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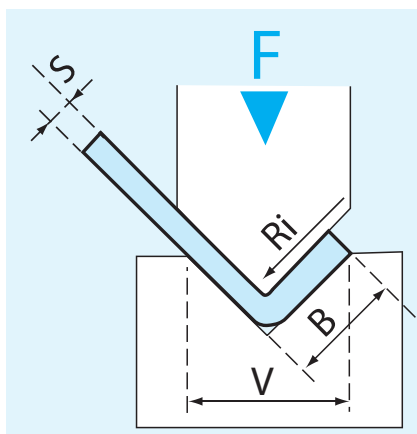
MATRICI/DIES 60

LAME PER CESOIE/SHEAR BLADES 61

MODULO DI IDENTIFICAZIONE LAME PER CESOIA 62

Calcolo della forza di piega in aria

Calculation of force for air bending



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

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/mm²
 aluminium 20-25 Kg/mm²
R acciaio dolce 40-45 Kg/mm²
 mild steel 40-45 Kg/mm²
R inox 65-70 Kg/mm²
 stainless steel 65-70 Kg/mm²

Tabella di piegatura in aria - per piega 90° con lamiera R = 45 kg/mm²

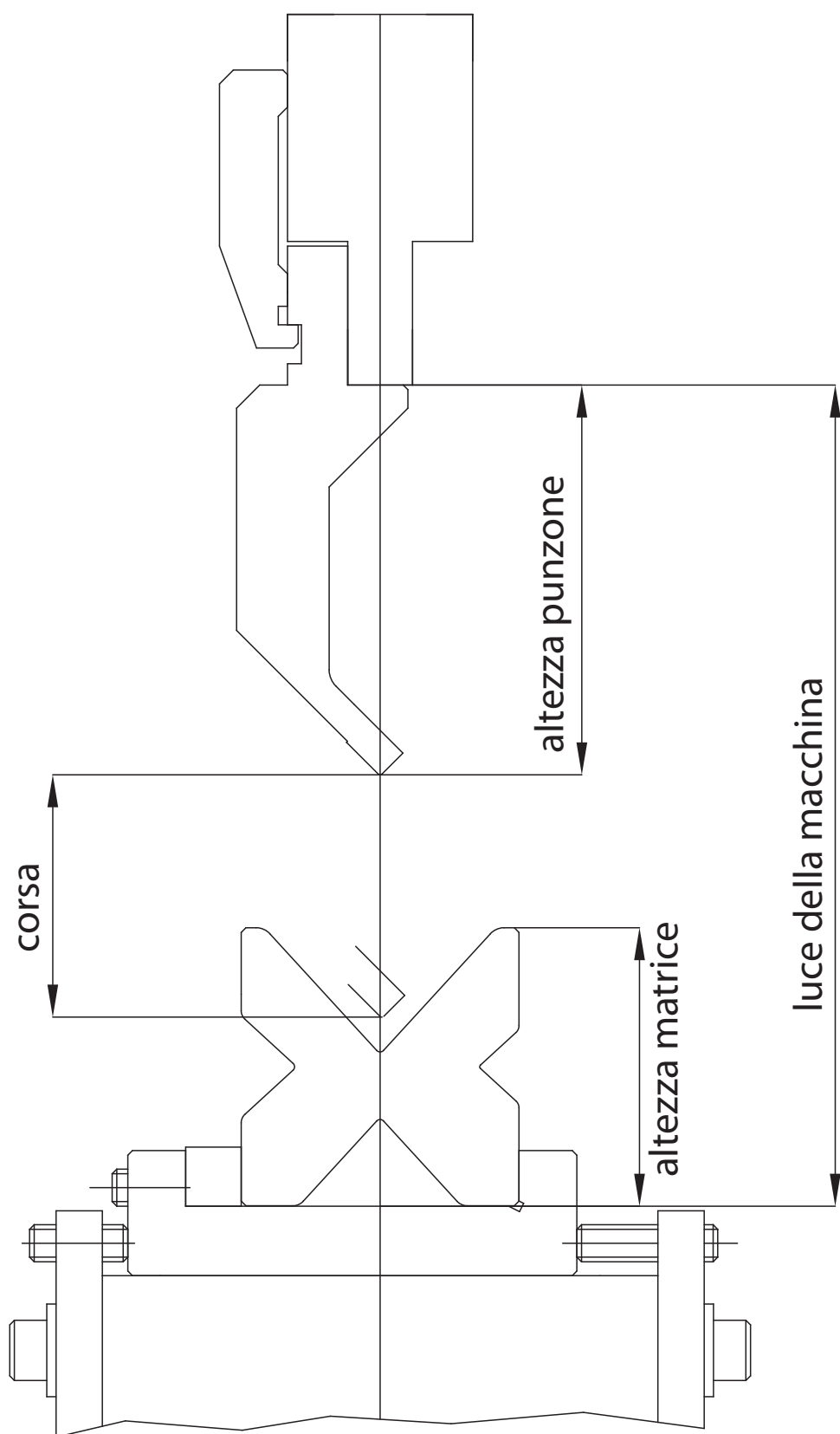
Chart by bending in the air - for 90° air bending, sheet resistance R = 45 kg/mm²

S	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
	4	5,5	7	8,5	11	14	17,5	22	28	35	45	55	71	89	113	140	175	B
	1	1,3	1,6	2	2,6	3,3	4	5	6,5	8	10	13	16	20	26	33	41	Ri
mm																		
0,5	3																	
0,6	4	4																
0,8	7	5	4															
1	11	8	7	6														
1,2	16	12	10	8	6													
1,5		17	15	13	9	8												
2			27	22	17	13	11											
2,5				35	26	21	17	13										
3					38	30	24	19	15									
4						54	42	34	27	21								
5							67	52	42	33	26							
6								75	60	48	38	30						
8									107	85	68	53	43					
10										134	105	85	67	53				
12											153	120	95	78	60			
15												188	150	120	95	75		
20													270	215	170	135	108	F

t/m

Soluzioni per l'utilizzo degli utensili AMADA-PROMECAM su tutte le presse piegatrici
RETROFITTING.

Special solutions to fit AMADA-PROMECAM tools suitable for any type of press brake.

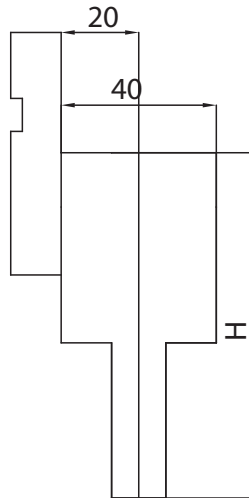
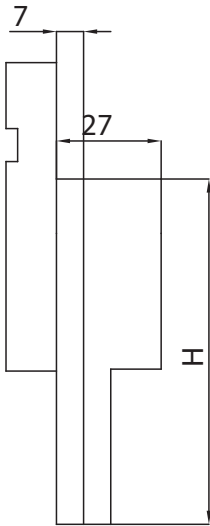


intermediari fissi/intermediates

42.260 H=100

42.280 H=120

42.270 H=150

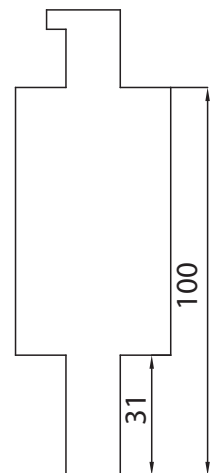
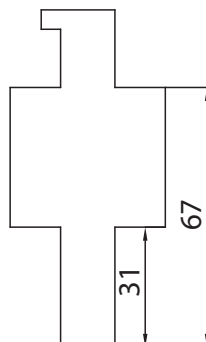
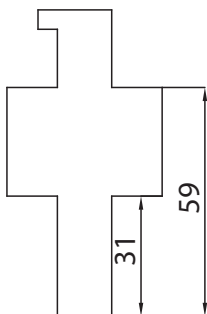


intermediari fissi retrofitting

40.000

40.010

40.020



intermediari registrabili/intermediates

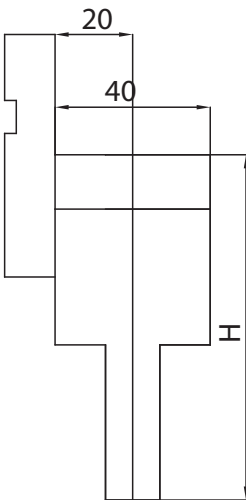
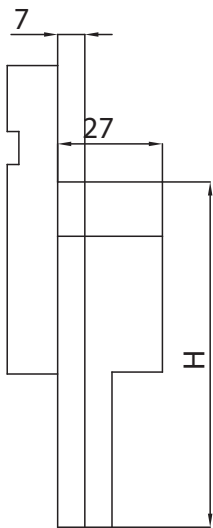
42.210	H=100
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42.240	H=100
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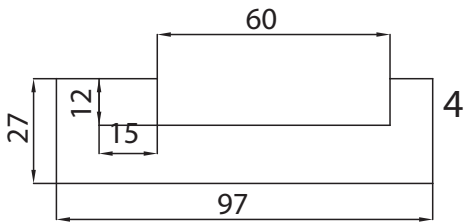
42.220	H=120
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42.250	H=120
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42.230	H=150
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canalina

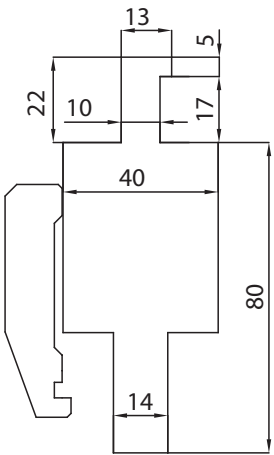


	L
90.100	2100mm
90.110	2600mm
90.120	3100mm
90.130	4100mm

adattatori - staffe non incluse/adapters

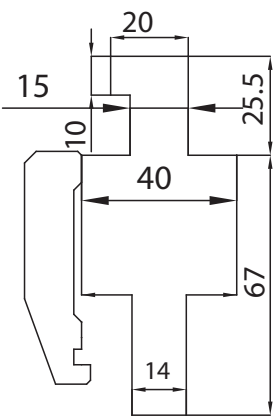
41.430	l=150mm
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LVD



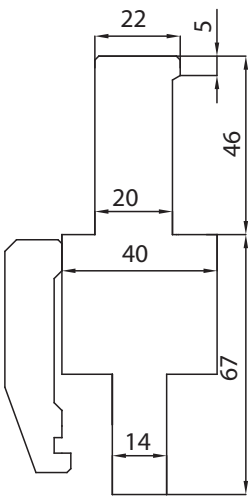
42.180	l=150mm
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DURMAZLAR



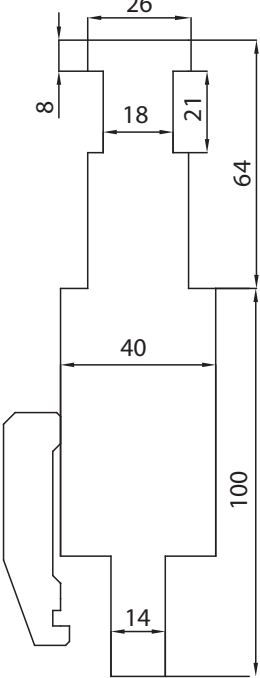
41.930	l=150mm
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BEYELER-S



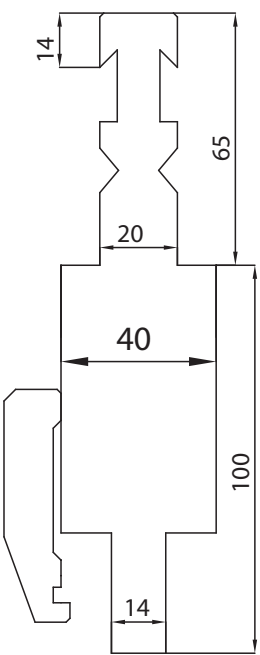
42.170	l=150mm
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EHT



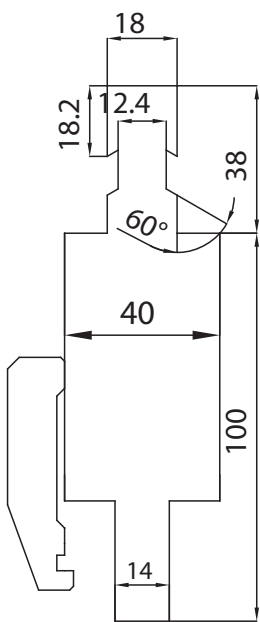
42.140	l=150mm
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BEYELER-RFA



42.730	l=150mm
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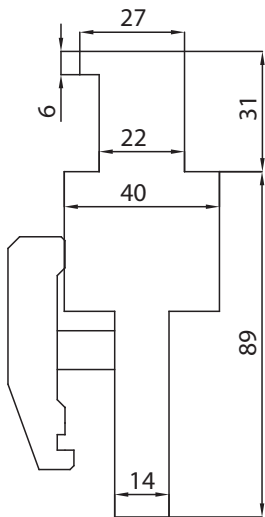
COLGAR



adattatori - staffe non incluse/adapters

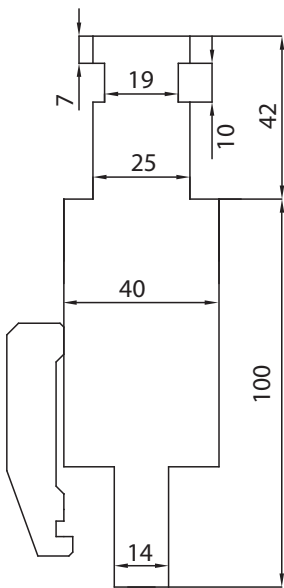
42.720	l=150mm
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BAYKAL



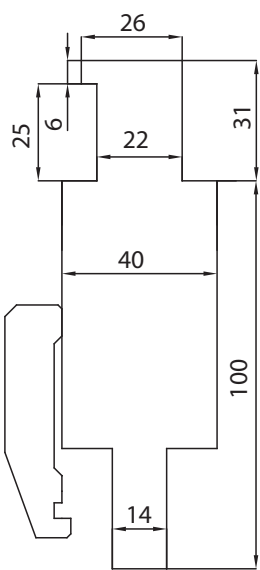
42.150	l=150mm
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WEINBRENNER



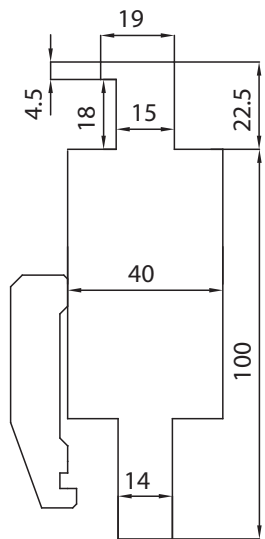
42.290	l=150mm
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DARLEY



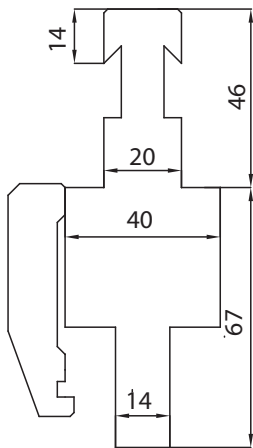
42.160	l=150mm
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CBC



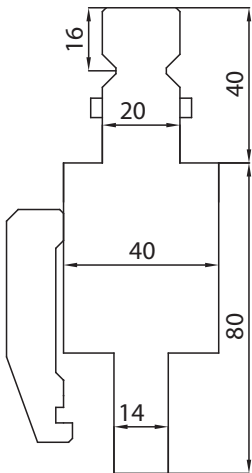
41.920	l=150mm
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BEYELER-R



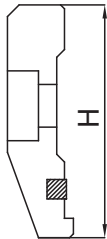
41.910	l=150mm
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WILA-TRUMPF

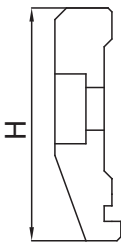


staffe/clamps L=150

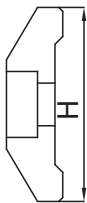
41.990	h58mm
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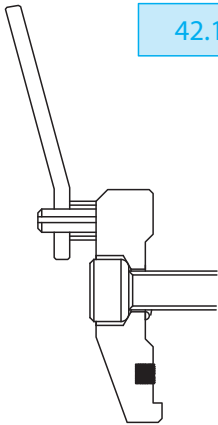
40.200	h58mm
50.120	h52mm



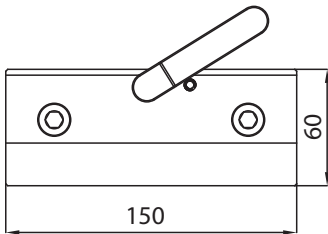
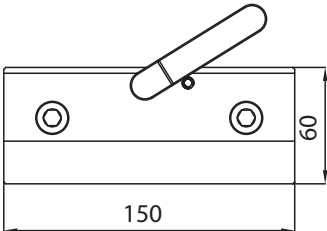
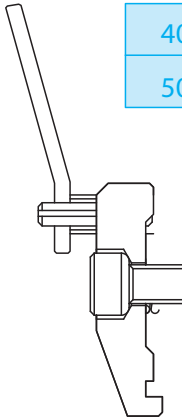
40.160	h50mm
50.130	h43mm



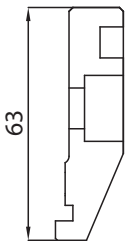
42.190	h58mm
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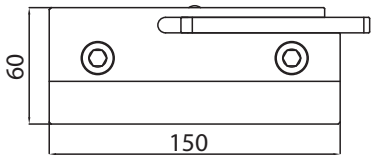
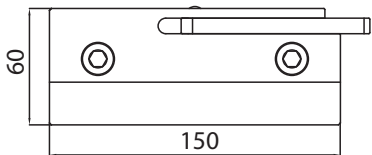
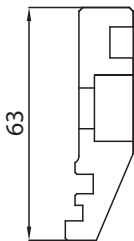
40.210	h58mm
50.110	h52mm



40.090	h63mm
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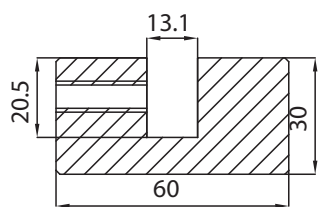
42.220	h63mm
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adattatori inferiori/lower adapters

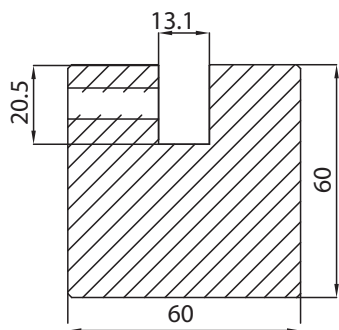
43.010	l=1000
	l=500

amada-trumpf/beyeler



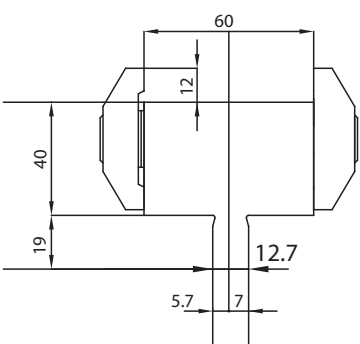
43.020	l=1000
	l=500

amada-trumpf/beyeler



43.040	l=835
	l=415

lvd-amada



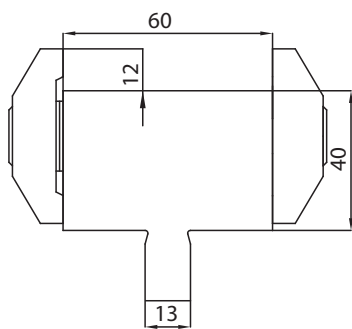
43.030	l=1000
	l=500

40.330	l=835
40.500	l=835

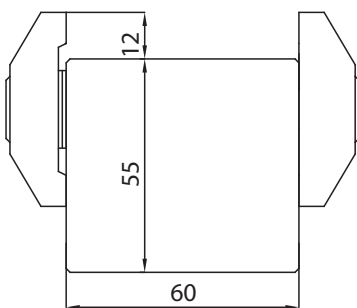
con staffa
intera

43.050	l=1000
	l=500

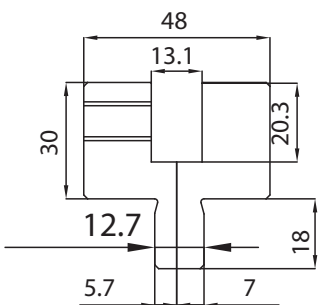
beyeler/trumpf-amada



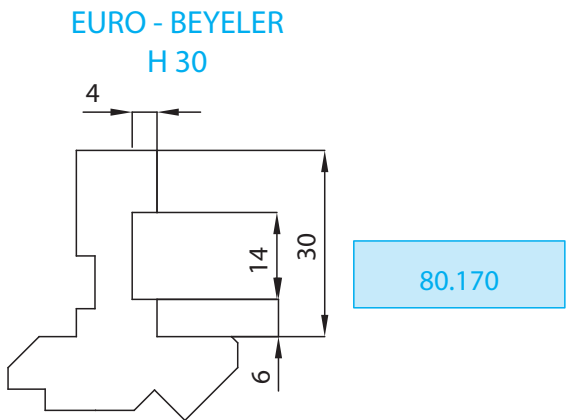
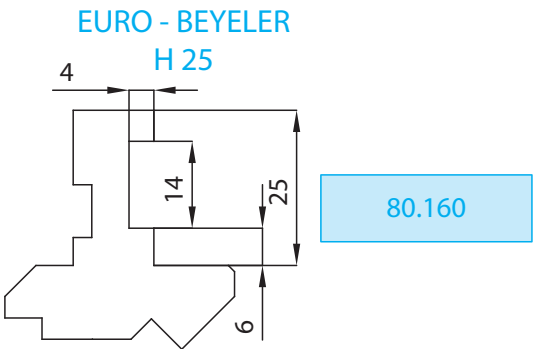
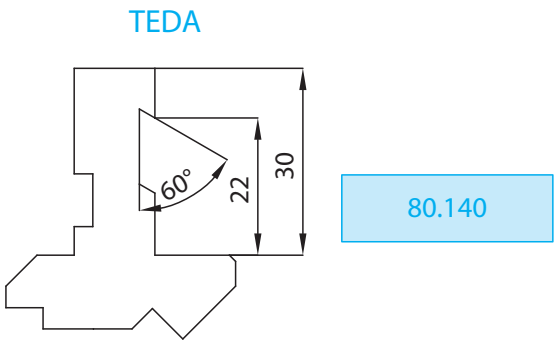
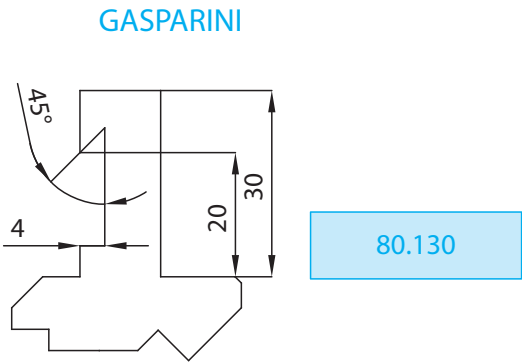
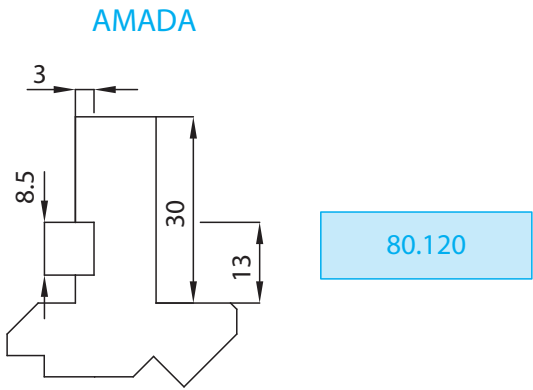
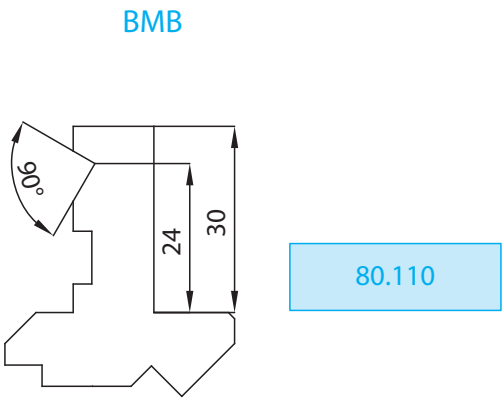
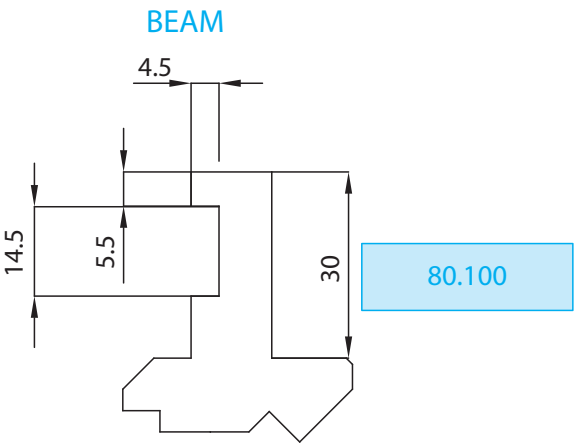
amada



