



Toolspress

high quality tooling systems

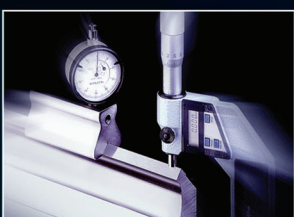
tools  **press**

EUROPEAN STYLE

Press Brake Tooling & Accessories

Version - 1.2

www.toolspress.com



toolspress

Spirito d'Innovazione

Toolspress è leader mondiale nella progettazione e produzione di utensili e sistemi di bloccaggio di alta qualità, per presse piegatrici. Realizziamo prodotti all'avanguardia ed innovativi, sfruttando 30 anni di esperienza ed un ampio programma di produzione, con più di mille modelli standard, che ci permettono di valutare e risolvere le problematiche proposte, ottimizzando i vostri sistemi di piegatura.

Toolspress è composta da Quattro importanti divisioni:

- Utensili Standard di Alta Precisione per Presse Piegatrici
- Utensili Speciali di Alta Precisione per Presse Piegatrici
- Sistemi di Bloccaggio per Presse Piegatrici
- Soluzioni Industriali per Presse Piegatrici
- Lame da cesoia

Queste quattro divisioni sono indipendenti e utilizzano le tecnologie più avanzate disponibili nel mercato mondiale, in questo modo possiamo garantire prodotti di alta qualità senza paragoni. La qualità Toolspress è ben conosciuta nel mercato mondiale da molti anni. I nostri clienti sono per noi partners tecnologici, grazie ad una stretta collaborazione, risolviamo e incrementiamo le loro performance di piegatura. Il mercato globale richiede sempre più tecnologia a prezzi molto competitivi e nel minor tempo possibile, per questi motivi la nostra società ricerca e sviluppa metodi di produzione che ci permettono di soddisfare le richieste dei nostri clienti.

The Spirit of Innovation

Toolspress is a world-class designer and manufacturer of high-quality press brake tooling and clamping system.

We provide the most innovative products in the fabricators industries.

Through a great manufacturing program with more than thousand standard model, we are able to guide your choice of the best bending system in the fastest time, due to the long experience we got in 30th years.

Toolspress has four important divisions:

- Precision Ground Standard Press Brakes Tooling
- Precision Ground Special Press Brakes Tooling
- Press Brakes Clamping System
- Industrial Solutions for Press Brakes
- Shear blades

These four divisions are independent and both use the ultimate technologies in manufacturing process available in the world market, in this way we can guarantee high precision quality products with no comparison.

Toolspress quality is very well known in the world market since many years.

Ours customers are for us technological partners, in fact through a tight cooperation they let us solve and improve their bending performance.

The global market needs always more and more technology to a very competitive prices in the shortest time. In this way our company develops manufacturing methods that allow us to meet our costumers requirements.

The Spirit of Innovation

Toolspress® ist der weltweit führende Entwickler und Hersteller von qualitativ hochwertigen Abkantwerkzeugen und Werkzeug-Spannsysteme. Wir entwickeln und vertreiben die innovativsten Produkte im Bereich der Abkanttechnik. Durch unser großes Herstellungsprogramm mit über tausend Standardwerkzeugen sind wir in der Lage, das von Ihnen gewünschten Werkzeugsystem innerhalb kürzester Zeit zu liefern. Toolspress® verfügt über eine 30-jährige Erfahrung in der Abkanttechnik.

Toolspress® hat vier wichtige Bereiche:

- Präzisions Standard Abkantwerkzeuge
- Präzisions Spezial Abkantwerkzeuge
- Spannsysteme für Abkantwerkzeuge
- Industrielle Lösungen für Abkantpressen
- Shear blades

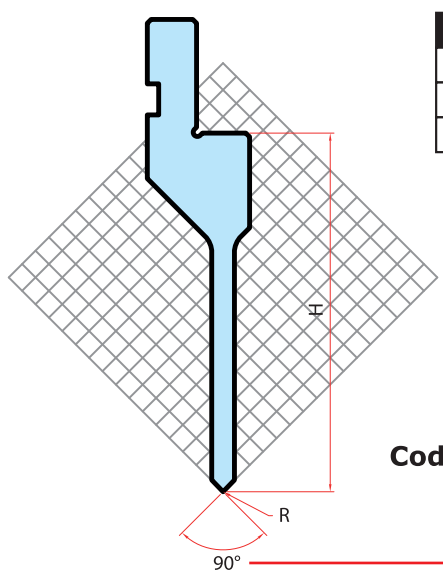
Diese vier Bereiche sind unabhängig, aber alle nutzen die neuesten auf dem Weltmarkt verfügbaren Fertigungstechnologie. Auf diese Weise können wir hochpräzise Qualitätsprodukte ohne Kompromisse garantieren.

Die Qualität von Toolspress® ist seit Jahren auf dem Markt bekannt.

Für uns sind unsere Kunden technologische Partner.

In enger Zusammenarbeit werden Lösungen erreicht und Abkantleistungen verbessert.

Die globalen Marktanforderungen fordern immer mehr Technologien, zu wettbewerbsfähigen Preisen, in kürzester Zeit. Daher entwickeln wir ständig neue Herstellungsverfahren, die es uns erlauben den Kundenanforderungen zu entsprechen.



MOD.	R	H	HR
108	0,2	94,92	
108	0,6	94,4	
108	0,8	94,65	

Il codice utensile è un codice parlante il quale si compone allineando i seguenti valori: modello, gradi della punta, R seguito dal valore del raggio della punta, il tipo di materiale.

The code contains important information and it is obtained using the following data: model, tip degrees, letter R followed by the radius value, type of material.

Cod: 108 90° R0,2 HR

HR-TH-IH

ton/m 50

90°

Gradi della punta dell'utensile, qualora ve ne siano 2 l'utensile ha 2 varianti.

Tip degrees, when there are 2 values, the tool can be offered in two variants.

L=830

L'utensile ha una lunghezza differente da quella standar di 835.

The tool has a different length than the standard of 835.

S

L'utensile non è sezionabile in modo standard.

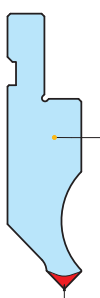
The tool can't be sectioned in the standard way.

Phone icon

Contattateci per ulteriori chiarimenti.

Please contact us for any clarification.

Toolspress HR



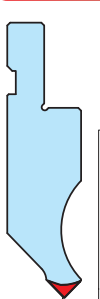
- 42CRM04 Bonificato a 23-28 Hrc
- 42CRM04 Hardening and Tempering to Hrc 23-28
- 42CRM04 Vergutet auf HRc 23-28
- Temprato a Induzione a 55-58 Hrc
- Induction Hardened to Hrc 55-58
- Induktive gehartet auf HRc 55-58

Toolspress TH

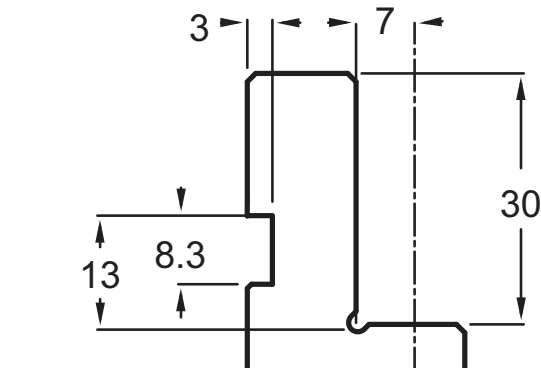


- 42CRM04 Temprato a Cuore 45-49 Hrc
- 42CRM04 Through Hardened to Hrc 45-49
- 42CRM04 Durchgehend vergutet auf HRc 45-49

Toolspress IH

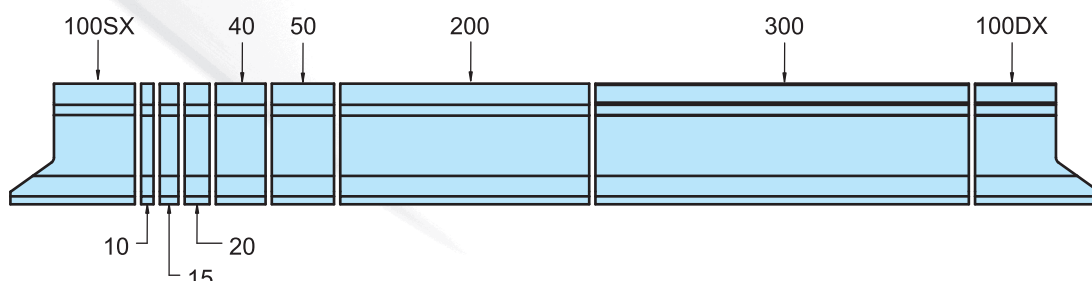


- C45 Temprato a Induzione a 55-58 Hrc
- C45 Induction Hardened to Hrc 55-58
- C45 Induktive gehartet auf HRc 55-58



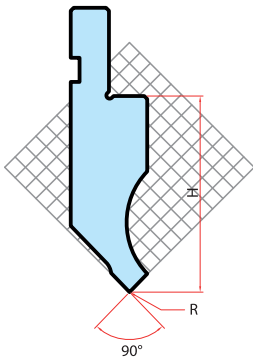
Dimensions: 3, 7, 13, 8.3, 30

Lunghezze standard - Standard length - Standardlängen
835 mm - 415 mm - 835 mm sect.



mod. 016 - 1010

90°



ton/m 100

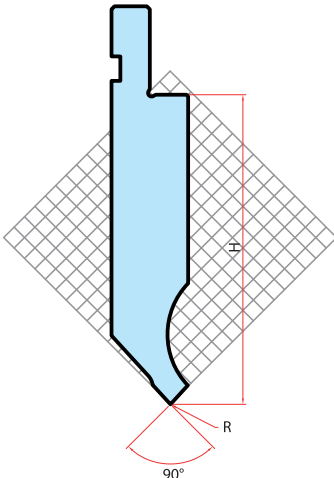
MOD.	R	H	HR
016	0,2	66,92	
016	0,6	66,4	
016	0,8	66,65	

MOD.	R	H	TH
016	0,2	66,92	
016	0,6	66,4	
016	0,8	66,65	

MOD.	R	H	IH
1010	0,2	66,92	
1010	0,8	66,65	

mod. 017 - 1018

90°



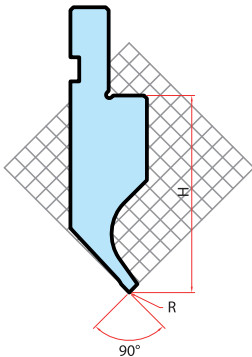
ton/m 100

MOD.	R	H	HR
017	0,2	104,92	
017	0,6	104,4	
017	0,8	104,65	

MOD.	R	H	IH
1018	0,2	104,92	
1018	0,8	104,65	

mod. 116

90°

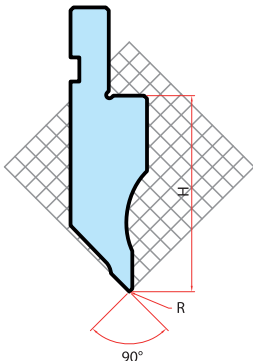


ton/m 20

MOD.	R	H	TH
116	0,2	66,92	
116	0,6	66,4	

mod. 4901

90°



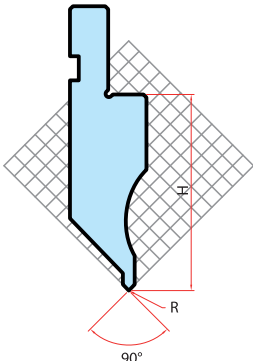
ton/m 80

MOD.	R	H	HR
4901	0,2	66,92	
4901	0,6	66,4	

MOD.	R	H	TH
4901	0,2	66,92	
4901	0,6	66,4	

mod. 4801

90°



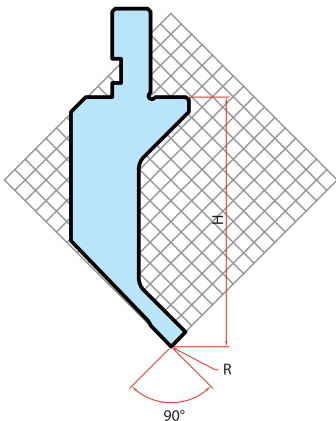
ton/m 80

MOD.	R	H	HR
4801	0,2	66,92	
4801	0,6	66,4	

MOD.	R	H	TH
4801	0,2	66,92	
4801	0,6	66,4	

mod. 1016

90°

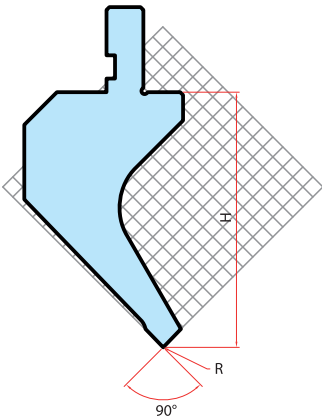


ton/m 20

MOD.	R	H	TH
1016	0,2	84,31	
1016	0,6	84,15	
1016	0,8	84,05	

mod. 462 - 1014

90°



ton/m 70

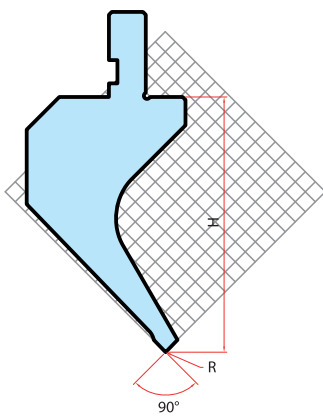
MOD.	R	H	HR
462	0,2	89,92	
462	0,6	89,4	
462	0,8	89,65	

MOD.	R	H	TH
462	0,2	89,92	
462	0,6	89,4	
462	0,8	89,65	

MOD.	R	H	IH
1014	0,2	89,92	
1014	0,8	89,65	

mod. 463

90°

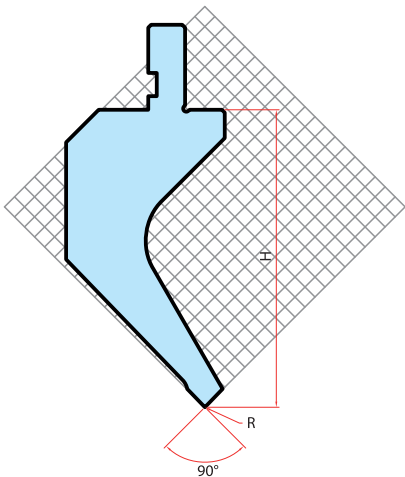


ton/m 50

MOD.	R	H	TH
463	0,2	89,92	
463	0,6	89,4	
463	0,8	89,65	

mod. 046 - 1015

90°



ton/m 50

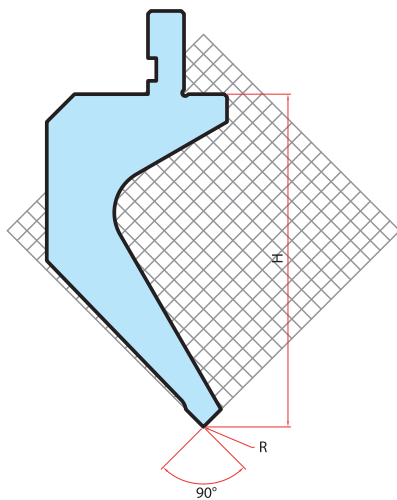
MOD.	R	H	HR
046	0,2	104,92	
046	0,6	104,4	
046	0,8	104,65	

