB300	50
	100
	200
	15, 20, 25, 30
AB600	50
	100
	200

ACTIVE BEND



BENDING DATA FOR ACTIVE BEND

BEND DEDUCTION

MATERIAL	T	90 DEGREE BENDING (PUNCH ANGLE 88 DEGREE X 0.2R)		
		AB-200	AB-300	AB-600
SPCC	0.8	2.10		
	1.0	2.32	2.67	
	1.2	2.49	2.88	
	1.6	2.90	3.51	
	2.0	3.56	3.98	
	3.0		5.21	5.50
	4.5			6.95
	6.0			9.95
SECC	0.8	1.78		
	1.0	1.98	2.47	
	1.2	2.25	2.59	
	1.6	2.88	3.06	
	2.0	3.63	4.05	
SUS304	0.5	1.14		
	0.8	2.09		
	1.0	2.23	2.60	
	1.2	2.63	3.08	
	1.5	3.24	3.49	
	2.0	3.68	3.95	
AL	0.5	1.52		
	1.0	2.05	1.97	
	1.5	2.69	2.79	
	2.0	3.80	3.94	
	3.0		5.17	

OUTSIDE RADIUS

MATERIAL	T	90 DEGREE BENDING (PUNCH ANGLE 88 DEGREE X 0.2R)		
		AB-200	AB-300	AB-600
SPCC	0.8	1.868		
	1.0	1.851	2.511	
	1.2	2.222	2.597	
	1.6	2.573	3.333	
	2.0	2.806	3.718	
	3.0			5.597
	4.5			7.093
SECC	0.8	1.726		
	1.0	1.823	2.378	
	1.2	2.321	2.527	
	1.6	2.729	2.909	
	2.0	2.870	3.454	
	3.0		4.755	
SUS304	0.5	1.970		
	0.8	2.485		
	1.0	2.497	3.156	
	1.2	2.657	3.455	
	1.5	2.847	3.684	
	2.0	3.209	4.102	
AL	0.5	0.971		
	1.0	1.536	1.891	
	1.5	2.414	2.535	
	2.0	2.669	3.362	
	3.0		4.210	

(UNIT:MM)



ACTIVE BEND

BENDING DATA FOR ACTIVE BEND

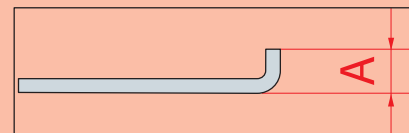
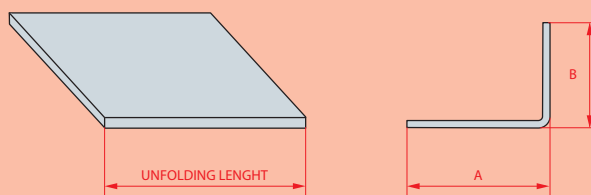
BENDING PRESSURE

T	AB200	AB300	AB600
0.5	50		
0.8	70		
1.0	80	80	
1.2	110	110	
1.6	200	200	
2.0	300	300	
2.3			
2.6			
3.0		510	300
4.0			
4.5			400

T	V DIE
0.5	40 (V 4)
0.8	70 (V 6)
1.0	110 (V 6)
1.2	120 (V 8)
1.6	170 (V 10)
2.0	220 (V 12)
2.3	250 (V 14)
2.6	280 (V 16)
3.2	270 (V 25)
4.0	340 (V 32)
4.5	440 (V 32)
6.0	480 (V 50)

MATERIAL	T	FLANGE DIMENSION (A)		
		AB-200	AB-300	AB-600
SPCC	0.8	6.01		
	1.0	6.13	9.15	
	1.2	6.37	9.39	
	1.6	6.91	9.64	
	2.0	7.21	9.84	
	3.0			17.0
	4.5			17.5
6.0			18.3	
SECC	0.8	5.80		
	1.0	6.16	9.01	
	1.2	6.39	9.23	
	1.6	6.93	9.56	
	2.0	7.33	9.94	
SUS304	0.5	5.49		
	0.8	6.01		
	1.0	6.35	9.34	
	1.2	6.61	9.40	
	1.5	7.04	9.64	
	2.0	7.44	10.05	
3.0		10.82		
AL	0.5	4.85		
	1.0	5.61	8.56	
	1.5	6.17	8.83	
	2.0	6.75	9.60	
3.0		10.47		

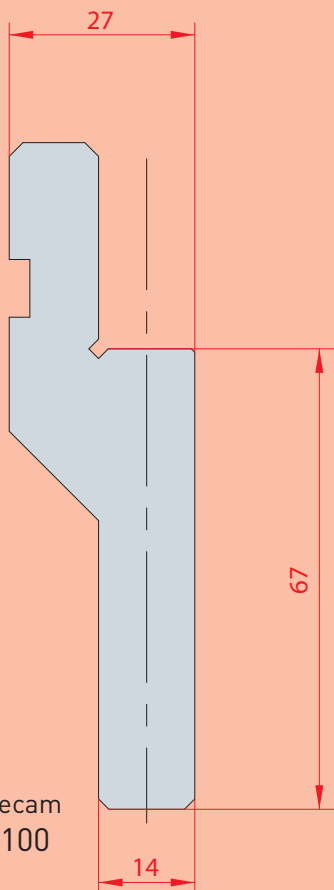
THIS DATA IS FOR REFERENCE. IT DEPENDS ON THE UPPER TOOL RADIUS, MATERIALS AND SO ON. WE RECOMMEND THE TEST BENDING.



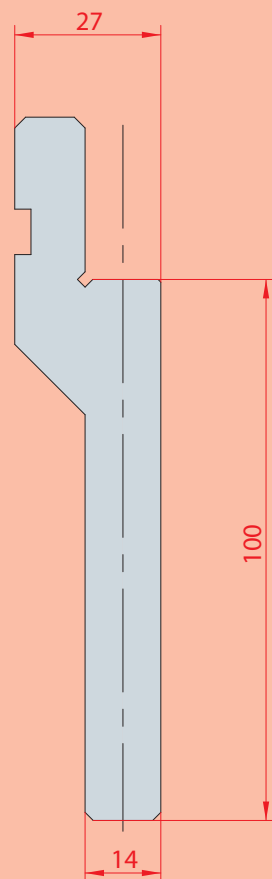
EQUIVALENT V WIDTH
 SB200... V 10
 SB300... V 16
 SB600... V 25

※ UNFOLDING VALUE = (A + B) - UNFOLDING LENGTH

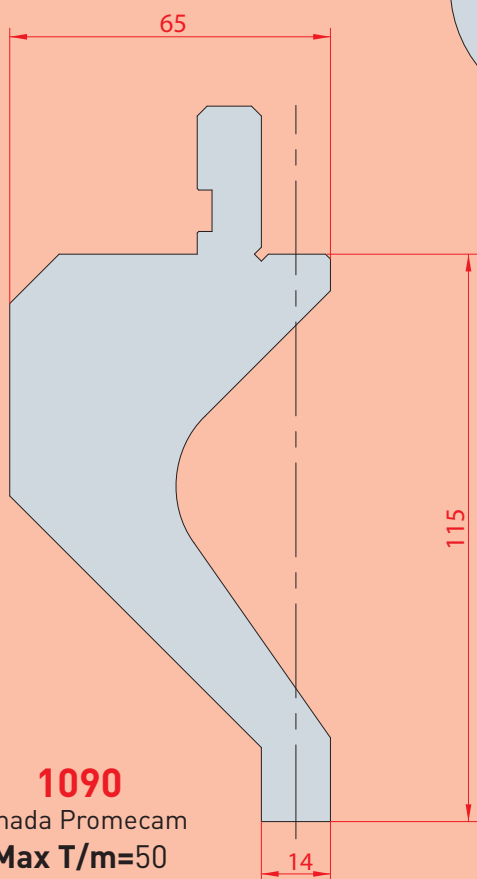
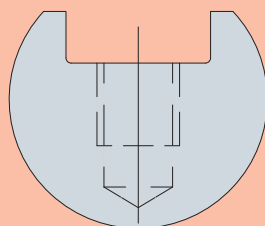
SUPPORTI PER ELEMENTI RAGGIATI / RADIUS TOOLS HOLDERS



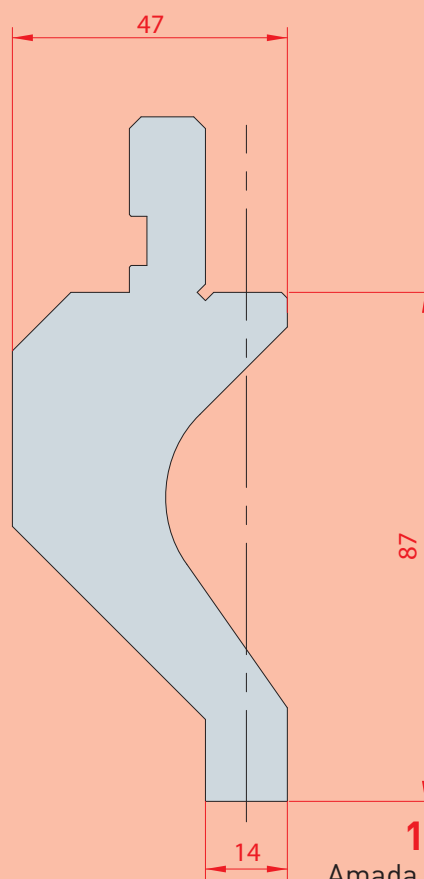
1036
Amada Promecam
Max T/m=100



1096
Amada Promecam
Max T/m=100



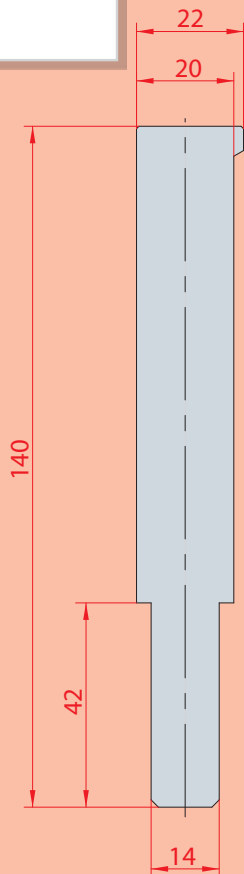
1090
Amada Promecam
Max T/m=50



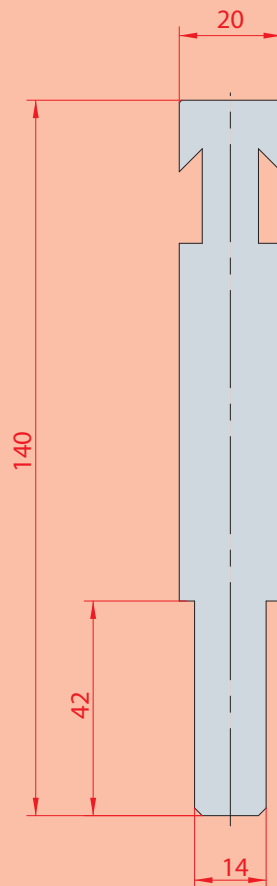
1091
Amada Promecam
Max T/m=50

SUPPORTI PER ELEMENTI RAGGIATI / RADIUS TOOLS HOLDERS

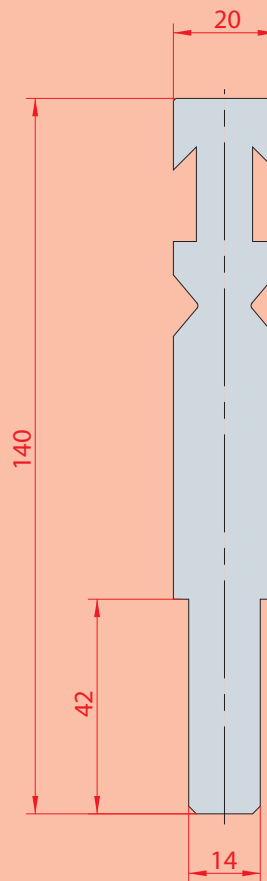
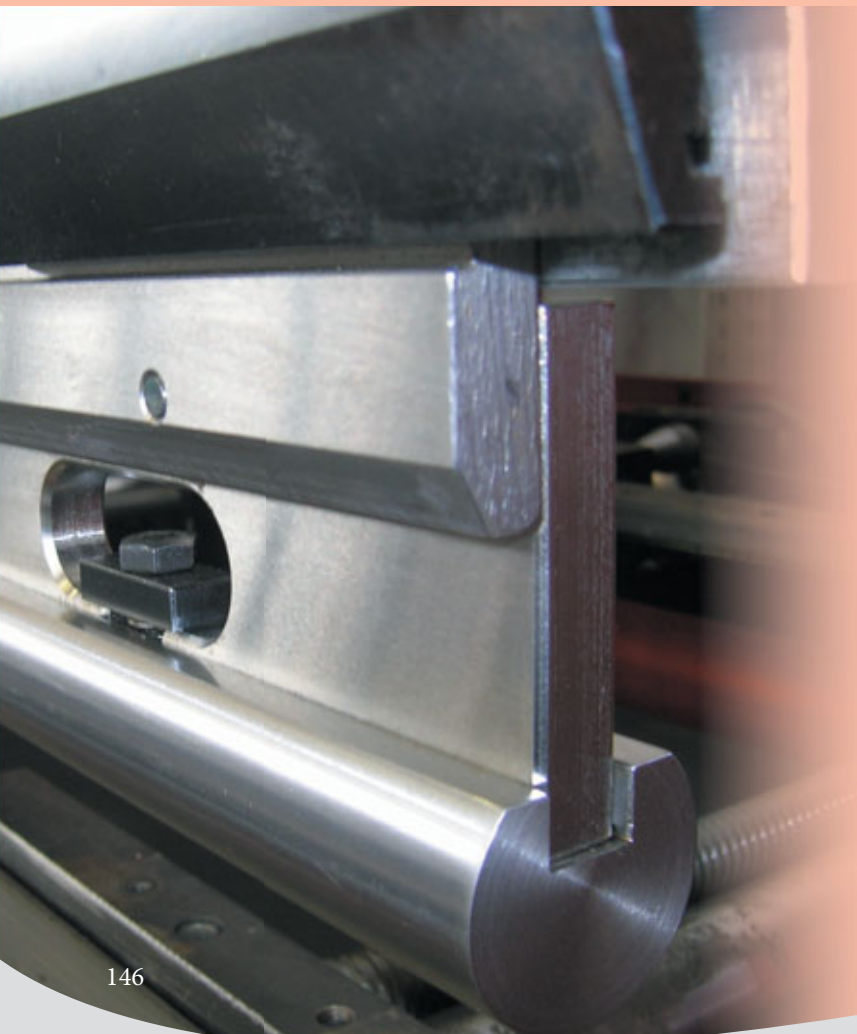
- C45 bonificato /quenched
- 42CrMo4
- C45



1241
Beyeler S
Max T/m=100



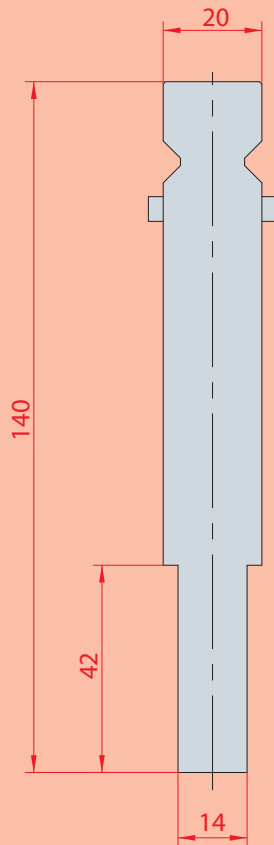
1239
Beyeler R
Max T/m=100



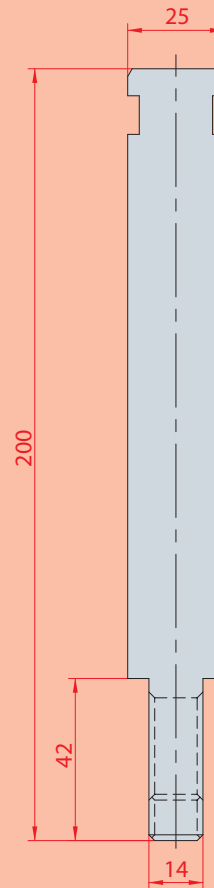
1273
Beyeler RF-A
Max T/m=100

SUPPORTI PER ELEMENTI RAGGIATI / RADIUS TOOLS HOLDERS

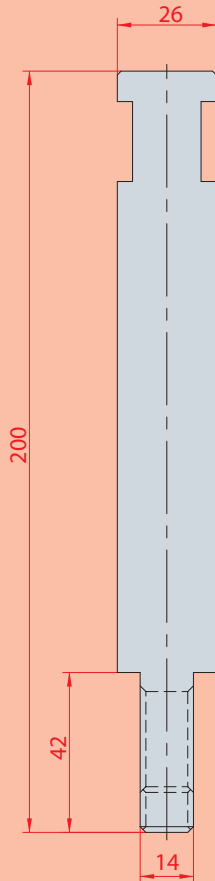
- C45 bonificato /quenched
- 42CrMo4
- C45



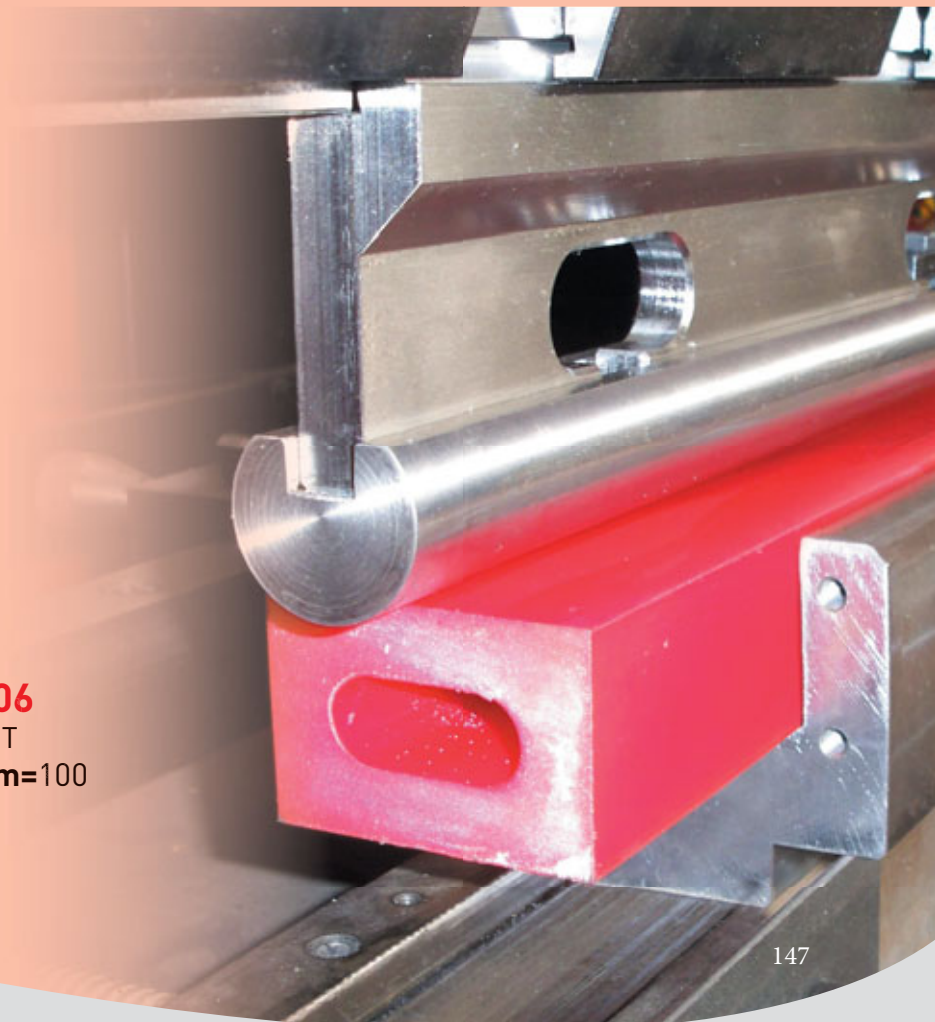
1240
Trumpf
Max T/m=100



1305
Weinbrenner
Max T/m=100

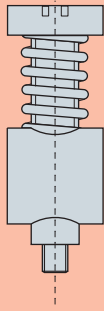


1306
EHT
Max T/m=100



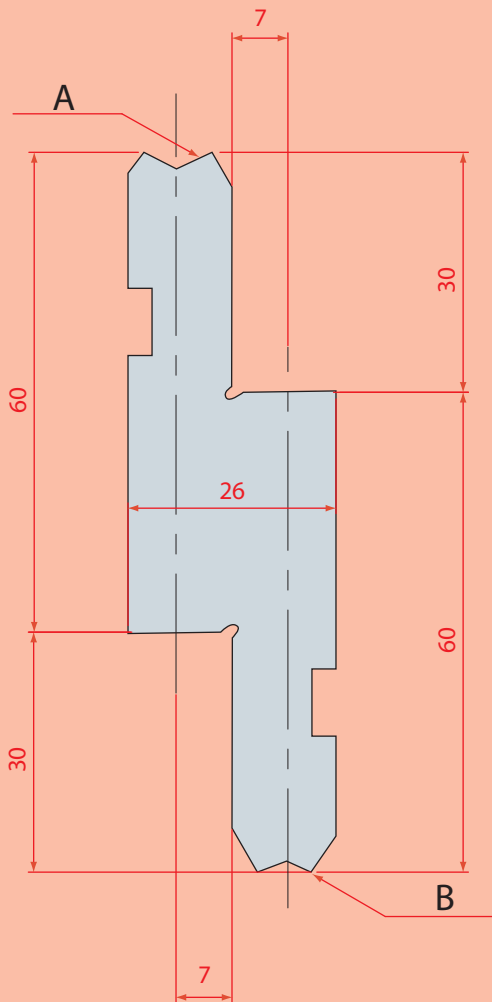
ELEMENTI RAGGIATI / RADIUS TOOLS

- C45 bonificato /quenched
- 42CrMo4
- C45

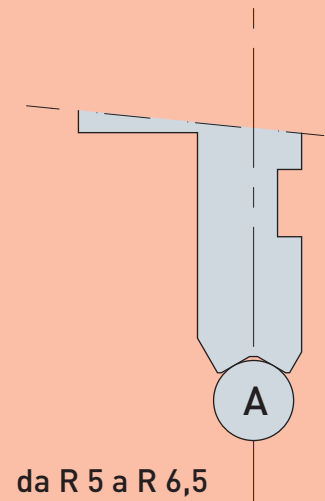
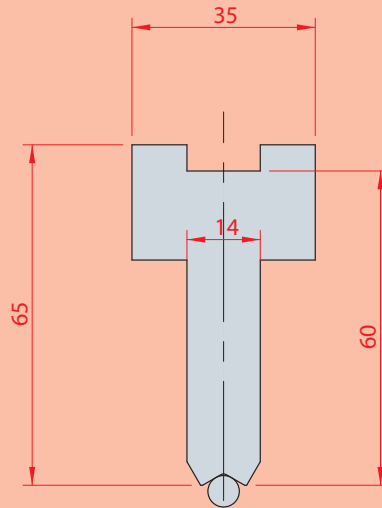


cod. 4275 Pezzo di ricambio / spare part

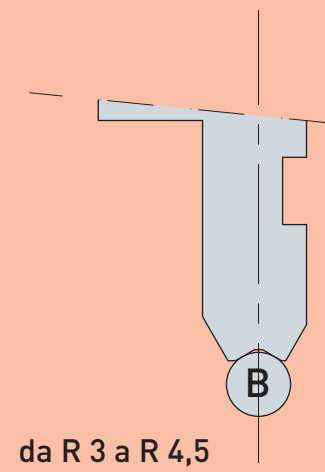
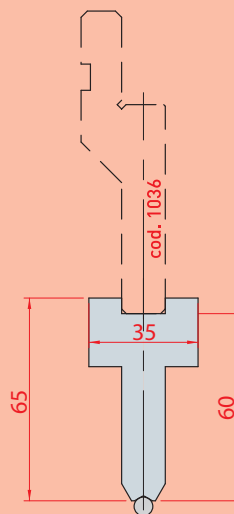
cod. 1155



cod. 1297



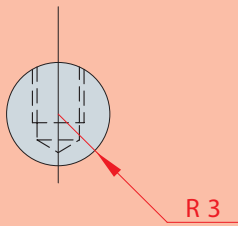
cod. 1296



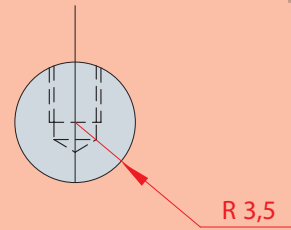
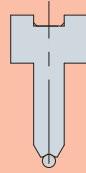
ELEMENTI RAGGIATI / RADIUS TOOLS