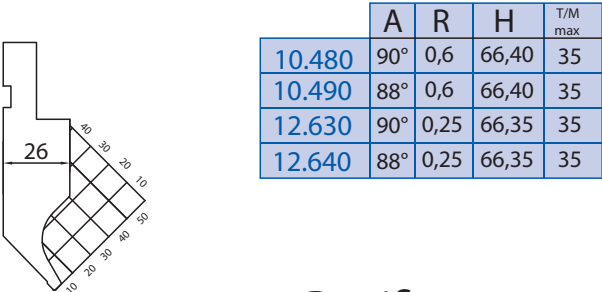
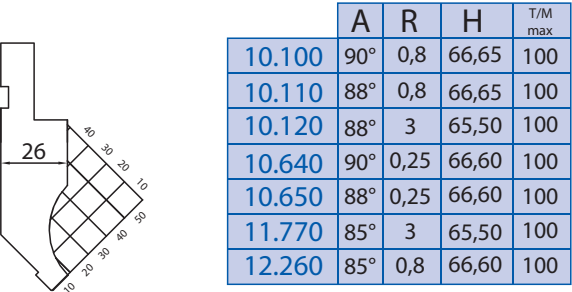
lvd-beyeler-trumpf



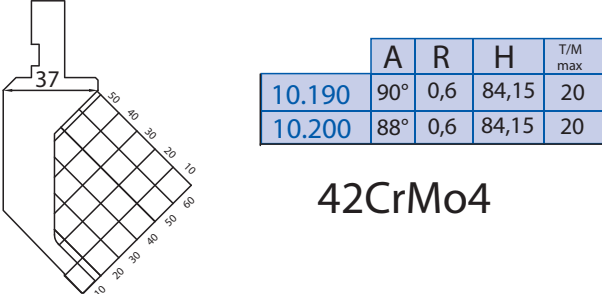
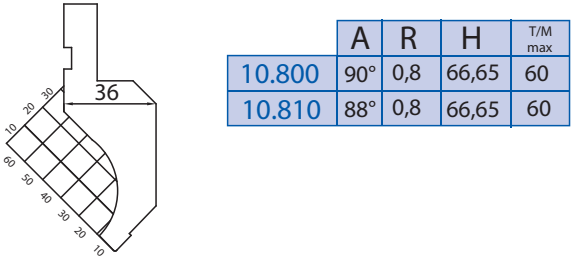
scanalature di sicurezza



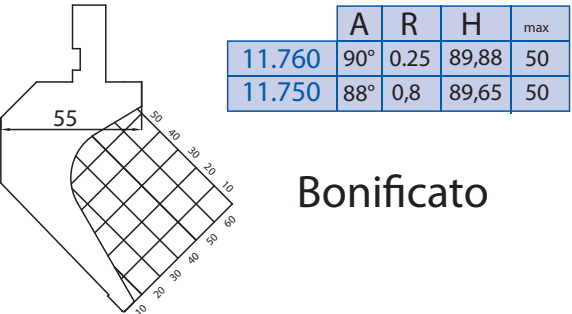
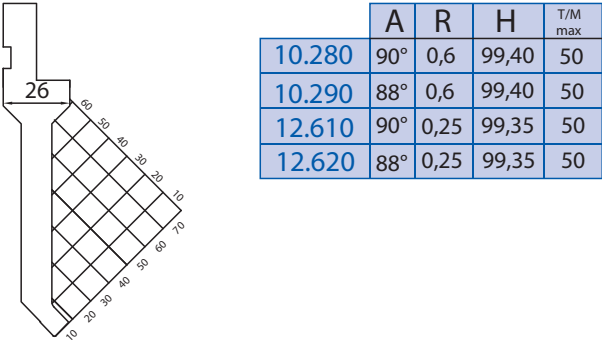
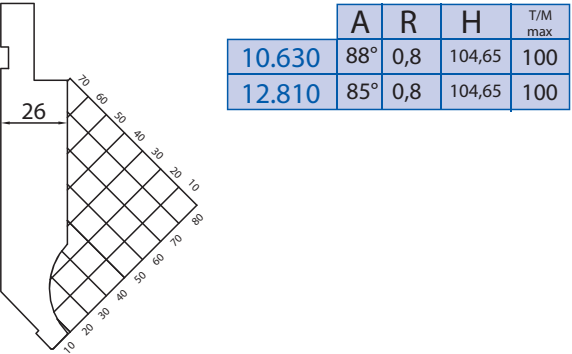
punzoni/punches 90°/88°/85°



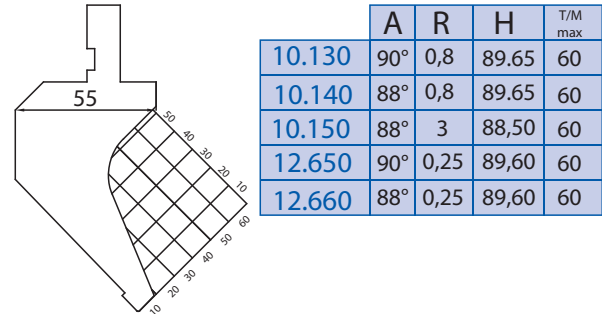
Bonificato



42CrMo4



Bonificato

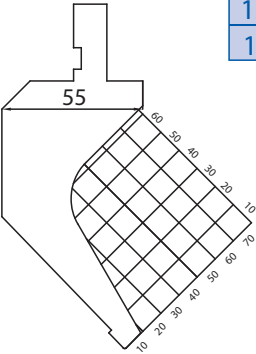


AMADA PROMECAM TYPE

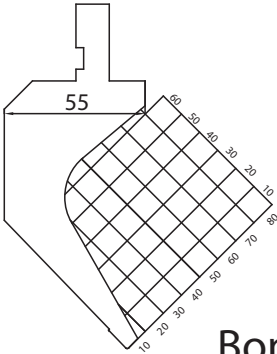
punzoni/punches 90°/88°/85°

AMADA PROMECAM TYPE

	A	R	H	T/M max
10.160	90°	0,8	104,65	50
10.170	88°	0,8	104,65	50
10.180	88°	3	103,50	50
11.720	85°	0,8	104,60	50
12.670	90°	0,25	104,60	50
12.680	88°	0,25	104,60	50

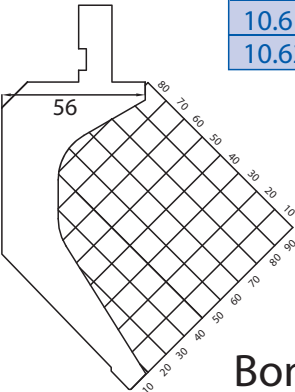


	A	R	H	T/M max
11.740	90°	0,25	104,88	50
11.730	88°	0,8	104,65	50



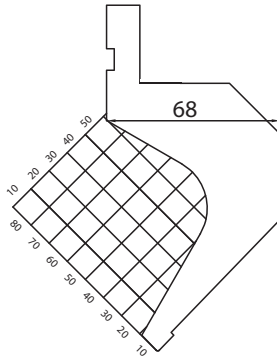
Bonificato

	A	R	H	T/M max
10.600	90°	0,8	120	50
10.610	88°	0,8	120	50
10.620	88°	3	119	50

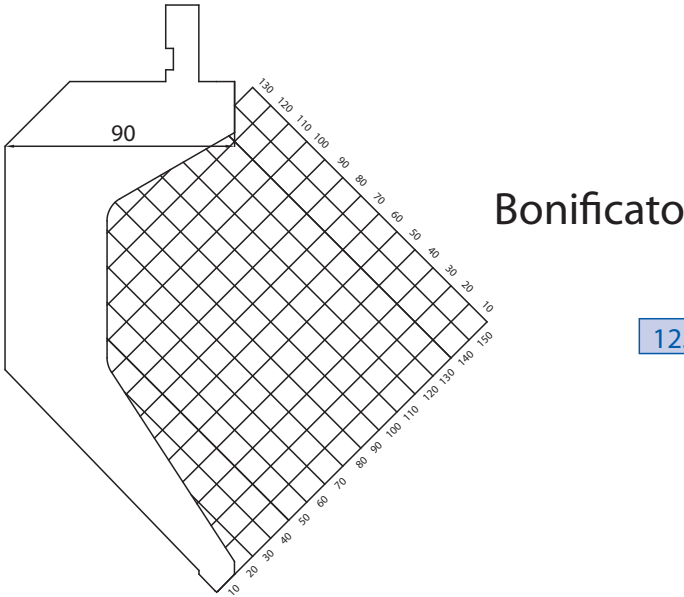
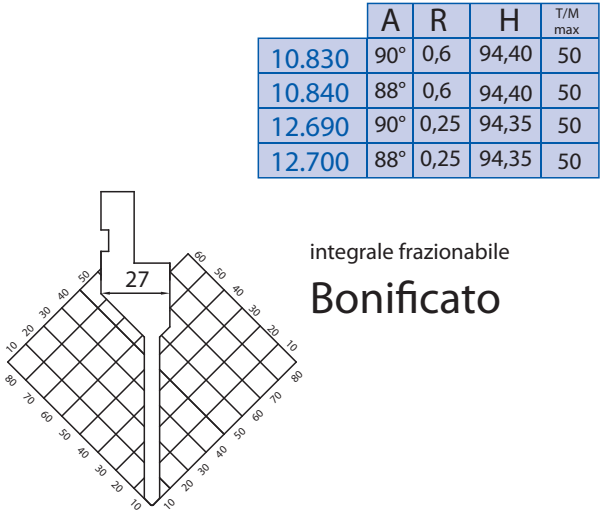
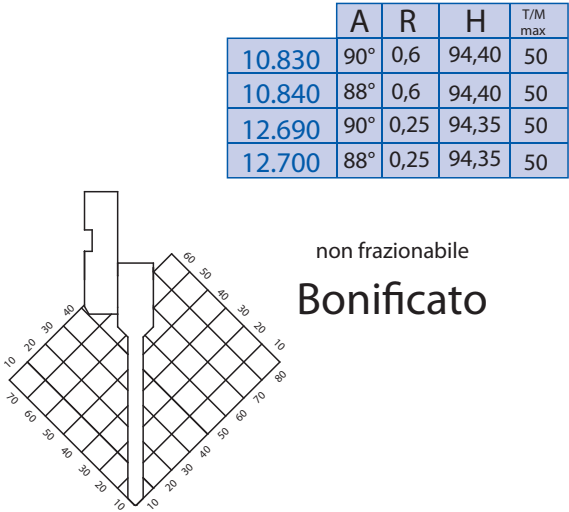
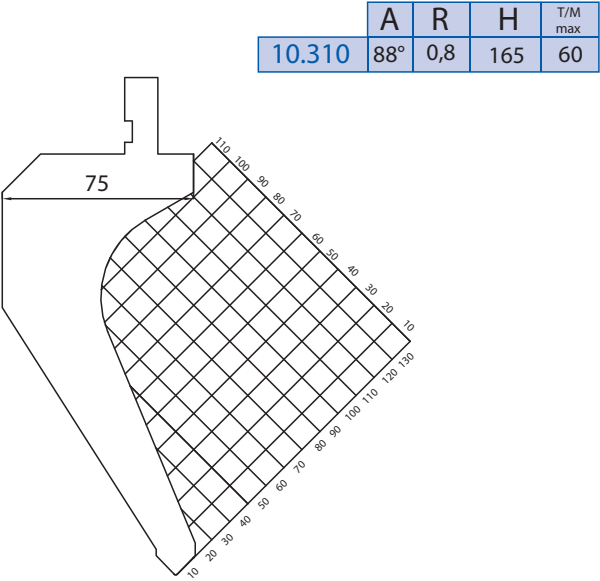
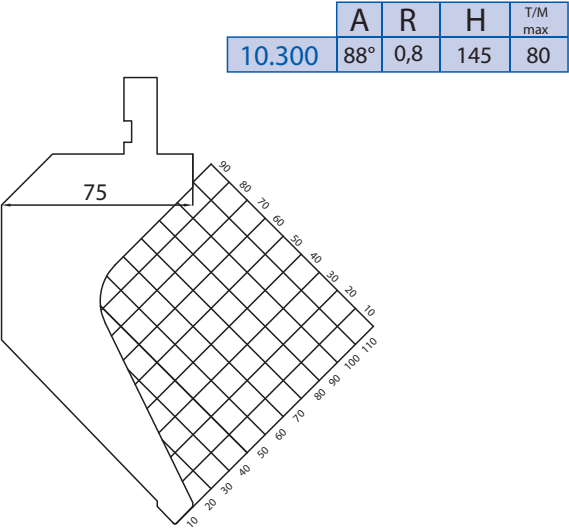


Bonificato

	A	R	H	T/M max
10.820	88°	0,8	104,65	45



punzoni/punches 90°/88°

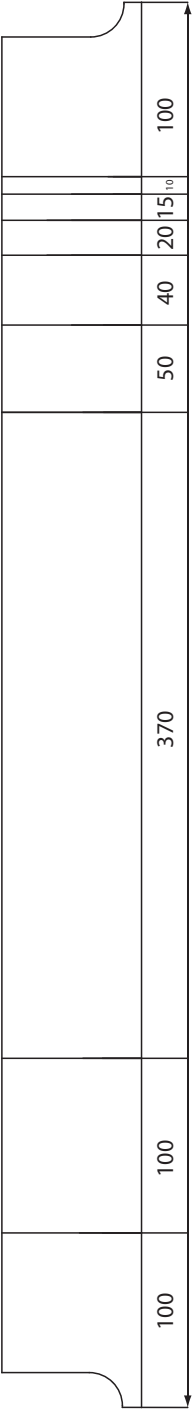


	A	R	H	T/M max
12.910	88°	0,8	200	75

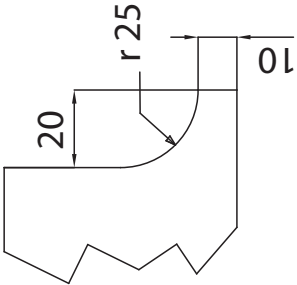
AMADA PROMECAM TYPE

punzoni/punches 90°/88° - frazionatura standard l = 805

AMADA PROMECAM TYPE

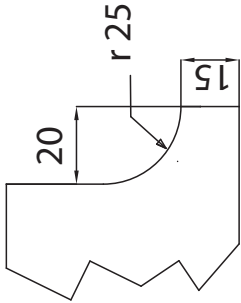


10.100	10.170	10.290	10.640	11.620	12.260	12.710
10.110	10.180	10.300	10.650	11.630	12.610	12.720
10.120	10.240	10.310	10.800	12.910	12.620	12.810
10.130	10.250	10.600	10.810	11.720	12.670	12.830
10.140	10.260	10.610	10.820	11.770	12.680	12.840
10.150	10.270	10.620	10.830	11.900	12.690	
10.160	10.280	10.630	10.840	11.910	12.700	

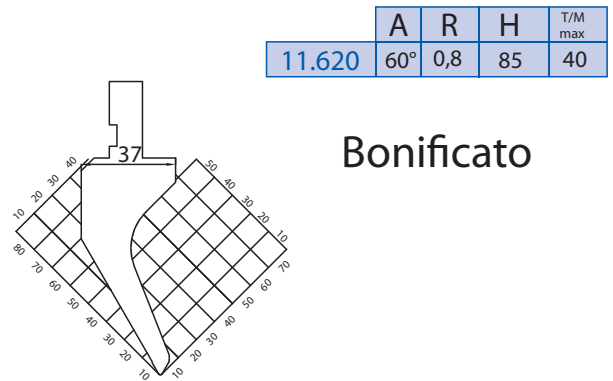
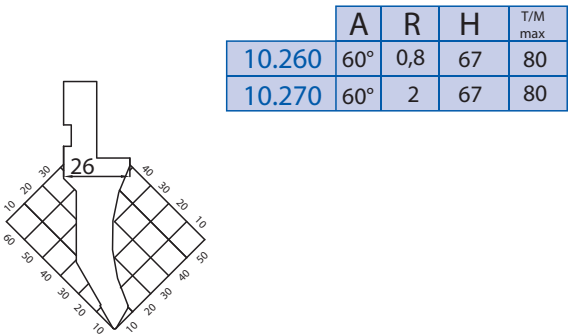


scarpette

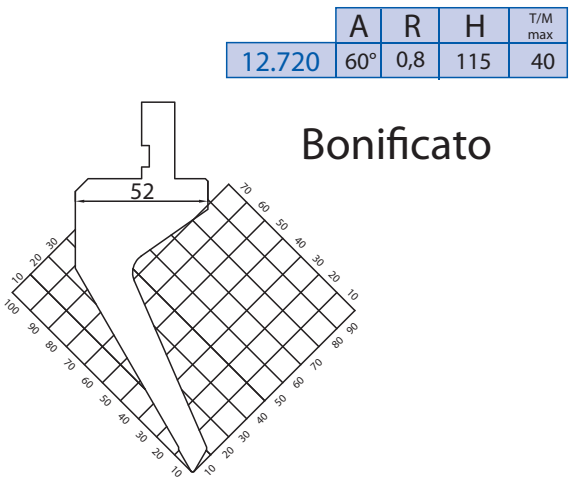
10.190	10.480	10.570	11.920	12.920	
10.200	10.490	10.860	11.930		
10.330	10.520	11.730	11.940		
10.340	10.530	11.740	12.630		
10.350	10.540	11.750	12.640		
10.320	10.550	11.760	12.820		
10.470	10.560	11.780	12.890		