MOD.	R	H	TH
046	0,2	104,92	
046	0,6	104,4	
046	0,8	104,65	

MOD.	R	H	IH
1015	0,2	104,92	
1015	0,6	104,4	

mod. 048

90°



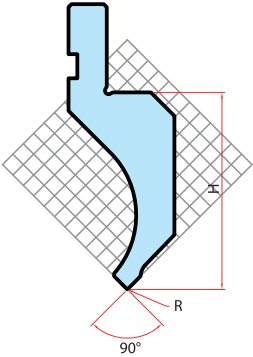
ton/m 50

MOD.	R	H	HR
048	0,2	119,92	
048	0,6	119,4	
048	0,8	119,65	

MOD.	R	H	TH
048	0,2	119,92	
048	0,6	119,4	
048	0,8	119,65	

mod. S2105

90°

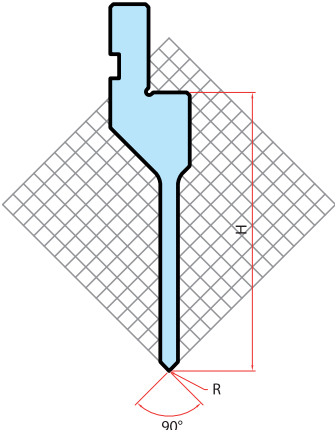


ton/m 60

MOD.	R	H	HR
S2105	0,8	66,65	

mod. 108

90°



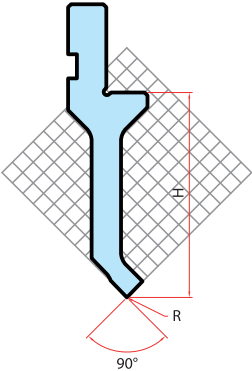
ton/m 50

MOD.	R	H	HR
108	0,2	94,92	
108	0,6	94,4	
108	0,8	94,65	

MOD.	R	H	TH
108	0,2	94,92	
108	0,6	94,4	
108	0,8	94,65	

mod. 201

90°



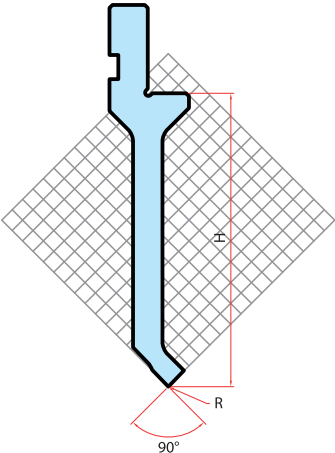
ton/m 30

MOD.	R	H	HR
201	0,2	69,92	
201	0,6	69,4	
201	0,8	69,65	

MOD.	R	H	TH
201	0,2	69,92	
201	0,6	69,4	
201	0,8	69,65	

mod. 203

90°



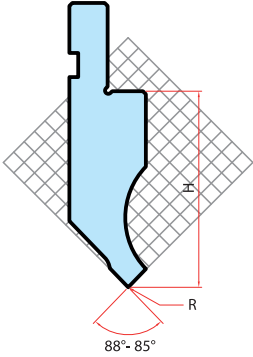
ton/m 30

MOD.	R	H	HR
203	0,2	99,92	
203	0,6	99,4	
203	0,8	99,65	

MOD.	R	H	TH
203	0,2	99,92	
203	0,6	99,4	
203	0,8	99,65	

mod. 004 - 1010

88°
85°



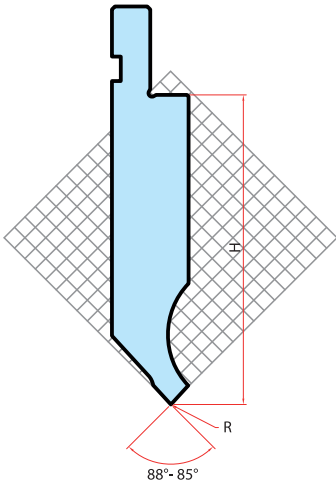
ton/m 100

MOD.	R	H	HR	TH
004	0,2	66,91		
004	0,6	66,4		
004	0,8	66,65		
004	1,5	66,34		
004	3	65,68		

MOD.	R	H	IH
1010	0,2	66,91	
1010	0,8	66,65	
1010	1,5	66,34	
1010	3	65,68	

mod. 005 - 1018

88°
85°



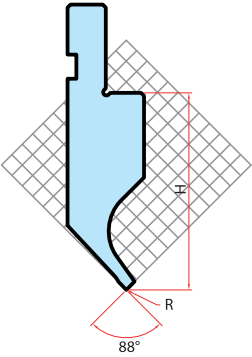
ton/m 100

MOD.	R	H	HR	TH
005	0,2	104,91		
005	0,6	104,4		
005	0,8	104,65		
005	1,5	104,34		
005	3	103,68		

MOD.	R	H	IH
1018	0,2	104,91	
1018	0,8	104,65	
1018	1,5	104,34	
1018	3	103,68	

mod. 116

88°

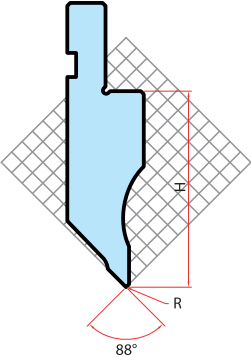


ton/m 20

MOD.	R	H	TH
116	0,2	66,91	
116	0,6	66,4	
116	0,8	66,65	

mod. 4902

88°



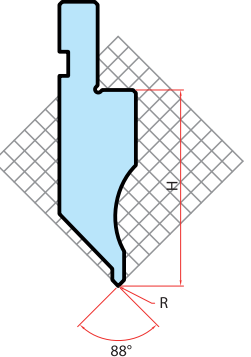
ton/m 80

MOD.	R	H	HR
4902	0,2	66,92	
4902	0,6	66,4	
4902	0,8	66,65	

MOD.	R	H	TH
4902	0,2	66,92	
4902	0,6	66,4	
4902	0,8	66,65	

mod. 4802

88°



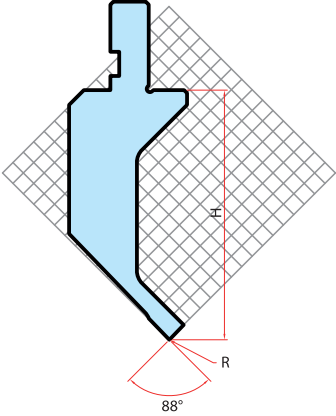
ton/m 80

MOD.	R	H	HR
4802	0,2	66,91	
4802	0,6	66,4	
4802	0,8	66,65	

MOD.	R	H	TH
4802	0,2	66,91	
4802	0,6	66,4	
4802	0,8	66,65	

mod. 1016

88°

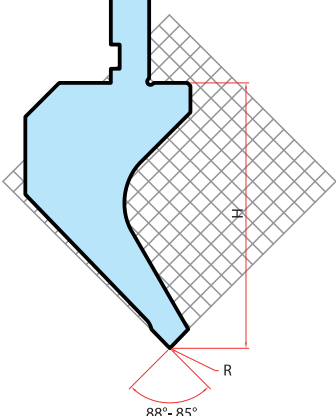


ton/m 20

MOD.	R	H	TH
1016	0,2	84,31	
1016	0,6	84,15	
1016	0,8	84,05	

mod. 462 - 1014

88°
85°



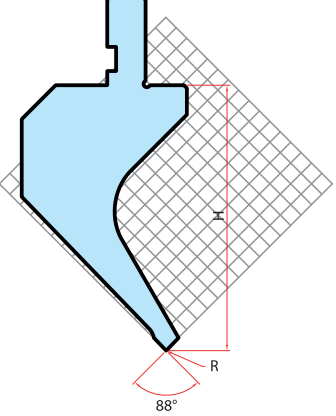
ton/m 70

MOD.	R	H	HR	TH
462	0,2	89,91		
462	0,6	89,4		
462	0,8	89,65		
462	1,5	89,34		
462	3	88,68		

MOD.	R	H	IH
1014	0,2	89,91	
1014	0,8	89,65	
1014	1,5	89,34	
1014	3	88,68	

mod. 453

88°

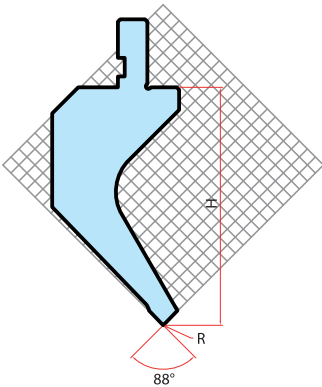


50 Ton/m

MOD.	R	H	TH
453	0,2	89,91	
453	0,6	89,4	
453	0,8	89,65	
453	1,5	89,34	
453	3	88,68	

mod. 045 - 1015

88°
85°



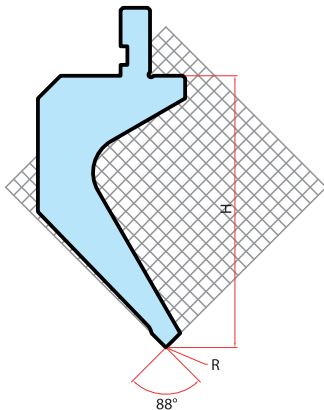
ton/m 50

MOD.	R	H	HR	TH
045	0,2	104,91		
045	0,6	104,4		
045	0,8	104,65		
045	1,5	104,34		
045	3	103,68		

MOD.	R	H	IH
1015	0,2	104,91	
1015	0,8	104,65	
1015	1,5	104,34	
1015	3	103,68	

mod. 047

88°
85°

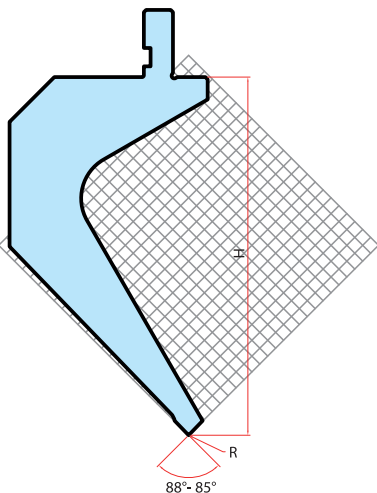


ton/m 50

MOD.	R	H	HR	TH
047	0,2	119,91		
047	0,6	119,4		
047	0,8	119,65		
047	1,5	119,34		
047	3	118,68		

mod. 472

88°
85°

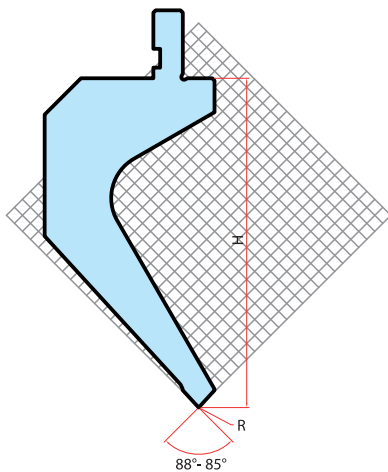


ton/m 50

MOD.	R	H	HR
472	0,6	159,4	
472	0,8	159,65	

mod. 473

88°
85°



ton/m 50

MOD.	R	H	HR
473	0,6	145	
473	0,8	145	

mod. S2050

88°

ton/m 30

MOD.	R	H	HR
S2050	0,25	90	

mod. S2055

88°

ton/m 30

MOD.	R	H	HR
S2055	0,25	110	

mod. 1019

88°
85°

ton/m 50

MOD.	R	H	IH
1019	0,8	86	

mod. S2101

88°
85°

ton/m 30

MOD.	R	H	HR
S2101	0,8	104,65	

mod. S2100

88°
85°

ton/m 60

MOD.	R	H	HR
S2100	0,8	66,65	

mod. S2102

88°
85°

ton/m 40

MOD.	R	H	HR
S2102	0,8	120	

mod. 109

88°
85°

ton/m 50

MOD.	R	H	HR
109	0,2	94,92	
109	0,6	94,4	
109	0,8	94,65	

MOD.	R	H	TH
109	0,2	94,92	
109	0,6	94,4	
109	0,8	94,65	

mod. 113

88°
85°

ton/m 50

MOD.	R	H	HR
113	0,6	159,4	
113	0,8	159,65	

mod. 200

88°
85°

ton/m 30

MOD.	R	H	HR
200	0,2	69,91	
200	0,6	69,4	
200	0,8	69,65	

MOD.	R	H	TH
200	0,2	69,91	
200	0,6	69,4	
200	0,8	69,65	

mod. 202

88°
85°

ton/m 30

MOD.	R	H	HR
202	0,2	99,91	
202	0,6	99,4	
202	0,8	99,65	

MOD.	R	H	TH
202	0,2	99,91	
202	0,6	99,4	
202	0,8	99,65	

mod. 1848 - 1864

85°

ton/m 100

MOD.	R	H	HR
1848	4,8	105	
1864	6,4	104,33	

mod. 047

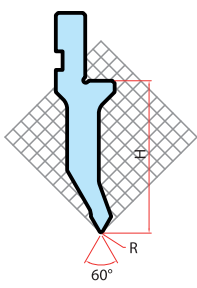
75°

ton/m 100

MOD.	R	H	HR
047	0,8	120	

mod. 1011

60°

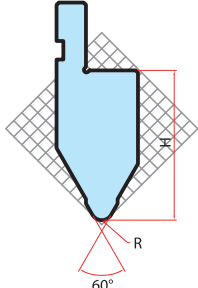


ton/m 100

MOD.	R	H	IH
1011	0,8	67	
1011	2	65,8	

mod. 003 - 1013

60°



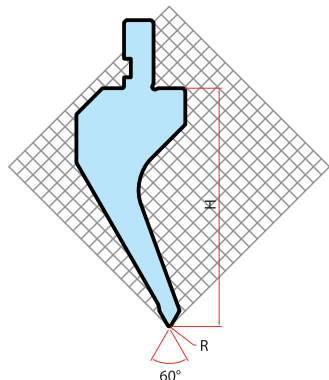
ton/m 100

MOD.	R	H	HR
003	4,8	66,2	
003	6	65	

MOD.	R	H	IH
1013	6	65	

mod. 454

60°

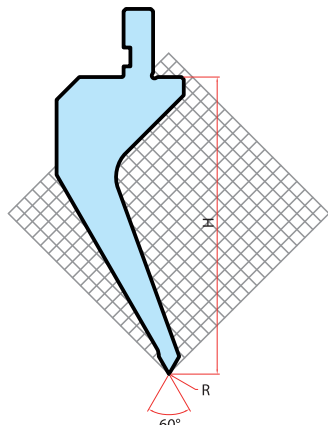


ton/m 60

MOD.	R	H	HR
454	0,8	105	
454	2	103,8	

mod. 455

60°

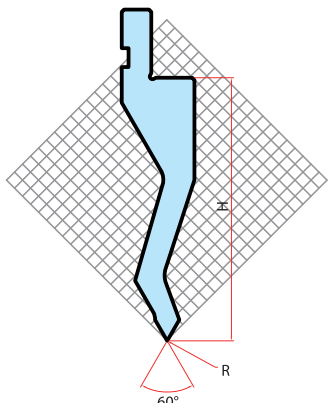


ton/m 60

MOD.	R	H	HR
455	0,8	130	
455	2	128,8	

mod. 456

60°

