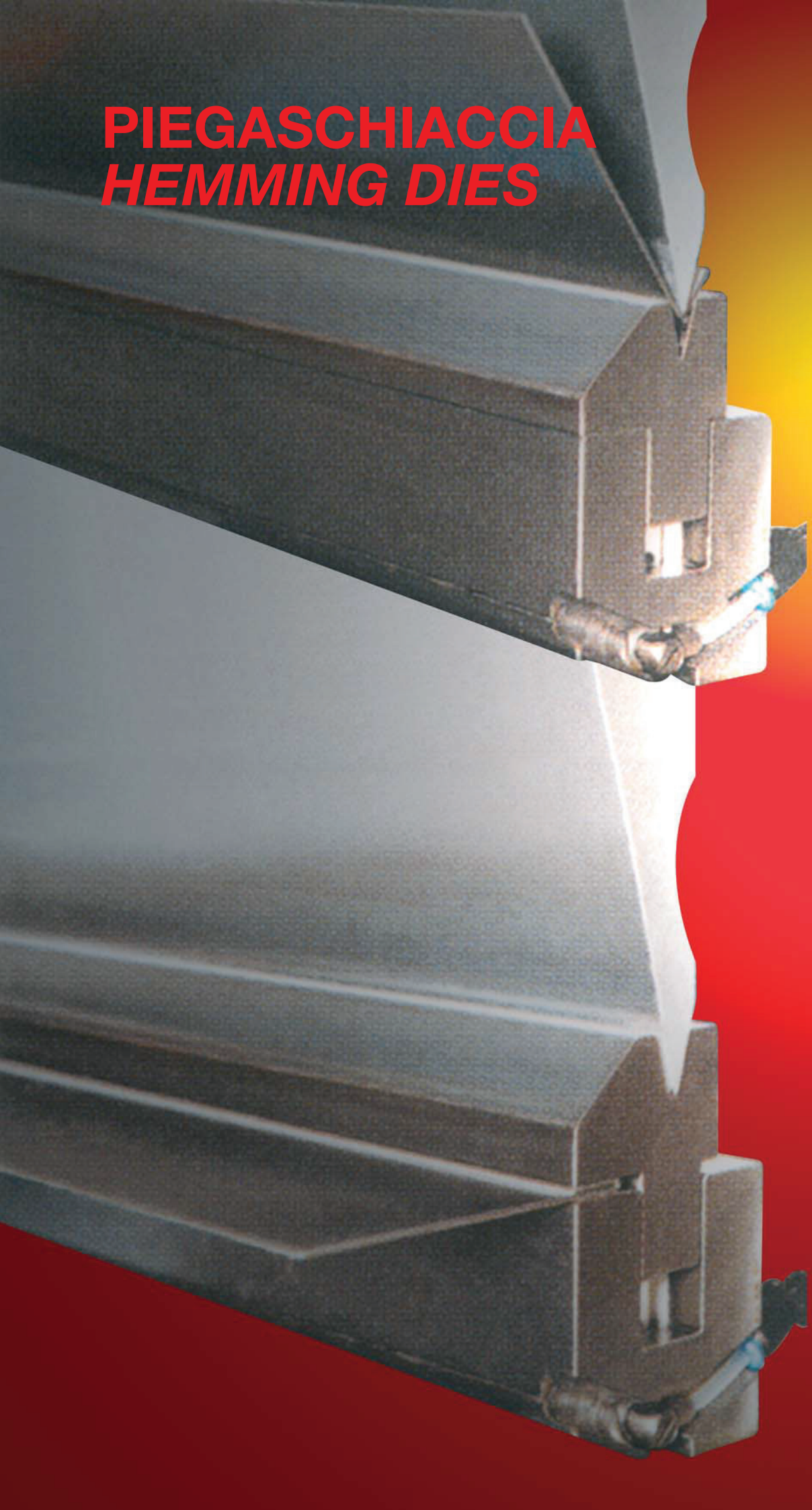
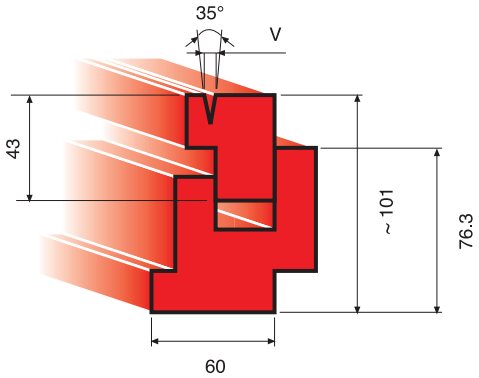
PIEGASCHIACCIA
HEMMING DIES