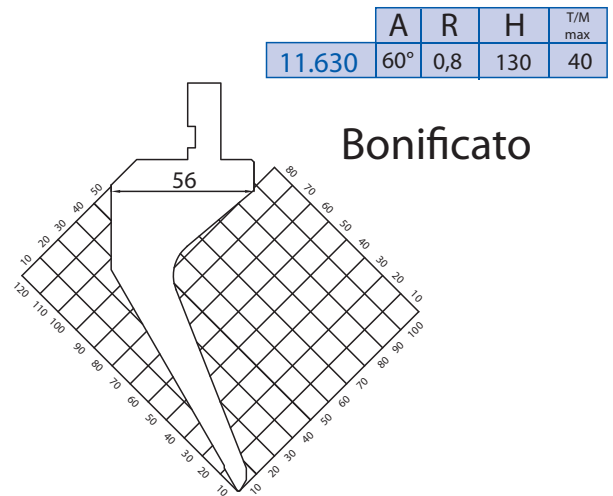
punzoni/punches 60°/45°



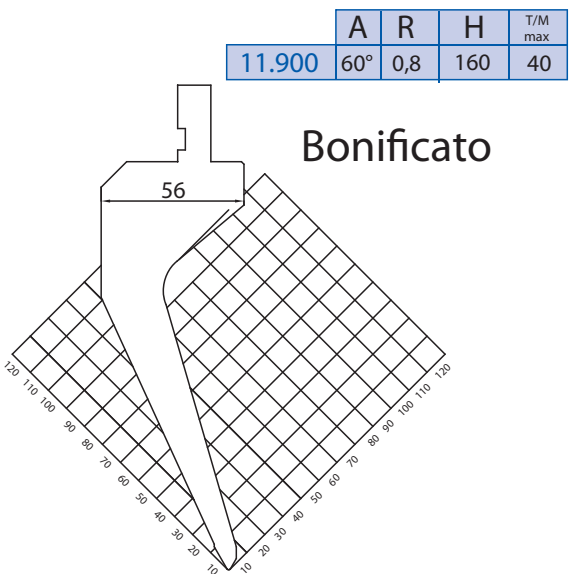
Bonificato



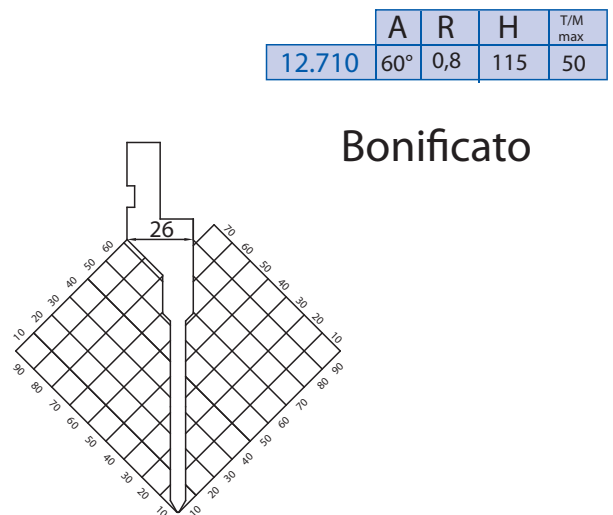
Bonificato



Bonificato



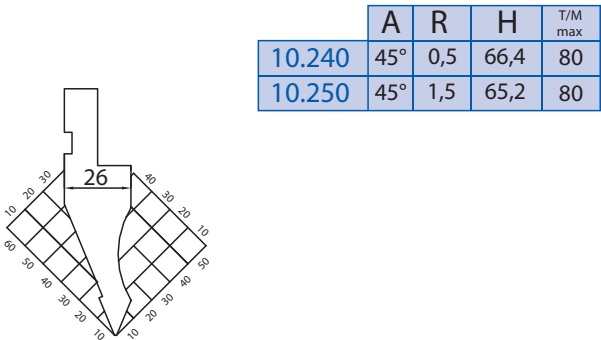
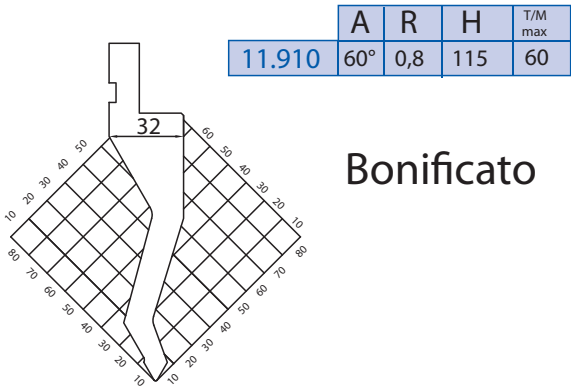
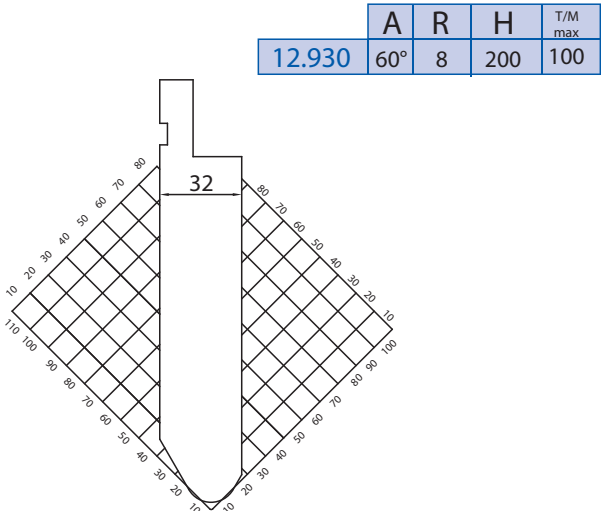
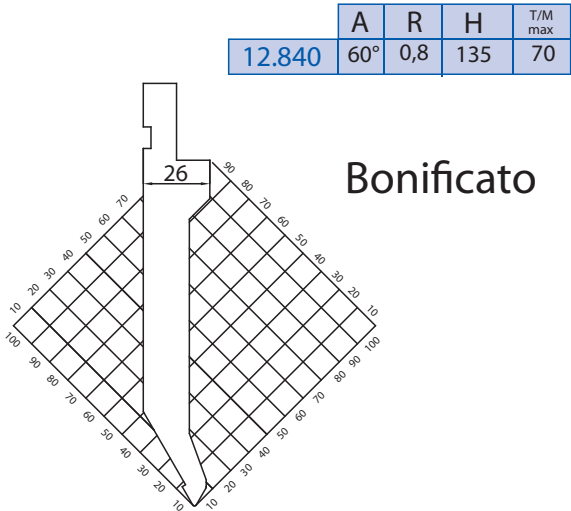
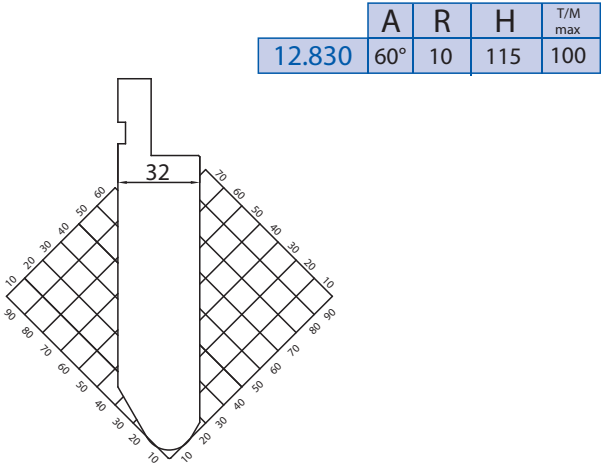
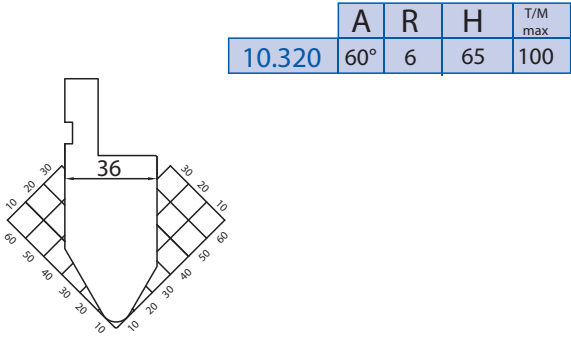
Bonificato



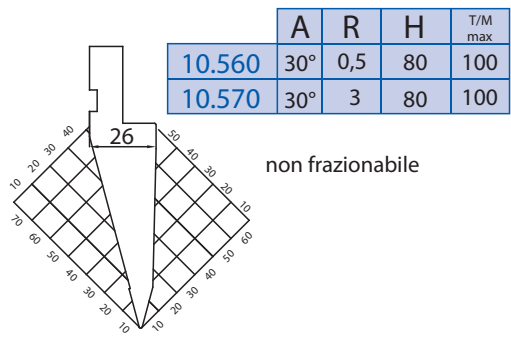
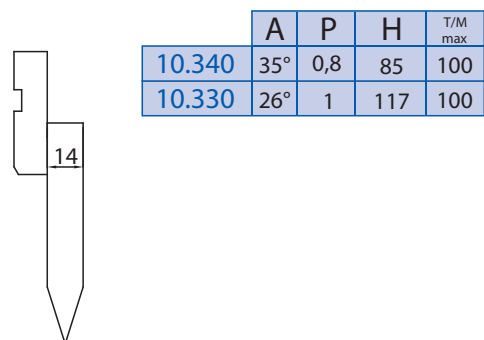
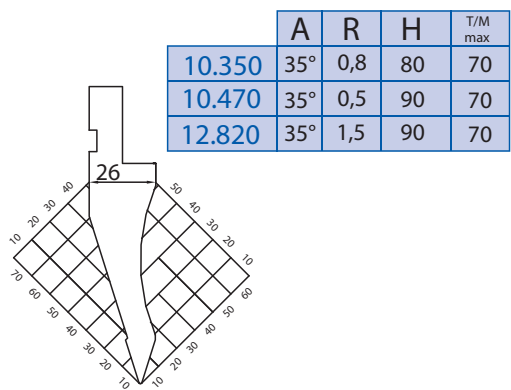
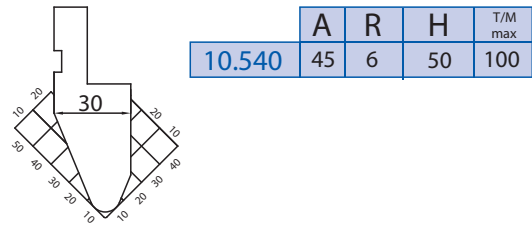
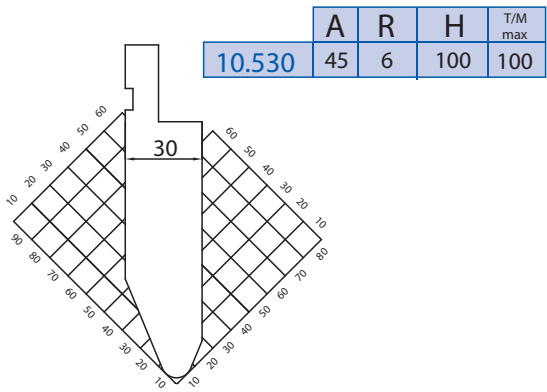
Bonificato

punzoni/punches 60°/45°

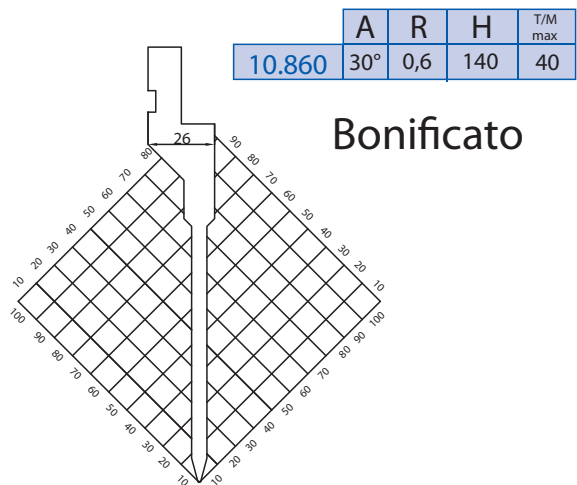
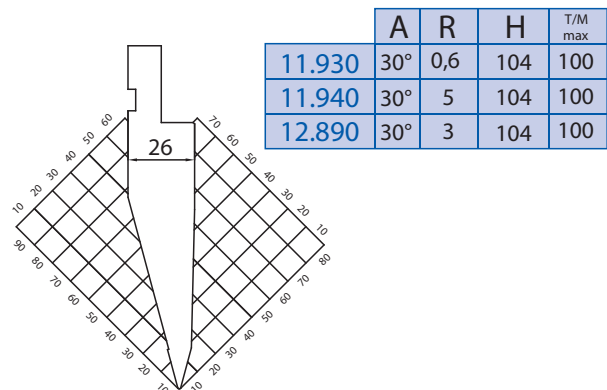
AMADA PROMECAM TYPE



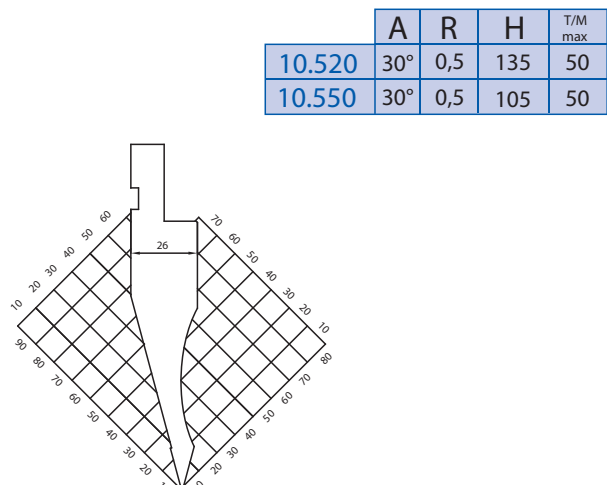
punzoni/punches 45°/35°/30°/26°



non frazionabile



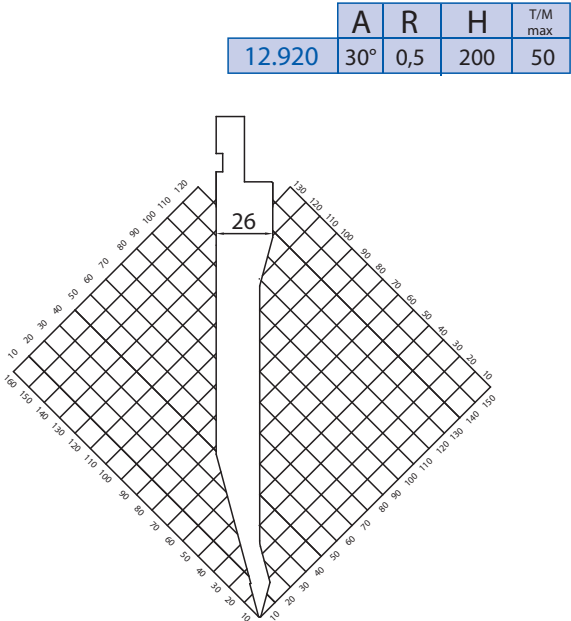
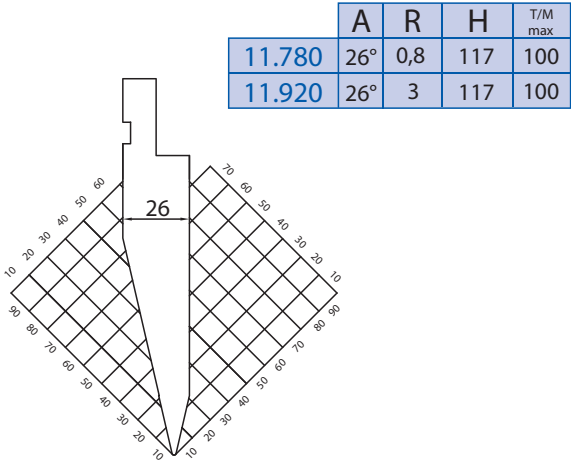
Bonificato



AMADA PROMECAM TYPE

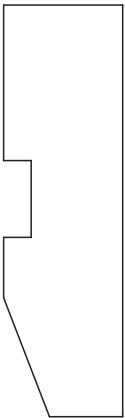
punzoni/punches 45°/35°30°/26°

AMADA PROMECAM TYPE

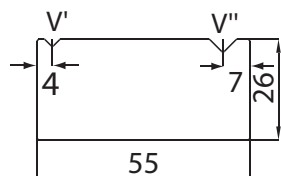


codolo per lame

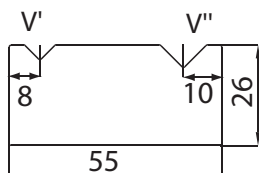
10.440



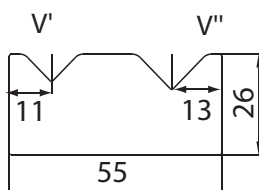
matrici/dies 2V 90°/88°/60°/30°



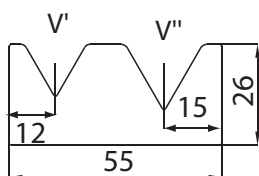
	A	V'	R'	V''	R''	T/M max
20.100	90°	4	0.3	7	0.5	100



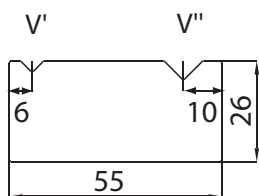
	A	V'	R'	V''	R''	T/M max
20.120	90°	8	0.5	12	0.8	100
20.410	88°	8	1	12	1.5	100
20.160	60°	8	0.8	12	1.2	60



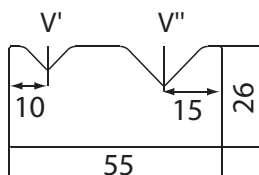
	A	V'	R'	V''	R''	T/M max
20.320	88°	14	2.75	18	3	100



	A	V'	R'	V''	R''	T/M max
20.170	60°	16	1.6	20	20	60



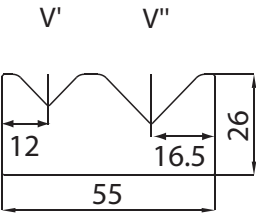
	A	V'	R'	V''	R''	T/M max
20.110	90°	6	0.4	10	0.6	100
20.460	88°	6	0.8	10	1.2	100
20.150	60°	6	0.4	10	0.6	60



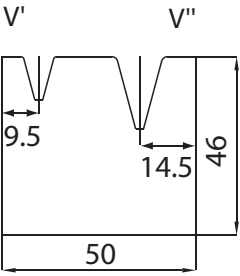
	A	V'	R'	V''	R''	T/M max
20.130	88°	12	2.75	20	3	100
20.330	60°	12	0.8	20	1.5	60

matrici/dies 2V 90°/88°/60°/30°

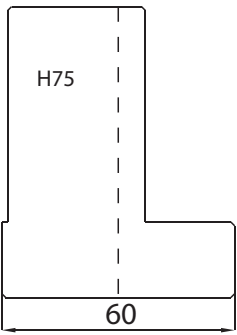
AMADA PROMECAM TYPE



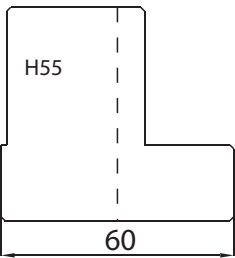
	A	V'	R'	V''	R''	T/M max
20.140	88°	16	2.75	25	3	100



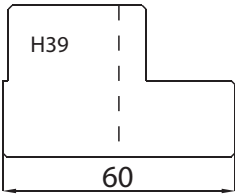
	A	V'	R'	V''	R''	T/M max
20.470	30°	8	0.8	12	1.5	40



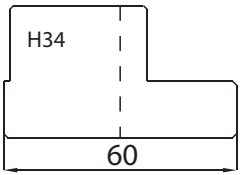
20.350



20.190

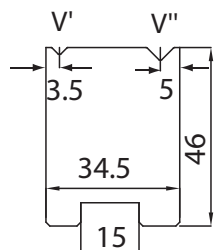


20.390

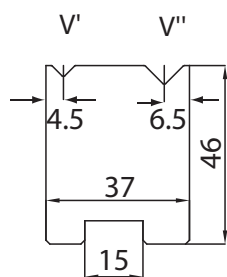


20.180

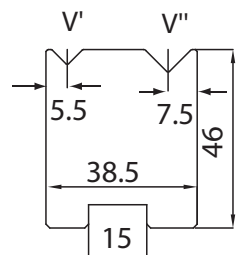
matrici 2V autocentranti/2V self centering dies 90°/88°/30°



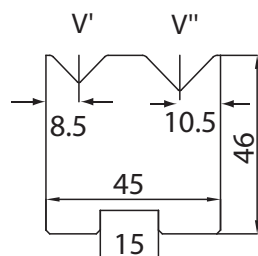
	A	V'	R'	V''	R''	T/M max
20.480	90°	4	0.3	7	0.5	80



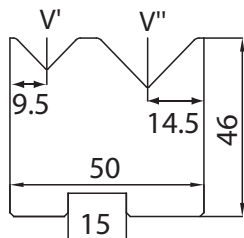
	A	V'	R'	V''	R''	T/M max
20.490	90°	6	0.4	10	0.6	80
20.500	88°	6	0.8	10	1.2	80



	A	V'	R'	V''	R''	T/M max
20.510	90°	8	0.5	12	0.8	80
20.520	88°	8	1	12	1.5	80



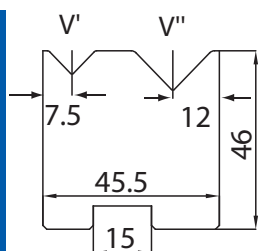
	A	V'	R'	V''	R''	T/M max
20.530	88°	14	1.25	18	1.5	80



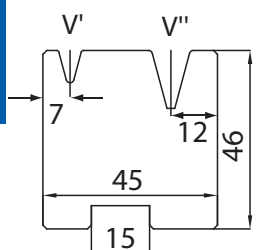
	A	V'	R'	V''	R''	T/M max
20.560	30°	8	0.8	12	1.5	40
20.550	88°	16	1.5	25	1.75	80

matrici 2V autocentranti/2V self centering dies 90°/88°/30°

AMADA PROMECAM TYPE

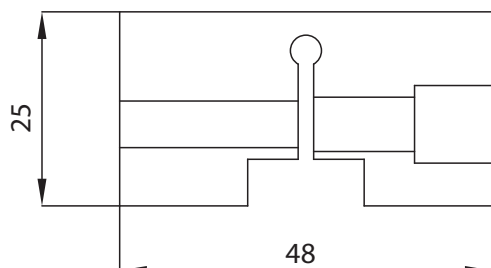


	A	V'	R'	V''	R''	T/M max
20.540	88°	12	0.8	20	1.75	80



	A	V'	R'	V''	R''	T/M max
20.570	30°	6	0.6	10	1	80

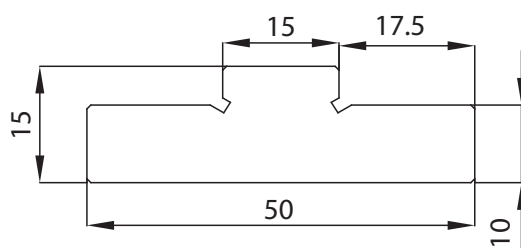
fermo per matrici autocentranti



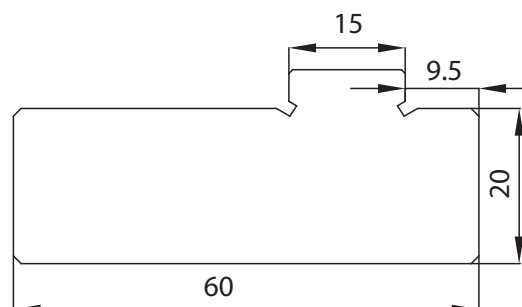
20.600

rialzi per matrici autocentranti

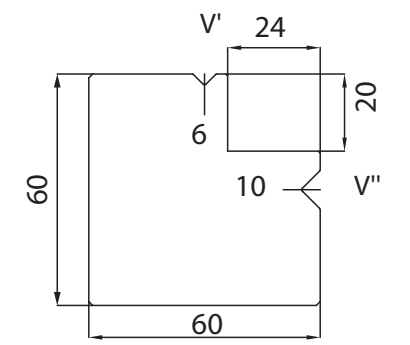
20.580



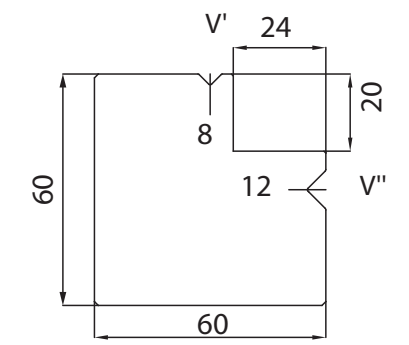
20.590



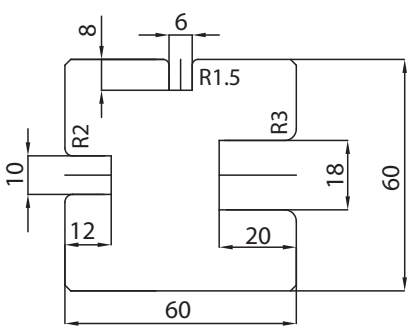
matrici/dies 4V/2V/1V



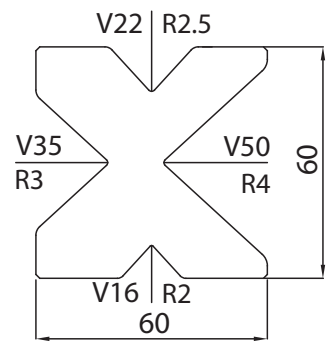
	A	V'	R'	V''	R''	T/M max
20.280	90°	6	0.4	10	0.6	80