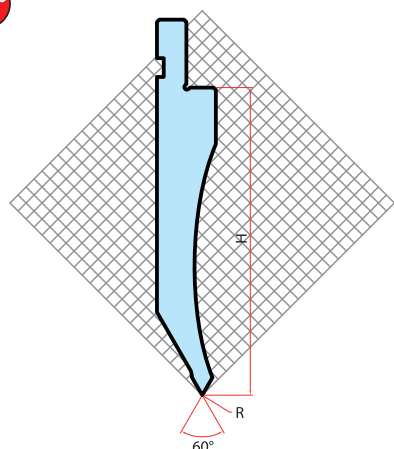


ton/m 60

MOD.	R	H	HR
456	0,8	115	
456	2	113,8	

mod. S1997

60°



ton/m 100

MOD.	R	H	HR
S1997	0,8	135	
S1997	2	133,8	

mod. 008 - 1011

45°

ton/m 100

MOD.	R	H	HR
008	0,37	66,4	

MOD.	R	H	TH
008	0,37	66,4	

MOD.	R	H	IH
1011	1,5	65,2	

mod. 215

45°

ton/m 100

MOD.	F	H	HR
215	3	67	

mod. 1011

35°

ton/m 100

MOD.	F	H	IH
1011	0,8	67	

mod. 1012

35°

ton/m 100

MOD.	F	H	HR
1012	0,8	90	

MOD.	F	H	IH
1012	0,8	90	

mod. 103

30°

ton/m 100

MOD.	R	H	HR
103	0,8	65,5	

MOD.	R	H	TH
103	0,8	65,5	

mod. 210

30°

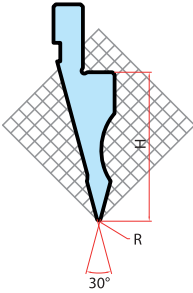
ton/m 100

MOD.	R	H	HR
210	0,65	104	
210	0,8	104	
210	1,5	102	
210	3	97,7	

MOD.	R	H	TH
210	0,65	104	
210	0,8	104	
210	1,5	102	
210	3	97,7	

mod. 1380

30°



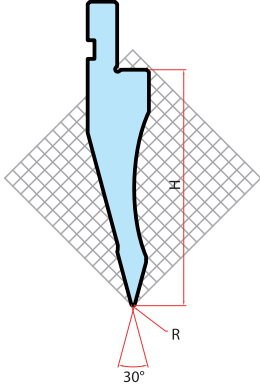
ton/m 100

MOD.	R	H	HR
1380	0,8	65,5	

MOD.	R	H	TH
1380	0,8	65,5	

mod. 1319

30°



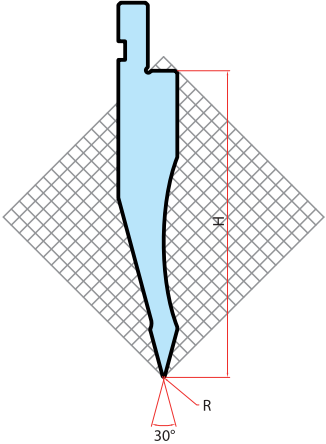
ton/m 100

MOD.	R	H	HR
1319	0,8	104	

MOD.	R	H	TH
1319	0,8	104	

mod. S1996

30°

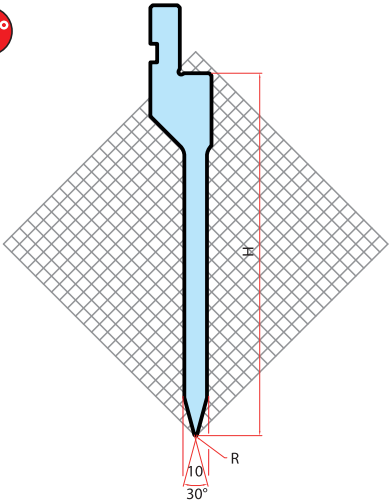


ton/m 100

MOD.	R	H	HR
S1996	0,5	135	

mod. 110

30°

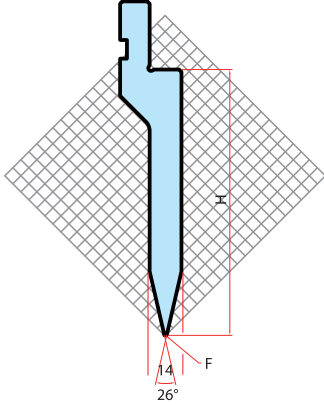


ton/m 50

MOD.	R	H	HR
110	0,65	160	

mod. S1754

26°

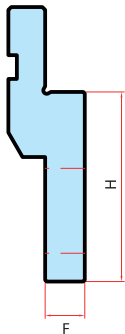


ton/m 100

MOD.	F	H	IH
S1754	1	117	

mod. 4005

L=830

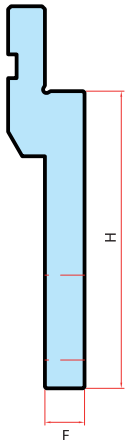


ton/m 100

MOD.	F	H	IH
4005	14	67	

mod. 4015

L=830

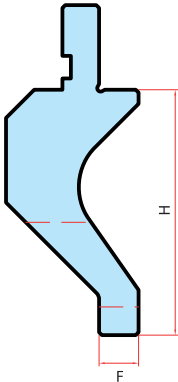


ton/m 100

MOD.	F	H	IH
4015	14	105	

mod. 4025

L=830

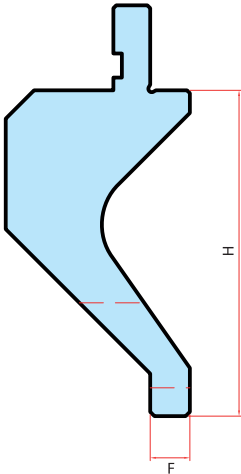


ton/m 50

MOD.	F	H	IH
4025	14	87	

mod. 4035

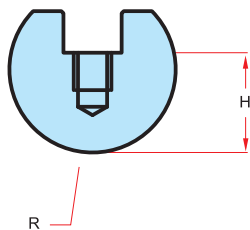
L=830



ton/m 50

MOD.	F	H	IH
4035	14	115	

mod. 4009

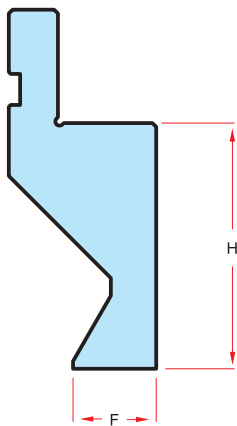


ton/m 100

MOD.	R	H	IH
4009.D16	8	13	
4009.D20	10	16	
4009.D25	12,5	18	
4009.D30	15	20	
4009.D35	17,5	22	
4009.D40	20	24	
4009.D50	25	29	
4009.D60	30	34	
4009.D70	35	45	
4009.D80	40	45	
4009.D90	45	60	
4009.D100	50	70	

PUNZONI PIATTI - FLATTENING PUNCHES - ZUDRÜCKEN

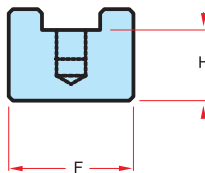
mod. 1523



ton/m 100

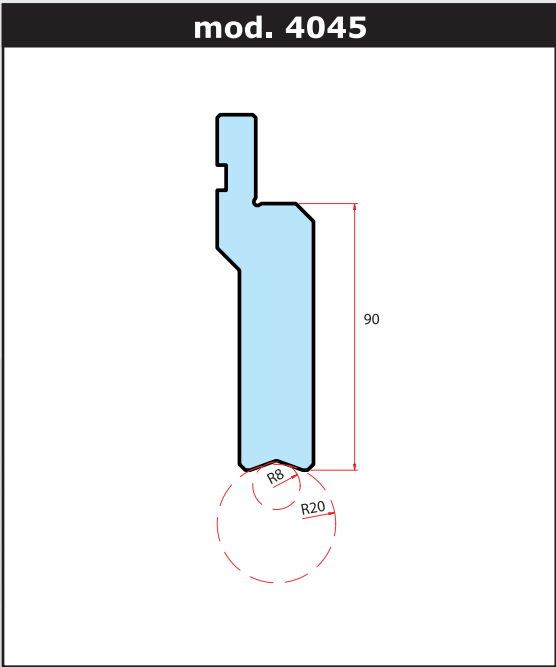
MOD.	F	H	IH
1523	23	65	

mod. 4002

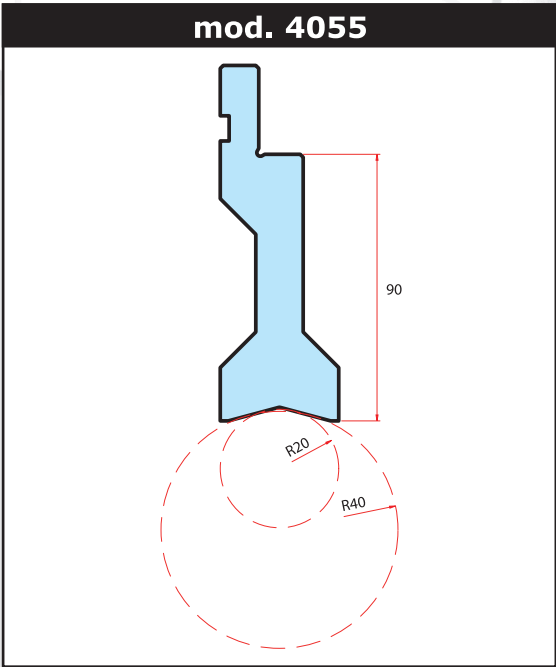


ton/m 100

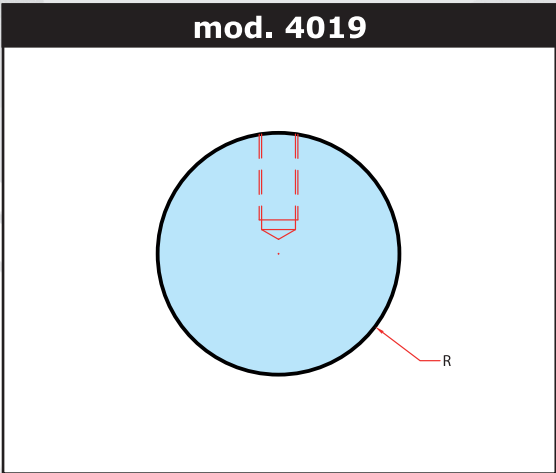
MOD.	F	H	IH
4002	30	17	



MOD.	IH
4045	



MOD.	IH
4055	



MOD.	IH
4019.D16	
4019.D20	
4019.D25	
4019.D30	
4019.D35	
4019.D40	
4019.D50	
4019.D60	
4019.D70	
4019.D80	

Lunghezze standard - Standard length - Standardlängen



25	25	30	35	40	45	50	100	200	300
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MOD.	V	R	W	ton/m	HR
M0632	6	0,4	14	100	
M0637	8	0,5	14	80	
M0629	10	0,6	18	100	
M0643	12	0,8	18	80	

90°

Gradi della matrice, qual'ora ve ne siano 2 l'utensile ha 2 varianti.
Die degrees, when there are 2 values, the tool can be offered in two variants.

L=830

L'utensile ha una lunghezza differente da quella standar di 835.
The tool has a different length than the standard of 835.

S

L'utensile non è sezionabile in modo standard.
The tool can't be sectioned in the standard way.

HR

Contattateci per ulteriori chiarimenti.
Please contact us for any clarification.

GOLD

Trattamento ideale per piegare la lamiera zincata e l'acciaio inox.
Ideal treatment to bend the galvanized steel and the stainless steel.

Il codice matrice è un codice parlante il quale si compone allineando i seguenti valori: modello, gradi del V, R seguito dal valore del raggio matrice, il tipo di manerale

The code contains important information and it is obtained using the following data: model, V die opening, V degrees, type of material.

HR-TH-IH o/or Gold

Cod: M0632 Gradi Degrees 6 HR

Toolspress HR

Temprato a Induzione a 55-58 Hrc
Induction Hardened to Hrc 55-58
Induktive gehartet auf Hrc 55-58

Bonificato a 23-28 Hrc
Hardening and Tempering to Hrc 23-28
Vergutet auf Hrc 23-28

Toolspress TH

Su ordinazione anche nella variante GOLD
Available in GOLD style

Temprato a Cuore 45-49 Hrc
Through Hardened to Hrc 45-49
Durchgehend vergutet auf Hrc 45-49

Toolspress IH

Temprato a Induzione a 55-58 Hrc
Induction Hardened to Hrc 55-58
Induktive gehartet auf Hrc 55-58

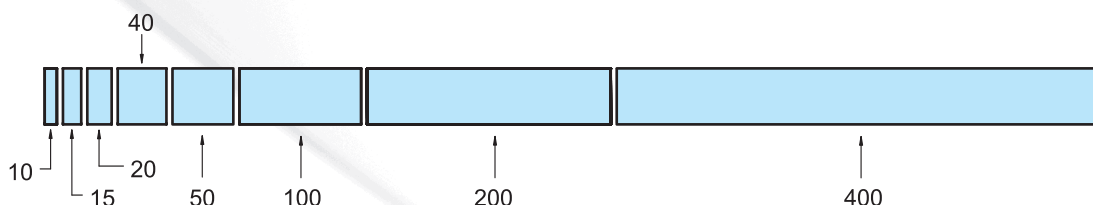
Toolspress HR

Su ordinazione anche nella variante GOLD
Available in GOLD style

Disponibile su modelli selezionati
Available on requested model

Bonificato a 23-28 Hrc
Hardening and Tempering to Hrc 23-28
Vergutet auf Hrc 23-28

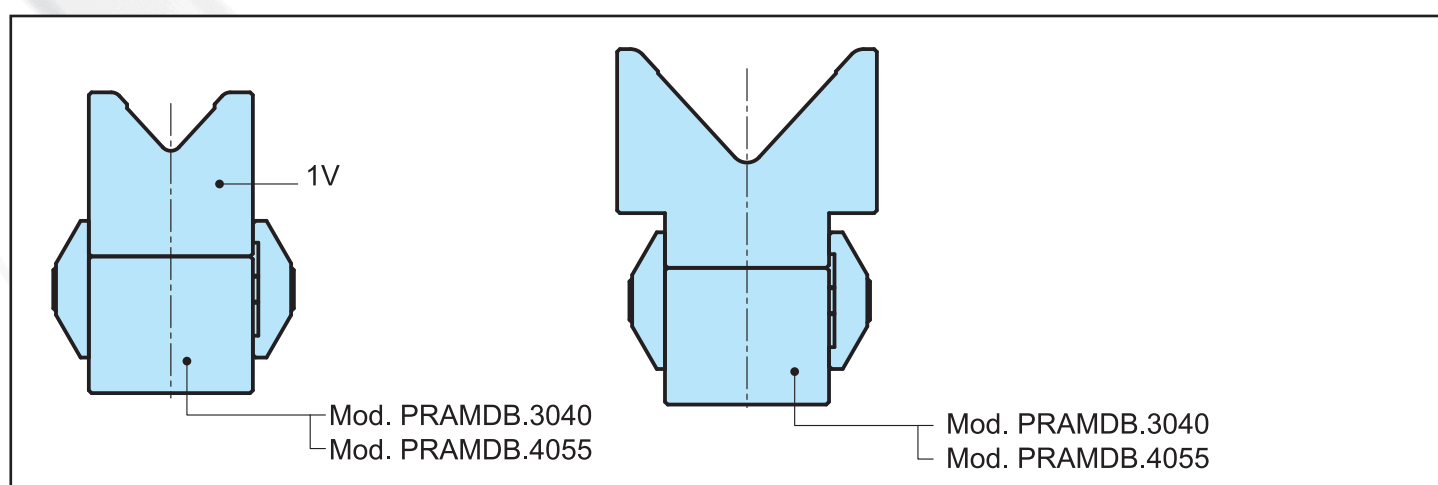
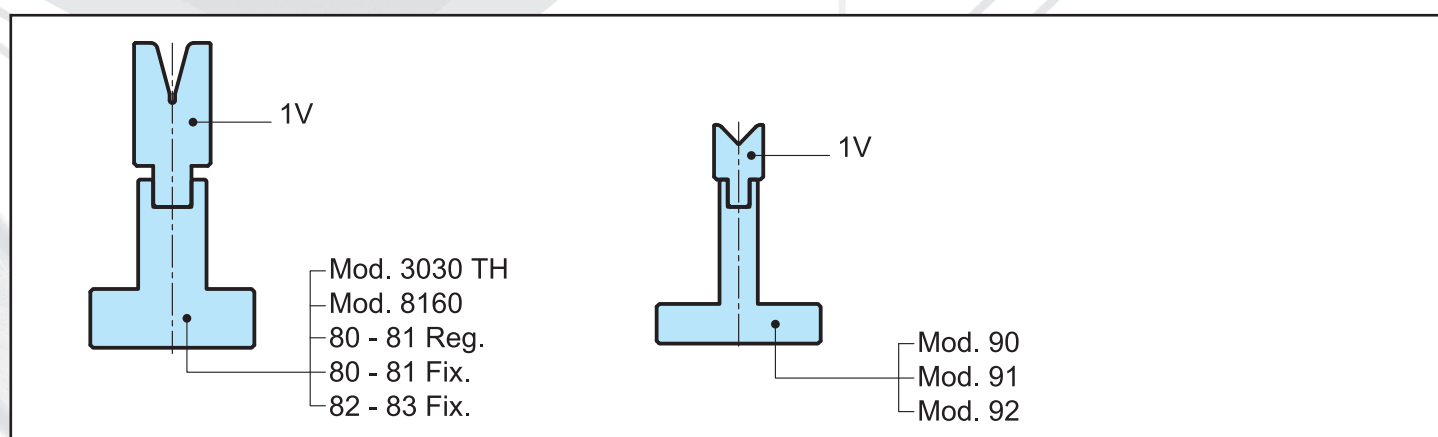
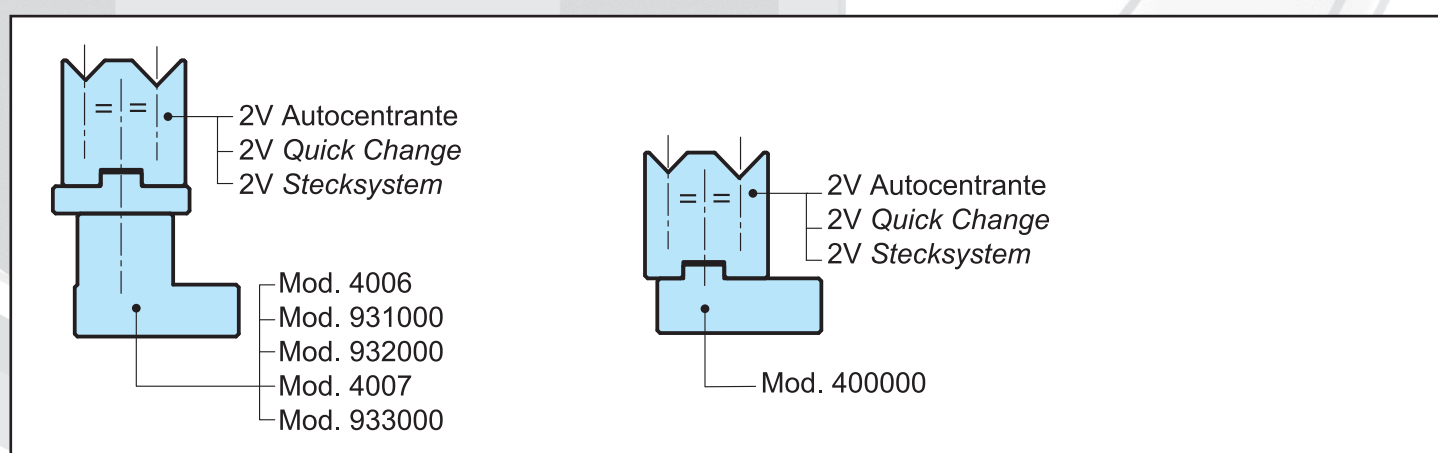
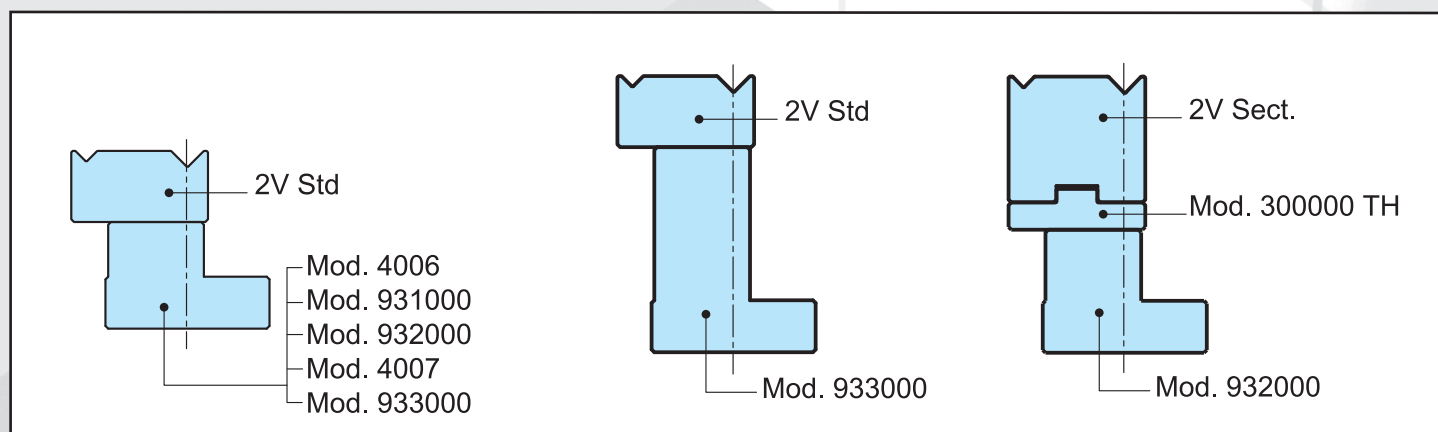
Lunghezze standard - Standard lenght - Standardlängen
835 mm - 415 mm - 835 mm sect.