SOLO PER SUPPORTO 1155 - 1296 - 1297

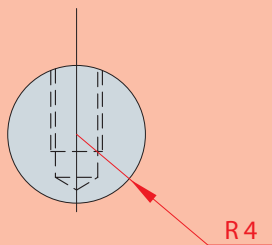
- C45 bonificato /quenched
- 42CrMo4
- C45



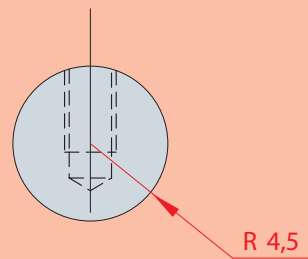
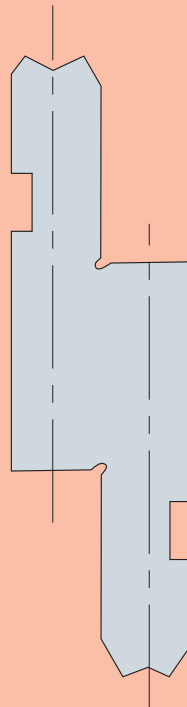
1180



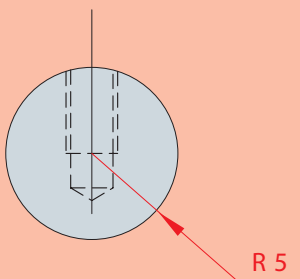
1181



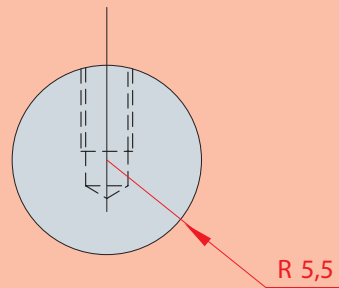
1182



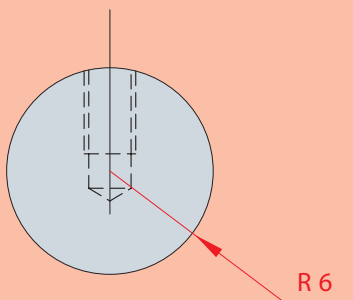
1183



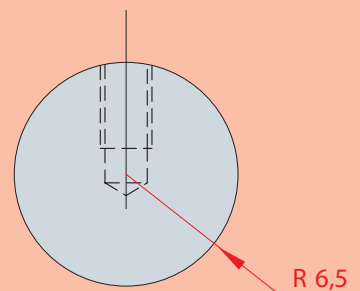
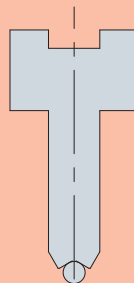
1184



1185



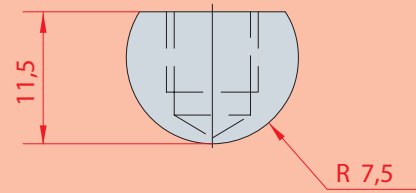
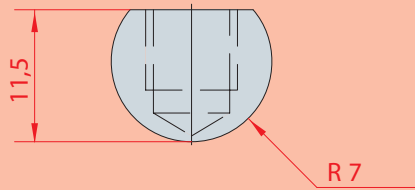
1186



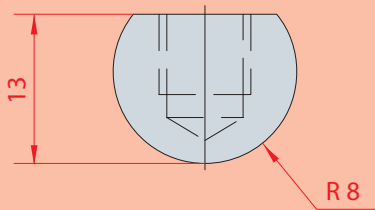
1187

ELEMENTI RAGGIATI / RADIUS TOOLS

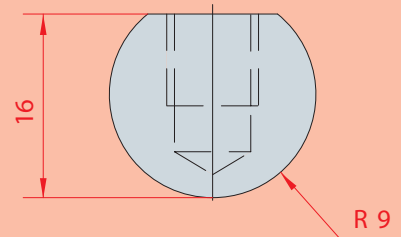
- C45 bonificato /quenched
- 42CrMo4
- C45



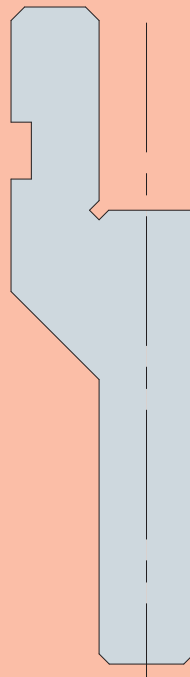
1100



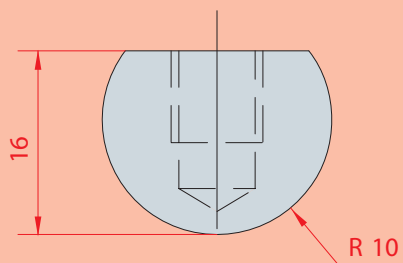
1101



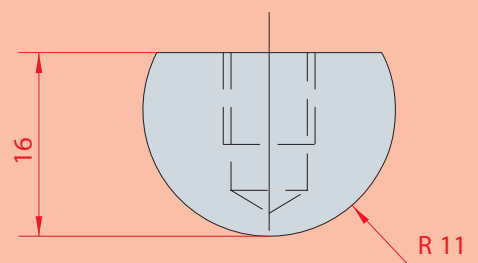
1102



1103



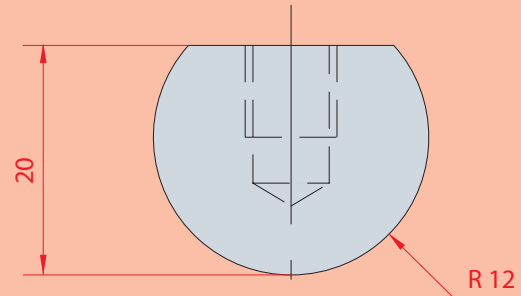
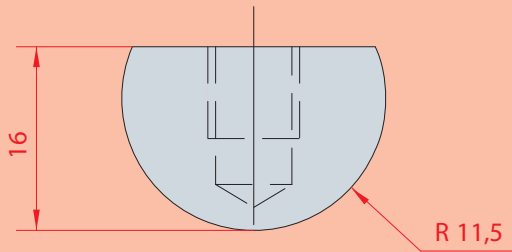
1037



1104

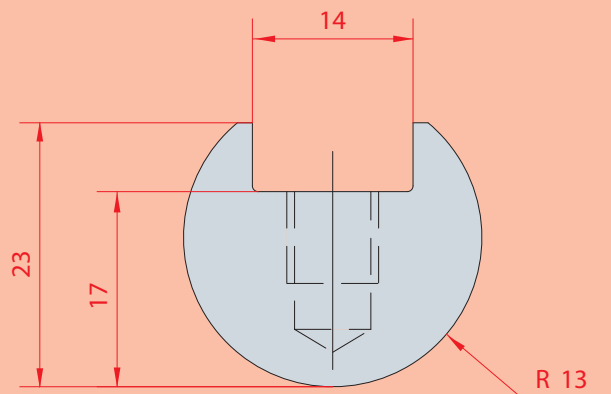
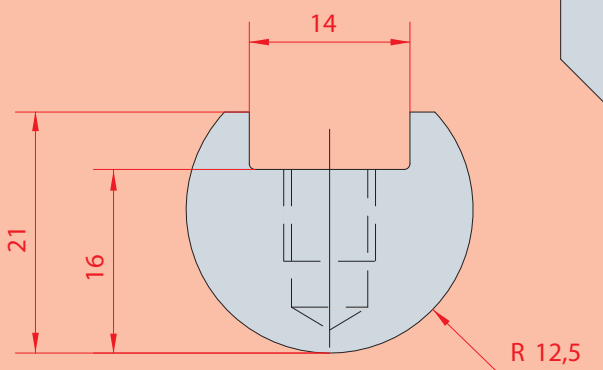
ELEMENTI RAGGIATI / RADIUS TOOLS

- C45 bonificato /quenched
- 42CrMo4
- C45



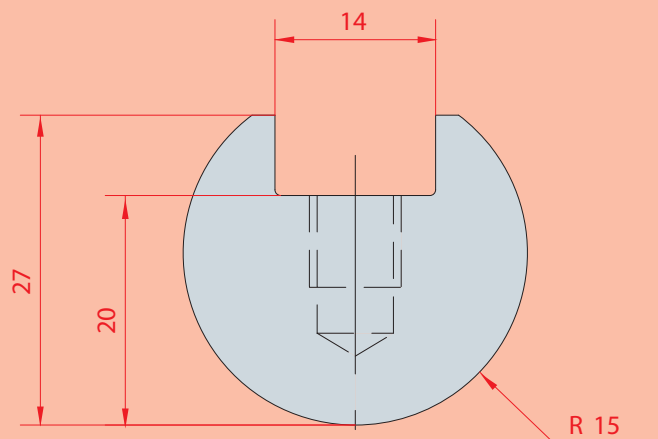
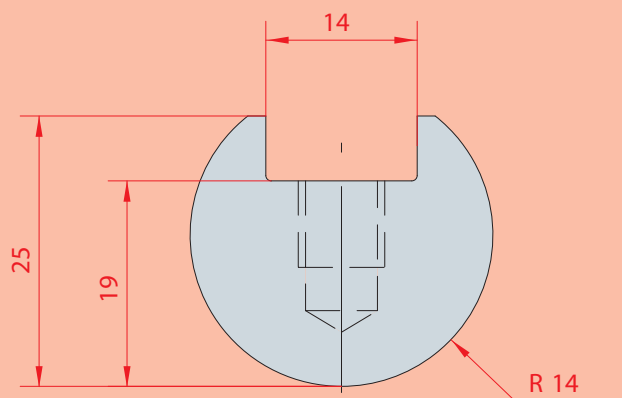
1105

1106



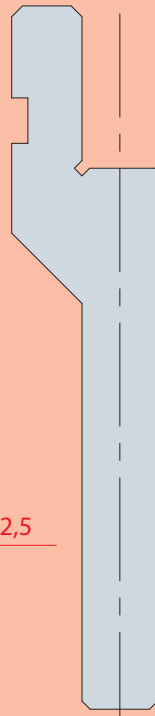
1107

1108



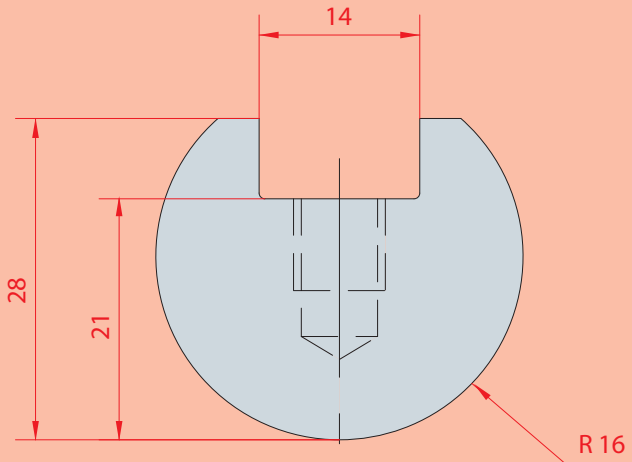
1109

1038

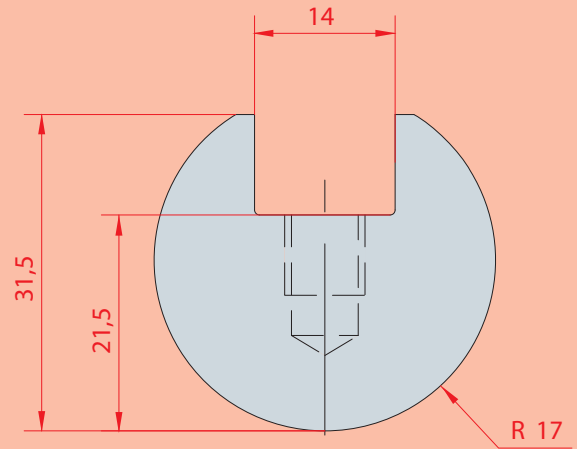


ELEMENTI RAGGIATI / RADIUS TOOLS

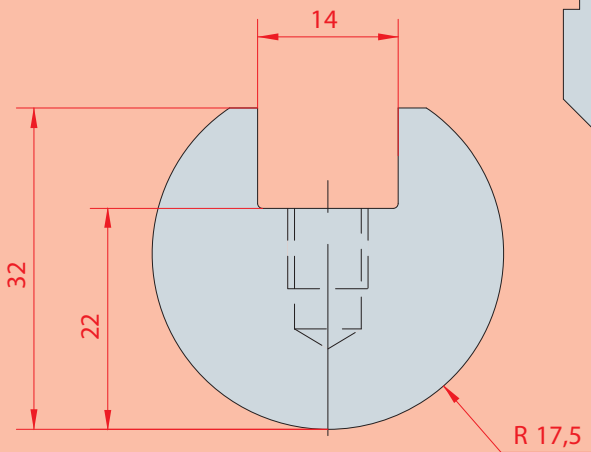
- C45 bonificato /quenched
- 42CrMo4
- C45



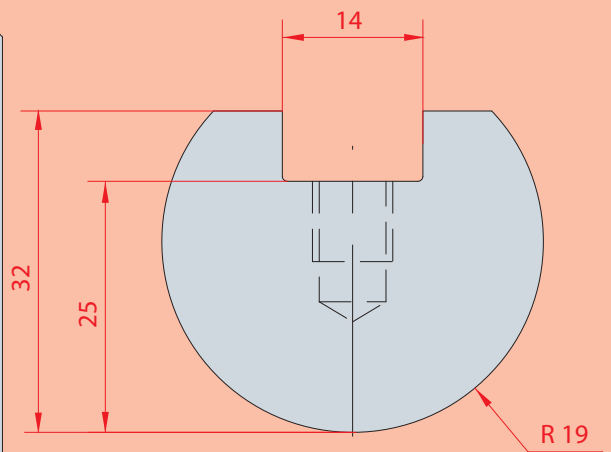
1110



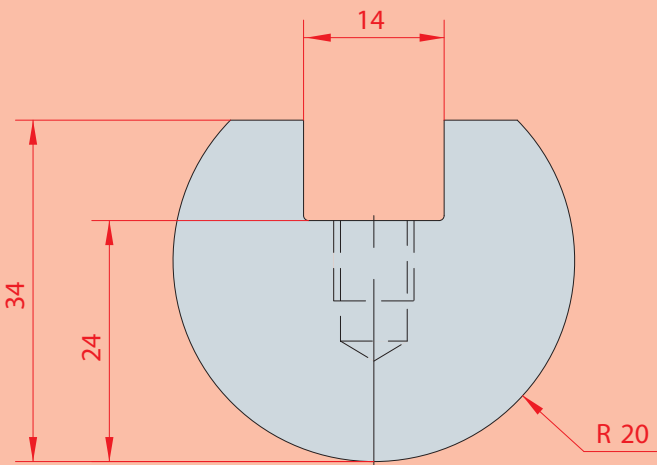
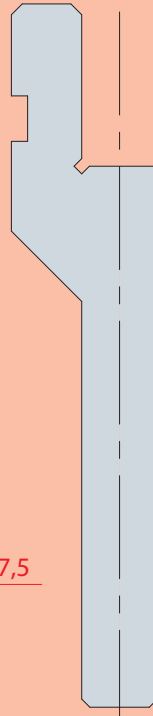
1111



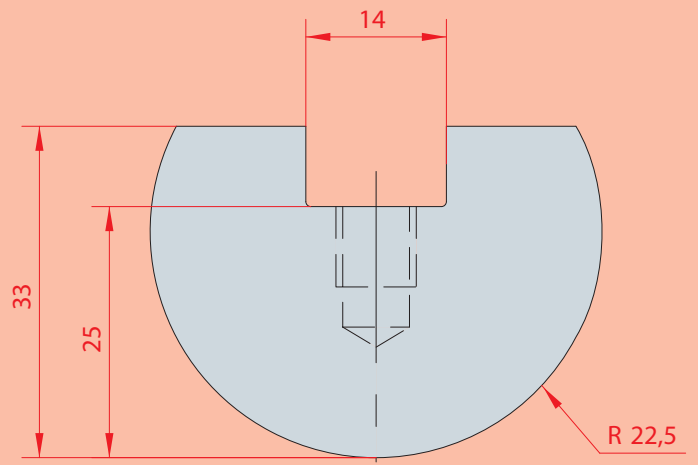
1039



1112



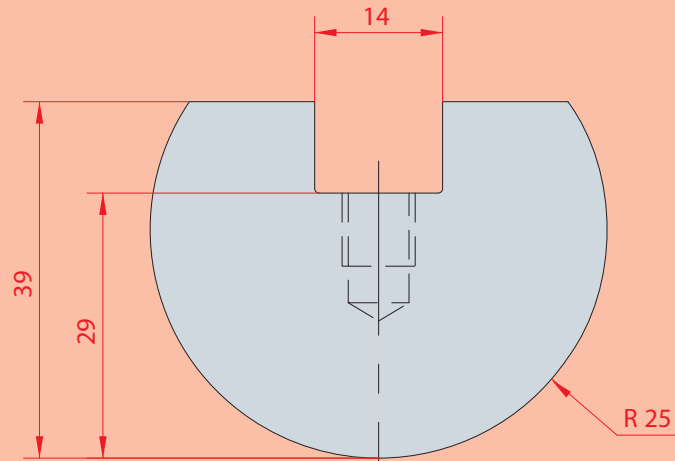
1040



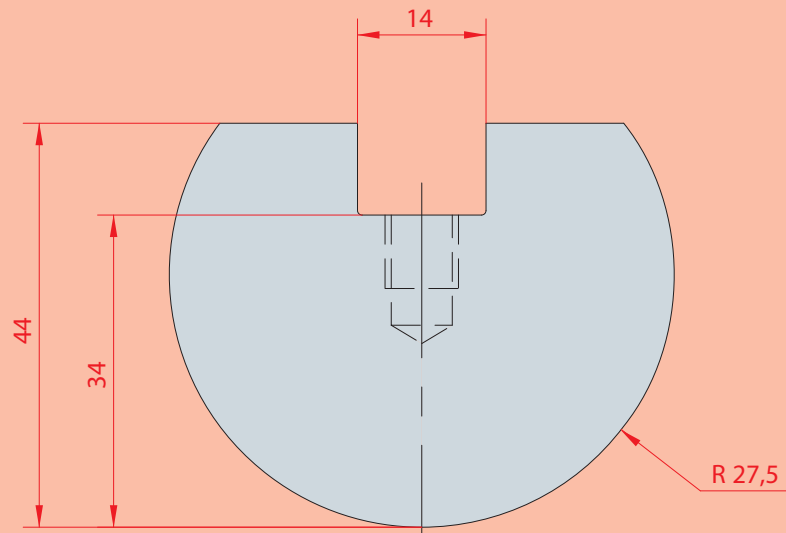
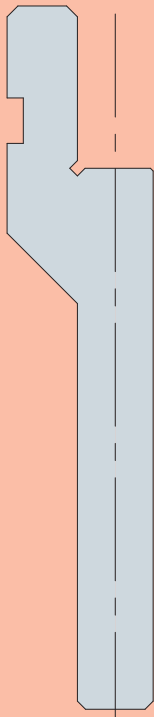
1113

ELEMENTI RAGGIATI / RADIUS TOOLS

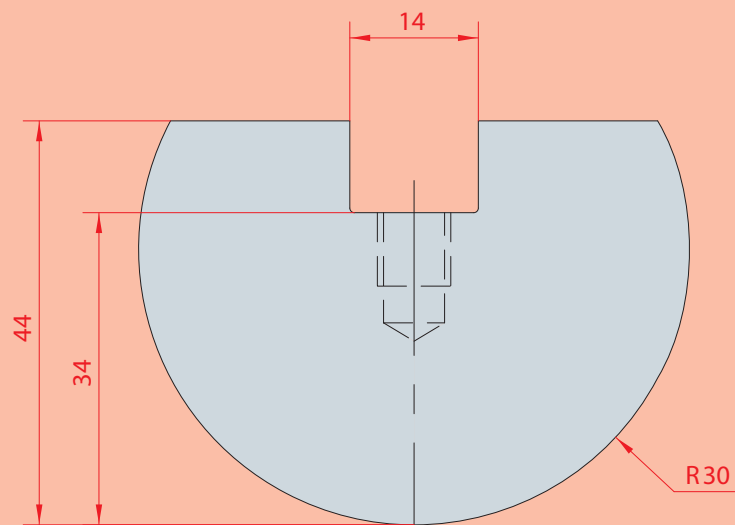
- C45 bonificato /quenched
- 42CrMo4
- C45