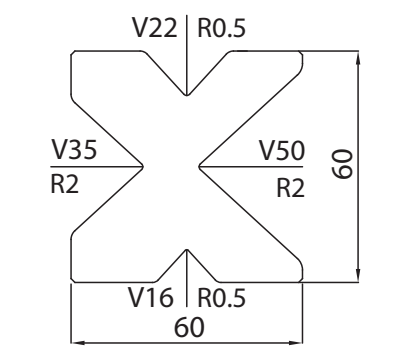
	A	V'	R'	V''	R''	T/M max
20.290	90°	8	0.5	12	0.8	80



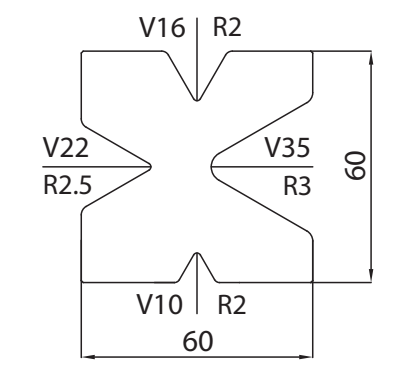
	T/M max
20.310	100



	T/M max
20.670	80



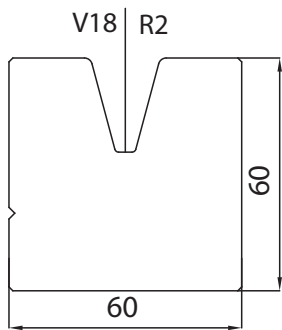
	T/M max
20.300	80



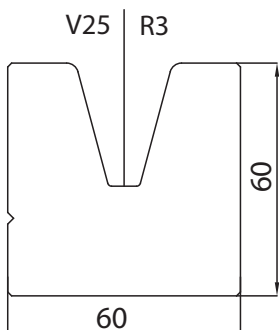
	T/M max
20.340	60

matrici/dies 4V/2V/1V

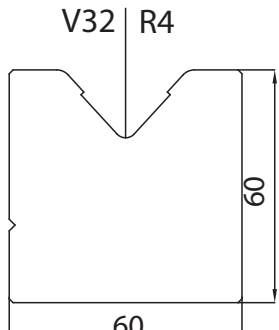
AMADA PROMECAM TYPE



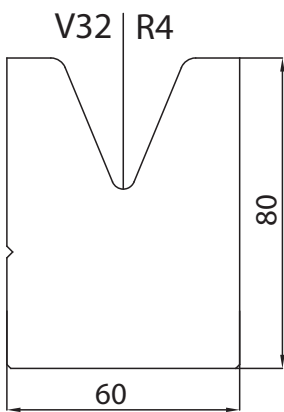
30°	20.860	T/M max 100
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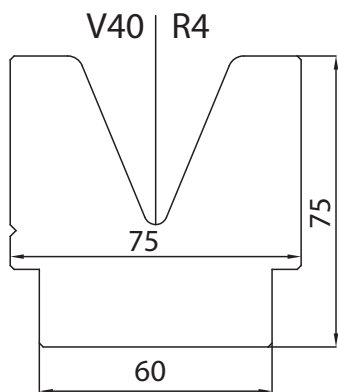
30°	20.870	T/M max 100
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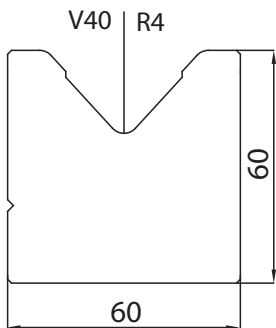
85°	20.200	T/M max 100
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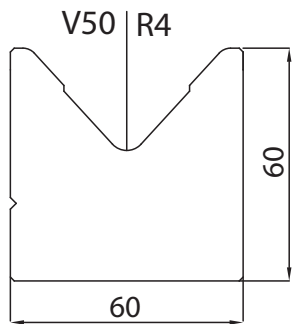
45°	20.880	T/M max 100
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45°	20.810	T/M max 100
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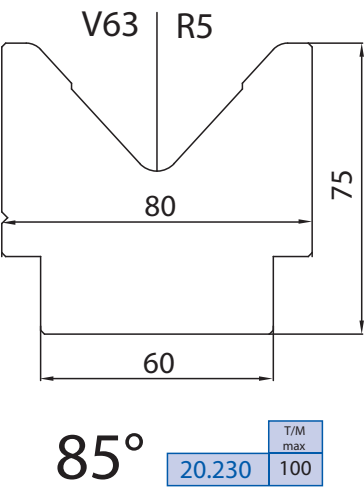
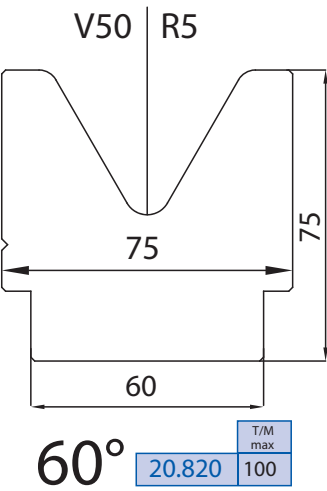


85°	20.210	T/M max 100
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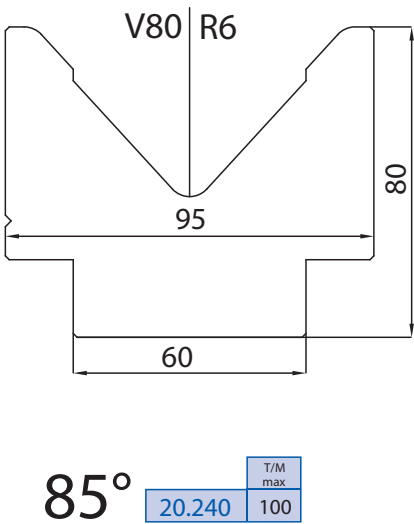
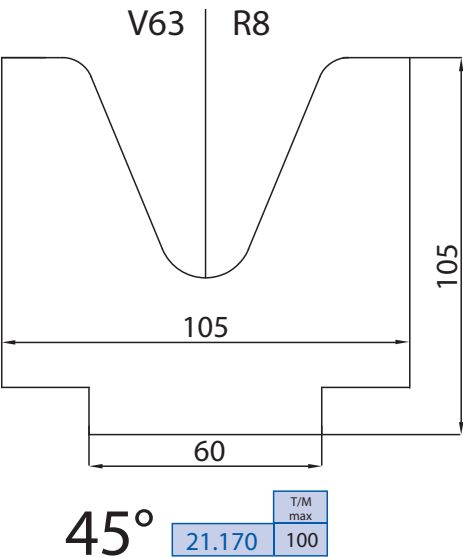
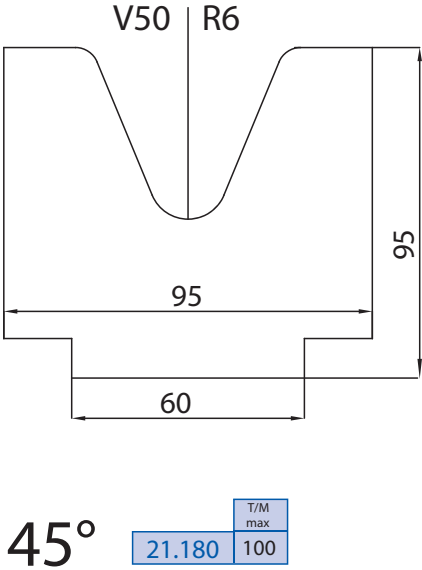
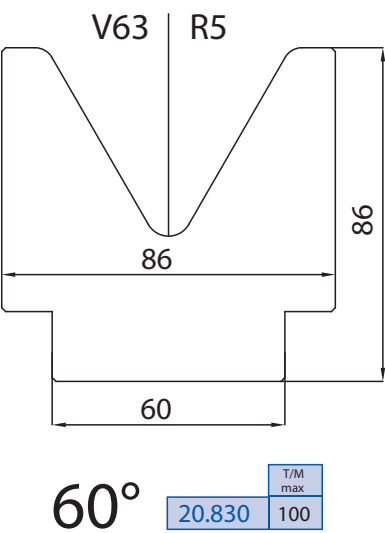


85°	20.220	T/M max 100
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matrici/dies 1V

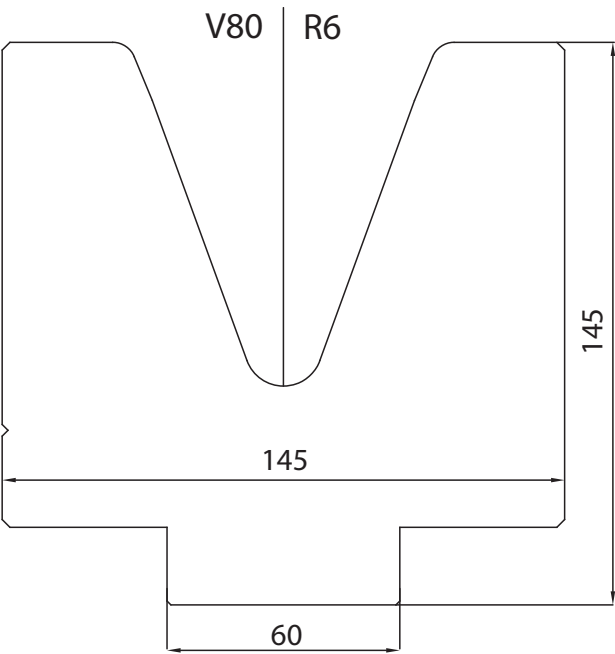


AMADA PROMECAM TYPE



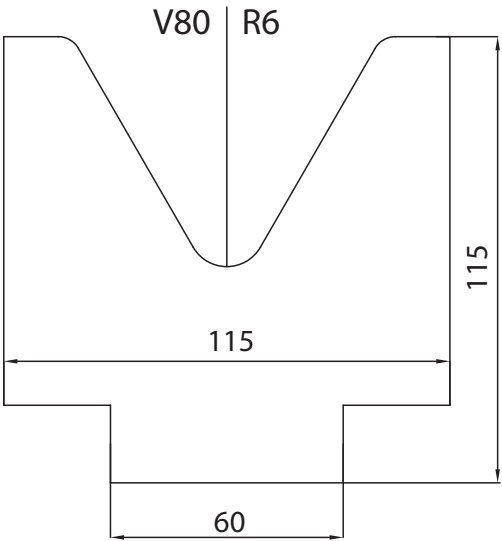
matrici/dies 1V

AMADA PROMECAM TYPE



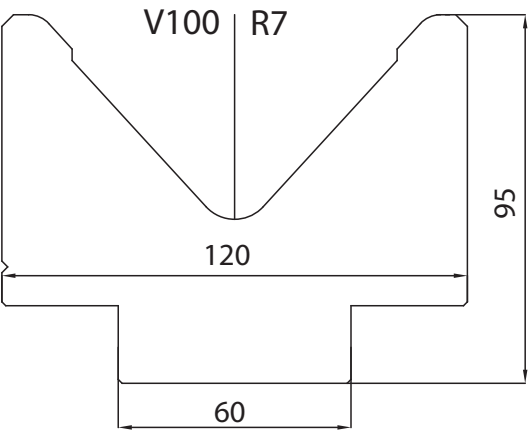
45°

20.840	T/M max 100
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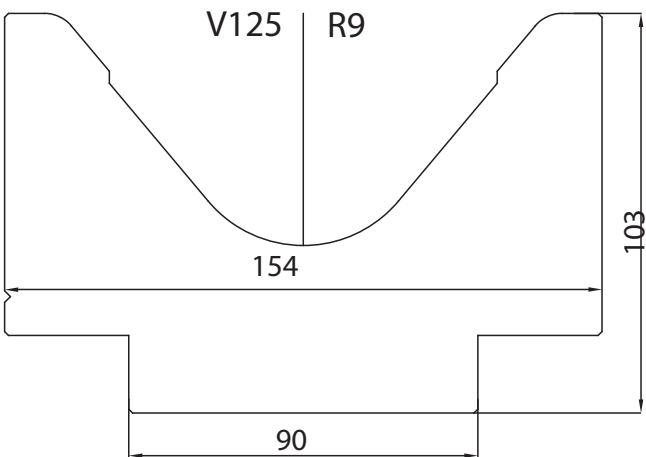
60°

20.890	T/M max 100
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85°

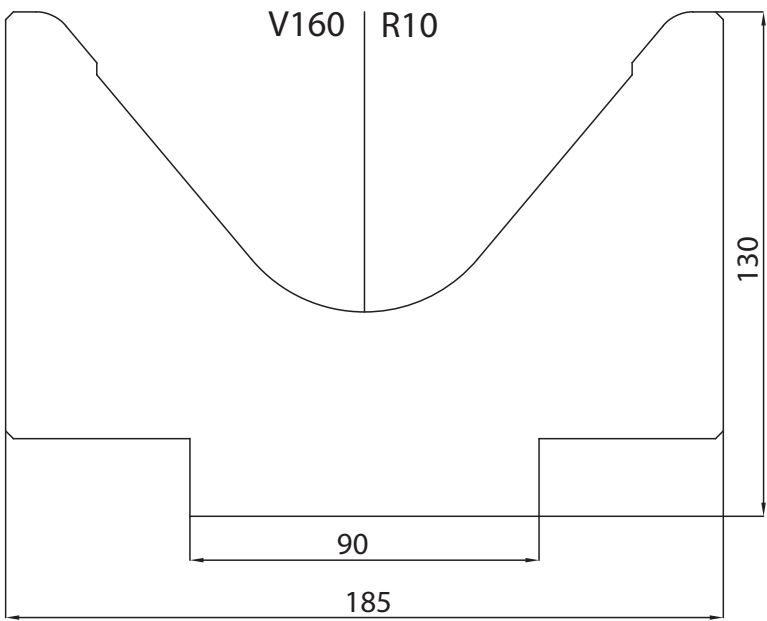
20.250	T/M max 100
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80°

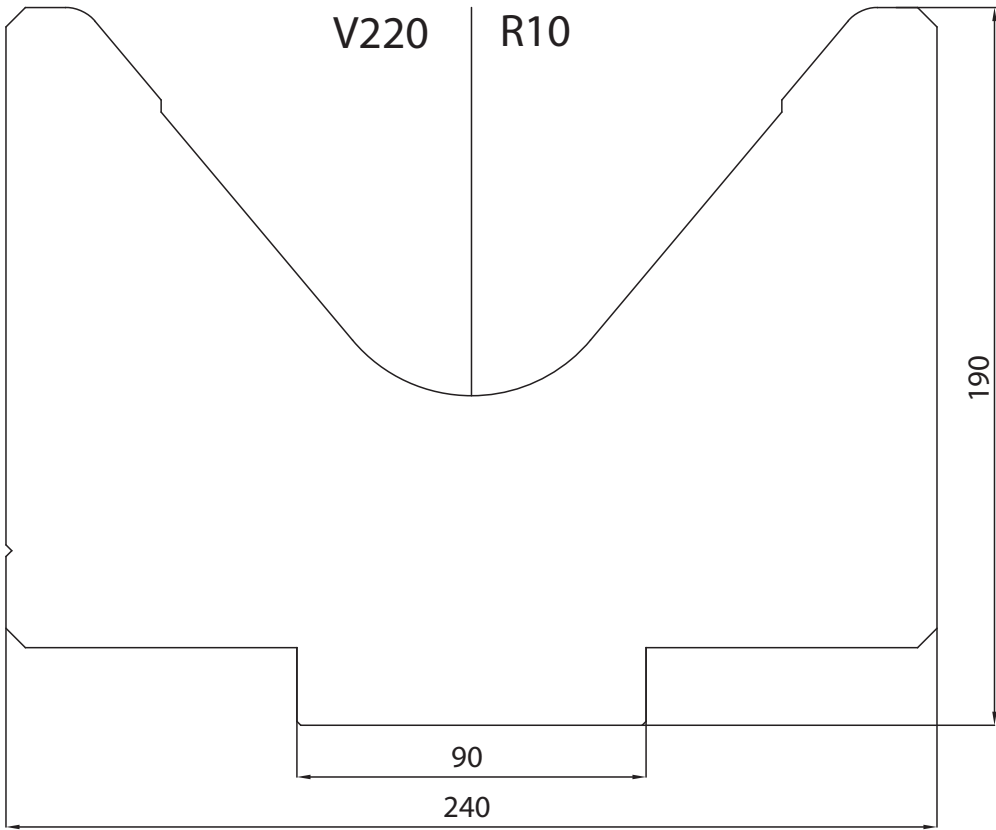
20.260	T/M max 100
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matrici/dies 1V



80°

T/M	max
20.270	100



70°

T/M	max
72.900	100

AMADA PROMECAM TYPE

matrici a T/T dies

A
90°

H 80	V	R	S	F	T/M max	H 120
30.100	6	0.4	14	r0.5	100	30.500
30.110	8	0.5	14	r0.5	100	30.510
30.120	10	0.6	18	r0.5	100	30.520
30.130	12	0.8	18	r0.5	100	30.530
30.140	16	1	24	r0.5	100	30.540

A
88°

H 80	V	R	S	F	T/M max	H 120
30.800	6	0.4	14	r0.5	100	30.830
30.810	8	0.5	14	r0.5	100	30.840
30.820	10	0.6	18	r0.5	100	30.850
30.150	12	2.75	18	r0.5	100	30.550
30.160	16	2.75	24	r0.5	100	30.560
30.170	20	3	30	r0.5	100	30.570
30.180	25	3	35	r0.5	100	30.580

A
60°

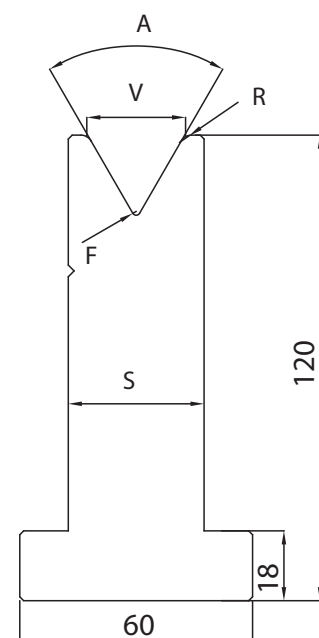
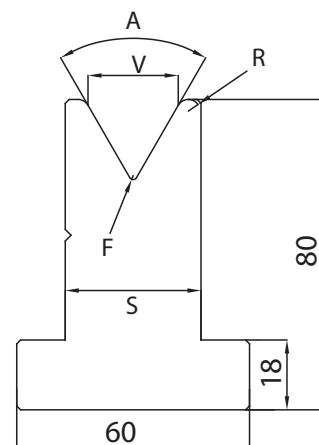
H 80	V	R	S	F	T/M max	H 120
30.190	6	0.4	14	r0.5	60	30.590
30.200	8	0.5	14	r0.5	60	30.600
30.210	10	0.6	18	r0.5	60	30.610
30.220	12	0.8	18	r0.5	60	30.620
30.230	16	3	24	r0.7	60	30.630
30.240	20	3	30	r0.7	60	30.640
30.250	25	3	35	r1	60	30.650

A
45°

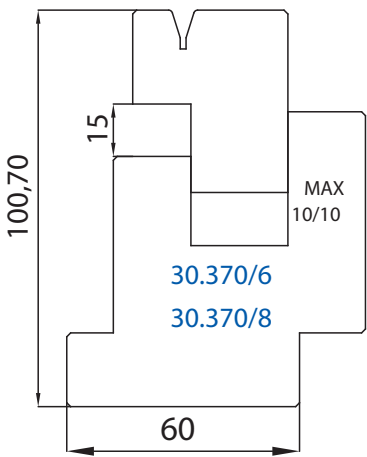
H 80	V	R	S	F	T/M max	H 120
30.260	6	0.6	14	r0.5	50	30.660
30.270	8	0.8	18	r0.5	50	30.670
30.280	10	1	18	r0.7	50	30.680
30.290	12	1.5	24	r0.7	50	30.690
30.300	16	2	24	r1	50	30.700
30.310	20	2.5	30	r1	50	30.710
30.320	25	3	35	r1	50	30.720