SISTEMA DI MONTAGGIO MATRICI

DIES SET UP SYSTEM

MATRIZEN MONTAGEBEISPIEL



90°

ton/m 95

MOD.	V	R	W	HR	TH
2110	6	1,5	14		
2111	8	1,5	14		
2112	10	2,0	14		
2113	12	2,5	17		

Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150 - 3030

90°

ton/m 95

MOD.	V	R	W	HR	TH
70	6	1,5	14		
71	8	1,5	14		
73	10	2,0	15		
75	12	2,5	17		

Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150 - 3030

90°

ton/m 95

MOD.	V	R	W	HR	TH
2100	6	1,5	14		
2101	8	1,5	14		
2102	10	2,0	14		
2103	12	2,5	17		

Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150 - 3030

90°

ton/m 95

MOD.	V	R	W	HR	TH
420	6	1,5	14		
421	8	1,5	14		
422	10	2,0	16		
423	12	2,5	16		

Supporti - Die Holder - Halter
Mod 90 - 91 - 92

88°

ton/m 95

MOD.	V	R	W	HR	TH
2114	10	2,0	14		
2115	12	2,5	17		
2116	14	2,5	18		

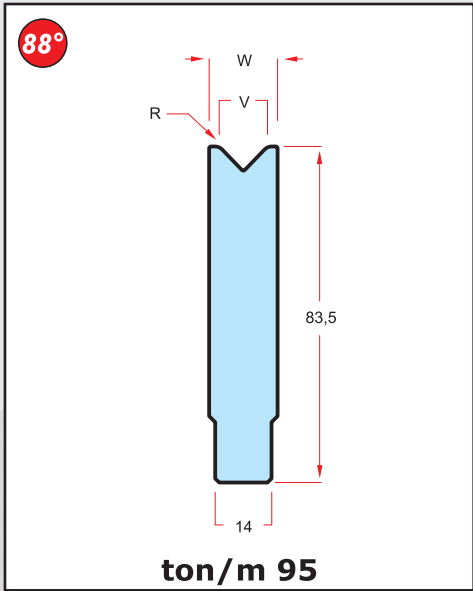
Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150 - 3030

88°

ton/m 95

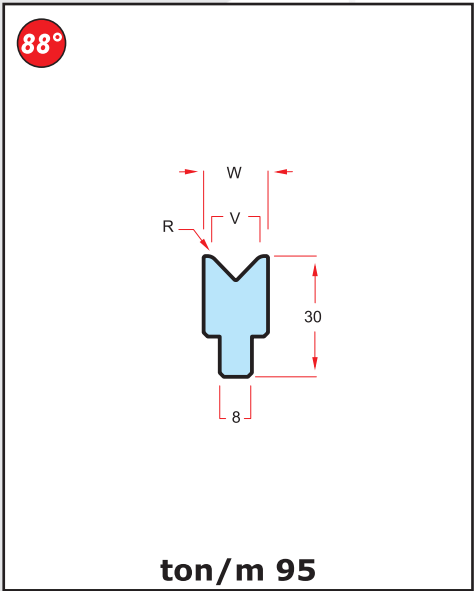
MOD.	V	R	W	HR	TH
70	6	1,5	14		
71	8	1,5	14		
73	10	2,0	15		
75	12	2,5	17		
76	14	2,5	18		
77	16	2,5	21		
78	18	3,0	23		
79	20	3,0	25		
82	25	3,0	30		

Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150 - 3030



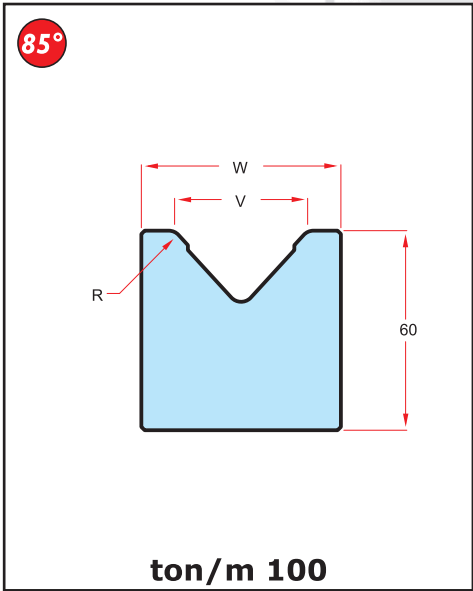
MOD.	V	R	W	HR	TH
2104	12	2,5	17		
2105	14	2,5	18		

Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150

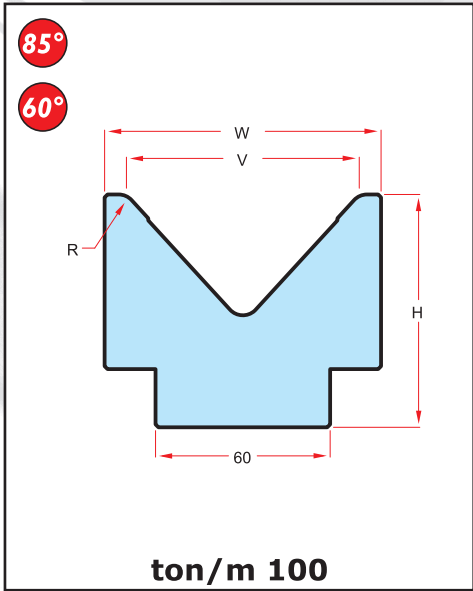


MOD.	V	R	W	HR	TH
420	6	1,5	14		
421	8	1,5	14		
422	10	2,0	14		
423	12	2,5	16		
424	14	2,5	18		

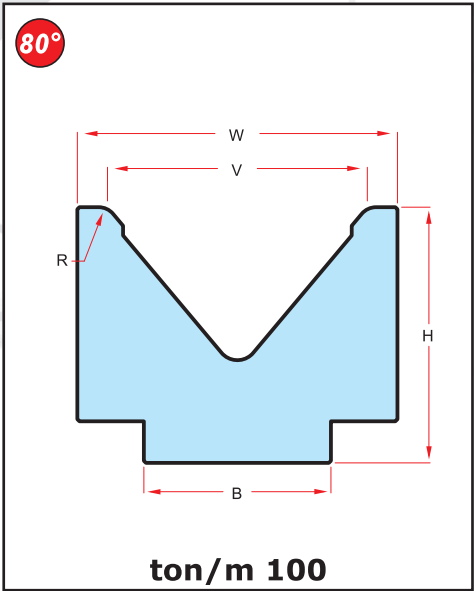
Supporti - Die Holder - Halter
Mod 90 - 91 - 92



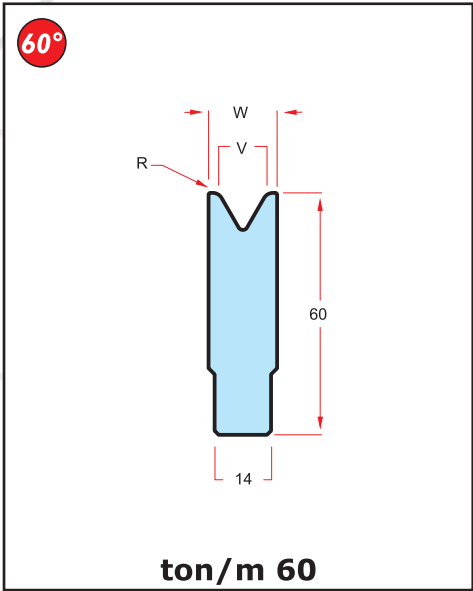
MOD.	V	R	IH
2011.32	32	4	
2011.40	40	4	
2011.50	50	4	



MOD.	A	V	R	W	H	IH
2011.63	85°	63	5	80	75	
2011.80	85°	80	6	95	95	
2011.80	60°	80	6	115	115	

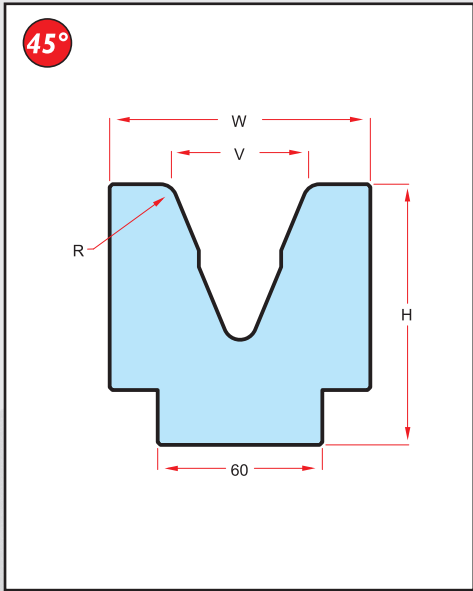


MOD.	V	B	R	W	H	IH
2011.100	100	60	7	120	110	
2011.125	125	90	9	153	123	
2011.160	160	120	11	185	130	

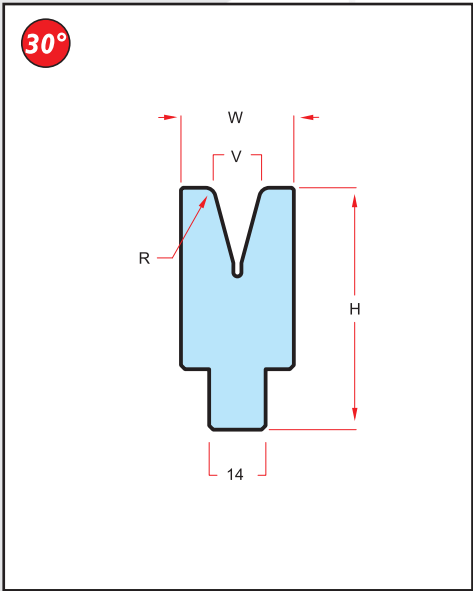


MOD.	V	R	W	HR	TH
70	6	1,5	14		
71	8	1,5	14		
73	10	2,0	15		
75	12	2,5	17		
76	14	2,5	18		
77	16	2,5	24		
79	20	3,0	30		
82	25	3,0	33		

Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150

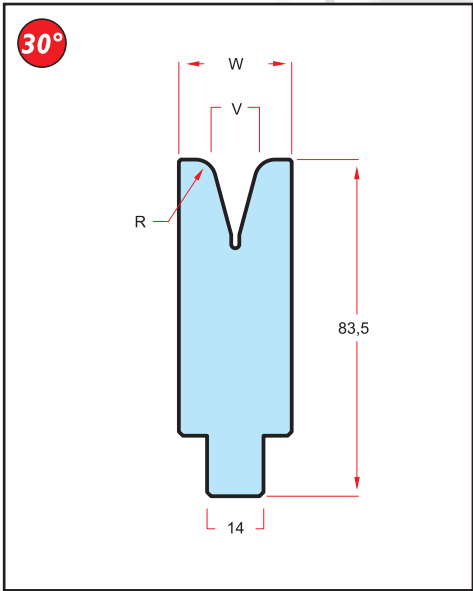


MOD.	V	R	W	H	ton/m	IH
342	32	5	60	60	40	
343	40	5	80	80	70	
344	50	6	95	95	70	
S630	63	8	105	105	90	



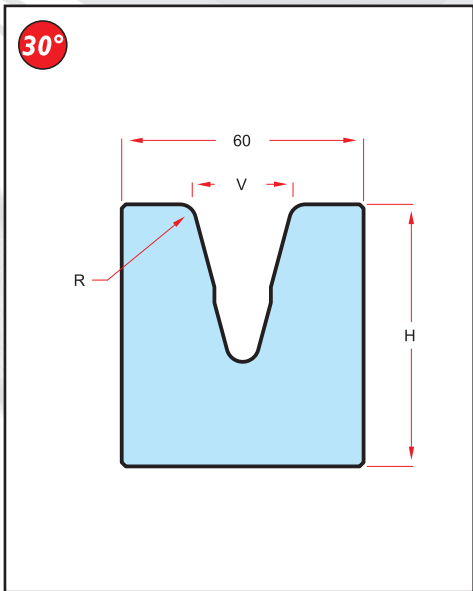
MOD.	H	V	R	W	ton/m	HR	TH
70	60	6	1,0	16	35		
71	60	8	1,0	19	35		
73	60	10	2,0	24	60		
75	60	12	2,5	28	60		
77	60	16	3	33	60		
79	80	20	4	40	60		
82	80	25	4	42	60		

Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150

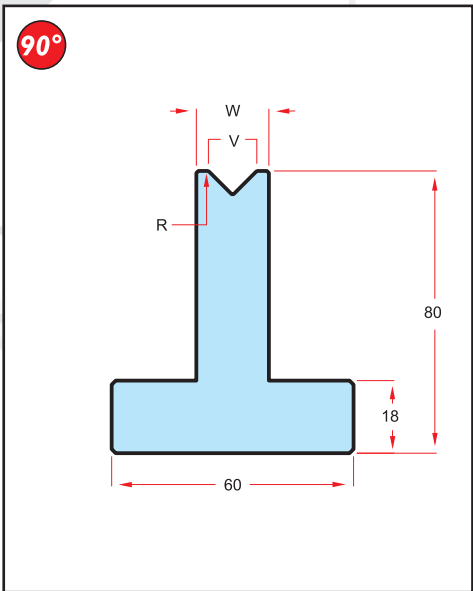


MOD.	V	R	W	ton/m	HR	TH
2200	6	3,0	16	35		
2201	8	3,0	19	35		
2202	10	3,0	24	50		
2203	12	5,0	28	50		
2204	14	5,0	32	50		
2205	16	5,0	36	50		

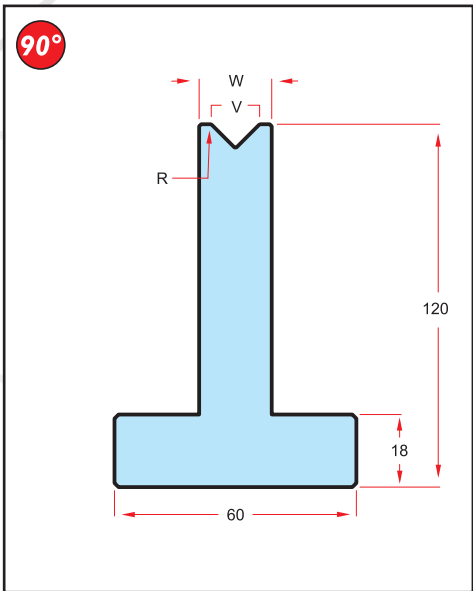
Supporti - Die Holder - Halter
Mod 80 Reg./ 81 Reg. - 82/83 - 8150



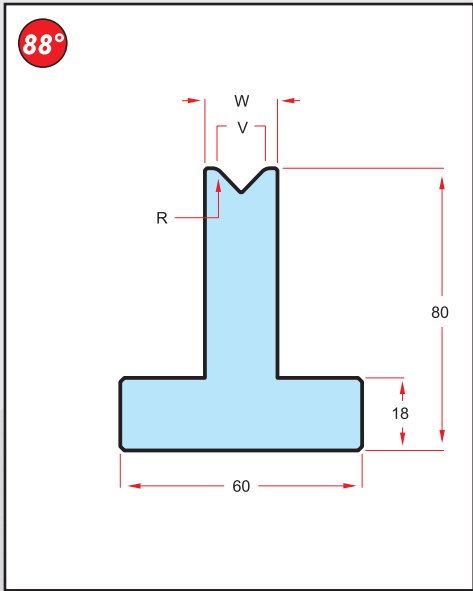
MOD.	V	R	H	ton/m	HR
340	18	3,0	60	80	
341	25	4,0	65	60	