1041



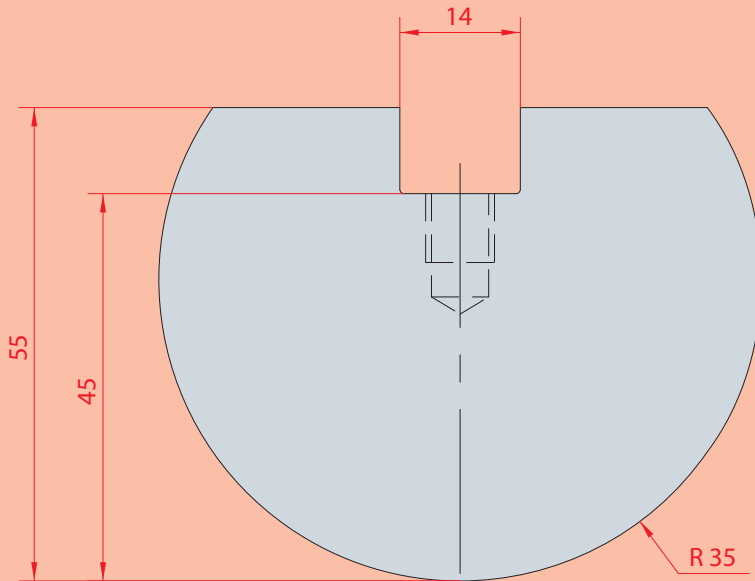
1114



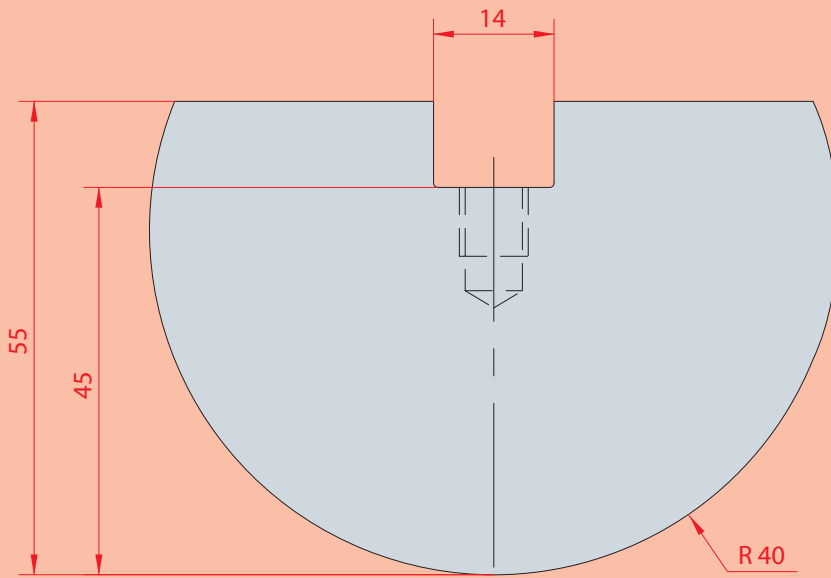
1042

ELEMENTI RAGGIATI / RADIUS TOOLS

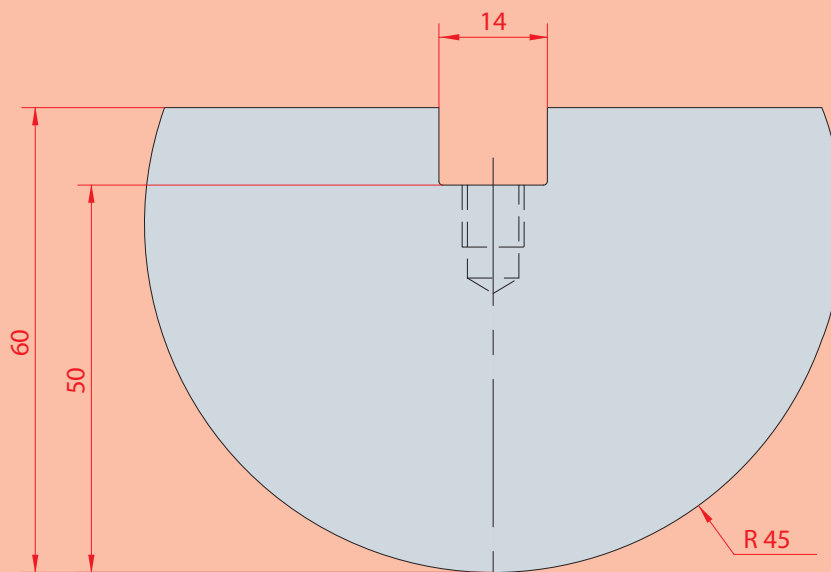
- C45 bonificato /quenched
- 42CrMo4
- C45



1115



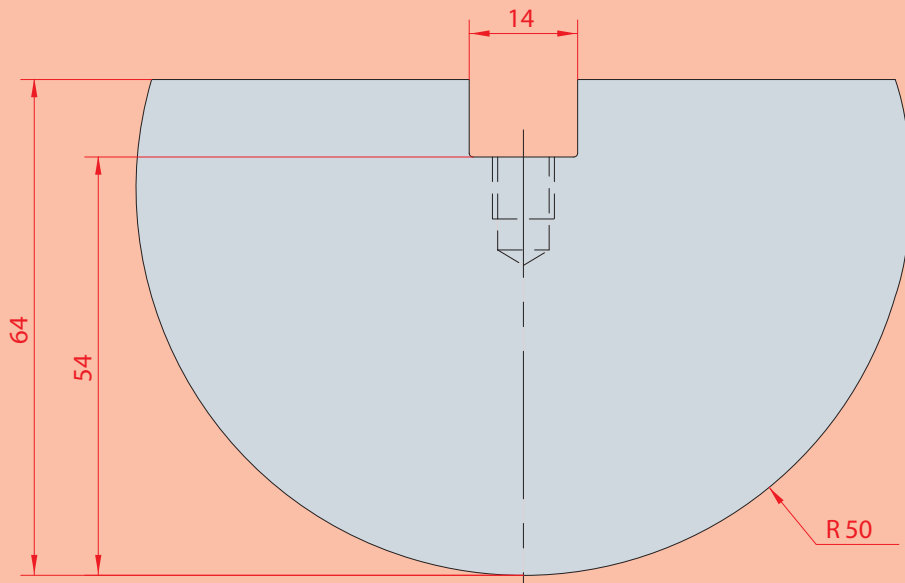
1116



1117

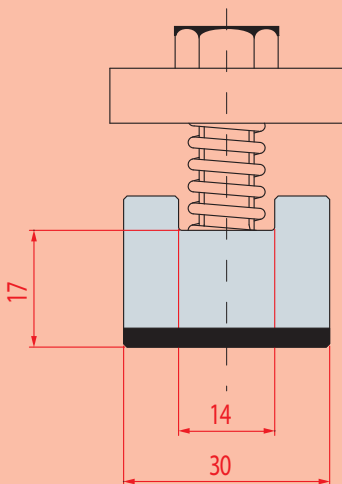
ELEMENTI RAGGIATI / RADIUS TOOLS

- C45 bonificato /quenched
- 42CrMo4
- C45

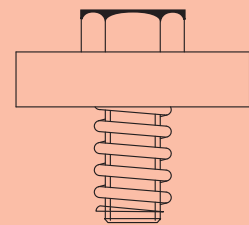
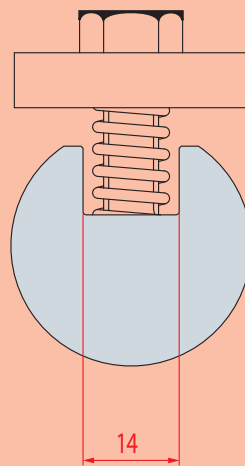


1118

ELEMENTO QUADRO ACCESSORI / RADIUS TOOLS ACCESSORIES



1043

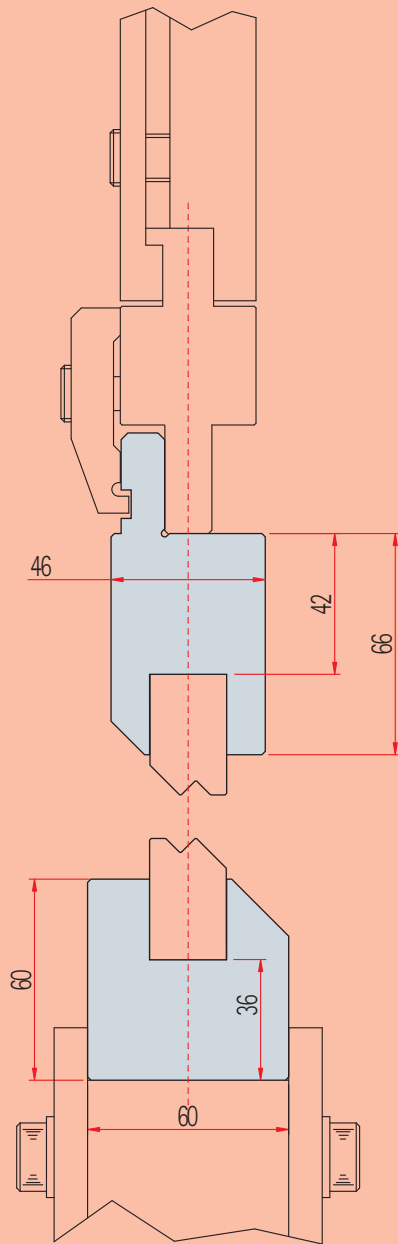


4274

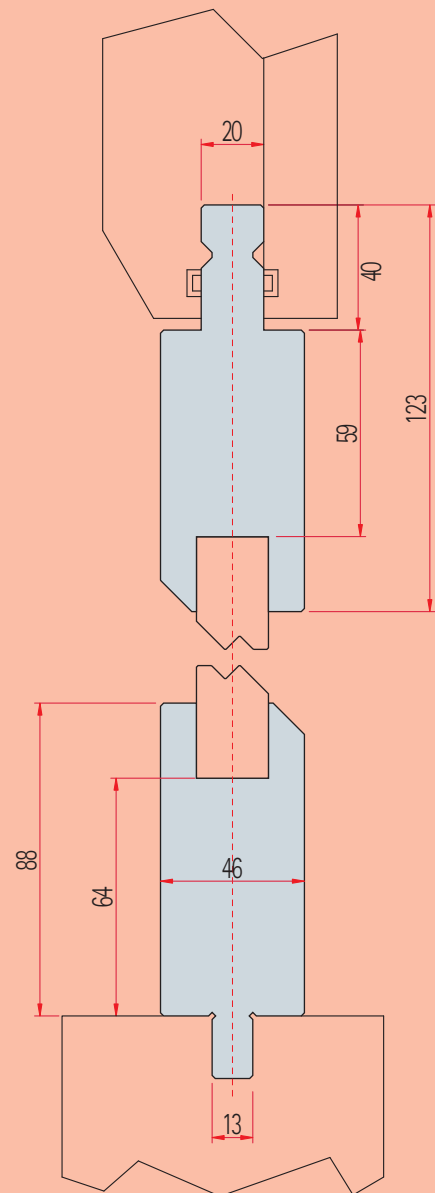
MOLLA + VITE + PIASTRINA
 SPRING + SCREW + PLATE

CONTENITORI PER INSERTI A Z / JOGGLE TOOL HOLDERS

- C45 bonificato /quenched
- 42CrMo4
- C45



Amada - 1150



Trumpf - 1242

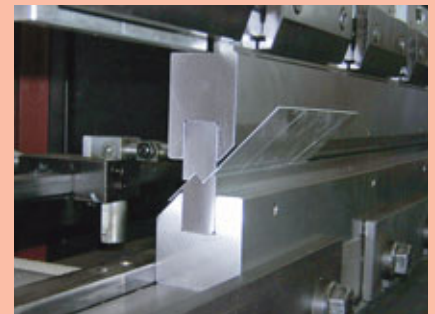


TABELLA INSERTI A Z / JOGGLE TOOLS CHART

■ C45 bonificato /quenched
■ 42CrMo4
■ C45

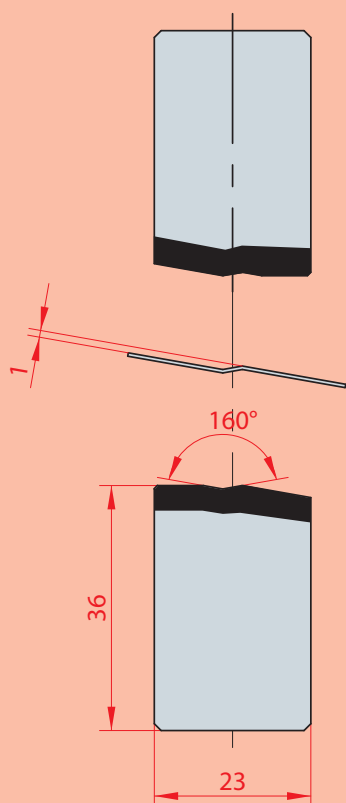
CODE	Z	GRADI DEGREES	SPESSORE MAX. LAMIERA MAX SHEET THICKNESS
1130	1	160°	0,5 mm
1276	1	90°	0,5 mm
1131	1,5	160°	0,6 mm
1277	1,5	90°	0,6 mm
1132	2	150°	0,8 mm
1274	2	90°	0,8 mm
1133	2,5	140°	1,0 mm
1275	2,5	90°	1,0 mm
1134	3	90°	1,0 mm
1135	3,5	90°	1,2 mm
1136	4	90°	1,2 mm
1137	4,5	90°	1,5 mm
1138	5	90°	1,5 mm
1139	5,5	90°	1,5 mm
1140	6	90°	1,5 mm
1141	6,5	90°	1,5 mm
1142	7	90°	2,0 mm
1143	7,5	90°	2,0 mm
1144	8	90°	2,5 mm
1145	9	90°	2,5 mm
1146	10	90°	3,0 mm
1147	11	90°	3,0 mm
1148	12	90°	3,0 mm
1278	13	90°	3,0 mm
1279	14	90°	3,0 mm
1280	15	90°	3,0 mm

INSERTI A Z - 160° / JOGGLE TOOLS - 160°

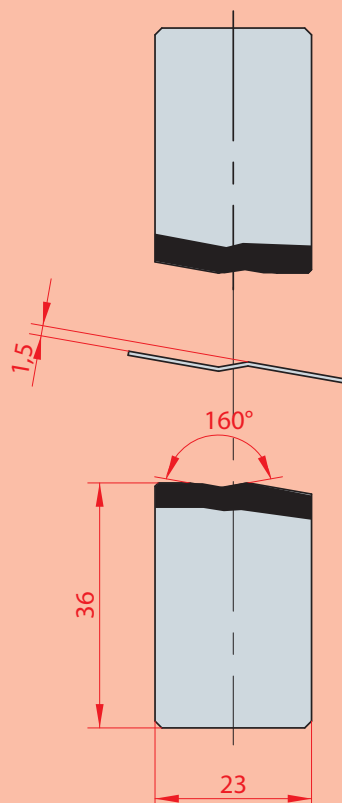
- C45 bonificato /quenched
- 42CrMo4
- C45

Per verificare la fattibilità della piega in base allo spessore lamiera, vedi tabella p. 159

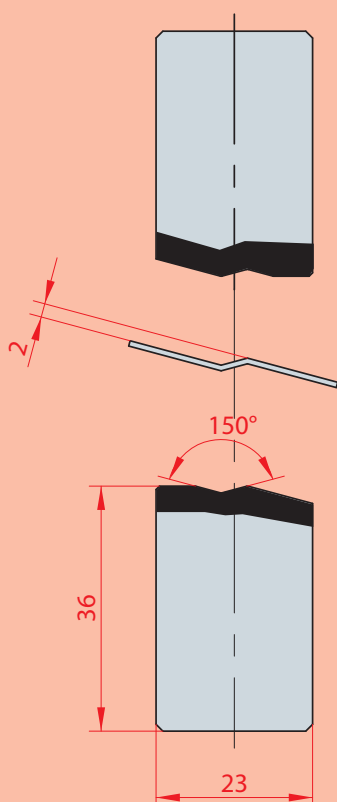
For choosing the right joggle tool with the sheet thickness please see the schedule on page 159



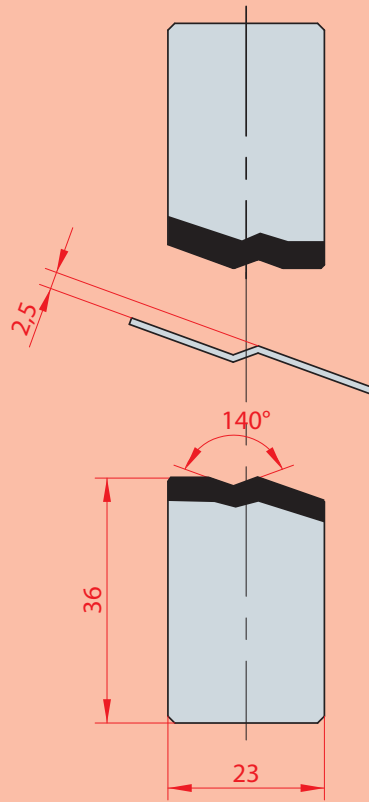
160°
1130



160°
1131



150°
1132



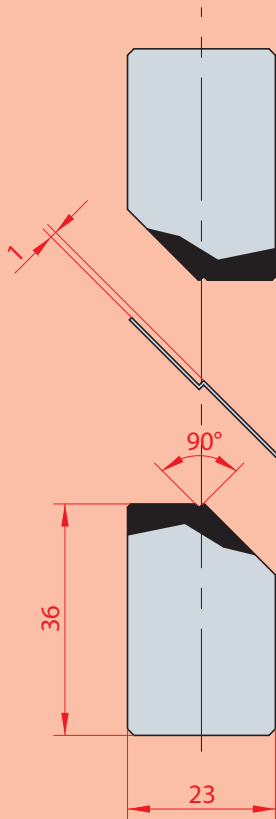
140°
1133

INSERTI A Z - 90° / JOGGLE TOOLS - 90°

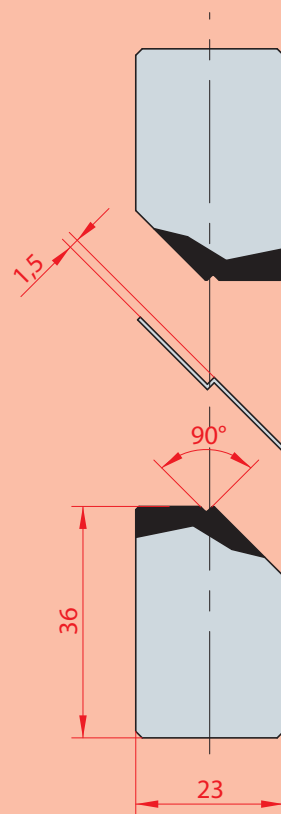
Per verificare la fattibilità della piega in base allo spessore lamiera, vedi tabella p. 159

For choosing the right joggle tool with the sheet thickness please see the schedule on page 159

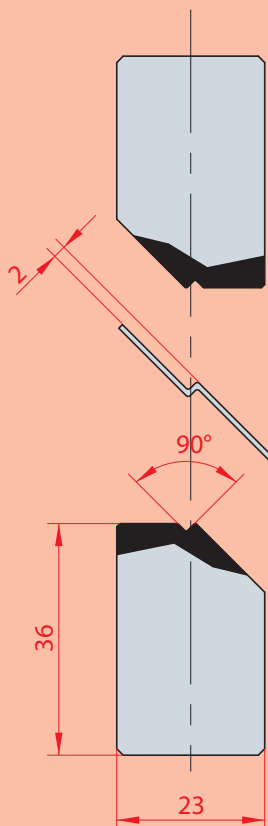
- C45 bonificato /quenched
- 42CrMo4
- C45



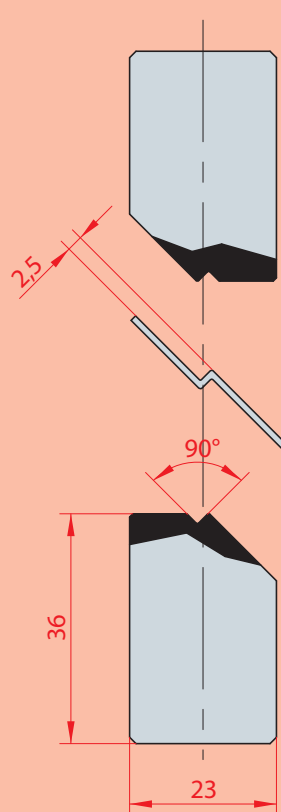
1276



1277



1274



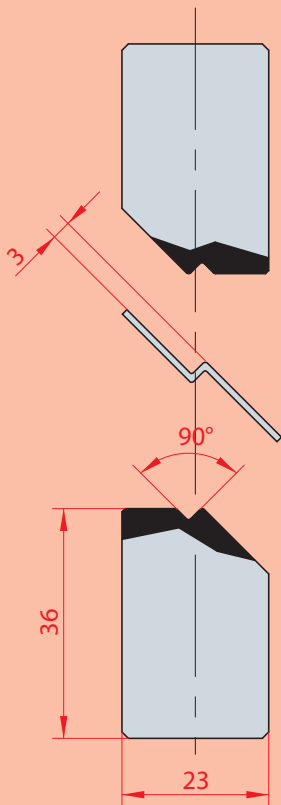
1275

INSERTI A Z - 90° / JOGGLE TOOLS - 90°

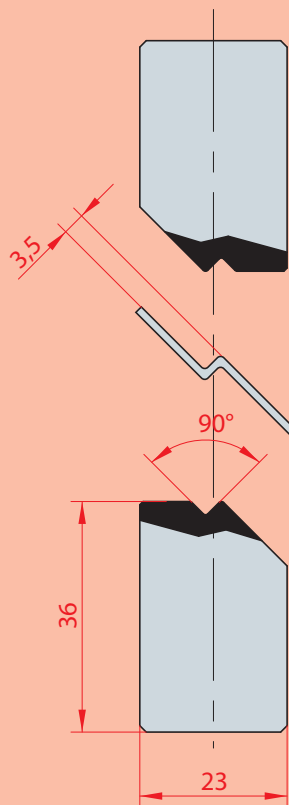
- C45 bonificato /quenched
- 42CrMo4
- C45

Per verificare la fattibilità della piega in base allo spessore lamiera, vedi tabella p. 159

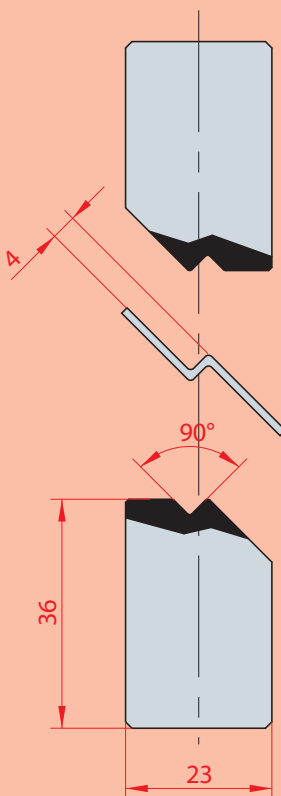
For choosing the right joggle tool with the sheet thickness please see the schedule on page 159



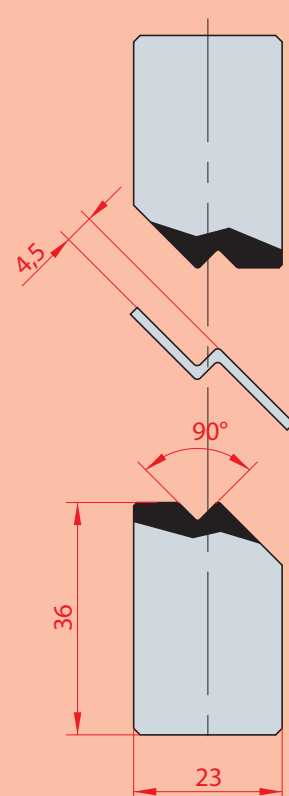
1134



1135



1136



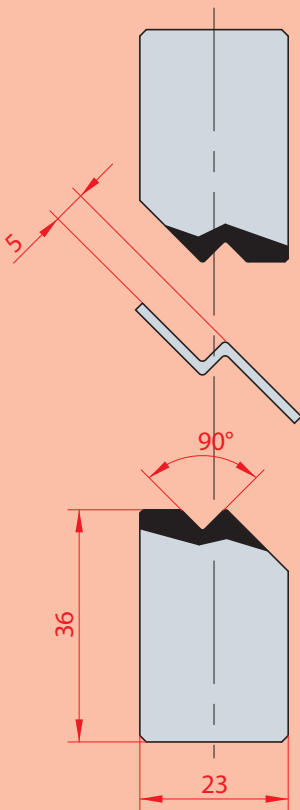
1137

INSERTI A Z - 90° / JOGGLE TOOLS - 90°

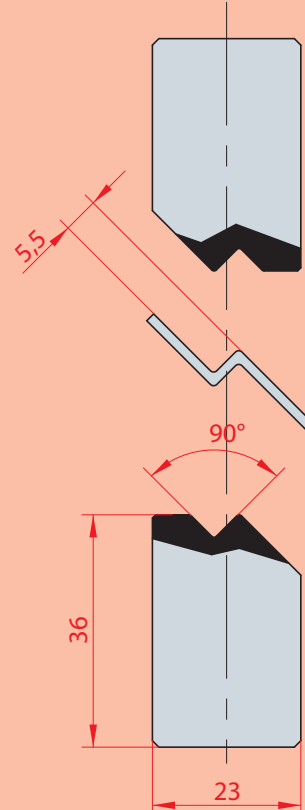
Per verificare la fattibilità della piega in base allo spessore lamiera, vedi tabella p. 159

For choosing the right joggle tool with the sheet thickness please see the schedule on page 159

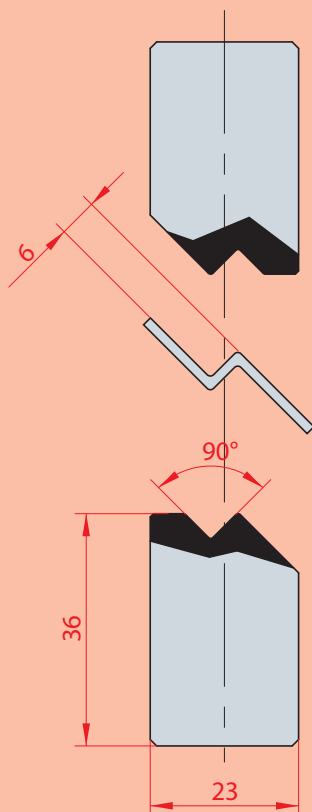
- C45 bonificato /quenched
- 42CrMo4
- C45



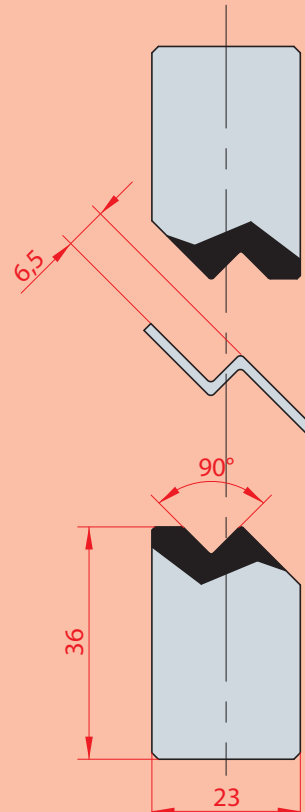
1138



1139



1140



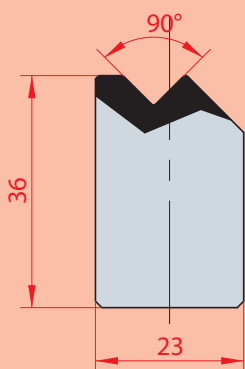
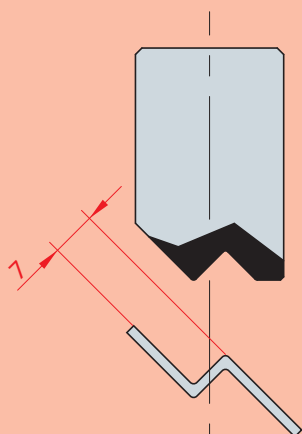
1141

INSERTI A Z - 90° / JOGGLE TOOLS - 90°

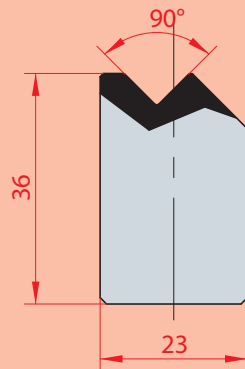
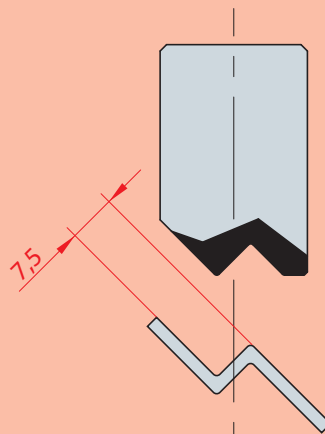
- C45 bonificato /quenched
- 42CrMo4
- C45

Per verificare la fattibilità della piega in base allo spessore lamiera, vedi tabella p. 159

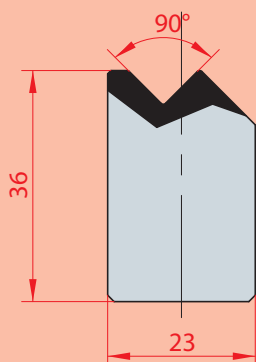
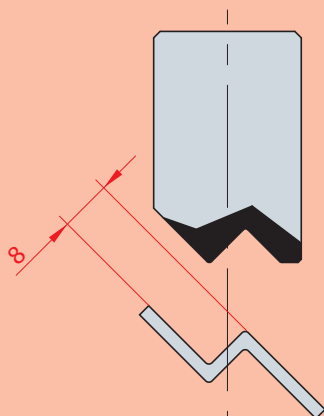
For choosing the right joggle tool with the sheet thickness please see the schedule on page 159



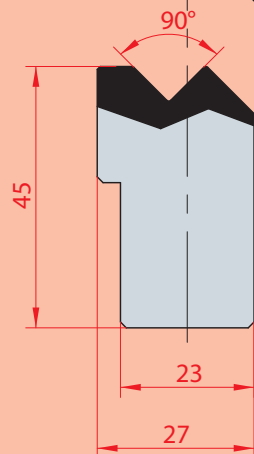
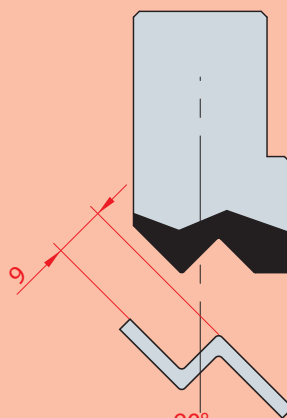
1142



1143



1144



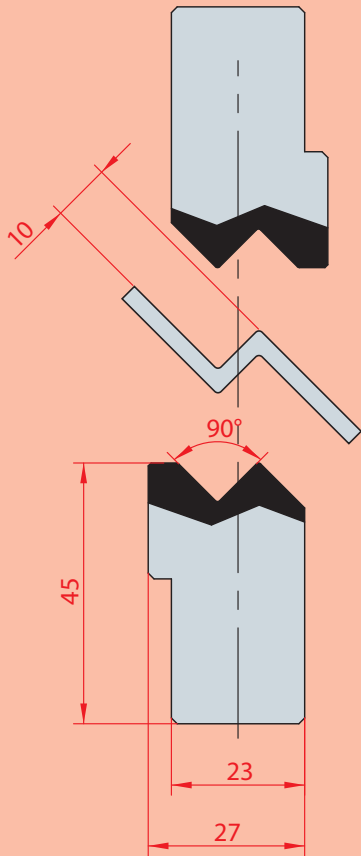
1145

INSERTI A Z - 90° / JOGGLE TOOLS - 90°

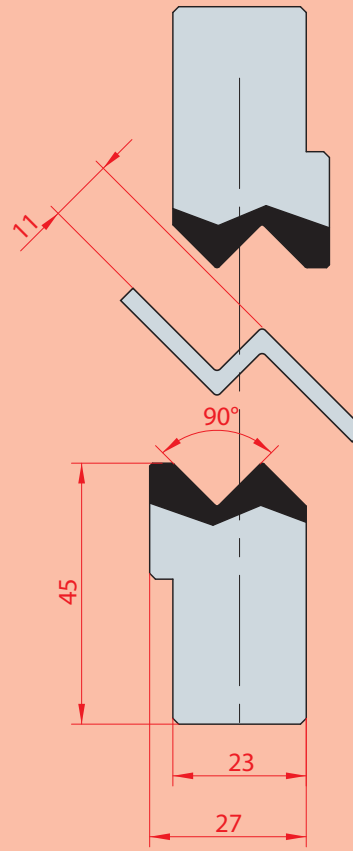
Per verificare la fattibilità della piega in base allo spessore lamiera, vedi tabella p. 159

For choosing the right joggle tool with the sheet thickness please see the schedule on page 159

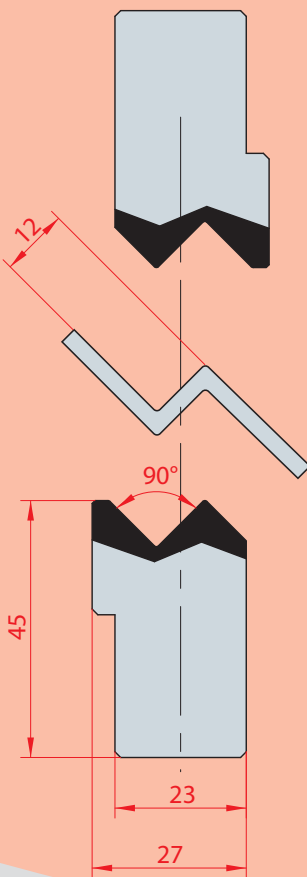
■	C45 bonificato /quenched
■	42CrMo4
■	C45



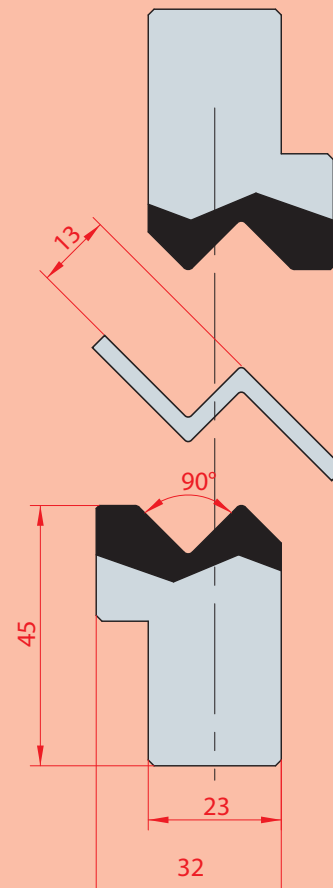
1146



1147



1148



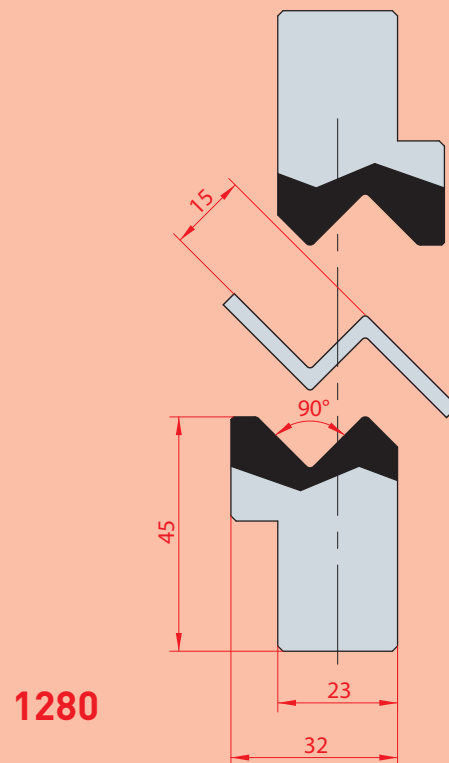
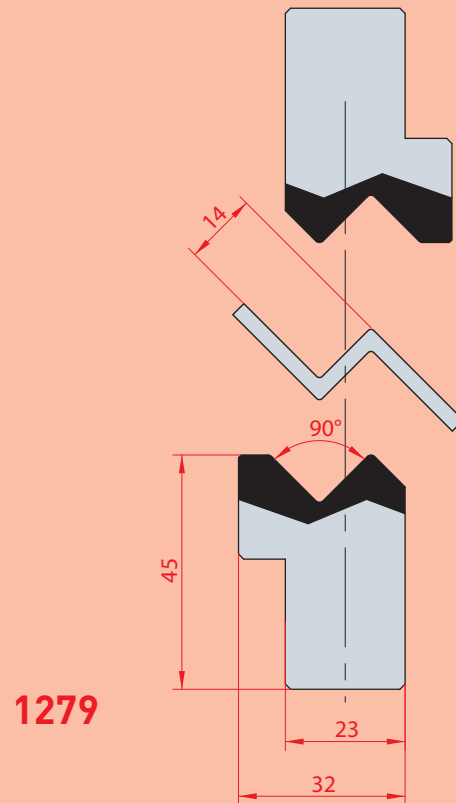
1278

INSERTI A Z - 90° / JOGGLE TOOLS - 90°

- C45 bonificato /quenched
- 42CrMo4
- C45

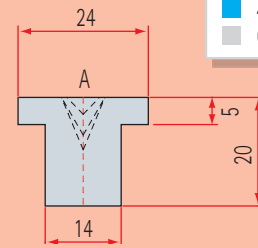
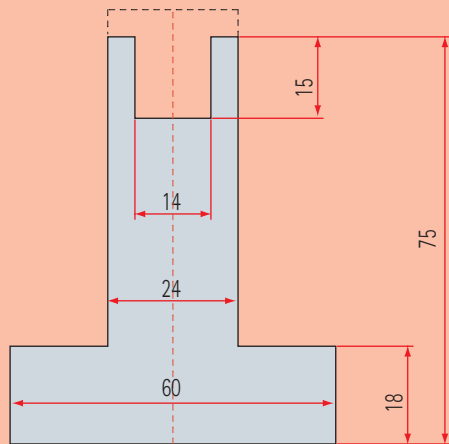
Per verificare la fattibilità della piega in base allo spessore lamiera, vedi tabella p. 159

For choosing the right joggle tool with the sheet thickness please see the schedule on page 159



CONTENITORI DI NYLON / NYLON INSERT AND HOLDERS

2109

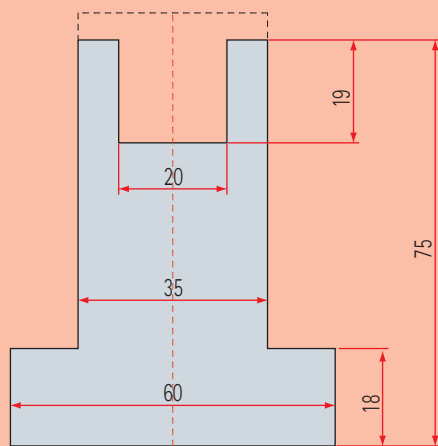


■ C45 bonificato /quenched
■ 42CrMo4
■ C45

2112

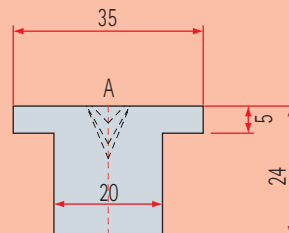
A	V		
88°	6	8	10
60°	6	8	10
45°	6	8	10
30°	6	8	

2110



2113

A	V				
88°	6	8	10	12	16
60°	6	8	10	12	16
45°	6	8	10	12	
30°	6	8	10		

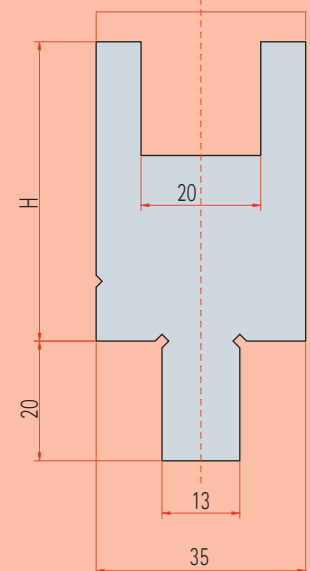


2115

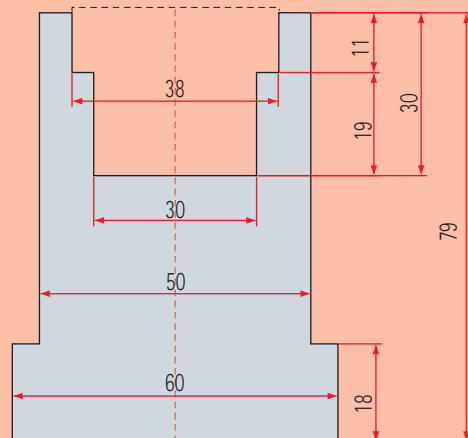
H 50

2116

H 95

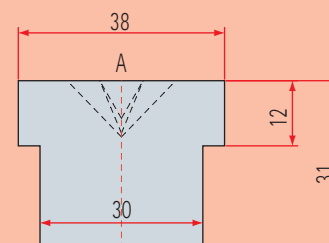


2111



2114

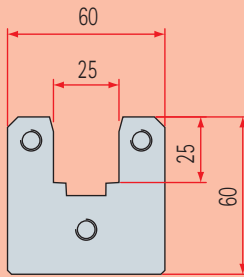
A	V						
88°	6	8	10	12	16	20	25
60°	6	8	10	12	16	20	
45°	6	8	10	12	16	20	
30°	6	8	10	12	16		



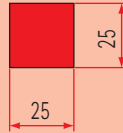
CONTENITORI E INSERTI IN POLIURETANO / HOLDERS AND POLYURETHANE INSERTS

- C45 bonificato /quenched
- 42CrMo4
- C45

2036

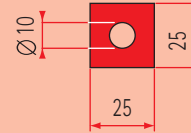


2101

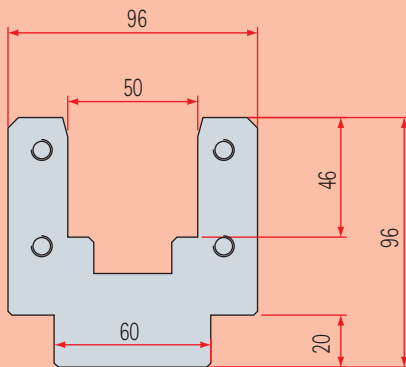


92 shore

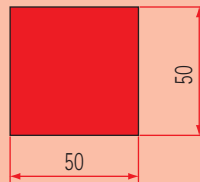
2105



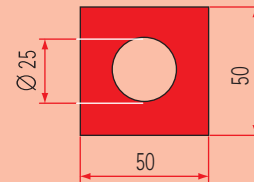
2037



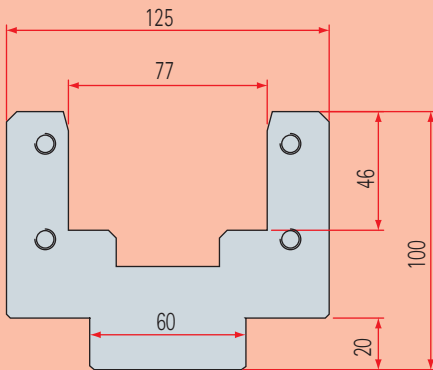
2102



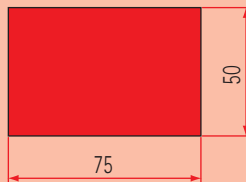
2106



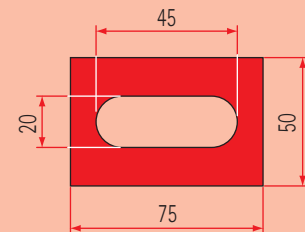
2038



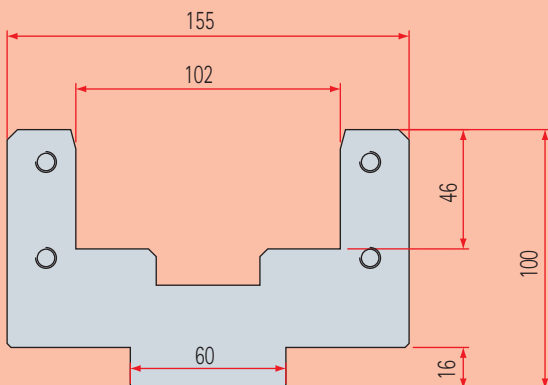
2103



2107



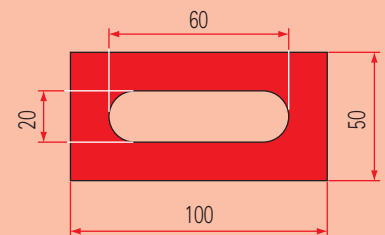
2040



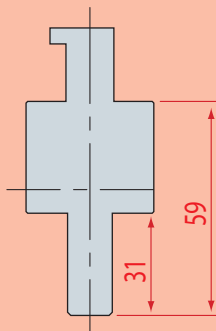
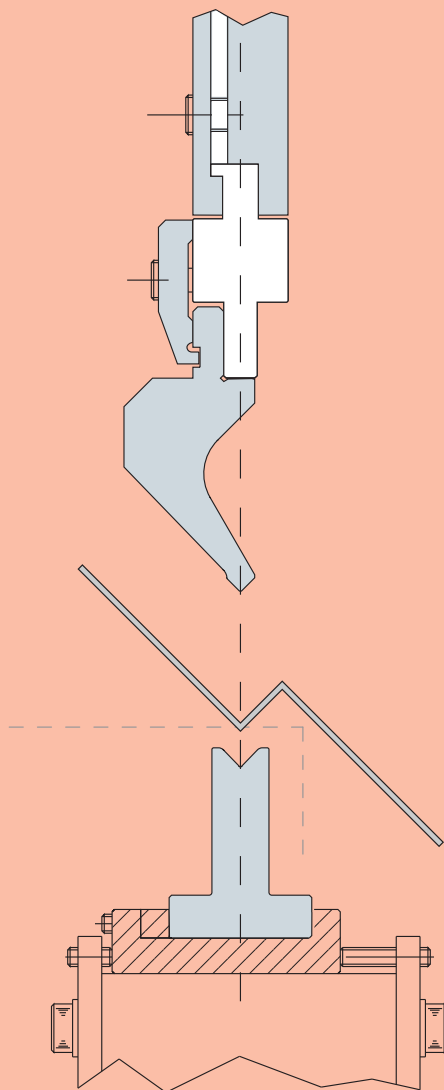
2104



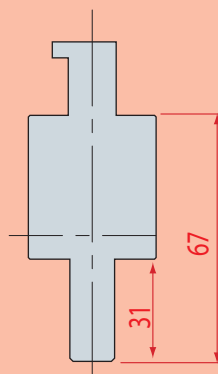
2108



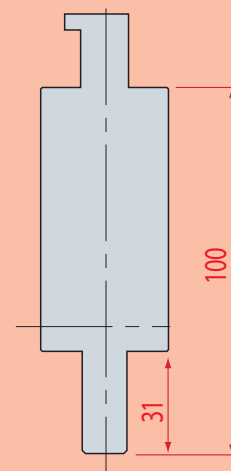
ADATTATORI PER UTENSILI AMADA-PROMECAM SU TUTTI I TIPI DI PRESSE
ADAPTORS TO FIT AMADA-PROMECAM TOOLS SUITABLE FOR ANY TYPE OF PRESS BRAKE



cod. 4000
L = 150 mm

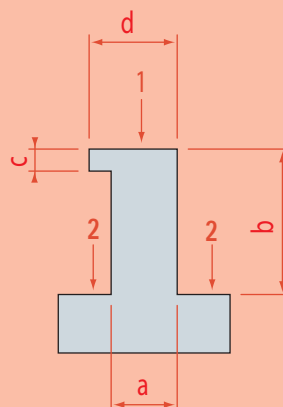


cod. 4001
L = 150 mm



cod. 4002
L = 150 mm

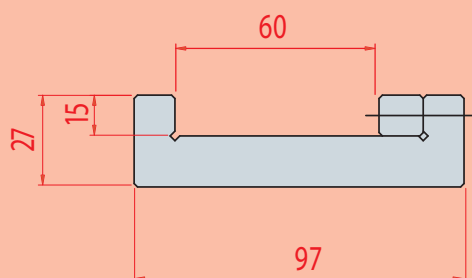
	1	2
a =		
b =		
c =		
d =		



Indicare quote
d'attacco e
punto di spinta.

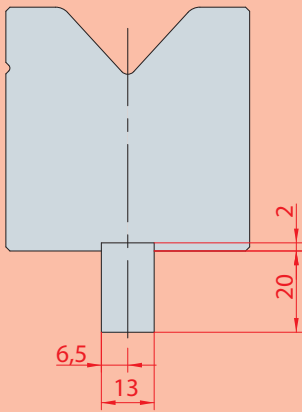
Please mark
contact points
and pressure
points.

Ordine minimo n. 5 intermediari
Minimum order n. 5 intermediates

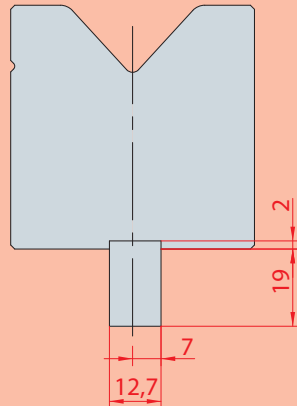


- cod. 9010** 2100 mm
- cod. 9011** 2600 mm
- cod. 9012** 3100 mm
- cod. 9013** 4100 mm

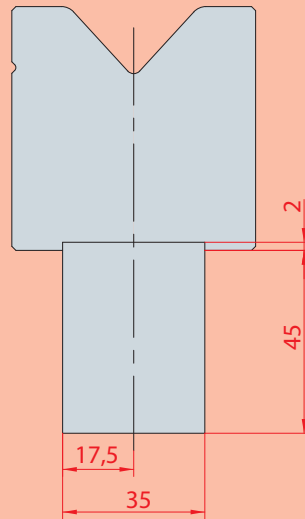
ATTACCHI SU RICHIESTA - SCANALATURE DI SICUREZZA / SAFETY GROOVES



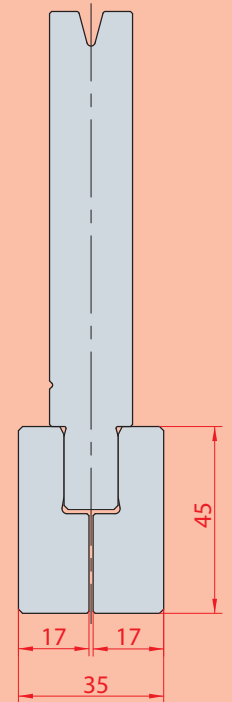
8100
BEYELER-TRUMPF



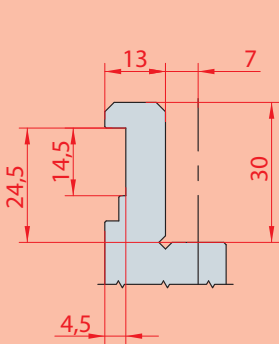
8101
LVD



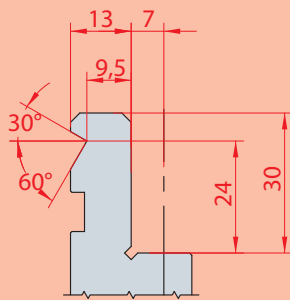
8102
WEINBRENNER



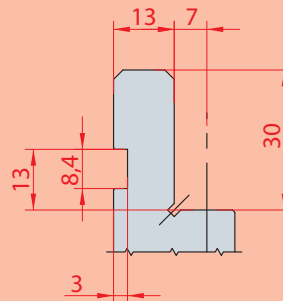
8105
WEINBRENNER



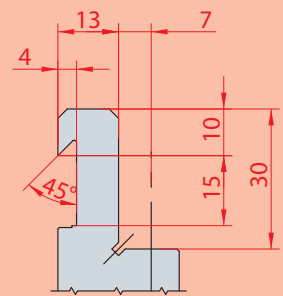
8010
BARRETTA



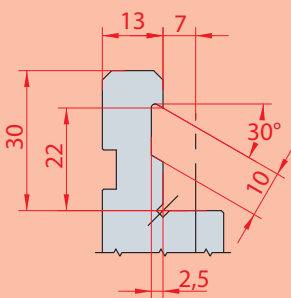
8011
BMB



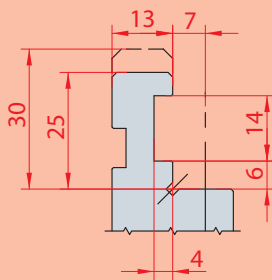
8012
AMADA-PROMECAM



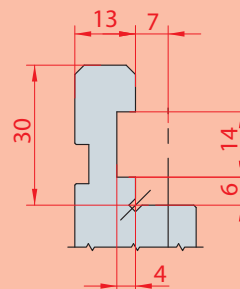
8013
GASPARINI



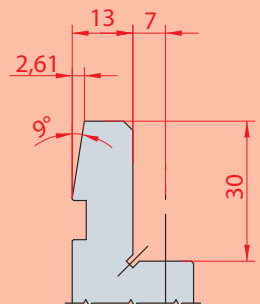
8014
TEDA



8016
EURO BEYELER



8017
BEYELER

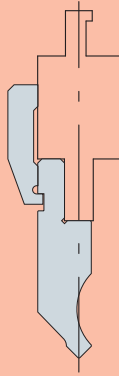
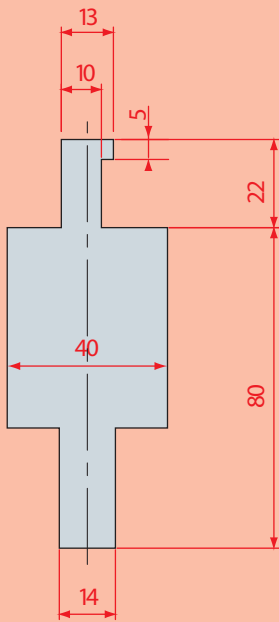


8020
ONE TOUCH

ADATTATORI / ADAPTORS

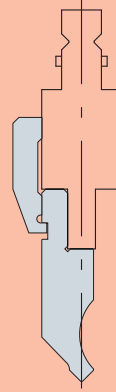
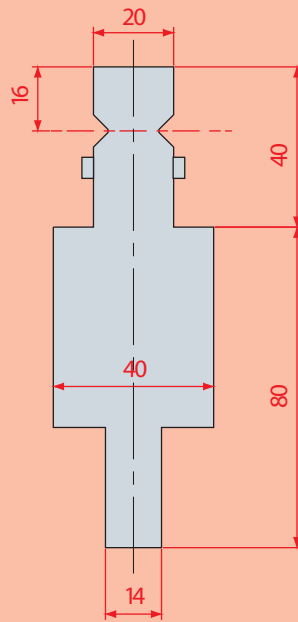
4143

L=150 mm
LVD



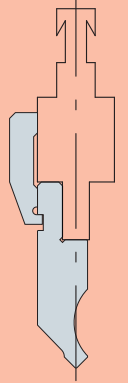
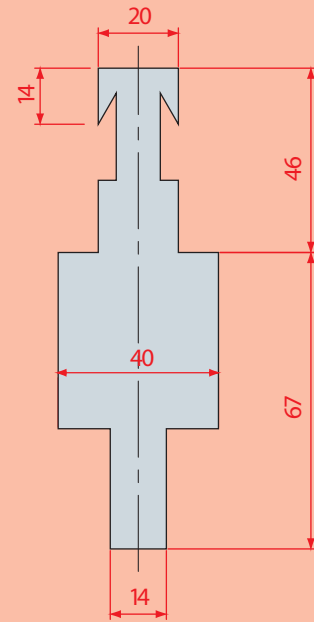
4191

L=150 mm
WILA/TRUMPF



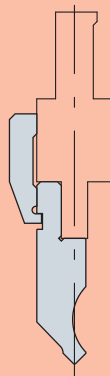
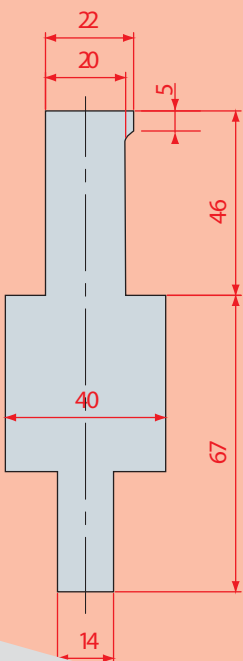
4192

L=150 mm
BEYELER-R



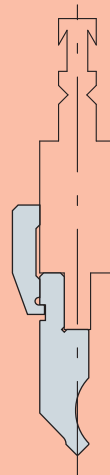
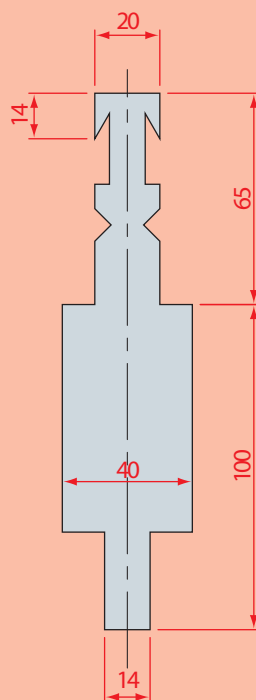
4193

L=150 mm
BEYELER-S



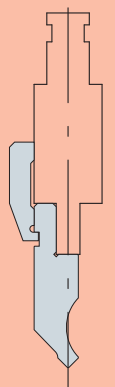
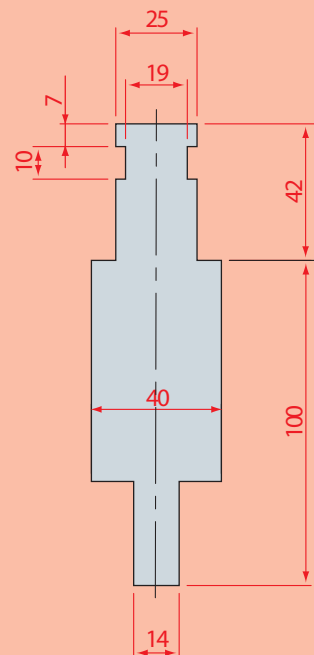
4214

L=150 mm
BEYELER-RF-A



4215

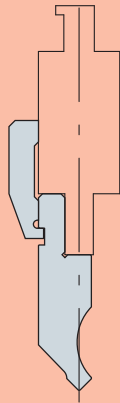
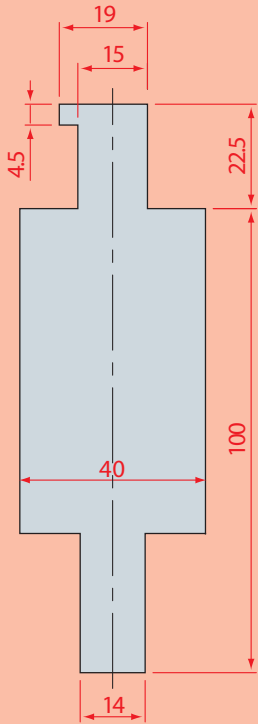
L=150 mm
WEINBRENNER



ADATTATORI / ADAPTORS

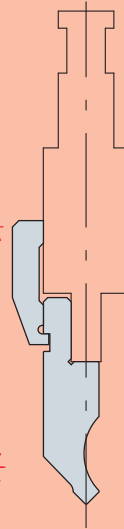
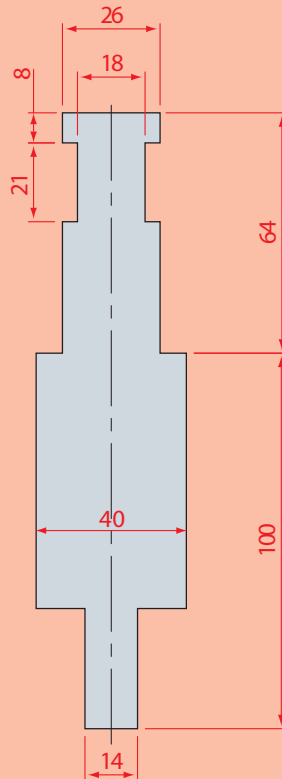
4216

L=150 mm
CBC



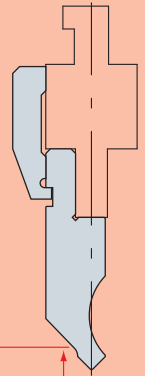
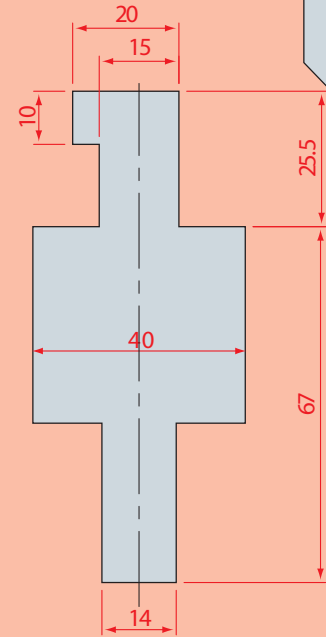
4217

L=150 mm
EHT



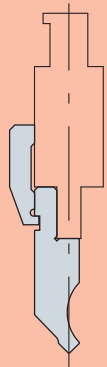
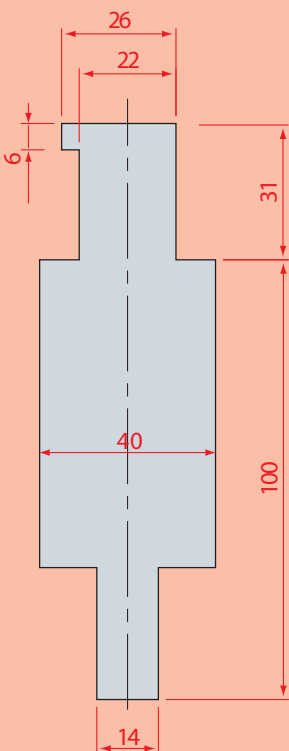
4218

L=150 mm
DURMAZLAR



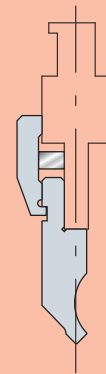
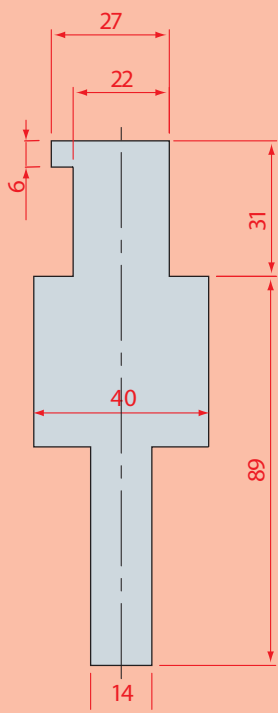
4229

L=150 mm
DARLEY



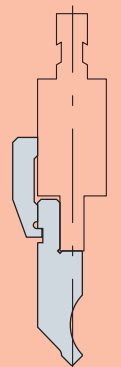
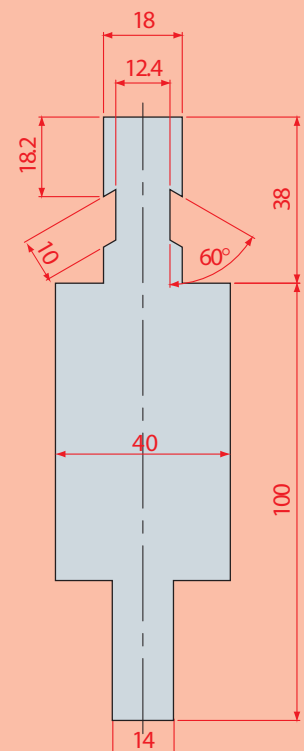
4272

L=150 mm
BAYKAL

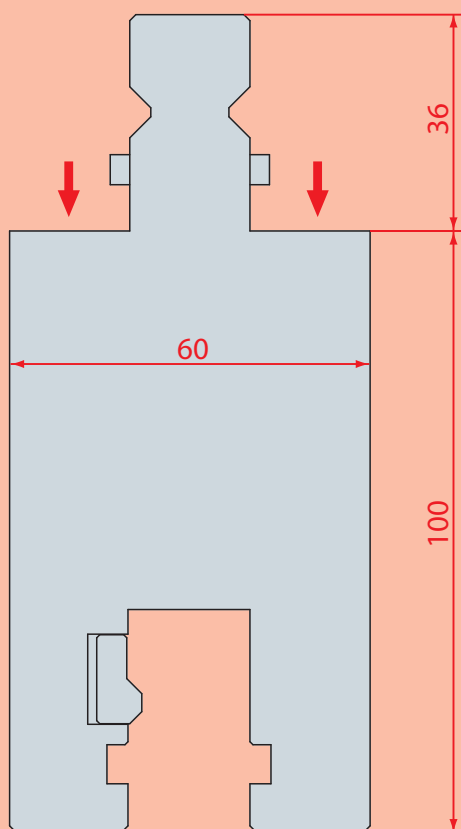


4273

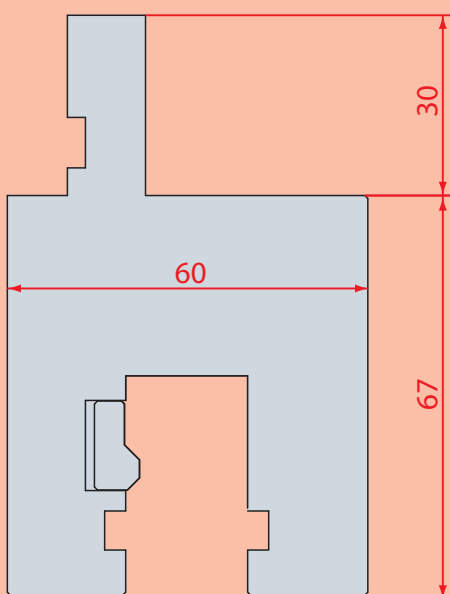
L=150 mm
COLGAR



ADATTATORI / ADAPTORS



4361
H100 L=150
PROLUNGA / EXTENSION
TRUMPF/TRUMP



4362
H67 L=150
ADATTATORE / ADAPTOR
AMADA/TRUMPF

BLOCCAGGIO RAPIDO / NEW CLAMPING SYSTEM

4353

LEVETTA DI BLOCCAGGIO / LEVER

PULSANTE PER INSERIMENTO FRONTALE / PUSH BOTTOM



Bloccaggio inserimento frontale con pulsante, Attacco Promecam, H=100mm, Spessore 27mm, L=150mm completo di Intermediario registrabile, senza modifica dell' attacco

Adjustable Intermediate, Type Promecam, H=100mm, large 27mm, L=150mm, for clamping the tools frontal ideal and easy for segmented tools, without modification of the safety groove !!!!!

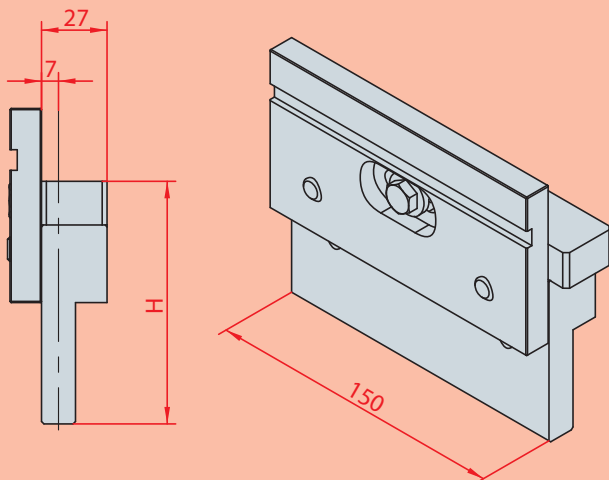
4355



Bloccaggio inserimento laterale, Attacco Promecam, H=100mm, Spessore 27mm, L=150mm completo di Intermediario registrabile, senza modifica dell' attacco

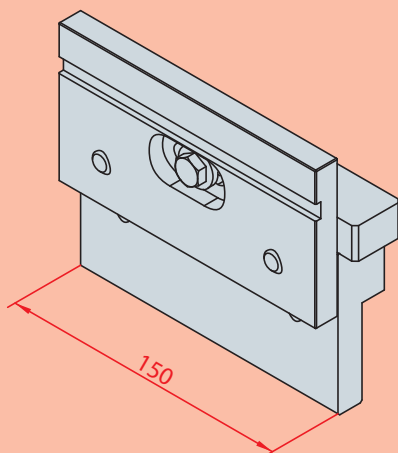
Adjustable Intermediate, Type Promecam, H=100mm, large 27mm, L=150mm, for clamping the tools lateral ideal and easy for segmented tools, without modification of the safety groove !!!!!
Move the lever and you fix the tools easily

INTERMEDIARI REGISTRABILI / ADJUSTABLE INTERMEDIATES



4221

H=100 mm

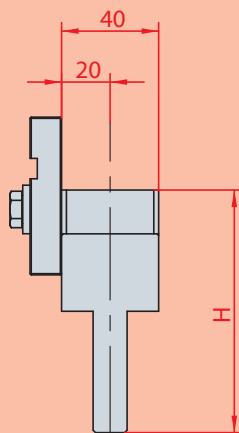


4222

H=120 mm

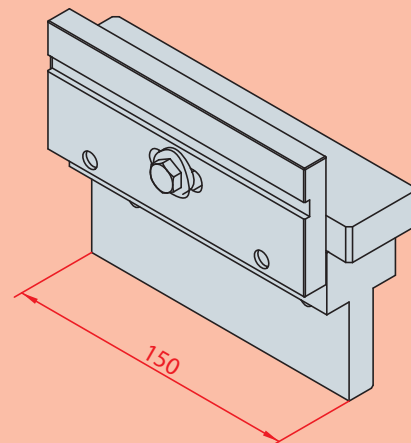
4223

H=150 mm



4224

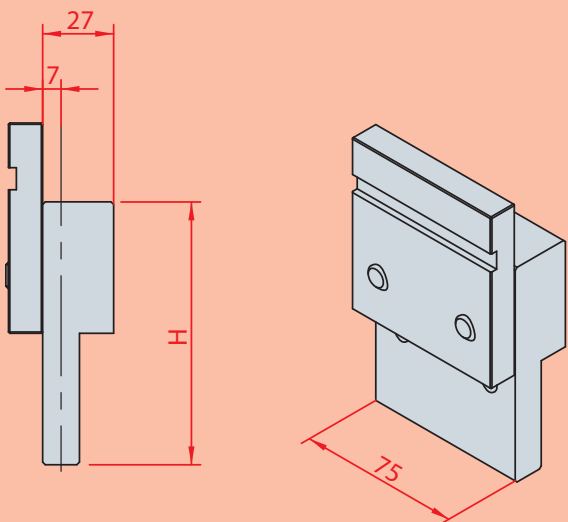
H=100 mm



4225

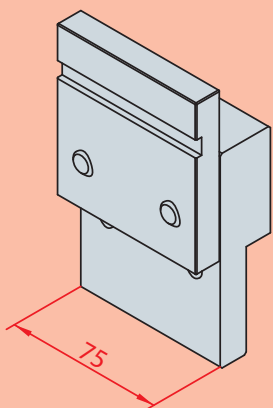
H=120 mm

INTERMEDIARI FISSI / RETROFITTING



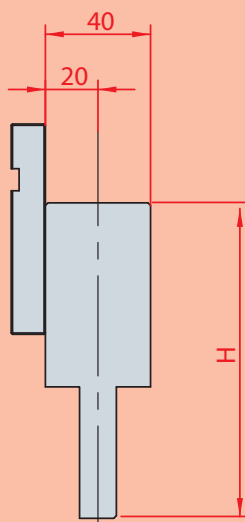
4226

H=100 mm



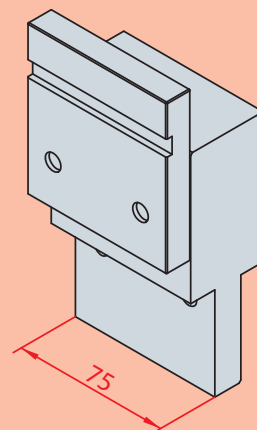
4227

H=150 mm



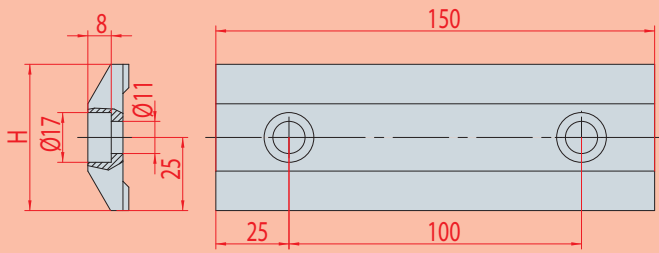
4228

H=120 mm

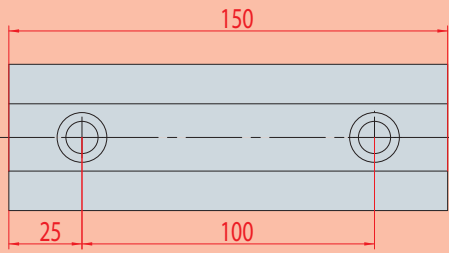


STAFFE / CLAMPS

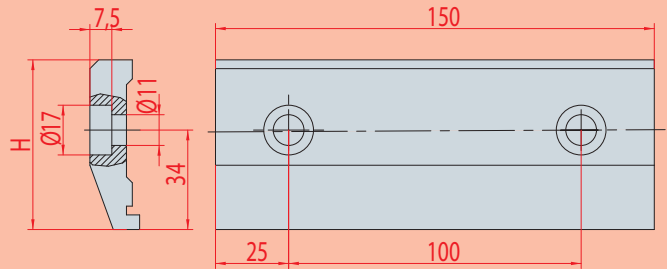
Le viti sono incluse solo con l'acquisto della staffa assieme ad un intermediario
Screws are only included together with the intermediate

**4016**

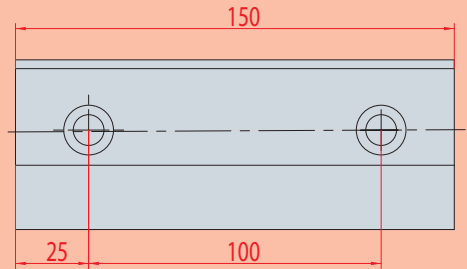
H=50mm

**5013**

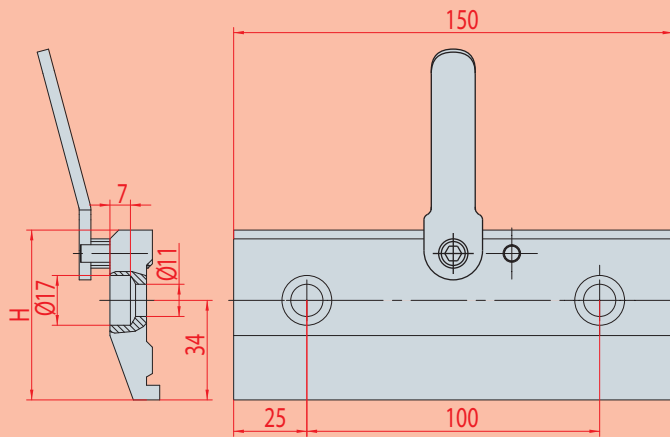
H=43mm

**4020**

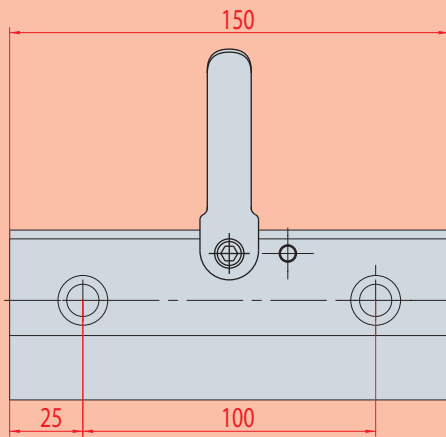
H=58mm

**5012**

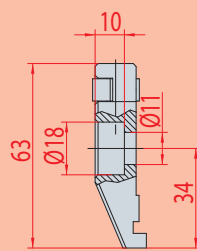
H=52mm

**4021**

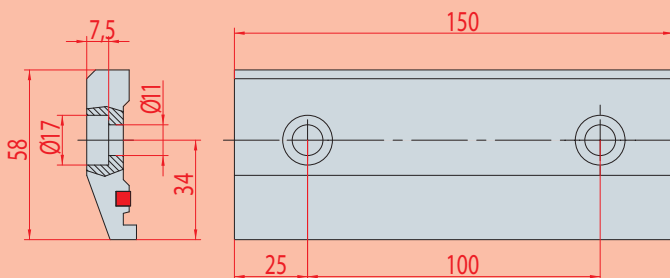
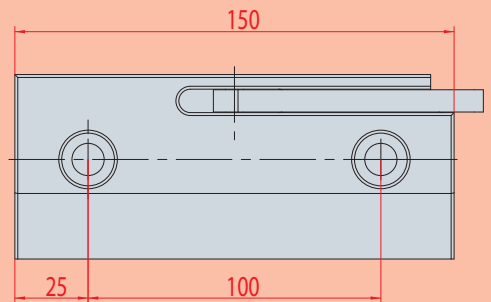
H=58mm

**5011**

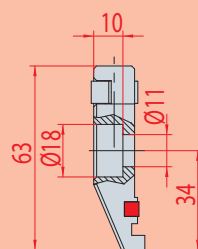
H=52mm

**4009**

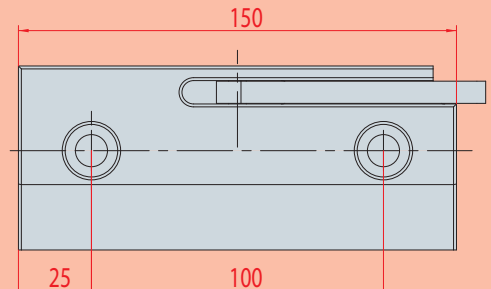
H=63mm

**4199**

H=58mm

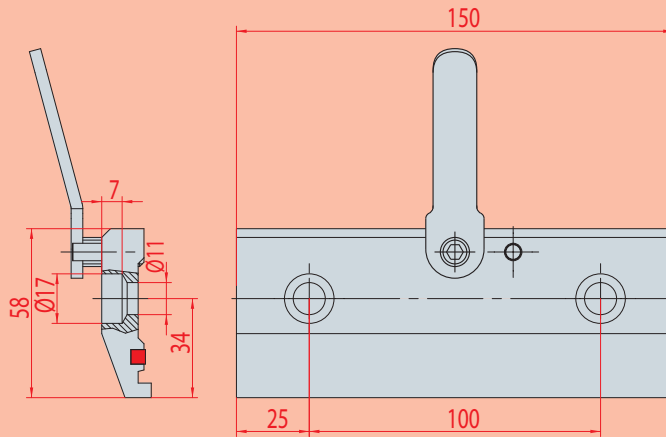
**4220**

H=63mm



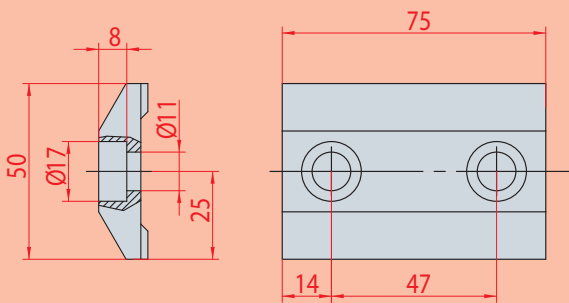
STAFFE / CLAMPS

Le viti sono incluse solo con l'acquisto della staffa assieme ad un intermediario
Screws are only included together with the intermediate

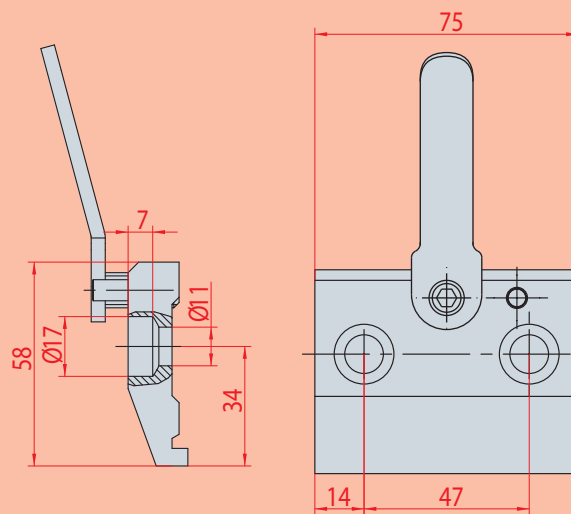
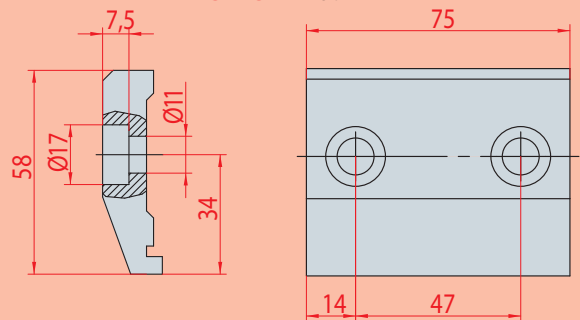


4219
H=58mm

4008 H=50mm



4090 H=58mm

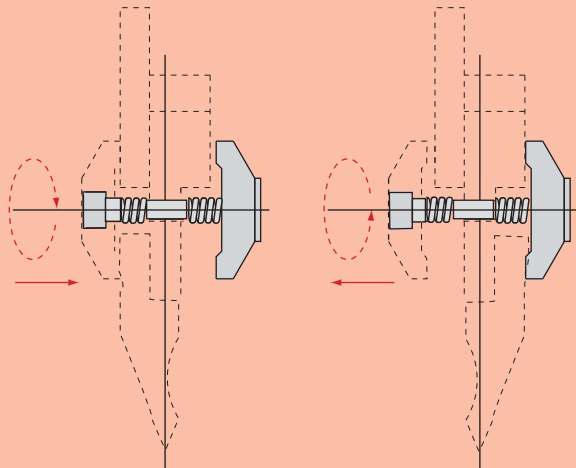
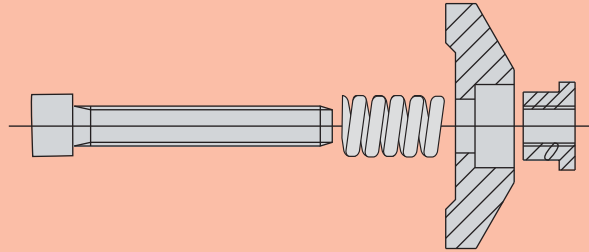


4007 H=58mm

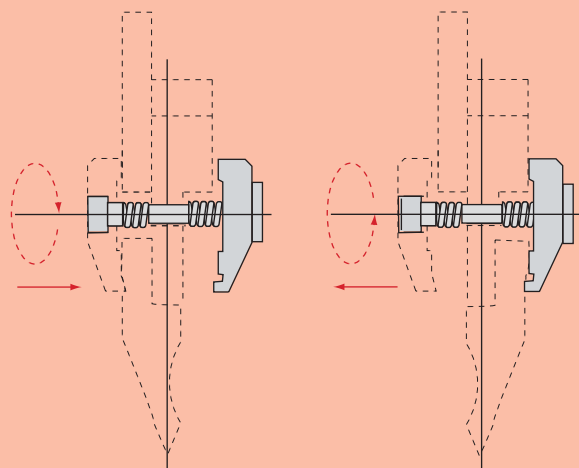
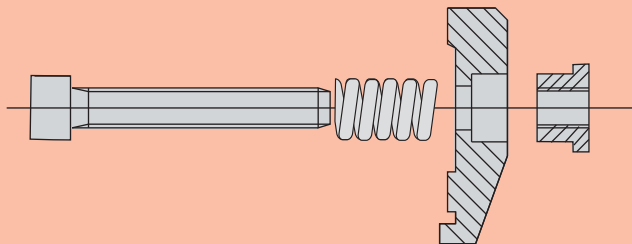
STAFFE / CLAMPS

Le viti sono incluse solo con l'acquisto della staffa assieme ad un intermediario
Screws are only included together with the intermediate

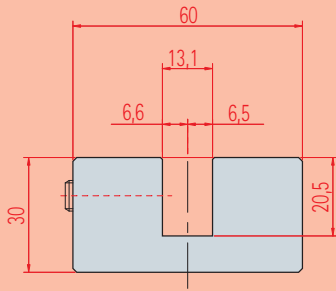
Kit per doppio staffaggio / Equipment for double clamping

**4031**

Kit per doppio staffaggio / Equipment for double clamping

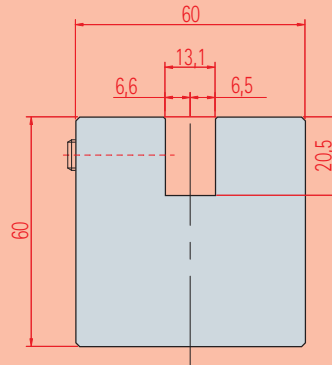
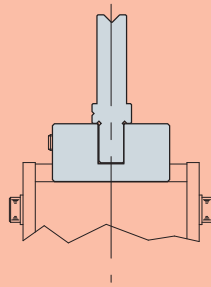
**4032**

ADATTATORE INFERIORE / LOWER ADAPTER



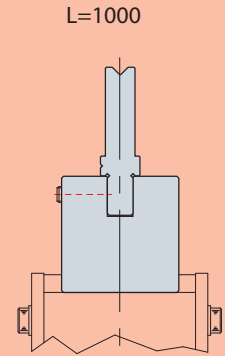
4301

L = 1000 mm
L = 500 mm
AMADA-BEYELER/TRUMPF

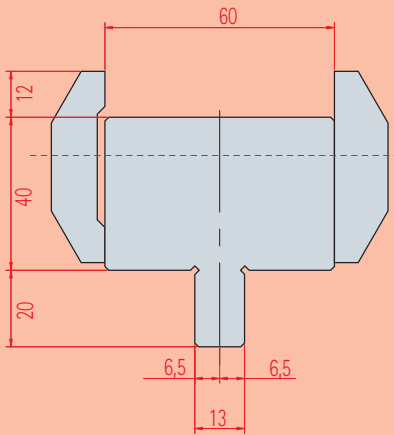


4302

L = 1000 mm
L = 500 mm
AMADA-BEYELER/TRUMPF

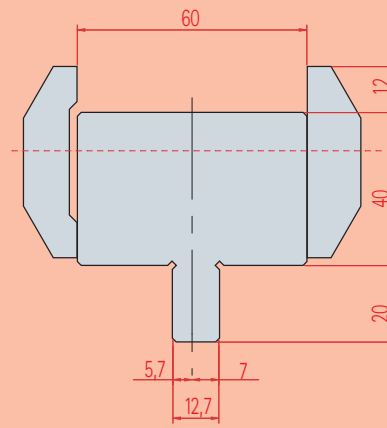
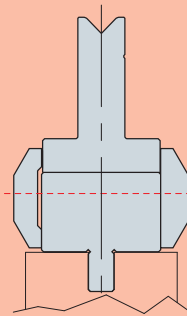


L=1000



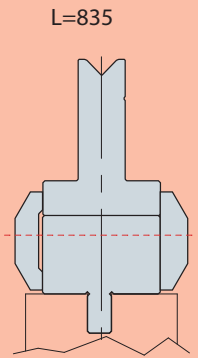
4303

L = 835 mm
L = 415 mm
BEYELER/TRUMPF - AMADA

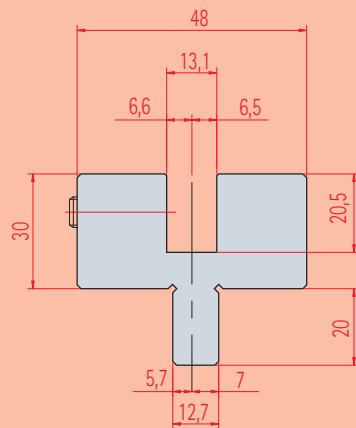


4304

L = 835 mm
L = 415 mm
LVD - AMADA

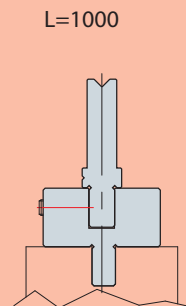


L=835



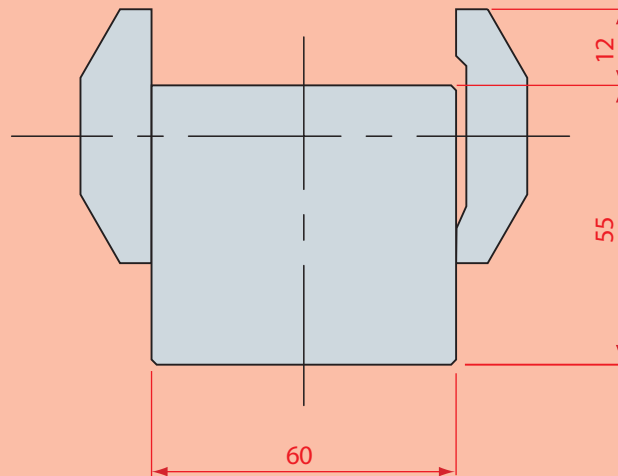
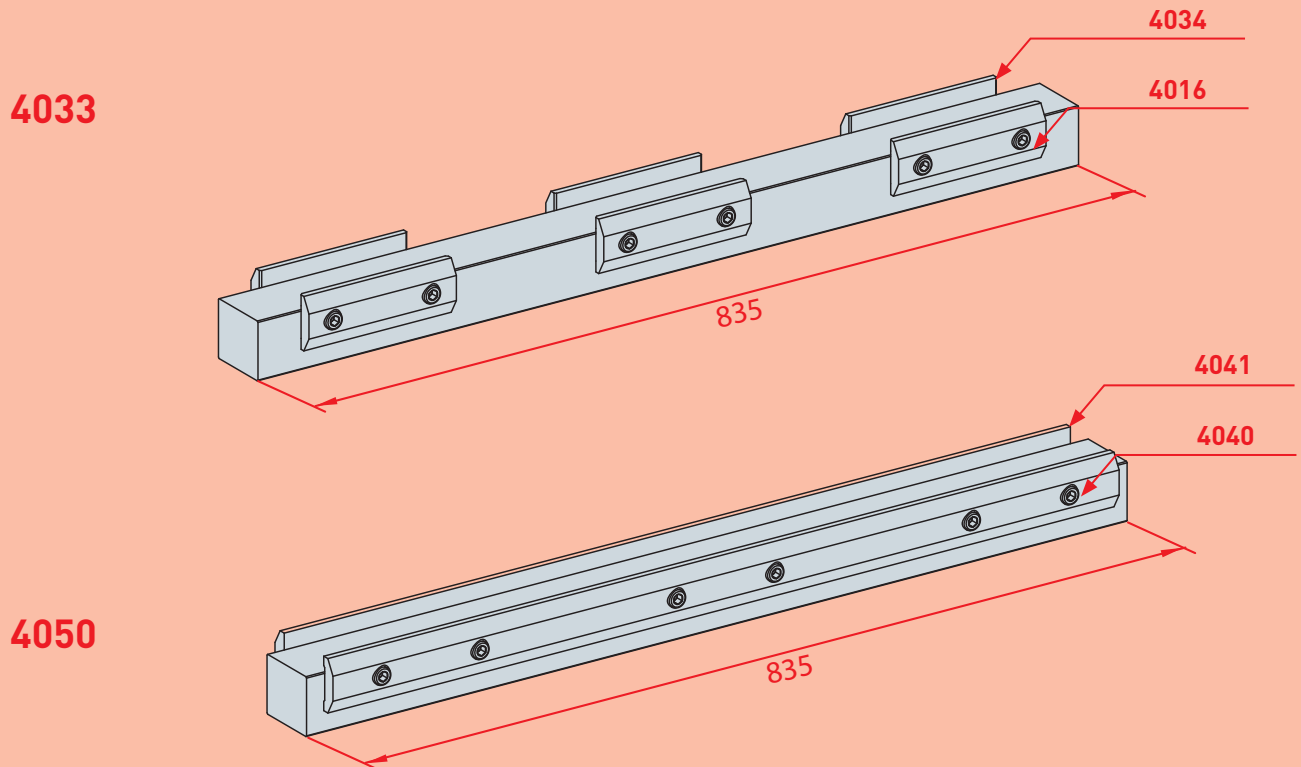
4305

L = 1000 mm - L = 500 mm
LDV-BEYELER/TRUMPF



L=1000

ADATTATORE INFERIORE / LOWER ADAPTER

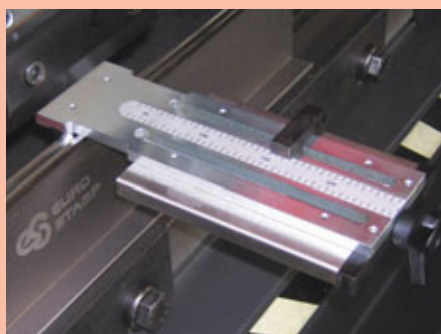
**4033**

L = 835 mm
 Controtavola AMADA
 Lower adapter

4050

L = 835 mm
 Controtavola AMADA
 Lower adapter

ACCESSORI / ACCESSORIES



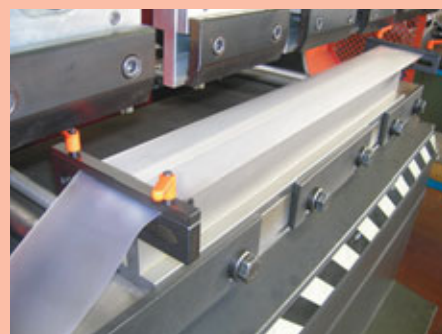
4306

squadre di riferimento
reference square



4307

squadre di riferimento orientabile
adjustable reference square



4309

tenditori
couple of tighteners

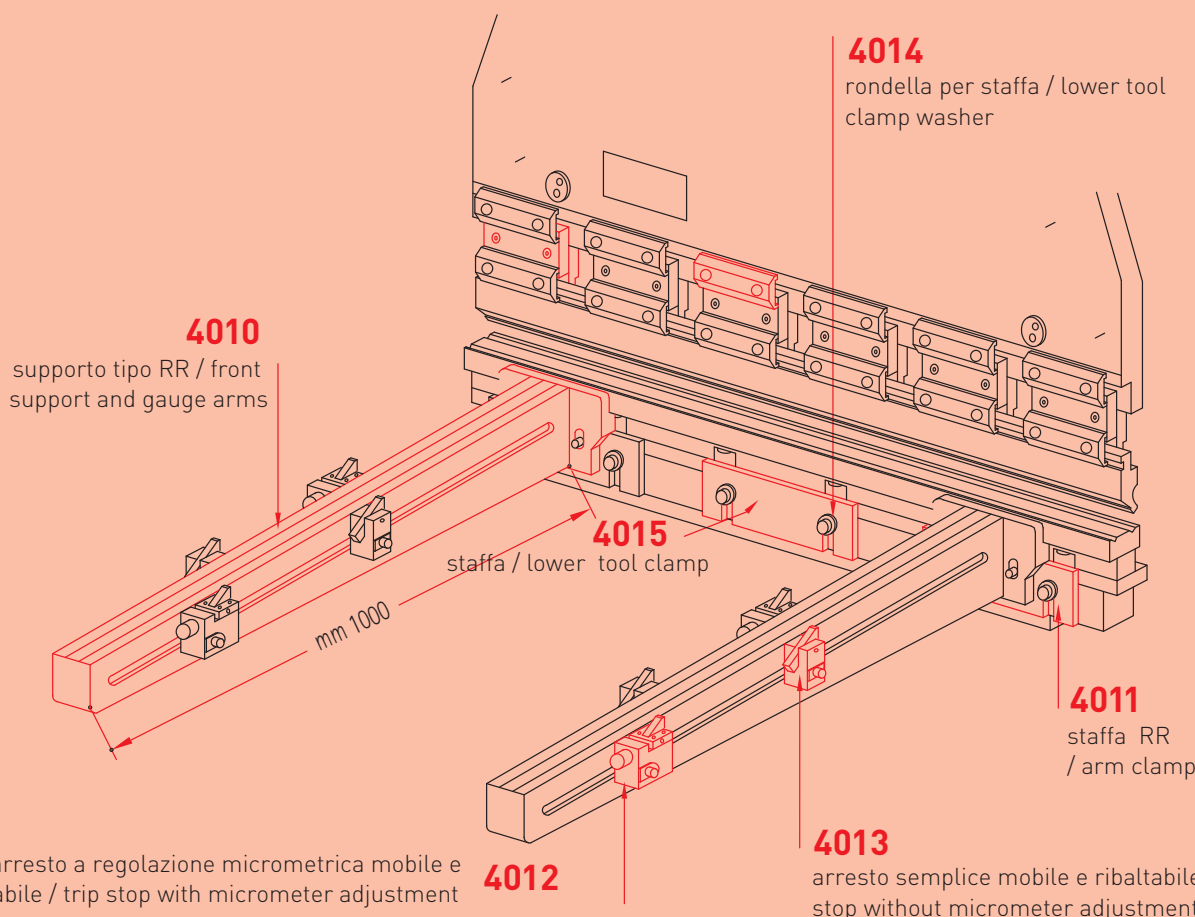


4308

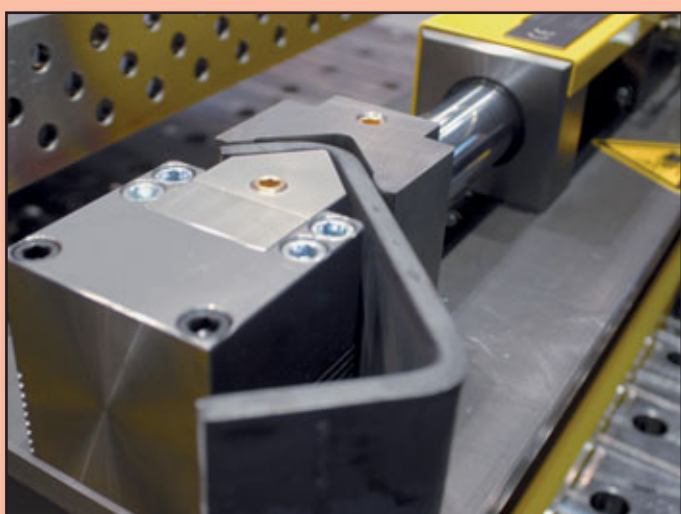
pellicola di poliuretano antigraffio
100x0,5 mm di spessore
film of polyurethane antiscratch
100 x 0,5 of thickness L = 30 mt

4314

pellicola di poliuretano antigraffio
100x0,8 mm di spessore
film of polyurethane antiscratch
100x0,8 of thickness L = 30 mt

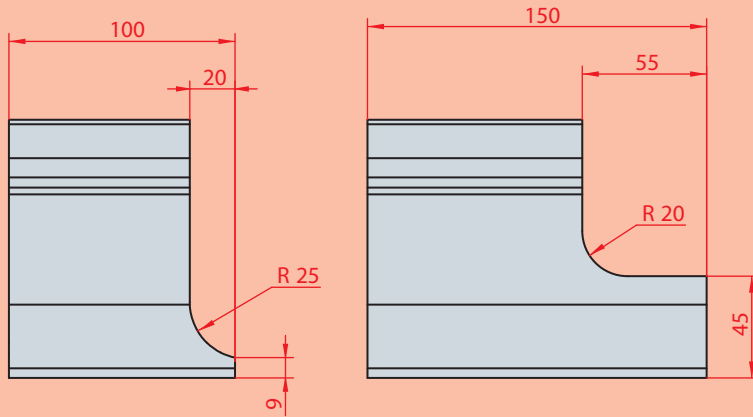


PRESSA ORIZZONTALE / HORIZONTAL PRESS



MODIFICHE A RICHIESTA / MODIFICATION ON REQUEST

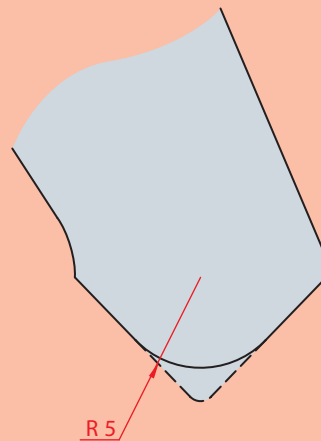
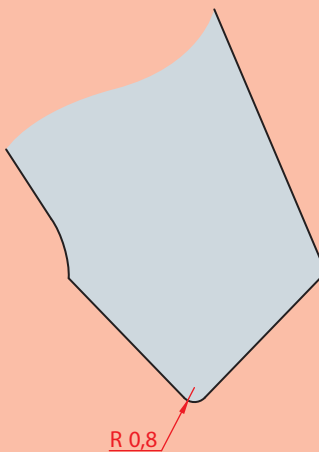
- C45 bonificato /quenched
- 42CrMo4
- C45



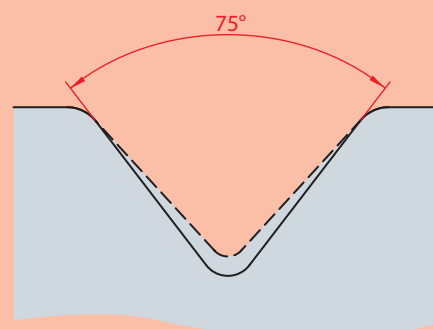
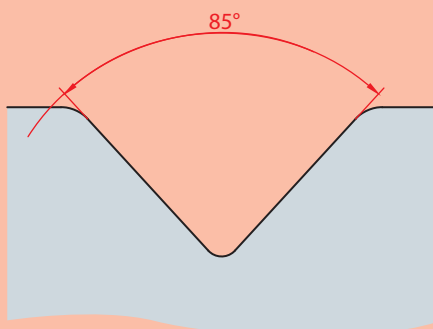
**SCARPETTE SPECIALI/
SPECIAL HORNS**



**TAGLI A RICHIESTA /
SPECIAL SECTIONING**

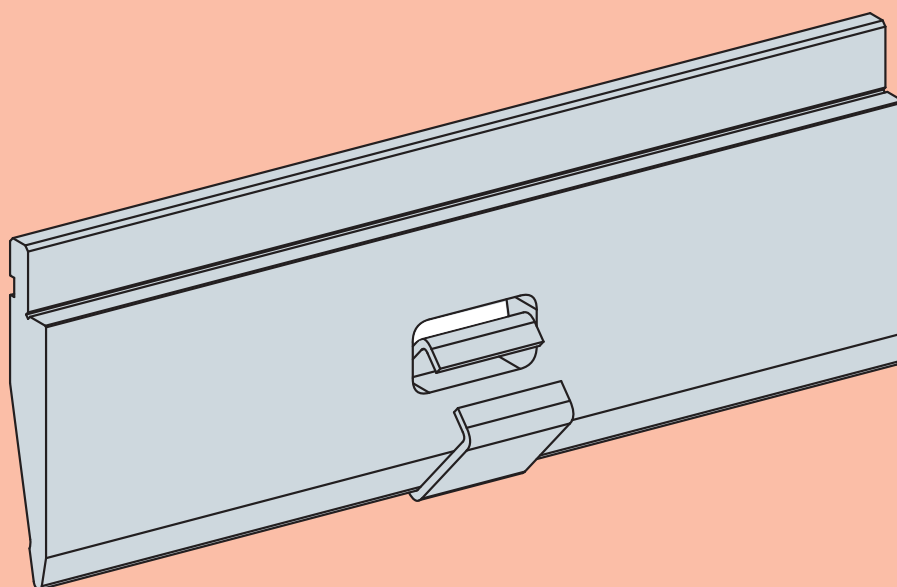
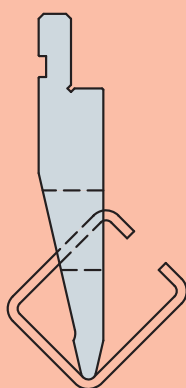
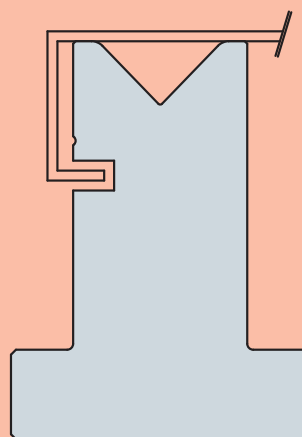
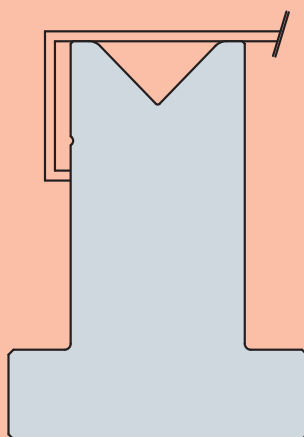
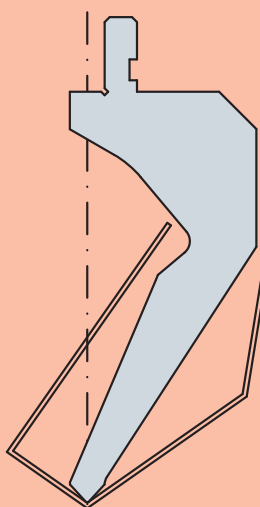
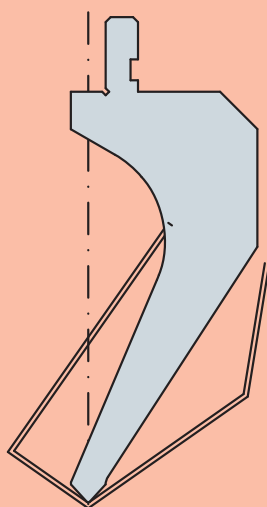


**MODIFICA RAGGIO/
MODIFICATION RADIUS**

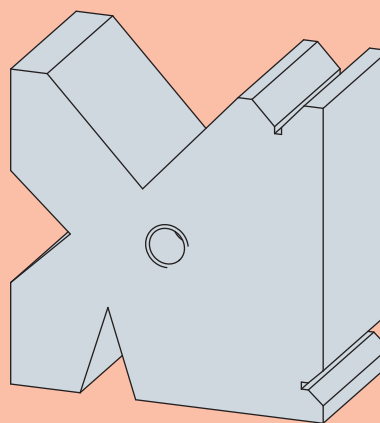
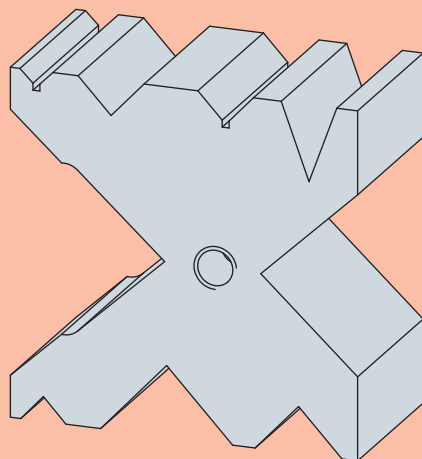
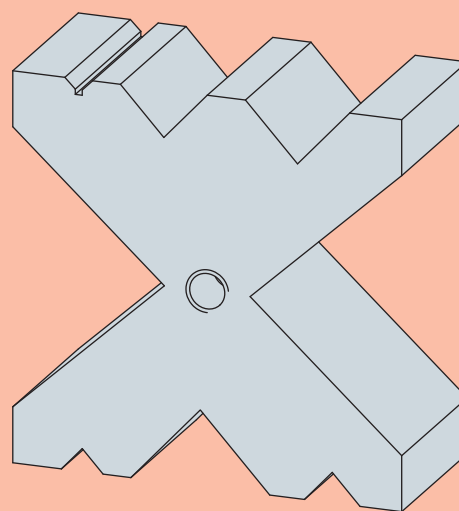
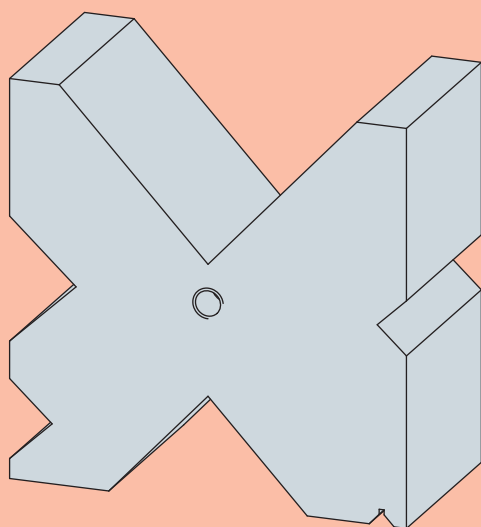
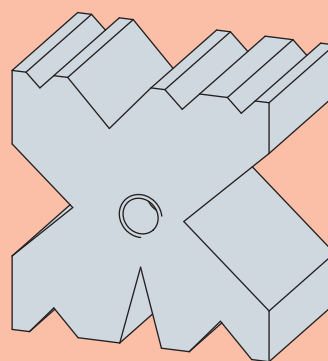
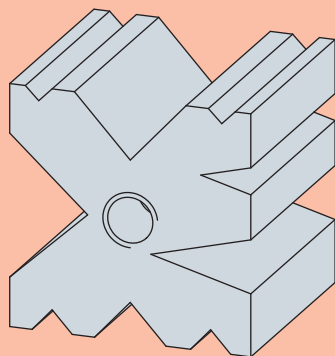


**MODIFICA ANGOLO/
MODIFICATION ANGLES**

SCARICO STAMPI / MODIFICATION PUNCHES-DIES



MATRICI MULTICAVA A RICHIESTA / MULTI V DIES ON REQUEST

**Materiali / Material:**

1.2312
C45
42CrM04

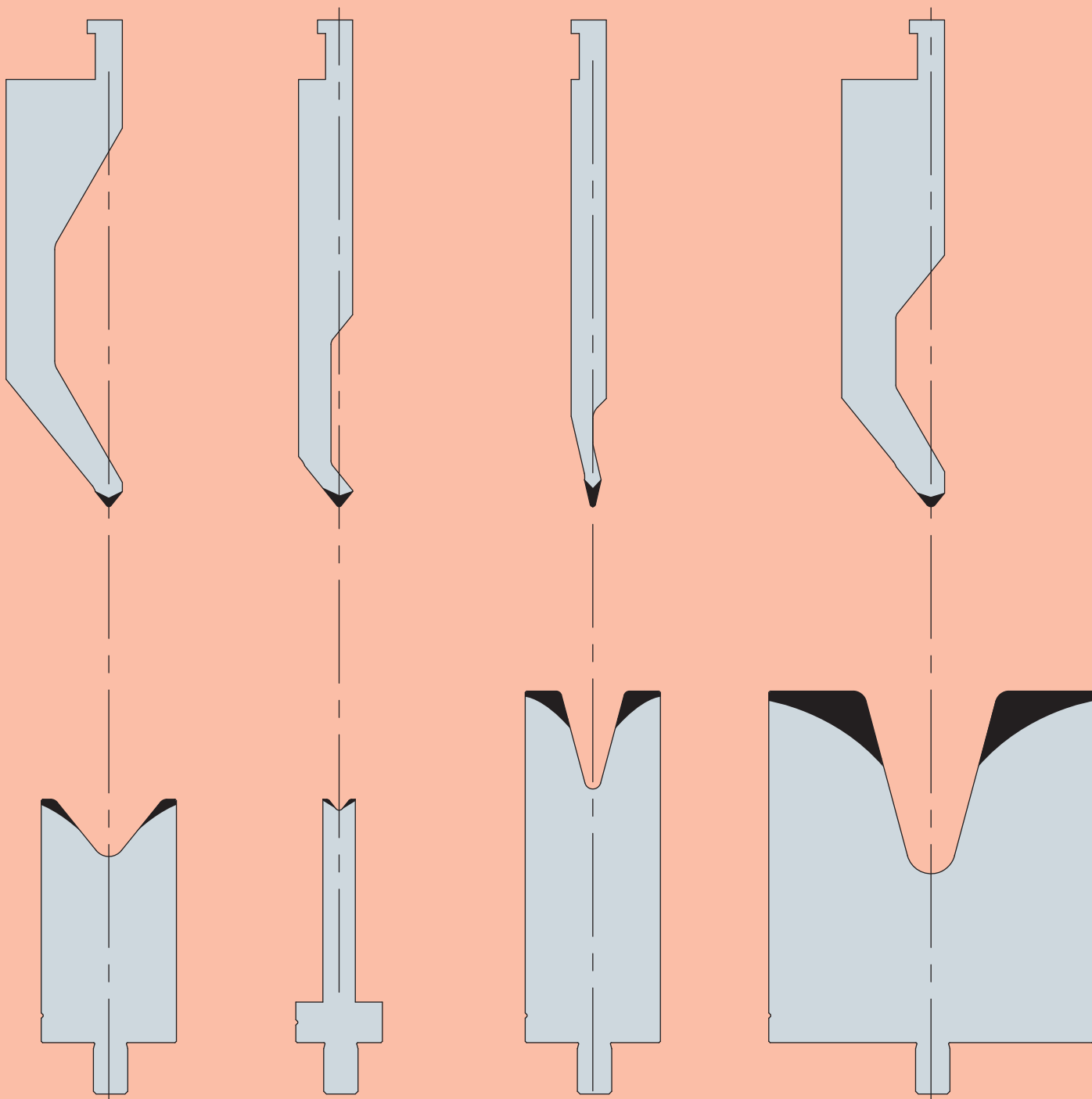
Lavorazioni / Working:

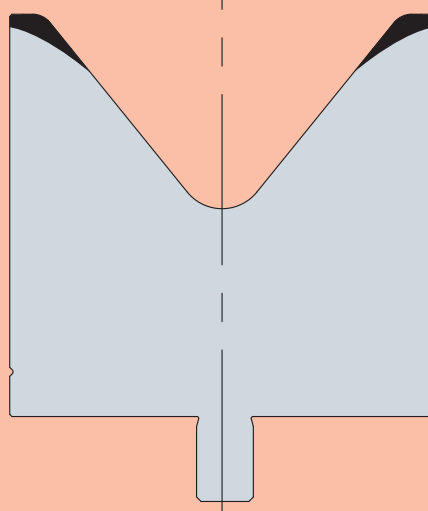
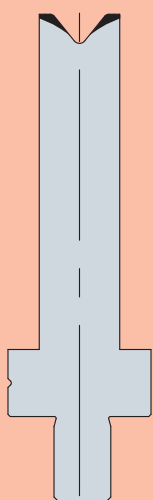
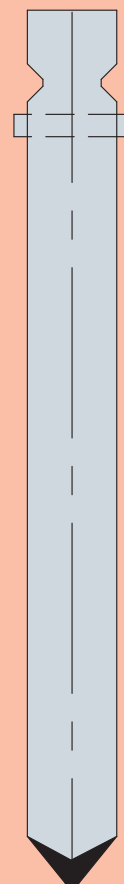
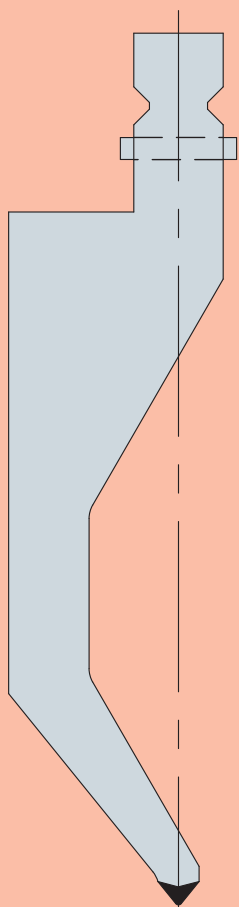
Temprato / Hardened
Bonificato nitrurato /
Quenched-nitrided
Piallato / Planed
Rettificato / Grounded

Lunghezze / Length (mm):

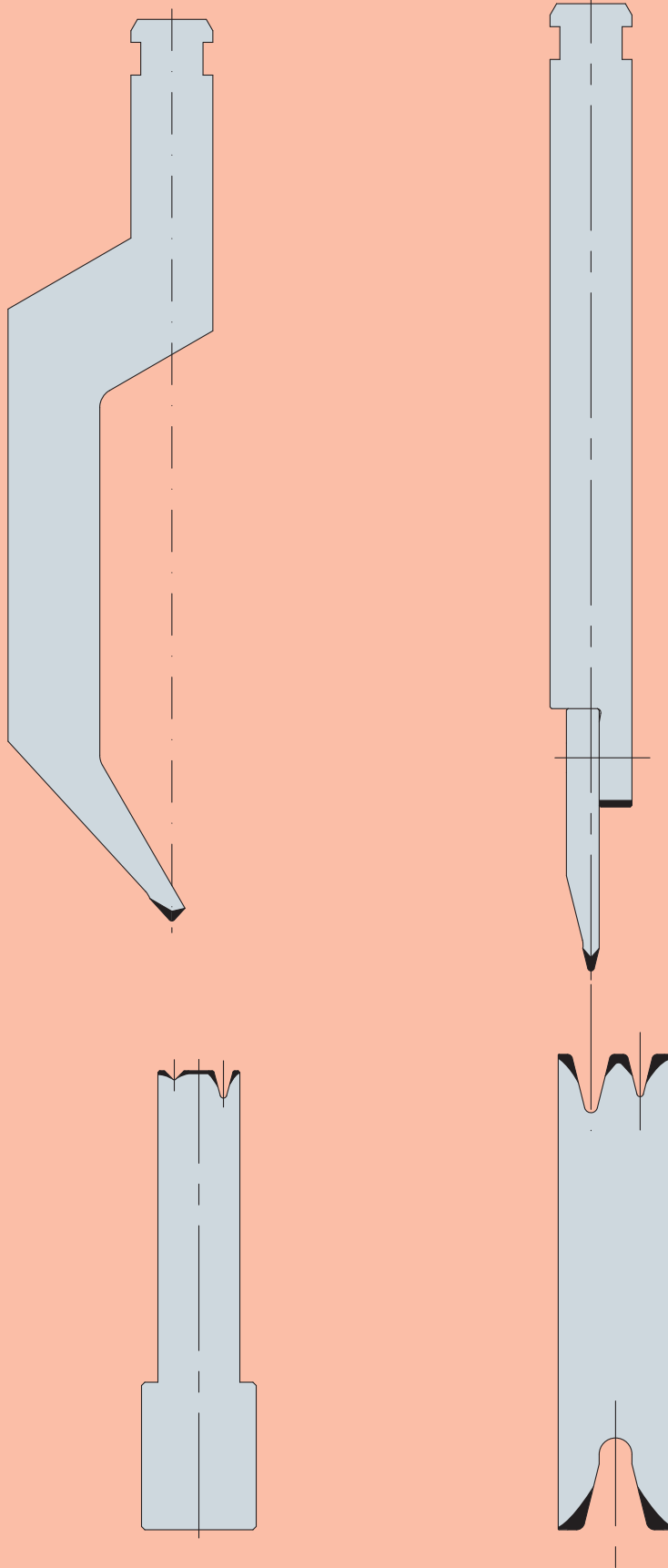
2000
3000
4000
6000
8000

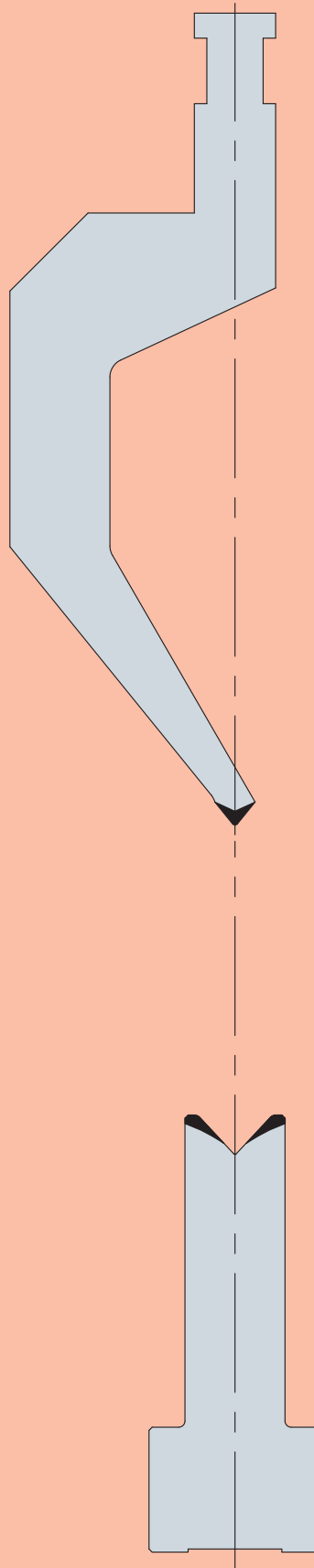
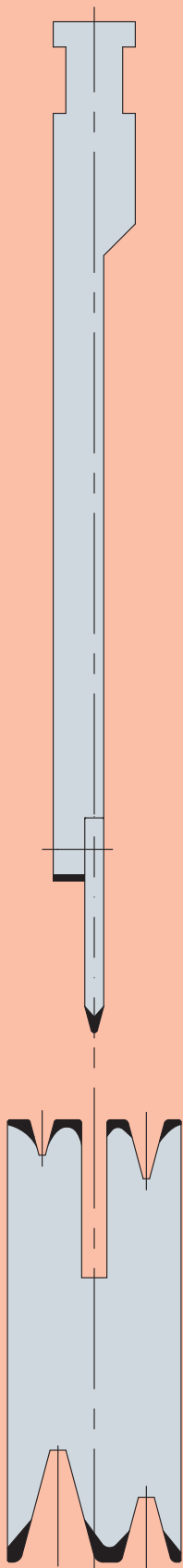
UTENSILI SPECIALI A RICHIESTA/SPECIAL TOOLS ON REQUEST **LVD**





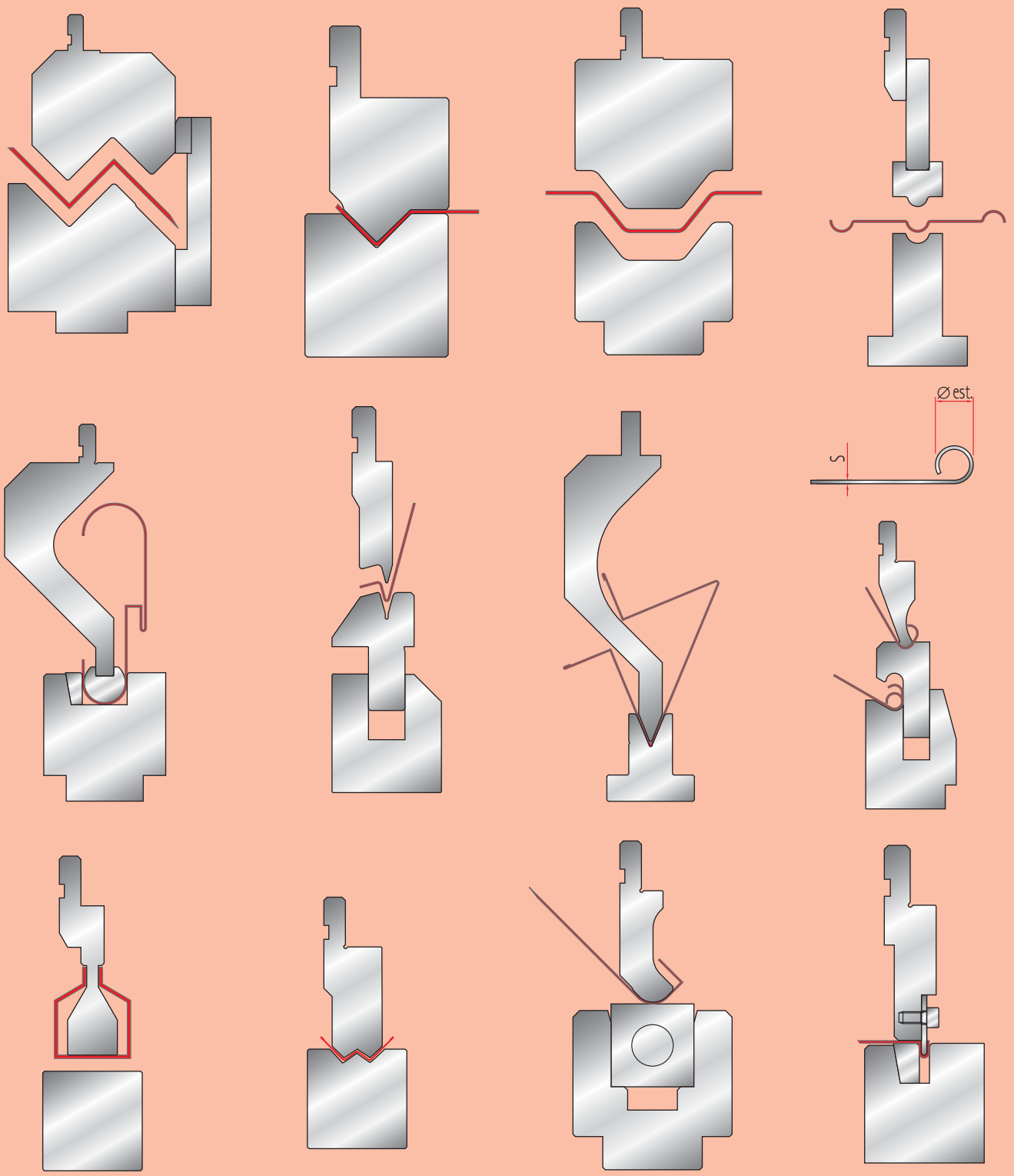
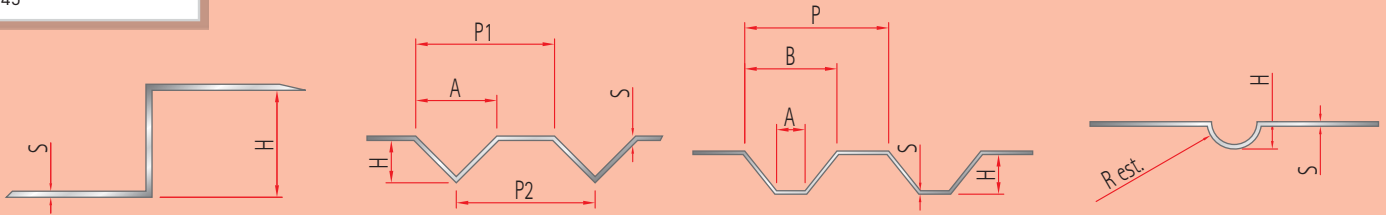
UTENSILI SPECIALI A RICHIESTA/SPECIAL TOOLS ON REQUEST **WEINBRENNER**





UTENSILI SPECIALI A RICHIESTA/SPECIAL TOOLS ON REQUEST

- C45 bonificato /quenched
- 42CrMo4
- C45



LAME PER CESCOIA / SHEAR BLADES

MATERIALE TAGLIATO / CUT MATERIAL:

ALLUMINIO / ALUMINIUM

FERRO / MILD STEEL

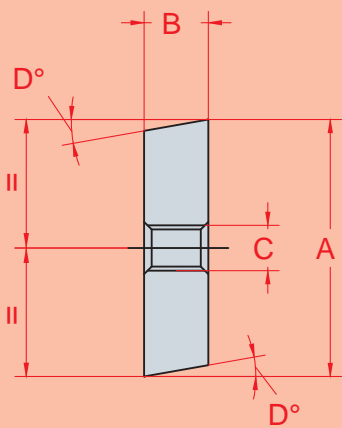
ACCIAIO INOSSIDABILE / STAINLESS STEEL

ALTRO MATERIALE / OTHER MATERIAL:

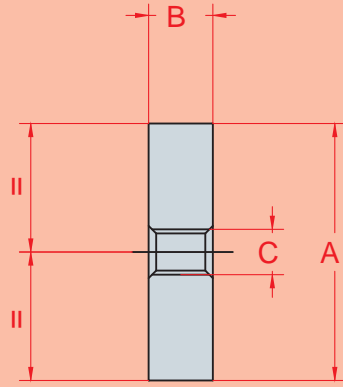
MOD. / PR.

QUOTA / DIMENSION	MISURA / MEASURE (mm)
A	
B	
C	
D	
E	
F	
H	
I	
K	
L	
N° fori / N° holes	

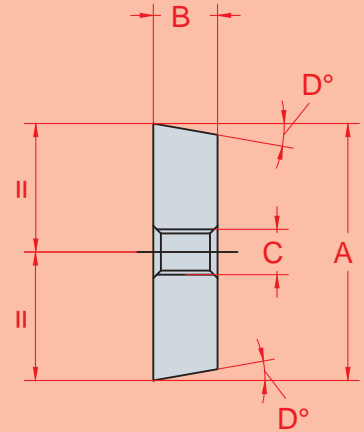
LAME PER CESCOIA / SHEAR BLADES



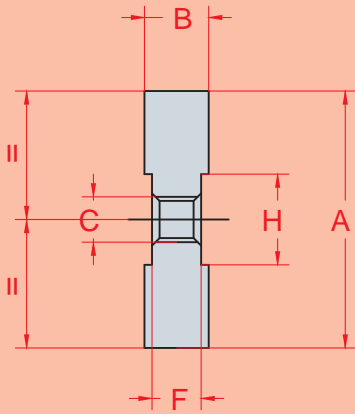
mod. 2000



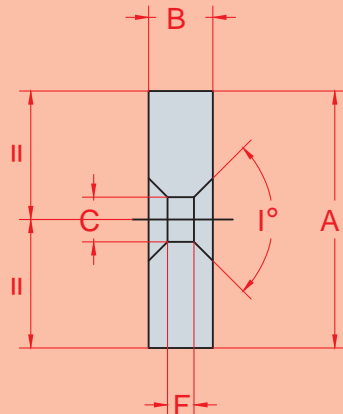
mod. 2001



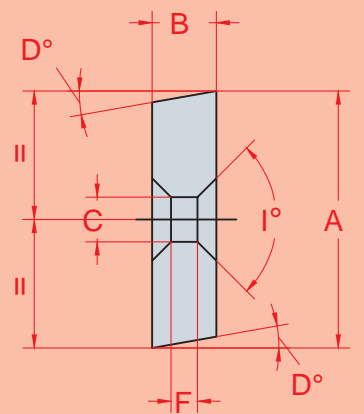
mod. 2002



mod. 2003

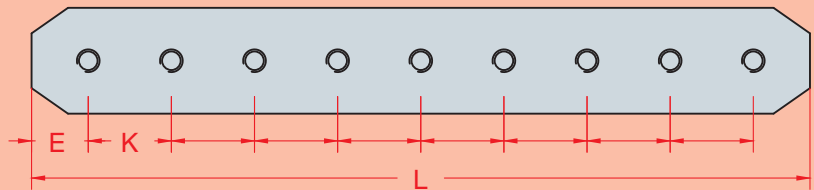


mod. 2004

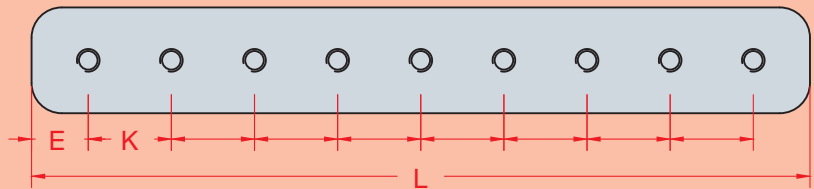


mod. 2005

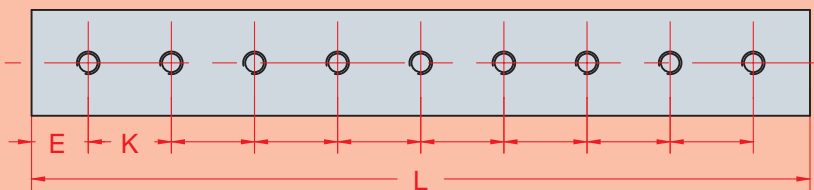
PROFILO 1
PROFILE 1



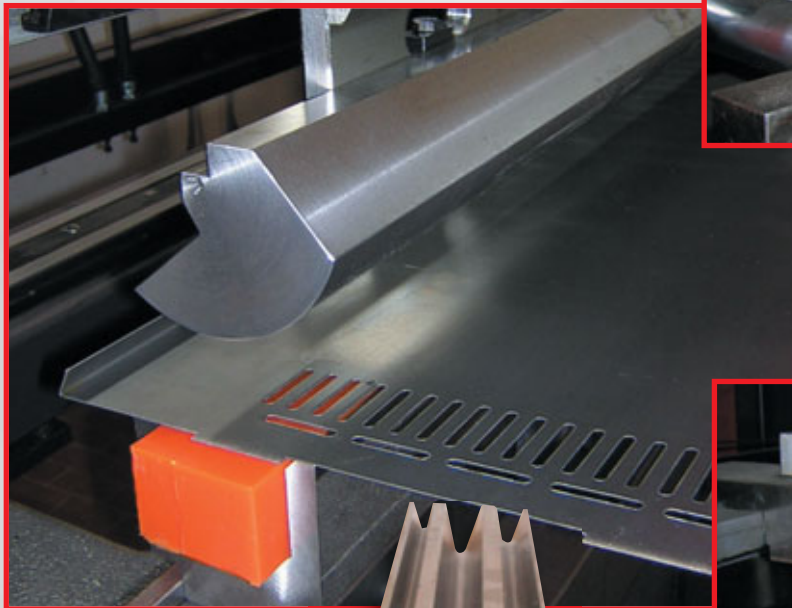
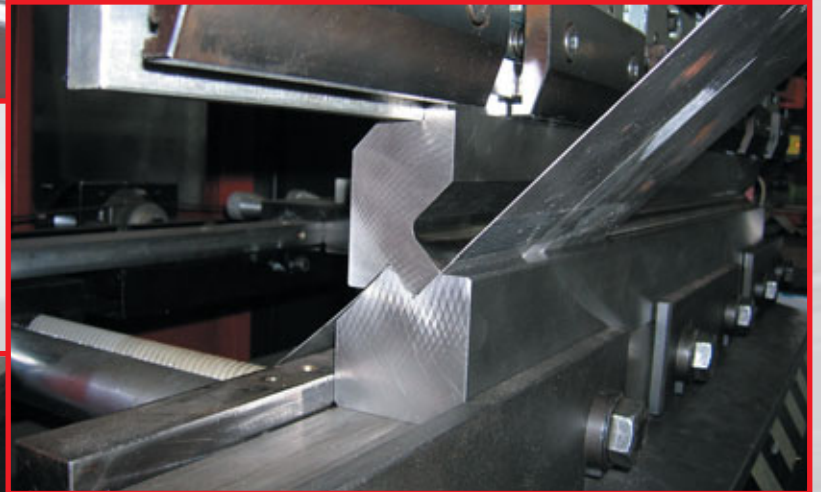
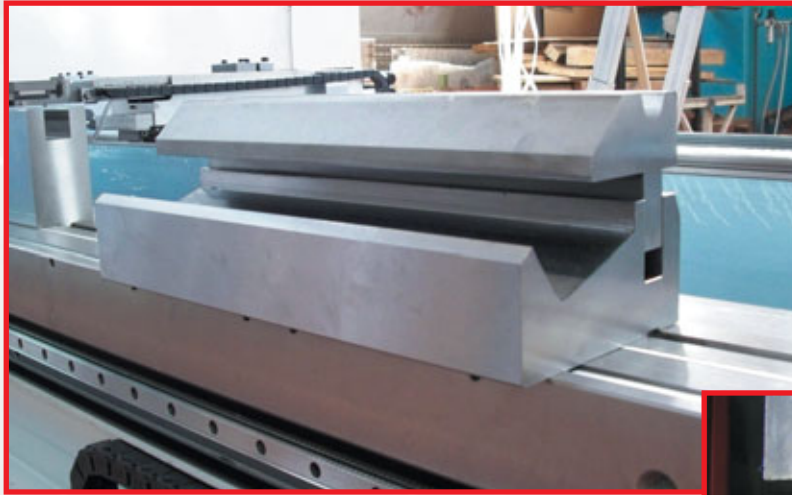
PROFILO 2
PROFILE 2



PROFILO 3
PROFILE 3



ESEMPI SPECIALI /EXAMPLE SPECIAL TOOLS



ESEMPI SPECIALI /EXAMPLE SPECIAL TOOLS

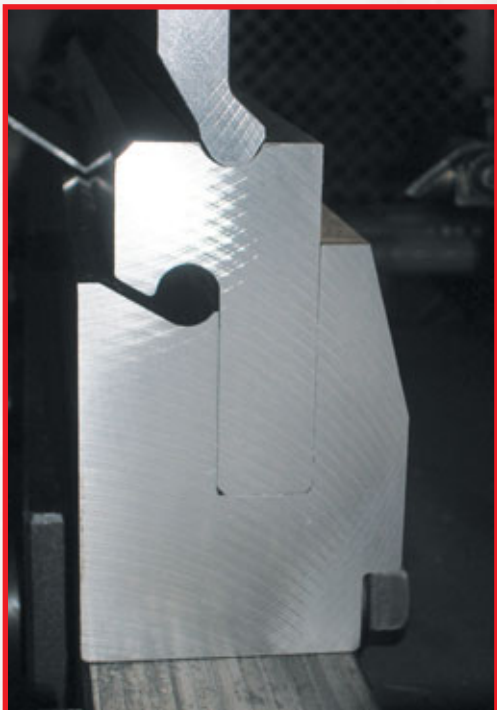
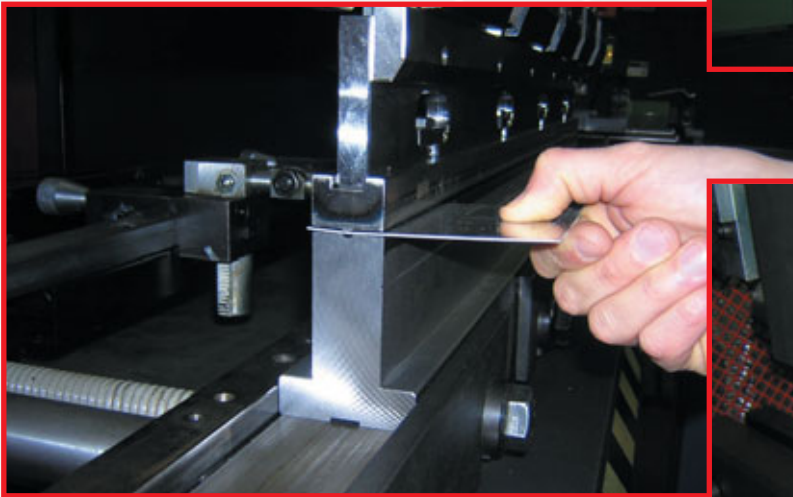
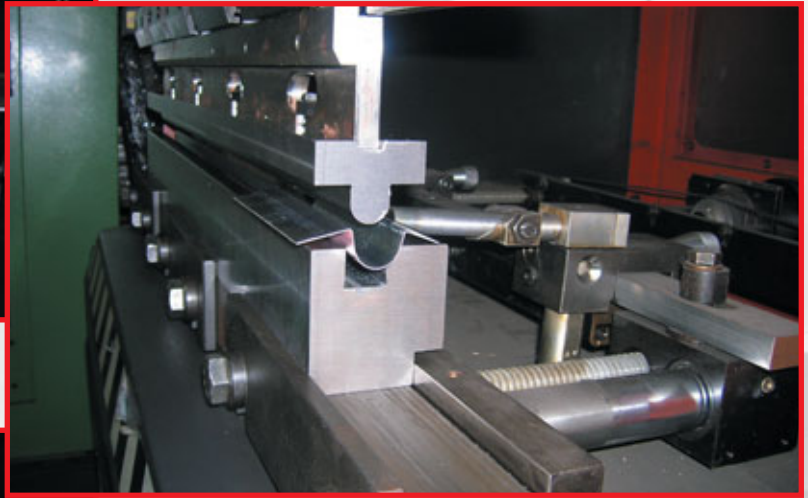
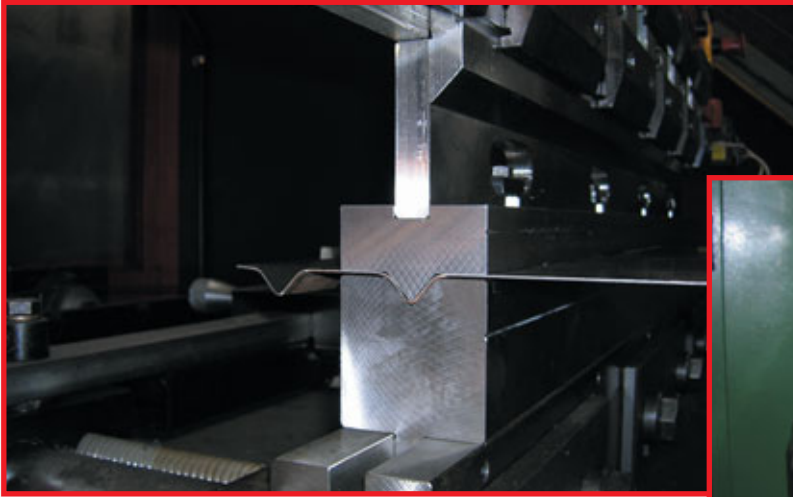



TABELLA MODIFICA RAGGI / MODIFICATION RADIUS

		ANGOLO α							
		90	88	86	60	45	35	30	26
RAGGIO OTTENUTO/ REQUEST RADIUS	1	0,08	0,09	0,09	0,2	0,32	0,47	0,57	0,69
	1,5	0,29	0,31	0,33	0,7	1,13	1,63	2	2,41
	2	0,5	0,53	0,56	1,2	1,94	2,79	3,44	
	2,5	0,7	0,75	0,79	1,7	2,74			
	3	0,91	0,97	1,03	2,2				
	3,5	1,12	1,19	1,26	2,7				
	4	1,33	1,41	1,49					
	4,5	1,53	1,63	1,73					
	5	1,74	1,85	1,96					
	5,5	1,95	2,07	2,19					
	6	2,15	2,29	2,42					
RAGGIO DI PARTENZA/RADIUS: 0.8									

ARMADI PORTA UTENSILI / TOOLING CABINETS



Armadi per utensili tipo Amada/Promecam con 5 cassetti
Tooling cabinet for Amada/Promecam with 5 drawers
codice/code: ACARM0NE0005

Armadi per utensili tipo Beyeler/Trumpf con 5 cassetti
Tooling cabinet for Beyeler/Trumpf with 5 drawers
codice/code: ACARM1NE0005