A
30°

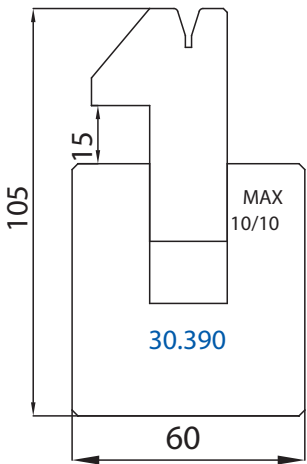
H 80	V	R	S	F	T/M max	H 120
30.420	6	0.6	14	r1	35	30.730
30.430	8	0.8	18	p2	35	30.740
30.440	10	1	24	p2	50	30.750
30.450	12	1.5	24	p2	40	30.760
30.460	16	2	30	p5	45	30.770
30.470	20	2.5	35	p5	50	30.780
30.480	25	3	40	p5	50	30.790



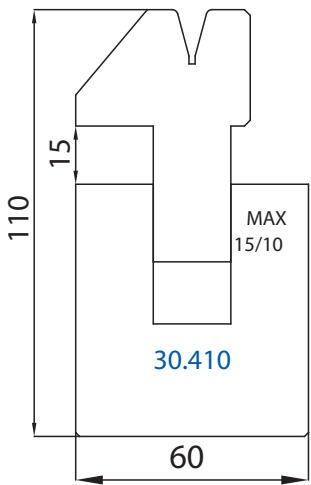
matrici piegaschiaccia/flattening hemming tools



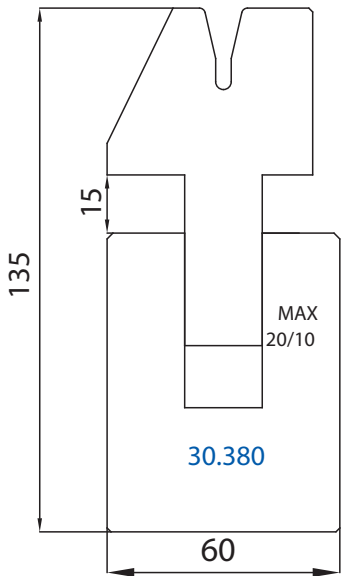
V6-R1
35°
V8-R1
35°



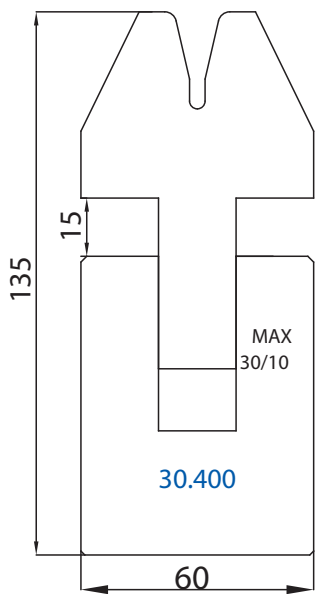
V6-R1
35°



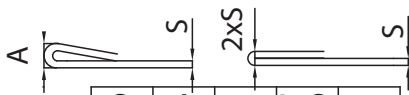
V8-R1.5
30°



V10-R1.5
26°

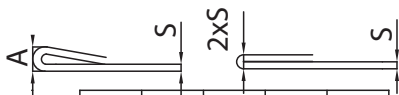


V12-R3
26°



S	A	T/M	2xS	T/M
0.6	3	9	1.2	23
0.8	3	12	1.6	32
1	3.5	15	1	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

Acc.R.45 Kg/mm²



S	A	T/M	2xS	T/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	31	2.5	80
1.5	4.6	38	3	95
2	5.5	50	4	130

Acc.R.70 Kg/mm²

piegaschiaccia pneumatici/hemming tools pneumatic

AMADA PROMECAM TYPE

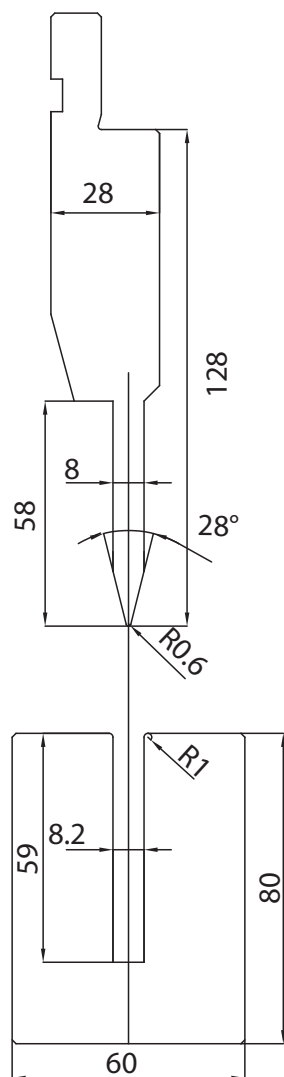


	V	A	R	H	T/M max
30.380PN	10	26°	1.5	135	100
30.390PN	6	35°	1	105	80
30.400PN	12	26°	3	135	100
30.410PN	8	30°	1.5	110	80

matrici piegaschiaccia/flattening hemming tools

11.950

80t/m



31.760

50t/m

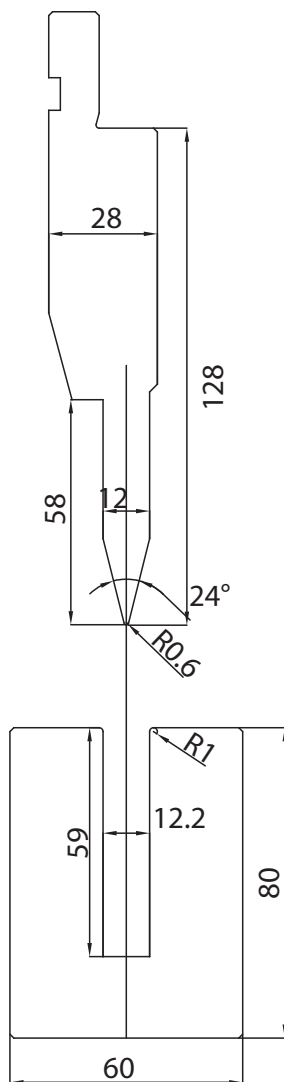


S	A	T/M	2xS	T/M
0.6	3	9	1.2	23
0.8	3	12	1.6	32
1	3.5	15	1	40
1.25	3.5	17	2.5	50
1.5	4.6	22	3	63
2	5.5	30	4	80
2.5	6.5	55	5	90
3	8	70	6	100

Acc.R.45 Kg/mm²

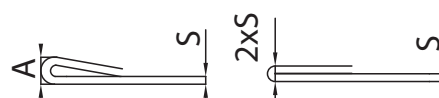
11.970

80t/m



31.780

50t/m

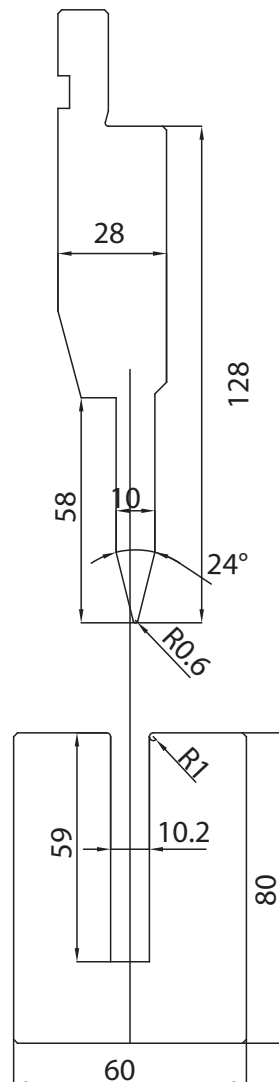


S	A	T/M	2xS	T/M
0.6	3	15	1.2	35
0.8	3	20	1.6	50
1	3.5	25	2	60
1.25	3.5	31	2.5	80
1.5	4.6	38	3	95
2	5.5	50	4	130

Acc.R.70 Kg/mm²

11.960

80t/m

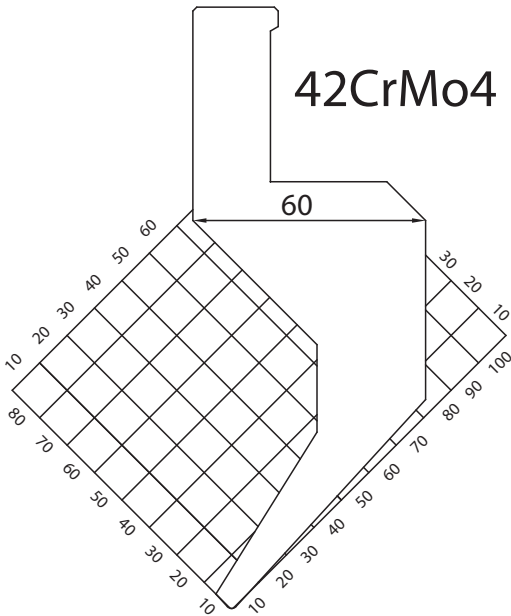


31.770

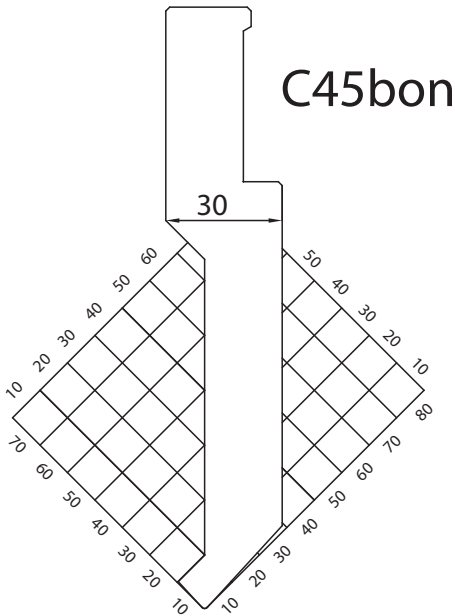
50t/m

punzoni/punches 80°/30°/28°

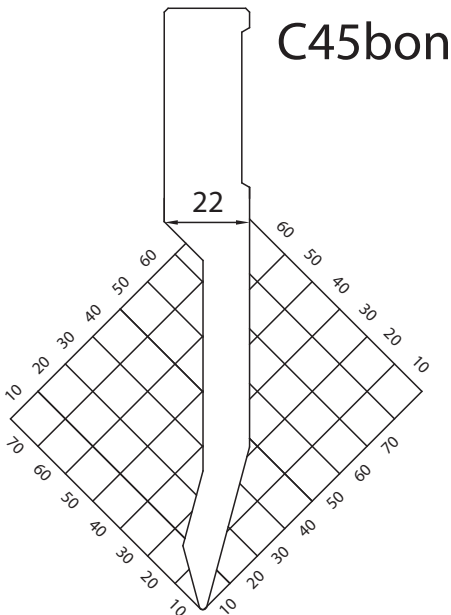
	A	R	H	T/M max
12.100	85°	1.5	155	50
12.110	85°	0,8	155	50



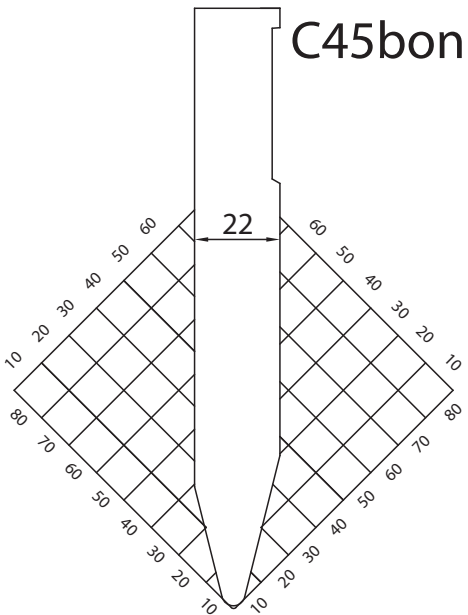
	A	R	H	T/M max
12.120	85°	1	155	100



	A	R	H	T/M max
12.130	30°	1	155	80
12.140	28°	1	155	80



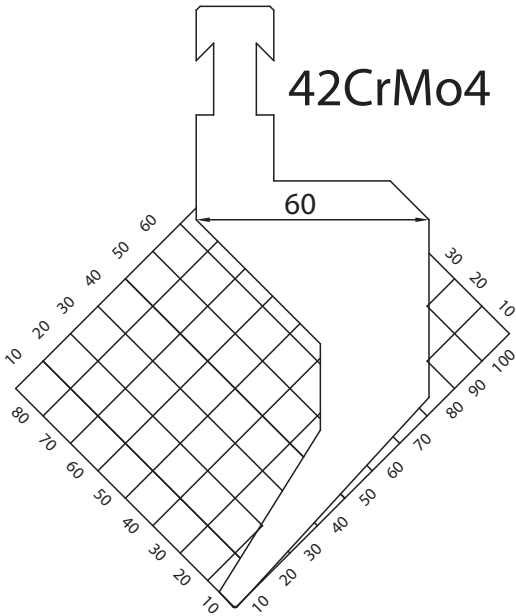
	A	R	H	T/M max
12.150	28°	3	155	100



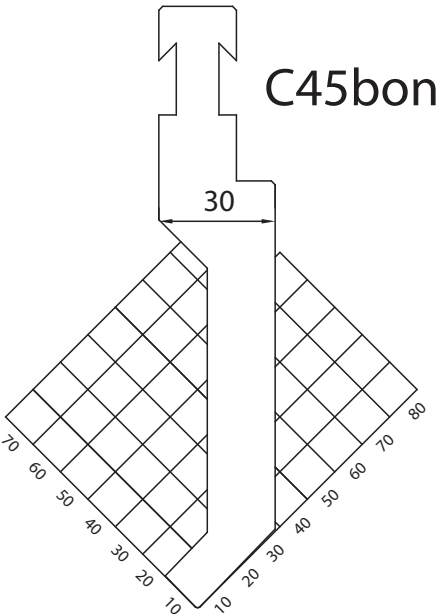
BEYELER

punzoni/punches 80°/30°/28°

	A	R	H	T/M max
12.160	85°	1.5	155	50

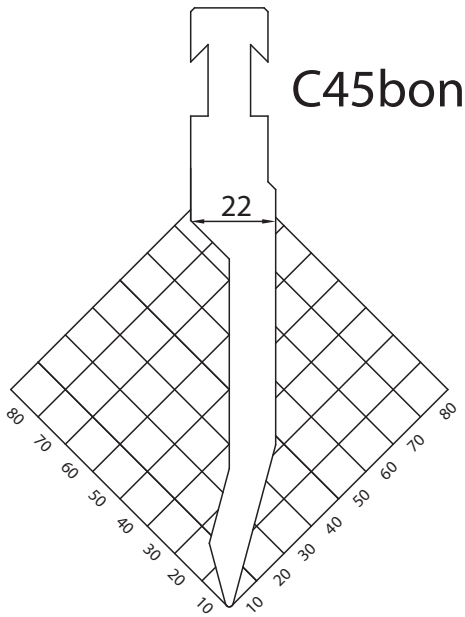


	A	R	H	T/M max
12.180	85°	1	155	100

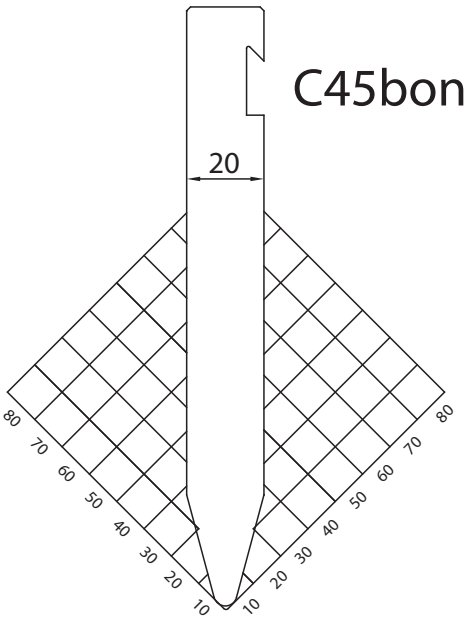


punzoni/punches 85°/86°/30°/28°

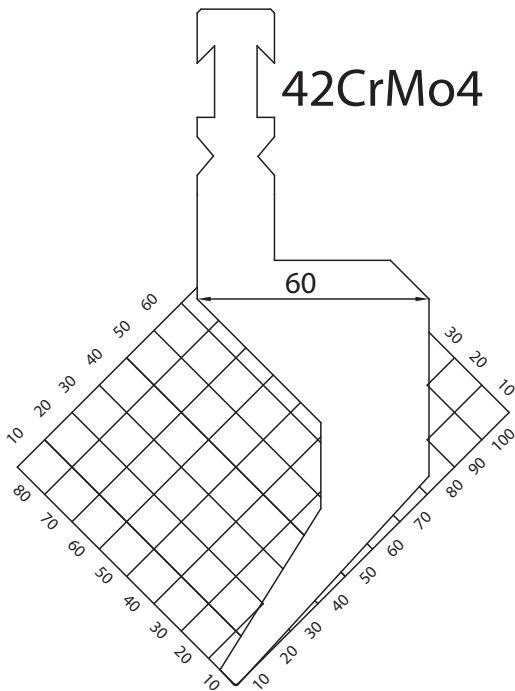
	A	R	H	T/M max
12.200	30°	1	155	80
12.210	28°	1	155	80



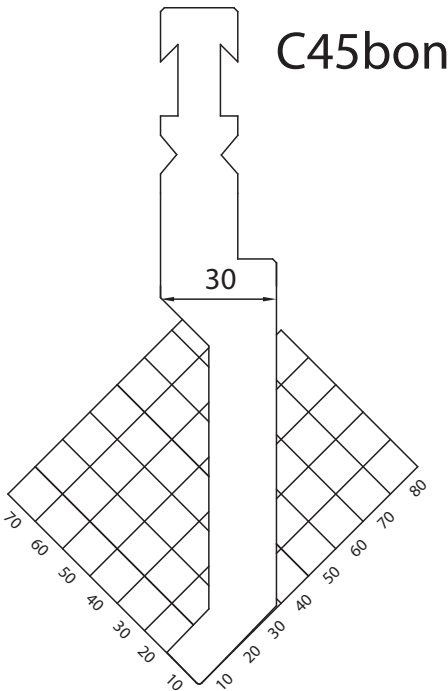
	A	R	H	T/M max
12.250	30°	3	155	100
12.260	30°	1	155	100



	A	R	H	T/M max
12.270	88°	1.5	175	50



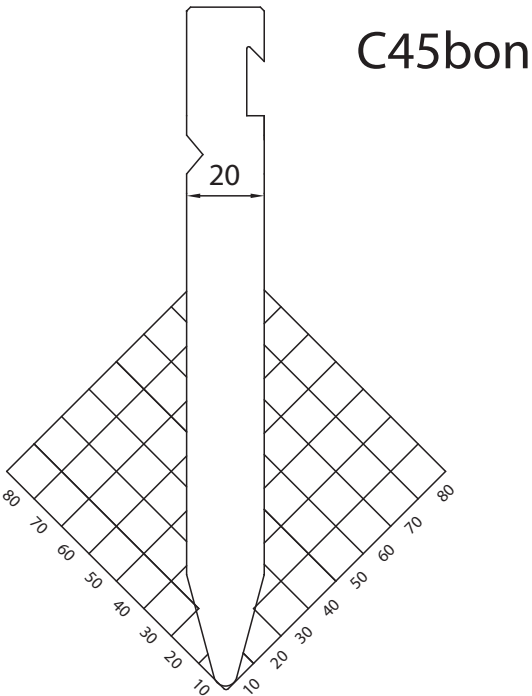
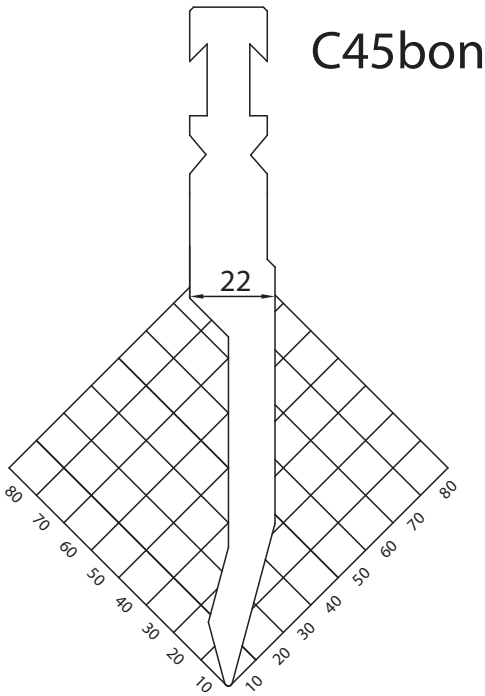
	A	R	H	T/M max
12.290	88°	1	175	100