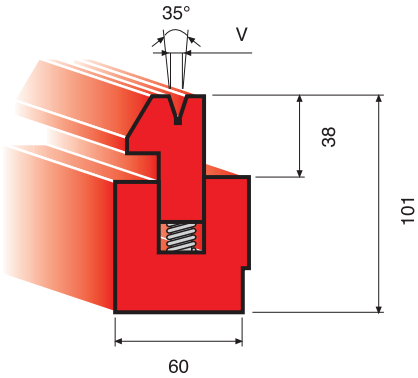
★ 3001 / 35° / A



V = 6 mm
V = 8 mm

SOLID 60 T / m

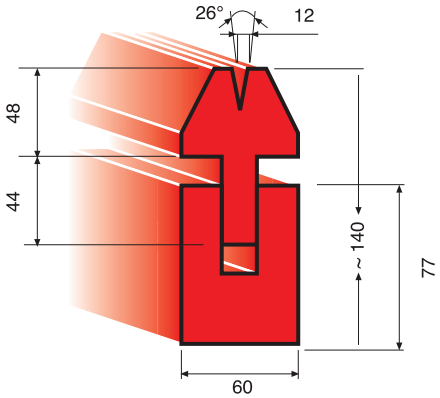
★ 3001 / 35° / B



V = 6 mm
V = 8 mm

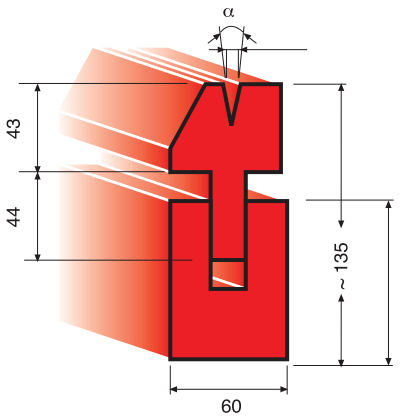
SOLID 60 T / m

★ 3001 / 12 / 26°



SOLID 100 T / m

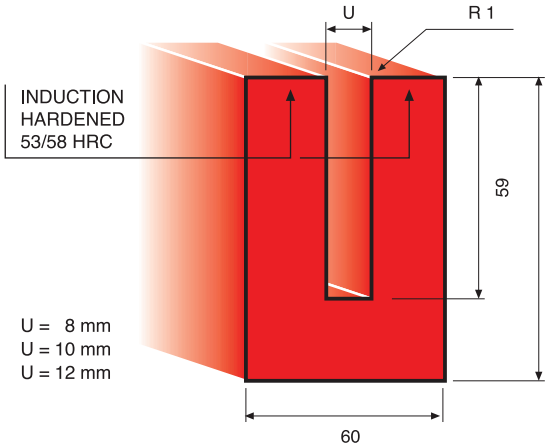
★ 3001



α
V = 10 mm / 26°
V = 10 mm / 35°
V = 12 mm / 35°

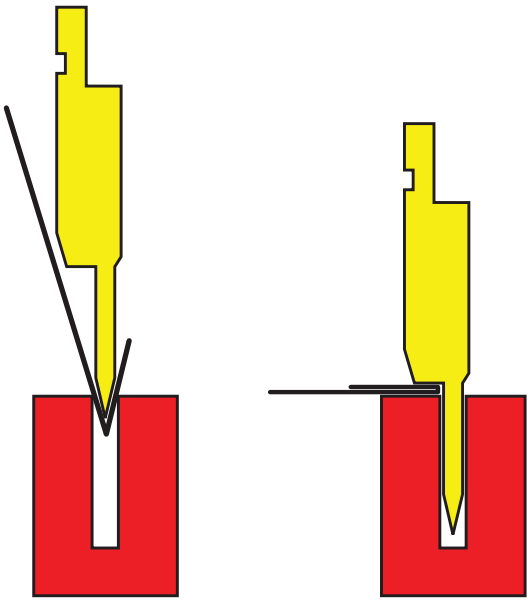
SOLID 100 T / m

★ 3000

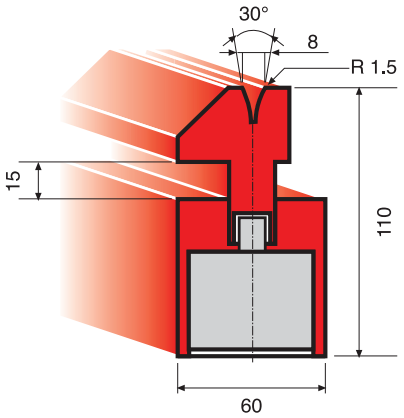


U = 8 mm
U = 10 mm
U = 12 mm

SOLID 50 T / m

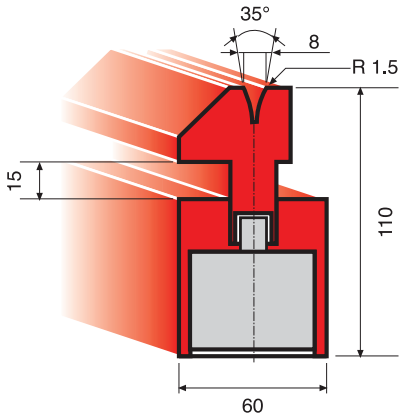


★ 3001 / 8 / 30° / PN



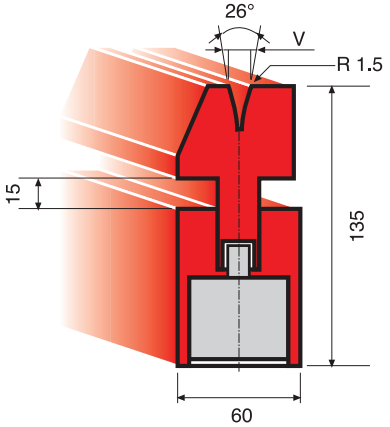
SOLID 80 T / m

★ 3001 / 8 / 35° / PN



SOLID 80 T / m

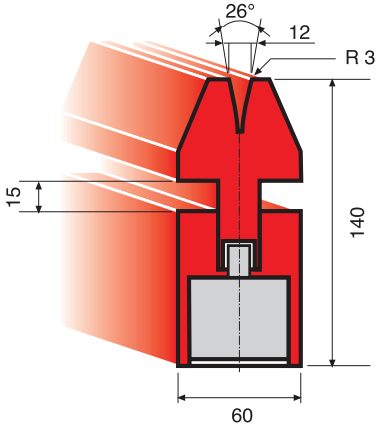
★ 3001 / PN



V = 10 / 26°
V = 10 / 35°
V = 12 / 35°

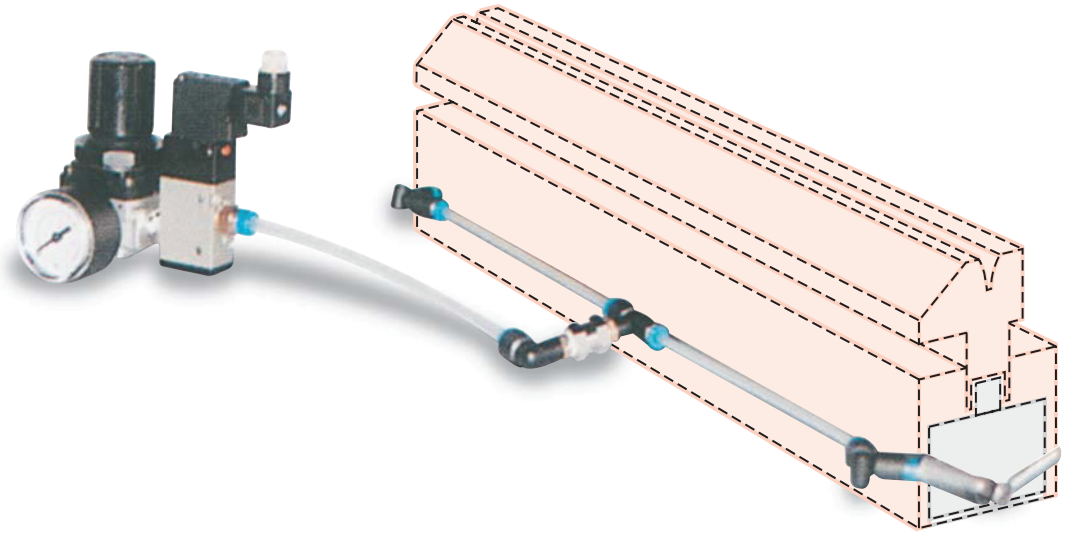
SOLID 100 T / m

★ 3001 / 12 / 26° / PN



SOLID 100 T / m

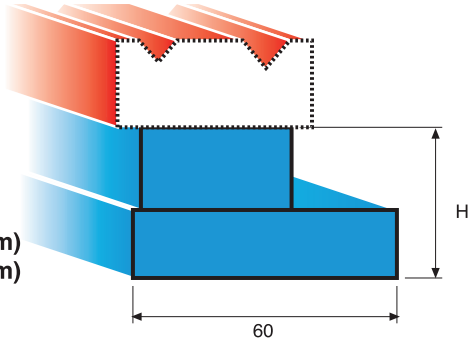
CENTRALINA PNEUMATICA
PNEUMATIC MOVING KIT



Supporti Matrici
Lower Tool Holders

★

4006 H = 34 mm
4006/A H = 39 mm

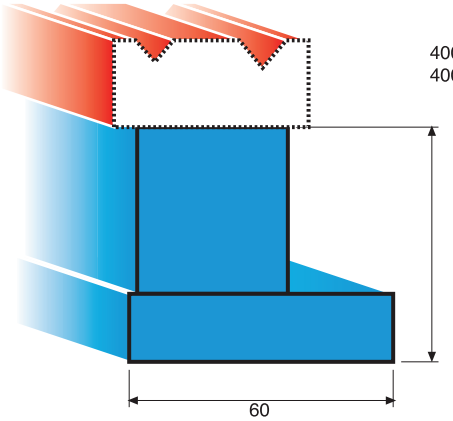


4006
4006/A
(830 mm)
(412 mm)

100 T / m

★

4007 H = 55 mm
4007/A H = 45 mm

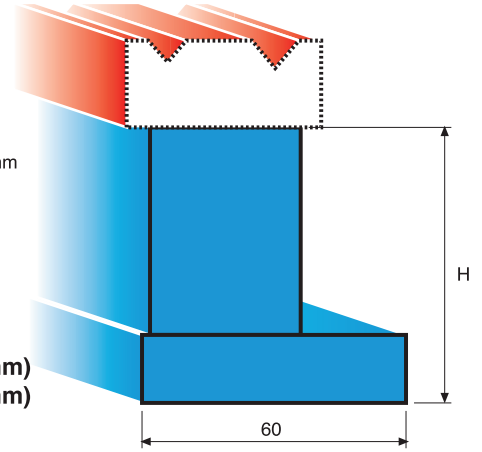


4007
4007/A
(830 mm)
(412 mm)

100 T / m

★

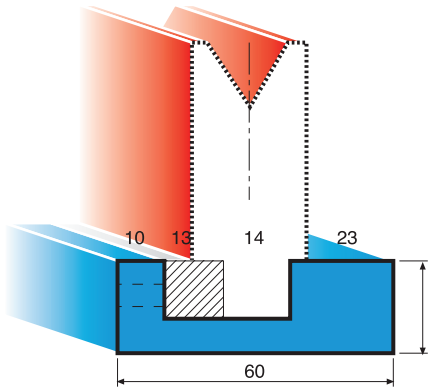
4008
H = 75 mm



4008
(830 mm)
(412 mm)

100 T / m

★

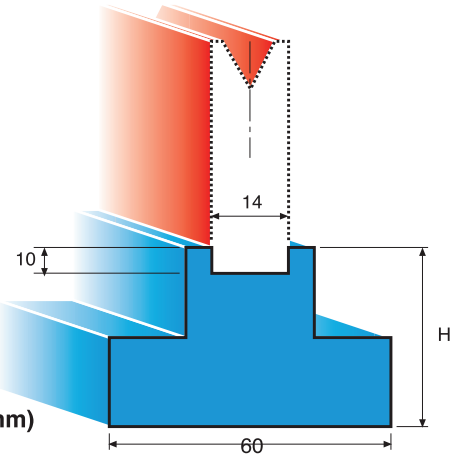


4015
(835 mm)

SOLID 100 T / m

★

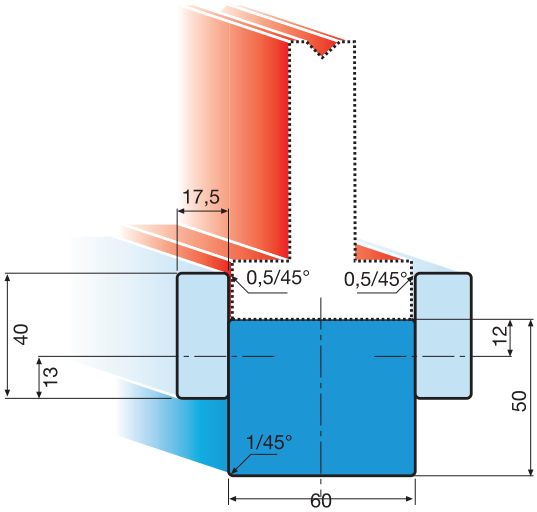
H = 31
H = 61.5



4017
(1050 mm)

SOLID 100 T / m

★

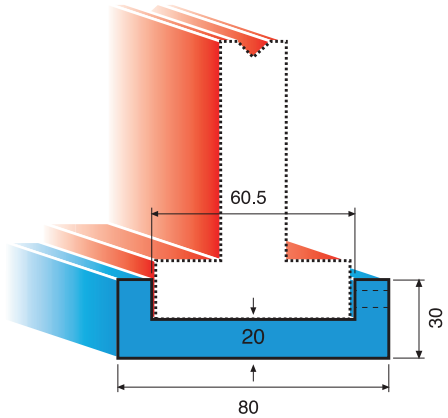


4018
(835 mm)

SOLID 100 T / m

★

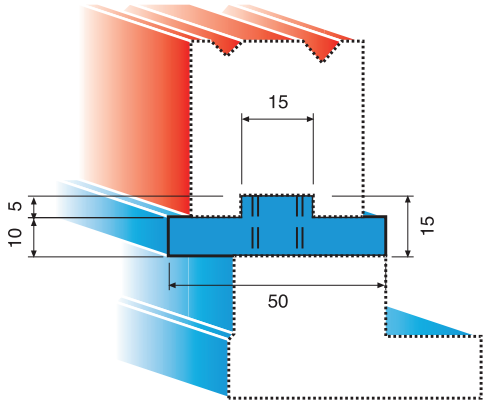
4016
(1050 mm)



SOLID 100 T / m

24h

★



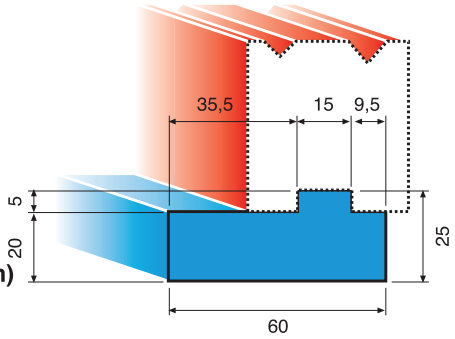
4010
(835 mm)

SOLID 100 T / m

24h

★

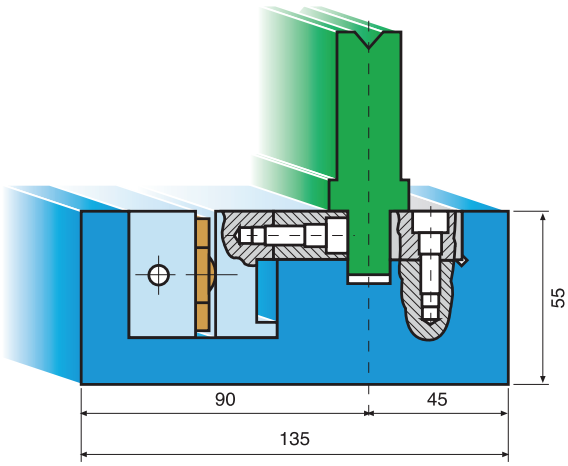
4011
(835 mm)



SOLID 100 T / m

24h

★



4014

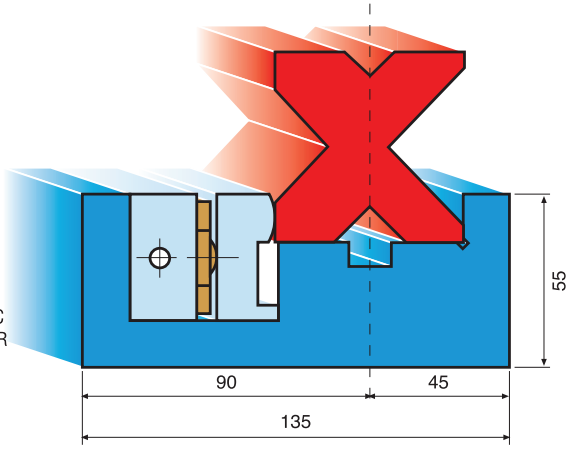
HYDRAULIC
DIE HOLDER
(TRUMPF,
LVD,
HACO,
BEYELER,
AMERICAN,
ETC.)

6 weeks

★

4014/A

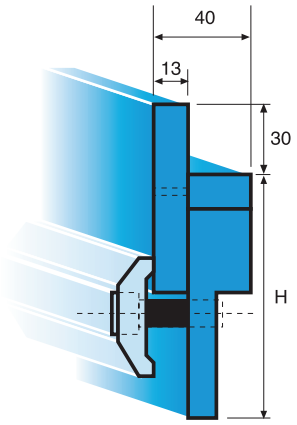
HYDRAULIC
DIE HOLDER
(AMADA)

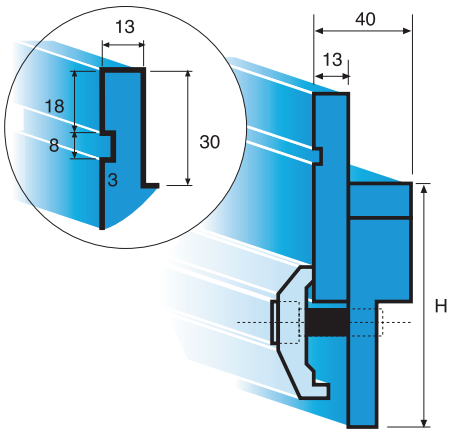


6 weeks

Intermediari Supporto Punzoni
Intermediate Upper Tool Holders

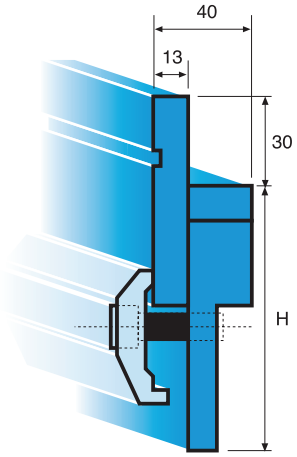
INT. 1 / STD
L = 150
H = 100



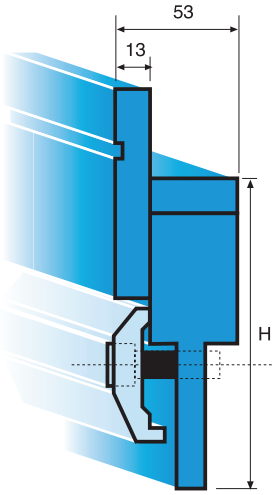


INT. 1
SECURITY
L = 150
H = 100

INT. 1
SECURITY
TALL
L = 150
H = 150

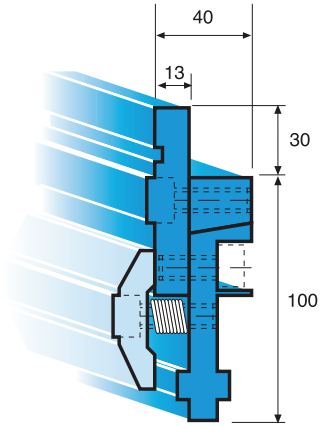


INT. 1
SEC / 120
L = 150
H = 120

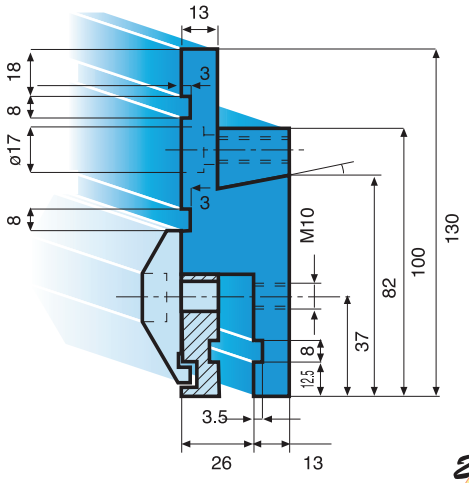


INT. 2
L = 150

BEYELER EURO



INT. AM



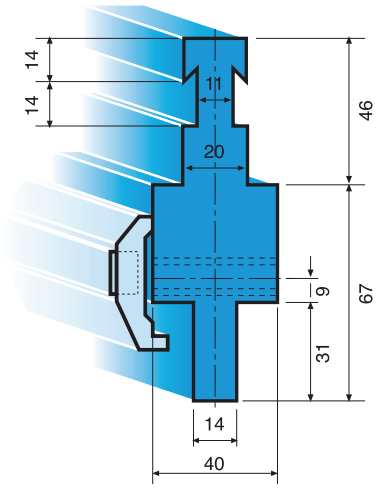
Intermediari Supporto Punzoni
Intermediate Upper Tool Holders

★

INT. 3
BEYELER R

AMADA

H = 67 mm
L = 150 mm

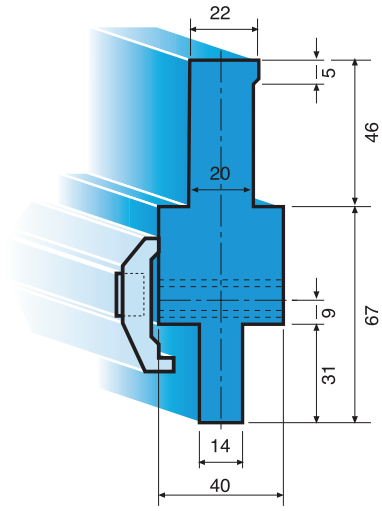


★

INT. 4
BEYELER S

AMADA

H = 67 mm
L = 150 mm

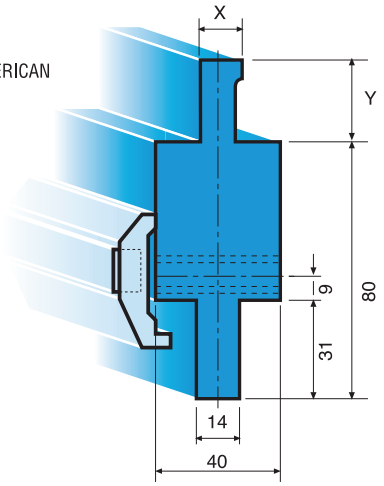


★

INT. 5
LVD-HACO-AMERICAN

AMADA

H = 80 mm
L = 150 mm

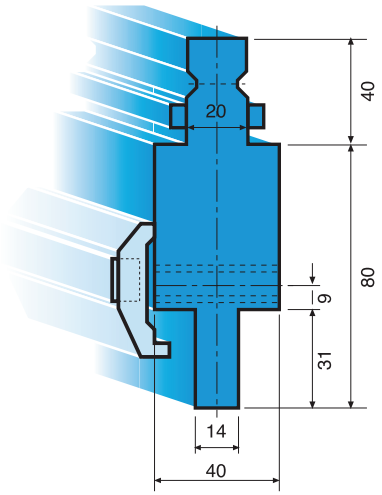


★

INT. 6
TRUMPF

AMADA

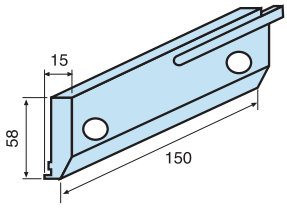
H = 80 mm
L = 150 mm



Staffa di sicurezza
Security Clamp

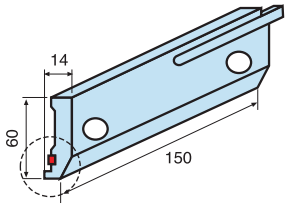
STAFFA
DI SICUREZZA
A CHIUSURA MANUALE
RAPIDA

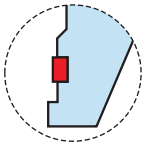
QUICK RELEASE
SECURITY CLAMP



CON BLOCCAGGIO
RINFORZATO
DI ADIPRENE
PER UTENSILI FRAZIONATI

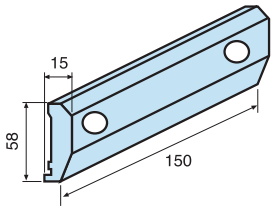
WITH ADIPRENE
RUBBER BLOCKING
FOR SEGMENTED
TOOLING





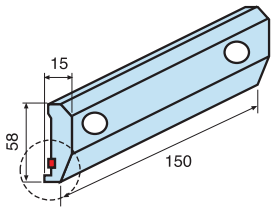
STAFFA
DI SICUREZZA

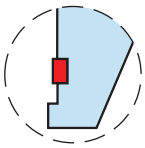
SECURITY
CLAMP



CON BLOCCAGGIO
RINFORZATO
DI ADIPRENE
PER UTENSILI FRAZIONATI

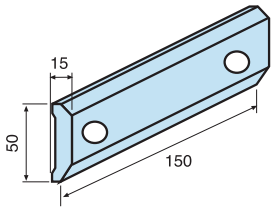
WITH ADIPRENE
RUBBER BLOCKING
FOR SEGMENTED
TOOLING





STAFFA
STANDARD

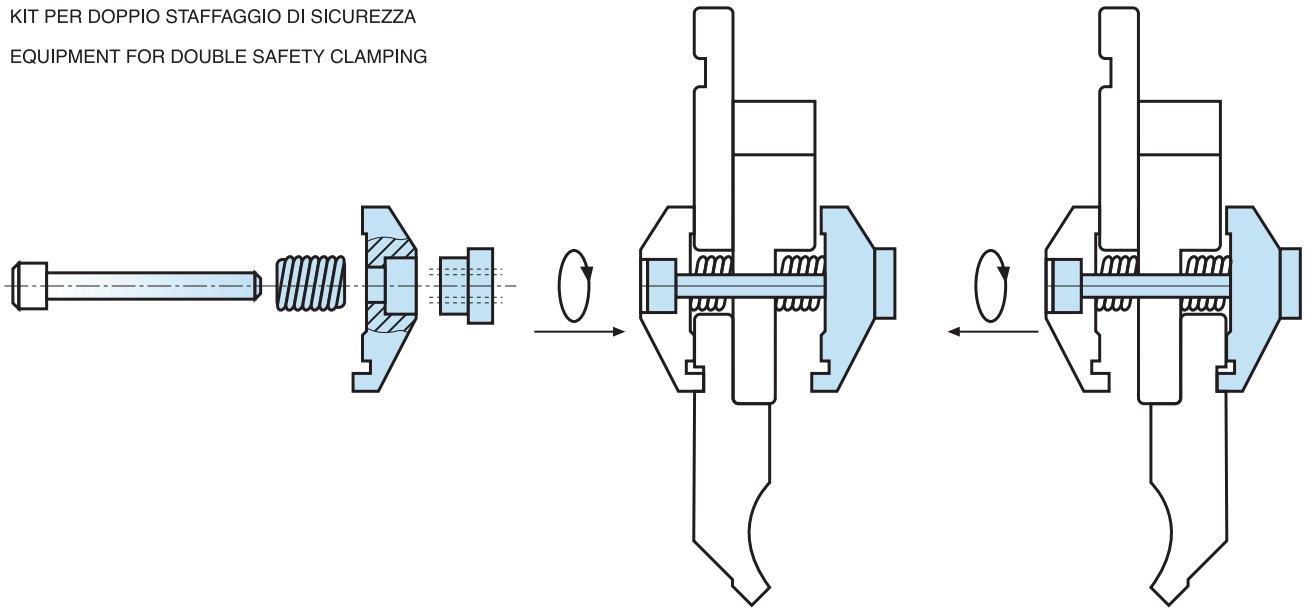
STD
CLAMP



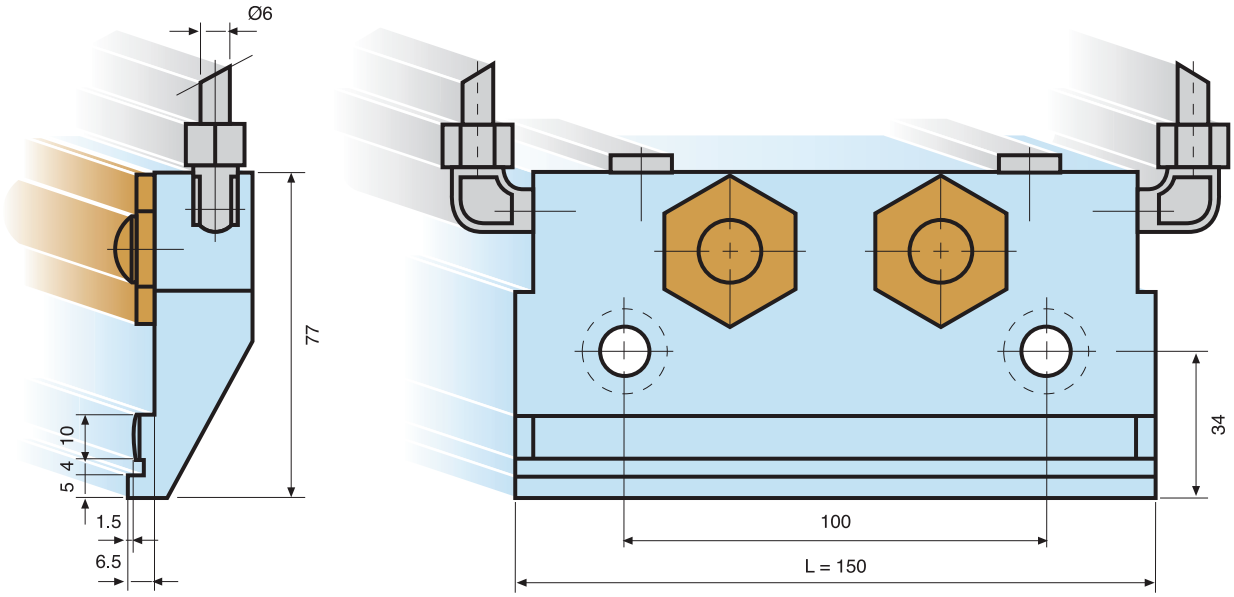
24h

KIT PER DOPPIO STAFFAGGIO DI SICUREZZA

EQUIPMENT FOR DOUBLE SAFETY CLAMPING



Staffa idraulica a bloccaggio rapido
Hydra Fast Clamp



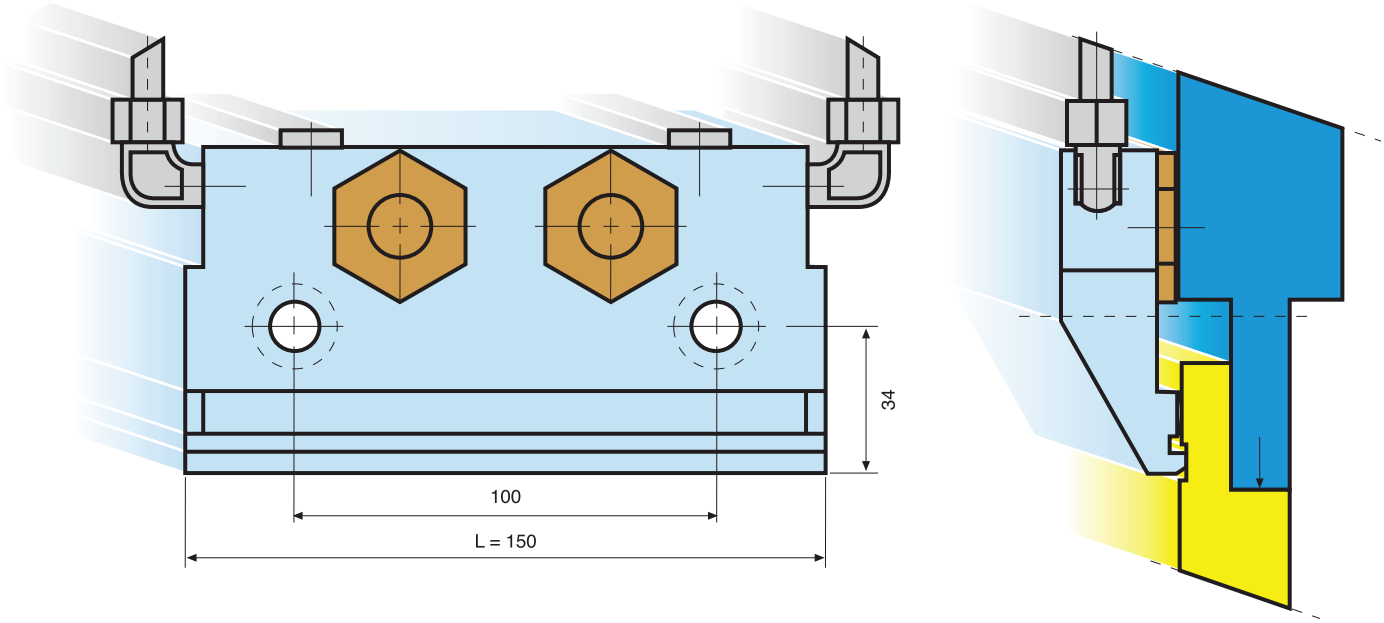
HYDRAULIC PRESSURE MAX 200 BAR
PRESSIONE IDRAULICA MAX 200 BAR

NOW

AT SOONEST

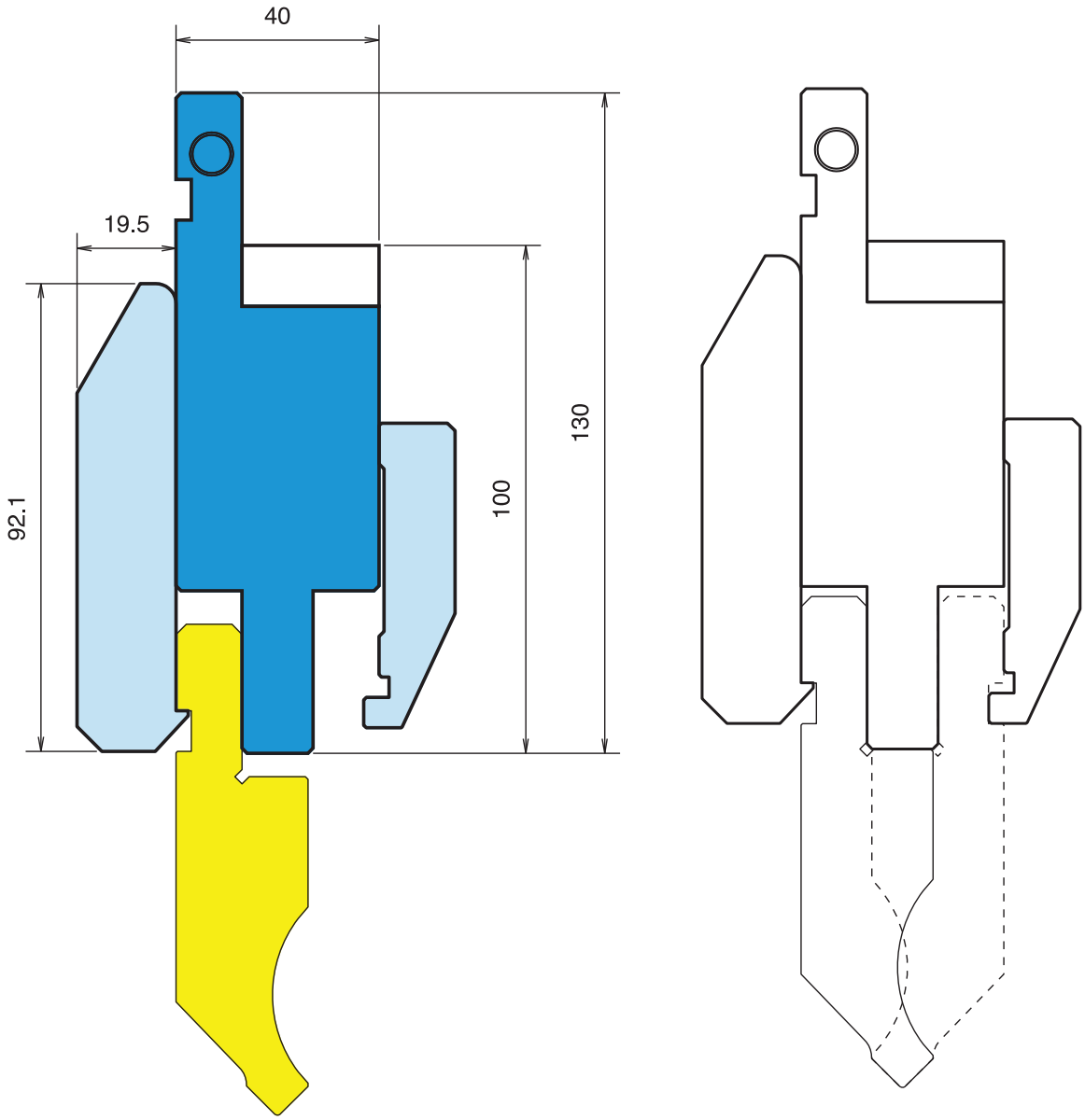
INT. HYDRA

HYDRAULIC PUNCH HOLDER
INTERMEDIARIO IDRAULICO
AMADA SYSTEM



NOW

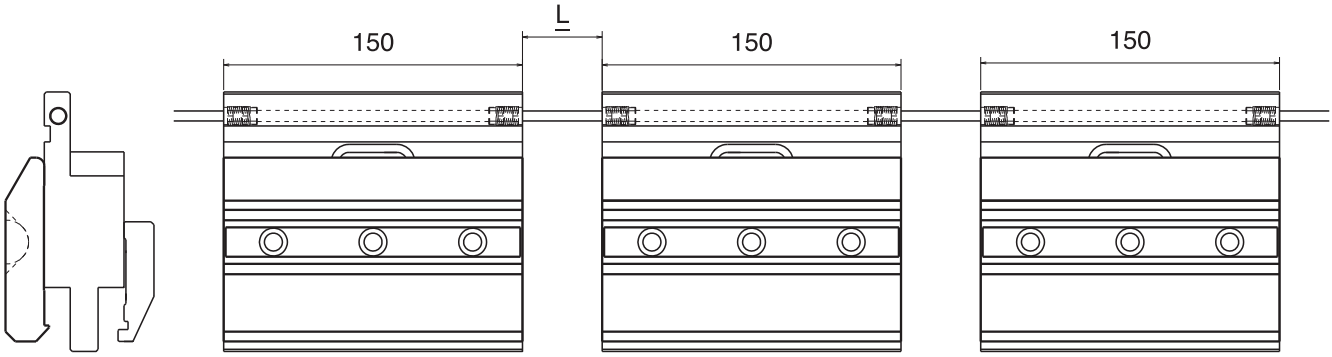
AT SOONEST



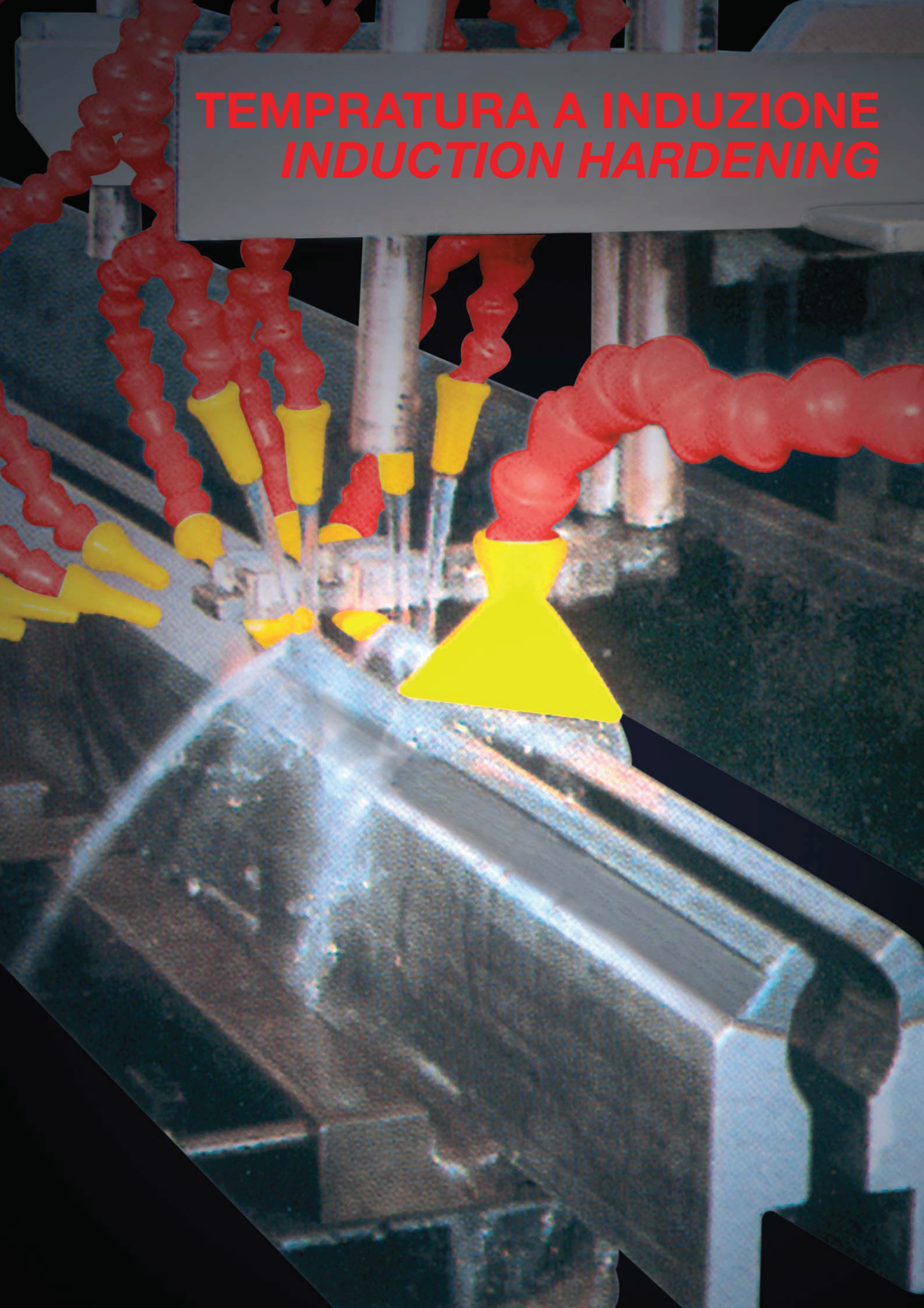
L'inserimento e il disimpegno della lama può avvenire frontalmente senza alcuna modifica del codolo.
Richiamo in battuta automatico.
Cuneo di regolazione.
Staffa posteriore regolabile anteriormente per il serraggio manuale.

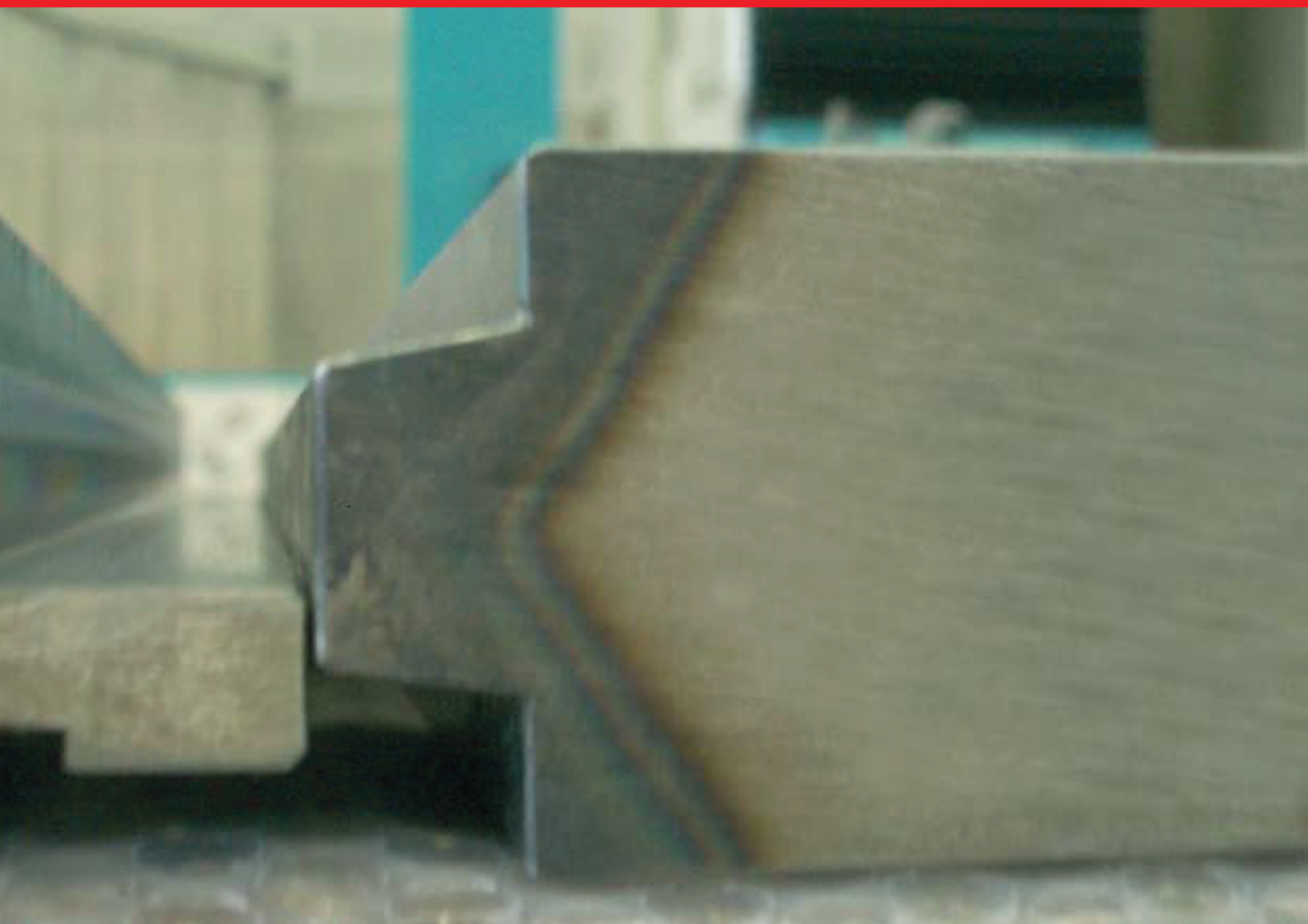
Punch installing and disinstalling from the front without fitting modification.
Authomatic working set-up of the punch.
Movable wedge.
Security back clamp adjustable from the front by manual blocking.

Montaggio Intermedi Pneumatici
Pneumatic Intermediates Assembly

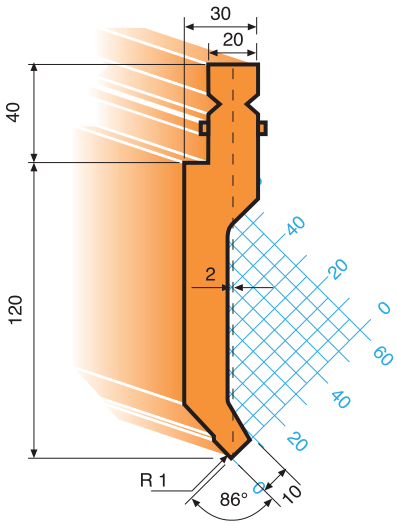


TEMPRATURA A INDUZIONE
INDUCTION HARDENING





★★ 1310 / T / 86° / R1

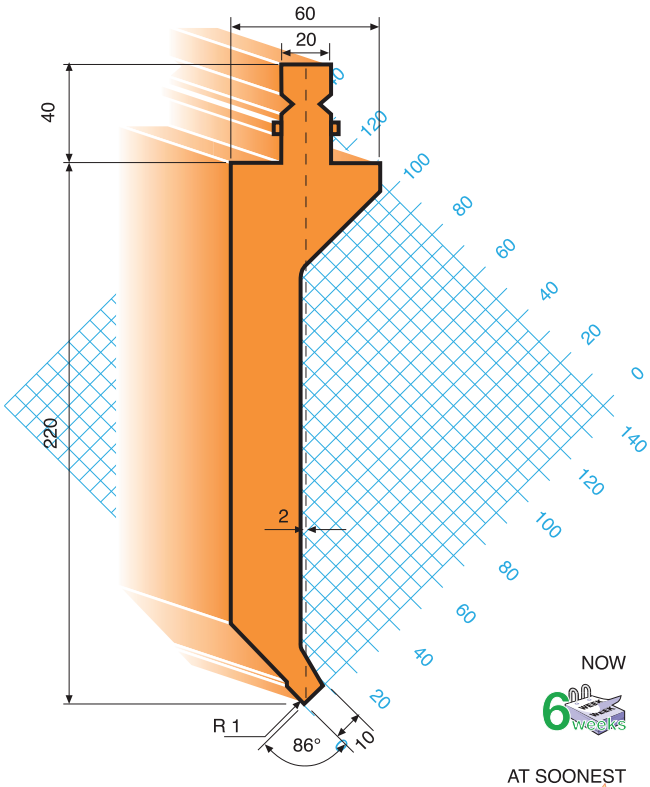


NOW

AT SOONEST

SOLID 100 T / m

★★ 1311 / T / 86° / R1

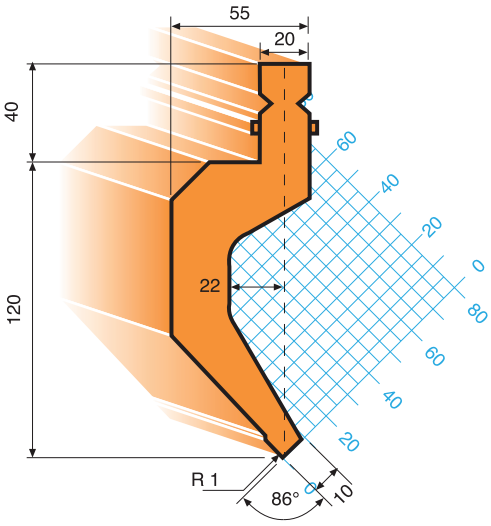


NOW

AT SOONEST

SOLID 100 T / m

★★ 1312 / T / 86° / R1

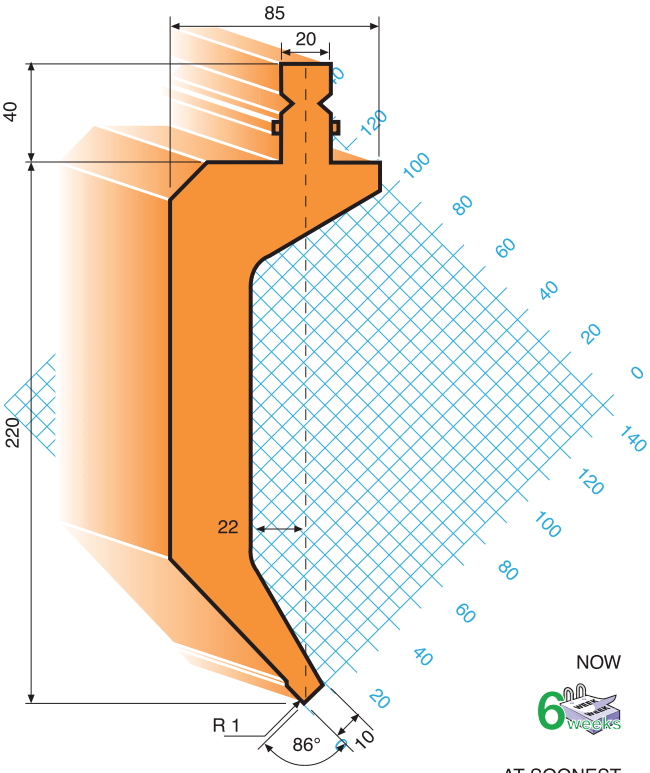


NOW

AT SOONEST

SOLID 100 T / m

★★ 1313 / T / 86° / R1



NOW

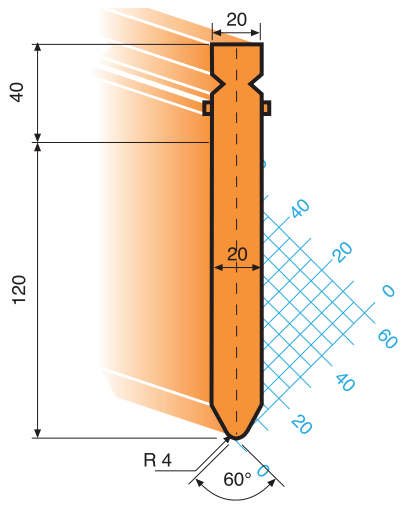
AT SOONEST

SOLID 100 T / m

Utensili per presse piegatrici realizzati con standards di qualità superiore, temprati a induzione sulle parti di lavoro e totalmente rettificati. Mat.: UNI EN 10083/1 - ISO 683 - (42CrM04) - (53-60 HRC) ★★

Press Brake Tooling in best quality, induction hardened and ground on the working surfaces. Mat.: UNI EN 10083/1 - ISO 683 - (42CrM04) - 53-60 HRC) ★★

★★ 1315 / T / 60° / R4

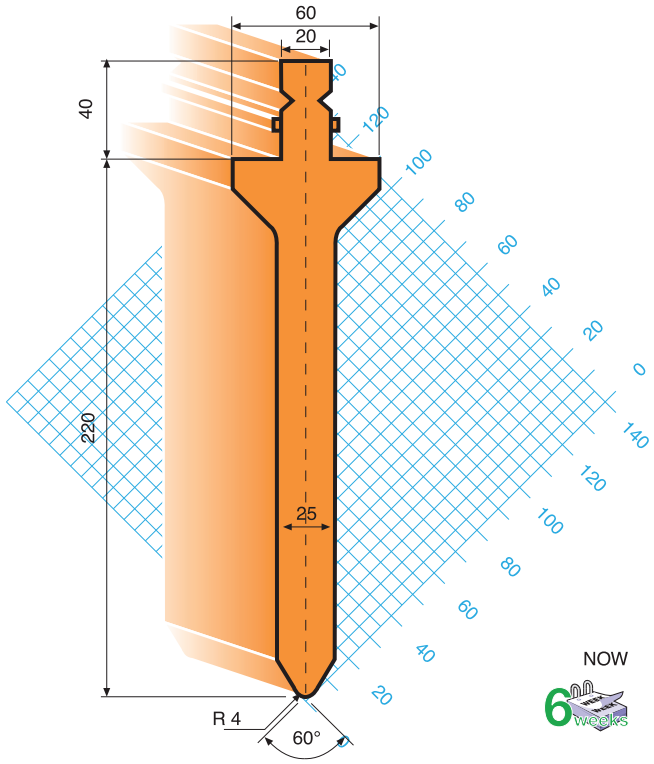


NOW

AT SOONEST

SOLID 130 T / m

★★ 1316 / T / 60° / R4

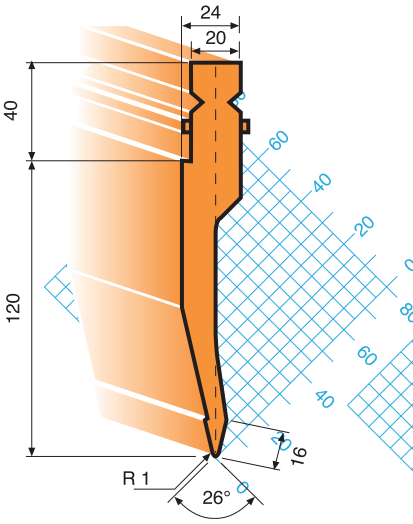


NOW

AT SOONEST

SOLID 130 T / m

★★ 1317 / T / 26° / R1

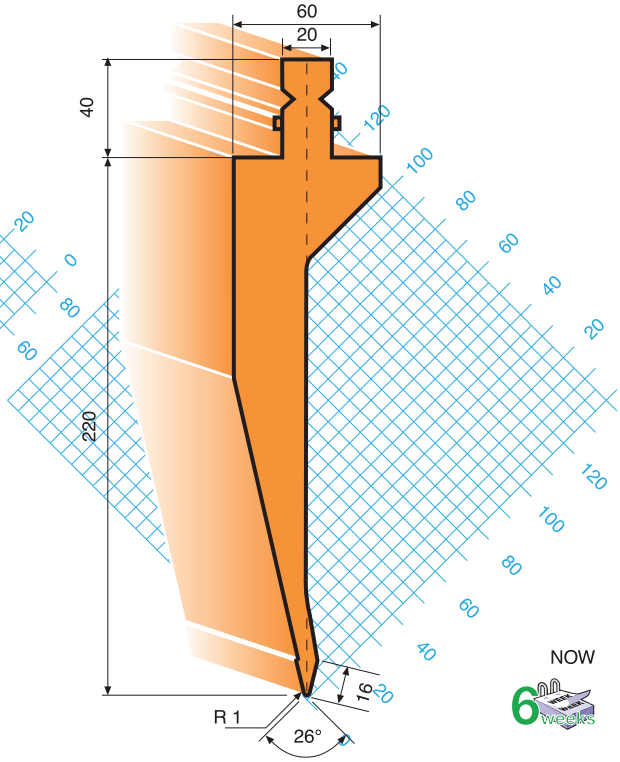


NOW

AT SOONEST

SOLID 100 T / m

★★ 1318 / T / 26° / R1

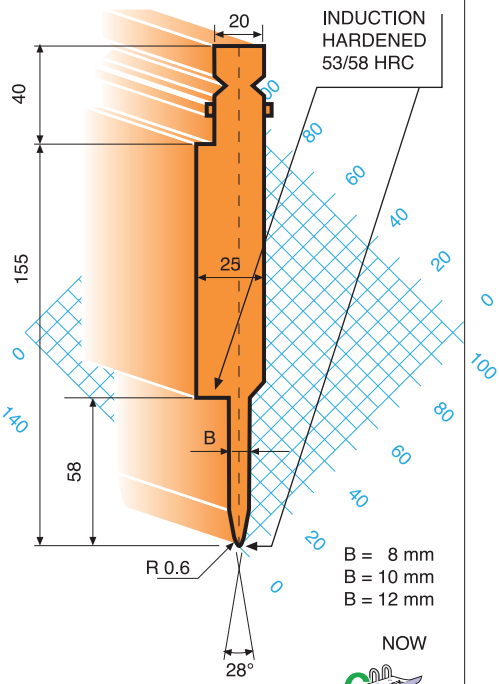


NOW

AT SOONEST

SOLID 100 T / m

★★ 1333 / T / 28° / R0.6

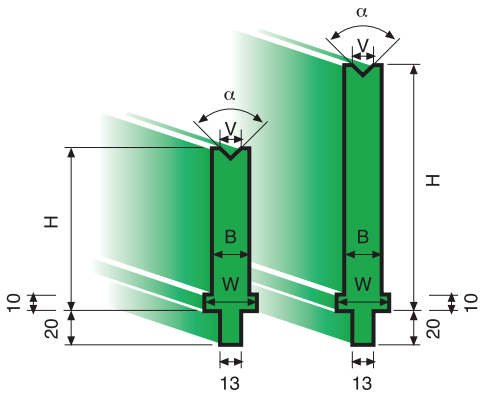


NOW

AT SOONEST

SOLID 70 T / m

★★ 2300 / T / 86° / V / H

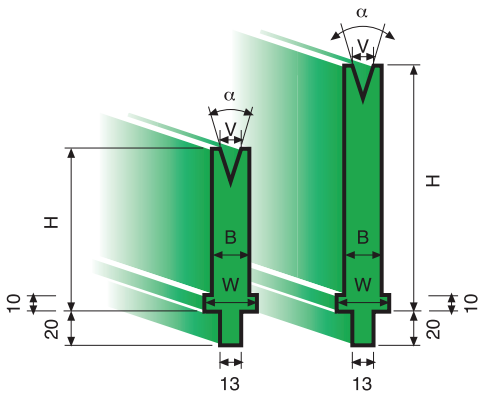


NOW

AT SOONEST

V	α	H (mm)	W (mm)	B (mm)	T / MT
6	86°	100	20	20	40
		100	20	10	24
		150	25	20	40
8	86°	100	20	20	40
		100	20	12	35
		150	25	20	40
10	86°	100	20	20	50
		100	20	14	38
		150	25	20	50
12	86°	100	25	25	50
		100	25	16	40
		150	25	25	50
16	86°	100	30	30	70
		150	30	30	70
20	86°	100	30	30	70
		150	30	30	70
24	86°	100	35	35	70
		150	35	35	70
30	86°	100	45	45	75
		150	45	45	75
40	86°	100	55	55	120
		150	55	55	120
50	86°	100	75	75	150
		150	75	75	150

★★ 2300 / T / 30° / V / H



NOW

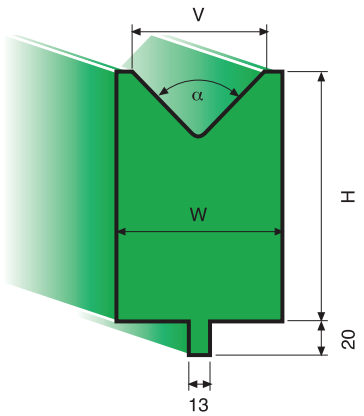
AT SOONEST

V	α	H (mm)	W (mm)	B (mm)	T / MT
6	30°	100	20	20	40
		100	20	12	17
		150	25	20	40
8	30°	100	20	20	40
		100	20	14	17
		150	25	20	40
10	30°	100	20	20	40
		100	20	16	20
		150	25	20	40
12	30°	100	25	25	40
		100	25	18	20
		150	25	25	40
16	30°	100	30	30	50
		150	30	30	50
20	30°	100	35	35	60
		150	35	35	60
24	30°	100	40	40	65
		150	40	40	65

Abkantwerkzeuge in bester Qualität, inducktionsgehärtet - Arbeitsflächen geschliffen. Mat.: UNI EN 100083/1 - ISO 683 - (42CrM04) - (53-60 HRC) ★★

Outils de pliage de qualité supérieure trempés par induction avec faces principales rectifiées. Mat.: UNI EN 10083/1 - ISO 683 - (42CrM04) - (53-60 HRC) ★★

★★ 2300 / T / 80° / V / H

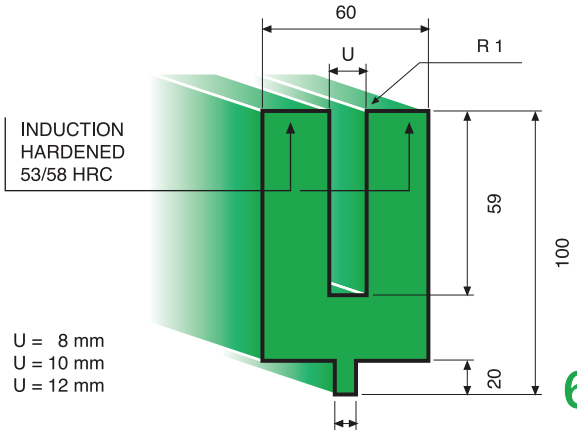


V	α	H (mm)	W (mm)	T / MT
60	**80°**	100	75	150
70	**80°**	100	85	150
80	**80°**	100	100	150
90	**80°**	120	110	150
100	**80°**	120	120	150

NOW 6 weeks

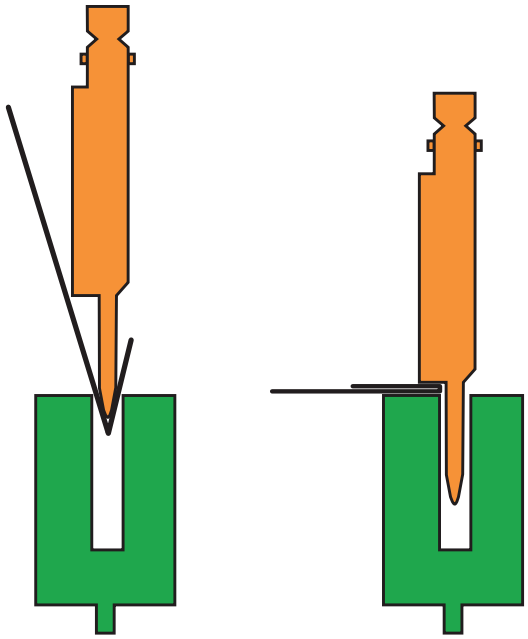
AT SOONEST 24h

★★ 2300 / T

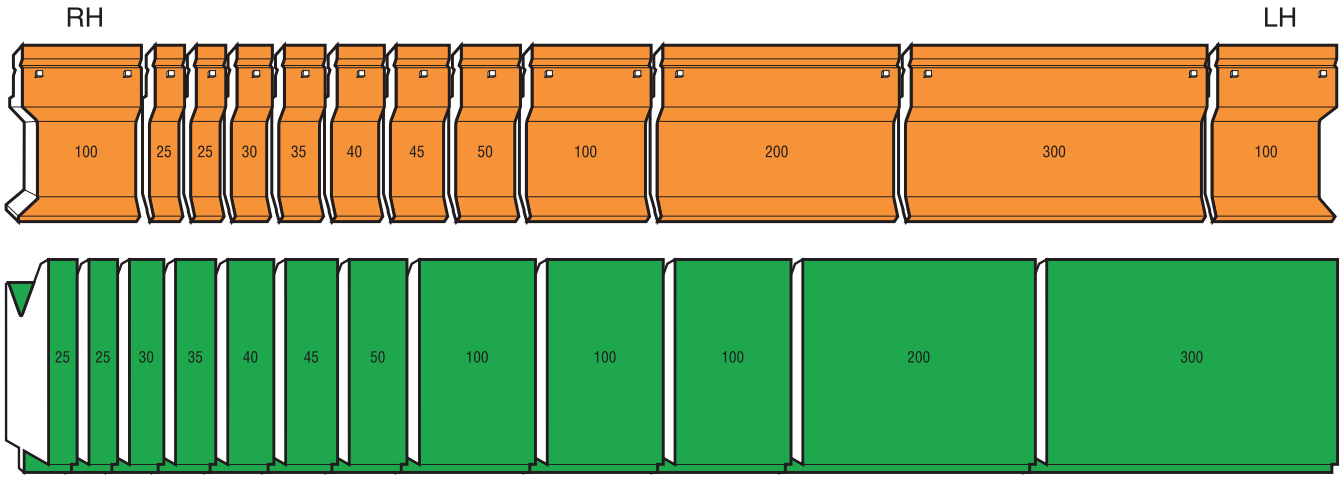


NOW 6 weeks

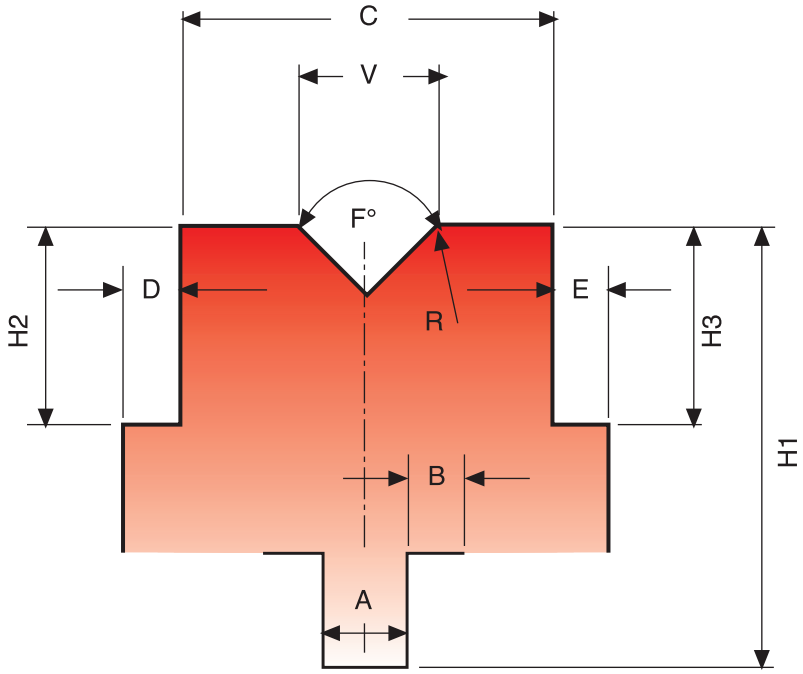
AT SOONEST 24h



Frazionatura standard per 1050 mm • *Standard sectioning for 1050 mm*
Standard Sektionierung für 1050 mm • *Fractionnement standard pour 1050 mm*



★
★★



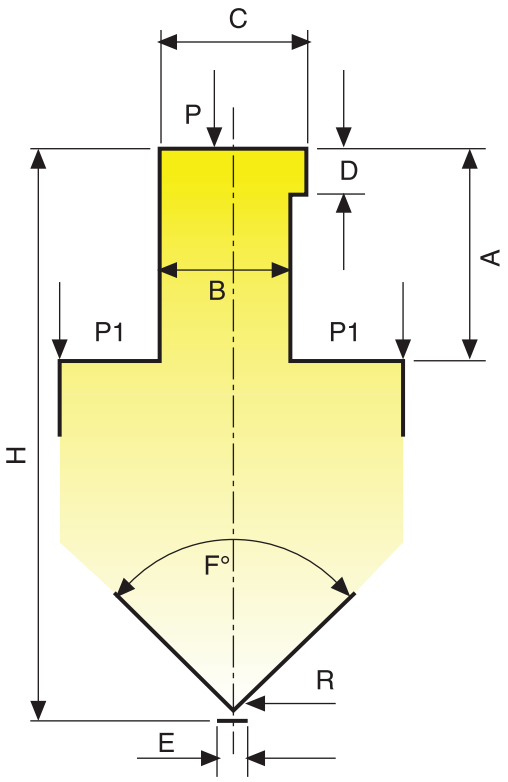
Per ogni vostra richiesta di matrici speciali, vogliate indicare:
- Altezza totale H1, H2 e H3;
- Dimensioni A, B, C, D, E e raggio R;
- Numero e disposizione delle cave da eseguire;
- Larghezza delle cave V;
- Gradi delle cave F°;
- Lunghezza e frazionati;

For any enquiry on special dies, please state:
- Total height H1, H2 and H3;
- Dimensions A, B, C, D, E and radius R;
- Number and position of grooves;
- Width of grooves V;
- Degrees on grooves F°;
- Length and segmented;

Bei Anfrage von Sondermatrizen nennen Sie uns bitte folgende Daten:
- Gesamte Höhe: H1, H2 und H3;
- Abmessung: A, B, C, D, E und Radius r;
- Anzahl und Position der V-Öffnungen;
- Öffnungsbreite: V;
- Öffnungsmaß: V; F°;
- Länge und Teilung;

Pour exécution particulière, les valeurs suivantes sont nécessaires:
- Hauteur totale H1, H2 et H3;
- Dimensions A, B, C, D, E et rayon R;
- Nombre et position des "v";
- Grandeur du/des V;
- Angle du/des "v" F°;
- Longueur et fractionnement;

★
★★



Per ogni vostra richiesta di punzoni speciali, vogliate indicare:
- Altezza totale H;
- Misure dell'attacco A - B - C - D;
- Gradi della punta F°;
- Misura del piano in punta E, oppure del raggio R;
- Se la pressa spinge in P o in P1;
- Lunghezza e frazionati;

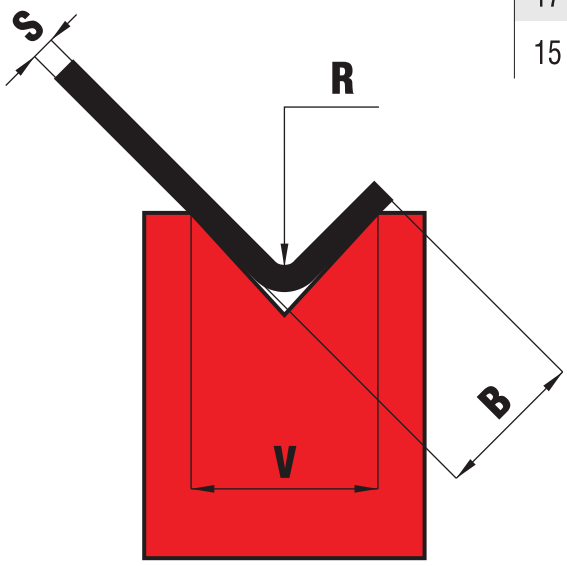
For any enquiry on special tools, please state:
- Total height H;
- Dimensions of tongue A - B - C - D;
- Degrees on the nose F°;
- Measure of flat on E or radius R;
- Whether the press-brake presses on P or P1;
- Length and segmented;

Bei Anfrage von Sonderstempeln nennen Sie uns bitte folgende Daten:
- Gesamte Höhe: H;
- Abmesungen: A - B - C - D;
- Winkel an der Spitze F°;
- Fase E oder Radius r;
- Biegekraft auf P oder P1;
- Länge und Teilung;

Pour exécution particulière, les valeurs suivantes sont nécessaires:
- Hauteur totale H;
- Dimensions de la fixation A - B - C - D;
- Angle de la pointe F°;
- Plat ou rayon R de la pointe;
- Force de pliage en P ou P1;
- Longueur et fractionnement;

Tabella di piegatura
Bending Table
Abkanttabelle
Abaque de pliage

V	R	B	S	0.5	0.8	1	1.2	1.5	1.8	2	2.5	3	4	5	6	8	10	12	15	20	25
4	0.7	2.6		4	10.5																
6	1	4		3.5	6	10	13														
8	1.5	5.2		2	5.5	8	11.5	18													
10	1.7	6.5			4.1	6.5	9.5	14.5	21	26											
12	2	7.8				5.5	8	12	17.5	21.5	33.5										
16	2.7	10.4					6	9	13	16	25	36									
20	3.4	13						7.5	10.5	13	20	29	52								
25	4.2	16							8.5	10.5	16	23	41	64							
30	5	20									14	19	34	54	77						
35	6	23										17	30	46	66						
40	7	26										15	26	40	58	103					
45	7.5	29											23	36	52	91					
50	8.5	32											21	32	46	82	128				
55	9	36												30	42	75	117				
60	10	39												27	39	69	107				
65	10.8	42												25	36	63	99	142			
70	11.7	45													33	59	92	132			
75	12.5	49													31	55	86	123			
80	13.5	52													29	52	80	116	180		
85	14	55														49	76	109	170		
90	15	58														46	71	103	160		
100	17	65														41	64	93	144	256	
110	18.5	71															59	84	131	233	
120	20	78															54	77	120	213	333
140	24	91																66	103	183	286
170	29	110																55	85	151	235



V = (mm)
R = (mm)
B = (mm)
S = (mm)
F = (KN/m)

Forza di piegatura al metro per materiale con resistenza di 400 N/mm^2. Per resistenza di 800 N/mm^2 (Inox) moltiplicare la forza per 2.

Bending force per meter for material tensile strength of 400 K/mm^2. For tensile strength of 800 N/mm^2 (Inox) multiply the bending force by 2.

Biegekraft pro Meter für eine Materialfestigkeit von 400 N/mm^2. Für eine Festigkeit von 800 N/mm^2 (Inox), bitte die Biegekraft verdoppeln.

Force de pliage par mètre pour une matière ayant une résistance de 400 N/mm^2. Pour une résistance de 800 N/mm^2 (Inox) multiplier la force par 2.