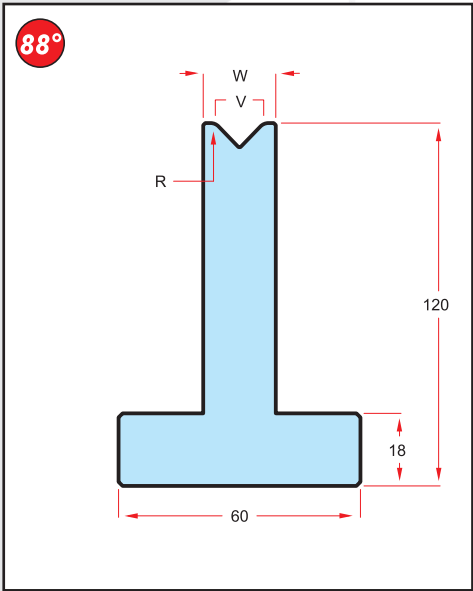
MOD.	V	R	W	ton/m	HR
M0632	6	0,4	14	100	
M0637	8	0,5	14	80	
M0629	10	0,6	18	100	
M0643	12	0,8	18	80	



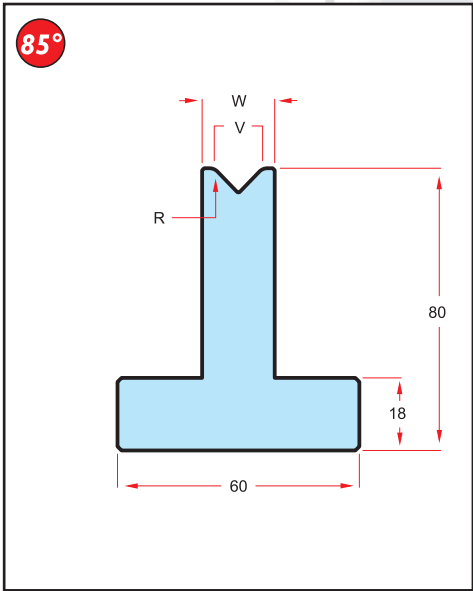
MOD.	V	R	W	ton/m	HR
S1100	6	0,4	14	100	
S1101	8	0,5	14	80	
S1102	10	0,6	18	100	
S1103	12	0,8	18	80	



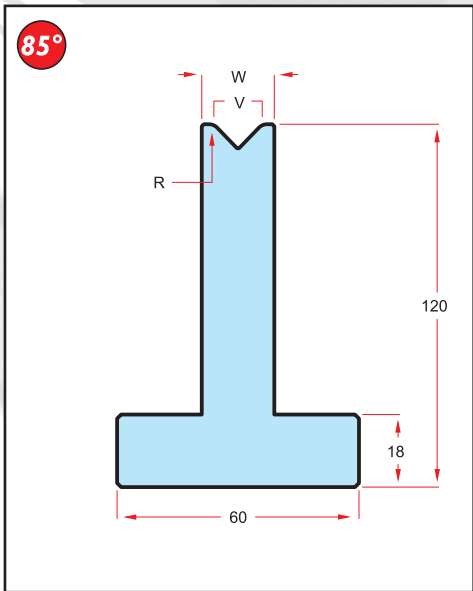
MOD.	V	R	W	ton/m	HR
M0670	6	0,4	14	100	
M0671	8	0,5	14	80	
M0672	10	0,6	18	100	
M0673	12	2,75	18	80	
M0648	16	2,75	24	100	
M0674	20	3,0	30	100	
M0675	25	3,0	35	100	



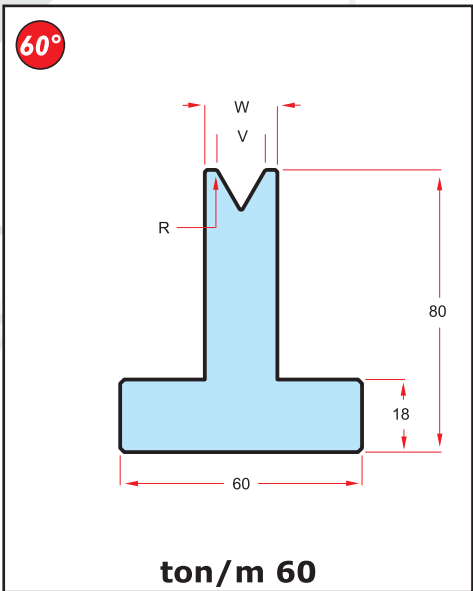
MOD.	V	R	W	ton/m	HR
S1105	6	0,4	14	100	
S1106	8	0,5	14	80	
S1107	10	0,6	18	100	
S1108	12	2,75	18	80	
S1109	16	2,75	24	100	
S1110	20	3,0	30	100	
S1111	25	3,0	35	100	



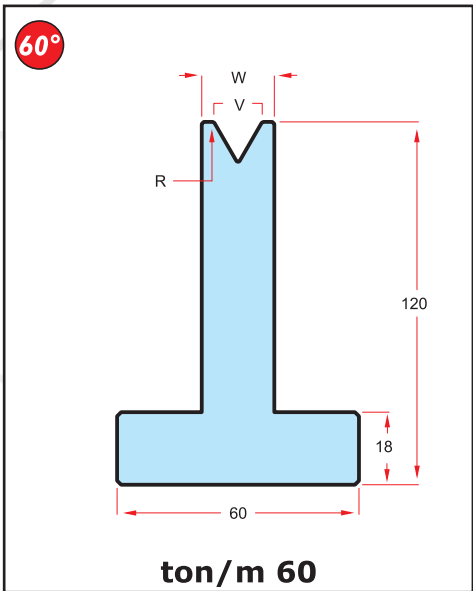
MOD.	V	R	W	ton/m	HR
M0770	6	1,5	14	100	
M0771	8	1,5	14	80	
M0772	10	2,0	18	100	
M0773	12	2,75	18	80	
M0748	16	2,75	24	100	
M0774	20	3,0	30	100	
M0775	25	3,0	35	100	



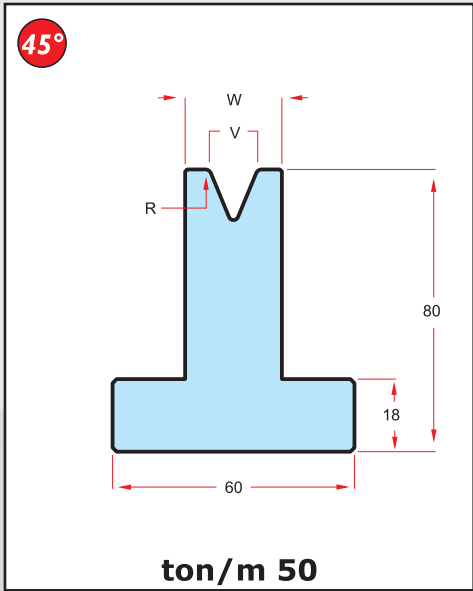
MOD.	V	R	W	ton/m	HR
S1205	6	1,5	14	100	
S1206	8	1,5	14	80	
S1207	10	2,0	18	100	
S1208	12	2,75	18	80	
S1209	16	2,75	24	100	
S1210	20	3,0	30	100	
S1211	25	3,0	35	100	



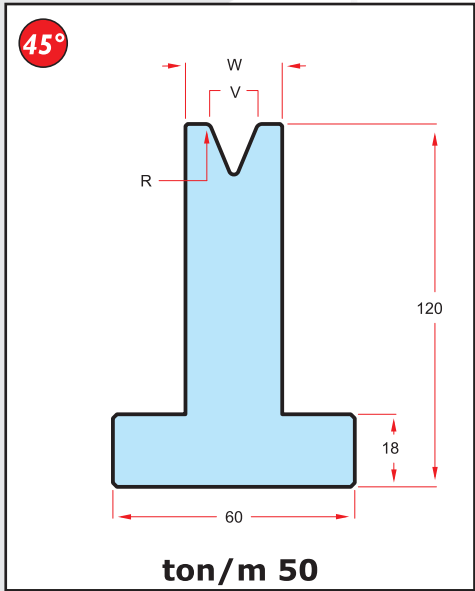
MOD.	V	R	W	HR
M0650	6	0,4	14	
M0651	8	0,5	14	
M0652	10	0,6	18	
M0653	12	0,8	18	
M0647	16	3,0	24	
M0654	20	3,0	30	
M0655	25	3,0	35	



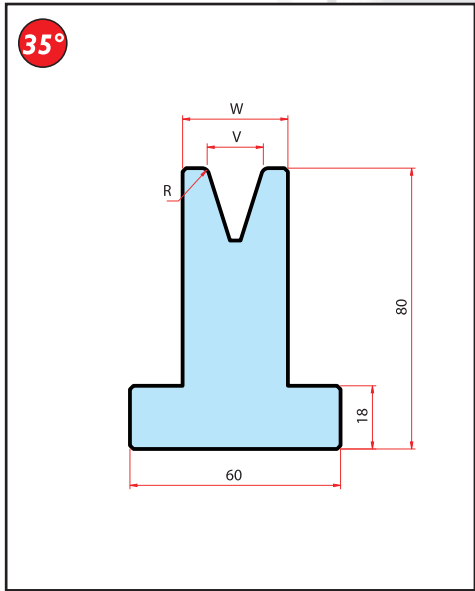
MOD.	V	R	W	HR
S1113	6	0,4	14	
S1114	8	0,5	14	
S1115	10	0,6	18	
S1116	12	0,8	18	
S1117	16	3,0	24	
S1118	20	3,0	30	
S1119	25	3,0	35	



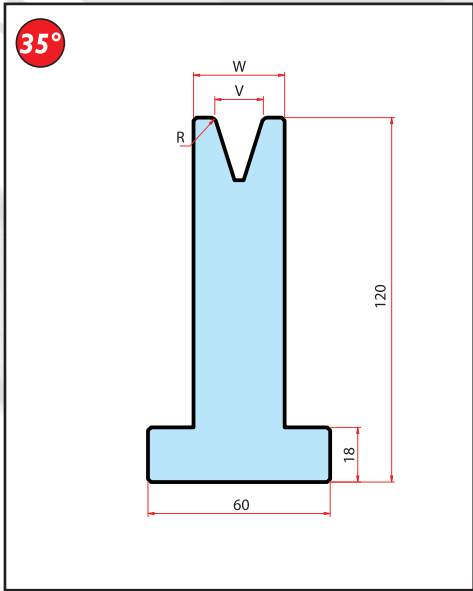
MOD.	V	R	W	HR
M1070	6	0,6	14	
M1071	8	0,8	18	
M1072	10	1,0	18	
M1073	12	1,5	24	
M1074	16	2,0	24	
M1075	20	2,5	30	
M1076	25	3,0	35	



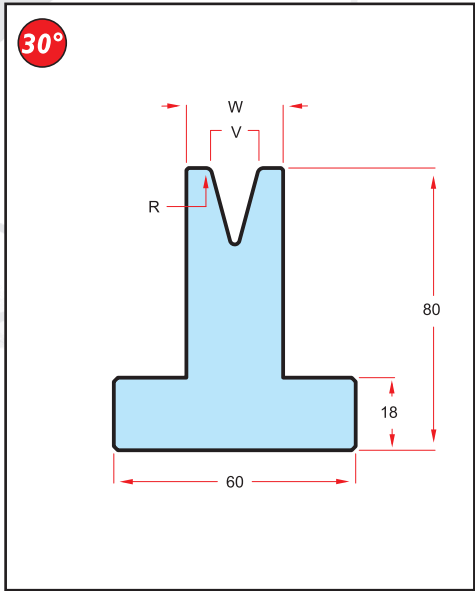
MOD.	V	R	W	HR
S1121	6	0,6	14	
S1122	8	0,8	18	
S1123	10	1,0	18	
S1124	12	1,5	24	
S1125	16	2,0	24	
S1126	20	2,5	30	
S1127	25	3,0	35	



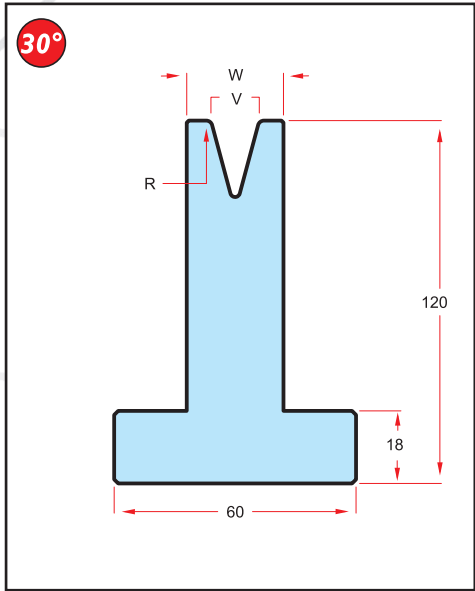
MOD.	V	R	W	Ton/m	HR
M0727	6	0,6	14	35	
M0728	8	0,8	14	35	
M0729	10	1,0	18	40	
M0730	12	1,5	18	40	
M0731	16	2,0	30	45	
M0732	20	2,5	35	50	
M0733	25	3,0	40	50	



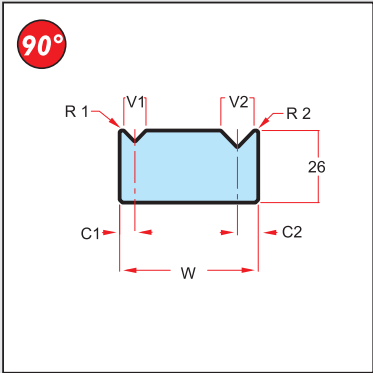
MOD.	V	R	W	Ton/m	HR
S1727	6	0,6	14	35	
S1728	8	0,8	14	35	
S1729	10	1,0	18	40	
S1730	12	1,5	18	40	
S1731	16	2,0	30	45	
S1732	20	2,5	35	50	
S1733	25	3,0	40	50	



MOD.	V	R	W	ton/m	HR
M1080	6	0,6	14	35	
M1081	8	0,8	18	35	
M1082	10	1,0	24	40	
M1083	12	1,5	24	40	
M1084	16	2,0	30	45	
M1085	20	2,5	35	50	
M1086	25	3,0	40	50	

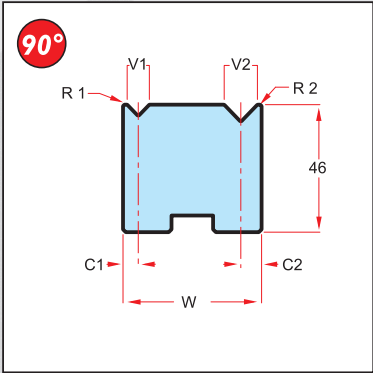


MOD.	V	R	W	ton/m	HR
S1129	6	0,6	14	35	
S1130	8	0,8	18	35	
S1131	10	1,0	24	40	
S1132	12	1,5	24	40	
S1133	16	2,0	30	45	
S1134	20	2,5	35	50	
S1135	25	3,0	40	50	



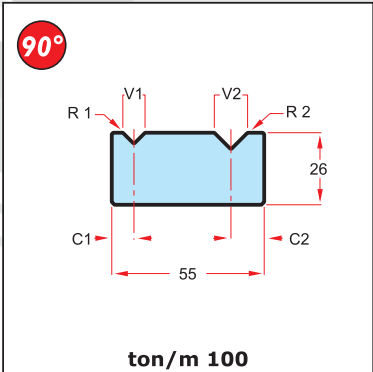
MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	HR	TH
121	4	7	0,4	0,4	3,5	5,0	50	60		
123	6	10	0,4	0,6	4,5	6,5	50	70		
124	8	12	0,5	0,8	5,5	7,5	50	80		
125	14	18	0,5	0,5	8,5	10,5	50	100		
311	6	10	1,5	2,5	6,0	10,0	50	80		

Supporti - Die Holder - Halter
Mod. 4006/4007 - 931/932/933



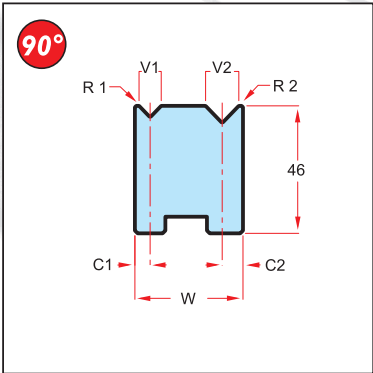
MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	HR	TH
30140	4	7	0,4	0,4	3,5	5,0	50	60		
30240	6	10	0,4	0,6	4,5	6,5	50	70		
30340	8	12	0,5	0,8	5,5	7,5	50	80		
30440	14	18	0,5	0,5	8,5	10,5	50	100		
31146	6	10	1,5	2,5	6,0	10,0	50	80		

Supporti - Die Holder - Halter - Mod. 931000
Guida - Die Rail - Matrizen Halter - Mod. 300000



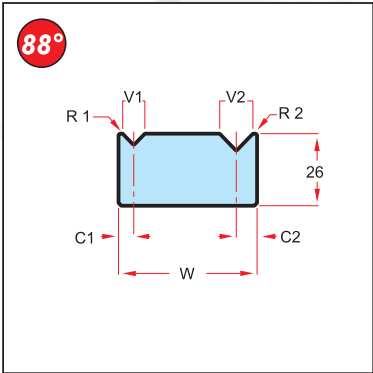
MOD.	V1	V2	R1	R2	C1	C2	IH
2012	6	10	0,4	0,6	6,0	10	
2013	8	12	0,5	0,8	8,0	10	

Supporti - Die Holder - Halter
Mod. 4006/4007 - 931/932/933



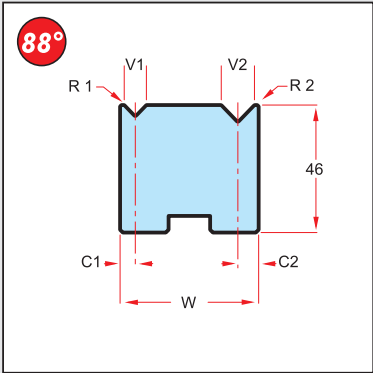
MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	HR	TH
501	4	7	0,4	0,4	3,5	5,0	34,5	60		
502	6	10	0,4	0,6	4,5	6,5	37	70		
503	8	12	0,5	0,8	5,5	7,5	39	80		
504	14	18	0,5	0,5	8,5	10,5	45	100		
511	6	10	1,5	2,5	6,0	10,0	40	80		

Supporti - Die Holder - Halter
Mod. 4006/4007 - 931/932/933



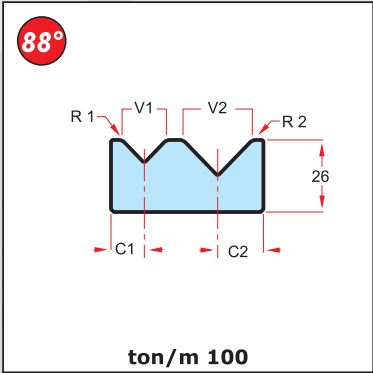
MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	HR	TH
121	4	7	0,4	0,4	3,5	5,0	50	60		
123	6	10	0,4	0,6	4,5	6,5	50	70		
124	8	12	0,5	0,8	5,5	7,5	50	80		
125	14	18	0,5	0,5	8,5	10,5	50	100		
126	12	20	0,5	0,5	7,5	12,0	50	100		
127	16	25	0,8	0,8	9,5	14,5	50	100		
311	6	10	1,5	2,5	6,0	10,0	55	80		
314	12	20	3,0	4,0	10,0	15,0	55	100		

Supporti - Die Holder - Halter
Mod. 4006/4007 - 931/932/933



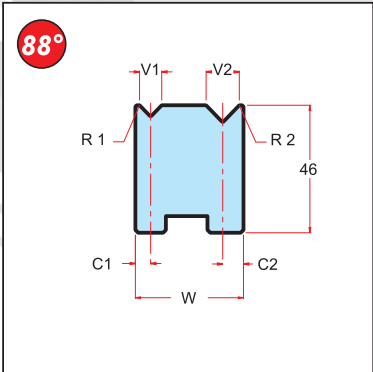
MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	HR	TH
30140	4	7	0,4	0,4	3,5	5,0	50	60		
30240	6	10	0,4	0,6	4,5	6,5	50	70		
30340	8	12	0,5	0,8	5,5	7,5	50	80		
30440	14	18	0,5	0,5	8,5	10,5	50	100		
30540	12	20	0,5	0,5	7,5	12,0	50	100		
30640	16	25	0,8	0,8	9,5	14,5	50	100		
31146	6	10	1,5	2,5	6,0	10,0	55	80		
31440	12	20	3,0	4,0	10,0	15,0	55	100		

Supporti - Die Holder - Halter - Mod. 931000
Guida - Die Rail - Matrizen Halter - Mod. 300000



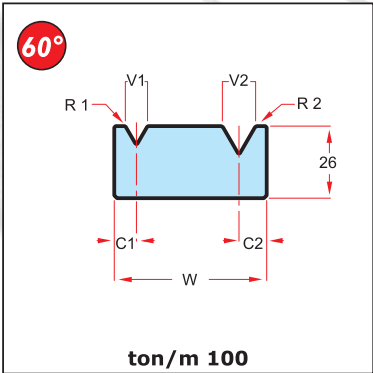
MOD.	V1	V2	R1	R2	C1	C2	IH
2014	12	20	2,75	3,0	10,0	15	
2015	16	25	2,75	3,0	12,0	16,5	

Supporti - Die Holder - Halter
Mod. 4006/4007 - 931/932/933



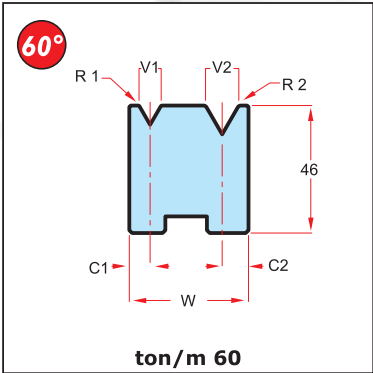
MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	HR	TH
501	4	7	0,4	0,4	3,5	5,0	34,5	60		
502	6	10	0,4	0,6	4,5	6,5	37	70		
503	8	12	0,5	0,8	5,5	7,5	39	80		
504	14	18	0,5	0,5	8,5	10,5	45	100		
505	12	20	0,5	0,5	7,5	12,0	45,5	100		
506	16	25	0,8	0,8	9,5	14,5	50	100		
507	6	10	1,5	2,5	6,0	10,0	40	80		
508	12	20	3,0	4,0	10,0	15,0	50	100		

Supporti - Die Holder - Halter - Mod. 4006/4007 - 931/932/933
Guida - Die Rail - Matrizen Halter - Mod. 300000



MOD.	V1	V2	R1	R2	C1	C2	W	IH
2012	6	10	0,4	0,6	6	10	41	
2013	8	12	0,5	0,8	8	10	43	
2014	16	20	1,6	2,0	12	15	55	

Supporti - Die Holder - Halter
Mod. 4006/4007 - 931/932/933



MOD.	V1	V2	R1	R2	C1	C2	W	HR	TH
502	6	10	0,6	1,0	6,5	8,5	41		
503	8	12	0,8	1,2	7,5	9,5	43		
506	16	25	1,6	2,5	12,0	17,0	55		

Supporti - Die Holder - Halter - Mod. 4006/4007 - 931/932/933
Guida - Die Rail - Matrizen Halter - Mod. 300000

30°

ton/m 30

MOD.	V1	V2	R1	R2	C1	C2	IH
337	8	12	1,0	1,0	14,5	18	

Supporti - Die Holder - Halter
Mod. 4006/4007 - 931/932/933

30°

ton/m 30

MOD.	V1	V2	R1	R2	C1	C2	W	HR	TH
33756	6	10	1,0	1,0	9,0	15,0	50		
33758	8	12	1,0	1,0	14,5	18,0	58,5		

Supporti - Die Holder - Halter - Mod. 4006/4007 - 931/932/933
Guida - Die Rail - Matrizen Halter - Mod. 300000

88°

85°

ton/m 100

MOD.	A	R1	R2	R3	R4	IH
2009	88-85	0,5	0,5	2,0	2,0	
2009.85	85	2,0	2,0	2,0	3,0	

60°

ton/m 100

MOD.	A	R1	R2	R3	R4	IH
2421	60	1,5	2,0	2,5	3,0	

30°

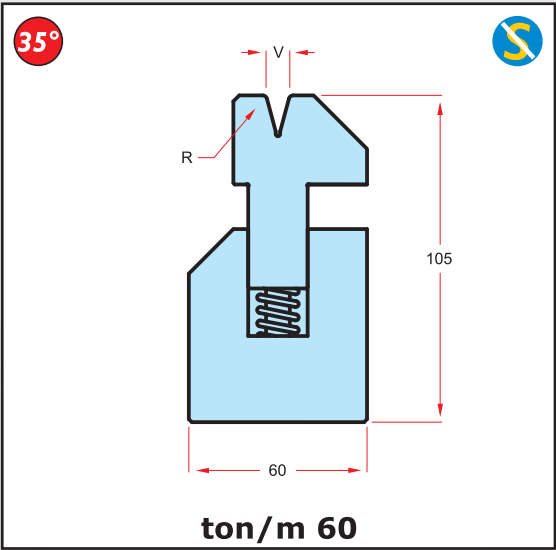
ton/m 80

MOD.	A	R1	R2	R3	IH
2410	30	1,0	1,0	1,0	

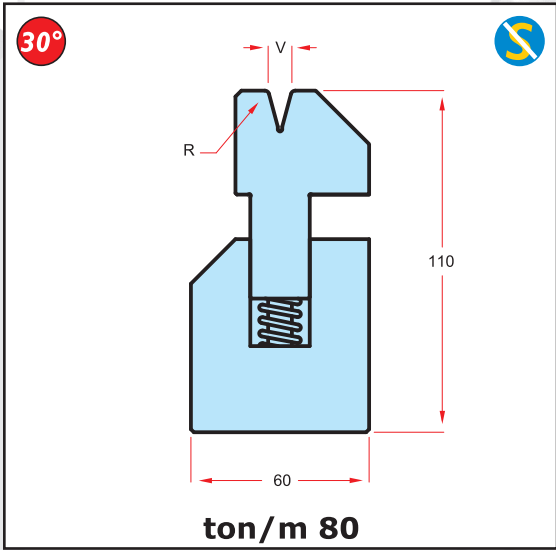
90°

ton/m 100

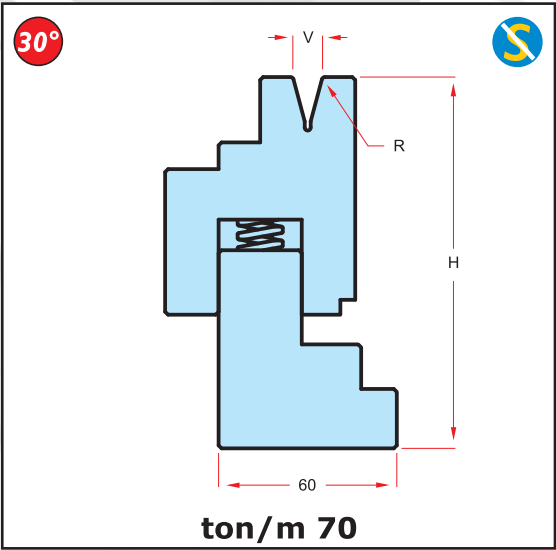
MOD.	A	S1	S2	S3	IH
2008	90	0,5	1,0	1,5	



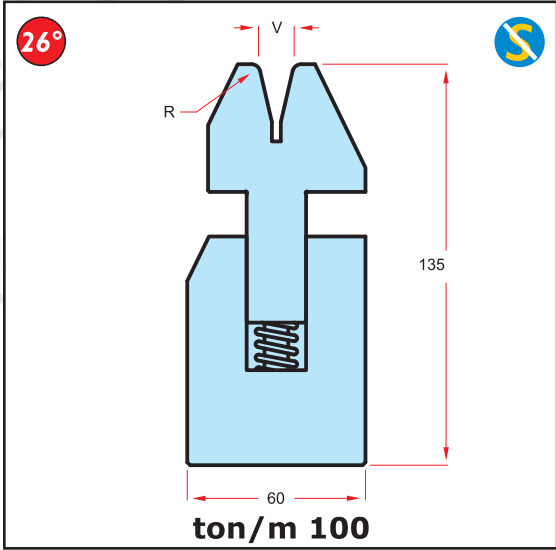
MOD.	V	R	HR
3001P	6	1	
3001P	8	2	



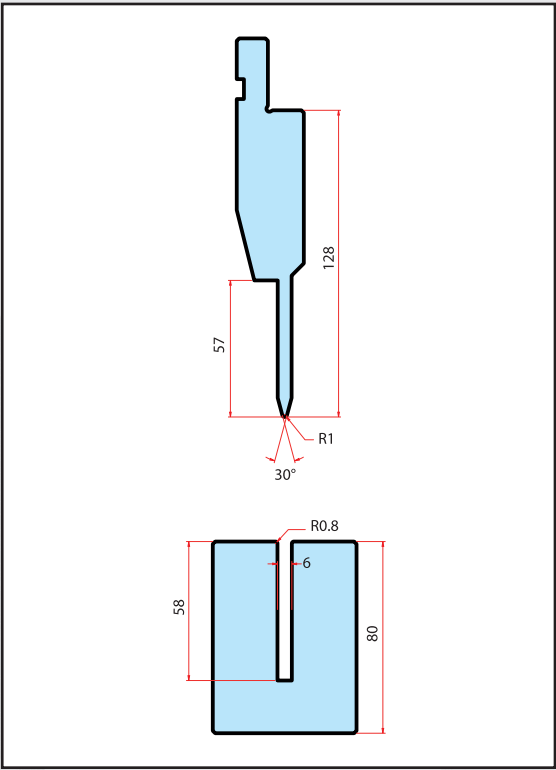
MOD.	V	R	HR
S1050	8	1,5	



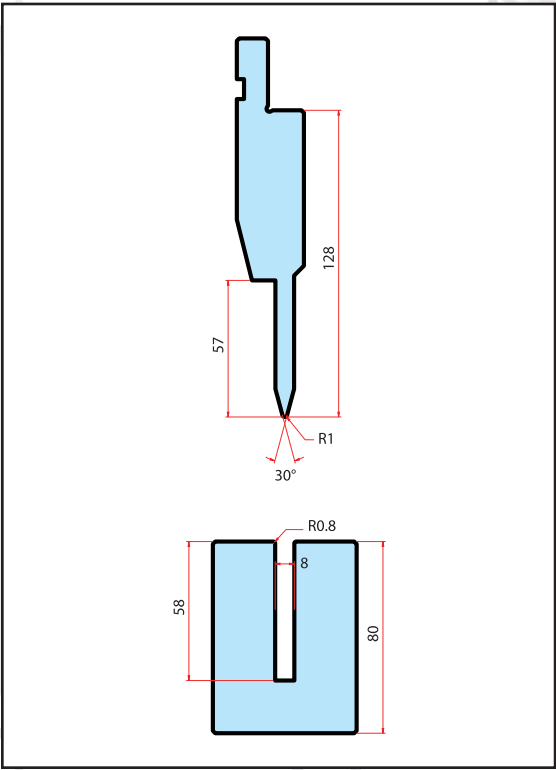
MOD.	V	R	H	HR
10463	6	1	117	
10430	8	1	117	
10412	10	1	135	



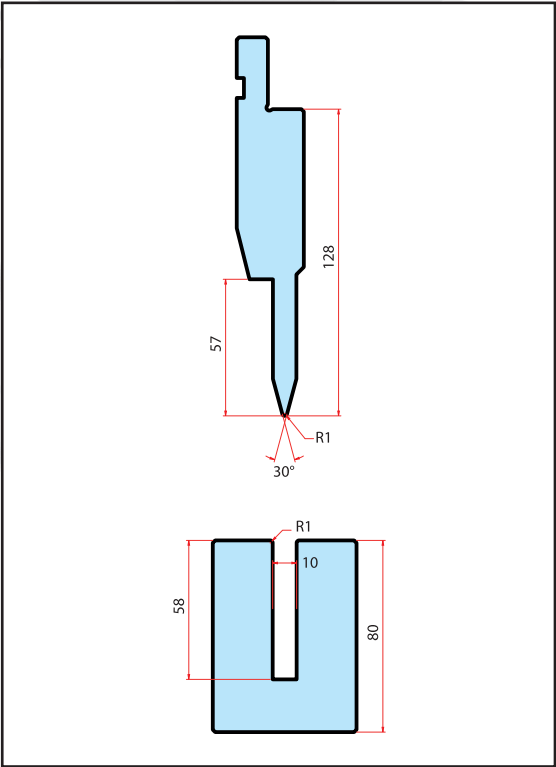
MOD.	V	R	HR
3001B	10	1,5	
3001B	12	3,0	



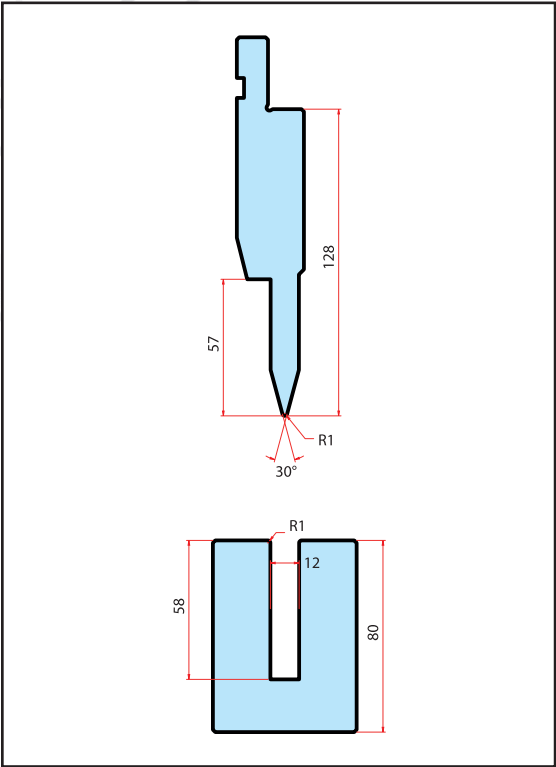
MOD.	V	HR
PV906	6	



MOD.	V	HR
PV908	8	

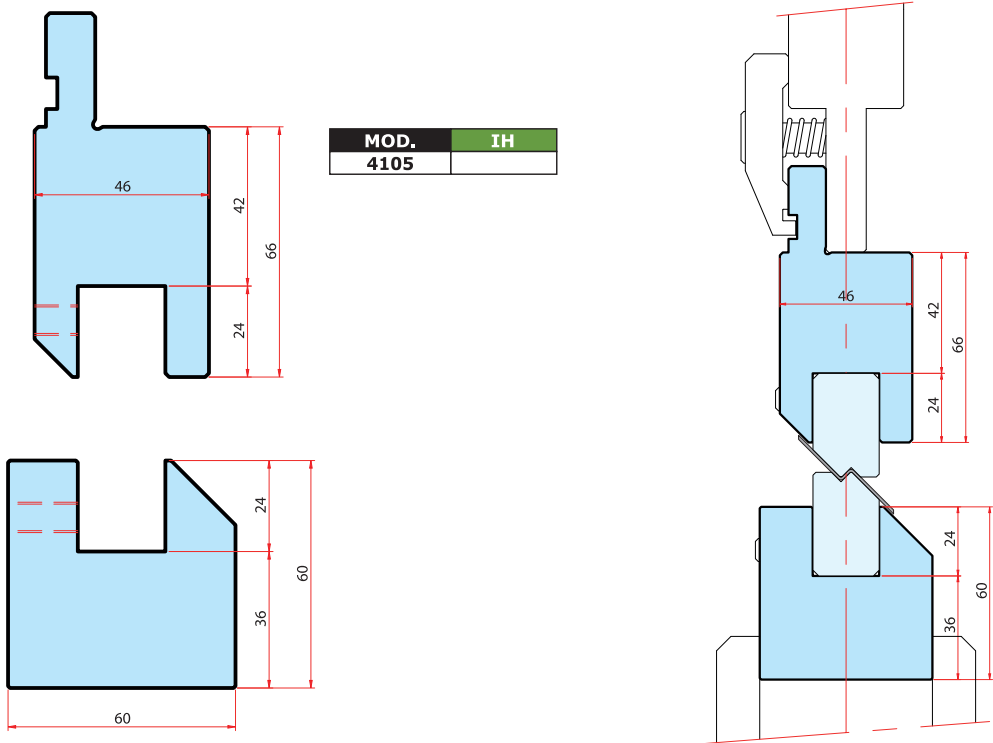


MOD.	V	HR
PV910	10	

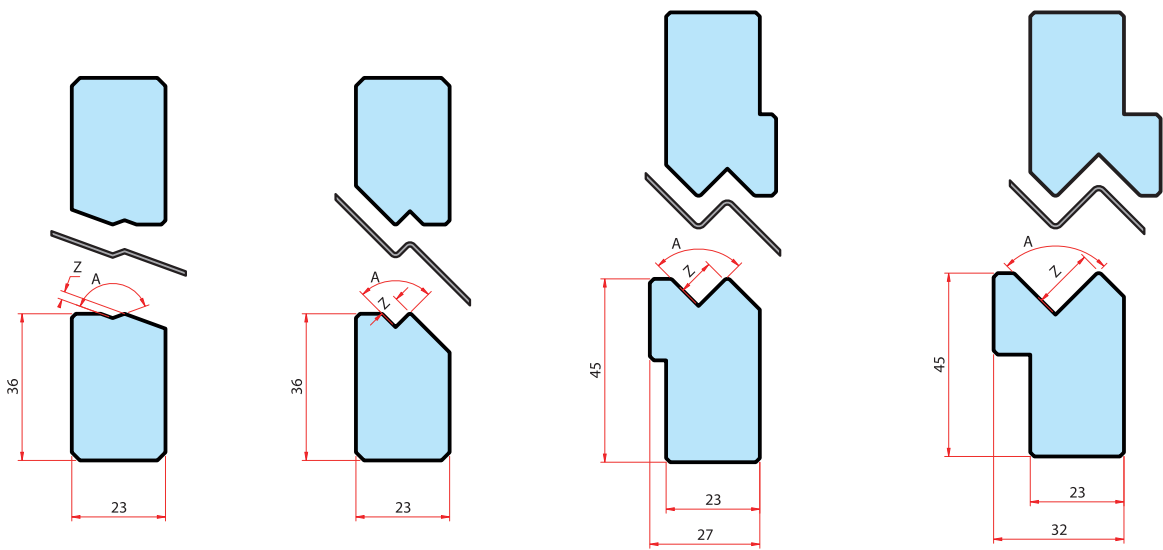


MOD.	V	HR
PV912	12	

supporto - holder



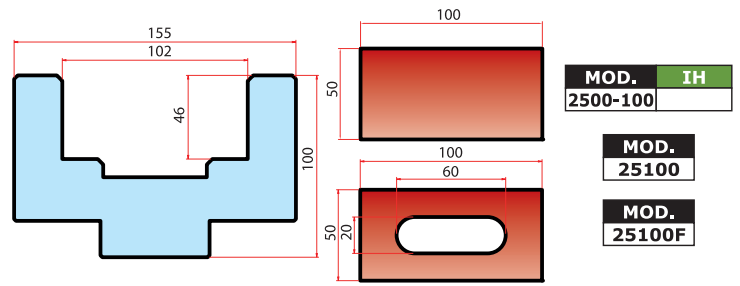
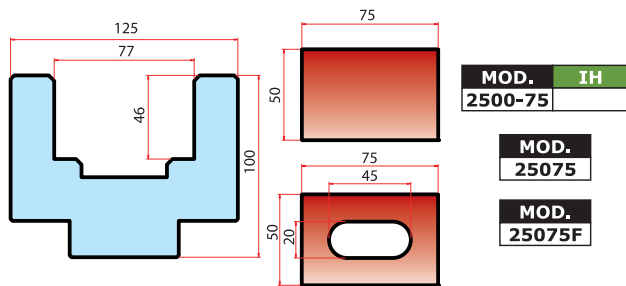
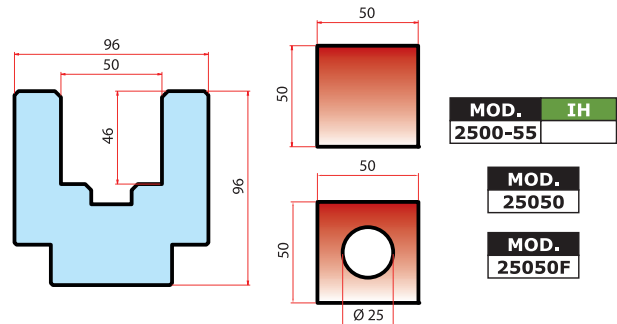
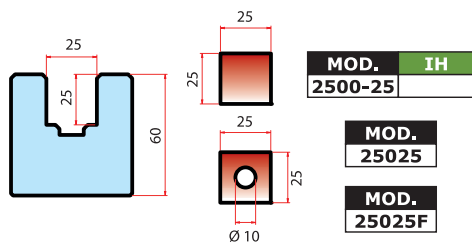
inserti - inserts



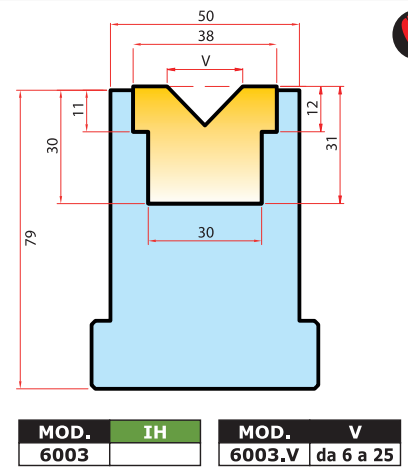
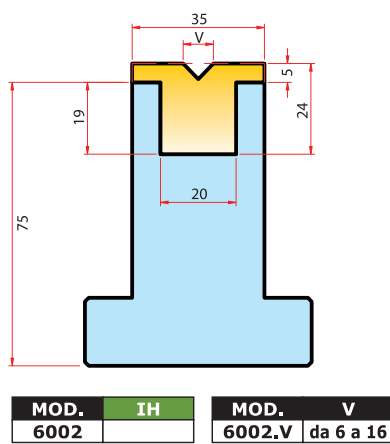
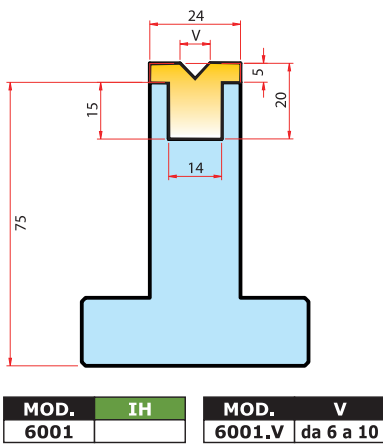
MOD.	Z(mm)	A	IH
42010	1,0	160°	
42015	1,5	160°	
42020	2,0	150°	
42025	2,5	140°	
41010	1,0	90°	
41015	1,5	90°	
41020	2,0	90°	
41025	2,5	90°	
41030	3,0	90°	
41035	3,5	90°	
41040	4,0	90°	
41045	4,5	90°	
41050	5,0	90°	

MOD.	Z(mm)	A	IH
41055	5,5	90°	
41060	6,0	90°	
41065	6,5	90°	
41070	7,0	90°	
41075	7,5	90°	
41080	8,0	90°	
41090	9,0	90°	
41100	10,0	90°	
41110	11,0	90°	
41120	12,0	90°	
41130	13,0	90°	
41140	14,0	90°	
41150	15,0	90°	

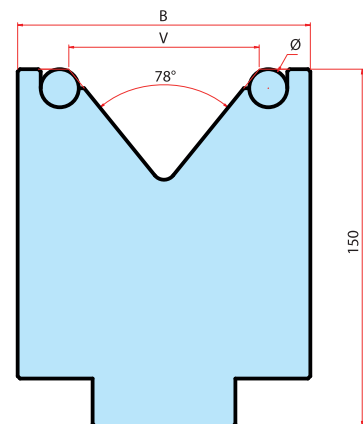
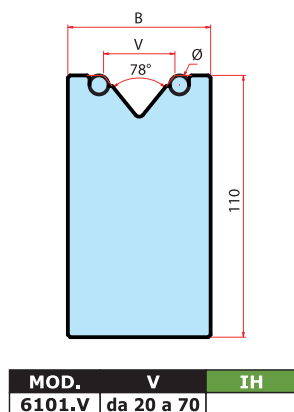
inserti e contenitori in poliuretano - *inserts and polyurethane holders*



inserti e contenitori nylon - *inserts and nylon holders*



matrici con rulli - *dies with rollers*



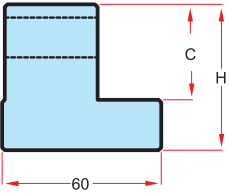


Diagram of a die holder (ton/m 100) showing dimensions: width 60, height H, and depth C.

MOD.	H	C	IH
4006	34	19	
4007	55	34	
931000	39	20	
932000	45	26	
933000	75	56	

L= 830/412 mm

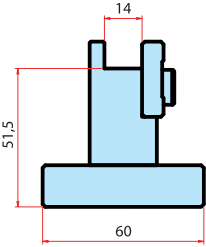


Diagram of a die holder (ton/m 100) showing dimensions: width 60, height 51,5, and depth 14.

MOD.	H	W	HR
8160	51,5	25	

L= 840/420 mm

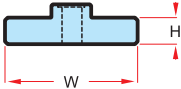


Diagram of a die holder (ton/m 100) showing dimensions: width W, height H, and depth TH.

MOD.	H	W	TH
300000	10	50	

L= 835/415 mm

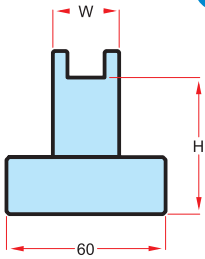


Diagram of a die holder (ton/m 100) showing dimensions: width W, height H, and depth 60.

MOD.	H	W	L	IH
80 REG	51,5	25	1050	
81 REG	51,5	25	1260	

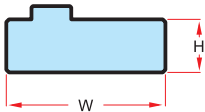


Diagram of a die holder (ton/m 100) showing dimensions: width W, height H, and depth 60.

MOD.	H	W	IH
400000	20	60	

L= 835/415 mm

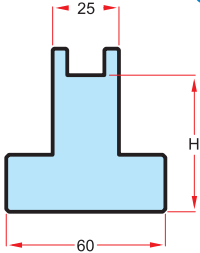


Diagram of a die holder (ton/m 100) showing dimensions: width 25, height H, and depth 60.

MOD.	H	L	IH
80 FIX	51,5	1050	
81 FIX	51,5	1260	
82 FIX	21	1050	
83 FIX	21	1260	

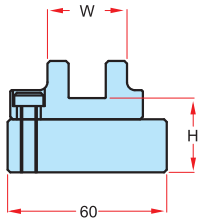


Diagram of a die holder (ton/m 100) showing dimensions: width W, height H, and depth 60.

MOD.	H	W	IH
3030	28	30	

L= 525 mm

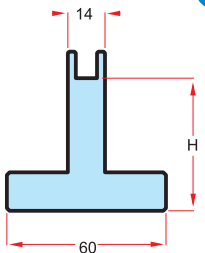
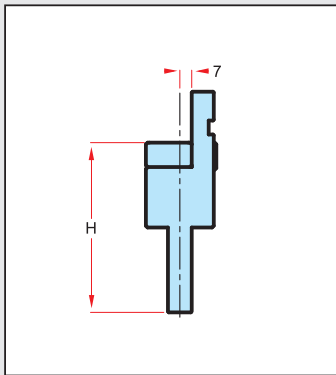


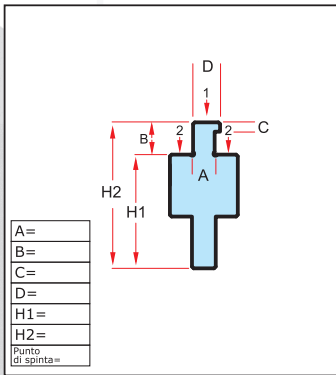
Diagram of a die holder (ton/m 100) showing dimensions: width 14, height H, and depth 60.

MOD.	H	IH
90	30	
91	50	
92	75	

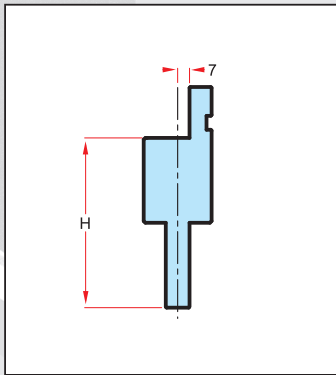
L= 835/1050 mm



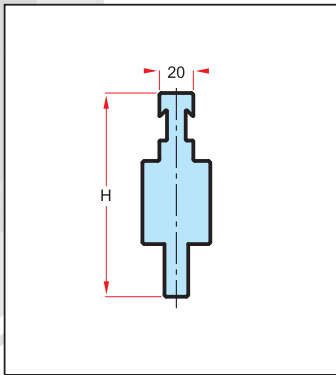
MOD.	H	L	IH
Z1.H100.W	100	150	
Z1.H120.W	120	150	



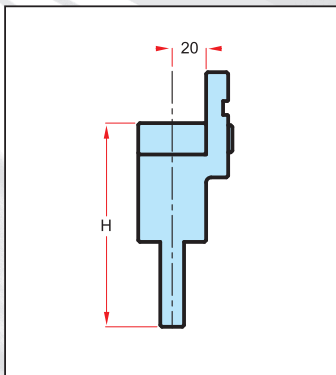
MOD.	L	IH
200.H67.S	150	



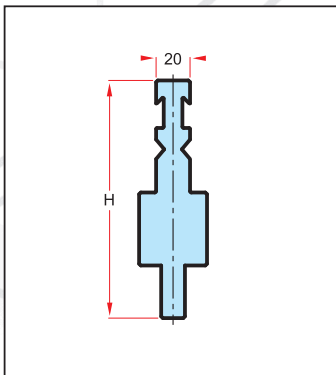
MOD.	H	L	IH
Z1.H100.S	100	150	
Z1.H120.S	120	150	



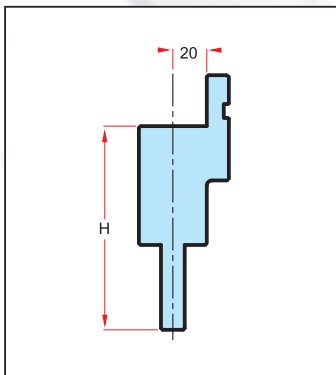
MOD.	H	L	IH
R.2000	120	150	



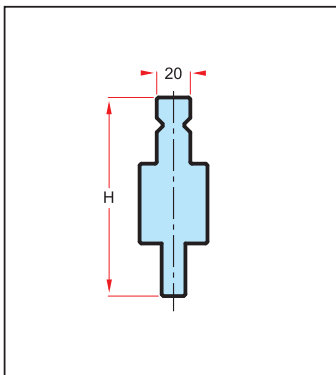
MOD.	H	L	IH
Z2.H120.W	120	150	
Z2.H150.W	150	150	



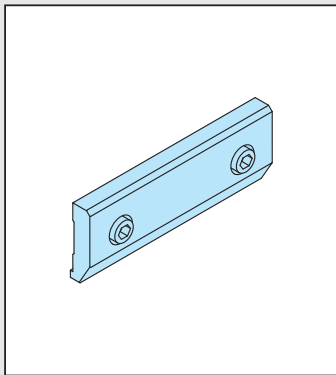
MOD.	H	L	IH
RFA.2000	140	150	



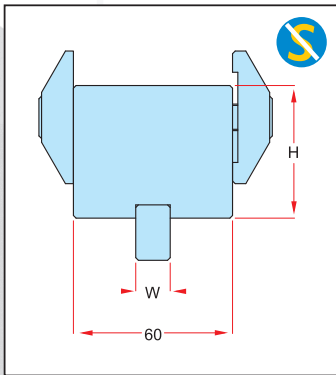
MOD.	H	L	IH
Z2.H120.S	120	150	
Z2.H150.S	150	150	



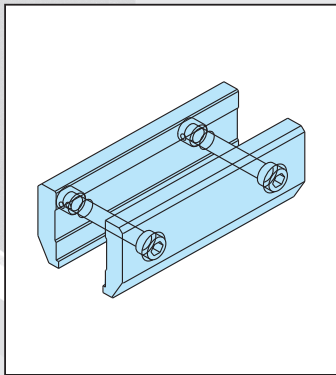
MOD.	H	L	IH
TRU.2000	117	150	



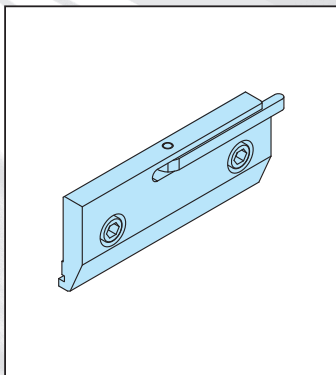
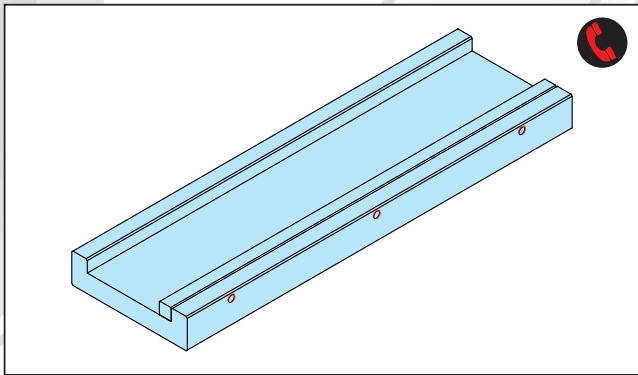
MOD.	L	IH
CL.2000.SS	150	



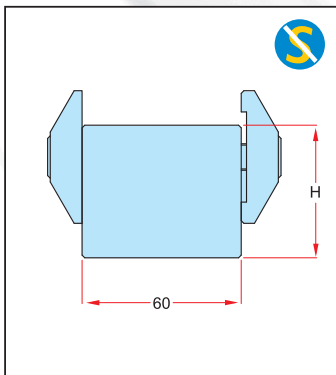
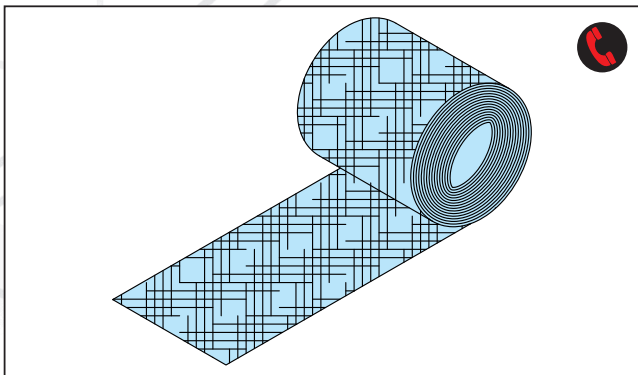
MOD.	H	W	IH
TRBEDB.3040	50	13	
AMEDB.3045	50	12,7	



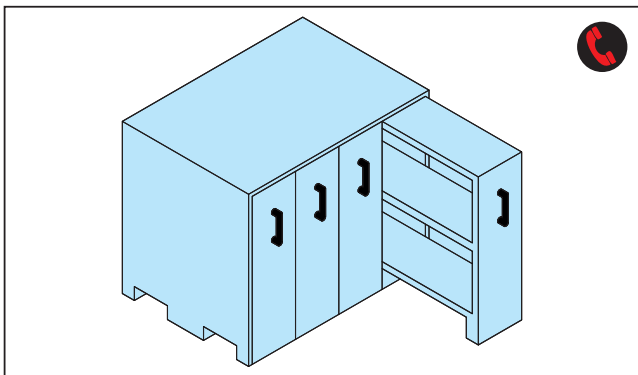
MOD.	L	IH
CL.2000.SD	150	



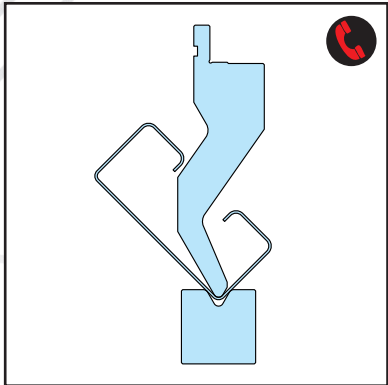
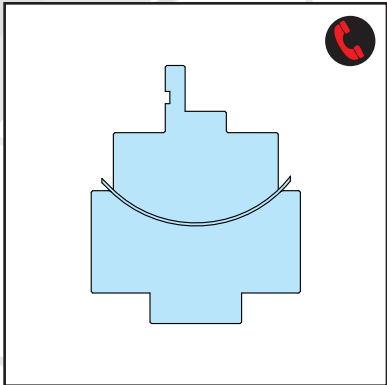
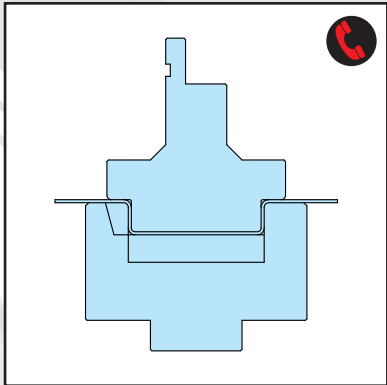
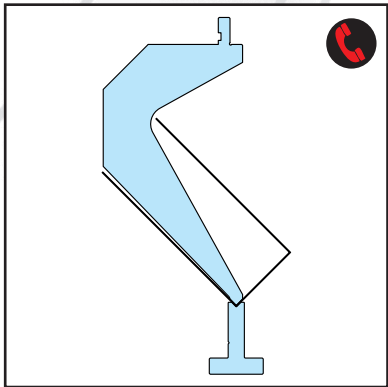
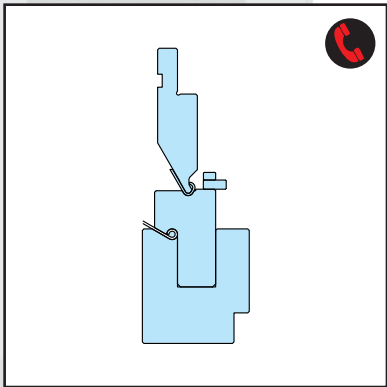
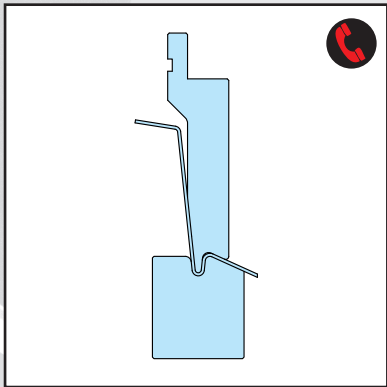
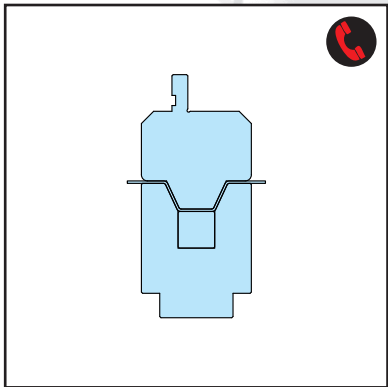
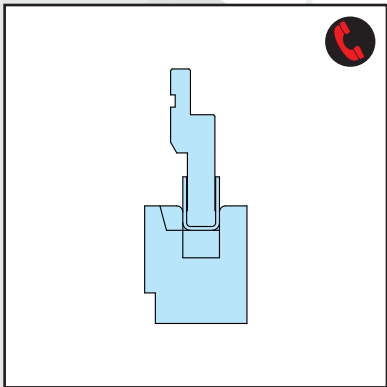
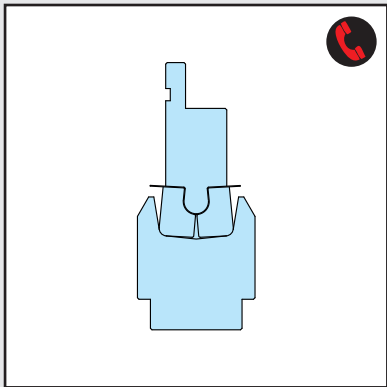
MOD.	L	IH
CL.2000.QR	150	



MOD.	H	IH
PRAMDB.3040	50	
PRAMDB.4055	55	



Stampi Speciali - Special Tools - Spezielle Einsätze



Lame da cesoia - Shear blades - Spezielle Einsätze - Schermesser

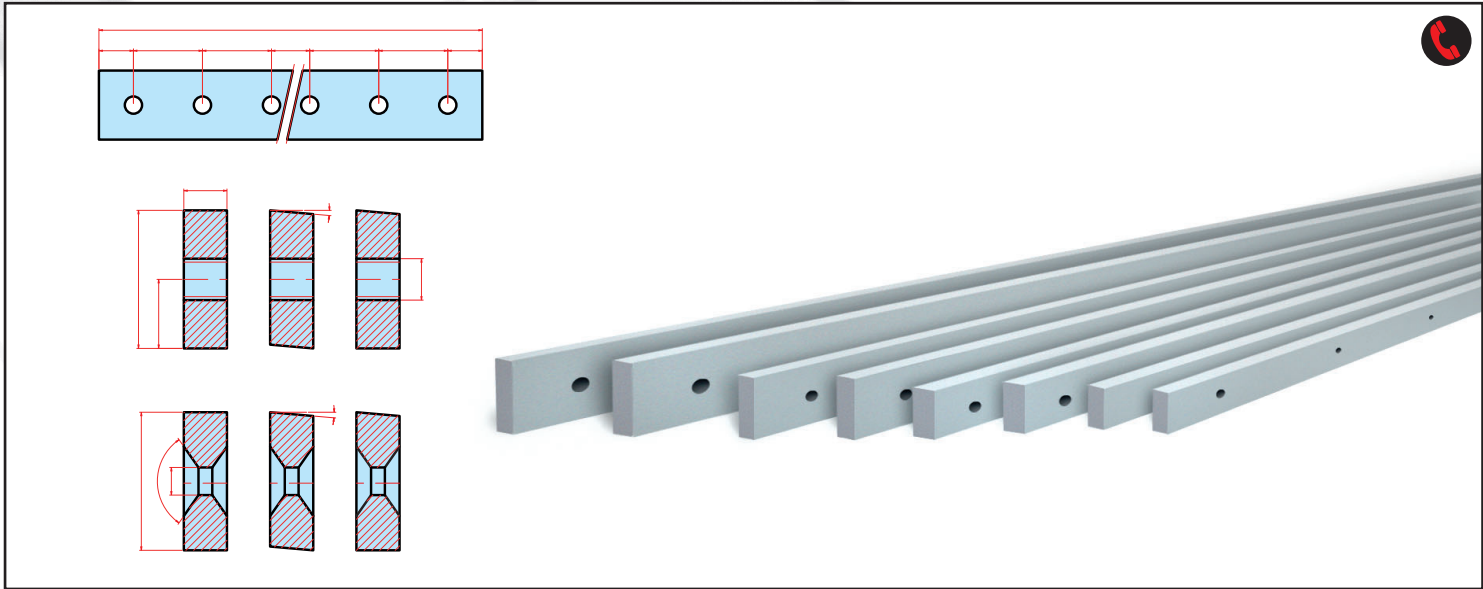


TABELLA DI PIEGATURA IN ARIA

AIR BENDING FORCE CHART

PRESSKRAFTTABELLE

S	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	320	400	500	630	V
Spessore mm	4	5,5	7	8,5	11	14	17,5	22	28	35	45	55	71	89	113	140	175	226	280	350	450	B
	1	1,3	1,6	2	2,6	3,3	4	5	6,5	8	10	13	16	20	26	33	41	53	65	83	100	Ri
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												120	96	78	60							
15													150	120	95	75						
20														215	170	135	108	85				
25															265	210	170	130	105			
30																300	240	190	150	120		
40																	430	340	270	215		
50																		525	420	340	270	t/m

La tabella di piegatura qui sopra raffigurata e basata su acciaio medio con resistenza di 45-50 chilogrammi per millimetro quadrato. Per calcolare la forza approssimativa di piegatura richiesta per piegare altri tipi di materiale utilizzare il fattore di moltiplicazione qui sotto indicato. I valori indicati nelle tabelle sono validi per pieghe a 90°. In caso di pieghe a 30°, la capacità di Massimo carico si riduce.

The bending force (tonnage) figures listed above are based on mild steel with a tensile strength of 45/50 kilograms per square millimeter. To calculate the approximate bending force (tonnage) requirements of others materials, please use the multipliers listed. The mentioned values are valid for 90° bending. At coining with 30° degree, the max loading capacity is reduced.

Die oben angegebene Abkantkraft (Ton.) gilt für Normalstahl mit einer Zugfestigkeit von 45-50 kg/mm². Um die entsprechende Abkantkraft für andere Materialien zu berechnen, benutzen Sie bitte die angegebenen Multiplikatoren. Die angegebenen Werte sind das Biegen für 90° gültig. Beim Prägen mit 30° Matrizen ist die max. Belastbarkeit reduziert.

Formula Standard per selezionare l'apertura del "V"
Standard formulas as for selecting a V-opening
Standardformel zur festlegung der V-Öffnung

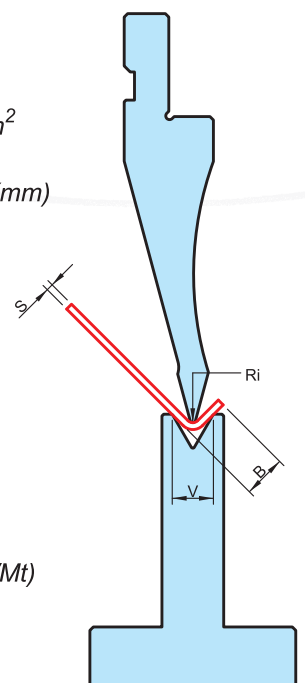
Spessore materiale (mm) Material thickness (mm) Blechdicke (mm)	0.5 - 2.5	3.0 - 8	9 - 10	12 - 30
Larghezza V V - opening V- Öffnung	S x 6	S x 8	S x 10	S x 12

Ottone dolce Soft Brass Weiches Messing	Ton x mt x 50%
Alluminio dolce Soft Aluminium Weiches Aluminium	Ton x mt x 50%
Lega di Alluminio trattato Heat Treated Aluminium Alloy Wärmebehandelte Alminiumlegierung	Ton x mt x 150%
Acciaio Inox Stainless Stell Rostfreier Stahl	Ton x mt x 150%

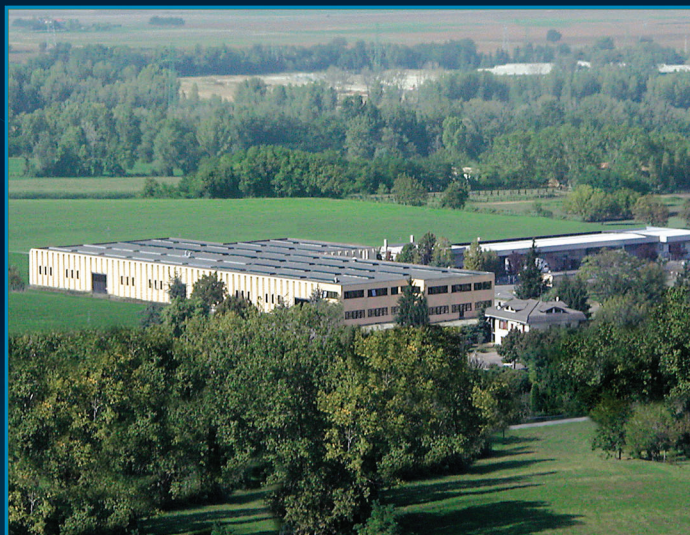
S = Spessore del materiale 45Kg/m²
F = Forza per 1 metro (Ton/Mt)
Ri= Raggio interno di piegatura (mm)
B = Lunghezza bordo minimo (mm)
V = Larghezza del V (mm)

S = Material thickness (45Kg/m²)
F = Force per meter (Ton/Mt)
Ri= Inside Radius (mm)
B = Minimun Hang lenght (mm)
V = V - Opening (mm)

S = Blechdicke in mm:
Zugfestigkeit ca. 45Kg/m²
F = Enforderilche Press Kraft (Ton/Mt)
Ri= Produktinnenradius (mm)
B = Kürzeste Schenkellänge (mm)
V = V - Öffnung (mm)



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