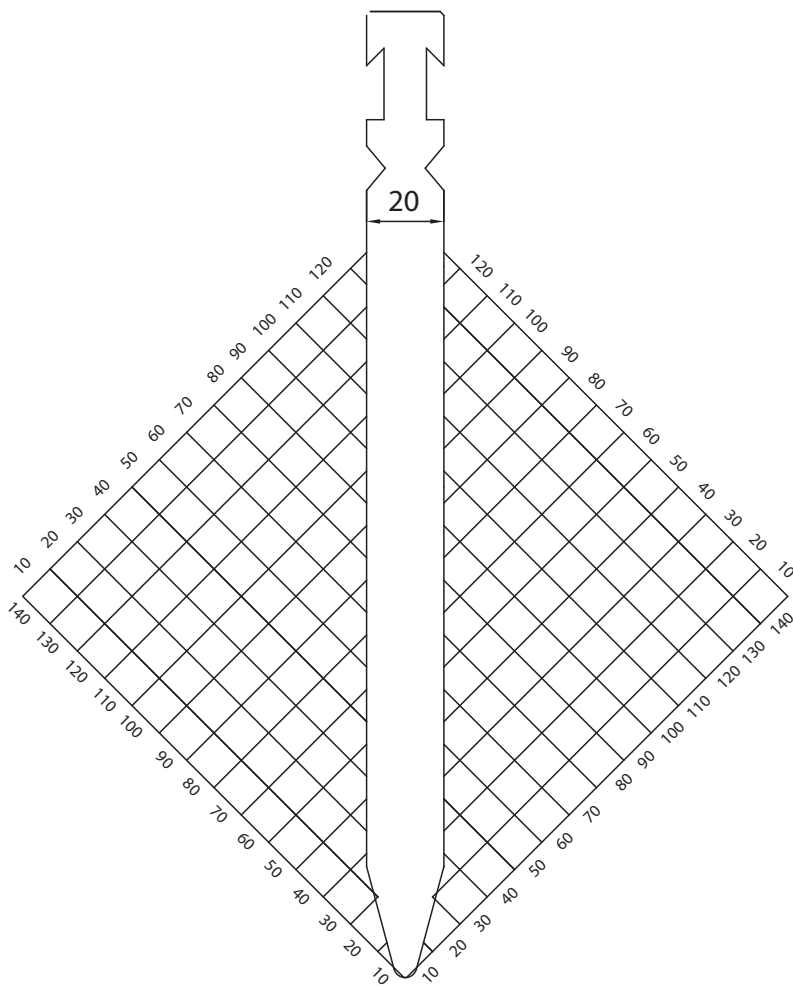
punzoni/punches 85°/86°/30°/28°

	A	R	H	T/M max
12.300	30°	1	175	80

	A	R	H	T/M max
12.310	30°	3	175	100
12.320	30°	1	175	100



punzoni/punches 86°/30°

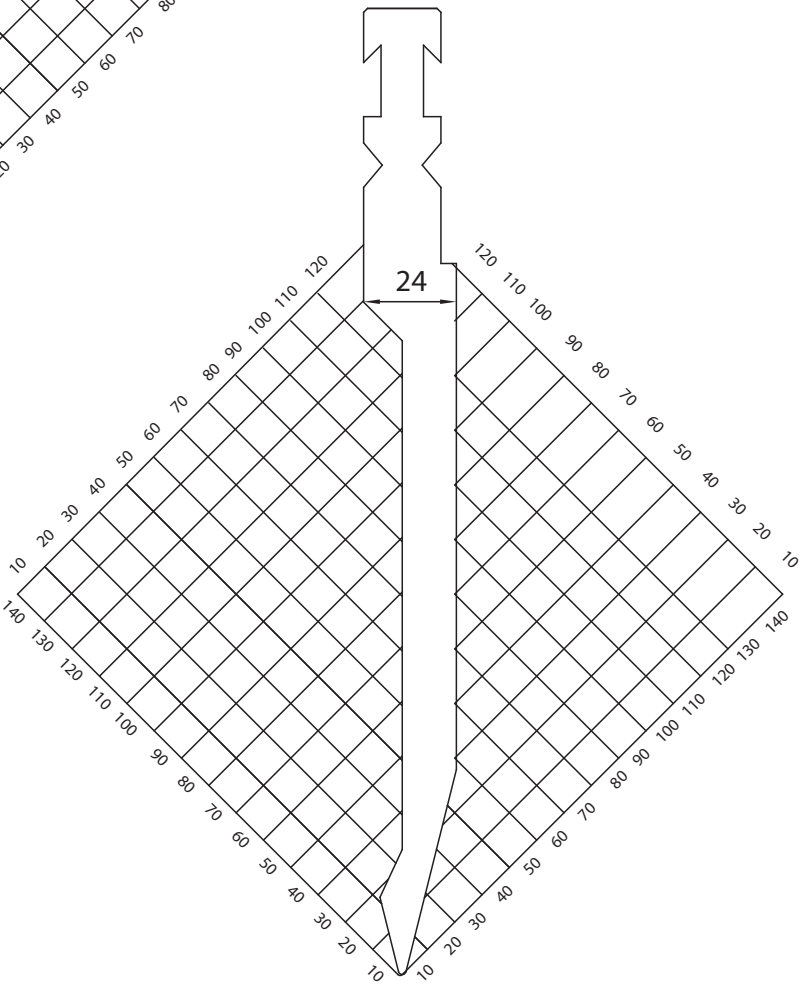


	A	R	H	T/M max
12.350	30°	3	250	120

C45bon

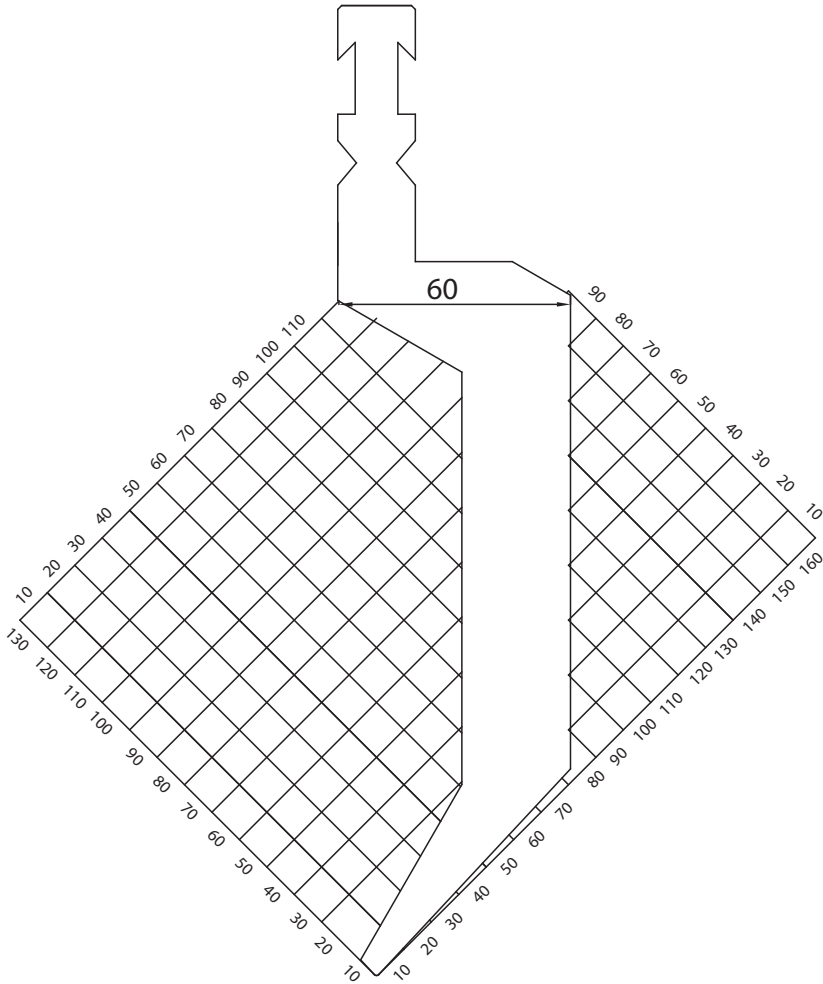
	A	R	H	T/M max
12.400	30°	1	250	50

C45bon



BEYELER RFA

punzoni/punches 86°/30°

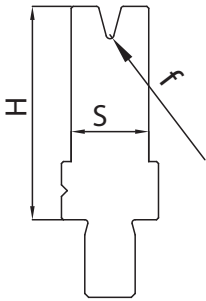


	A	R	H	T/M max
12.500	86°	1.5	250	60

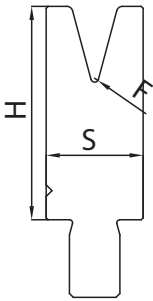
42CrMo4

matrici/dies 90°/88°/60°30°

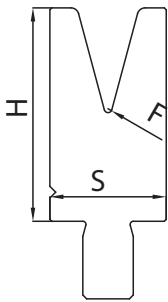
	A	V	R	H	S	F	T/M max
31.010	90°	6	0.4	55	15	0.5	100
31.020	90°	8	0.5	55	15	0.5	100
31.150	30°	6	0.6	55	15	1	35
31.160	30°	8	0.8	55	15	p2	35



	A	V	R	H	S	F	T/M max
31.030	90°	10	1	55	20	0.5	100
31.040	90°	12	1.5	55	20	0.5	100
31.060	88°	10	1	55	20	0.5	100
31.070	88°	12	1.5	55	20	0.5	100
31.170	30°	10	1	55	20	p2	50
31.180	30°	12	1.5	55	20	p2	40



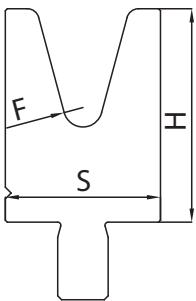
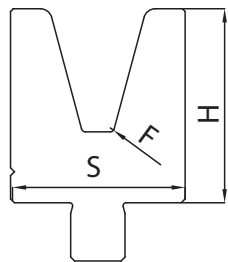
	A	V	R	H	S	F	T/M max
31.050	90°	16	2	55	30	0.5	100
31.080	88°	16	2	55	30	0.5	100
31.090	88°	20	2	55	30	0.5	100
31.190	30°	16	2	55	30	p5	45
31.200	30°	20	2.5	55	35	p5	50



matrici/dies 90°/88°/60°30°

	A	V	R	H	S	F	T/M max
31.790	60°	50	5	55	70	p15	100
31.140	60°	60	7	65	80	15	60
31.220	30°	32	4	60	60	10	50

	A	V	R	H	S	F	T/M max
31.100	88°	24	3	55	40	0.5	100
31.110	85°	32	4	55	50	3	100
31.120	85°	40	4	55	55	4	100
31.130	60°	40	5	55	55	5	80
31.210	30°	24	3	55	40	p8	50



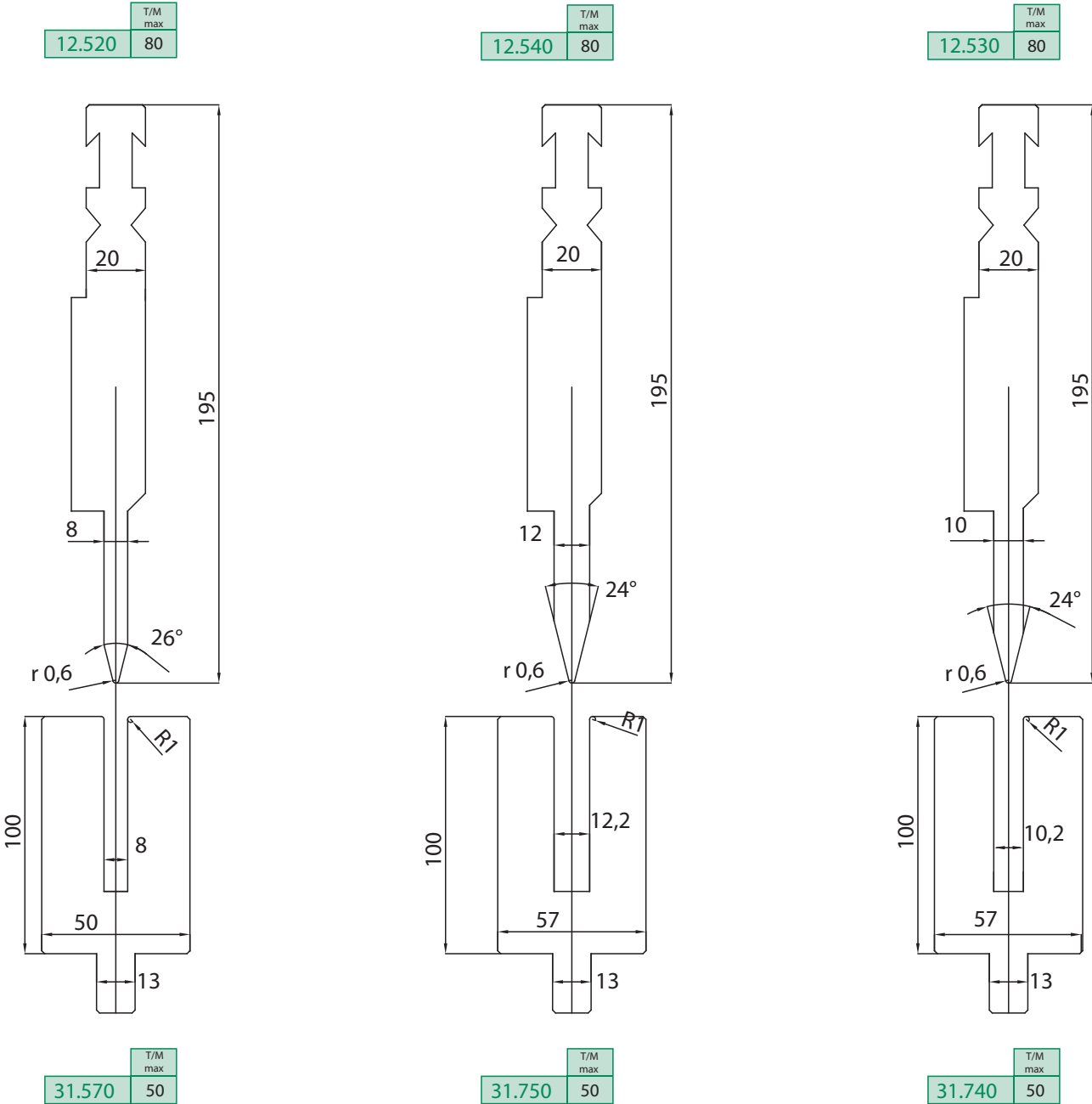
BEYELER

frazionatura standard/segmentation

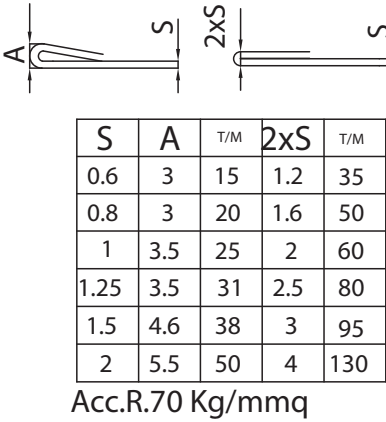
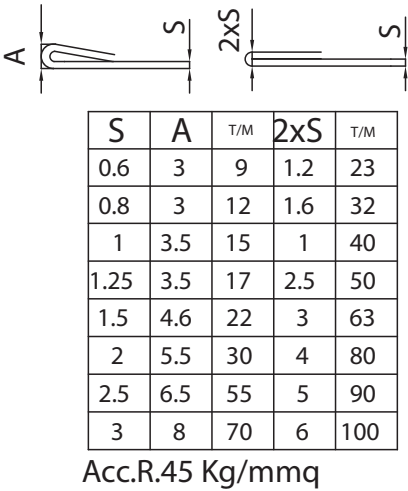
Gli utensili sono disponibili nelle lunghezze di 500mm e 1000mm, 1100mm per i frazionati

10	15	20	30	40	50	60	75	100	100	200	400

piegaschiaccia/hemming tools

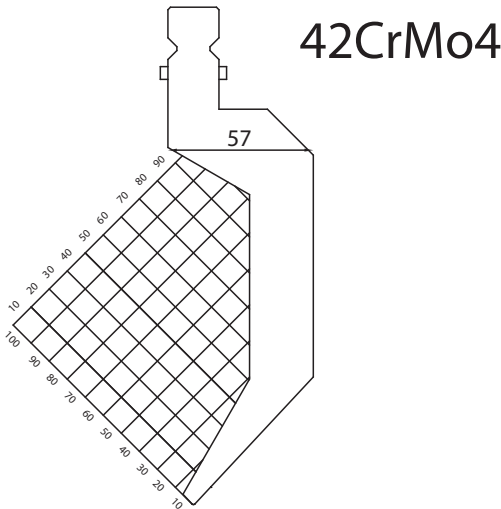


BEYELER RF-A

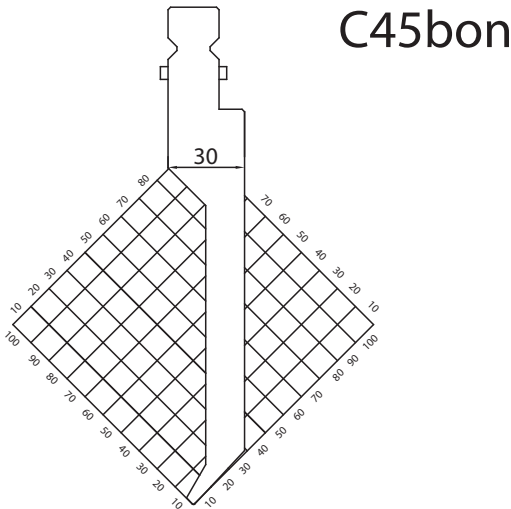


punzonipunches 86°/60°/28°

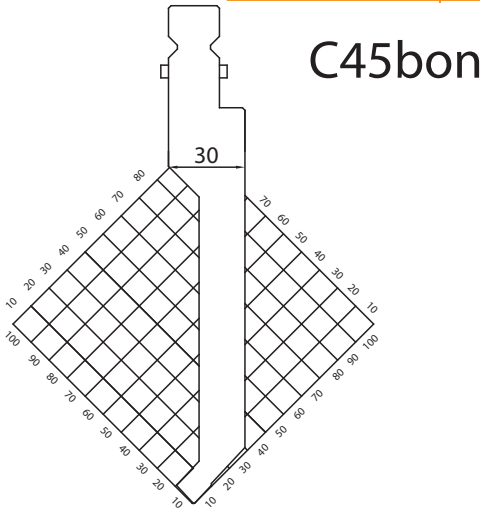
	A	R	H	T/M max
12.330	86°	0,8	195	40



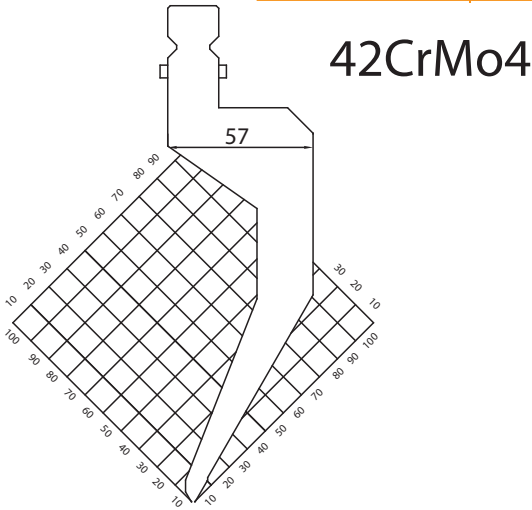
	A	R	H	T/M max
12.340	86°	0,8	195	30



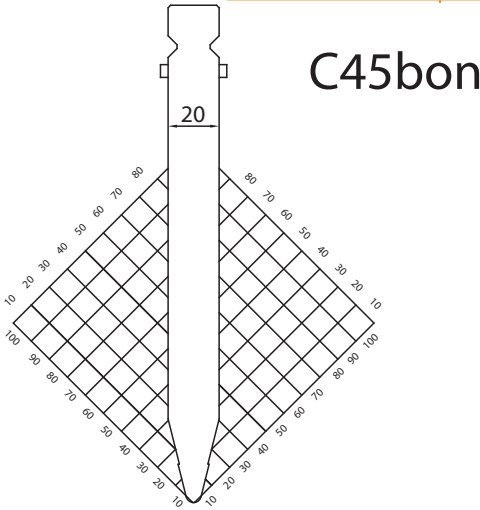
	A	R	H	T/M max
12.350	86°	0,8	195	100



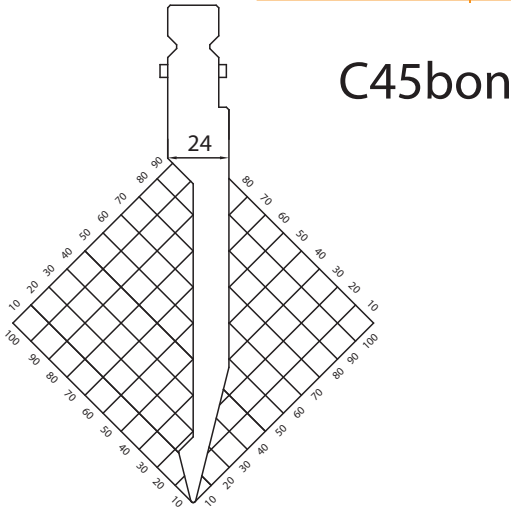
	A	R	H	T/M max
12.360	60°	0,8	195	40



	A	R	H	T/M max
12.370	28°	3	195	100



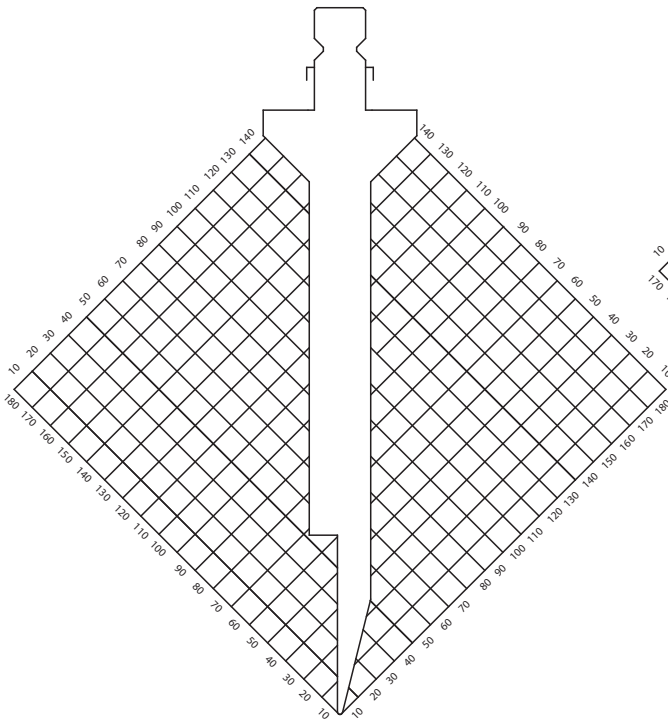
	A	R	H	T/M max
12.380	28°		195	80



punzoni/punches 86°/60°/28°

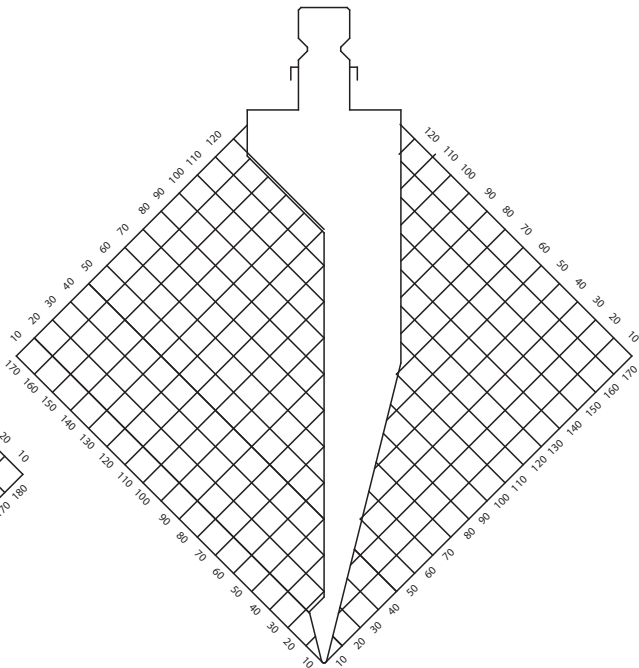
	A	R	H	T/M max
12.950	28°	1	240	40

42CrMo4



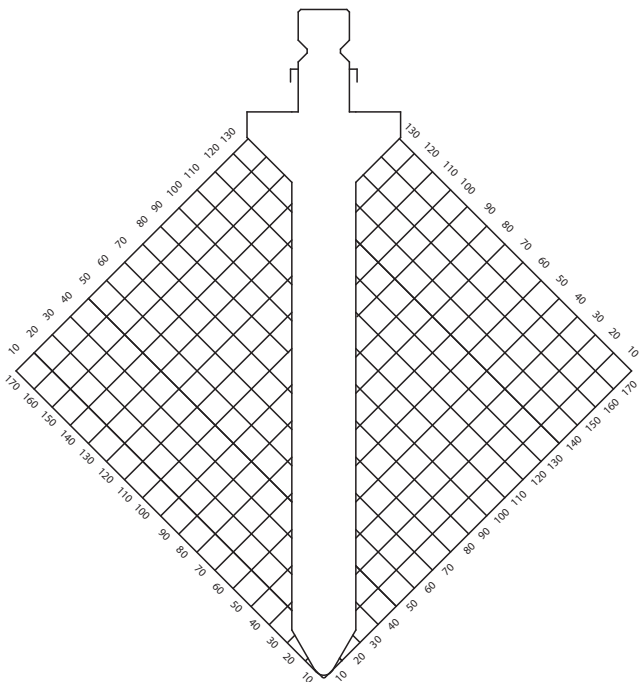
	A	R	H	T/M max
13.020	28°	1	220	80

42CrMo4



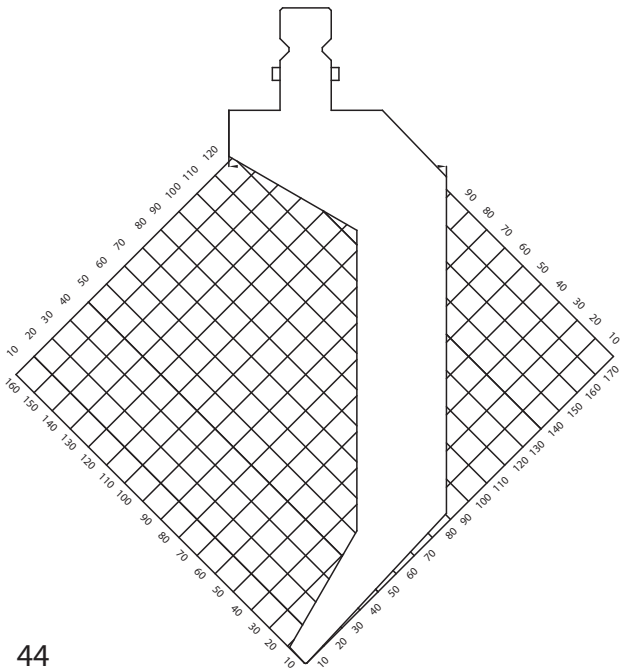
	A	R	H	T/M max
13.030	60°	4	220	100

42CrMo4



	A	R	H	T/M max
12.940	86°	1	220	60

42CrMo4



frazionamento punzoni

550mm:2x25-30-35-40-45-50-100-100scsx-100scdx

1250mm:2x25-30-35-40-45-50-100-2x200-300-100scsx-100scdx

2050mm:2x25-30-35-40-45-50-100-2x200-3x300-100scsx-100scdx

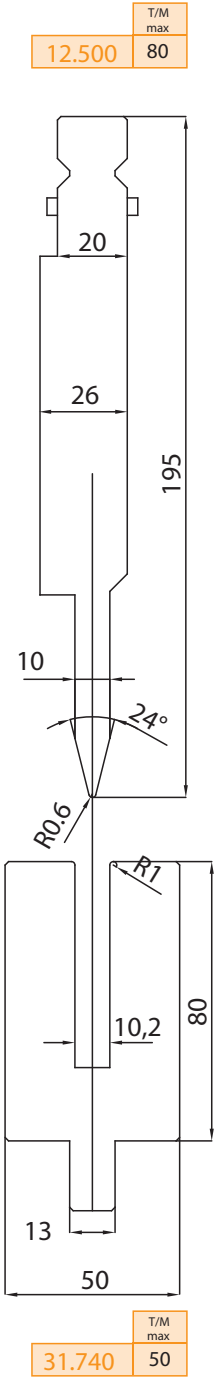
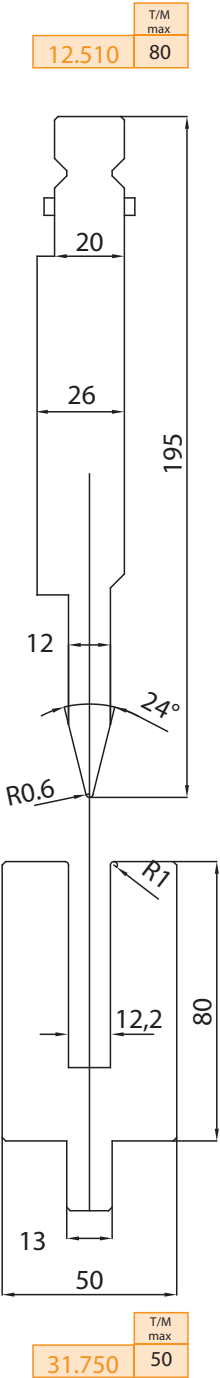
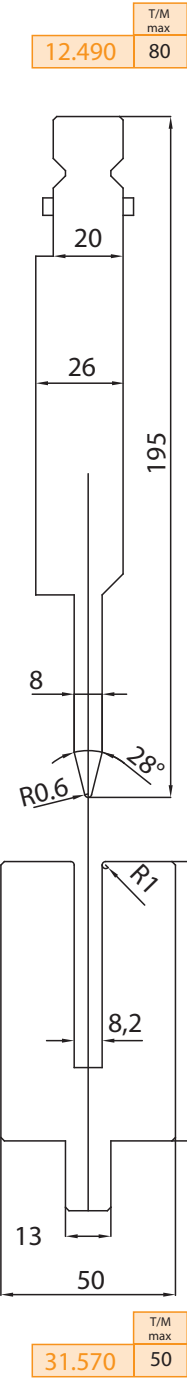
2550mm:2x25-30-35-40-45-50-100-3x200-4x300-100scsx-100scdx

3050mm:2x25-30-35-40-45-50-100-4x200-5x300-100scsx-100scdx

4050mm:2x25-30-35-40-45-50-100-6x200-7x300-100scsx-100scdx

piegaschiaccia/hemming tools

WILA-TRUMPF



Technical drawing of hemming tool 31.570. Dimensions: A, S, 2xS, 80, 13, 50. Material: 31.570, T/M max 50.

S	A	T/M	2xS	T/M
0.6	3	9	1.2	23
0.8	3	12	1.6	32
1	3.5	15	1	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

Acc.R.45 Kg/mm²

Technical drawing of hemming tool 31.750. Dimensions: A, S, 2xS, 80, 13, 50. Material: 31.750, T/M max 50.

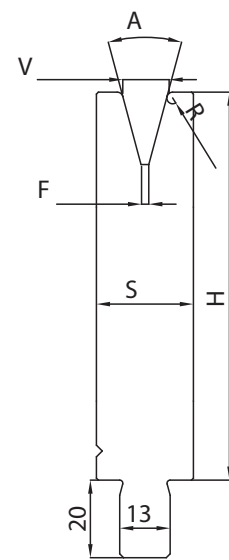
S	A	T/M	2xS	T/M
0.6	3	15	1.2	35
0.8	3	20	1.6	50
1	3.5	25	2	60
1.25	3.5	31	2.5	80
1.5	4.6	38	3	95
2	5.5	50	4	130

Acc.R.70 Kg/mm²

matrici/dies 86°/80°/30°

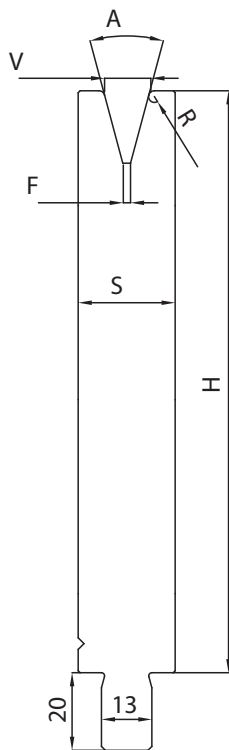
A
86°

H100	V	R	S	F	T/M max	H150
31.230	6	0.6	20	r0.5	100	31.430
31.240	8	0.8	20	r0.5	100	31.440
31.250	10	1	20	r0.5	100	31.450
31.260	12	1	25	r0.5	100	31.460
31.270	16	1.6	30	r0.5	100	31.470
31.280	20	2	30	r0.5	100	31.480
31.290	24	2.5	35	r0.5	100	31.490
31.300	30	3	45	r3	100	
31.310	40	3	55	3	100	
31.320	50	3	75	3	100	



A
80°

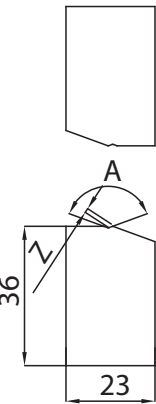
H100	V	R	S	F	T/M max	H120
31.330	60	5	75	r5	100	
31.340	80	5	100	r8	100	
	100	8	120	r10	100	31.350



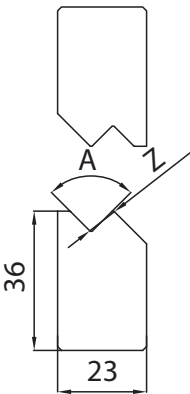
A
30°

H100	V	R	S	F	T/M max	H150
31.360	6	0.6	20	r1	50	31.500
31.370	8	1	20	p2	40	31.510
31.380	10	1	20	p2	40	31.520
31.390	12	1	25	p2	40	31.530
31.400	16	1.6	30	p5	45	31.540
31.410	20	2	35	p5	50	31.550
31.420	24	2.5	40	p5	50	31.560

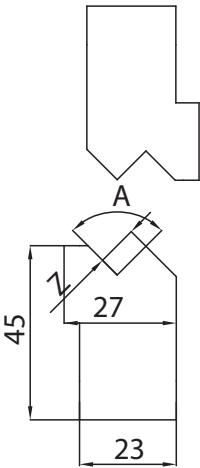
inserti a Z/joogle tools L=835/415



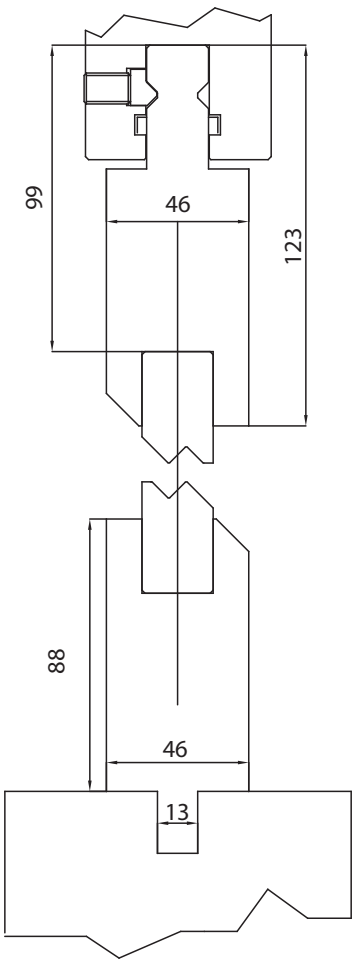
	Z	A
11.300	1	160°
11.310	1.5	160°
11.320	2	150°
11.330	2.5	140°



	Z	A
12.760	1	90°
12.770	1.5	90°
12.740	2	90°
12.750	2.5	90°
11.340	3	90°
11.350	3.5	90°
11.360	4	90°
11.370	4.5	90°
11.380	5	90°
11.390	5.5	90°
11.400	6	90°
11.410	6.5	90°
11.420	7	90°
11.430	7.5	90°
11.440	8	90°

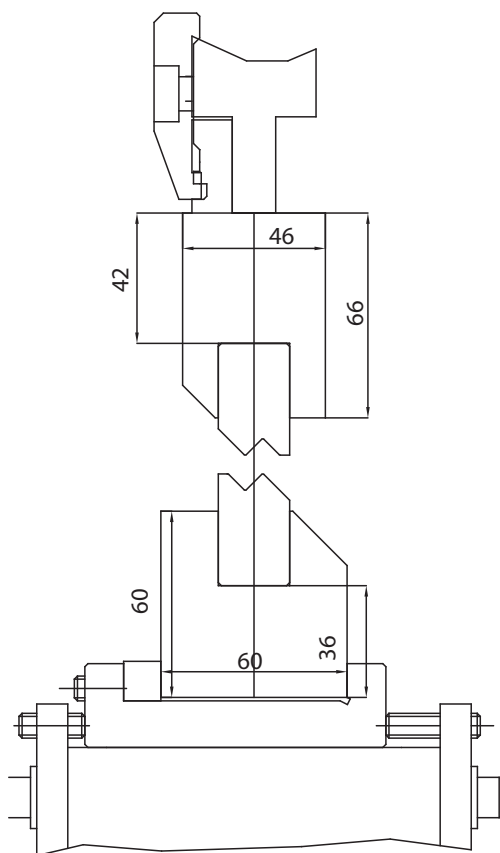
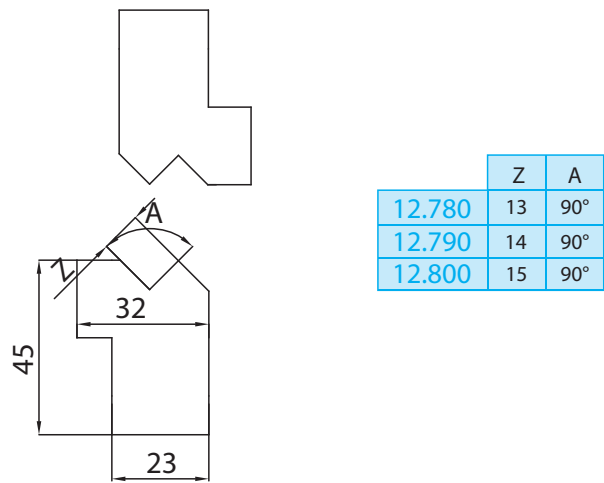


	Z	A
11.450	9	90°
11.460	10	90°
11.470	11	90°
11.480	12	90°



12.420
porta inserti TRUMPF

inserti a Z/joogole tools L=835/415

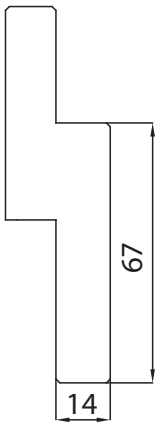


11.500
porta inserti AMADA-PROMECAM

supporti per elementi raggiati/holder for radius inserts L=410/830

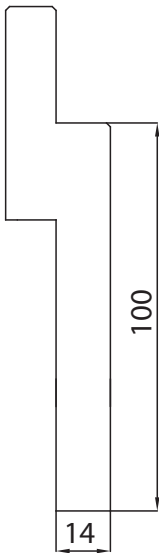
10.360

AMADA-PROMECA



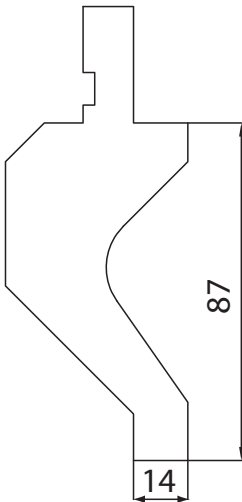
10.960

AMADA-PROMECA



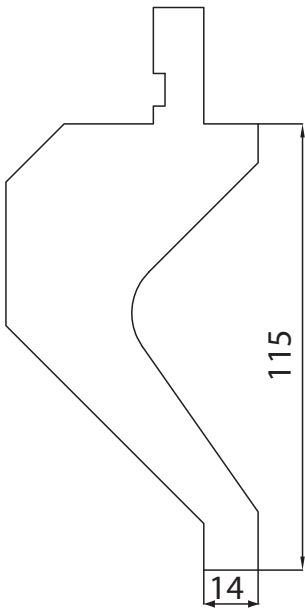
10.910

AMADA-PROMECA



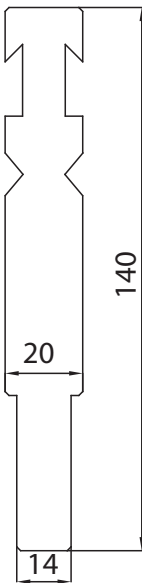
10.900

AMADA-PROMECA



12.730

BEYELER - RFA



12.390

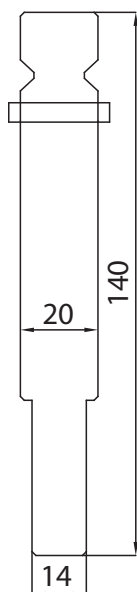
BEYELER R



supporti per elementi raggiati/holder for radius inserts L=410/830

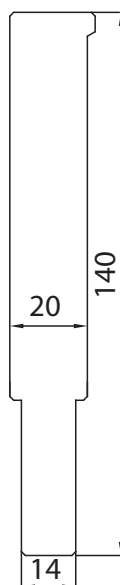
12.400

WILA - TRUMPF

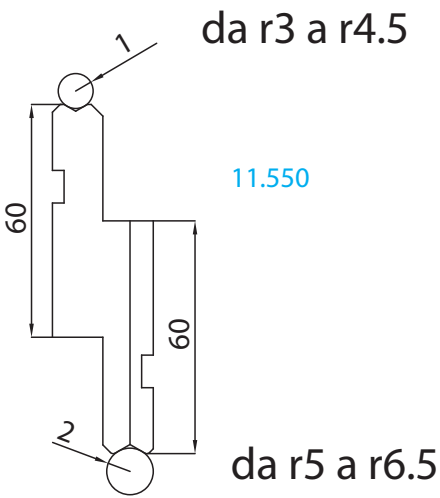


12.410

BEYELER S

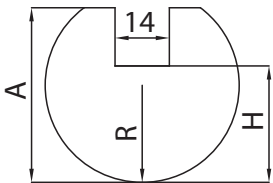


elementi raggiati/radius tools L=415/835
supporti per tondi

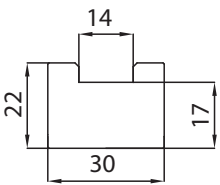


	R
11.800	3
11.810	3.5
11.820	4
11.830	4.5
11.840	5
11.850	5.5
11.860	6
11.870	6.5

da r7 a r50



	A	R	H
11.000		7	11.5
11.010		7.5	11.5
11.020		8	13
11.030		9	16
10.370		10	16
11.040		11	16
11.050		11.5	16
11.060		12	16
11.070	21	12.5	16
11.080	23	13	17
11.090	25	14	19
10.380	27	15	20
11.100	28	16	21
11.110	31.5	17	21.5
10.390	32	17.5	22
11.120	32	19	25
10.400	34	20	25
11.130	34	22.5	25
10.410	39	25	29
11.140	44	27.5	34
10.420	44	30	34
11.150	55	35	45
11.160	55	40	45
11.170	60	45	50
11.180	64	50	54

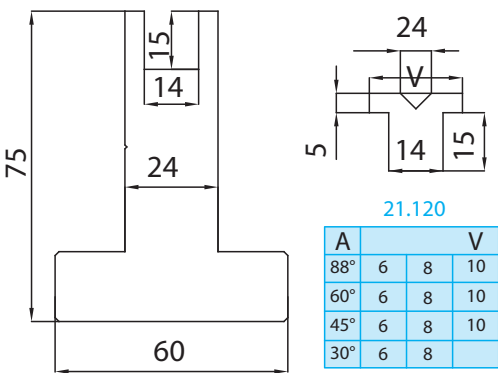


10.430

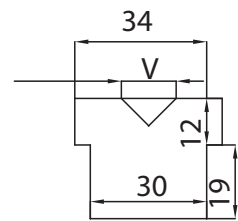
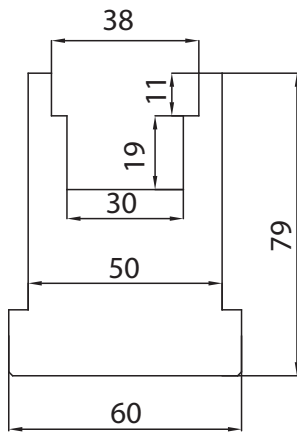
elemento per
schiacciare

contenitori in nylon/Nylon holders

21.090
porta inserto
AMADA PROMECAM

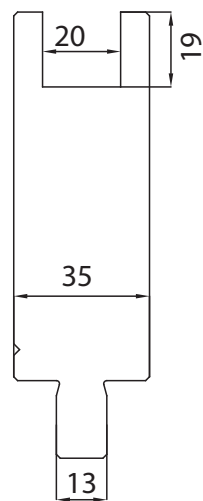


21.110
porta inserto
AMADA PROMECAM

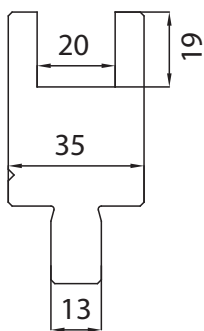


21.140							
A	V						
88°	6	8	10	12	16	20	25
60°	6	8	10	12	16	20	
45°	6	8	10	12	16	20	
30°	6	8	10	12	16	20	

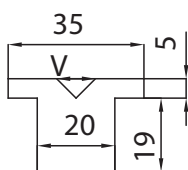
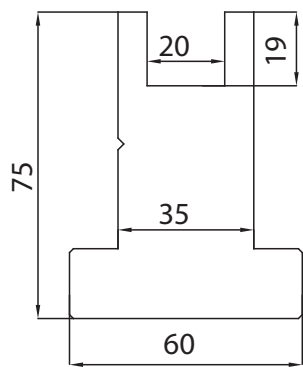
21.160
porta inserto
BEYELER



21.150
porta inserto
BEYELER

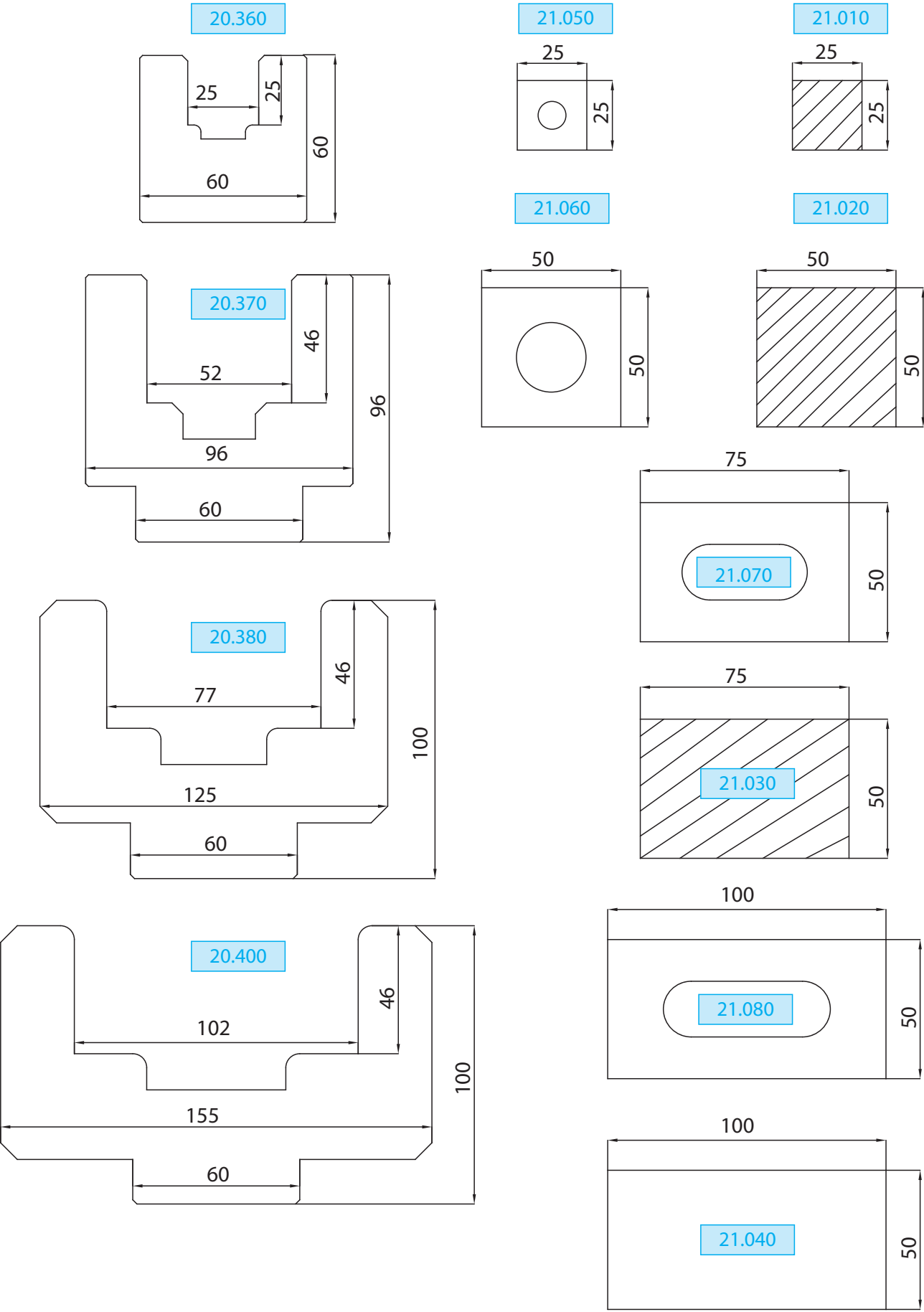


21.100
porta inserto
AMADA PROMECAM



21.130						
A	V					
88°	6	8	10	12	16	
60°	6	8	10	12	16	
45°	6	8	10	12		
30°	6	8	10			

contenitori e inserti di poliuretano/polyurethan inserts and holders L=415/835



armadi/tooling cabinets

**54004**

massa a vuoto/net mass 300 kg.
metri di utensili/meter of tools 48
mis. P 1050 x L 850 x H 1240 mm.

54004/1

massa a vuoto/net mass 340 kg.
metri di utensili/meter of tools 48
mis. P 1250 x L 850 x H 1240 mm.

54005

massa a vuoto/net mass 350 kg.
metri di utensili/meter of tools 60
mis. P 1050 x L 1040 x H 1240 mm.

54005/1

massa a vuoto/net mass 400 kg.
metri di utensili/meter of tools 60
mis. P 1250 x L 1040 x H 1240 mm.

54004



54004/1



54005



54005/1



stampi speciali/special tools



LP



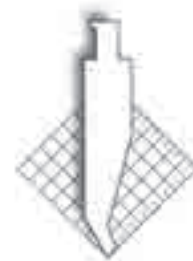
LSP 60°-45°



LSP 26°-30°



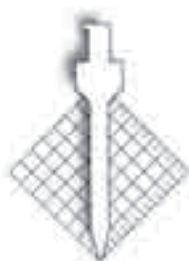
LSC 60°



LSN 60°



LXP 30°



LSS 30°



LS 60°



LSS 15°



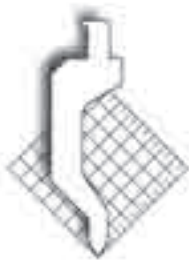
LMC 85°



LMC 60°



LMCI 60°



LBC 60°



LCC 85°



LCC 60°



LCI 60°



LCCB 60°



SSP1



SSP2



SSP3

stampi speciali/special tools



SSP4



SSP5



SSP6



SSP7



SSP8



SSP9



SSP10

	S mm	kN/mt
0,6	R450 N/mm ²	120
	R700 N/mm ²	190
0,8	R450 N/mm ²	170
	R700 N/mm ²	260
1,0	R450 N/mm ²	210
	R700 N/mm ²	320
1,2	R450 N/mm ²	250
	R700 N/mm ²	390
1,5	R450 N/mm ²	310
	R700 N/mm ²	480
2,0	R450 N/mm ²	410
	R700 N/mm ²	640
2,5	R450 N/mm ²	520
	R700 N/mm ²	810
3,0	R450 N/mm ²	620
	R700 N/mm ²	970



SSP11

	S mm	kN/mt
0,6	R450 N/mm ²	250
	R700 N/mm ²	390
0,8	R450 N/mm ²	330
	R700 N/mm ²	520
1,0	R450 N/mm ²	410
	R700 N/mm ²	640
1,2	R450 N/mm ²	500
	R700 N/mm ²	770
1,5	R450 N/mm ²	620
	R700 N/mm ²	970
2,0	R450 N/mm ²	830
	R700 N/mm ²	1290
2,5	R450 N/mm ²	1040
	R700 N/mm ²	1610
3,0	R450 N/mm ²	1240
	R700 N/mm ²	1930



SSP12

	S mm	kN/mt
0,6	R450 N/mm ²	120
	R700 N/mm ²	190
0,8	R450 N/mm ²	170
	R700 N/mm ²	260
1,0	R450 N/mm ²	210
	R700 N/mm ²	320
1,2	R450 N/mm ²	250
	R700 N/mm ²	390
1,5	R450 N/mm ²	310
	R700 N/mm ²	480
2,0	R450 N/mm ²	410
	R700 N/mm ²	640
2,5	R450 N/mm ²	520
	R700 N/mm ²	810
3,0	R450 N/mm ²	620
	R700 N/mm ²	970



SSP13

	S mm	kN/mt
0,6	R450 N/mm ²	150
	R700 N/mm ²	240
0,8	R450 N/mm ²	210
	R700 N/mm ²	320
1,0	R450 N/mm ²	260
	R700 N/mm ²	400
1,2	R450 N/mm ²	310
	R700 N/mm ²	480
1,5	R450 N/mm ²	380
	R700 N/mm ²	600
2,0	R450 N/mm ²	510
	R700 N/mm ²	800
2,5	R450 N/mm ²	640
	R700 N/mm ²	1000
3,0	R450 N/mm ²	770
	R700 N/mm ²	1200

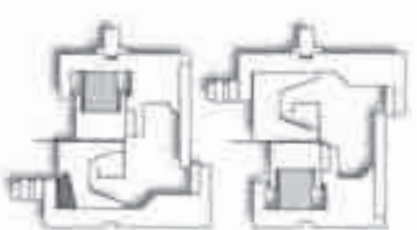


SSP14



SSP15

	S mm	kN/mt
0,6	R450 N/mm ²	210
	R700 N/mm ²	320
0,8	R450 N/mm ²	270
	R700 N/mm ²	430
1,0	R450 N/mm ²	340
	R700 N/mm ²	530
1,2	R450 N/mm ²	410
	R700 N/mm ²	640
1,5	R450 N/mm ²	510
	R700 N/mm ²	800
2,0	R450 N/mm ²	680
	R700 N/mm ²	1060
2,5	R450 N/mm ²	860
	R700 N/mm ²	1330
3,0	R450 N/mm ²	1030
	R700 N/mm ²	1600



SSP16/S

SSP17/E



SSP23

stampi speciali/special tools



SSP24



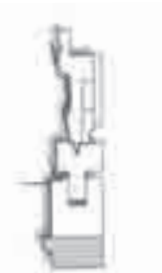
SSP25



SSP26



SSP27



SSP28



SSP30



SSP31



SSP32



SSP35



SSP40



SSP45



SSP50



SSP51



SPS



SPSP



SPSS



MTPS



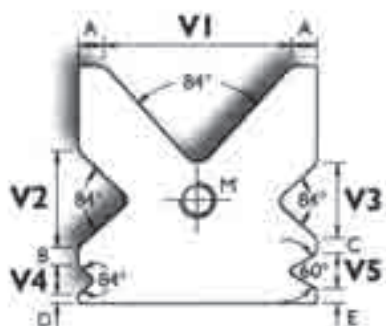
MTPS2



spessore thickness	X	resistenza-resistance	
		450 N/mm ²	700 N/mm ²
0,6	mm 1,2	230 kN/mt	350 kN/mt
0,8	mm 1,6	320 kN/mt	500 kN/mt
1	mm 2,0	400 kN/mt	600 kN/mt
1,2	mm 2,4	500 kN/mt	800 kN/mt
1,5	mm 3,0	630 kN/mt	950 kN/mt
2	mm 4,0	800 kN/mt	1300 kN/mt
2,5	mm 5,0	900 kN/mt	1800 kN/mt
3	mm 6,0	1000 kN/mt	2100 kN/mt

spessore thickness	X	resistenza-resistance	
		450 N/mm ²	700 N/mm ²
0,6	mm 3,0	90 kN/mt	150 kN/mt
0,8	mm 3,0	120 kN/mt	200 kN/mt
1	mm 3,5	150 kN/mt	250 kN/mt
1,2	mm 3,5	170 kN/mt	260 kN/mt
1,5	mm 4,6	220 kN/mt	380 kN/mt
2	mm 3,0	120 kN/mt	200 kN/mt
2,5	mm 6,5	550 kN/mt	900 kN/mt
3	mm 8,0	700 kN/mt	1000 kN/mt

matrici/dies



tipo type	dimensioni dimensions	84°			60°							
		V1	V2	V3	V4	V5	A	B	C	D	E	M
M60	60X60	40	25	20	10	12	10	6	5	3	5	
M70	70X70	50	32	25	10	12	10	6	5	3	5	M12
M80	80X80	63	32	25	10	12	8,5	6	5	3	5	M12
M90	90X90	70	40	25	10	12	10	6	5	3	5	M16
M100	100X100	80	40	32	10	12	10	6	5	3	5	M16
M110	110X110	90	50	32	10	12	10	9	5	3	5	M16
M120	120X120	90	50	40	12	16	15	10	10	5	5	M16
M130	130X130	110	50	40	12	16	10	10	10	5	5	M16
M140	140X140	110	50	40	16	20	15	10	10	5	5	M20



MT1



MT2



MT3



MT4



MT5



MT6



MT7



MT8



MT9



MT10



MT11

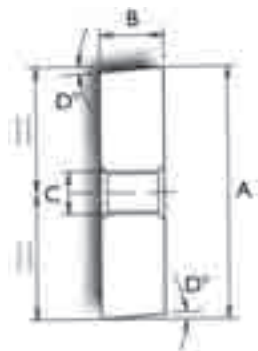


MT12

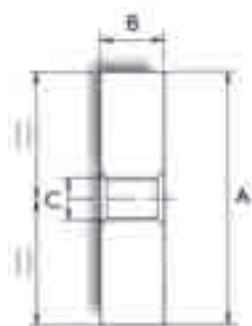
frazionatura/segmentation



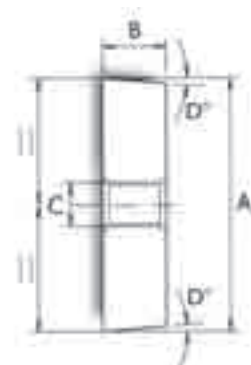
lame per cesoie/shear blades



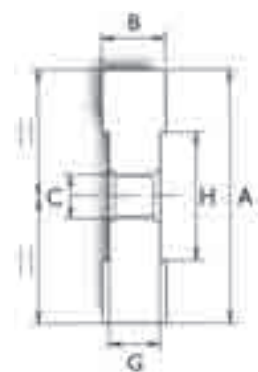
lame a 2 fili



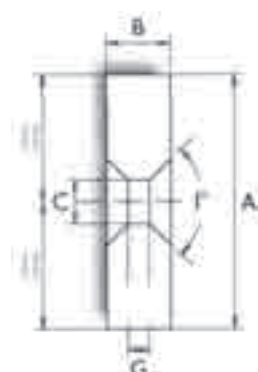
lame a 4 fili



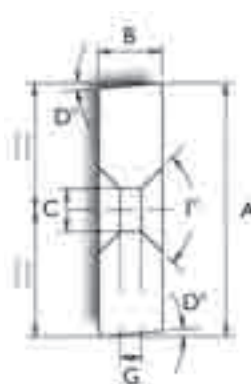
lame a 2 fili
complanari



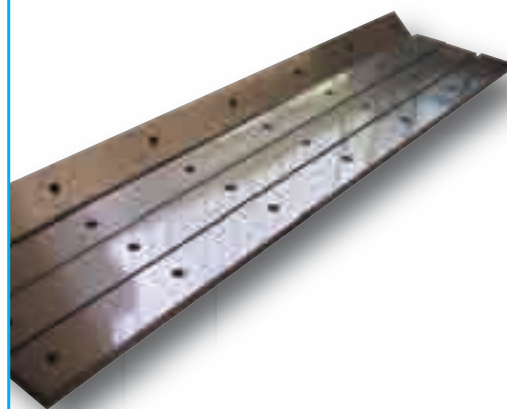
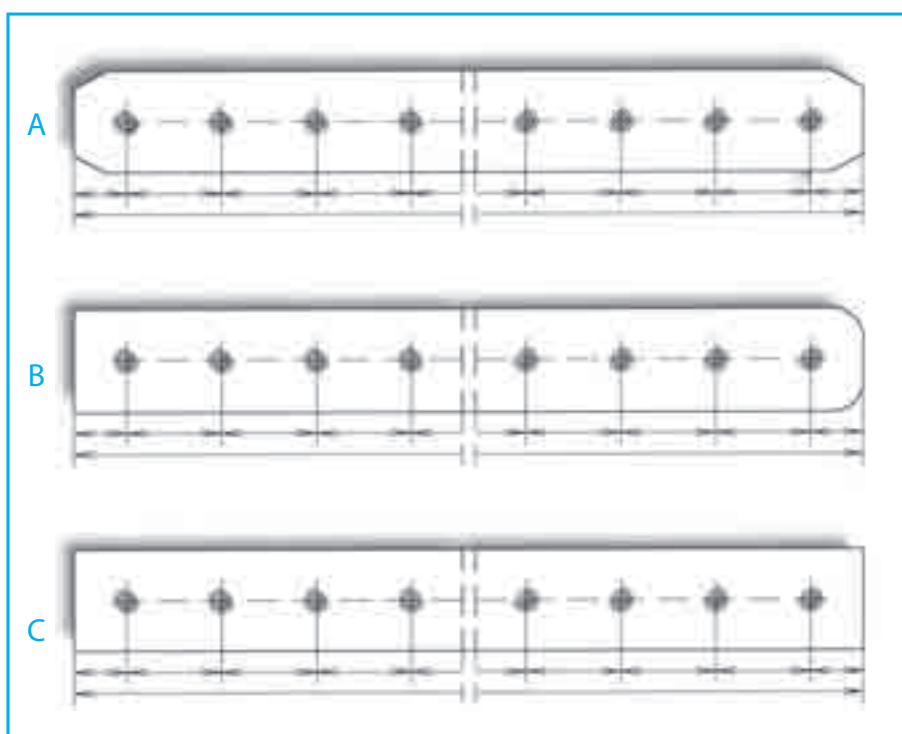
lame a 4 fili



lame a 4 fili
fori svasati



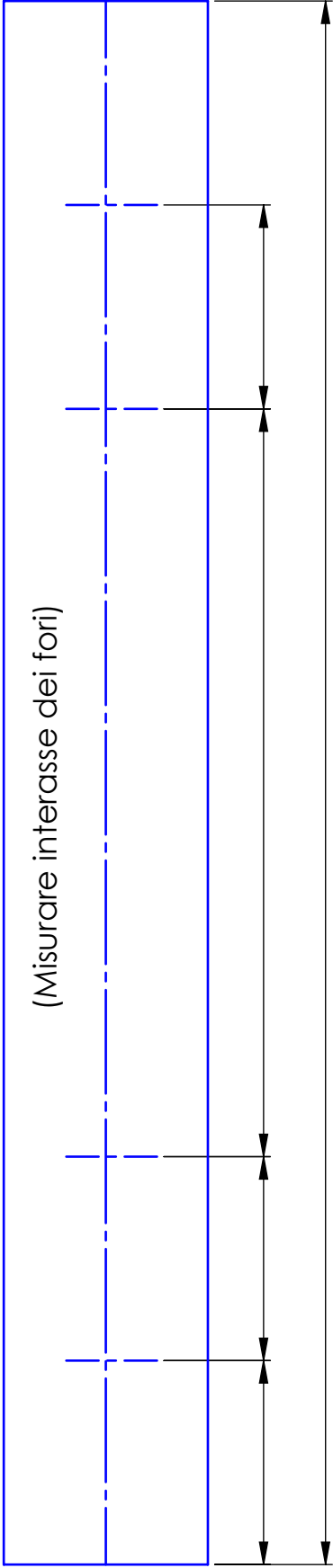
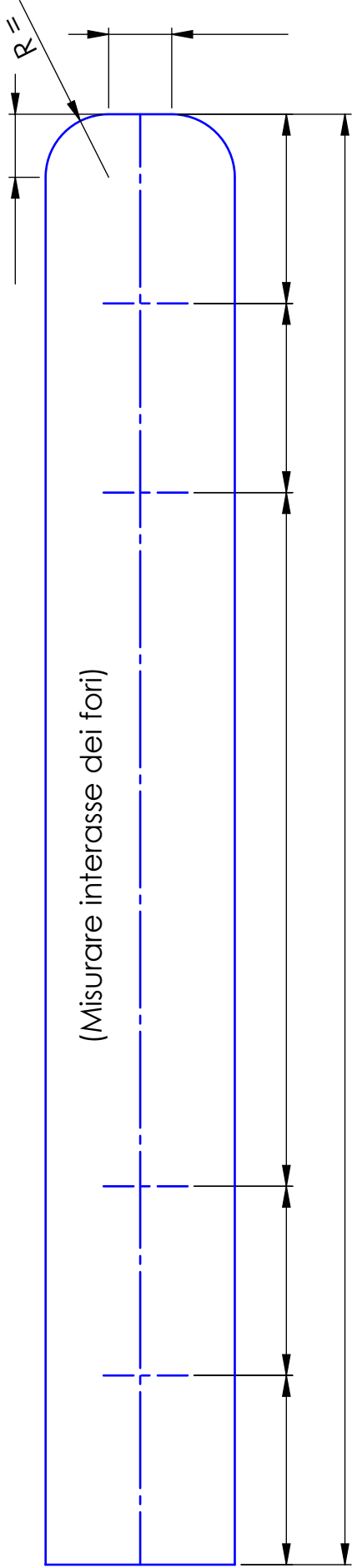
lame a 2 fili
fori svasati



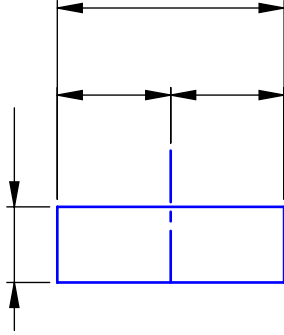
dimensioni

MODULO DI IDENTIFICAZIONE LAME PER CESOIA

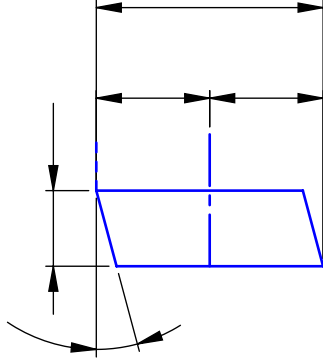
RICHIEDENTE:



Lama a 4 fili



Lama a 2 fili



CESOIA:

MODELLO:

FORI:

LAMIERA SP:

DISEGNO: