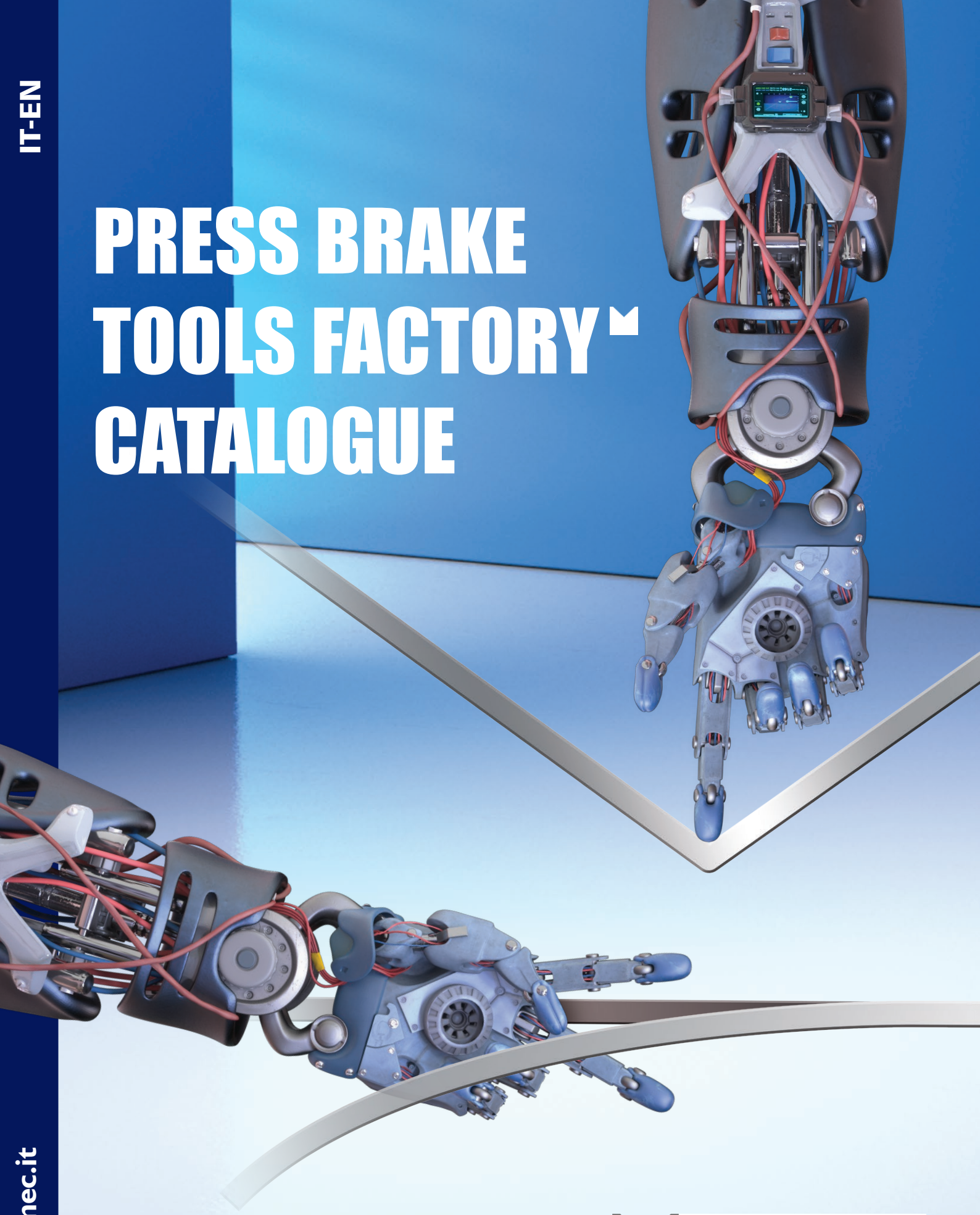
IT-EN

PRESS BRAKE TOOLS FACTORY CATALOGUE



GIMEC®
PRESS BRAKE TOOLS FACTORY

2025 rel.2

SINCE 1986

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since 1986

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Dal 1986 Gimec è tra le aziende più qualificate nella costruzione di utensili ed attrezzature per la lavorazione della lamiera.
In particolare siamo specializzati nella fornitura di utensili per presse piegatrici e lame per cesoia.
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Since 1986 Gimec is among the leading companies in the manufacturing of tools and equipment for sheet metal working.
In particular, we are specialized in providing tools for press brake and shear blades.
The methodical analysis of all materials used, the careful monitoring of the product during the various stages of production and continued innovative research, help us to increase the high technological level reached in this area.
We are a compact and agile company, which daily works with passion and enthusiasm, characteristics that have always distinguished us in the market.
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NON ESITARE A CONTATTARCI - PROFESSIONALITA' E COMPETENZA SONO I NOSTRI PUNTI DI FORZA
DON'T HESITATE TO CONTACT US PROFESSIONALISM AND COMPETENCE ARE OUR STRENGTH POINTS



UTENSILI SUPERIORI - UPPER TOOLS

tipo **Europa**® style	pag. 04	**serie US®**
tipo **Japan**® style	pag. 32	**serie USJ®**
tipo **Trumpf** ® style	pag. 34	**serie UST®**
tipo **Wila**® style	pag. 40	**serie USW®**
tipo **Beyeler Bystronic**® style	pag. 46	**serie USB®**
tipo **LVD**® style	pag. 50	**serie USL®**
tipo **HACO**® style	pag. 54	**serie USH®**
tipo **COLGAR**® style	pag. 55	**serie USC®**

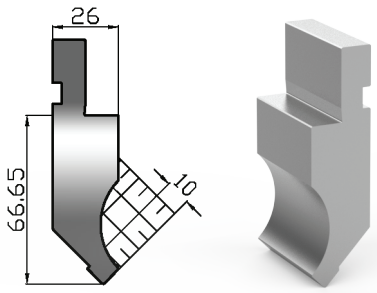
UTENSILI INFERIORI - LOWER TOOLS

tipo **Europa**® style	pag. 20	**serie 60®**
tipo **Japan**® style	pag. 33	**serie USJ®**
tipo **Trumpf**® style	pag. 39	**serie 13 UST®**
tipo **Wila**® style	pag. 44	**serie USW®**
tipo **Beyeler Bystronic**® style	pag. 49	**serie 13 USB®**
tipo **LVD**® style	pag. 52	**serie 12,7 USL®**
tipo **HACO**® style	pag. 54	**serie USH®**
tipo **ROLLA-V**® style	pag. 56	**serie ROLLA-V®**

UTENSILI - TOOLS

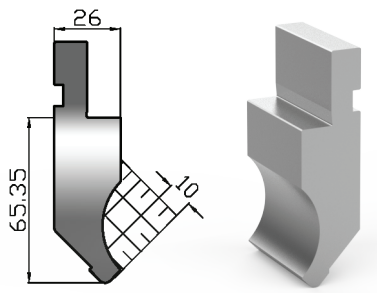
STAMPI PER PRESSE PIEGATRICI - PRESS BRAKE TOOLS	pag. 62	**STAMPI**
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LAME PER CESOIA - SHEAR BLADES	pag. 84	**LAME**
ATTREZZATURE - FIXTURES	pag. 86	**ATTREZZATURE**

US 110/88° R0,8



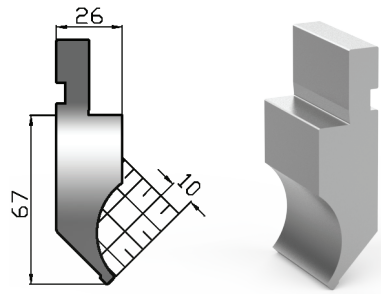
altezza height mm	angolo degree	raggio radius mm	max kN/mt
66,65	88°	0,8	1000

US 110/88° R3,0



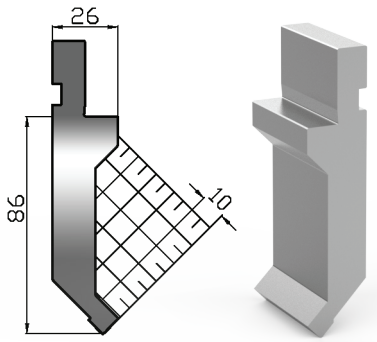
altezza height mm	angolo degree	raggio radius mm	max kN/mt
65,35	88°	3,0	1000

US 126/88° R0,6



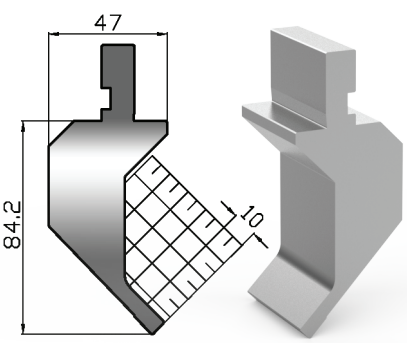
altezza height mm	angolo degree	raggio radius mm	max kN/mt
67,0	88°	0,6	350

US 125/88° R0,8



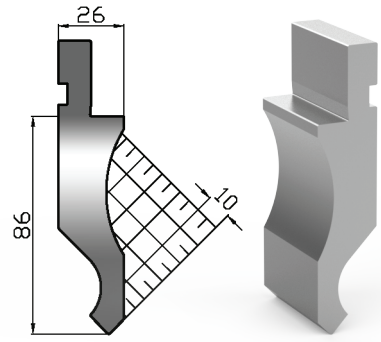
altezza height mm	angolo degree	raggio radius mm	max kN/mt
86,0	88°	0,8	500

US 117/88° R0,6



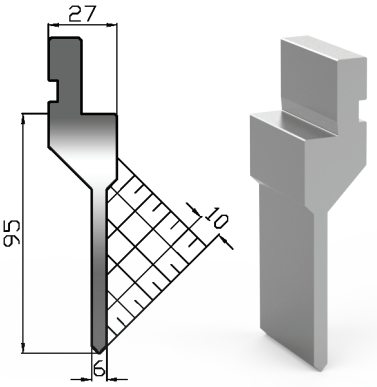
altezza height mm	angolo degree	raggio radius mm	max kN/mt
84,2	88°	0,6	300

US 120/88° R0,8



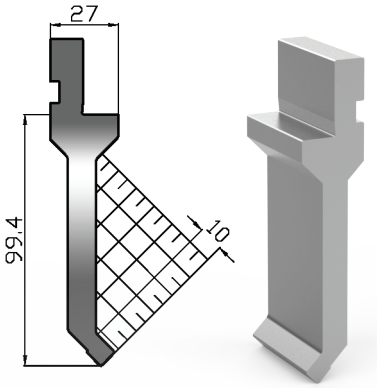
altezza height mm	angolo degree	raggio radius mm	max kN/mt
86,0	88°	0,8	1000

US 147/88° R0,25



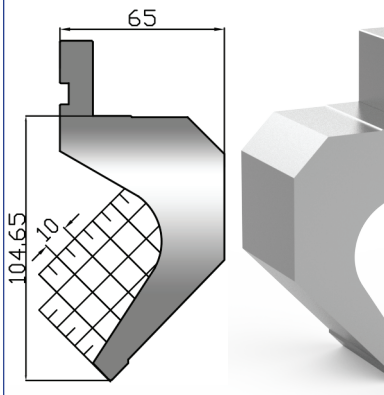
altezza height mm	angolo degree	raggio radius mm	max kN/mt
95,0	88°	0,25	500

US 143/88° R0,6



altezza height mm	angolo degree	raggio radius mm	max kN/mt
99,4	88°	0,6	500

US 158/88° R0,8

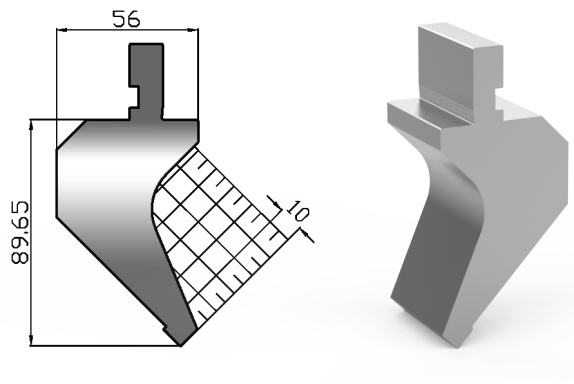


altezza height mm	angolo degree	raggio radius mm	max kN/mt
104,65	88°	0,8	450

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (9 pz/pcs) — acciaio - steel

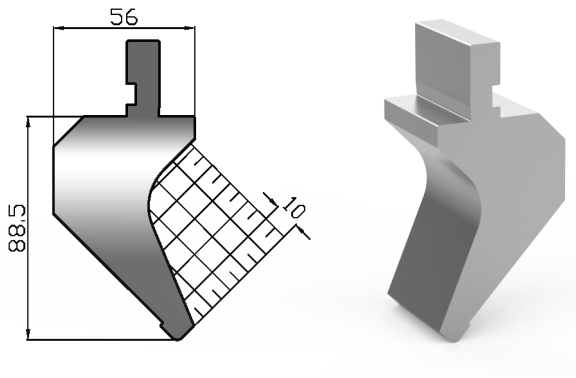
835								415	C45 T HRC 52÷58
10	15	20	40	50	100	100 L	100 R	370	42CrMo4 T HRC 52÷58

US 114/88° R0,8



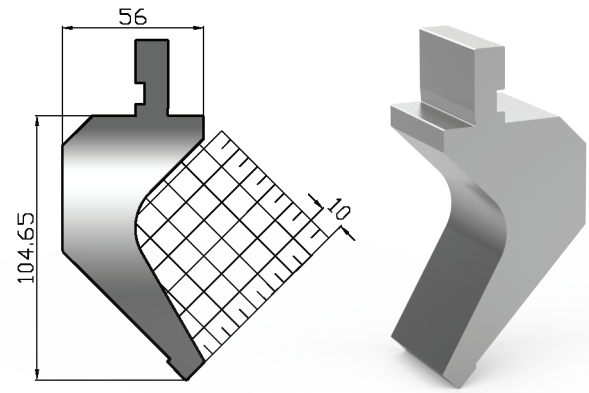
altezza height mm	angolo degree	raggio radius mm	max kN/mt
89,65	88°	0,8	600

US 114/88° R3,0



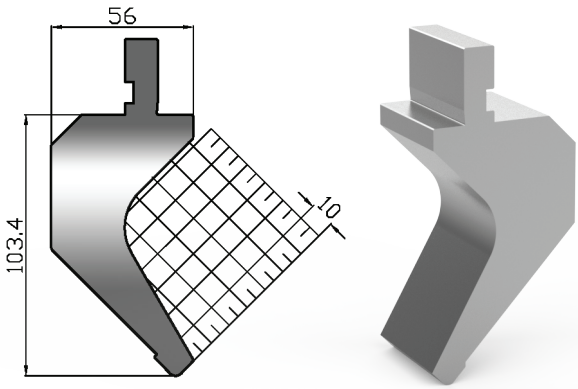
altezza height mm	angolo degree	raggio radius mm	max kN/mt
88,5	88°	3,0	600

US 115/88° R0,8



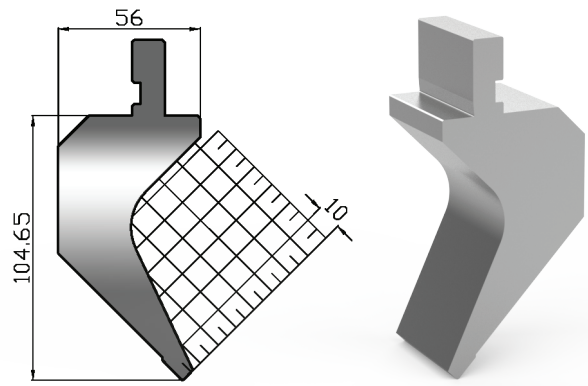
altezza height mm	angolo degree	raggio radius mm	max kN/mt
104,65	88°	0,8	500

US 115/88° R3,0



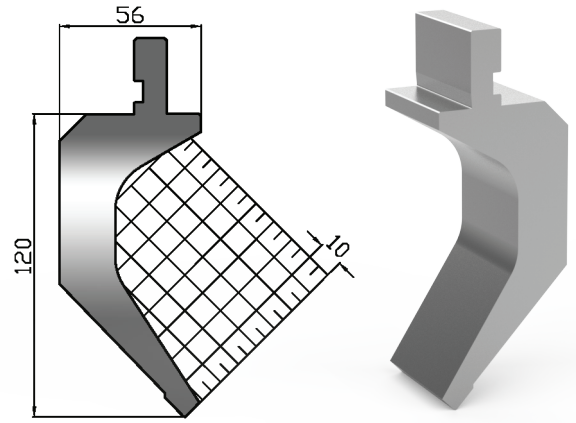
altezza height mm	angolo degree	raggio radius mm	max kN/mt
103,4	88°	3,0	500

US 144/88° R0,8



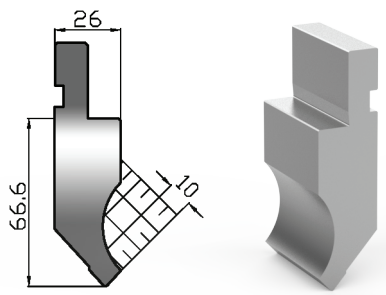
altezza height mm	angolo degree	raggio radius mm	max kN/mt
104,65	88°	0,8	450

US 152/88° R0,8



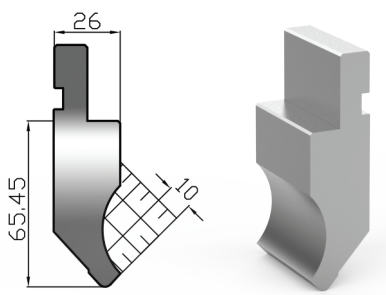
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	88°	0,8	500

US 110/85° R0,8



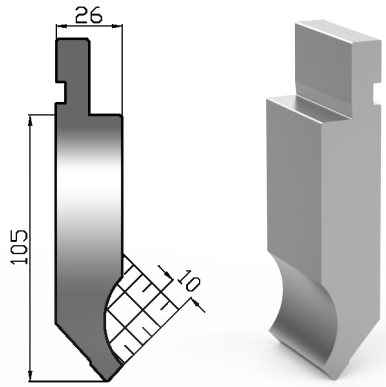
altezza height mm	angolo degree	raggio radius mm	max kN/mt
66,6	85°	0,8	1000

US 110/85° R3,0



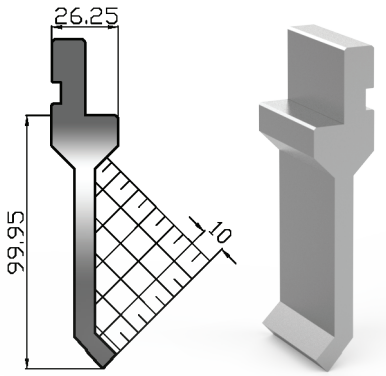
altezza height mm	angolo degree	raggio radius mm	max kN/mt
65,45	85°	3,0	1000

US 110/85° R0,8 h105



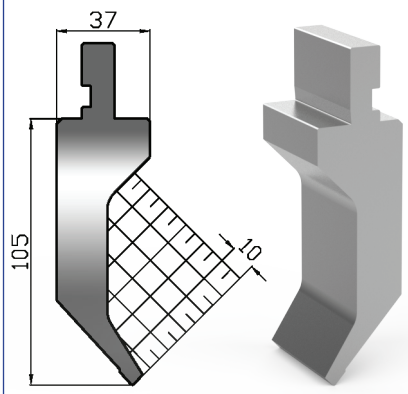
altezza height mm	angolo degree	raggio radius mm	max kN/mt
105	85°	0,8	1000

US 143/85° R0,25



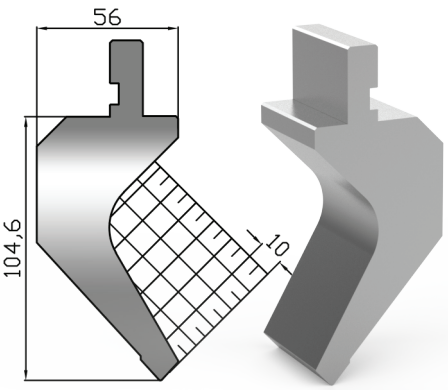
altezza height mm	angolo degree	raggio radius mm	max kN/mt
99,95	85°	0,25	350

US 142/85° R0,8



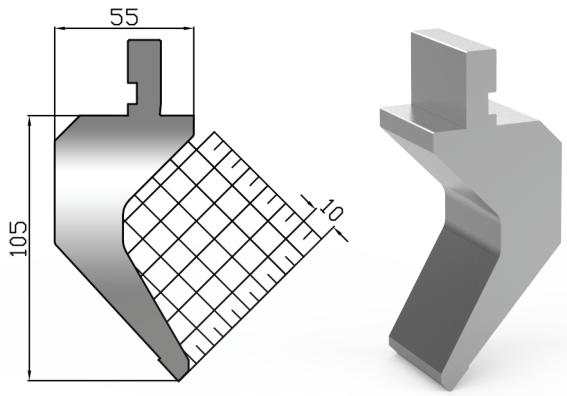
altezza height mm	angolo degree	raggio radius mm	max kN/mt
105,0	85°	0,8	600

US 115/85° R0,8



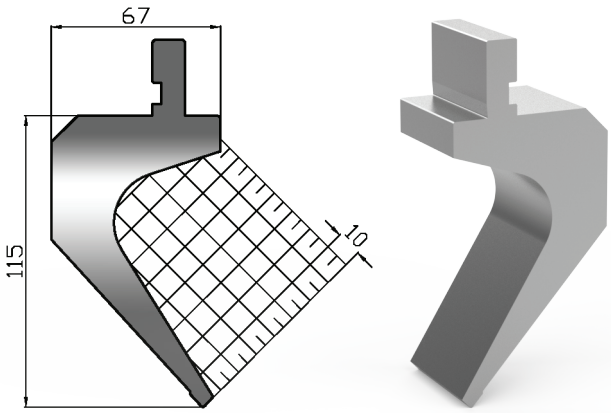
altezza height mm	angolo degree	raggio radius mm	max kN/mt
104,6	85°	0,8	500

US 129/85° R0,8



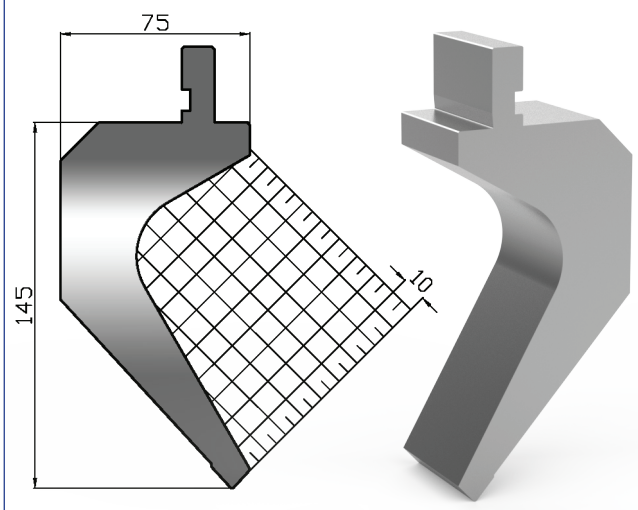
altezza height mm	angolo degree	raggio radius mm	max kN/mt
105,0	85°	0,8	1000

US 141/85° R0,8



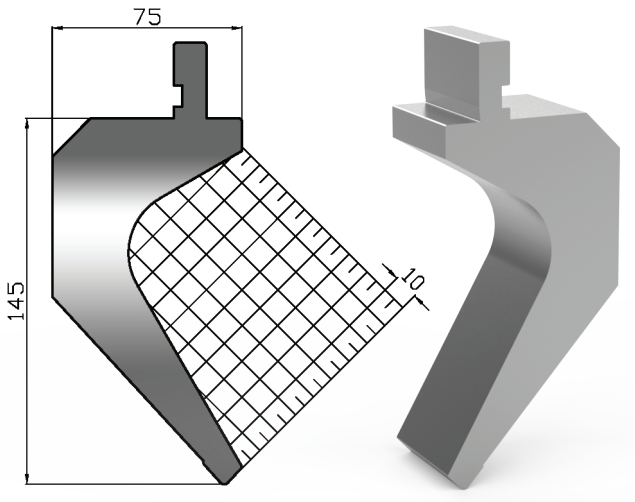
altezza height mm	angolo degree	raggio radius mm	max kN/mt
115,0	85°	0,8	700

US 127/85° R0,8



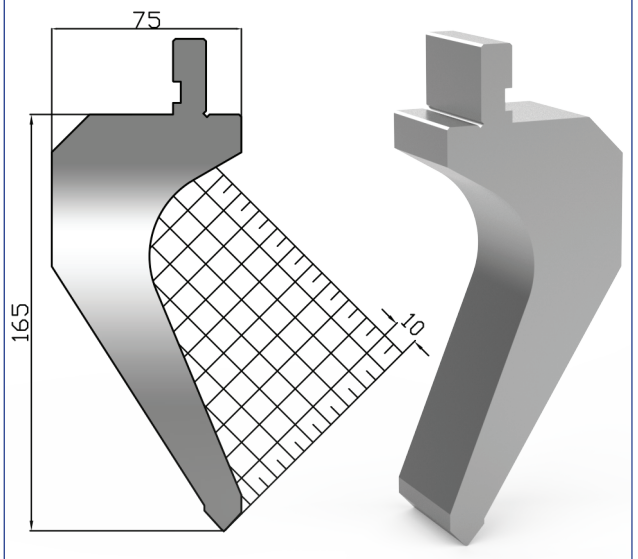
altezza height mm	angolo degree	raggio radius mm	max kN/mt
145,0	85°	0,8	500

US 145/85° R2,0



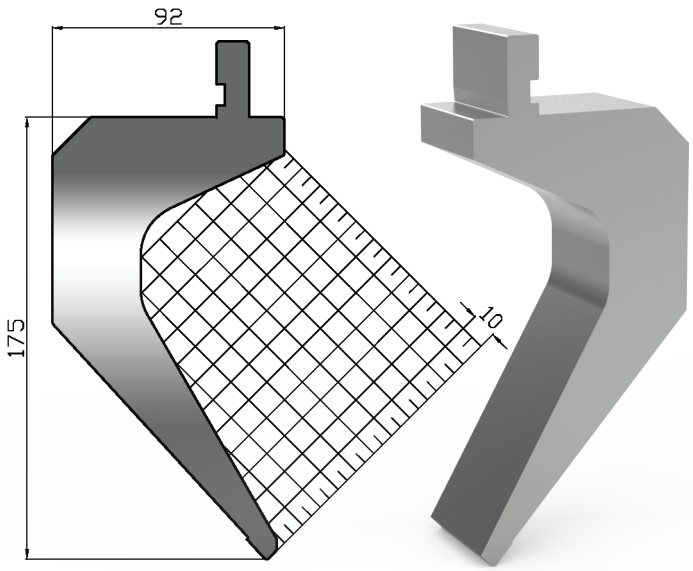
altezza height mm	angolo degree	raggio radius mm	max kN/mt
145,0	85°	2,0	900

US 162/85° R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
165,0	85°	0,8	600

US 146/85° R1,25

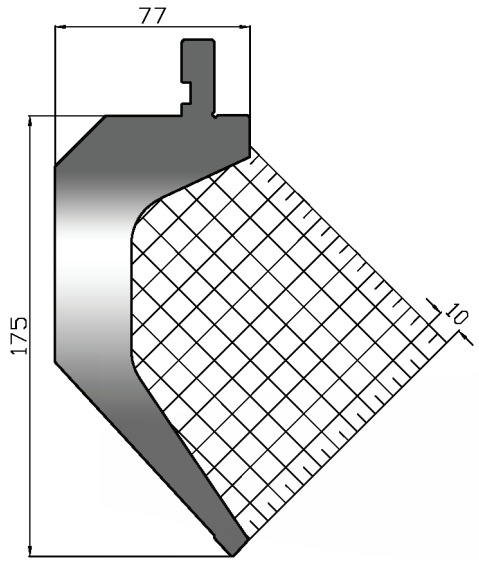


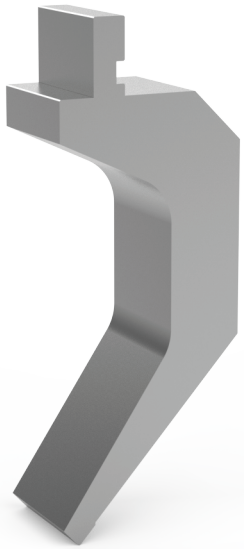
altezza height mm	angolo degree	raggio radius mm	max kN/mt
175,0	85°	1,25	900

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (9 pz/pcs) — acciaio - steel

835								415	C45 T HRC 52÷58
10	15	20	40	50	100	100 L	100 R	370	42CrMo4 T HRC 52÷58

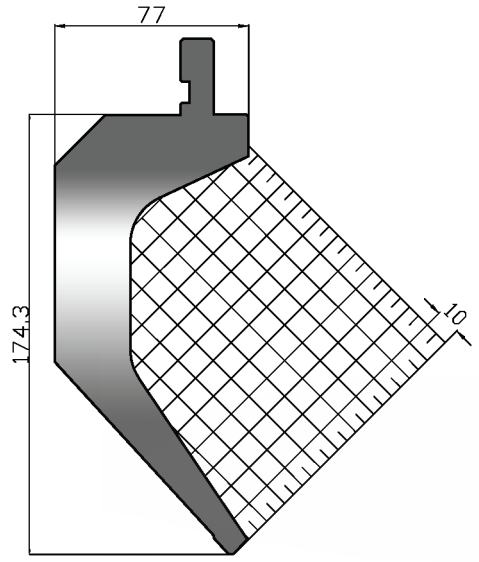
US 175/85° R0,8

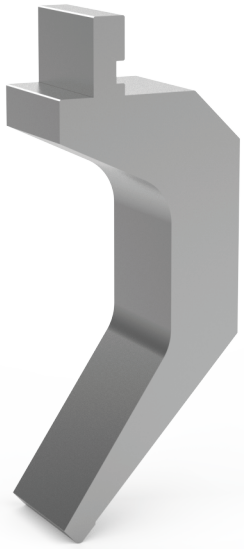




altezza height mm	angolo degree	raggio radius mm	max kN/mt
175,0	85°	0,8	700

US 175/85° R2,0





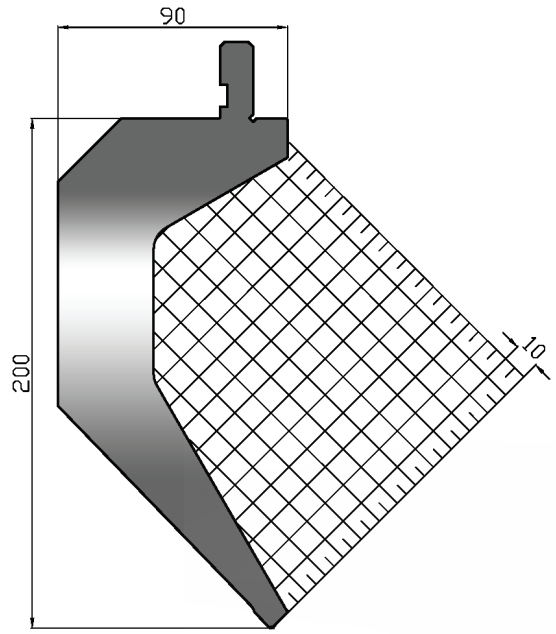
altezza height mm	angolo degree	raggio radius mm	max kN/mt
174,3	85°	2,0	700

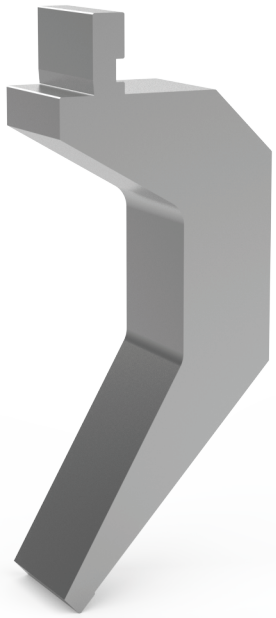
lunghezze - lengths mm 525 - fraz/sect A 495 (8 pz/pcs) - fraz/sect B 500 (3 pz/pcs) — acciaio - steel

	525		B	100 L	300	100 R		
A	25	30	35	40	45	50	100	170

42CrMo4 T HRC 52÷58

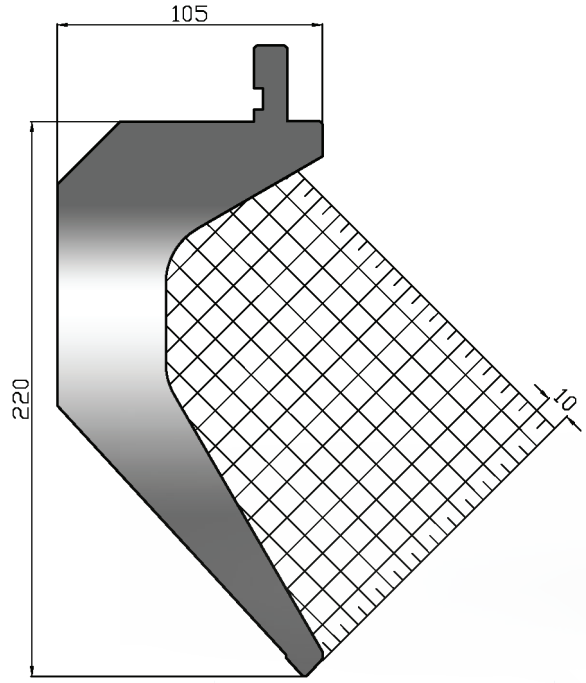
US 153/85° R0,8





altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	85°	0,8	850

US 156/85° R1,5





altezza height mm	angolo degree	raggio radius mm	max kN/mt
220,0	85°	1,5	850

lunghezze - lengths mm 415 - fraz/sect 805 (9 pz/pcs)

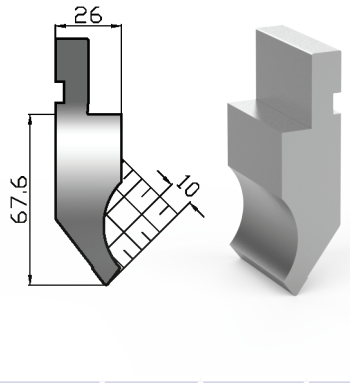
acciaio - steel

10	15	20	40	50	100	100 L	100 R	370

415

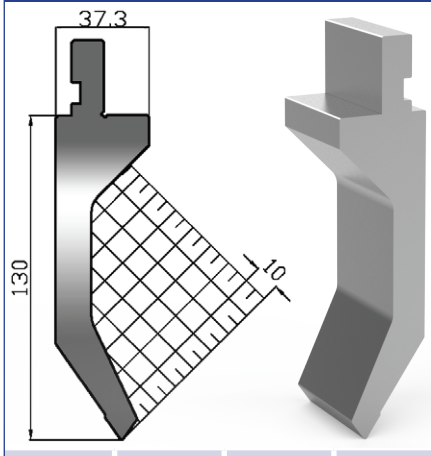
42CrMo4 T HRC 52÷58

US 110/75° R0,8



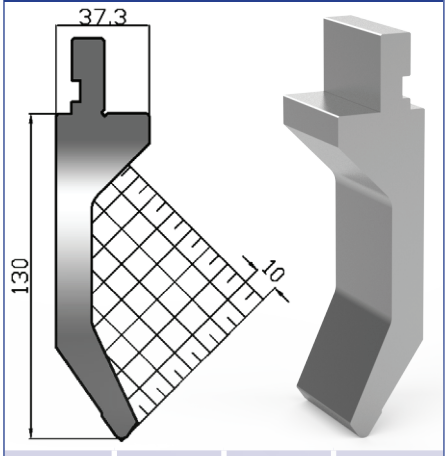
altezza height mm	angolo degree	raggio radius mm	max kN/mt
67,6	75°	0,8	1000

US 170/70° R0,8



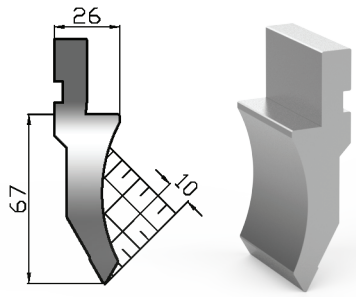
altezza height mm	angolo degree	raggio radius mm	max kN/mt
130,0	70°	0,8	450

US 170/70° R3,0



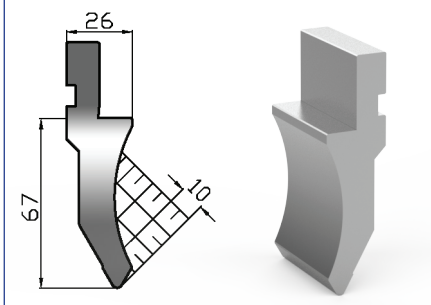
altezza height mm	angolo degree	raggio radius mm	max kN/mt
130,0	70°	3,0	450

US 124/60° R0,8



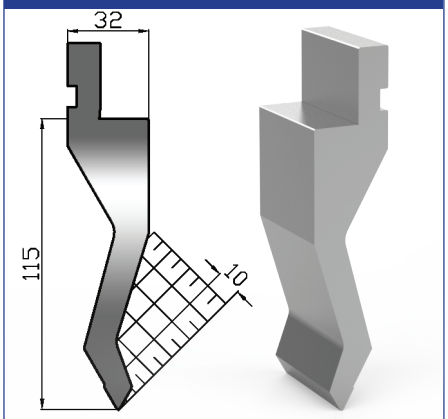
altezza height mm	angolo degree	raggio radius mm	max kN/mt
67,0	60°	0,8	800

US 124/60° R2,0



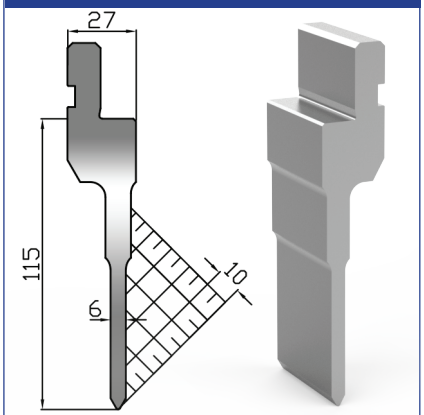
altezza height mm	angolo degree	raggio radius mm	max kN/mt
67,0	60°	2,0	800

US 134/60° R0,8



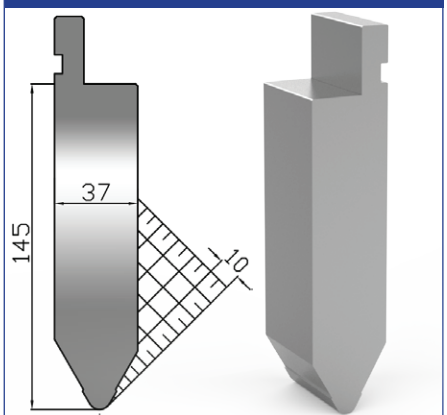
altezza height mm	angolo degree	raggio radius mm	max kN/mt
115,0	60°	0,8	700

US 151/60° R0,8



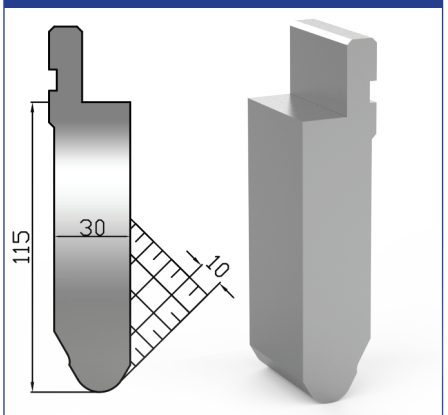
altezza height mm	angolo degree	raggio radius mm	max kN/mt
115,0	60°	0,8	500

US 155/60° R5,0



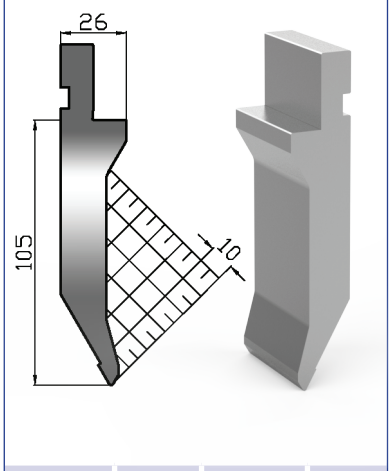
altezza height mm	angolo degree	raggio radius mm	max kN/mt
145,0	60°	5,0	1600

US 155/60° R10,0



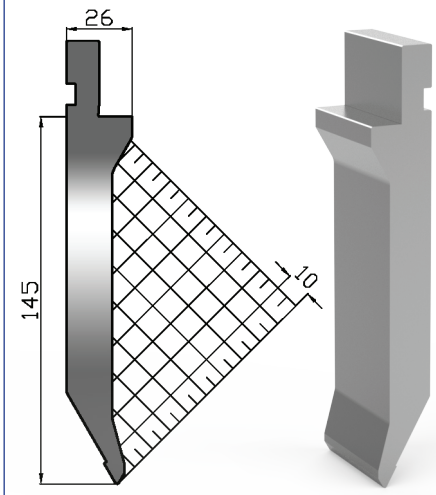
altezza height mm	angolo degree	raggio radius mm	max kN/mt
115,0	60°	10,0	1500

US 128/60° R0,8



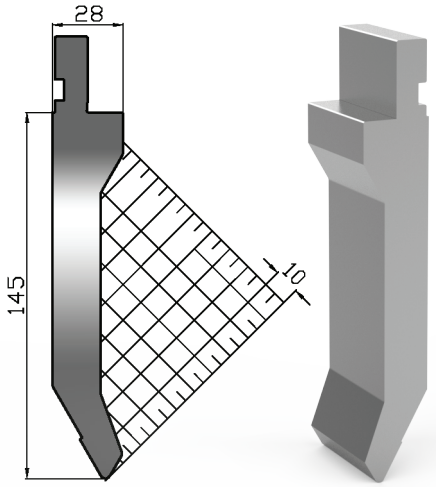
altezza height mm	angolo degree	raggio radius mm	max kN/mt
105,0	60°	0,8	800

US 135/60° R0,8



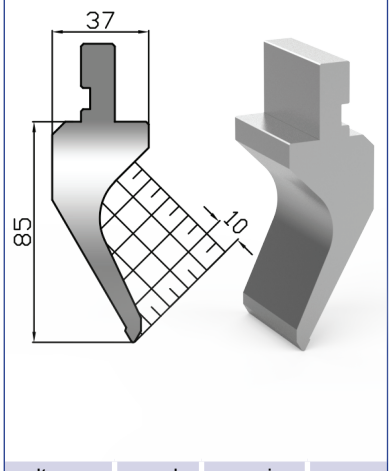
altezza height mm	angolo degree	raggio radius mm	max kN/mt
145,0	60°	0,8	800

US 136/60° R2,0



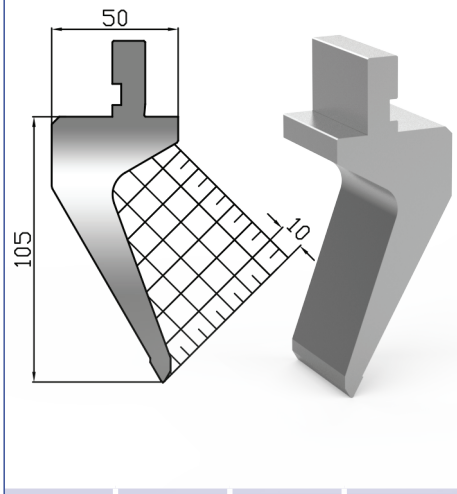
altezza height mm	angolo degree	raggio radius mm	max kN/mt
145,0	60°	2,0	1000

US 148/60° R0,8



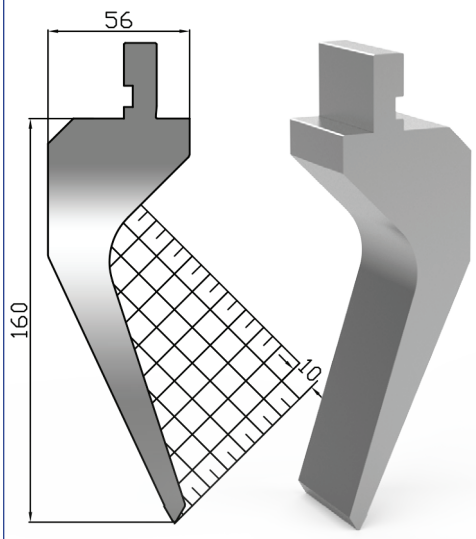
altezza height mm	angolo degree	raggio radius mm	max kN/mt
85,0	60°	0,8	400

US 132/60° R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
105,0	60°	0,8	700

US 150/60° R0,8



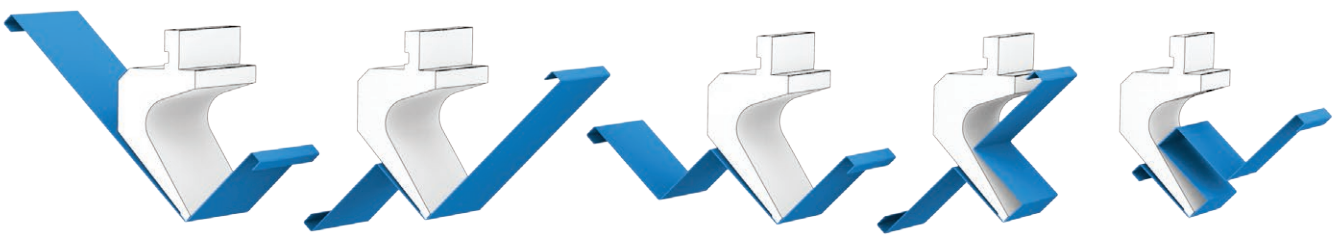
altezza height mm	angolo degree	raggio radius mm	max kN/mt
160	60°	0,8	400

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (9 pz/pcs) — acciaio - steel

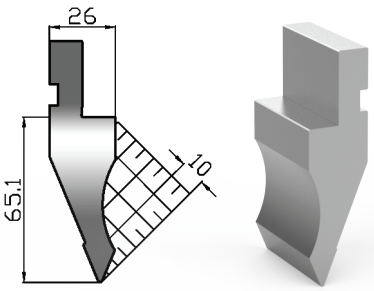
835								415
10	15	20	40	50	100	100 L	100 R	370

C45 T HRC 52÷58

42CrMo4 T HRC 52÷58

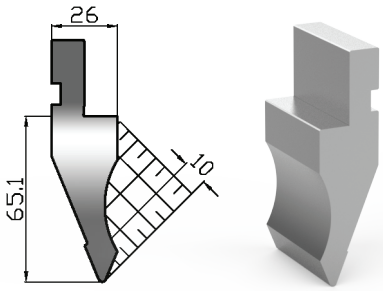


US 111/45° R0,8



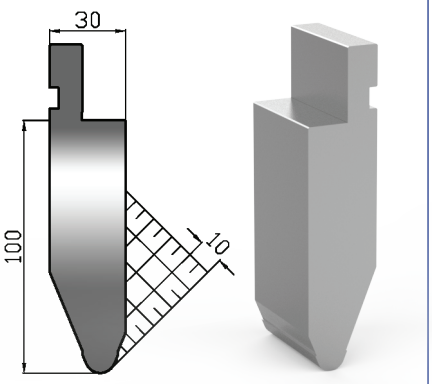
altezza height mm	angolo degree	raggio radius mm	max kN/mt
65,1	45°	0,8	800

US 111/45° R1,5



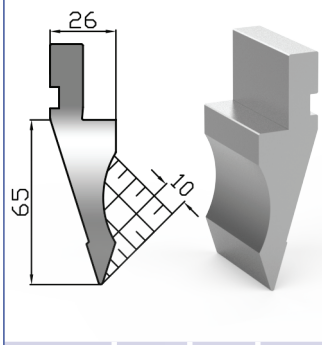
altezza height mm	angolo degree	raggio radius mm	max kN/mt
65,1	45°	1,5	800

US 149/45° R6,0



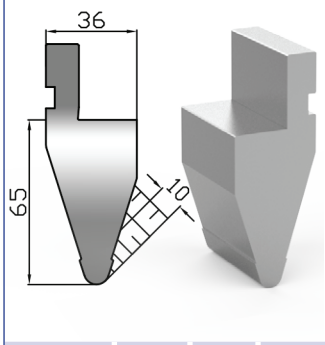
altezza height mm	angolo degree	raggio radius mm	max kN/mt
100,0	45°	6,0	1000

US 111/35° R0,8



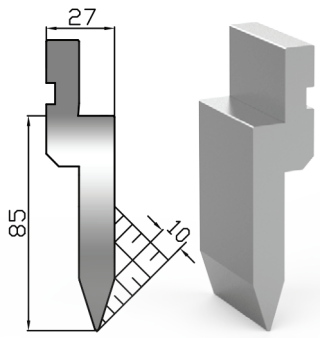
altezza height mm	angolo degree	raggio radius	max kN/mt
65,0	35°	0,8	500

US 113/35° R5,0



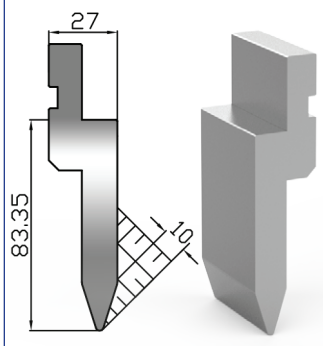
altezza height mm	angolo degree	raggio radius	max kN/mt
65,0	35°	5,0	1000

US 121/35° R0,8



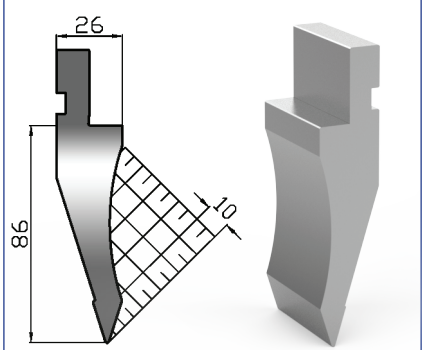
altezza height mm	angolo degree	raggio radius	max kN/mt
85,0	35°	0,8	1000

US 121/35° R1,5



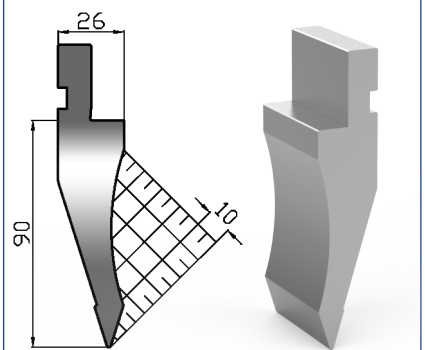
altezza height mm	angolo degree	raggio radius	max kN/mt
83,35	35°	1,5	1000

US 112/35° R0,8 h 86 mm



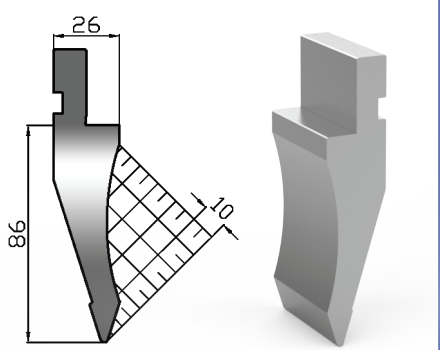
altezza height mm	angolo degree	raggio radius mm	max kN/mt
86,0	35°	0,8	700

US 112/35° R0,8 h 90 mm



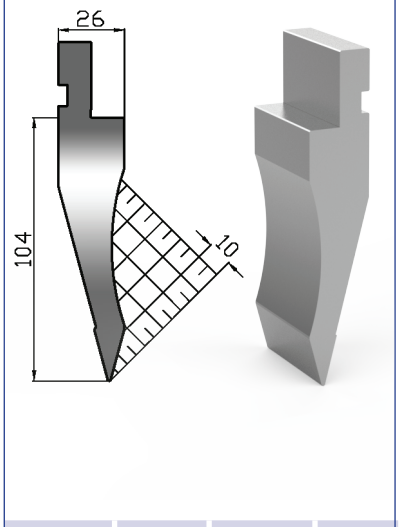
altezza height mm	angolo degree	raggio radius mm	max kN/mt
90,0	35°	0,8	700

US 112/35° R1,5 h 86 mm



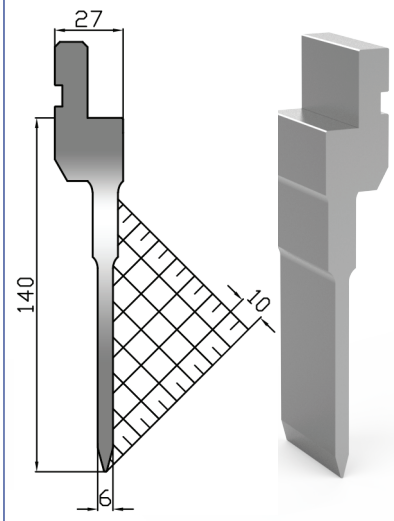
altezza height mm	angolo degree	raggio radius mm	max kN/mt
86,0	35°	1,5	700

US 133/30° R0,8



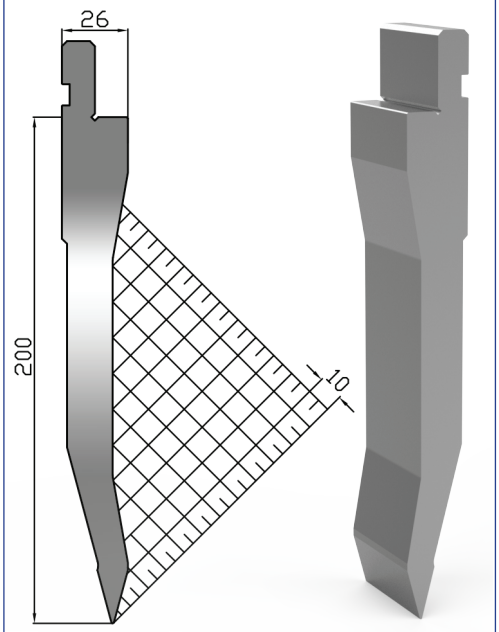
altezza height mm	angolo degree	raggio radius mm	max kN/mt
104,0	30°	0,8	700

US 157/30° R0,6



altezza height mm	angolo degree	raggio radius mm	max kN/mt
140,0	30°	0,6	400

US 154/30° R0,5

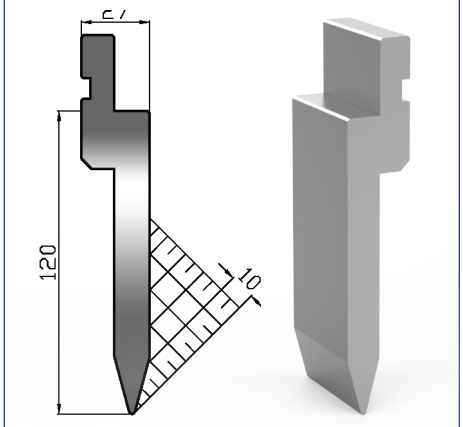


altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	30°	0,5	500

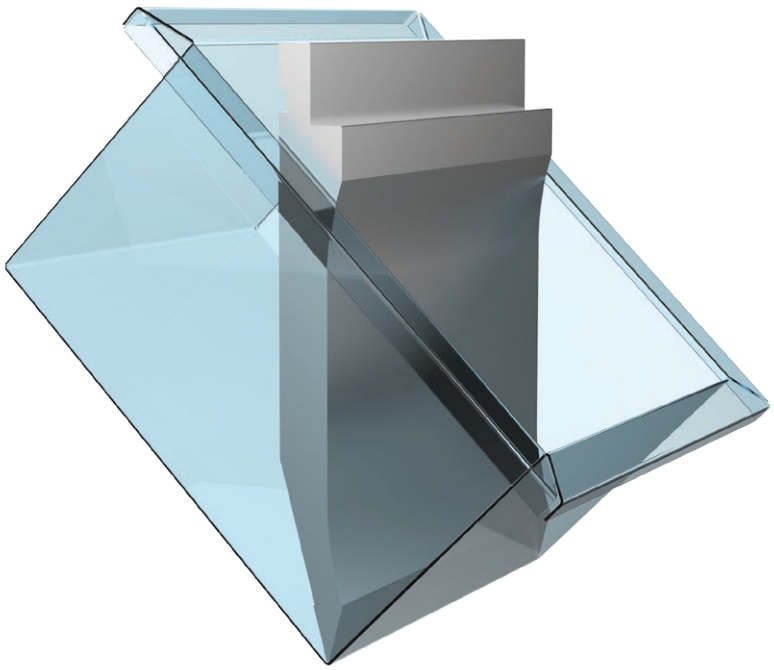
lunghezze - lengths mm 835 - 415 - fraz/sect 805 (9 pz/pcs) — acciaio - steel

835								415	C45 T HRC 52÷58
10	15	20	40	50	100	100 L	100 R	370	42CrMo4 T HRC 52÷58

US 159/30° R1,2



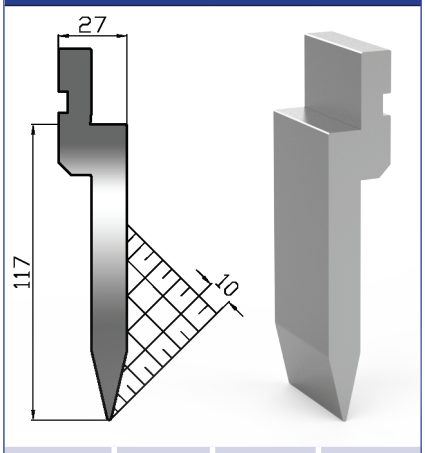
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	30°	1,2	1000



lunghezze - lengths mm 500 - fraz/sect 550 (10 pz/pcs) — acciaio - steel

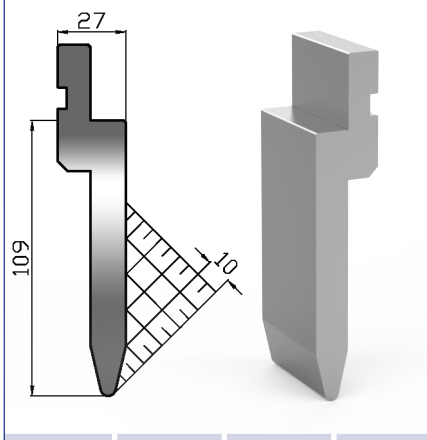
500									C45 T HRC 52÷58
25	25	30	35	40	45	50	100	100 L	100 R

US 122/26° R0,8



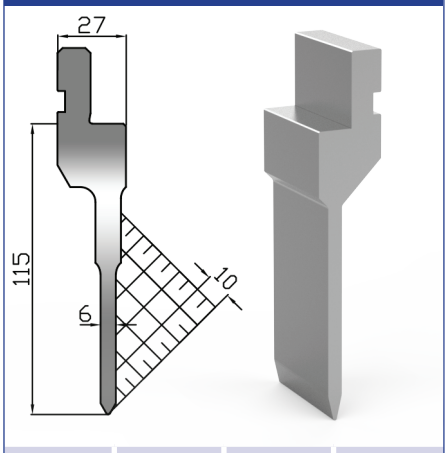
altezza height mm	angolo degree	raggio radius mm	max kN/mt
117,0	26°	0,8	1000

US 122/26° R3,0



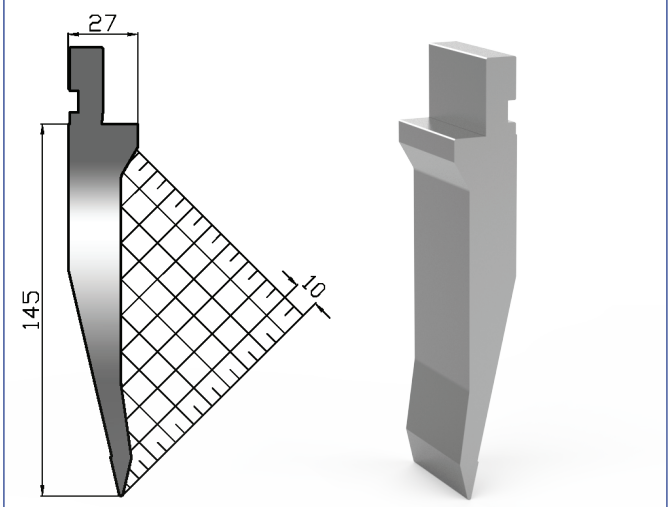
altezza height mm	angolo degree	raggio radius mm	max kN/mt
109,0	26°	3,0	1000

US 137/26° R0,8



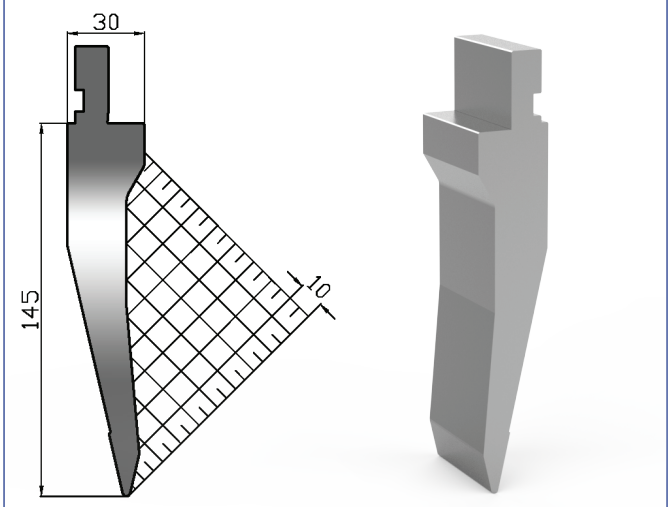
altezza height mm	angolo degree	raggio radius mm	max kN/mt
117,0	26°	0,8	500

US 139/26° R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
145,0	26°	0,8	1000

US 140/26° R1,5



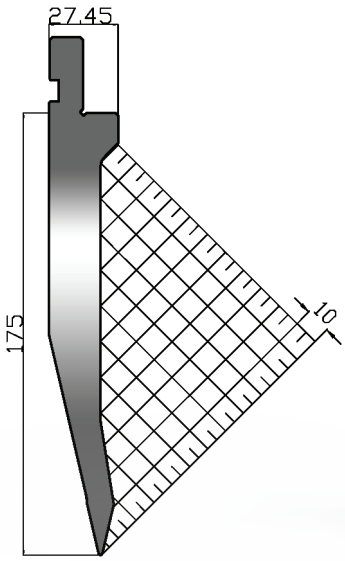
altezza height mm	angolo degree	raggio radius mm	max kN/mt
145,0	26°	1,5	1000

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (9 pz/pcs) — acciaio - steel

835								415	C45 T HRC 52÷58
10	15	20	40	50	100	100 L	100 R	370	42CrMo4 T HRC 52÷58



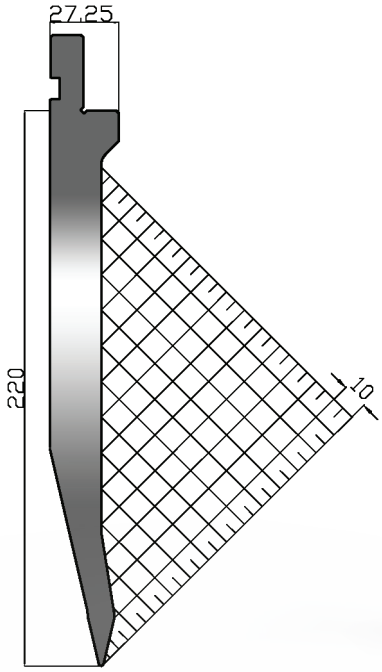
US 175/26° R0,8

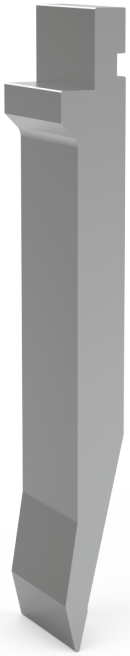




altezza height mm	angolo degree	raggio radius mm	max kN/mt
175,0	26°	0,8	950

US 161/26° R1,0



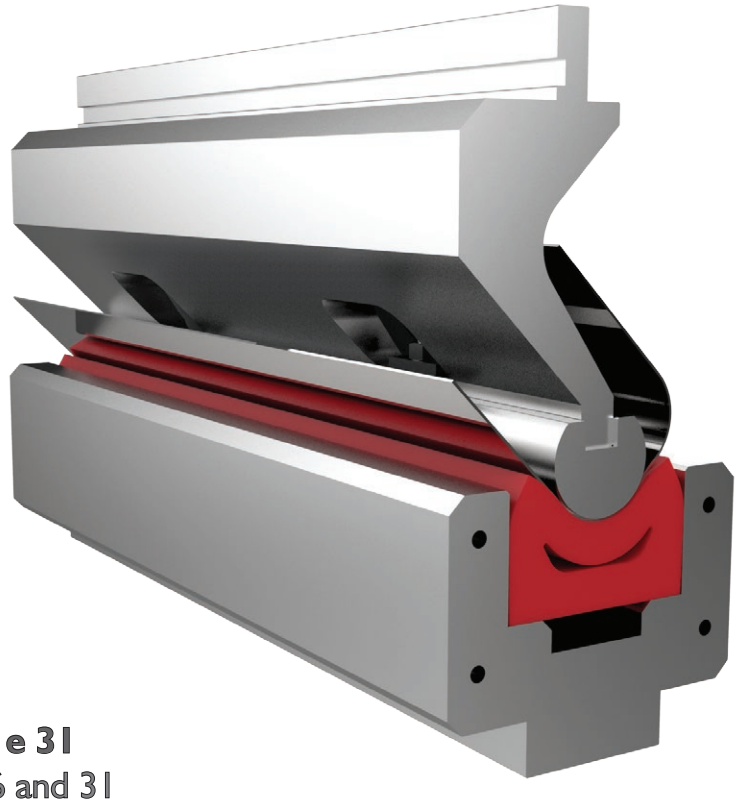


altezza height mm	angolo degree	raggio radius mm	max kN/mt
220,0	26°	1,0	1000

lunghezze - lengths mm 525 - fraz/sect A 495 (8 pz/pcs) - fraz/sect B 500 (3 pz/pcs) — acciaio - steel

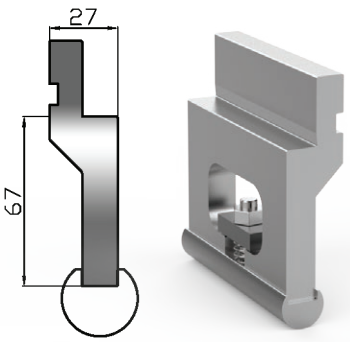
	525		B	100 L	300	100 R		
A	25	30	35	40	45	50	100	170

42CrMo4 T HRC 52÷58



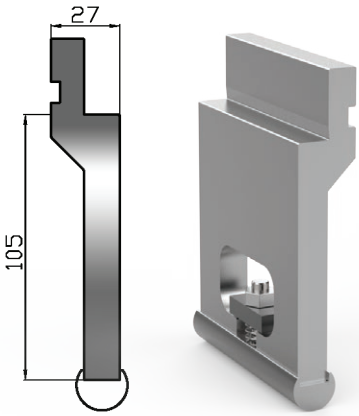
trovali a pagina 16 e 31
find them on page 16 and 31

US 119 h 67 mm



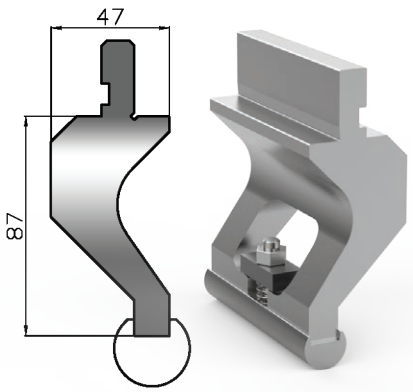
altezza height mm	raggio - radius MIN	raggio - radius MAX	max kN/mt
67,0	8,0	50,0	800

US 119 h 105 mm



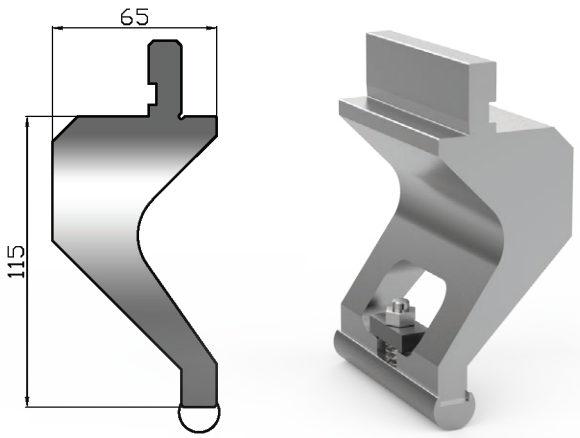
altezza height mm	raggio - radius MIN	raggio - radius MAX	max kN/mt
105,0	8,0	50,0	800

US 119 C h 87 mm



altezza height mm	raggio - radius MIN	raggio - radius MAX	max kN/mt
87,0	8,0	50,0	500

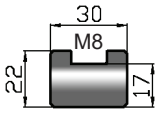
US 119 C h 115 mm



altezza height mm	raggio - radius MIN	raggio - radius MAX	max kN/mt
115,0	8,0	50,0	500

US 310

4 fori-holes mm 104-209-...-209-104 = mm 835
2 fori-holes mm 103-209-...-209-103 = mm 415

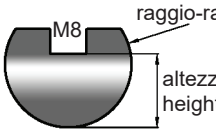


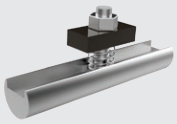


codice articolo item code		max kN/mt
US 310	NON TEMPRATO - NOT HARDENED	1000
US 310 T	TEMPRATO - HARDENED	

US 305 R8÷50 mm

4 fori-holes mm 104-209-..-209-104 = mm 835
2 fori-holes mm 103-209-..-209-103 = mm 415

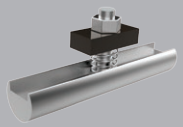




acciaio - steel

C 45

rettificato-grinding



acciaio - steel

39NCM3

nitrurato-nitrided

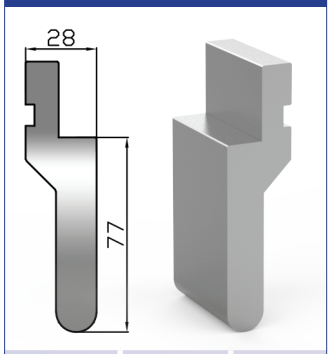
codice articolo item code	raggio radius mm	altezza height mm
US 305/R 8	8	10
US 305/R 9	9	10
US 305/R 10	10	12
US 305/R 12,5	12,5	17
US 305/R 15	15	20
US 305/R 17,5	17,5	22
US 305/R 20	20	24
US 305/R 22,5	22,5	25
US 305/R 25	25	29
US 305/R 27,5	27,5	34
US 305/R 30	30	34
US 305/R 35	35	45
US 305/R 40	40	44
US 305/R 45	45	50
US 305/R 50	50	54
US 305N/R 8	8	10
US 305N/R 9	9	10
US 305N/R 10	10	12
US 305N/R 12,5	12,5	17
US 305N/R 15	15	20
US 305N/R 17,5	17,5	22
US 305N/R 20	20	24
US 305N/R 22,5	22,5	25
US 305N/R 25	25	29
US 305N/R 27,5	27,5	34
US 305N/R 30	30	34
US 305N/R 35	35	45
US 305N/R 40	40	44
US 305N/R 45	45	50
US 305N/R 50	50	54

lunghezze - lengths mm 835 (830) - 415 (412)

acciaio - steel

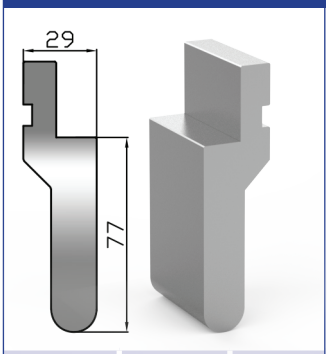
835 (830)	415 (412)	C45
		C45 T HRC 52÷58
		39NCM3 NIT

US 307 R 8



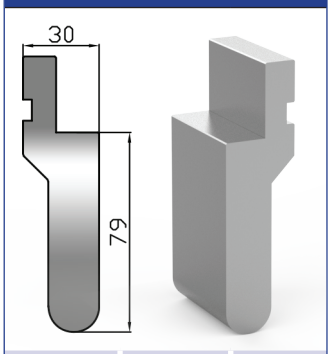
altezza height mm	raggio radius mm	max kN/mt
77,0	8,0	1000

US 307 R 9



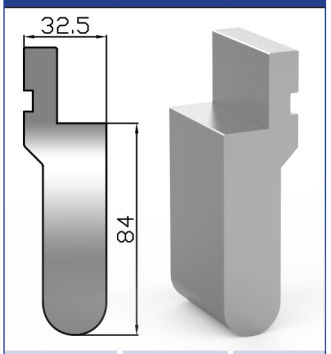
altezza height mm	raggio radius mm	max kN/mt
77,0	9,0	1000

US 307 R 10



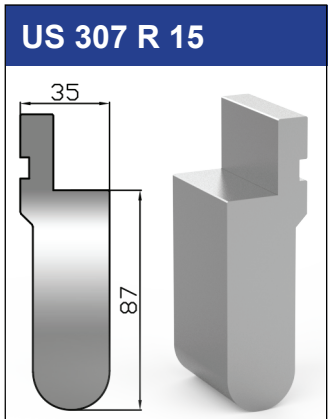
altezza height mm	raggio radius mm	max kN/mt
79,0	10,0	1000

US 307 R 12,5



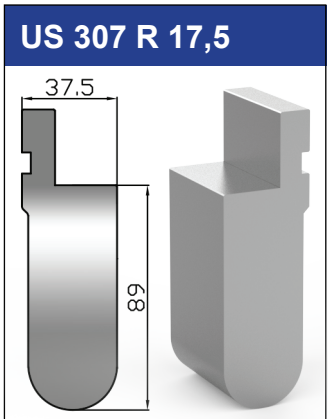
altezza height mm	raggio radius mm	max kN/mt
84,0	12,5	1000

US 307 R 15



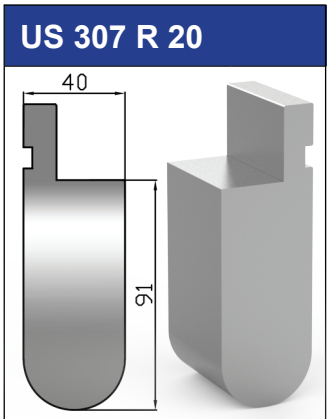
altezza height mm	raggio radius mm	max kN/mt
87,0	15	1000

US 307 R 17,5



altezza height mm	raggio radius mm	max kN/mt
89,0	17,5	1000

US 307 R 20



altezza height mm	raggio radius mm	max kN/mt
91,0	20,0	1000



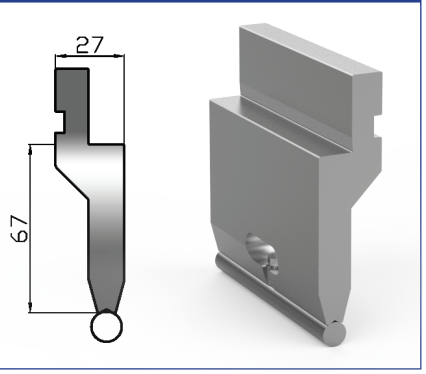
ACCOPPIABIILI IN ALTEZZA
COMBINABLE HEIGHT

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (9 pz/pcs) — acciaio - steel

835	415	C45 T HRC 52÷58
10 15 20 40 50 100 100 L 100 R	370	42CrMo4 T HRC 52÷58

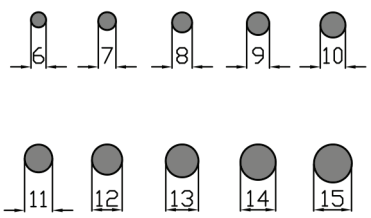
US 118 h 67 mm

altezza height mm	raggio - radius MIN	raggio - radius MAX	max kN/mt
67,0	3,0	7,5	450



US 305 R3÷7,5 mm

6 fori-holes mm 55,0-145-...-145...55,0=mm 835
3 fori-holes mm 62,5-145-...-145...62,5=mm 415

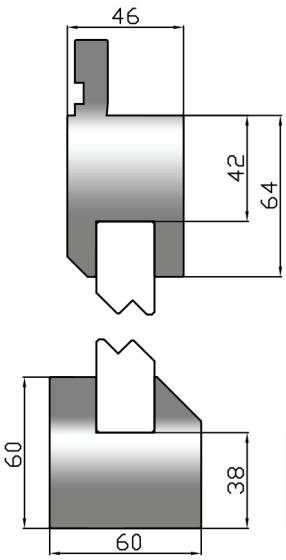


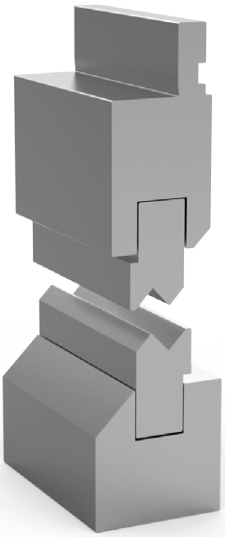
codice articolo item code	raggio radius	altezza height
US 305/R 3,0	3,0	6 mm
US 305/R 3,5	3,5	7 mm
US 305/R 4,0	4,0	8 mm
US 305/R 4,5	4,5	9 mm
US 305/R 5,0	5,0	10 mm
US 305/R 5,5	5,5	11 mm
US 305/R 6,0	6,0	12 mm
US 305/R 6,5	6,5	13 mm
US 305/R 7,0	7,0	14 mm
US 305/R 7,5	7,5	15 mm

lunghezze - lengths mm 835 (830) - 415 (412) — acciaio - steel

835 (830)	415 (412)	C45

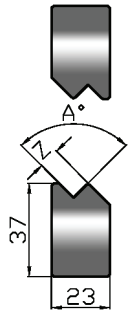
US 130

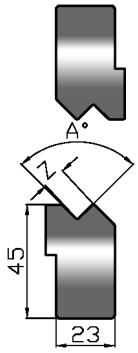




altezza height mm	max kN/mt
64 + 60	1000

US 131 Z 1÷15

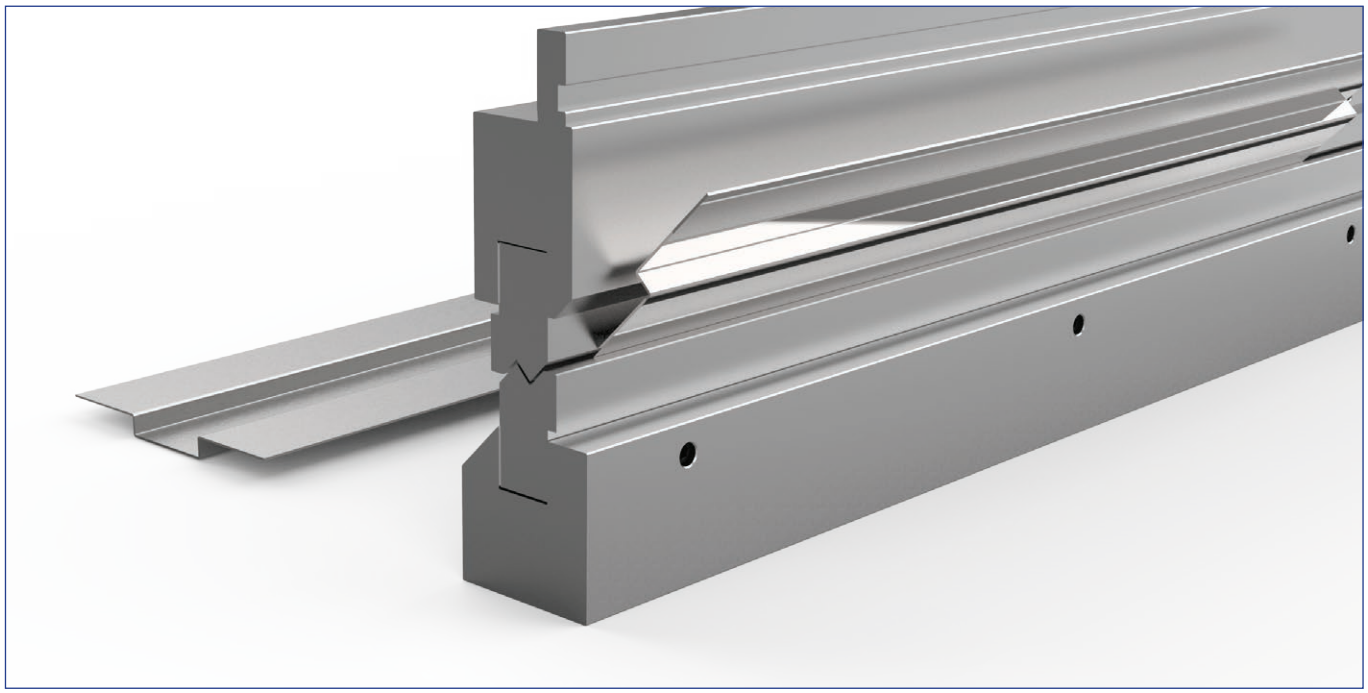




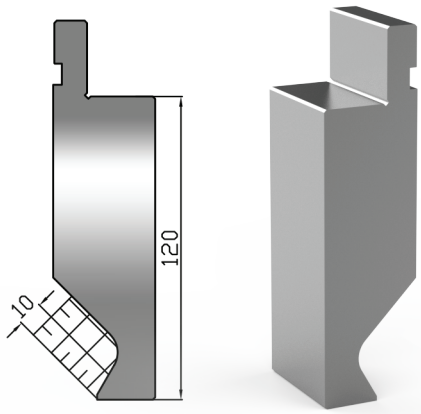
codice articolo item code	Z mm	A°	MAX sp./th.mm
US 131 / 1,0	1,0	160°	0,5
US 131 / 1,5	1,5	160°	0,6
US 131 / 2,0	2,0	150°	0,8
US 131 / 2,5	2,5	140°	1,0
US 131 / 3,0	3,0	90°	1,0
US 131 / 3,5	3,5	90°	1,2
US 131 / 4,0	4,0	90°	1,2
US 131 / 4,5	4,5	90°	1,5
US 131 / 5,0	5,0	90°	1,5
US 131 / 5,5	5,5	90°	1,5
US 131 / 6,0	6,0	90°	1,5
US 131 / 6,5	6,5	90°	1,5
US 131 / 7,0	7,0	90°	2,0
US 131 / 7,5	7,5	90°	2,0
US 131 / 8	8	90°	2,5
US 131 / 9	9	90°	2,5
US 131 / 10	10	90°	3,0
US 131 / 11	11	90°	3,0
US 131 / 12	12	90°	3,0
US 131 / 13	13	90°	3,0
US 131 / 14	14	90°	3,0
US 131 / 15	15	90°	3,0

lunghezze - lengths mm 835 - 415 — acciaio - steel

835	*415*	C45 T HRC 52÷58

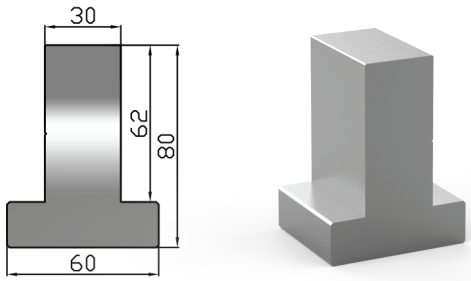


US FLAT / PUN



altezza height mm	angolo degree	max kN/mt
120,0	180	450

US FLAT / MAT



altezza height mm	angolo degree	max kN/mt
80	180	1000

lunghezze - lengths mm 835 - 415 - 800 fraz/sect — acciaio - steel

835	415

US FLAT/PUN fraz/sect 800 (10 pz/pcs)

10	15	15	20	40	50	100	100	150	300

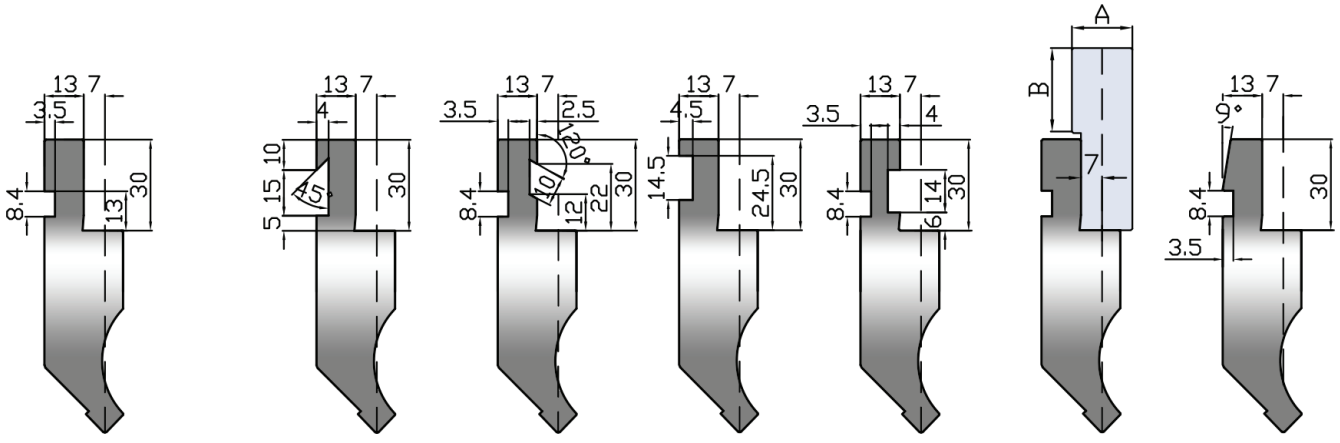
US FLAT/MAT fraz/sect 800 (9 pz/pcs)

10	15	15	20	40	50	100	150	400

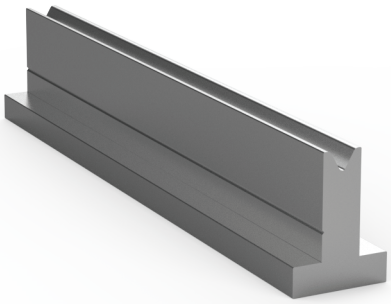
C45 T HRC 52÷58

42CrMo4 T HRC 52÷58

ATTACCHI STANDARD e SPECIALI • STANDARD and SPECIAL CLAMPINGS

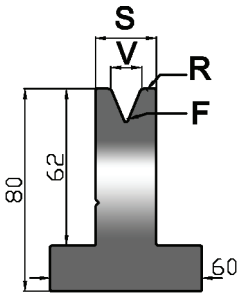


STANDARD **A** **B** **C** **D** **X** **ONE TOUCH**



altezza - height

80 mm



US 220/88° h.80 mm — 88°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 220/88° V06	6	0,40	14	r 0,5	1000
US 220/88° V08	8	0,50	14	r 0,5	1000
US 220/88° V10	10	0,80	18	r 0,5	1000
US 220/88° V12	12	2,75	18	r 0,5	1000
US 220/88° V16	16	2,75	24	r 0,5	1000
US 220/88° V20	20	3,00	30	r 0,5	1000
US 220/88° V25	25	3,00	35	r 0,5	1000
US 220/88°V06R	6	2,75	14	r 0,5	1000
US 220/88°V08R	8	2,75	14	r 0,5	1000
US 220/88°V10R	10	2,75	18	r 0,5	1000

US 220/85° h.80 mm — 85°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 220/85° V06	6	2,75	14	r 0,5	1000
US 220/85° V08	8	2,75	14	r 0,5	1000
US 220/85° V10	10	2,75	18	r 0,5	1000
US 220/85° V12	12	2,75	18	r 0,5	1000
US 220/85° V16	16	2,75	24	r 0,5	1000
US 220/85° V20	20	3,00	30	r 0,8	1000
US 220/85° V25	25	3,00	35	r 0,8	1000

US 220/60° h.80 mm — 60°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 220/60° V06	6	0,50	14	r 0,5	600
US 220/60° V08	8	0,80	14	r 0,5	600
US 220/60° V10	10	0,80	18	r 0,5	600
US 220/60° V12	12	0,80	18	r 0,5	600
US 220/60° V16	16	2,75	24	r 2,0	600
US 220/60° V20	20	3,00	30	r 2,0	600
US 220/60° V25	25	3,00	35	r 2,0	600
US 220/60°V06R	6	1,50	14	r 0,5	600
US 220/60°V08R	8	1,50	14	r 0,5	600
US 220/60°V10R	10	2,75	18	r 0,5	600
US 220/60°V12R	12	2,75	18	r 0,5	600

US 220/45° h.80 mm — 45°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 220/45° V06	6	0,80	14	r 0,5	500
US 220/45° V08	8	1,00	18	r 0,8	500
US 220/45° V10	10	1,20	18	r 0,8	500
US 220/45° V12	12	1,60	24	r 0,8	500
US 220/45° V16	16	2,75	26	r 2,0	500
US 220/45° V20	20	3,00	30	r 2,0	600
US 220/45° V25	25	3,00	37	r 2,0	600

US 220/35° h.80 mm — 35°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 220/35° V06	6	0,80	14	r 0,5	350
US 220/35° V08	8	1,00	16	r 0,5	350
US 220/35° V10	10	1,20	20	r 0,5	400
US 220/35° V12	12	1,60	22	r 0,5	400
US 220/35° V16	16	3,00	30	r 2,0	450
US 220/35° V20	20	3,00	35	r 2,0	500
US 220/35° V25	25	3,00	40	r 2,0	500

US 220/30° h.80 mm — 30°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 220/30° V06	6	0,60	14	r 1,0	350
US 220/30° V08	8	0,80	18	r 1,2	350
US 220/30° V10	10	1,00	24	r 1,2	500
US 220/30° V12	12	1,50	24	r 1,2	400
US 220/30° V16	16	2,00	30	r 3,0	450
US 220/30° V20	20	2,50	35	r 3,0	500
US 220/30° V25	25	3,00	40	r 3,0	500

US 220/26° h.80 mm — 26°

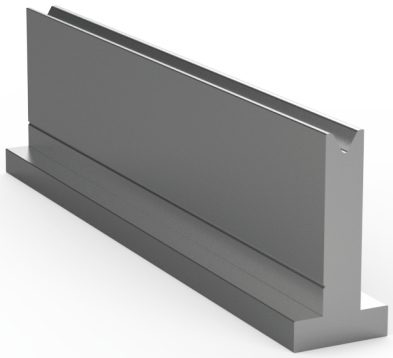


codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 220/26° V06	6	0,80	16	r 1,0	250
US 220/26° V08	8	1,00	20	r 1,0	250
US 220/26° V10	10	1,20	24	r 1,0	250
US 220/26° V12	12	1,60	26	r 1,0	250

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (8 pz/pcs) — acciaio - steel

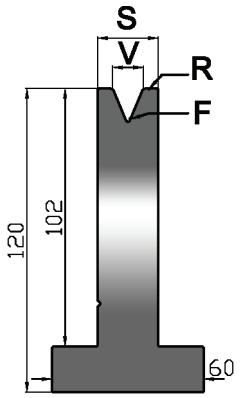
835								415
10	15	20	40	50	100	200	370	

C45 T HRC 52÷58



altezza - height

120 mm



US 420/88° h.120 mm — 88°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 420/88° V06	6	0,40	14	r 0,5	1000
US 420/88° V08	8	0,50	14	r 0,5	1000
US 420/88° V10	10	0,80	18	r 0,5	1000
US 420/88° V12	12	2,75	18	r 0,5	1000
US 420/88° V16	16	2,75	24	r 0,5	1000
US 420/88° V20	20	3,00	30	r 0,5	1000
US 420/88° V25	25	3,00	35	r 0,5	1000
US 420/88°V06R	6	2,75	14	r 0,5	1000
US 420/88°V08R	8	2,75	14	r 0,5	1000
US 420/88°V10R	10	2,75	18	r 0,5	1000

US 420/85° h.120 mm — 85°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 420/85° V06	6	2,75	14	r 0,5	1000
US 420/85° V08	8	2,75	14	r 0,5	1000
US 420/85° V10	10	2,75	18	r 0,5	1000
US 420/85° V12	12	2,75	18	r 0,5	1000
US 420/85° V16	16	2,75	24	r 0,5	1000
US 420/85° V20	20	3,00	30	r 0,8	1000
US 420/85° V25	25	3,00	35	r 0,8	1000

US 420/60° h.120 mm — 60°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 420/60° V06	6	0,50	14	r 0,5	600
US 420/60° V08	8	0,80	14	r 0,5	600
US 420/60° V10	10	0,80	18	r 0,5	600
US 420/60° V12	12	0,80	18	r 0,5	600
US 420/60° V16	16	2,75	24	r 2,0	600
US 420/60° V20	20	3,00	30	r 2,0	600
US 420/60° V25	25	3,00	35	r 2,0	600
US 420/60°V06R	6	1,50	14	r 0,5	600
US 420/60°V08R	8	1,50	14	r 0,5	600
US 420/60°V10R	10	2,75	18	r 0,5	600
US 420/60°V12R	12	2,75	18	r 0,5	600

US 420/45° h.120 mm — 45°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 420/45° V06	6	0,80	14	r 0,5	500
US 420/45° V08	8	1,00	18	r 0,8	500
US 420/45° V10	10	1,20	18	r 0,8	500
US 420/45° V12	12	1,60	24	r 0,8	500
US 420/45° V16	16	2,75	26	r 2,0	500
US 420/45° V20	20	3,00	30	r 2,0	600
US 420/45° V25	25	3,00	37	r 2,0	700

US 420/35° h.120 mm — 35°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 420/35° V0		0,80	14	r 0,5	350
US 420/35° V0		1,00	16	r 0,5	350
US 420/35° V1		1,20	20	r 0,5	400
US 420/35° V		,60	22	r 0,5	400
US 420/35° V1	16	3,00	30	r 2,0	450
US 420/35° V20	20	3,00	35	r 2,0	500
US 420/35° V25	25	3,00	40	r 2,0	500

US 420/30° h.120 mm — 30°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 420/30° V06	6	0,60	14	r 1,0	350
US 420/30° V08	8	0,80	18	r 1,2	350
US 420/30° V10	10	1,00	24	r 1,2	500
US 420/30° V12	12	1,50	24	r 1,2	400
US 420/30° V16	16	2,00	30	r 3,0	450
US 420/30° V20	20	2,50	35	r 3,0	500
US 420/30° V25	25	3,00	40	r 3,0	500

US 420/26° h.120 mm — 26°



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt
US 420/26° V06	6	0,80	16	r 1,0	250
US 420/26° V08	8	1,00	20	r 1,0	250
US 420/26° V10	10	1,20	24	r 1,0	250
US 420/26° V12	12	1,60	26	r 1,0	250

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (8 pz/pcs)

acciaio - steel

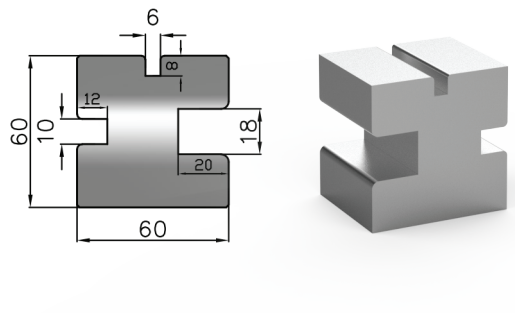
835

415

10 *15* *20* *40* *50* *100* *200* *370*

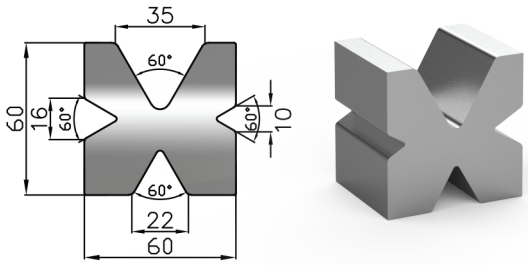
C45 T HRC 52÷58

US 208/3U



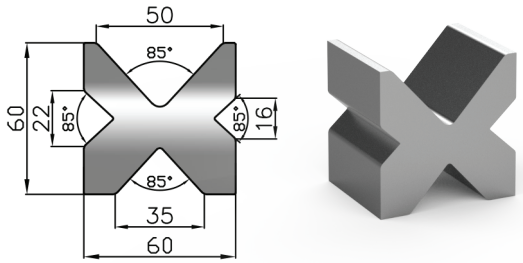
V mm	6	10	18	max kN/mt
raggio radius	mm 1,5	mm 2	mm 3,0	1000

US 210/4V (60°)



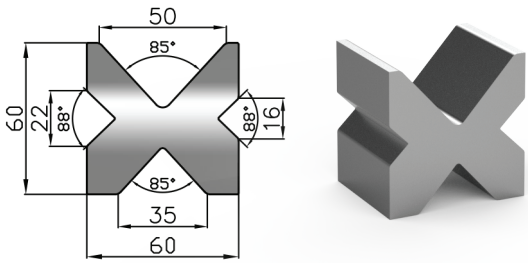
V mm	10/60°	16/60°	22/60°	35/60°	max kN/mt
raggio radius	mm1,5	mm 2	mm2,5	mm 3	600

US 205/4V (85°)



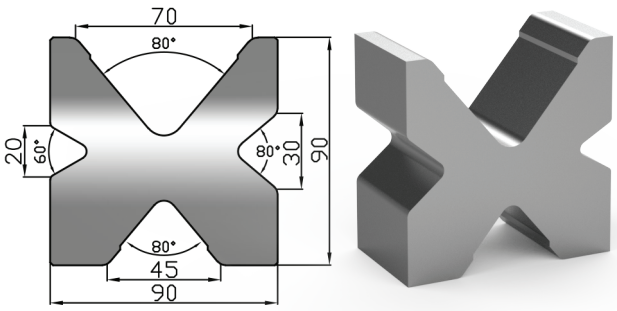
V mm	16/85°	22/85°	35/85°	50/85°	max kN/mt
raggio radius	mm 2	mm 2	mm 2	mm 3	800

US 209/4V (85° - 88°)



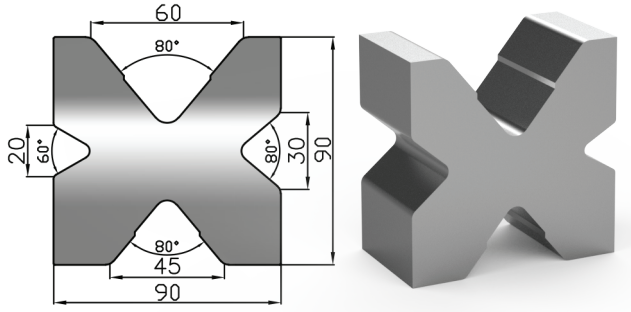
V mm	16/88°	22/88°	35/85°	50/85°	max kN/mt
raggio radius	mm 2	mm 2	mm 2	mm 3	800

US 203/4V



V mm	20/60°	30/80°	45/80°	70/80°	max kN/mt
raggio radius	mm 2	mm 4	mm 4	mm 5	600

US 204/4V



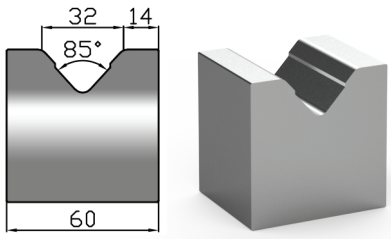
V mm	20/60°	30/80°	45/80°	60/80°	max kN/mt
raggio radius	mm 2	mm 4	mm 4	mm 5	1000

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (8 pz/pcs) — acciaio - steel

835							415
10	15	20	40	50	100	200	370

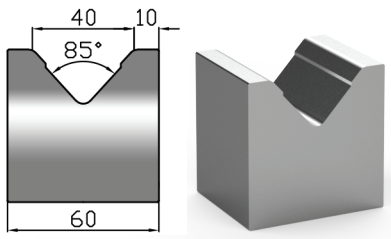
C45 T HRC 52÷58

US 211/85° V 32



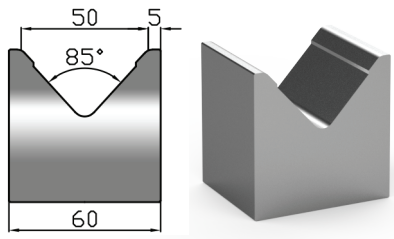
V32/85°	altezza height	raggio radius	max kN/mt
	mm 60	mm 4	1000

US 211/85° V 40



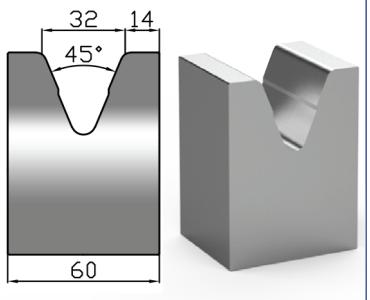
V40/85°	altezza height	raggio radius	max kN/mt
	mm 60	mm 4	1000

US 211/85° V 50



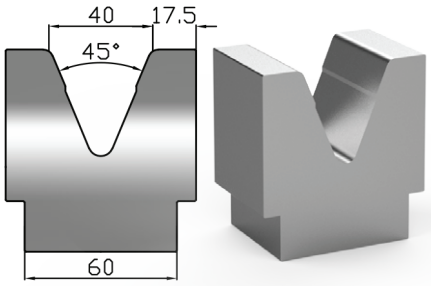
V50/85°	altezza height	raggio radius	max kN/mt
	mm 60	mm 4	1000

US 220/45° V 32



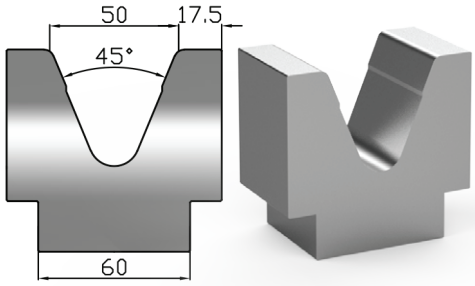
V32/45°	altezza height	raggio radius	max kN/mt
	mm 80	mm 4	1000

US 220/45° V 40



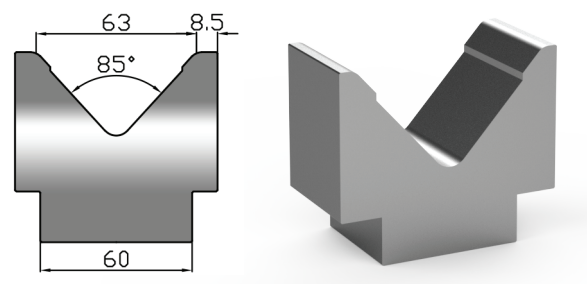
V40/45°	altezza height	raggio radius	max kN/mt
	mm 80	mm 4	1000

US 220/45° V 50



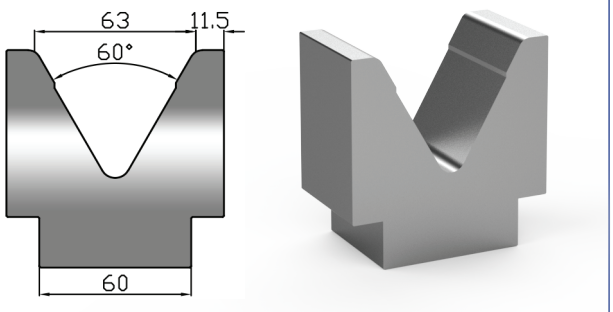
V50/45°	altezza height	raggio radius	max kN/mt
	mm 80	mm 4	900

US 211/85° V 63



V63/85°	altezza height	raggio radius	max kN/mt
	mm 75	mm 5	1000

US 220/60° V 63



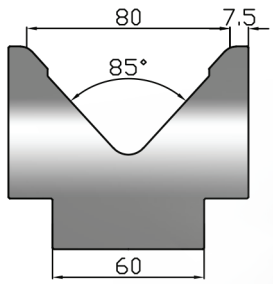
V63/60°	altezza height	raggio radius	max kN/mt
	mm 86	mm 5	1000

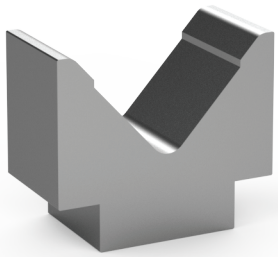
lunghezze - lengths mm 835 - 415 - fraz/sect 805 (8 pz/pcs) — acciaio - steel

835							415
10	15	20	40	50	100	200	370

C45 T HRC 52÷58

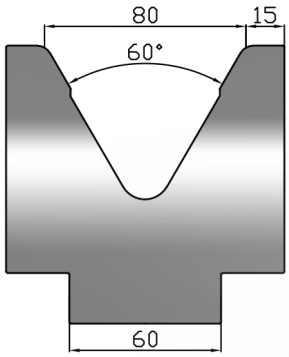
US 211/85° V 80





	altezza height	raggio radius	max kN/mt
V80/85°	mm 80	mm 6	1000

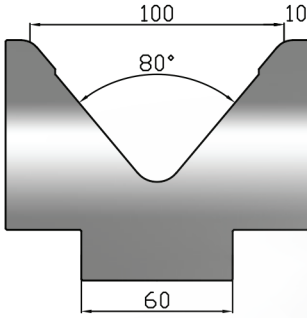
US 220/60° V 80





	altezza height	raggio radius	max kN/mt
V80/60°	mm 110	mm 6	1000

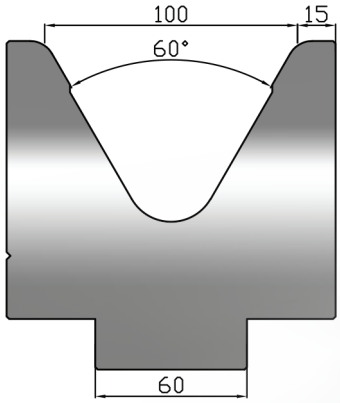
US 211/80° V 100





	altezza height	raggio radius	max kN/mt
V100/80°	mm 95	mm 8	1000

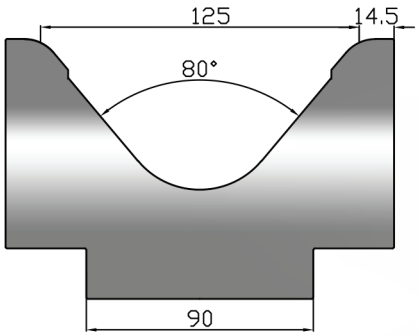
US 220/60° V 100

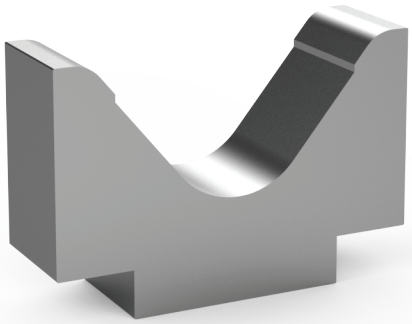




	altezza height	raggio radius	max kN/mt
V100/60°	mm 130	mm 10	1000

US 211/80° V125 base mm 90





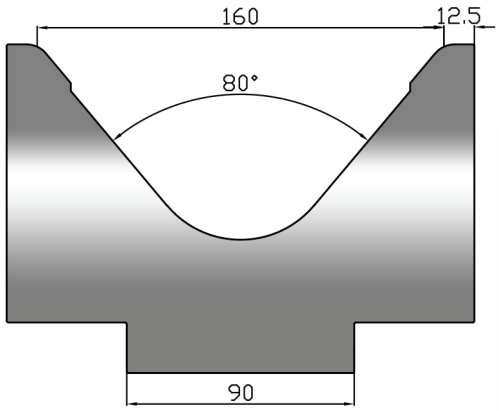
	altezza height	raggio radius	max kN/mt
V125/80°	mm 103	mm 15	1000

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (8 pz/pcs) — acciaio - steel

835							415
10	15	20	40	50	100	200	370

C45 T HRC 52÷58

US 211/80° V160 base mm 90





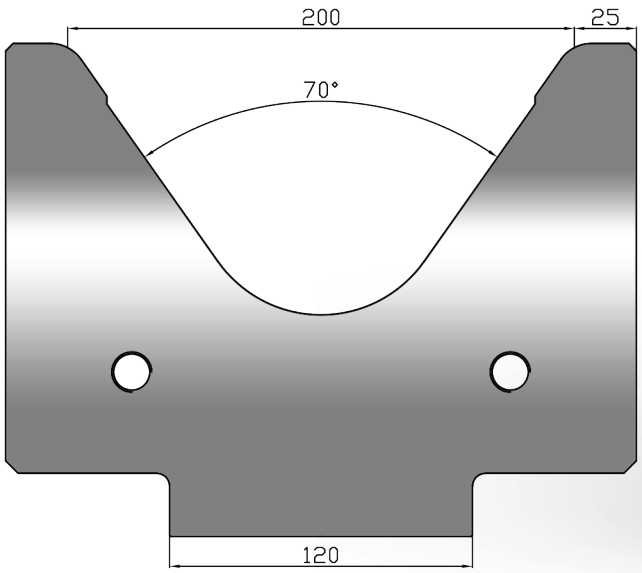
V160/80°	altezza height	raggio radius	max kN/mt
	mm 130	mm 10	1000

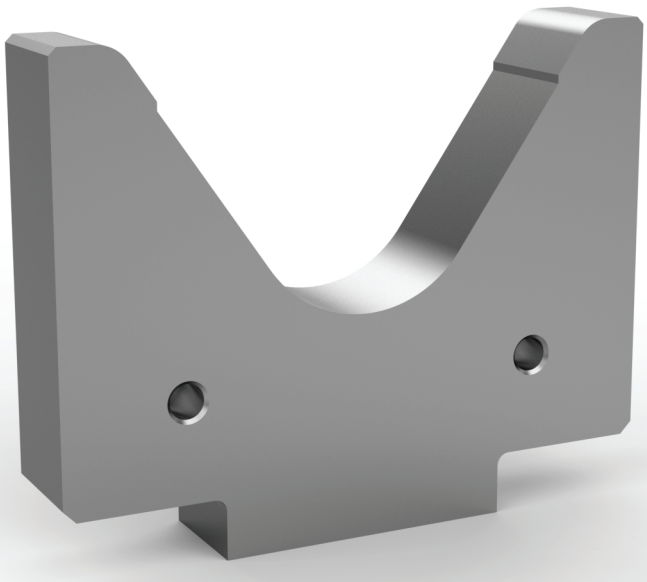
lunghezze - lengths mm 835 - 415 - fraz/sect 805 (8 pz/pcs) — acciaio - steel

835							415
10	15	20	40	50	100	200	370

C45 T HRC 52÷58

US 211/70° V200 base mm 120





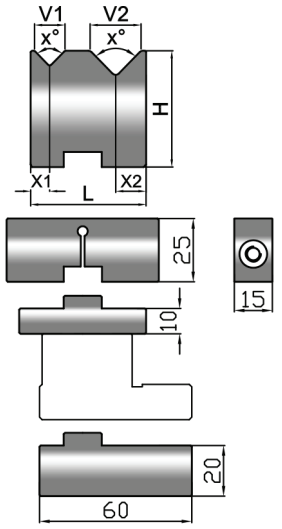
V200/70°	altezza height	raggio radius	max kN/mt
	mm 195	mm 15	2200

lunghezze - lengths mm 415 - fraz/sect 805 (8 pz/pcs) — acciaio - steel

							415
10	15	20	40	50	100	200	370

42CrMo4 T HRC 52÷58

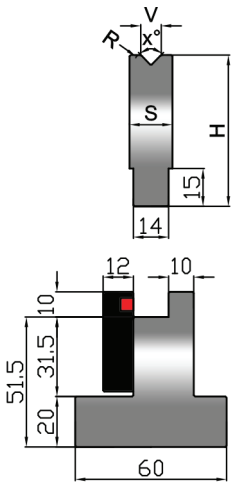
2V - serie 500 series

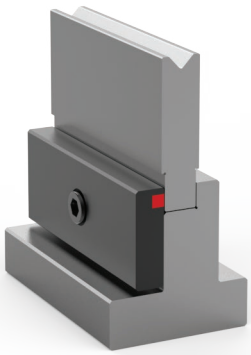


	codice articolo item code	V1 + raggio-radius	V2 + raggio-radius	LxH mm	X1 mm	X2 mm	max kN/mt
88°	US 520/88° V 6+10	mm 6 R 0,80	mm 10 - R 1,2	37x46	4,5	6,5	800
	US 540/88° V 8+12	mm 8 R 1,00	mm 12 R 1,50	39x46	5,5	7,5	800
	US 550/88° V14+18	mm 14 R 1,25	mm 18 R 1,50	45x46	8,5	10,5	800
	US 560/88° V12+20	mm 12 R 0,80	mm 20 R 1,75	45,5x46	7,5	12,0	800
	US 570/88° V16+25	mm 16 R 1,50	mm 25 R 1,75	50x46	9,5	14,5	800
							400
30°	US 580/30° V 6+10	mm 6 - R 0,60	mm 10 - R 1,00	45x46	7,0	12,0	400
	US 590/30° V 8+12	mm 8 - R 0,80	mm 12 - R 1,50	50x46	9,5	14,5	400

SUPPORTO MATRICI - TOOLS HOLDER		
US 500	altezza - height	H mm 10
US 505		H mm 20
US 501	fermo per matrici - stop for dies mm 60 x 25 x 15	

1V - serie 600 series





	codice articolo item code	V mm	H mm	R mm	S mm	max kN/mt
88°	US 604/88°	4	60	0,60	14	1000
	US 606/88°	6	60	0,80	14	1000
	US 608/88°	8	60	1,00	14	1000
	US 610/88°	10	60	1,20	18	1000
	US 612/88°	12	60	1,50	18	1000
	US 616/88°	16	60	2,00	24	1000
	US 620/88°	20	60	2,00	30	1000
	US 625/88°	25	60	3,00	35	1000
60°	US 606/60°	6	60	0,60	14	600
	US 608/60°	8	60	0,80	14	600
	US 610/60°	10	60	1,00	18	600
	US 612/60°	12	60	1,20	18	600
	US 616/60°	16	60	1,60	24	600
	US 620/60°	20	60	2,00	30	600
	US 625/60°	25	65	2,50	35	500
30°	US 606/30°	6	60	0,60	14	350
	US 608/30°	8	60	0,80	18	350
	US 610/30°	10	60	1,00	24	500
	US 612/30°	12	60	1,50	24	400
	US 616/30°	16	60	2,00	30	450
	US 620/30°	20	60	2,50	35	500
	US 625/30°	25	65	3,00	45	500

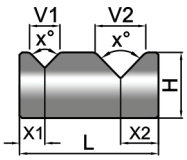
SUPPORTO MATRICI - TOOLS HOLDER		
US 600	altezza - height	H mm 51,5

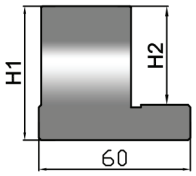
lunghezze - lengths mm 835 - 415 - fraz/sect 805 (8 pz/pcs) — acciaio - steel

835								415
10	15	20	40	50	100	200	370	

C45 T HRC 52÷58

2V - serie 200 series



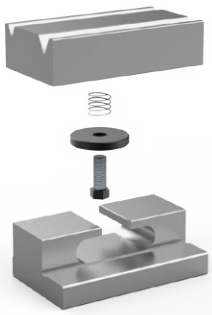


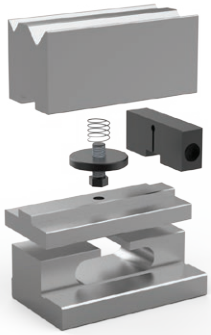
	codice articolo item code	V1 + raggio-radius	V2 + raggio-radius	LxH mm	X1 mm	X2 mm	max kN/mt
88°	US 212/88° V 6+10	mm 6 R 0,80	mm 10 R 1,20	55x26	6,0	10,0	1000
	US 213/88° V 8+12	mm 8 R 1,00	mm 12 R 1,50	55x26	8,0	10,0	1000
	US 214/88° V12+20	mm 12 R 2,75	mm 20 R 3,00	55x26	10,0	15,0	1000
	US 207/88° V14+18	mm 14 R 2,75	mm 18 R 3,00	55x26	11,0	13,0	1000
	US 215/88° V16+25	mm 16 R 2,75	mm 25 R 3,00	55x26	12,0	16,5	1000
60°	US 218/60° V 6+10	mm 6 R 0,40	mm 10 R 0,60	55x26	6,0	10,0	600
	US 219/60° V 8+12	mm 8 R 0,80	mm 12 R 1,20	55x26	8,0	10,0	800
	US 221/60° V12+20	mm 12 R 0,80	mm 20 R 1,50	55x26	10,0	15,0	800
	US 222/60° V16+20	mm 16 R 1,60	mm 20 R 2,00	55x26	12,0	15,0	800
SUPPORTO MATRICI - TOOLS HOLDER							
	US 406/34	altezza - height		H1 mm 34 - H2 mm 20			
	US 407/55			H1 mm 55 - H2 mm 36			
	US 408/75			H1 mm 75 - H2 mm 56			

lunghezze - lengths mm 835 - 415 — acciaio - steel

835 / 830	415 / 410	C45 T HRC 52÷58

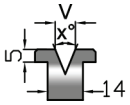
serie 200 series

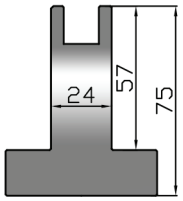


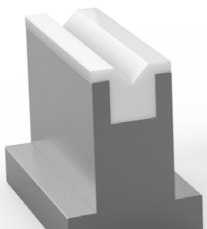


serie 500 series

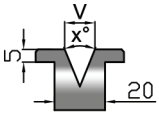
US 220 NYL 14

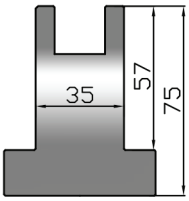


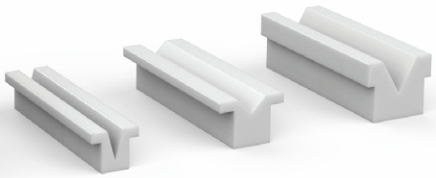




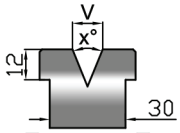
US 220 NYL 20

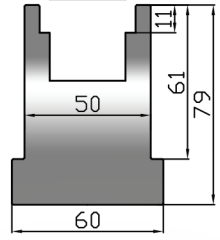






US 220 NYL 30





NYLON 14					
V 6/88°	V 8/88°	V 10/88°			
V 6/60°	V 8/60°	V 10/60°			
V 6/45°	V 8/45°	V 10/45°			
V 6/30°	V 8/30°				

NYLON 20					
V 6/88°	V 8/88°	V 10/88°	V 12/88°	V 16/88°	
V 6/60°	V 8/60°	V 10/60°	V 12/60°	V 16/60°	
V 6/45°	V 8/45°	V 10/45°	V 12/45°		
V 6/30°	V 8/30°	V 10/30°			

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

lunghezze - lengths mm 835 - 415 — acciaio - steel

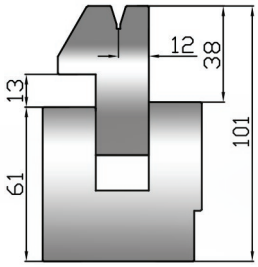
835	415	C45

US 303/35° V 6

/ M con molle - with springs

/ PN pneumatico - pneumatic

V mm 6/35°	
altezza height	mm 101-88
raggio radius	mm 1,0
max kN/mt	600





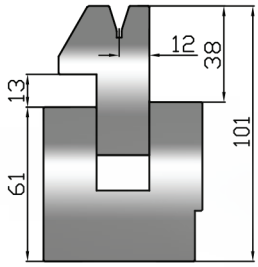


US 303/35° V 8

/ M con molle - with springs

/ PN pneumatico - pneumatic

V mm 8/35°	
altezza height	mm 101-88
raggio radius	mm 1,0
max kN/mt	600





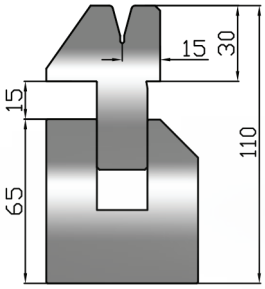


US 306/30° V 8

/ M con molle - with springs

/ PN pneumatico - pneumatic

V mm 8/30°	
altezza height	mm 110-95
raggio radius	mm 1,5
max kN/mt	800





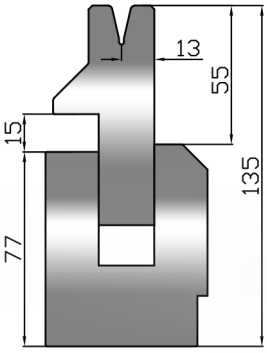


US 308/26° V 8

/ M con molle - with springs

/ PN pneumatico - pneumatic

V mm 8/26°	
altezza height	mm 135-120
raggio radius	mm 1,5
max kN/mt	400





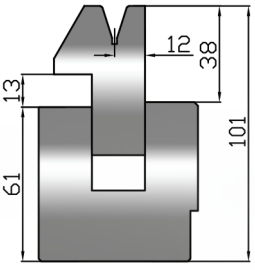


US 303/35° V 10

/ M con molle - with springs

/ PN pneumatico - pneumatic

V mm 10/35°	
altezza height	mm 101-88
raggio radius	mm 1,0
max kN/mt	600

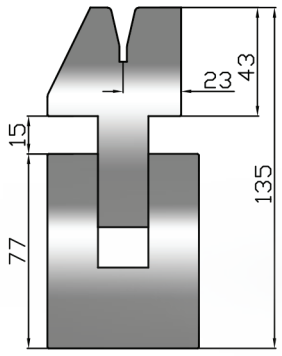






US 302/26° V 10 / M con molle - with springs / PN pneumatico - pneumatic

V mm 10/26°	
altezza height	mm 135-120
raggio radius	mm 1,5
max kN/mt	1000

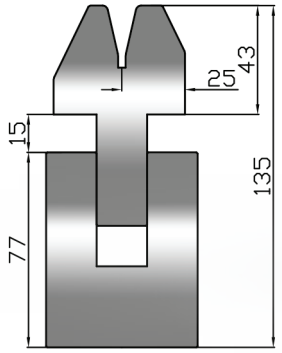


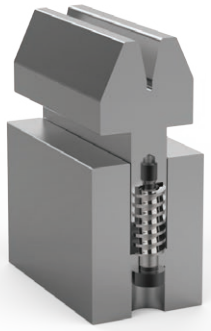




US 300/26° V 12 / M con molle - with springs / PN pneumatico - pneumatic

V mm 12/26°	
altezza height	mm 135-120
raggio radius	mm 2,0
max kN/mt	1000





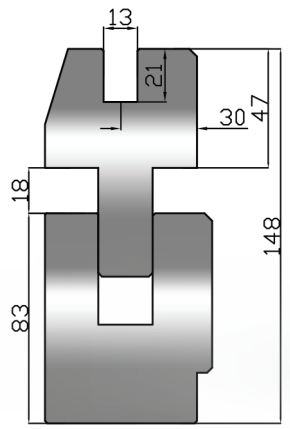


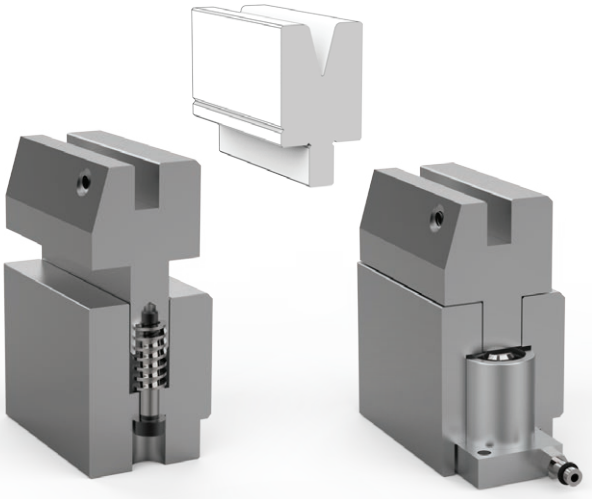
lunghezze - lengths mm 835 - 415 — acciaio - steel

835	415	C45 T HRC 52÷58
		42CrMo4 T HRC 52÷58

US 301 / M con molle - with springs / PN pneumatico - pneumatic

U mm 13 x 20 h	
altezza height	mm 148-130
max kN/mt	1000

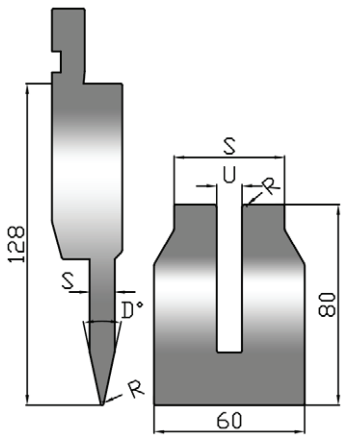




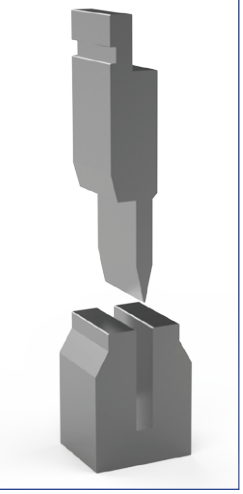
lunghezze - lengths mm 500 — acciaio - steel

500	42CrMo4 T HRC 52÷58

US 138



codice articolo item code **L**	H mm	S mm	D°	R mm	codice articolo item code **M**	H mm	U mm	S mm	R mm
US 138 L 8 max 800 kN/mt	128	8	24°	0,6	**US 138 M 8** max 500 kN/mt	80	8,1	40	1,0
US 138 L10 max 800 kN/mt	128	10	24°	0,6	**US 138 M10** max 500 kN/mt	80	10,1	44	1,0
US 138 L12 max 800 kN/mt	128	12	24°	0,6	**US 138 M12** max 500 kN/mt	80	12,1	46	1,0



Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura. Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.

We suggest to use these tools on syncronized press brakes as it is necessary to change quickly the press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on the flattened fold.

lunghezze - lengths mm 835 - 415 - fraz/sect 805 (8 pz/pcs) — acciaio - steel

835							415
10	15	20	40	50	100	200	370

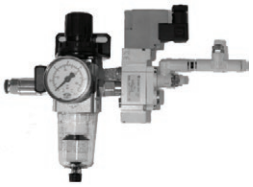
42CrMo4 T HRC 52÷58

AVVERTENZE WARNINGS

- utilizzare le matrici piegaschiaccia con utensili superiori con la stessa gradazione
- la tempra viene eseguita sia sulle parti di lavoro che di scorrimento
- un eventuale taglio a misura delle matrici piegaschiaccia richiede una valutazione tecnica
- per le matrici piegaschiaccia pneumatiche il KIT/PNEU viene fornito A RICHIESTA

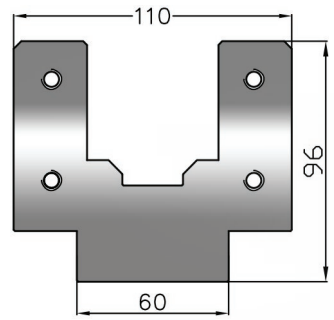
- employ these hemming tools with upper tool having the same degree
- induction hardened is applied on working surfaces and flowing parts
- any possible cut to size of the hemming tools requires a technical evaluation
- for pneumatic hemming tools the KIT/PNEU is supplied ON REQUEST

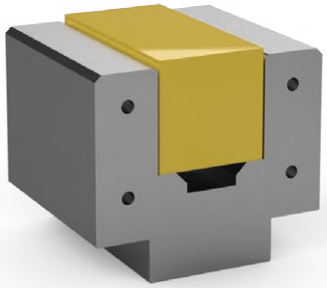
KIT/PNEU

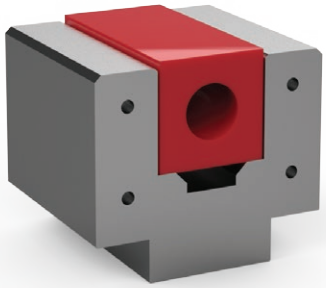


SPESSORE THICKNESS	X	POTENZA POWER		X	POTENZA POWER	
		Rm=450 N/mm²	Rm=700 N/mm²		Rm=450 N/mm²	Rm=700 N/mm²
mm	X mm	kN/mt	kN/mt	X mm	kN/mt	kN/mt
0,6	**3,0**	90	150	**1,2**	230	350
0,8	**3,0**	120	200	**1,6**	320	500
1,0	**3,5**	150	250	**2,0**	400	600
1,2	**3,5**	170	300	**2,4**	500	800
1,5	**4,6**	220	380	**3,0**	630	950
2,0	**5,5**	300	500	**4,0**	800	1300
2,5	**6,5**	550	900	**5,0**	900	1800
3,0	**8,0**	700	1000	**6,0**	1000	2100

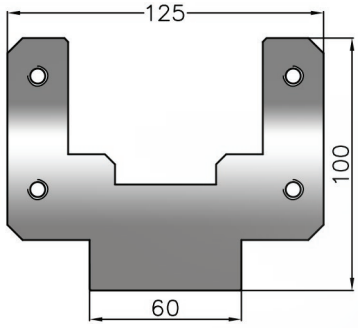
US 250	USG 50 mm 50x50	USG 50/F mm 50x50

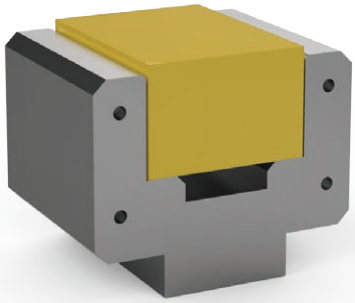


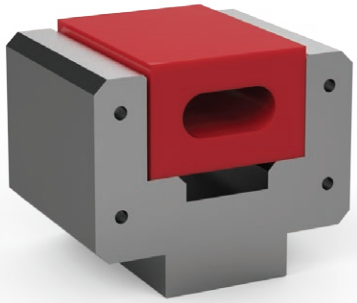




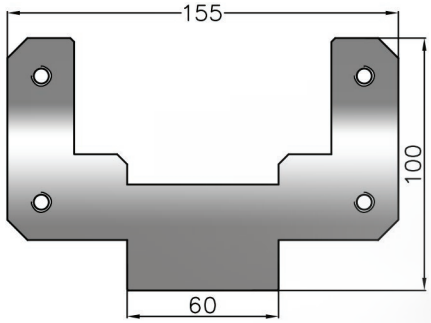
US 275	USG 75 mm 75x50	USG 75/F mm 75x50

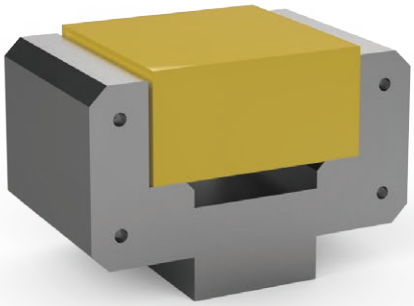


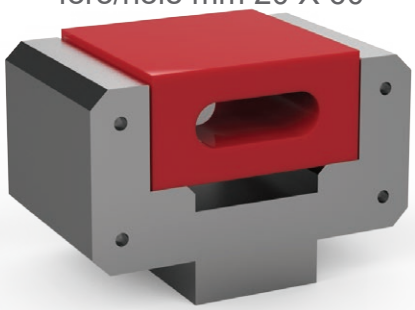




US 2100	USG 100 mm 100x50	USG 100/F mm 100x50





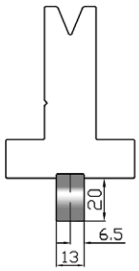


82 Shore (giallo-yellow)	92 Shore (rosso-red)

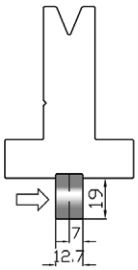
lunghezze - lengths mm 835 - 415 — acciaio - steel

835	*415*	C45

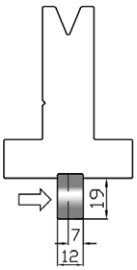
MODIFICHE ATTACCHI STANDARD - STANDARD CLAMPING MODIFICATION



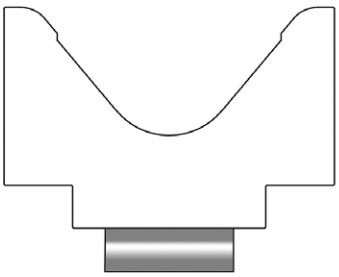
Z13



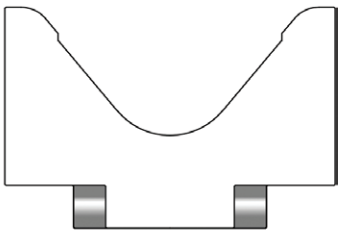
Z12,7



Z12

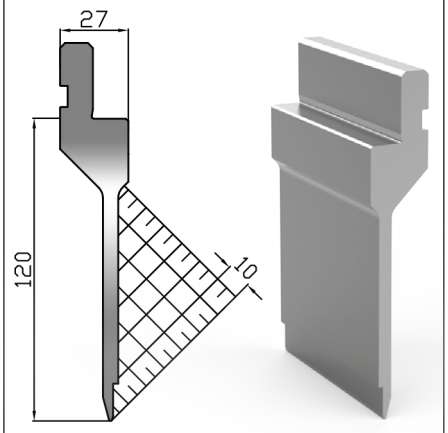


Z60 mm 60
Z90 mm 90



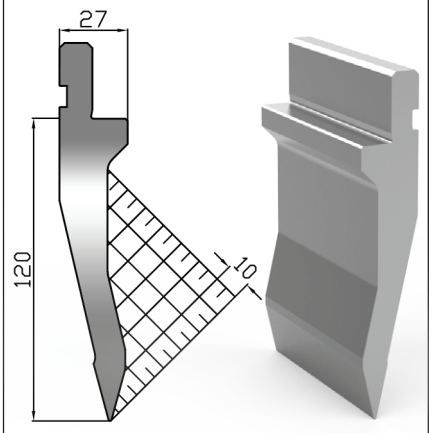
MODIFICA
MODIFICATION

USJ 120 EP/30° R0,6



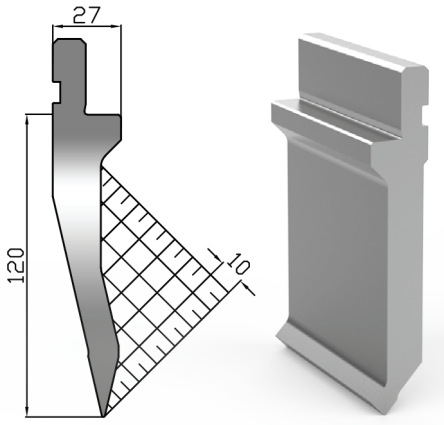
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	30°	0,6	450

USJ 120 EX/26° R0,6



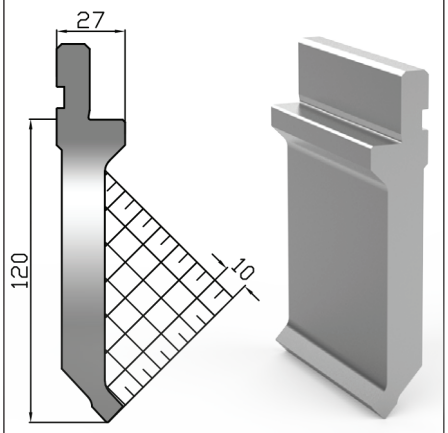
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	26°	0,6	1000

USJ 120 EX/30° R0,6



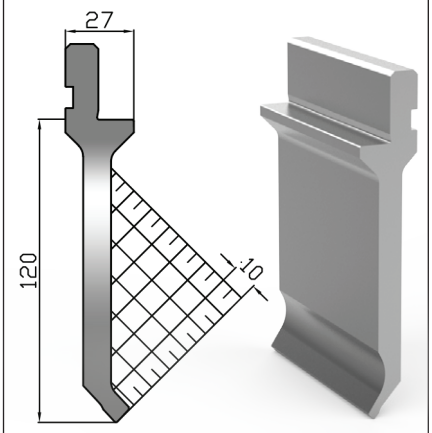
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	30°	0,6	1000

USJ 120 ED/86° R0,6



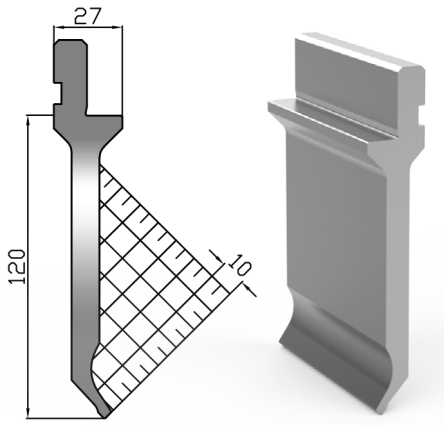
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	86°	0,6	1000

USJ 120 ES1/86° R0,6



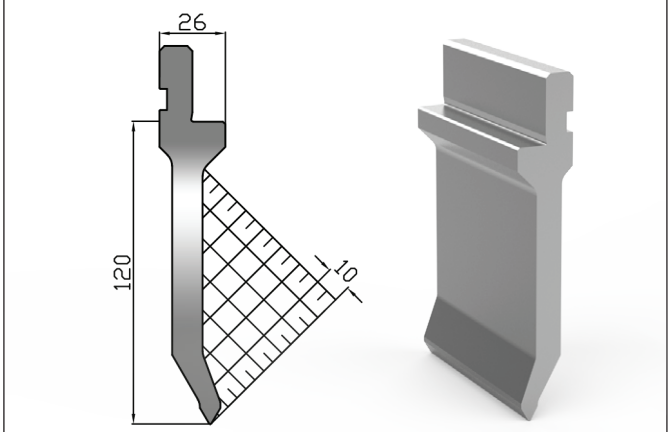
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	86°	0,6	500

USJ 120 ES2/86° R0,6



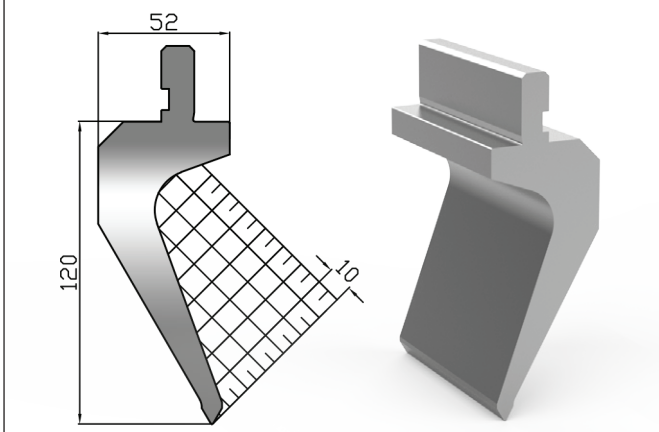
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	86°	0,6	300

USJ 120 ES/60° R0,6



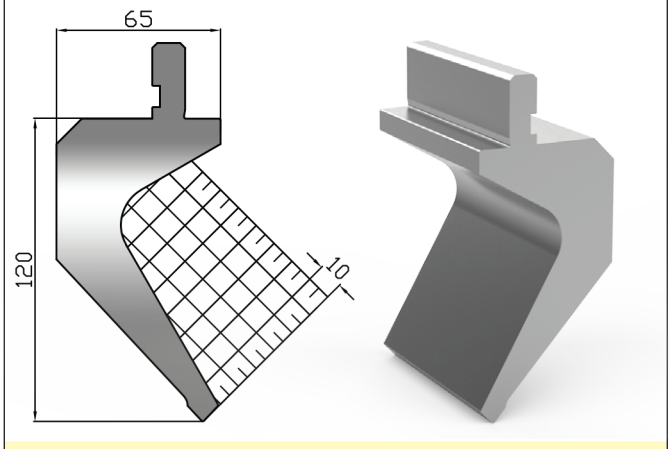
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	60°	0,6	700

USJ 120 EC/60° R0,6



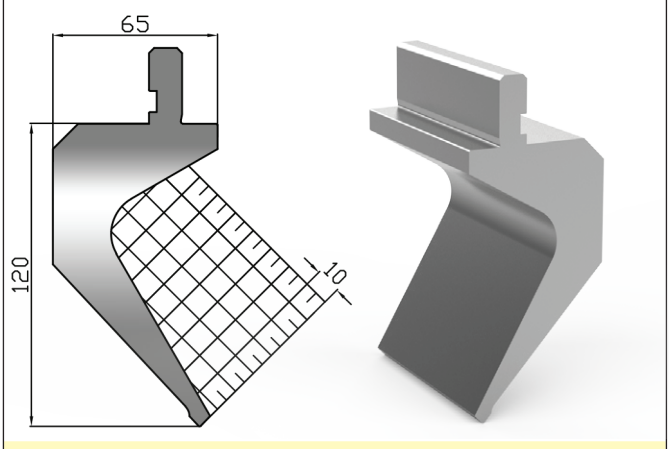
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	60°	0,6	700

USJ 120 EC1/86° R0,6



altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	86°	0,6	500

USJ 120 EC2/86° R0,6



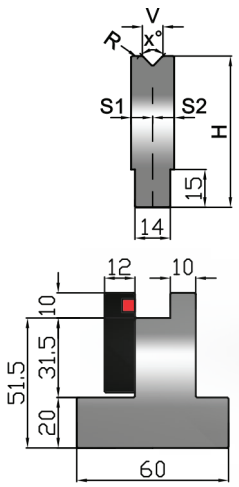
altezza height mm	angolo degree	raggio radius mm	max kN/mt
120,0	86°	0,6	450

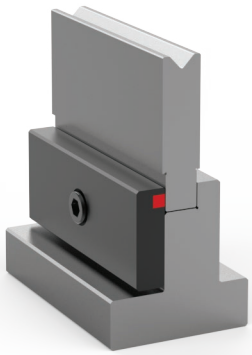
lunghezze - lengths mm 800 - 415 - fraz/sect 800 (10 pz/pcs) — acciaio - steel

835									415
10	15	15	20	40	50	150	100 L	100 R	300

42CrMo4 T HRC 52÷58

1V - serie USJ series





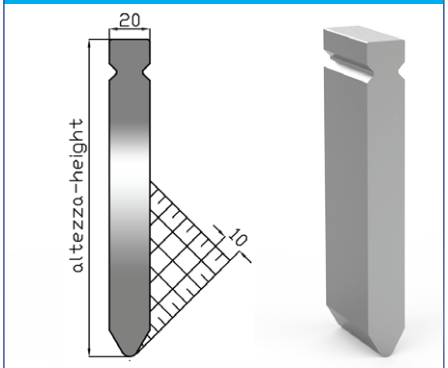
	codice articolo item code	V mm	H mm	R mm	S1+S2 mm	max kN/mt
86°	USJ V 6/86°	6	60	1,50	7,0+4,0	800
	USJ V 8/86°	8	60	1,50	7,0+5,0	900
	USJ V10/86°	10	60	2,00	7,0+6,5	1000
	USJ V12/86°	12	60	2,50	7,5+7,5	1000
	USJ V16/86°	16	60	2,50	10,0+10,0	1000
	USJ V20/86°	20	60	3,00	12,2+12,2	1000
	USJ V25/86°	25	60	3,00	14,75+14,75	1000
30°	USJ V 6/30°	6	60	1,00	8,5+8,5	500
	USJ V 8/30°	8	60	1,50	10,0+10,0	600
	USJ V10/30°	10	60	2,00	12,0+12,0	700
	USJ V12/30°	12	60	2,50	15,0+15,0	800
	USJ V16/30°	16	60	3,00	16,5+16,5	600
	USJ V20/30°	20	80	4,00	20,0+20,0	600
	USJ V25/30°	25	80	4,00	21,0+21,0	600
SUPPORTO MATRICI - TOOLS HOLDER						
	US 600	altezza - height			H mm 51,5	

lunghezze - lengths mm 800 - 415 - fraz/sect 800 (9 pz/pcs) — acciaio - steel

835								415
10	15	15	20	40	50	100	150	400

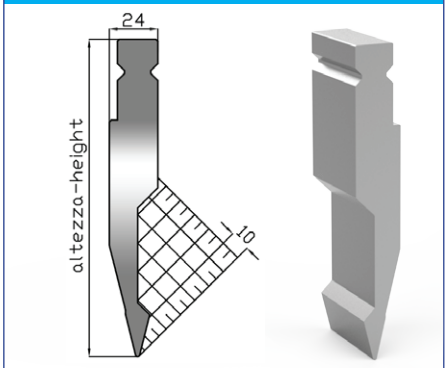
CrMo Nitr. & Phosp.

UST 157S/60°



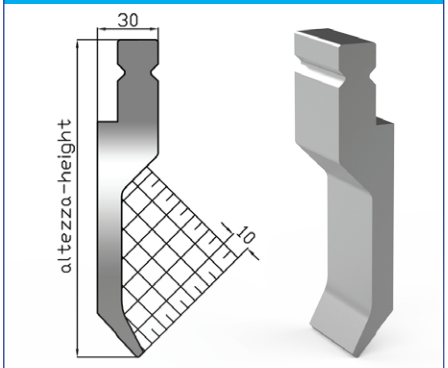
altezza height mm	angolo degree	raggio radius mm	max kN/mt
156,8	60°	2,0	1800
156,8		2,5	
156,8		3,0	
157,0		4,0	
156,1		4,7	
155,8		5,0	
154,6		6,0	
154,2		6,35	
157,0		8,0	
157,0		10,0	

UST 157X/28°



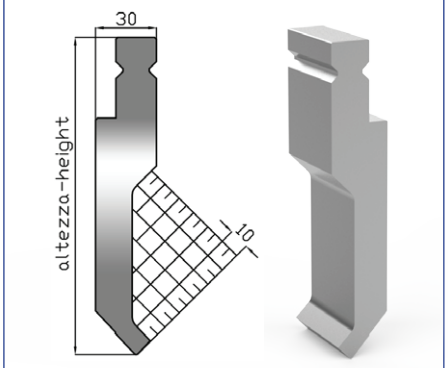
altezza height mm	angolo degree	raggio radius mm	max kN/mt
156,8	28°	0,5	600
157,0		1,0	
154,2		1,6	
153,0		2,0	
152,1		2,3	
151,4		2,5	
149,8		3,0	
149,7		3,2	
146,8		4,0	

UST 157DS/86°



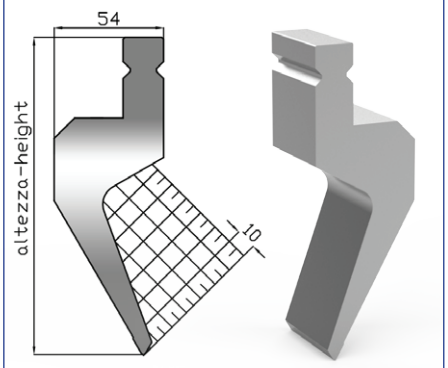
altezza height mm	angolo degree	raggio radius mm	max kN/mt
157	86°	1,0	400

UST 157D/86°



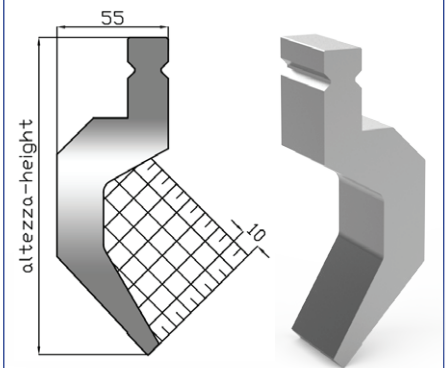
altezza height mm	angolo degree	raggio radius mm	max kN/mt
156,8	86°	0,5	800
157,0		1,0	
156,4		1,6	
156,2		2	
156,0		2,3	
156,0		2,5	
155,8		3,0	
155,6		3,2	
155,2		4,0	

UST 157C/60°



altezza height mm	angolo degree	raggio radius mm	max kN/mt
157	60°	1,0	700

UST 157C/86°



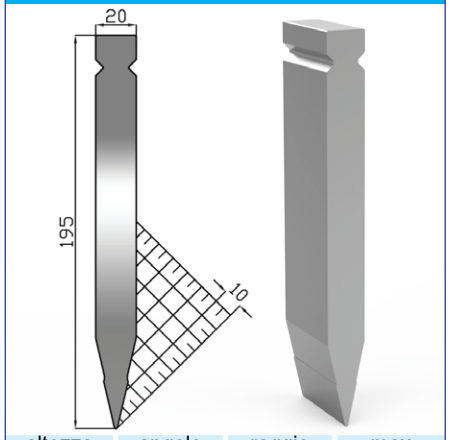
altezza height mm	angolo degree	raggio radius mm	max kN/mt
156,8	86°	0,5	800
157,0		1,0	
156,2		1,6	
156,2		2,0	
156,0		2,3	
156,0		2,5	
156,7		3,0	
155,6		3,2	
155,3		4,0	
154,3		6,0	

lunghezze - lengths mm 500 - fraz/sect 550 (10 pz/pcs) — acciaio - steel

500									
25	25	30	35	40	45	50	100	100 L	100 R

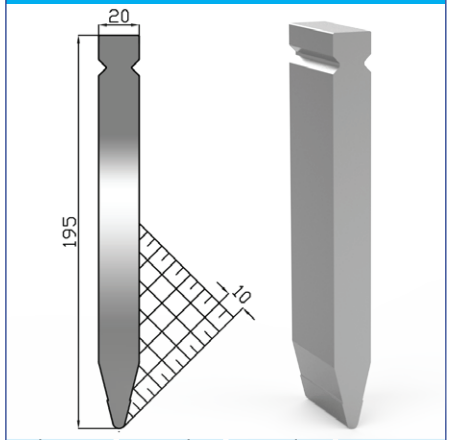
42CrMo4 T HRC 52÷58

UST 195S/26°R0,8



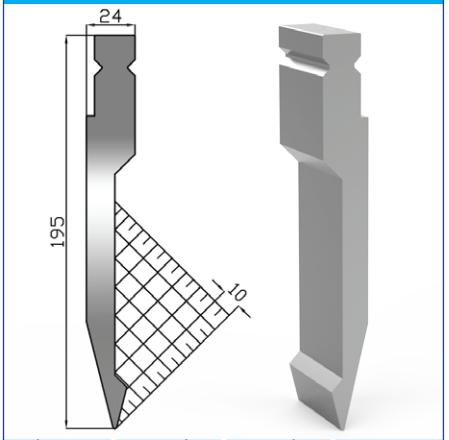
altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	26°	0,8	1000

UST 195S/28°R3,0



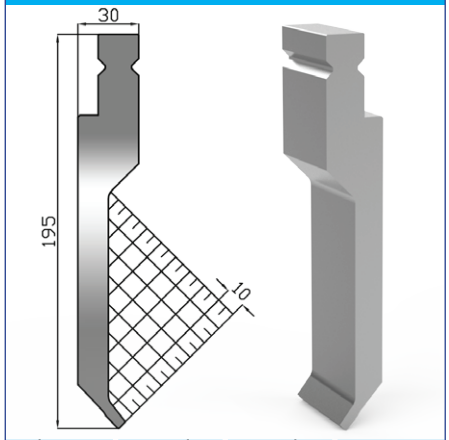
altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	28°	3,0	1000

UST 195X/28°R1,0



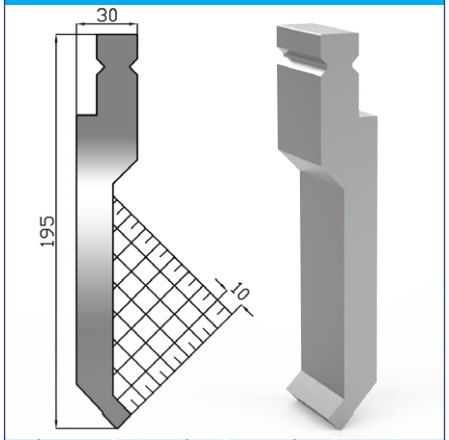
altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	28°	1,0	800

UST 195D/86°R0,6



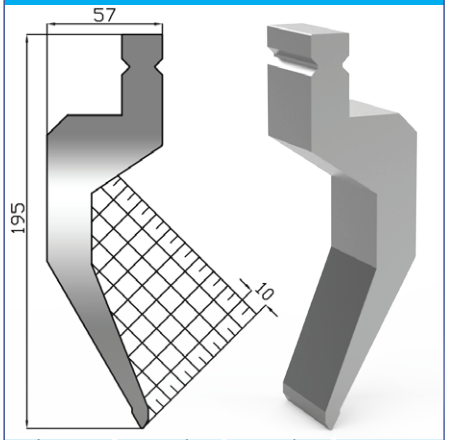
altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	86°	0,6	300

UST 195D/86°R0,8



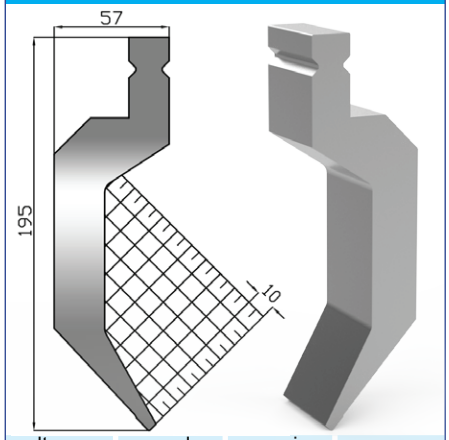
altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	86°	0,8	1000

UST 195C/60°R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	60°	0,8	400

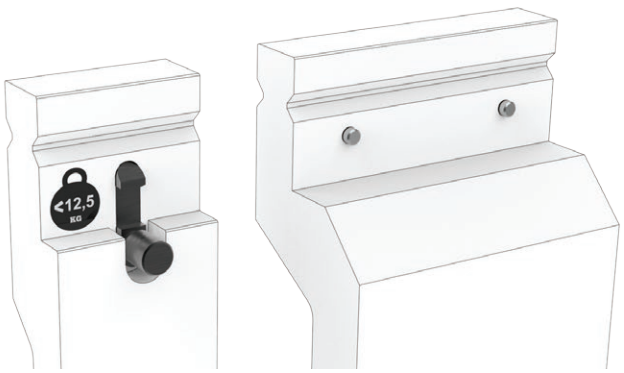
UST 195C/86°R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	86°	0,8	400

Gli utensili con peso inferiore a 12,5 kg vengono forniti con singolo o doppio pulsante.
Oltre tale peso l'utensile viene fornito con spine.

Tools with a weight less than 12,5 kg are supplied with a single or double push buttons.
Beyond such weight the tool is supplied with pins.



lunghezze - lengths mm 500 - fraz/sect 550 (10 pz/pcs) — acciaio - steel

500	25	25	30	35	40	45	50	100	100 L	100 R

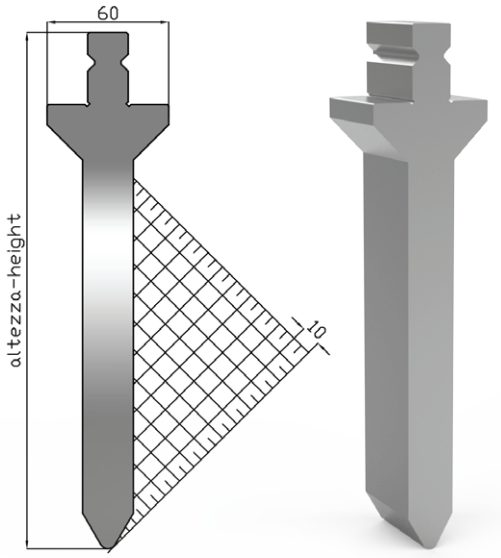
42CrMo4 T HRC 52÷58

H 255 mm

serie UST®

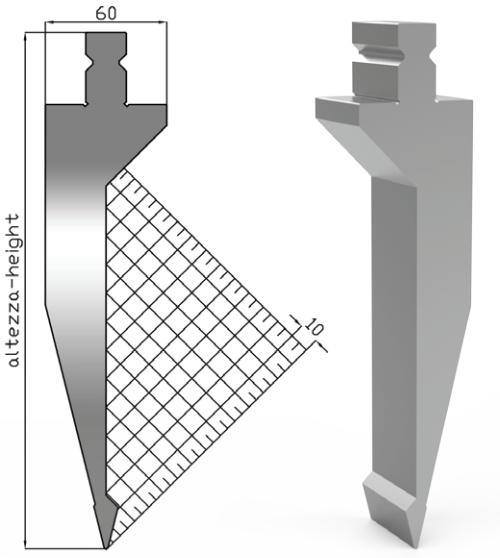
STANDARD TOOLS

UST 255S/60°



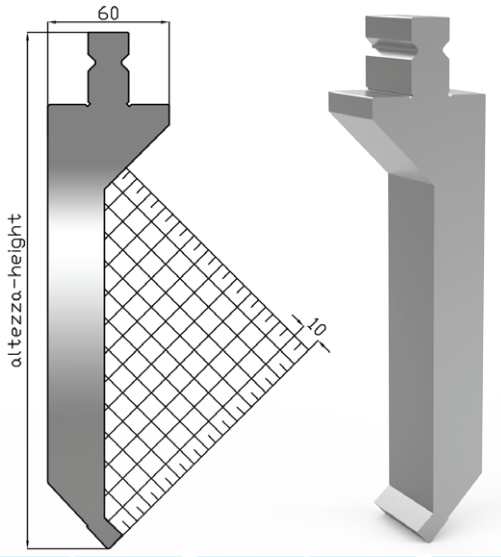
altezza height mm	raggio radius mm	altezza height mm	raggio radius mm	angolo degree	max kN/mt
255,6	2,0	254,4	5,0	60°	2500
255,6	2,5	253,4	6,0		
255,6	3,0	253,0	6,35		
255,8	4,0	255,8	8,0		
254,8	4,7	255,8	10,0		

UST 255X/28°



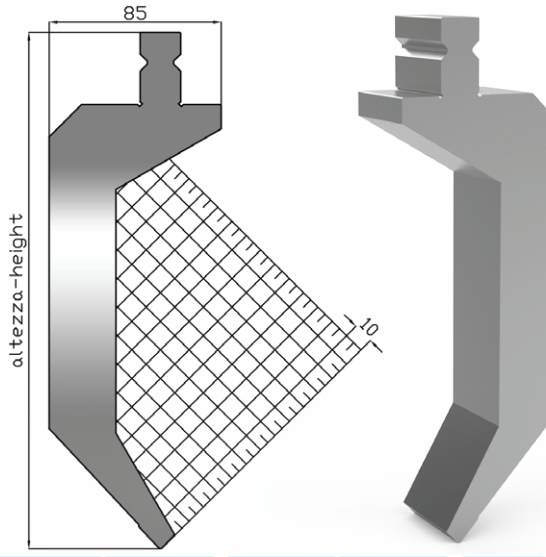
altezza height mm	raggio radius mm	altezza height mm	raggio radius mm	angolo degree	max kN/mt
255,6	0,5	249,8	2,5	28°	600
255,8	1,0	248,6	3,0		
253,6	1,6	248,5	3,2		
251,8	2,0	245,6	4,0		
251,4	2,3				

UST 255D/86°



altezza height mm	raggio radius mm	altezza height mm	raggio radius mm	angolo degree	max kN/mt
255,6	0,5	254,6	3,0	86°	800
255,8	1,0	254,4	3,2		
255,2	1,6	254,1	4,0		
255,0	2,0				
254,8	2,3				
254,5	2,5				

UST 255C/86°



altezza height mm	raggio radius mm	altezza height mm	raggio radius mm	angolo degree	max kN/mt
255,6	0,5	254,3	3,0	86°	800
255,8	1,0	254,3	3,2		
255,0	1,6	254,1	4,0		
255,0	2,0	253,6	5,0		
254,8	2,3	253,3	6,0		
254,5	2,5				

lunghezze - lengths mm 500 - fraz/sect 550 (10 pz/pcs)

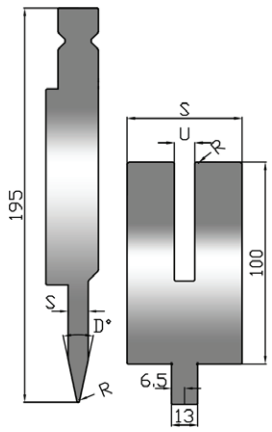
acciaio - steel

500

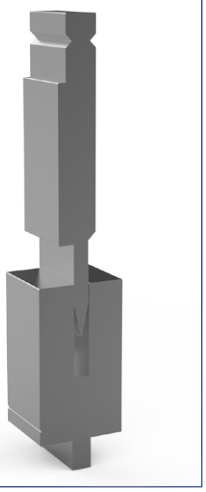
42CrMo4 T HRC 52÷58

25	25	30	35	40	45	50	100	100 L	100 R

UST 138



codice articolo item code **L**	H mm	S mm	D°	R mm	codice articolo item code **M**	H mm	U mm	S mm	R mm
UST 138 L 8 max 800 kN/mt	195	8	24°	0,6	**UST 138 M 8** max 500 kN/mt	100	8,1	50	1,0
UST 138 L10 max 800 kN/mt	195	10	24°	0,6	**UST 138 M10** max 500 kN/mt	100	10,1	57	1,0
UST 138 L12 max 800 kN/mt	195	12	24°	0,6	**UST 138 M12** max 500 kN/mt	100	12,1	57	1,0



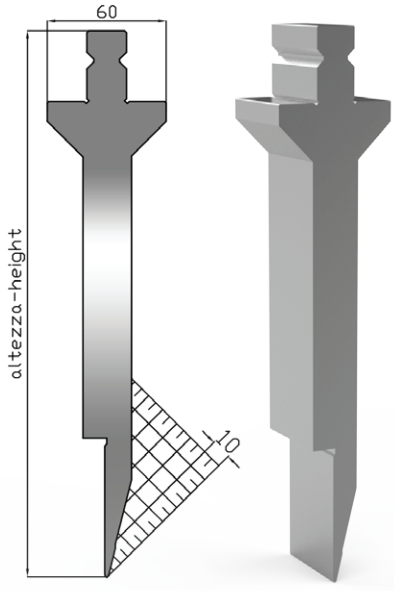
Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura. Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.

We suggest to use these tools on syncronized press brakes as it is necessary to change quickly the press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on the flattended.

lunghezze - lengths mm 500 - fraz/sect 550 (9 - 10 pz/pcs) — acciaio - steel

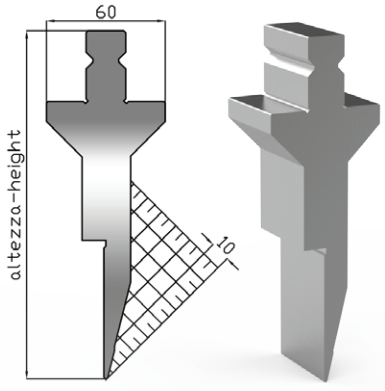
									500		
L	25	25	30	35	40	45	50	100	100 L	100 R	C45 T HRC 52÷58
M	25	25	30	35	40	45	50	100	200		

UST 275SP/28°



altezza height mm	angolo degree	raggio radius mm	max kN/mt
275,6	14°- 28°	0,5	400
275,8		1,0	

UST 175SP/28°

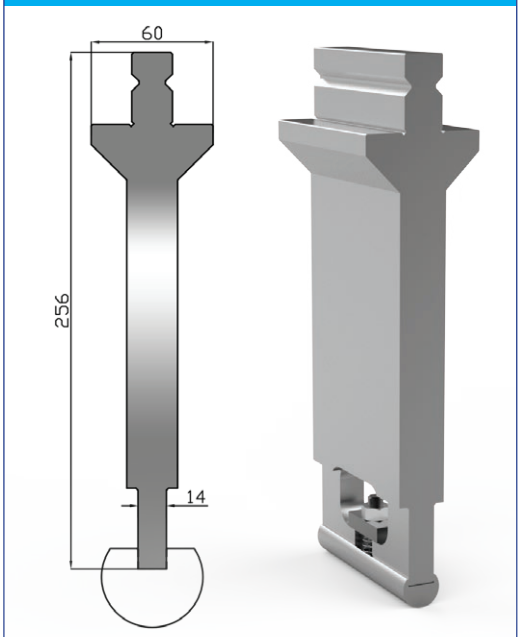


altezza height mm	angolo degree	raggio radius mm	max kN/mt
175,6	14 - 28°	0,5	400
175,8		1,0	

lunghezze - lengths mm 500 - fraz/sect 550 (10 pz/pcs) — acciaio - steel

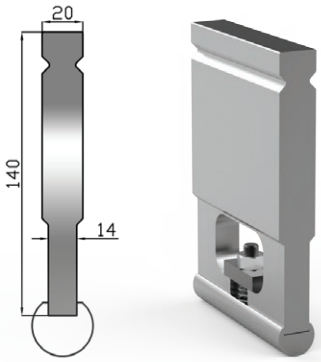
								500		
25	25	30	35	40	45	50	100	100 L	100 R	42CrMo4 T HRC 52÷58

UST 256



altezza height mm	raggio radius mm	max kN/mt
256	MIN 8 - MAX 50	800

UST 140



altezza height mm	raggio radius mm	max kN/mt
140	MIN 8 - MAX 50	800

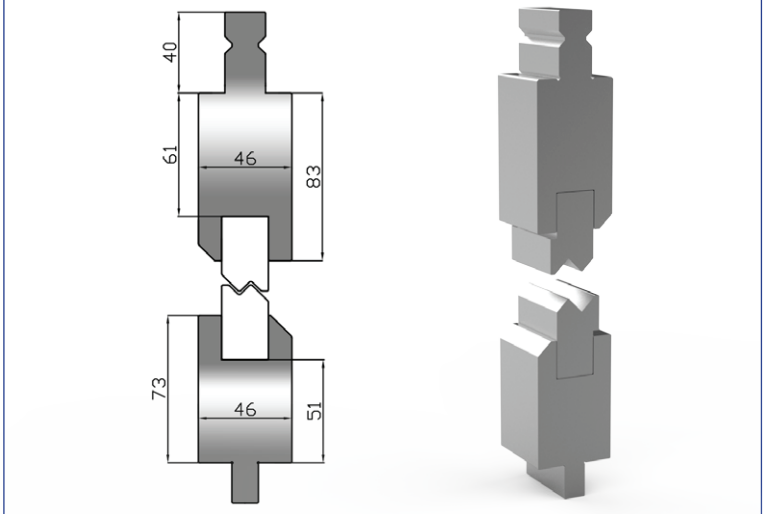
per gli elementi raggiati consultare la pagina 16

for the radius elements see page 16

lunghezze - lengths mm 835 (830) - 415 (412) — acciaio - steel

835	415	C45

UST 130



altezza height mm	max kN/mt
83 + 73	1000

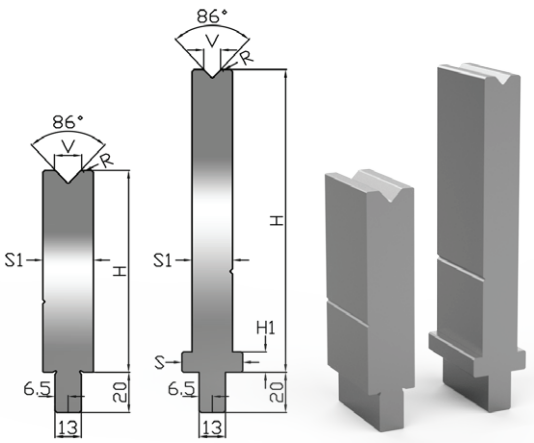
per gli elementi zeta consultare la pagina 18

for the offset elements see page 18

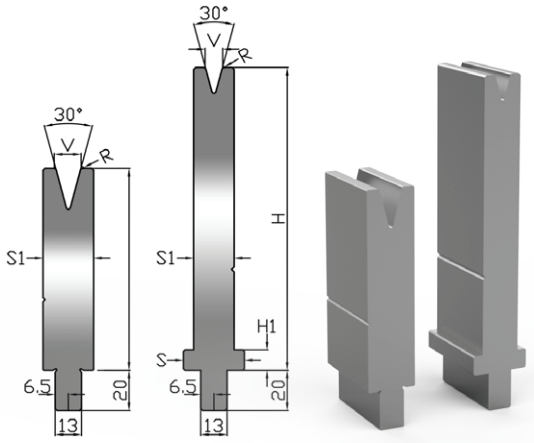
lunghezze - lengths mm 835 (830) - 415 (412) — acciaio - steel

835	415	C45 T HRC 52÷58

1V - serie 13 series

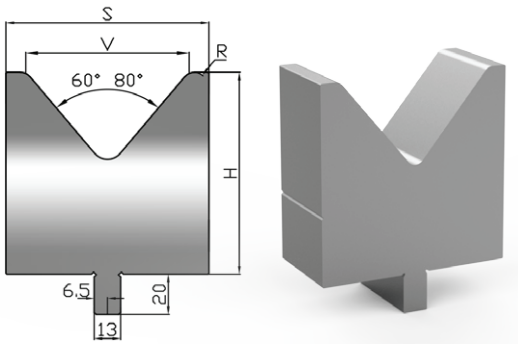


	codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
86°	UST100N-S/86°V04	4	0,6	100-14	20 - 8	250
	UST100 N / 86° V06	6	0,6	100	20	1200
	UST100 N / 86° V08	8	0,8	100	20	1150
	UST100 N / 86° V10	10	1,0	100	20	1100
	UST100 N / 86° V12	12	1,0	100	25	1200
	UST100 N / 86° V16	16	1,6	100	30	1200
	UST100 N / 86° V20	20	2,0	100	30	1150
	UST100 N / 86° V24	24	2,5	100	35	1200
	UST100 N / 86° V30	30	3,0	100	45	1200
	UST100 N / 86° V40	40	3,0	100	55	1200
	UST100 N / 86° V50	50	3,0	100	75	1500
	UST150 N / 86° V06	6	0,6	150-10	30-20	1200
	UST150 N / 86° V08	8	0,8	150-10	30-20	1150
	UST150 N / 86° V10	10	1,0	150-10	30-20	1100
	UST150 N / 86° V12	12	1,0	150	25	1200
	UST150 N / 86° V16	16	1,6	150	30	1200
	UST150 N / 86° V20	20	2,0	150	30	1150



30°	UST100 N / 30° V06	6	0,6	100	20	400
	UST100 N / 30° V08	8	1,0	100	20	400
	UST100 N / 30° V10	10	1,0	100	20	400
	UST100 N / 30° V12	12	1,0	100	25	400
	UST100 N / 30° V16	16	1,6	100	30	500
	UST100 N / 30° V20	20	2,0	100	35	600
	UST100 N / 30° V24	24	2,5	100	40	650
	UST100 N / 30° V30	30	3,0	100	55	900
	UST100 N / 30° V40	40	5,0	100	60	900
	UST150 N / 30° V06	6	0,6	150-10	30-20	400
	UST150 N / 30° V08	8	1,0	150-10	30-20	400
	UST150 N / 30° V10	10	1,0	150-10	30-20	400
	UST150 N / 30° V12	12	1,0	150	25	400
	UST150 N / 30° V16	16	1,6	150	30	500
	UST150 N / 30° V20	20	2,0	150	35	600
	UST150 N / 30° V24	24	2,5	150	40	650
	UST150 N / 30° V30	30	3,0	150	55	900
	UST150 N / 30° V40	40	5,0	150	60	900

1V - serie 13 series



	codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
80°	UST150 N / 80° V24	24	2,0	150	35	1000
	UST150 N / 80° V30	30	5,0	150	45	900
	UST150 N / 80° V40	40	5,0	150	55	1200
	UST150 N / 80° V50	50	5,0	150	65	1500
	UST100 N / 80° V60	60	5,0	100	75	1500
	UST100 N / 80° V70	70	5,0	100	85	1500
	UST100 N / 80° V80	80	5,0	100	100	1500
	UST120 N / 80° V90	90	8,0	120	110	1500
	UST120 N / 80°V100	100	8,0	120	120	1500
60°	UST120 N / 60°V120	120	8,0	120	145	1600

lunghezze - lengths mm 500 - fraz/sect C 250 (7 pz/pcs) - M 550 (9 PZ/PCS) — acciaio - steel

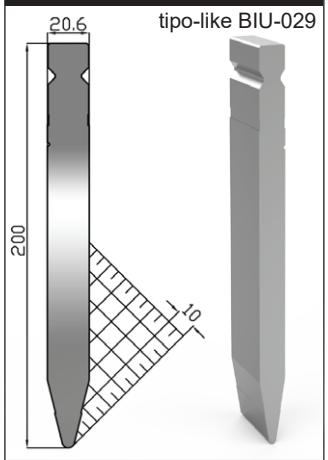
					500				
C	25	25	30	35	40	45	50	42CrMo4 T HRC 52÷58	
M	25	25	30	35	40	45	50	100	200

H 200 mm

serie USW®

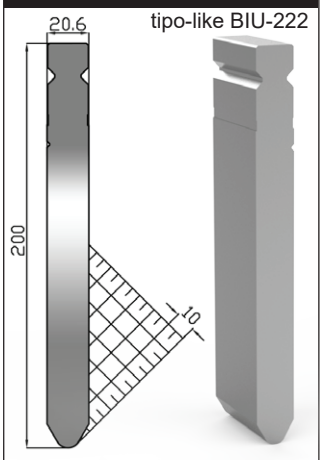
STANDARD TOOLS

USW 200S/28°R3,0



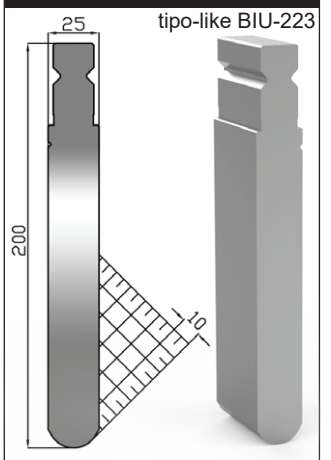
altezza height mm	angolo degree	raggio radius	max kN/mt
200,0	28°	3,0	1600

USW 200S/60°R6,0



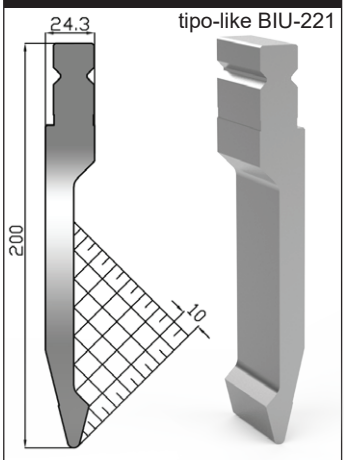
altezza height mm	angolo degree	raggio radius	max kN/mt
200,0	60°	6,0	1600

USW 200S/60°R12,5



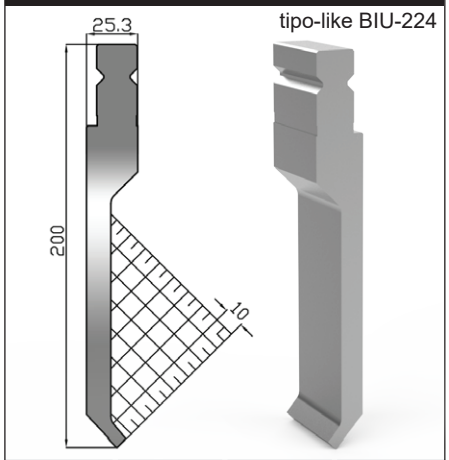
altezza height mm	angolo degree	raggio radius	max kN/mt
200,0	60°	12,5	2250

USW 200X/28°R3,0



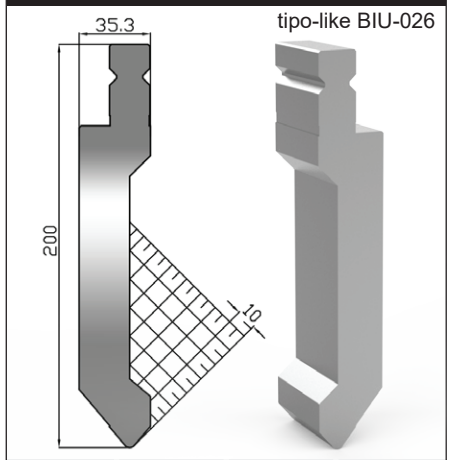
altezza height mm	angolo degree	raggio radius	max kN/mt
200,0	28°	3,0	1000

USW 200D/86°R0,6



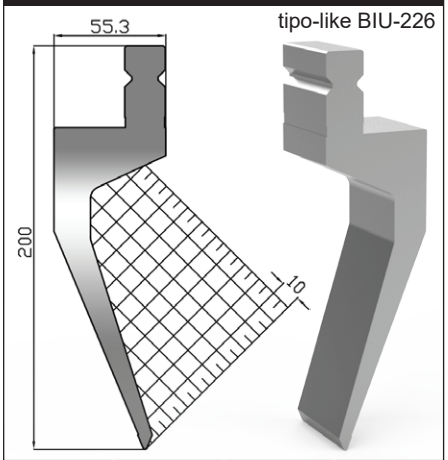
altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	86°	0,6	450

USW 200DP/80°R3,0



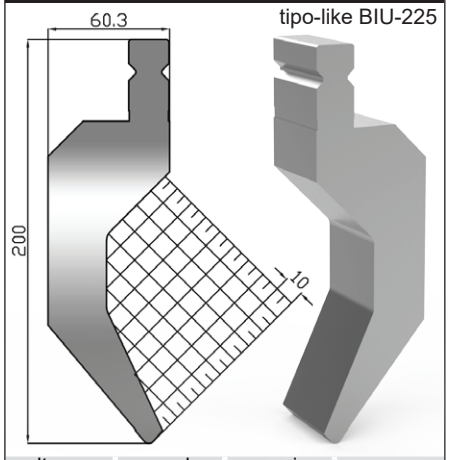
altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	80°	3,0	1400

USW 200C/45°R1,0



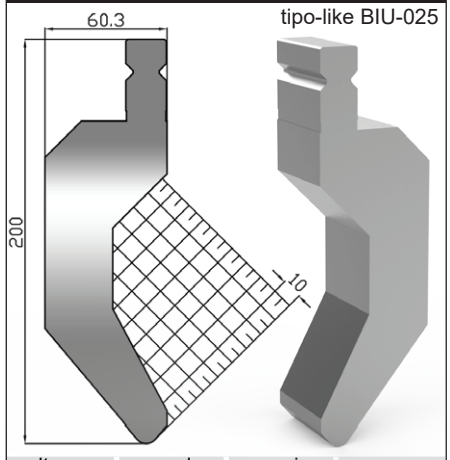
altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	45°	1,0	400

USW 200CP/80°R3,0



altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	80°	6,0	900

USW 200CP/80°R6,0



altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	80°	6,0	1300

lunghezze - lengths
mm 515 - fraz/sect 550 (8 pz/pcs)

515

20 *25* *30* *35* *40*

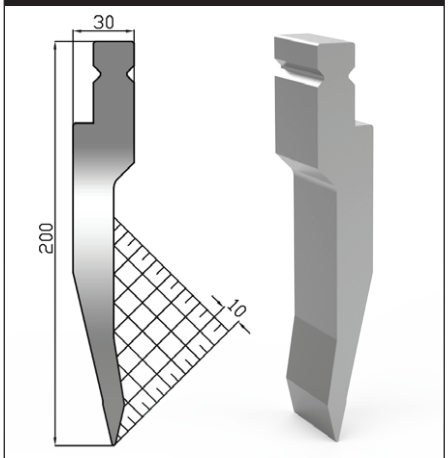
100 L *100 R*

200

acciaio - steel

42CrMo4 T HRC 52÷58

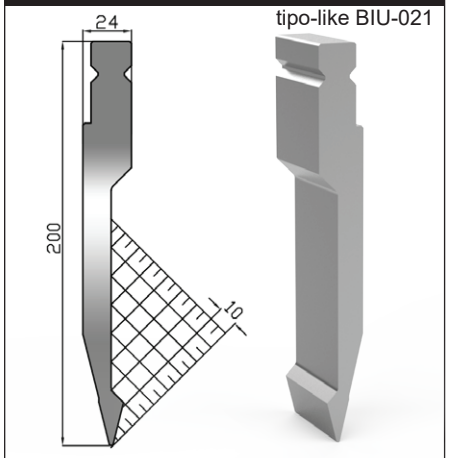
USW 200X/26°R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	26°	0,8	700

USW 200X/28°R1,0

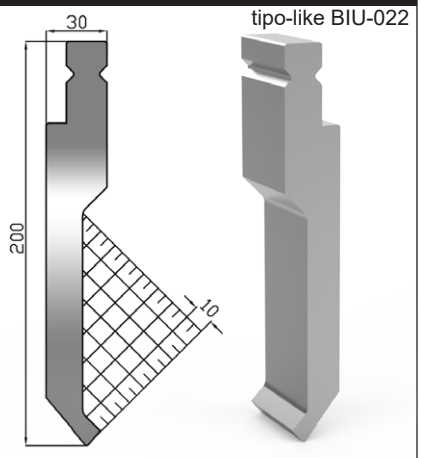
tipo-like BIU-021



altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	28°	1,0	700

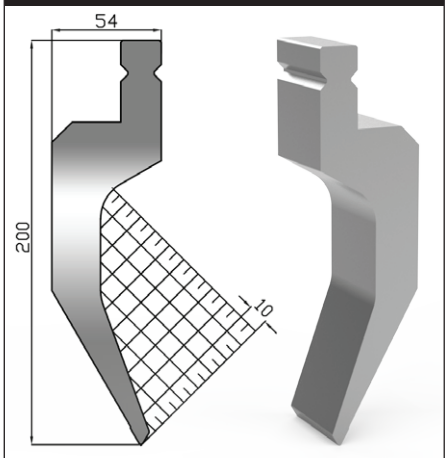
USW 200D/80°R1,0

tipo-like BIU-022



altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	80°	1,0	800

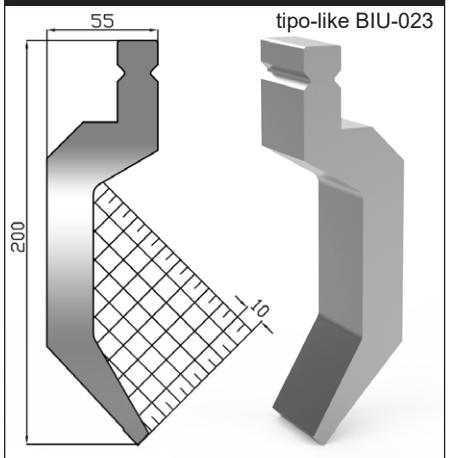
USW 200C/60°R1,0



altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	60°	1,0	700

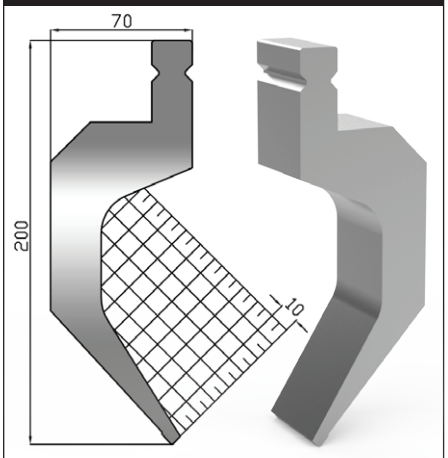
USW 200C/86°R1,0

tipo-like BIU-023



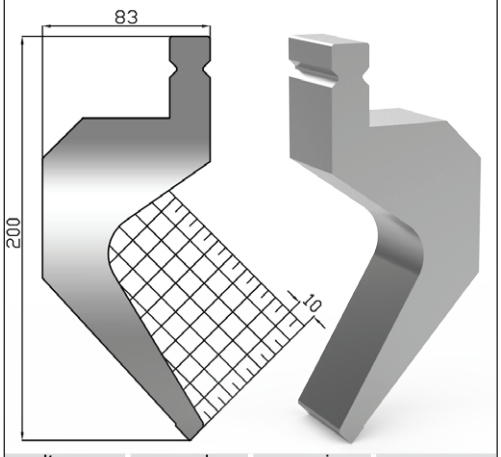
altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	86°	1,0	650

USW 200CS/85°R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	85°	0,8	600

USW 200C/85°R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
200,0	85°	0,8	800

lunghezze - lengths
mm 500 - fraz/sect 550 (10 pz/pcs)

500

25 *25* *30* *35* *40*

45 *50*

100 L *100 R* *100*

acciaio - steel

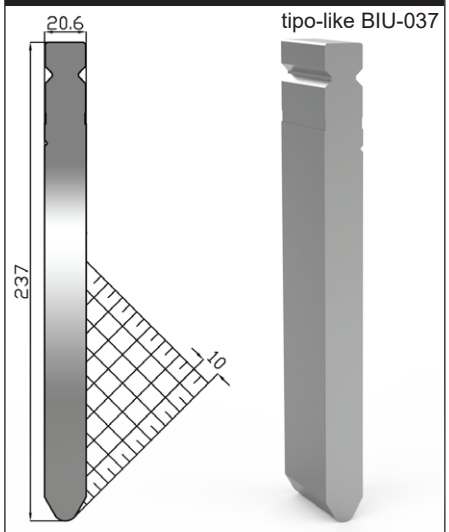
42CrMo4 T HRC 52÷58

H 237 mm

serie USW®

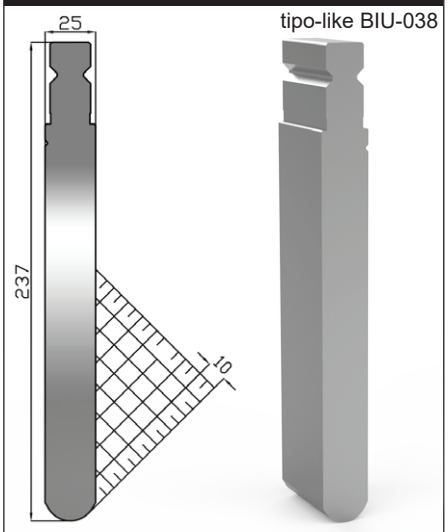
STANDARD TOOLS

USW 237S/60°R6,0



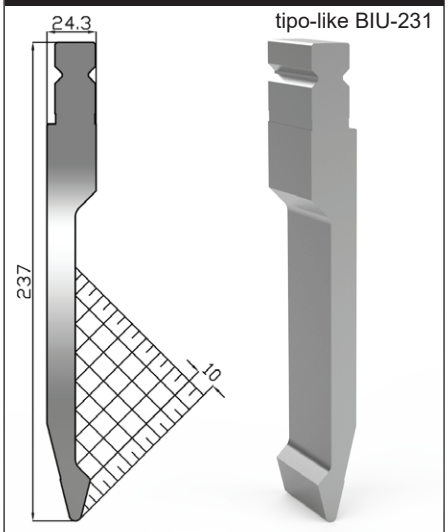
altezza height mm	angolo degree	raggio radius mm	max kN/mt
237,0	60°	6,0	1600

USW 237S/60°R12,5



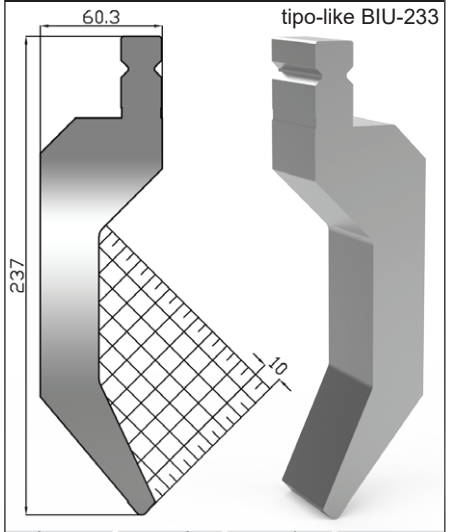
altezza height mm	angolo degree	raggio radius mm	max kN/mt
237,0	60°	12,5	2250

USW 237X/28°R3,0



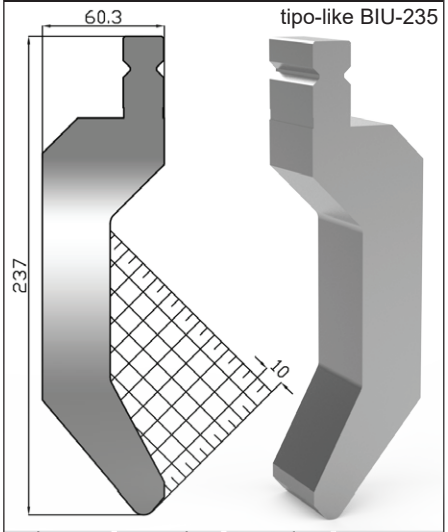
altezza height mm	angolo degree	raggio radius mm	max kN/mt
237,0	28°	3,0	1000

USW 237CP/80°R3,0



altezza height mm	angolo degree	raggio radius mm	max kN/mt
237,0	80°	3,0	900

USW 237CP/80°R6,0



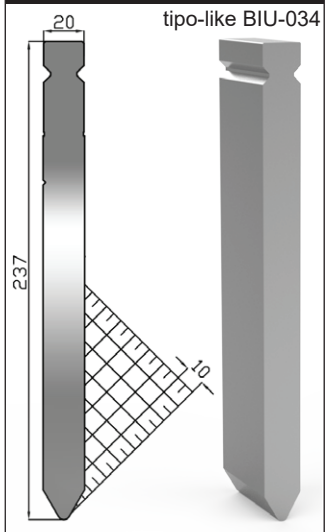
altezza height mm	angolo degree	raggio radius mm	max kN/mt
237,0	80°	6,0	1300

lunghezze - lengths mm 515 - fraz/sect 550 (8 pz/pcs) — acciaio - steel

515								
20	25	30	35	40	100 L	100 R	200	

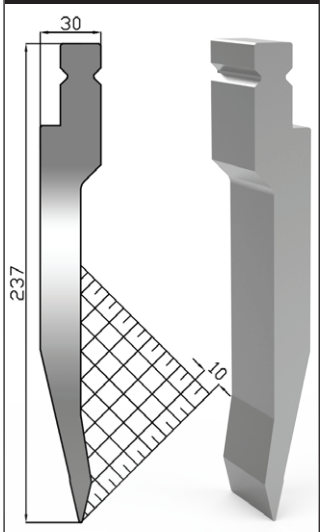
42CrMo4 T HRC 52÷58

USW 237S/60°R3,0



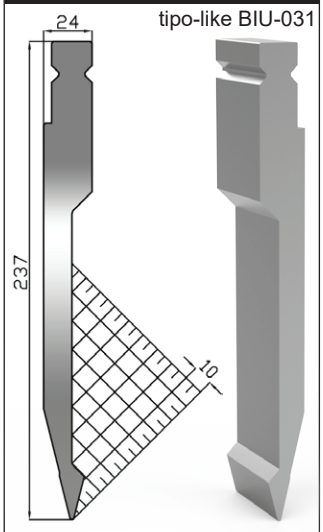
altezza height mm	angolo degree	raggio radius	max kN/mt
237,0	60°	3,0	1600

USW 237X/26°R0,8



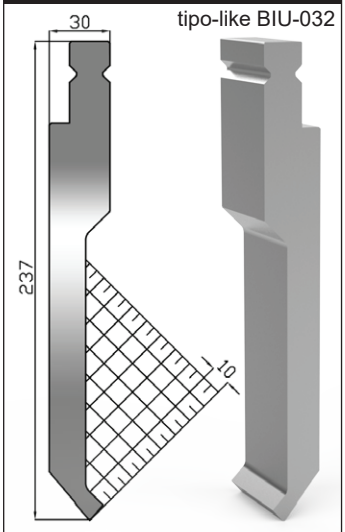
altezza height mm	angolo degree	raggio radius	max kN/mt
237,0	26°	0,8	1000

USW 237X/28°R1,0



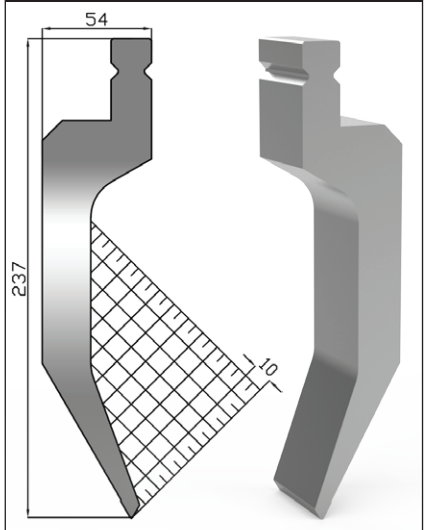
altezza height mm	angolo degree	raggio radius	max kN/mt
237,0	28°	1,0	600

USW 237D/80°R1,0



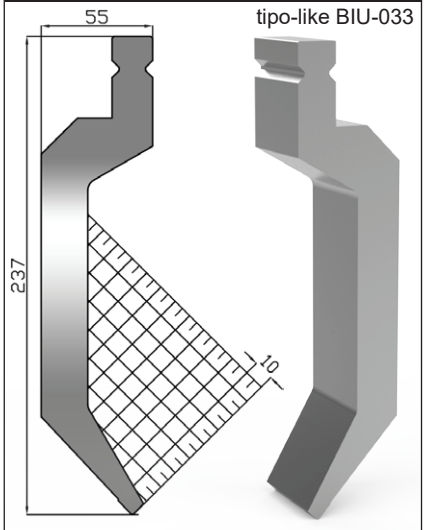
altezza height mm	angolo degree	raggio radius	max kN/mt
237,0	80°	1,0	800

USW 237C/60°R1,0



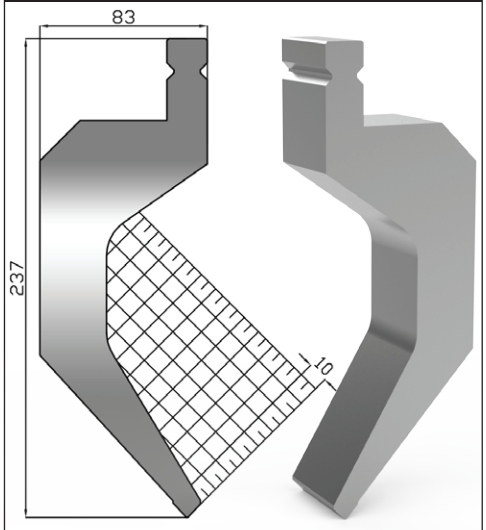
altezza height mm	angolo degree	raggio radius mm	max kN/mt
237,0	60°	1,0	700

USW 237C/86°R1,0



altezza height mm	angolo degree	raggio radius mm	max kN/mt
237,0	86°	1,0	500

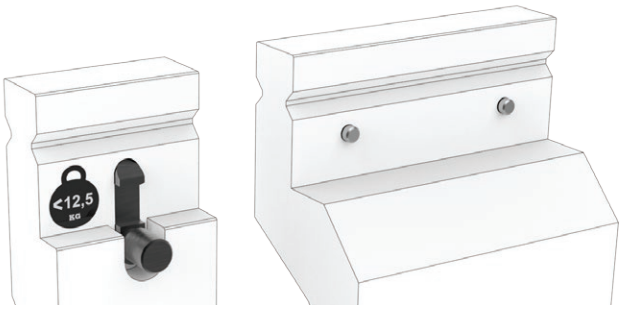
USW 237C/85°R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
237,0	85°	0,8	800

Gli utensili con peso inferiore a 12,5 kg vengono forniti con singolo o doppio pulsante.
Oltre tale peso l'utensile viene fornito con spine.

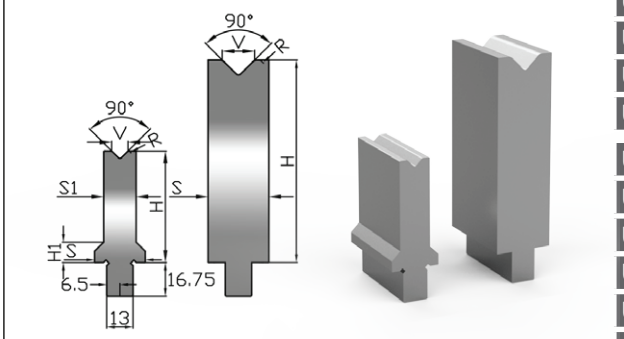
Tools with a weight less than 12,5 kg are supplied with a single or double push buttons.
Beyond such weight the tool is supplied with pins.



lunghezze - lengths mm 500 - fraz/sect 550 (10 pz/pcs) — acciaio - steel

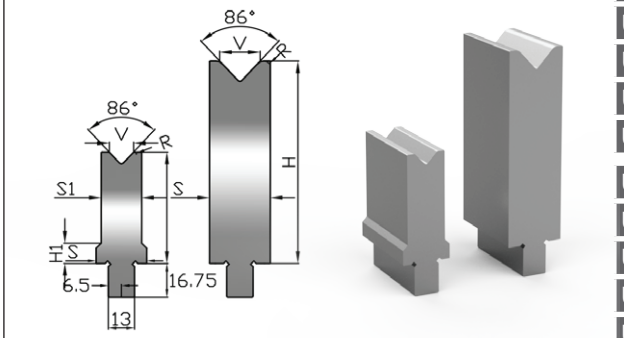
							500			
25	*25*	*30*	*35*	*40*	*45*	*50*	*100 L*	*100 R*	*100*	42CrMo4 T HRC 52÷58

90°



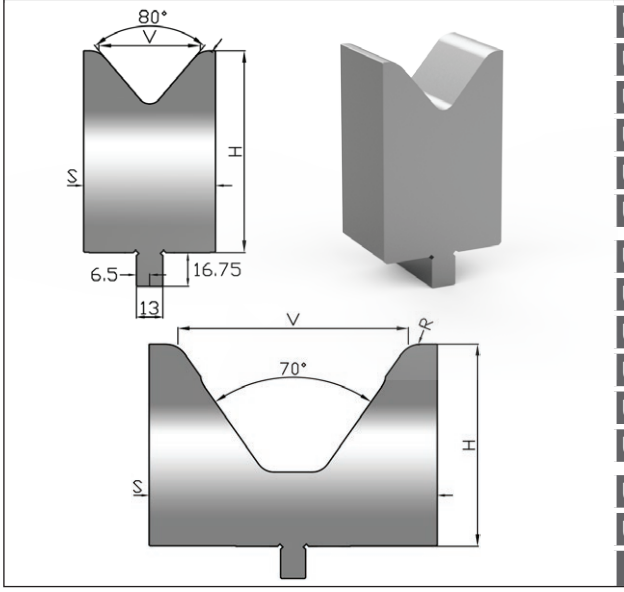
codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USW V 6/90° H 55 (041)	6	1,0	55-10	25-16	1200
USW V 8/90° H 55 (042)	8	1,0	55-10	25-16	1200
USW V10/90° H 55 (043)	10	1,0	55-10	25-20	1200
USW V12/90° H 55 (044)	12	1,0	55-10	25-20	1200
USW V16/90° H 55 (045)	16	1,5	55	30	1200
USW V 6/90° H100 (341)	6	2,0	100-10	25-16	1200
USW V 8/90° H100 (342)	8	2,5	100-10	25-16	1200
USW V10/90° H100 (343)	10	2,5	100-10	25-20	1200
USW V12/90° H100 (344)	12	3,0	100-10	25-20	1200
USW V16/90° H100 (345)	16	3,5	100-10	30	1200
USW V20/90° H100 (346)	20	4,0	100-10	35	1200

86°



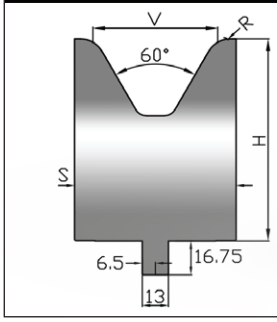
codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USW V 4/86° H 55 (024)	4	0.4	55-10	25-10	450
USW V 6/86° H 55 (021)	6	1,0	55-10	25-16	1200
USW V 8/86° H 55 (010)	8	1,0	55-10	25-16	1200
USW V10/86° H 55 (022)	10	1,0	55-10	25-20	1200
USW V12/86° H 55 (011)	12	1,0	55-10	25-20	1200
USW V16/86° H 55 (012)	16	1,5	55	25	1200
USW V20/86° H 55 (023)	20	2,0	55	30	1200
USW V 4/86° H100 (336)	4	0,8	100-10	25-10	450
USW V 6/86° H100 (321)	6	2,0	100-10	25-16	1200
USW V 8/86° H100 (310)	8	2,5	100-10	25-16	1200
USW V10/86° H100 (322)	10	2,5	100-10	25-20	1200
USW V12/86° H100 (311)	12	3,0	100-10	25-20	1200
USW V16/86° H100 (312)	16	3,5	100	25	1200
USW V20/86° H100 (323)	20	4,0	100	30	1200

80° - 70°



codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
USW V 24/80°H 55 (013)	24	2,5	55	35	1250
USW V 30/80°H 55 (014)	30	3,0	55	40	1250
USW V 40/80°H 55 (015)	40	4,0	55	50	1250
USW V 50/80°H 55 (035)	50	5,0	55	75	1500
USW V 80/80°H 65 (017)	80	8,0	65	100	1500
USW V100/80°H 85 (018)	100	10,0	85	125	1500
USW V 24/80°H100 (313)	24	5,0	100	35	1250
USW V 30/80°H100 (324)	30	6,0	100	40	1250
USW V 40/80°H100 (325)	40	8,0	100	55	1250
USW V 50/80°H100 (326)	50	10,0	100	65	1500
USW V 80/80°H100 (317)	80	16,0	100	105	1500
USW V100/80°H100 (318)	100	20,0	100	130	1500
USW V120/70°H105 (070)	120	12,0	105	150	2500
USW V160/70°H140 (071)	160	16,0	140	200	2500

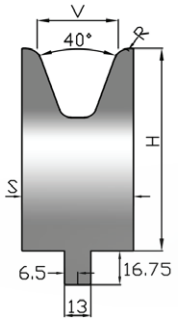
60°



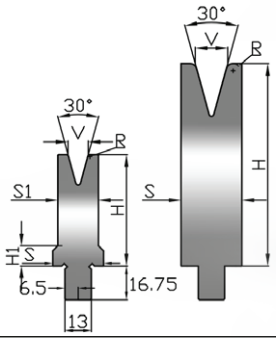


codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
USW V 60/60°H 65 (016)	60	6,0	65	80	1250
USW V 60/60°H100 (327)	60	12,0	100	80	1250
USW V 80/60°H100 (372)	80	16,0	100	110	2200
USW V100/60°H120 (373)	100	20,0	120	140	2500
tempra profonda - deep hardening					
USW V120/60°H135 (374)	120	24,0	135	170	2700
USW V160/60°H180 (375)	160	32,0	180	220	3000
USW V200/60°H220 (376)	200	40,0	220	300	3500

40° - 30°









codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USW V 30/40°H 55 (031)	30	3,0	55	40	700
USW V 40/40°H 55 (032)	40	4,0	55	50	800
USW V 30/40°H100 (328)	30	6,0	100	45	1000
USW V 40/40°H100 (329)	40	8,0	100	55	1250
USW V 6/30° H 55 (061)	6	1,0	55-10	25-16	800
USW V 8/30° H 55 (051)	8	1,0	55-10	25-16	800
USW V10/30° H 55 (062)	10	1,0	55-10	25-20	800
USW V12/30° H 55 (052)	12	1,0	55-10	25-20	800
USW V16/30° H 55 (053)	16	1,5	55	30	800
USW V20/30° H 55 (063)	20	2,0	55	35	800
USW V24/30° H 55 (054)	24	2,5	55	40	800
USW V 6/30° H100 (361)	6	2,0	100-10	25-16	800
USW V 8/30° H100 (351)	8	2,5	100-10	25-16	800
USW V10/30° H100 (362)	10	2,5	100-10	25-20	800
USW V12/30° H100 (352)	12	3,0	100-10	25-20	800
USW V16/30° H100 (353)	16	3,5	100	30	800
USW V20/30° H100 (363)	20	4,0	100	35	800
USW V24/30° H100 (354)	24	5,0	100	40	800

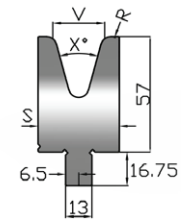
lunghezze - lengths mm 515 - 255 fraz/sect 550 (8 pz/pcs) — acciaio - steel

515	255 *(V80 ÷ 200 mm)*

20	25	30	35	40	100	100	200

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30° - 40° - 60°





codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
USW V 8/30° H 57 (401)	8	2,5	57	22	600
USW V10/30° H 57 (402)	10	2,5	57	22	600
USW V12/30° H 57 (403)	12	3,0	57	22	600
USW V16/30° H 57 (404)	16	3,5	57	30	600
USW V24/30° H 57 (405)	24	5,0	57	40	600
USW V30/40°H 57 (406)	30	6,0	57	45	700
USW V40/40°H 57 (407)	40	8,0	57	55	800
USW V 50/60°H 57 (408)	50	10,0	57	75	1000

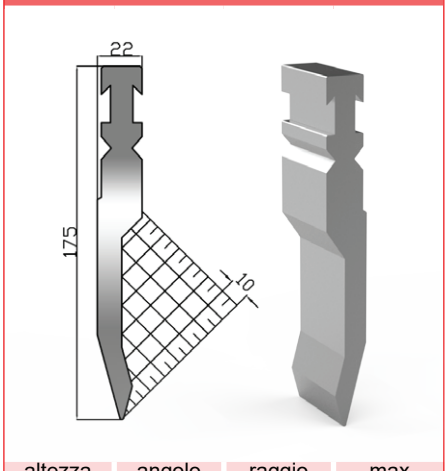
lunghezze - lengths mm 515 - fraz/sect 475 (8 pz/pcs) — acciaio - steel

515

20	25	30	35	40	100	100	125

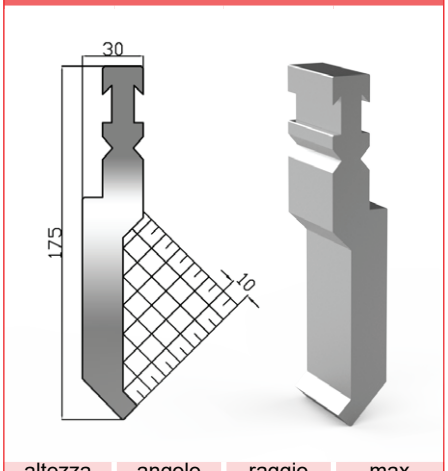
C45 T HRC 52÷58

USB 175/30°R1,0 / RFA



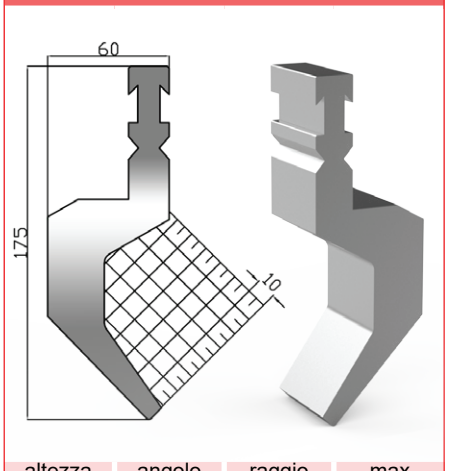
altezza height mm	angolo degree	raggio radius mm	max kN/mt
175,0	30°	1,0	800

USB 175/88°D R1,0 / RFA



altezza height mm	angolo degree	raggio radius mm	max kN/mt
175,0	88°	1,0	1000

USB 175/88°C R1,5 / RFA



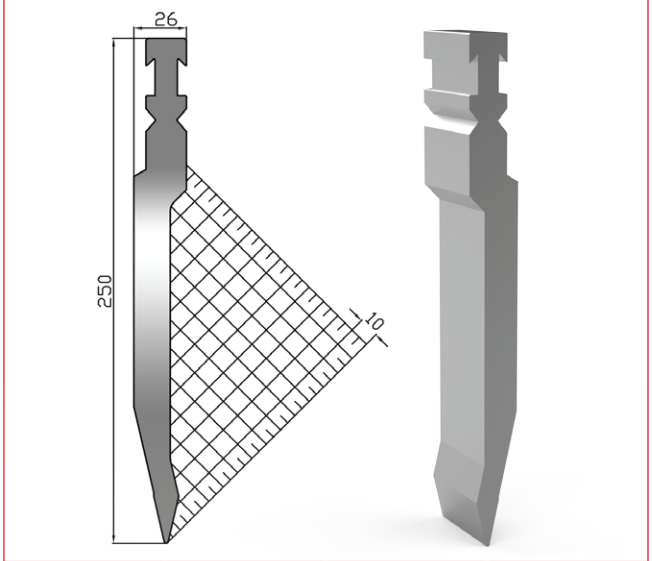
altezza height mm	angolo degree	raggio radius mm	max kN/mt
175,0	88°	1,5	500

lunghezze - lengths mm 1000 - 500 - fraz/sect 1100 (13 pz/pcs) — acciaio - steel

1000											500	
10	15	20	30	40	50	60	75	100	100 L	100 R	200	300

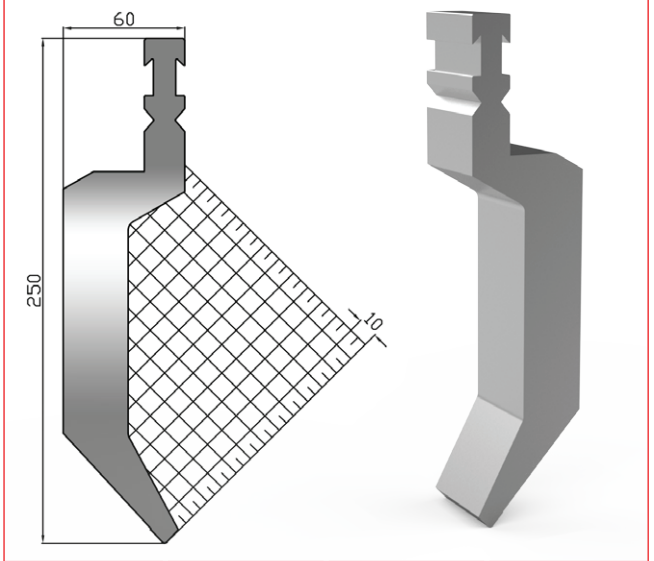
42CrMo4 T HRC 52÷58

USB 250/26°R1,0 / RFA



altezza height mm	angolo degree	raggio radius mm	max kN/mt
250,0	26°	1,0	900

USB 250/85°R1,5 / RFA



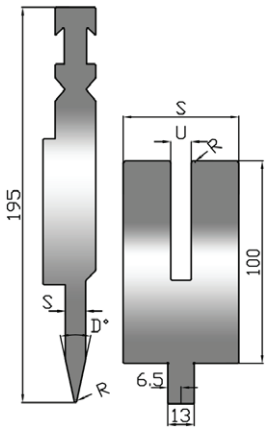
altezza height mm	angolo degree	raggio radius mm	max kN/mt
250,0	85°	1,5	1000

lunghezze - lengths mm 508 - fraz/sect 1100 (9 pz/pcs) — acciaio - steel

								508	
10	15	20	30	50	200 L	100 R	300	375	

42CrMo4 T HRC 52÷58

USB 138



codice articolo item code **L**	H mm	S mm	D°	R mm	codice articolo item code **M**	H mm	U mm	S mm	R mm
USB 138 L 8 max 800 kN/mt	195	8	24°	0,6	**USB 138 M 8** max 500 kN/mt	100	8,1	50	1,0
USB 138 L10 max 800 kN/mt	195	10	24°	0,6	**USB 138 M10** max 500 kN/mt	100	10,1	57	1,0
USB 138 L12 max 800 kN/mt	195	12	24°	0,6	**USB 138 M12** max 500 kN/mt	100	12,1	57	1,0



Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura. Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.

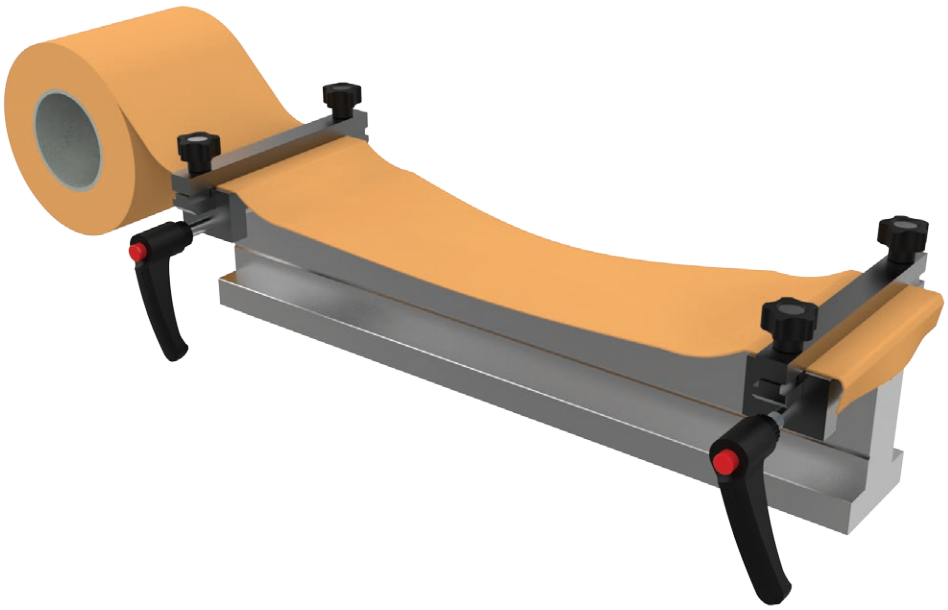
We suggest to use these tools on syncronized press brakes as it is necessary to change quickly the press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on the flattended.

lunghezze - lengths mm 500 - fraz/sect 550 (8 pz/pcs) — acciaio - steel

	500								
L	20	25	30	35	40	100 L	100 R	200	C45 T HRC 52÷58
M	20	25	30	35	40	100	100	200	

Non troverete in nessun altro luogo una pellicola più tenace e duratura !!!
Nowhere else you can find a more strong and lasting film !!!

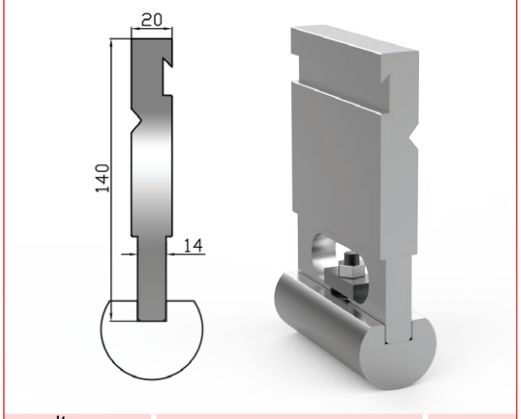




URET
PELLICOLA ANTIGRAFFIO - DIE COVER FILM

trovala a pagina 90
find it on page 90

USB 140 / RFA



altezza height mm	raggio radius mm	max kN/mt
140	MIN 8 - MAX 50	800

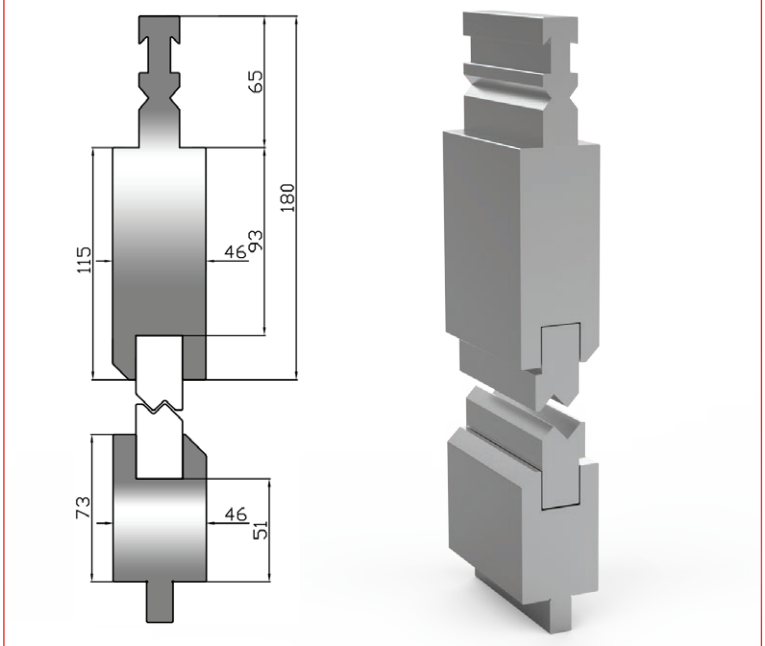
per gli elementi raggiati
consultare la pagina 16

for the radius elements
see page 16

lunghezze - lengths mm 835 (830) - 415 (412) — acciaio - steel

835 (830)	*415 (412)*	C45

USB 130



altezza height mm	max kN/mt
115 + 73	1000

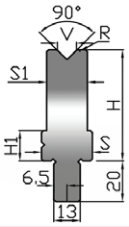
per gli elementi zeta
consultare la pagina 18

for the offset elements
see page 18

lunghezze - lengths mm 835 - 415 — acciaio - steel

835	*415*	C45 T HRC 52÷58

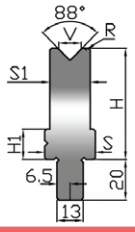
90°





codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USB55 / 90° V06	6	0,4	55-15	25-15	1150
USB55 / 90° V08	8	0,5	55-15	25-15	1100
USB55 / 90° V10	10	1,0	55-15	25-20	1100
USB55 / 90° V12	12	1,5	55-15	25-20	1200
USB55 / 90° V16	16	2,0	55	30	1200

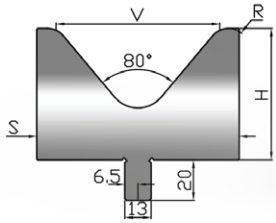
88°

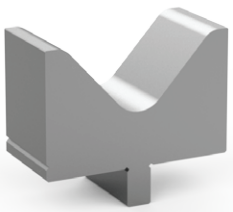




codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USB55 / 88° V10	10	1,0	55-15	25-20	1100
USB55 / 88° V12	12	1,5	55-15	25-20	1200
USB55 / 88° V16	16	2,0	55	30	1200
USB55 / 88° V20	20	2,0	55	30	1100
USB55 / 88° V24	24	3,0	55	40	1200

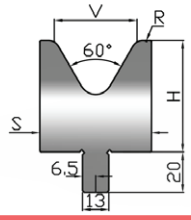
85° 80°

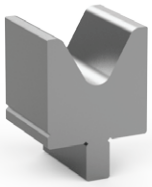




codice articolo item code	V mm	R mm	H-H1 mm	S mm	max kN/mt
USB55 / 85° V32	32	4,0	55	50	1200
USB55 / 85° V40	40	4,0	55	55	1200
USB65 / 80° V80	80	10,0	65	100	1700
USB85 / 80° V100	100	12,0	85	125	2300

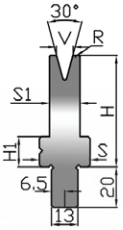
60°

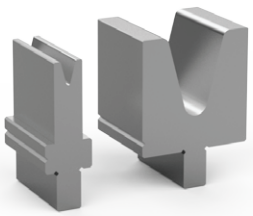




codice articolo item code	V mm	R mm	H-H1 mm	S mm	max kN/mt
USB55 / 60° V40	40	5,0	55	55	1300
USB55 / 60° V50	50	5,0	55	70	1200
USB65 / 60° V60	60	7,0	65	80	1100

30°





codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USB55 / 30° V06	6	0,6	55-15	25-15	350
USB55 / 30° V08	8	0,8	55-15	25-15	200
USB70 / 30° V08	8	0,7	70-15	25-20	200
USB55 / 30° V10	10	1,0	55-15	25-20	350
USB70 / 30° V10	10	1,0	70-15	25-20	350
USB55 / 30° V12	12	1,5	55-15	25-20	300
USB70 / 30° V12	12	1,5	70	25	300
USB55 / 30° V12 P	12	2,0	55	35	500
USB55 / 30° V14 P	14	3,0	55	42	600
USB55 / 30° V16	16	2,0	55	30	450
USB70 / 30° V16	16	2,0	70	30	450
USB55 / 30° V20	20	2,5	55	35	500
USB55 / 30° V24	24	3,0	55	40	550
USB60 / 30° V32	32	4,0	60	60	650

lunghezze - lengths mm 1000 - 500 - fraz/sect 1100 (12 pz/pcs)

acciaio - steel

1000										500	
10	15	20	30	40	50	60	75	100	100	200	400

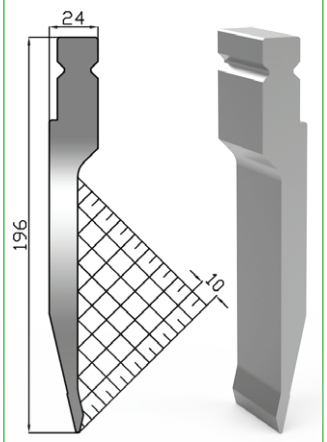
42CrMo4 T HRC 52÷58

H 196 mm

serie USL®

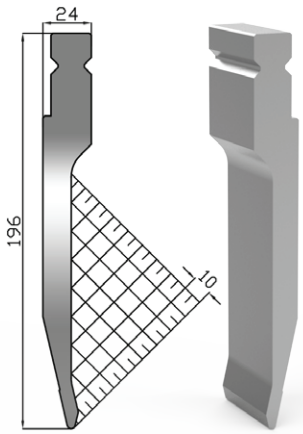
STANDARD TOOLS

USL 196/26°R1 J10W



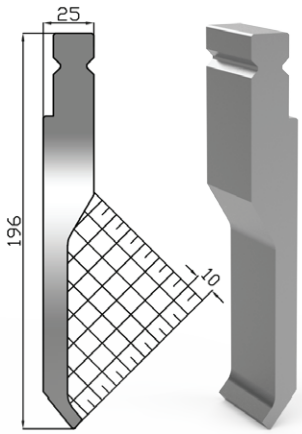
altezza height mm	angolo degree	raggio radius	max kN/mt
196,0	26°	1,0	400

USL 196/26°R2 J10W



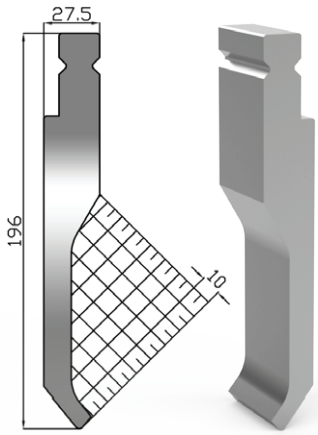
altezza height mm	angolo degree	raggio radius	max kN/mt
196,0	26°	2,0	600

USL 196/78°R1 E10W



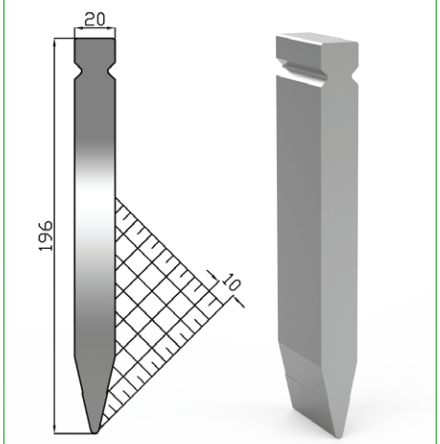
altezza height mm	angolo degree	raggio radius	max kN/mt
196,0	78°	1,0	400

USL 196/78°R2 E10W



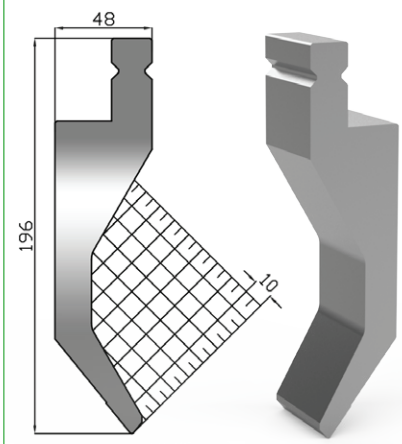
altezza height mm	angolo degree	raggio radius	max kN/mt
196,0	78°	2,0	680

USL 196/26°R2 R10W



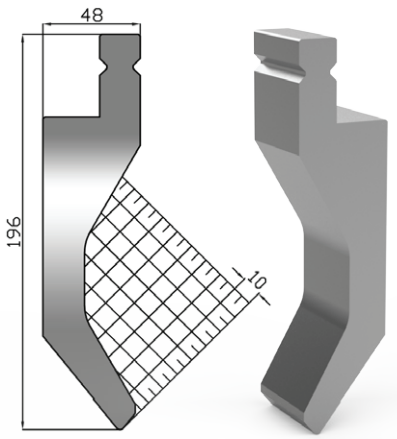
altezza height mm	angolo degree	raggio radius mm	max kN/mt
196,0	26°	2,0	800

USL 196/78°R1 D10W



altezza height mm	angolo degree	raggio radius mm	max kN/mt
196,0	78°	1,0	400

USL 196/78°R2 D10W



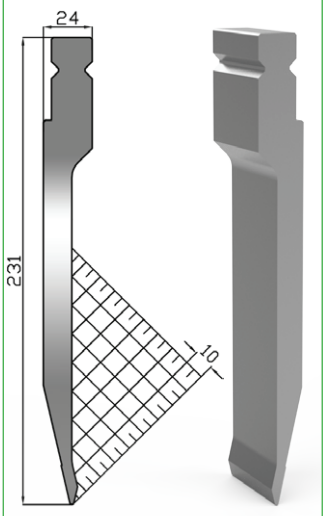
altezza height mm	angolo degree	raggio radius mm	max kN/mt
196,0	78°	2,0	750





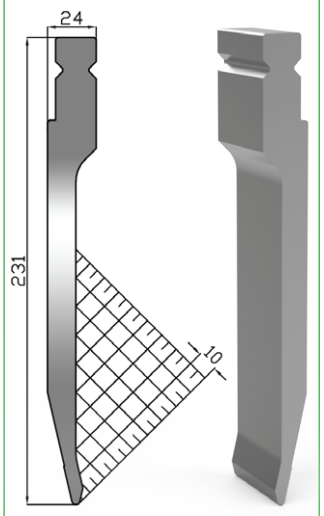


USL 231/26°R1 J15W



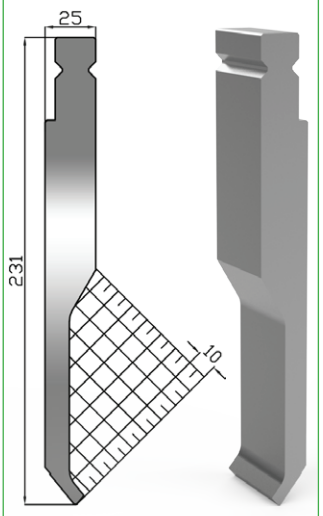
altezza height mm	angolo degree	raggio radius	max kN/mt
231,0	26°	1,0	400

USL 231/26°R2 J15W



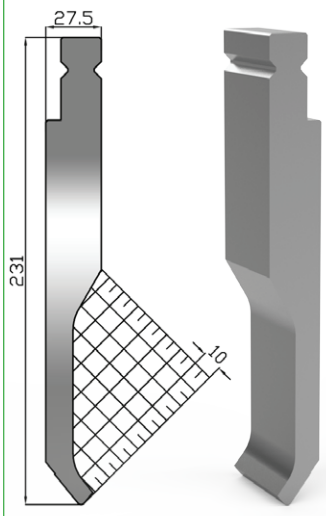
altezza height mm	angolo degree	raggio radius	max kN/mt
231,0	26°	2,0	600

USL 231/78°R1 E15W



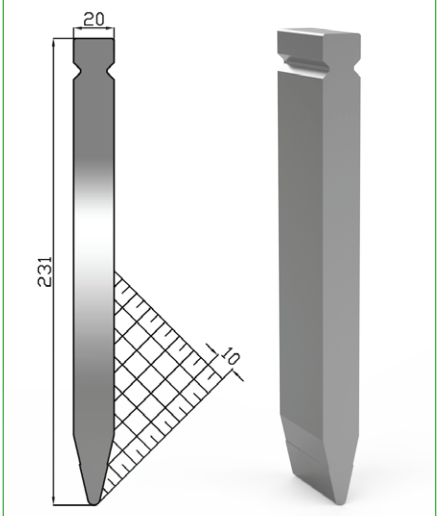
altezza height mm	angolo degree	raggio radius	max kN/mt
231,0	78°	1,0	400

USL 231/78°R2 E15W



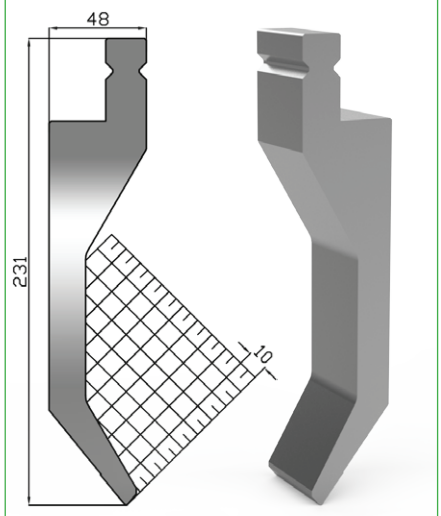
altezza height mm	angolo degree	raggio radius	max kN/mt
231,0	78°	2,0	680

USL 231/26°R3 R15W



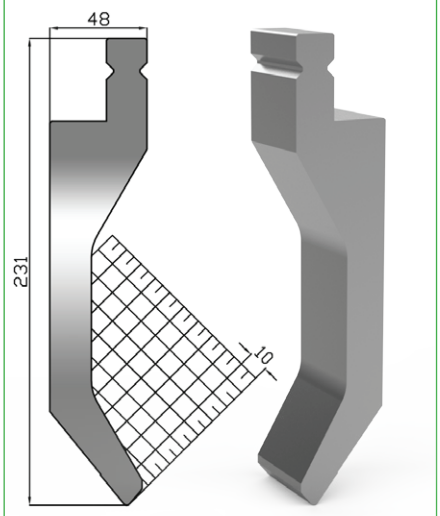
altezza height mm	angolo degree	raggio radius mm	max kN/mt
231,0	26°	3,0	1200

USL 231/78°R1 D15W



altezza height mm	angolo degree	raggio radius mm	max kN/mt
231,0	78°	1,0	400

USL 231/78°R2 D15W



altezza height mm	angolo degree	raggio radius mm	max kN/mt
231,0	78°	2,0	750

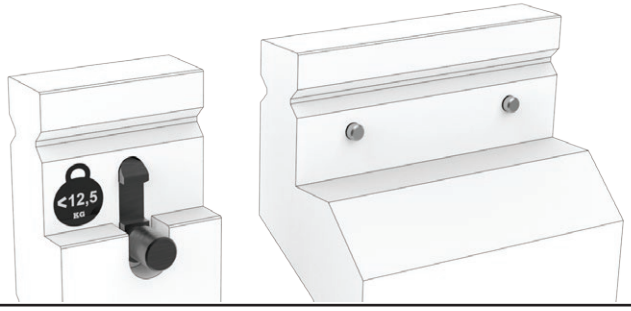
lunghezze - lengths mm 510 - 250 - fraz/sect 550 (9 pz/pcs) — acciaio - steel

510								250
25	30	35	40	45	50	100 L	100 R	125

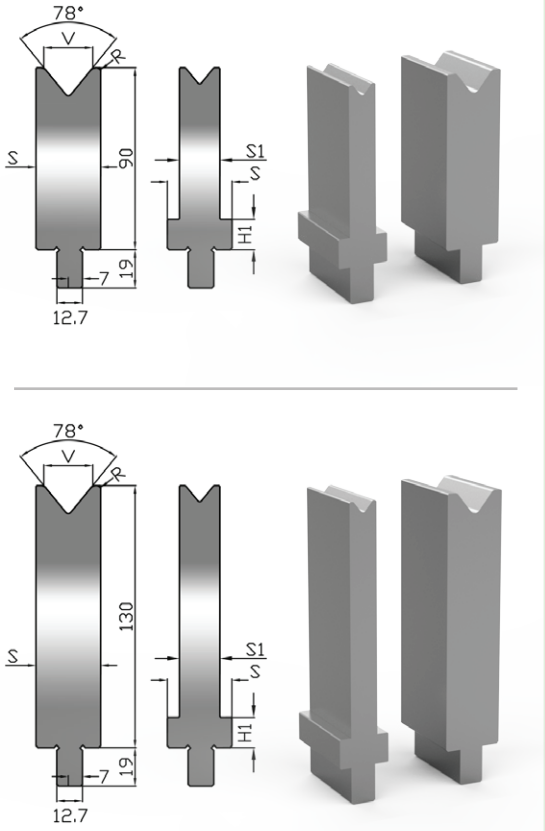
42CrMo4 T HRC 52÷58

Gli utensili con peso inferiore a 12,5 kg vengono forniti con singolo o doppio pulsante.
Oltre tale peso l'utensile viene fornito con spine.

Tools with a weight less than 12,5 kg are supplied with a single or double push buttons.
Beyond such weight the tool is supplied with pins.



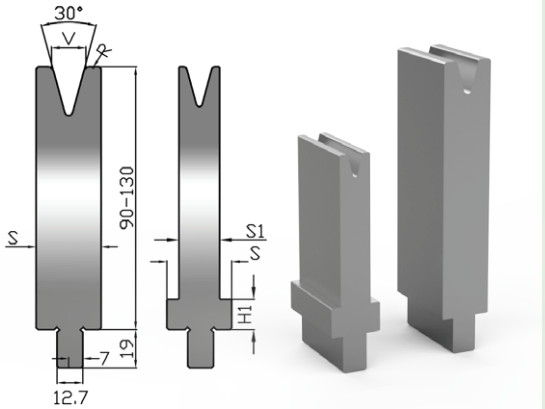
1V - serie 12,7 series



78°

codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USL 109 L/78° V06	6	0,8	75-15	26-10	280
USL 109 L/78° V08	8	0,8	75-15	26-12	320
USL 109 L/78° V10	10	1,0	75-15	26-14	360
USL 109 L/78° V12	12	1,2	75-15	26-18	500
USL 109 L/78° V16	16	1,6	90	25	700
USL 109 L/78° V20	20	2,0	90	30	750
USL 109 L/78° V24	24	2,4	90	32	910
USL 109 L/78° V30	30	3,0	90	40	1150
USL 109 L/78° V40	40	4,0	90	50	1350
USL 109 L/78° V50	50	4,0	90	65	1800
USL 109 L/78° V60	60	5,0	90	75	2000
USL 109 L/78° V80	80	6,0	90	95	2300
USL 109 L/78° V100	100	6,0	90	125	3400
USL 149 L/78° V06	6	0,8	115-15	26-10	280
USL 149 L/78° V08	8	0,8	115-15	26-12	320
USL 149 L/78° V10	10	1,0	115-15	26-14	360
USL 149 L/78° V12	12	1,2	115-15	26-18	500
USL 149 L/78° V16	16	1,6	130	25	700
USL 149 L/78° V20	20	2,0	130	30	750
USL 149 L/78° V24	24	2,4	130	32	910
USL 149 L/78° V30	30	3,0	130	40	1150
USL 149 L/78° V40	40	4,0	130	50	1350
USL 149 L/78° V50	50	4,0	130	65	1800
USL 149 L/78° V60	60	5,0	130	75	2000
USL 149 L/78° V80	80	6,0	130	95	2300
USL 149 L/78° V100	100	6,0	130	125	3400
USL 149 L/78° V120	120	8,0	130	140	2700

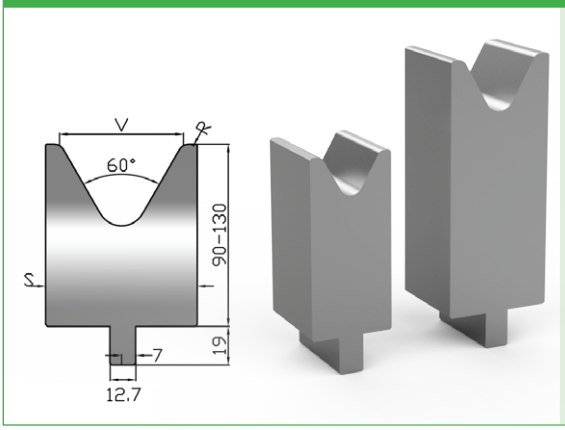
1V - serie 12,7 series



30°

codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USL 109 L/30° V06	6	0,8	75-15	26-14	250
USL 109 L/30° V08	8	0,8	75-15	26-16	260
USL 109 L/30° V10	10	1,0	75-15	26-22	360
USL 109 L/30° V12	12	1,2	75-15	26	460
USL 109 L/30° V16	16	1,6	90	30	510
USL 109 L/30° V20	20	2,0	90	40	680
USL 109 L/30° V24	24	2,4	90	46	930
USL 109 L/30° V30	30	3,0	90	56	1100
USL 109 L/30° V40	40	4,0	90	75	1400
USL 109 L/30° V50	50	4,0	90	90	1350
USL 149 L/30° V06	6	0,8	115-15	26-14	250
USL 149 L/30° V08	8	0,8	115-15	26-16	260
USL 149 L/30° V10	10	1,0	115-15	26-22	360
USL 149 L/30° V12	12	1,2	115-15	26	460
USL 149 L/30° V16	16	1,6	130	30	510
USL 149 L/30° V20	20	2,0	130	40	680
USL 149 L/30° V24	24	2,4	130	46	930
USL 149 L/30° V30	30	3,0	130	56	1100
USL 149 L/30° V40	40	4,0	130	75	1400
USL 149 L/30° V50	50	4,0	130	90	1350
USL 149 L/30° V60	60	5,0	130	95	1550

1V - serie 12,7 series



60°

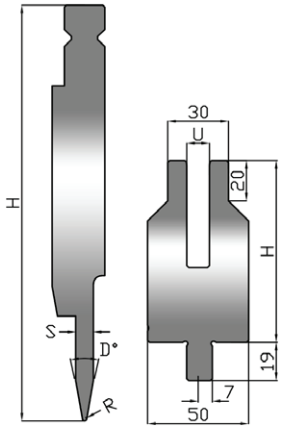
codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
USL 109 L/60° V30	30	3,0	109	42	1050
USL 109 L/60° V40	40	3,0	109	55	1300
USL 109 L/60° V50	50	4,0	109	70	1780
USL 109 L/60° V60	60	5,0	109	75	1700
USL 109 L/60° V80	80	6,0	109	110	1850
USL 149 L/60° V30	30	3,0	130	42	1050
USL 149 L/60° V40	40	4,0	130	55	1300
USL 149 L/60° V50	50	4,0	130	70	1780
USL 149 L/60° V60	60	5,0	130	75	1700
USL 149 L/60° V80	80	6,0	130	110	2500
USL 149 L/60° V100	100	6,0	130	125	2700
USL 149 L/60° V120	120	8,0	130	140	2200

lunghezze - lengths mm 510 - 250 - fraz/sect 550 (12 pz/pcs) — acciaio - steel

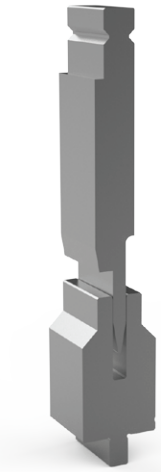
510										250	
20	20	25	25	30	35	40	40	45	75	75	120

42CrMo4 T HRC 52÷58

USLP + USL



codice articolo item code **L**	H mm	S mm	D°	R mm	codice articolo item code **M**	H mm	U mm	S mm	R mm
USLP 10W8 max 400 kN/mt	206	6,8	20°	1,0	**USL109/U8** max 350 kN/mt	109	7,2	50	1,0
USLP 10W10 max 400 kN/mt	206	8,8	20°	1,0	**USL109/U10** max 350 kN/mt	109	9,2	50	1,0
USLP 10W12 max 400 kN/mt	206	10,8	20°	1,0	**USL109/U12** max 350 kN/mt	109	11,2	50	1,0
USLP 15W8 max 400 kN/mt	251	6,8	20°	1,0	**USL149/U8** max 350 kN/mt	149	7,2	50	1,0
USLP 15W10 max 400 kN/mt	251	8,8	20°	1,0	**USL149/U10** max 350 kN/mt	149	9,2	50	1,0
USLP 15W12 max 400 kN/mt	251	10,8	20°	1,0	**USL149/U12** max 350 kN/mt	149	11,2	50	1,0



Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura. Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.

We suggest to use these tools on syncronized press brakes as it is necessary to change quickly the press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on the flattended.

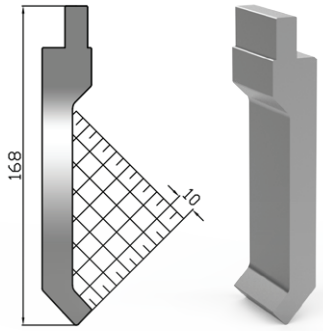
lunghezze - lengths mm 510 - 250 - fraz/sect 550 (9 pz/pcs) — acciaio - steel

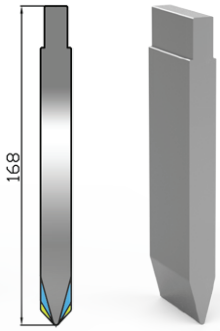
	510								250
L	25	30	35	40	45	50	100 L	100 R	125
M	25	30	35	40	45	50	100	100	125

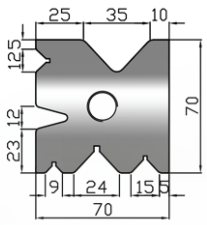
42CrMo4 T HRC 52÷58

serie USH®

kN 300 ÷ 600



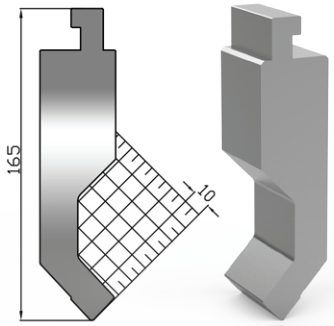


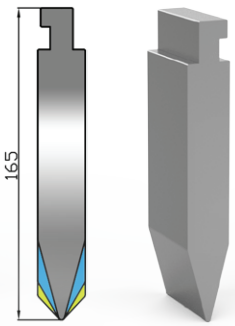


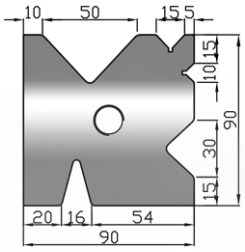


USH 168 A 86° R1,5 | **USH 168 B** 86°60°30° R1,5 | **USH M 70** V9-12-15-24-35/86°+V12/30°

kN 800 ÷ 1350



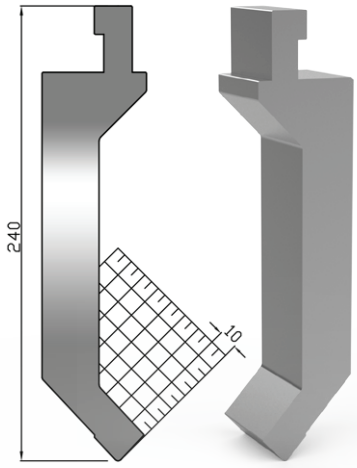


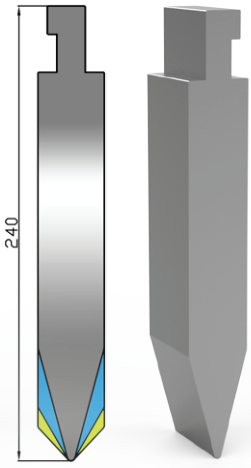


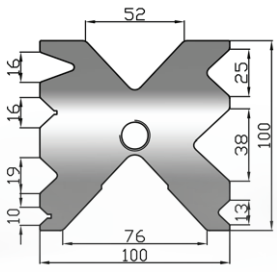


USH 165 A 86° R1,5 | **USH 165 B** 86°60°30° R1,5 | **USH M 90** V10-15-30-50/86°+V16/30°

kN 1600 ÷ 2800



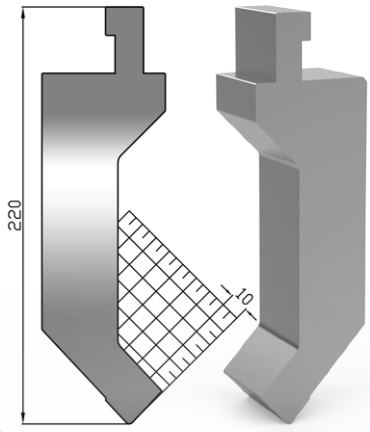


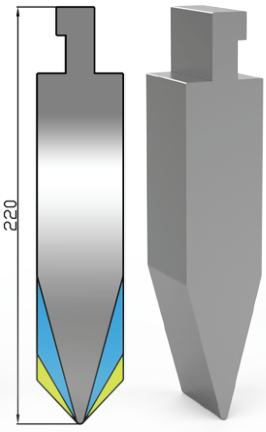


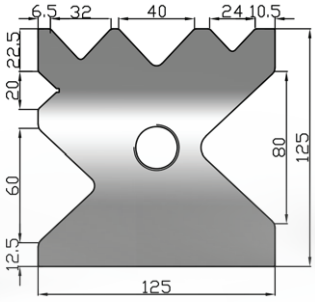


USH 240 A 86° R2,0 | **USH 240 B** 86°60°30° R2,0 | **USH M100** V10-13-16-19-25-38-52-76/86°+V16/40°

kN 3000 ÷ 4000



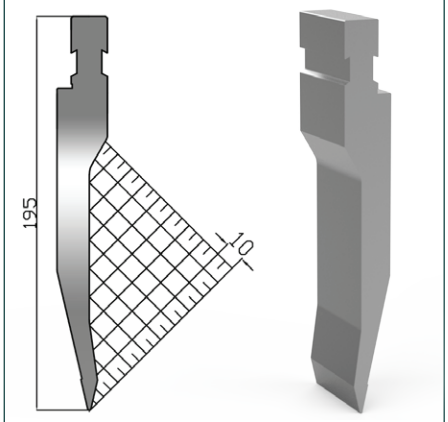






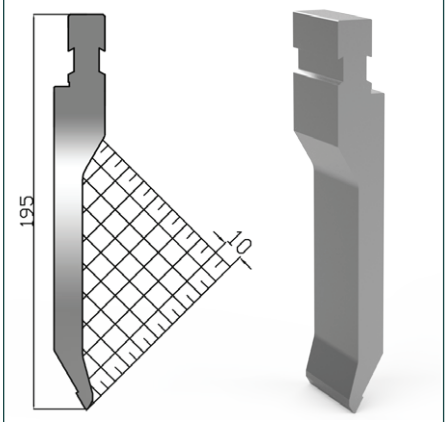
USH 220 A 86° R2,0 | **USH 220 B** 86°60°30° R2,0 | **USH M125** V20-24-32-40-60-80/86°

USC 195/26° R0,8



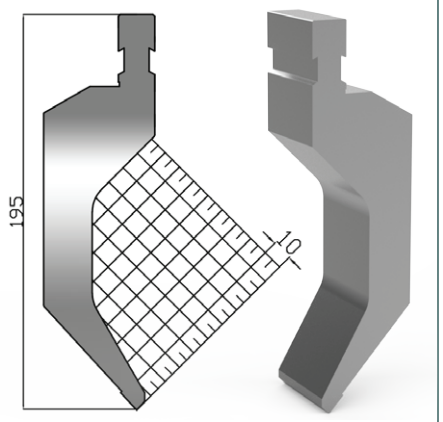
altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	26°	0,8	1000

USC 195/60° R0,8



altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	60°	0,8	800

USC 195/85° R0,8



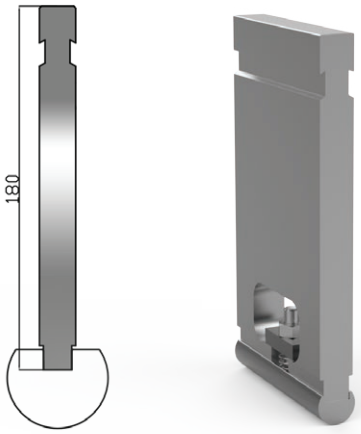
altezza height mm	angolo degree	raggio radius mm	max kN/mt
195,0	85°	0,8	1000

lunghezze - lengths mm 525 - fraz/sect A 495 (8 pz/pcs) - fraz/sect B 500 (3 pz/pcs) — acciaio - steel

42CrMo4 T HRC 52÷58

	525	B	100 L	300			100 R	
A	25	30	35	40	45	50	100	170

USC 180



altezza height mm	raggio radius mm	max kN/mt
180	MIN 8 - MAX 50	500

USC 310

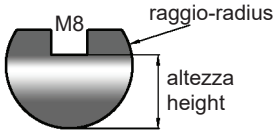
3 fori-holes
mm 53,5-209-209-53,5=mm 525

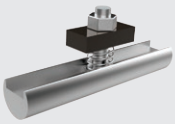


codice articolo - item code		max kN/mt
USC 310	NON TEMPRATO - NOT HARDENED	1000
USC 310 T	TEMPRATO - HARDENED	

USC 305 R 8 ÷ 50 mm

3 fori-holes
mm 53,5-209-209-53,5=mm 525





acciaio - steel
C 45
rettificato-grinding

acciaio - steel
39NCM3
nitrurato-nitrided

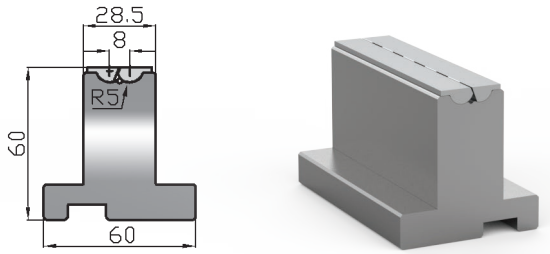
codice articolo item code	raggio radius mm	altezza height mm
USC 305/R 8	8	10
USC 305/R 9	9	10
USC 305/R 10	10	12
USC 305/R 12,5	12,5	17
USC 305/R 15	15	20
USC 305/R 17,5	17,5	22
USC 305/R 20	20	24
USC 305/R 22,5	22,5	25
USC 305/R 25	25	29
USC 305/R 27,5	27,5	34
USC 305/R 30	30	34
USC 305/R 35	35	45
USC 305/R 40	40	44
USC 305/R 45	45	50
USC 305/R 50	50	54

lunghezze - lengths mm 525 (522) — acciaio - steel

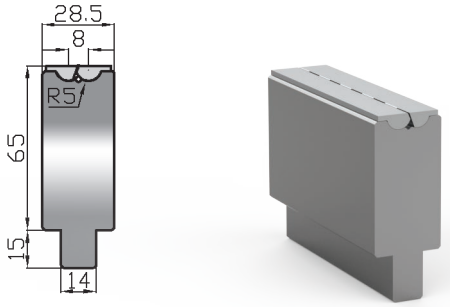
525 (522)	C45
	C45 T HRC 52÷58
	39NCM3 NIT

serie USC®

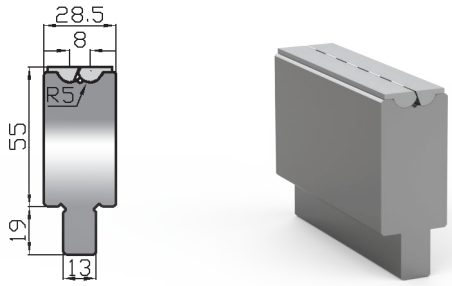
RVP 60-1



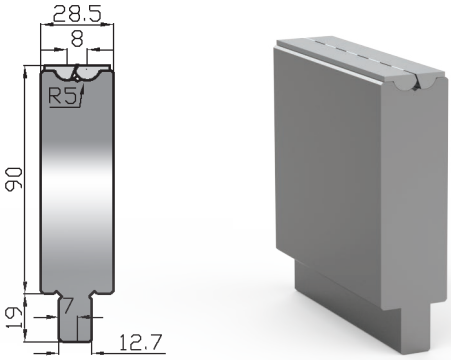
RVS 80-1



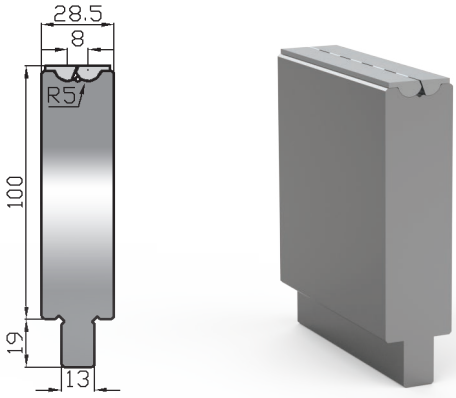
RVT 55-1

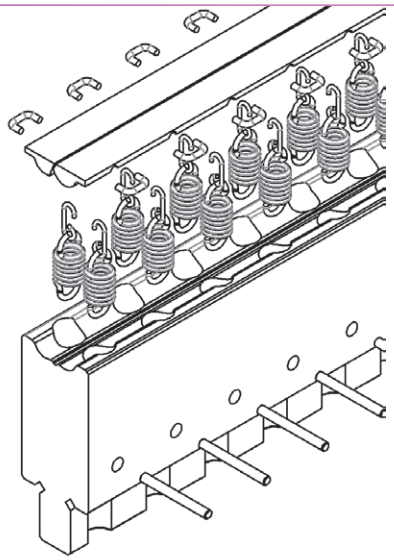


RVT 90-1



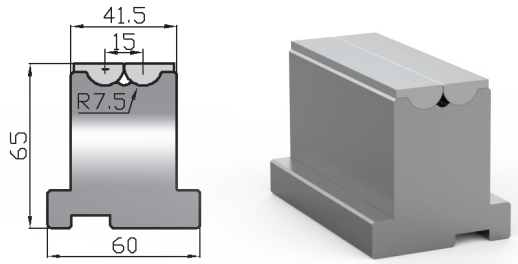
RVT 100-1



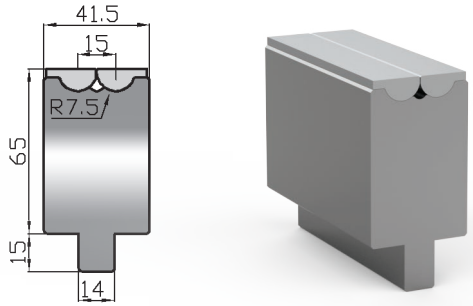


type 1 (rel.8)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	max raggio ut.sup radius up.tool	carico load max kN/mt	acciaio - steel
V mm 8	1,5	0,7	40°	5,1	3	2	1000	corpo / body 42CrMo4 nitr. HRC 53÷55
		1,0	35°	5,1	2,7	1,5		
		1,5	35°	5,1	2,2	0,6		inserti / inserts Toolox 44 HRC÷44
lunghezze - lengths		mm 500 mm 440 fraz (mm 15-20-25-30-50-100-200)						

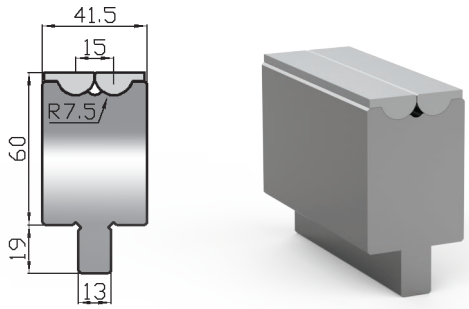
RVP 65-2



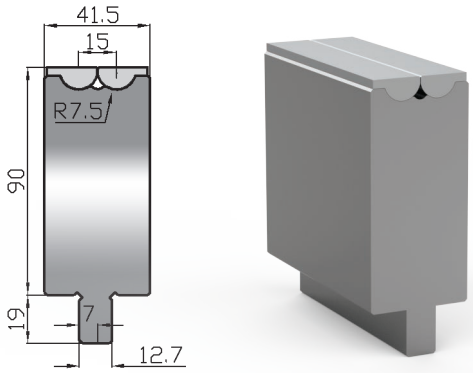
RVS 80-2

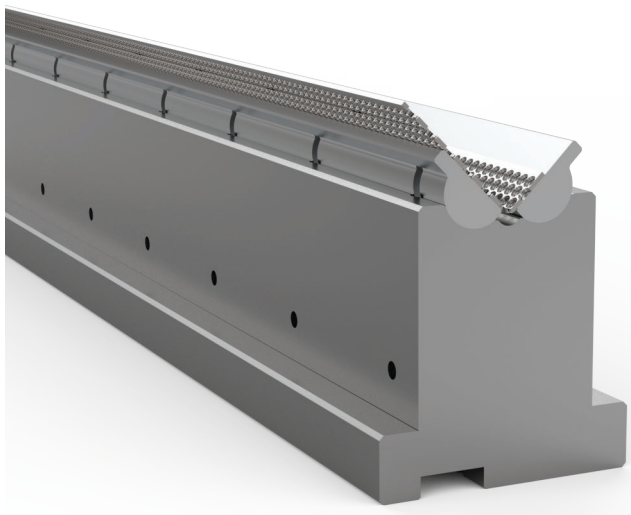


RVT 60-2

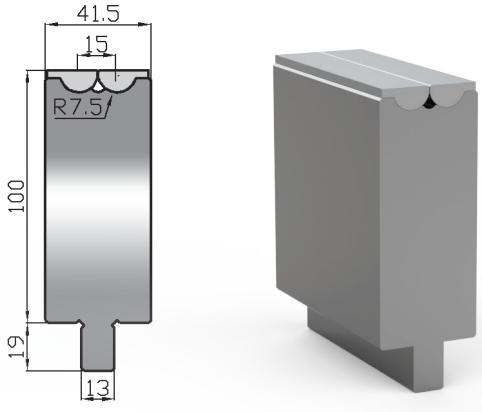


RVT 90-2



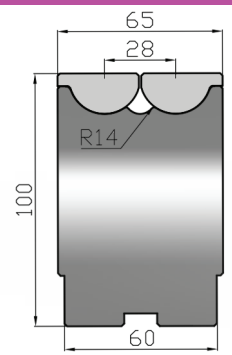


RVT 100-2



type 2 (rel.2)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	max raggio ut.sup radius up.tool	carico load max kN/mt	acciaio - steel
V mm 15	3,2	2,0	59°	9,8	6	3,6	1500	corpo / body 42CrMo4 nitr. HRC 53÷55
		3,0	47°	9,8	5	1,8		
		3,2	47°	9,8	4,8	1,5		inserti / inserts Toolox 44 HRC÷44
lunghezze - lengths		mm 500 mm 450 fraz (mm 20-25-30-35-40-100-200)						

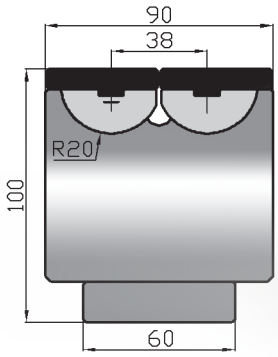
RVM 100-2.5

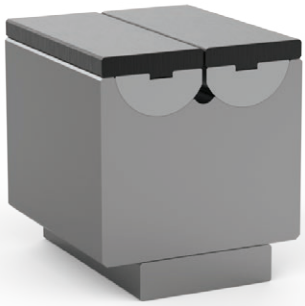




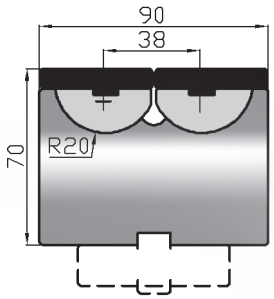
type 2.5 (rel.1)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	max raggio ut.sup radius up.tool	carico load max kN/mt	acciaio - steel
V mm 28	6,0	2,0	46°	18,6	13,8	7,8	2500	corpo / body 42CrMo4 nitr. HRC 53÷55
		4,0	46°	18,6	11,8	6,2		
		6,0	55°	18,6	9,8	3		inserti / inserts Toolox 44 HRC÷44
lunghezze - lengths		mm 500 mm 470 fraz (mm 35-40-45-50-100-200)						

RVP 100-3



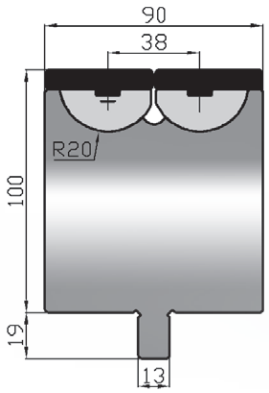


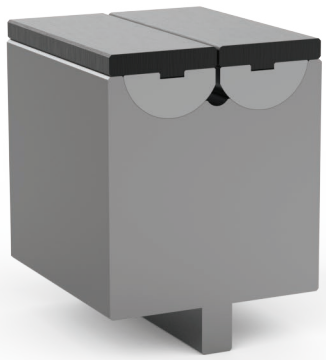
RVM 70-3





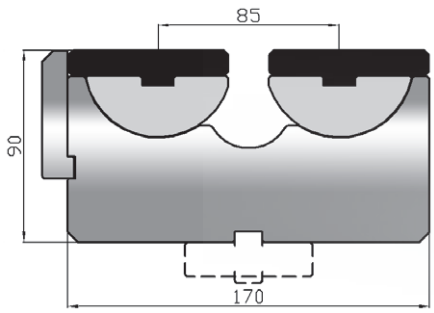
RVT 100-3

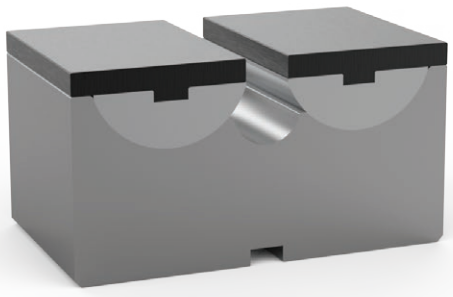




type 3 (rel.3)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	max raggio ut.sup radius up.tool	carico load max kN/mt	acciaio - steel
V mm 38	6,0	2,0	68°	23,6	13,9	9,5	2500	corpo / body 42CrMo4 nitr. HRC 53÷55 elementi tondi / round elements 42CrMo4 nitr. HRC 53÷55 elementi piatti / flat elements Toolox 44 HRC÷44
		4,0	47°	23,6	11,9	6,3		
		6,0	50°	23,6	9,9	3,1		
lunghezze - lengths		mm 500 mm 455 fraz (mm 45-50-60-100-200)						

RVM 90-4





type 4 (rel.2)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	max raggio ut.sup radius up.tool	carico load max kN/mt	acciaio - steel
V mm 85	12,0	6,0	78°	56,6	42,1	28,9	3000	corpo / body 42CrMo4 nitr. HRC 53÷55 elementi tondi / round elements 42CrMo4 nitr. HRC 53÷55 elementi piatti / flat elements Toolox 44 HRC÷44
		8,0	76°	56,6	40,1	25,7		
		12,0	73°	56,6	36,1	19,3		
lunghezze - lengths		mm 500 mm 250						

ATTACCHI - CLAMPINGS

RVM 100-2.5 - RVM 70-3 - RVM 90-4

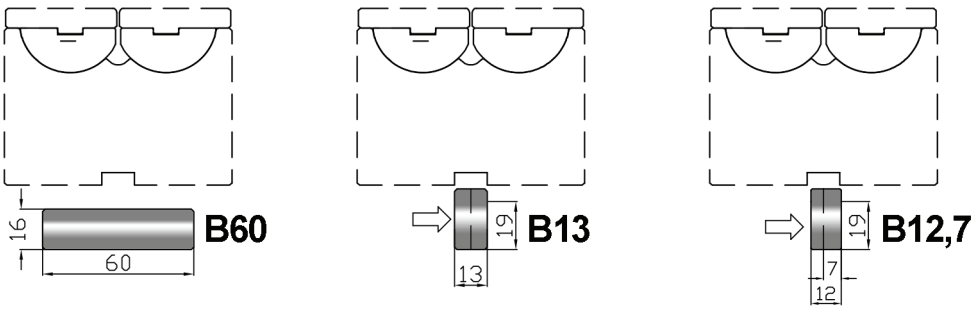


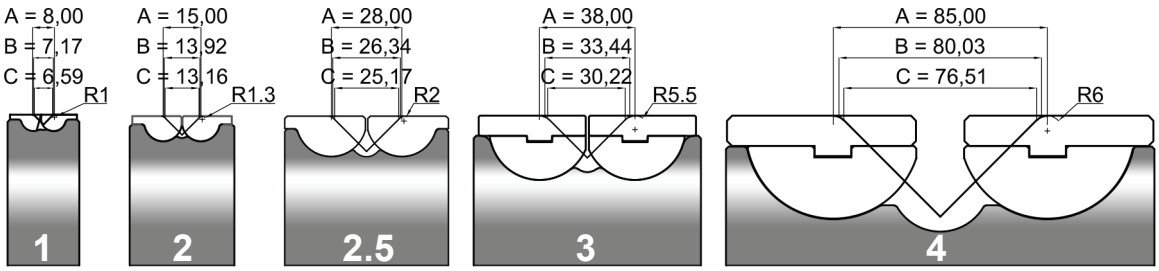
TABELLA CALCOLO FORZA - FORCE CALCULATION TABLE

A distanza dal centro di rotazione - rotor centre distance

B valore per calcolo bordo - value for calculating flange size (DNC)

C valore per calcolo tonnellaggio - value for calculating tonnages

R raggio cava - corner radius (DNC)



type 1 - V 8			
spes. thick. mm	resistenza lamiera sheet resistance N/mm²		
	200	450	700
0,7	21	48	74
1,0	49	110	171
1,5	130	294	457

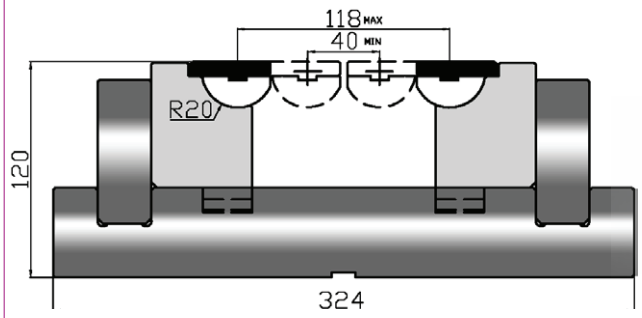
type 2 - V 15			
spes. thick. mm	resistenza lamiera sheet resistance N/mm²		
	200	450	700
2,0	97	219	341
3,0	260	586	911
3,2	306	688	1070

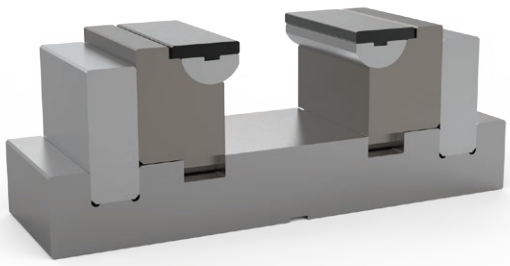
type 2.5 - V 28			
spes. thick. mm	resistenza lamiera sheet resistance N/mm²		
	200	450	700
3,0	106	238	370
4,0	208	468	728
6,0	559	1257	1956

type 3 - V 38			
spes. thick. mm	resistenza lamiera sheet resistance N/mm²		
	200	450	700
2,0	33	75	117
4,0	162	364	567
6,0	427	962	1496

type 4 - V 85			
spes. thick. mm	resistenza lamiera sheet resistance N/mm²		
	200	450	700
6,0	124	278	433
8,0	237	534	830
12,0	613	1378	2144

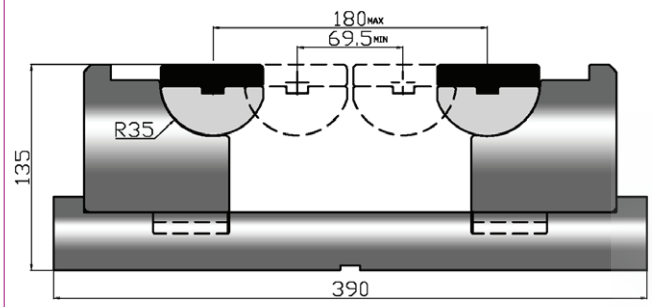
RVHD3

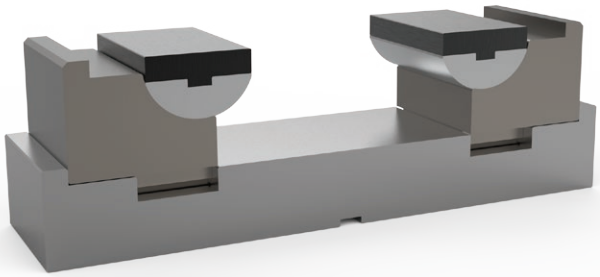




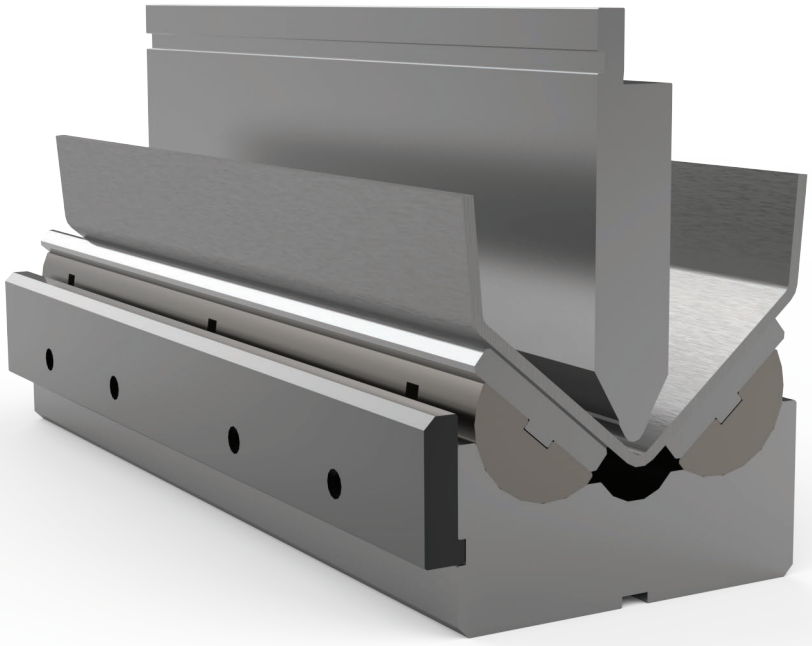
V mm	40 ÷ 118	max kN/mt	3500	lunghezze - lengths	mm 500 - 250

RVPV4





V mm	69,5÷180	max kN/mt	3000	lunghezze - lengths	mm 500 - 250



CARATTERISTICHE TECNICHE - TECHNICAL FEATURES

L'uso delle matrici ROLLA-V ha i seguenti vantaggi:

-piegatura di bordi molti ridotti
-minimi segni di piegatura
-possibilità di eseguire pieghe vicine a fori ed asole, evitando deformazioni anche su parti di lamiera tagliate oblique.

Con i modelli a cava variabile si possono eseguire pieghe con forma ad "U" fino a 180°.

The use of ROLLA-V tools has the following advantages:

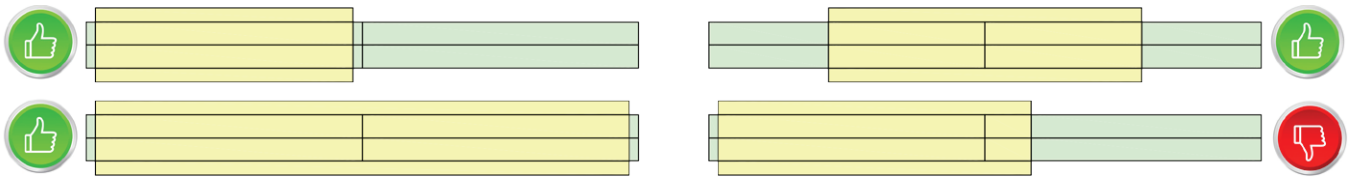
-very small edges
-minimum signs of bending
-allow to perform bends near holes and slots avoiding deformations, also, on oblique cut sheet parts.

With the ROLLS-V dies with variable slot, it is possible to perform "U" bends up 180°.

SETUP UTENSILI - TOOLS SETUP

È essenziale che la linea centrale del ROLLA-V sia sulla stessa linea dell'utensile superiore.
Si consiglia di utilizzare un punzone con angolo 88° o similare per centrare la matrice.
La programmazione può essere effettuata indicando differenti larghezze della cava per ottenere l'angolo di piega desiderato. Non è necessario utilizzare l'intera lunghezza dell'utensile, ma in questi casi assicurarsi che il pezzo da piegare sia posizionato centralmente sulla matrice ROLLA-V.

The centerline of the ROLLA-V must be on the same centerline as the upper tool.
We recommend using an 88' or similar angle punch to help centralize the lower tool.
Programming can be by signaling different V widths to achieve the desired bend angle.
It is not necessary to use the entire length of the tool, but in such cases, ensure the component is centrally placed on the ROLLA-V die.



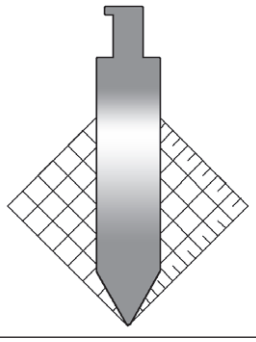
MANUTENZIONE - MAINTENANCE

Assicurarsi che le superfici del raggio dell'utensile siano lubrificate con Molykote BR2 Plus o grasso simile.
È necessaria solo una leggera lubrificazione.
È importante che periodicamente (a seconda del materiale in lavorazione) l'utensile venga smontato, pulito e lubrificato nuovamente. (Vedere le istruzioni fornite per il montaggio / smontaggio)

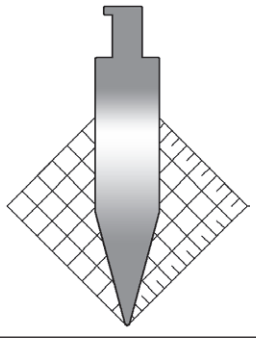


Please ensure that the tool radius surfaces are lubricated with Molykote BR2 Plus or similar grease.
Only a light coating is necessary.
It is essential that periodically (dependent on the material being processed) the tool is stripped, cleaned, and re-greased.
(See the instructions provided for assembly / disassembly)

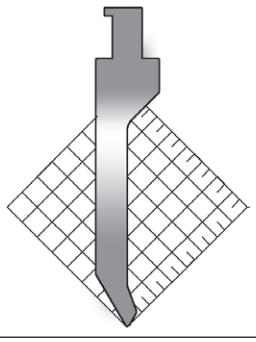
LS 60°



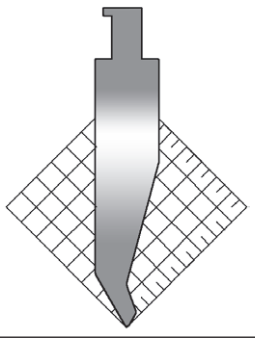
LS 30°



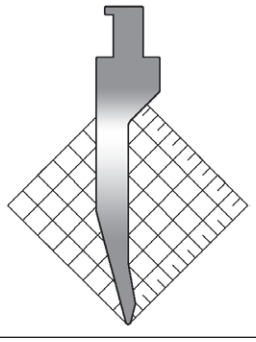
LD 60°



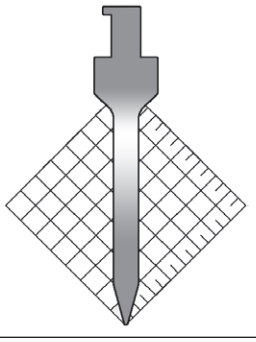
LDN 60°



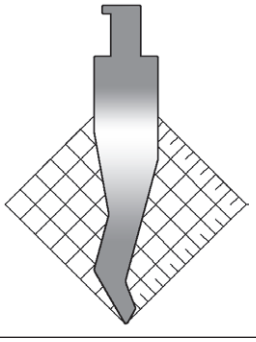
LX 30°



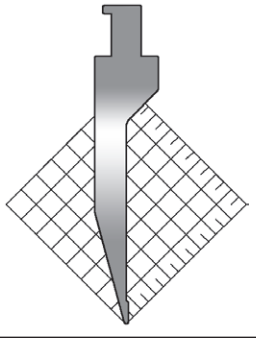
LDP 30°



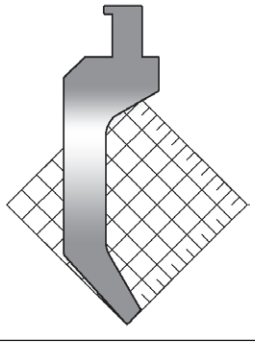
LDS 60°



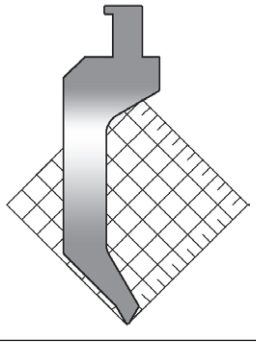
LUP 15°



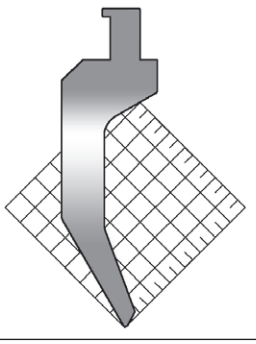
LSCC 84°



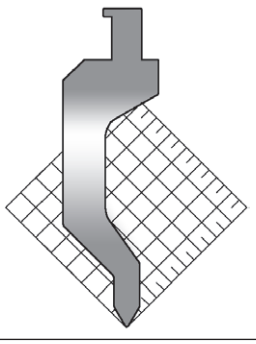
LSCC 60°



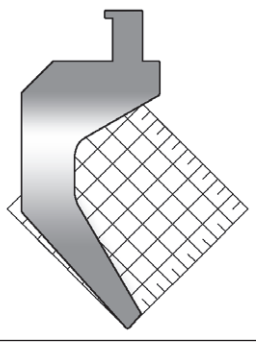
LSCZ 60°



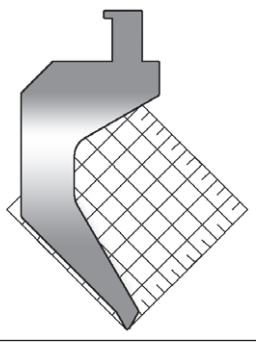
LSCY 60°



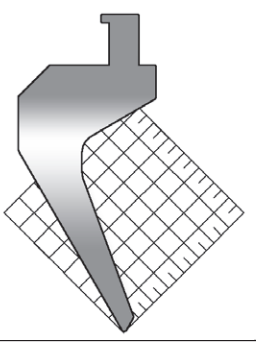
LCC 84°



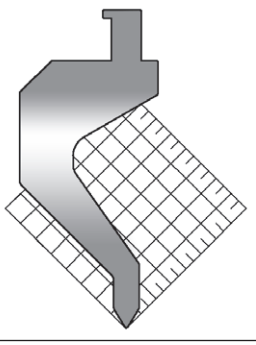
LCC 60°



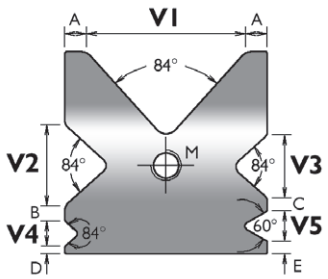
LCZ 60°



LCY 60°



M



tipo type	dimensioni dimensions mm
M 60	60 x 60
M 70	70 x 70
M 80	80 x 80
M 90	90 x 90
M 100	100 x 100
M 110	110 x 110
M 120	120 x 120
M 130	130 x 130
M 140	140 x 140

84°				60°	A	B	C	D	E	M
V1	V2	V3	V4	V5						
40	25	20	10	12	10	6	5	3	5	
50	32	25	10	12	10	6	5	3	5	M12
63	32	25	10	12	8,5	6	5	3	5	M12
70	40	25	10	12	10	6	5	3	5	M16
80	40	32	10	12	10	9	5	3	5	M16
90	50	32	10	12	10	9	5	3	5	M16
90	50	40	12	16	15	10	10	5	5	M16
110	50	40	12	16	10	10	10	5	5	M16
110	50	40	16	20	15	10	10	5	5	M20

M1



M2



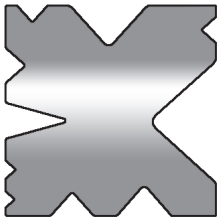
M3



M4



M5



M8



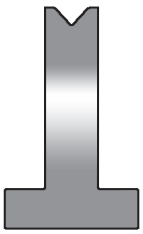
M9



M10



M11



M12



M13



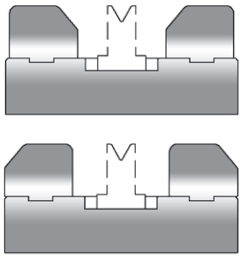
M14



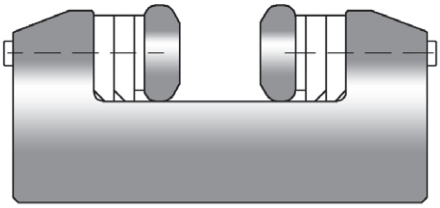
M19



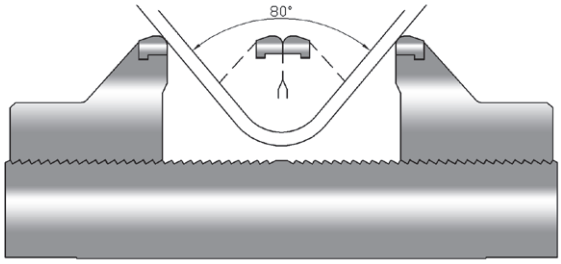
M20 A-B



M16

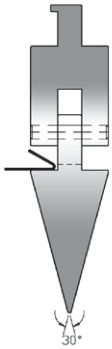


V-MUTABILIS matrice regolabile - adjustable die — carico-load max 4000 kN/mt

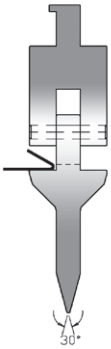


V mm 0 - 200 / 250 / 350 / 400

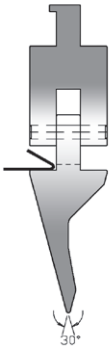
SP



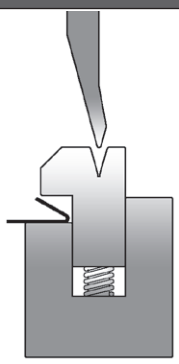
SPD



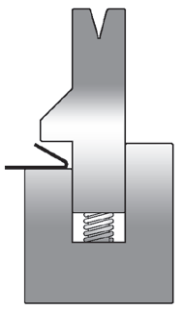
SPX



MP



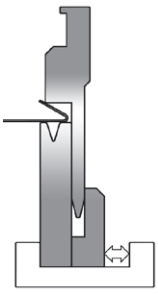
MPS



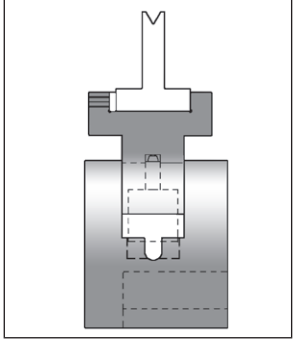
SP1



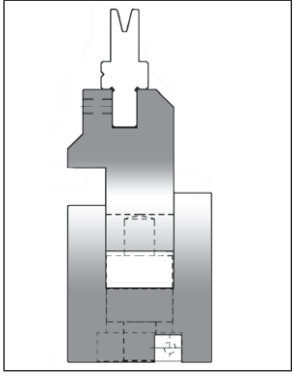
SP2



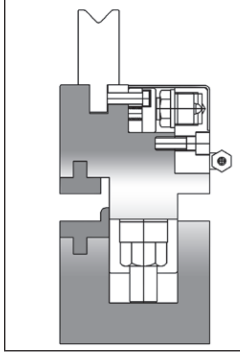
SP3 A



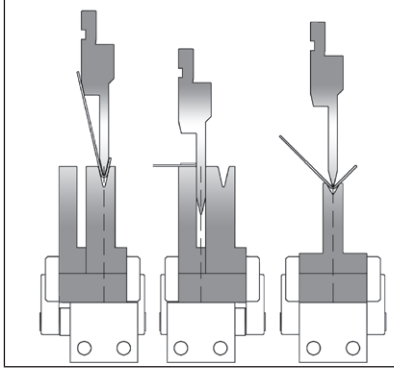
SP3 B



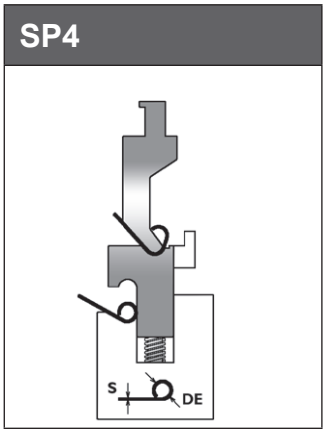
SP3 C



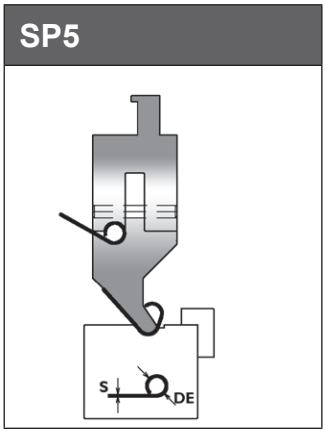
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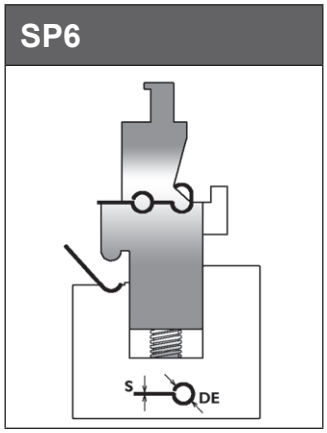
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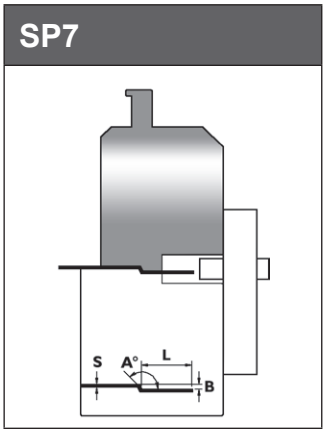
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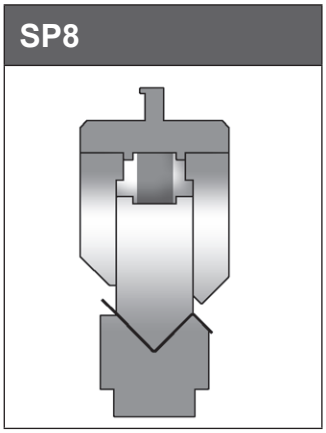
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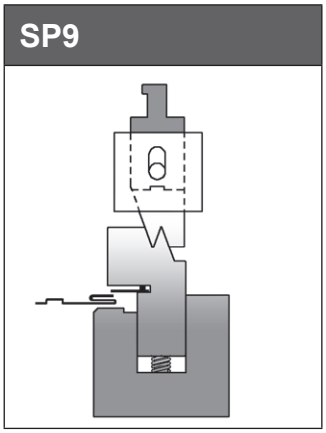
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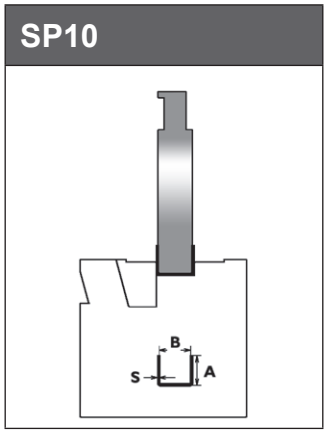
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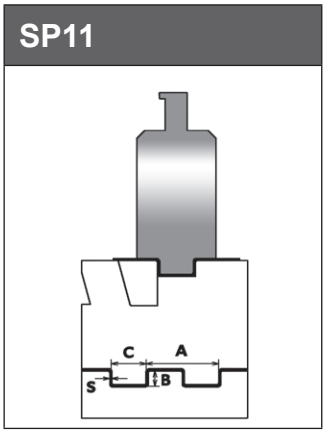
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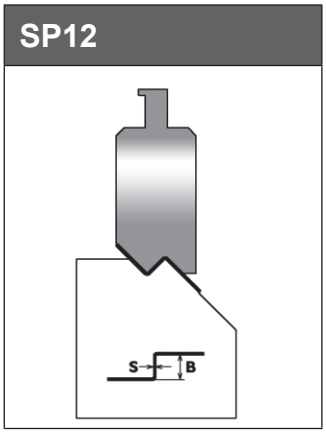
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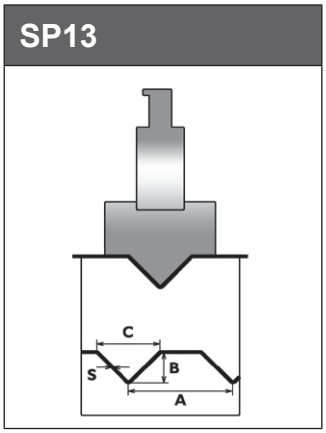
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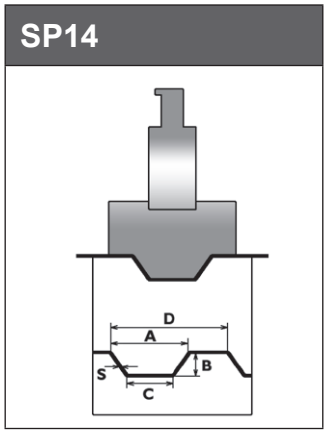
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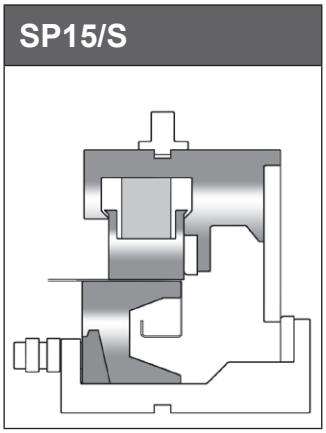
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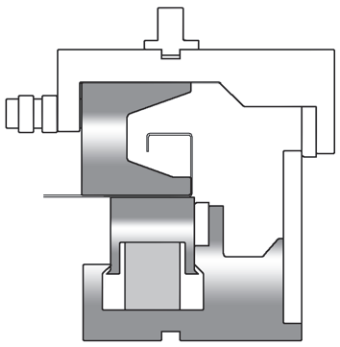
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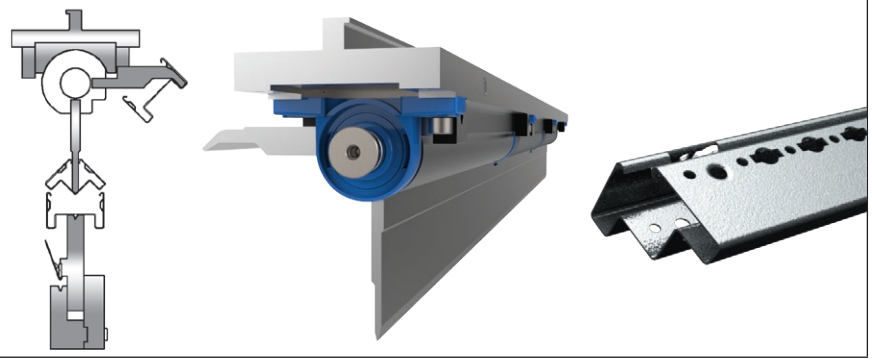
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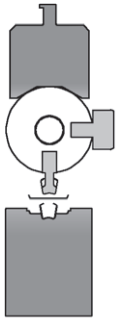
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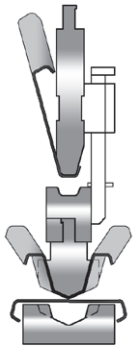
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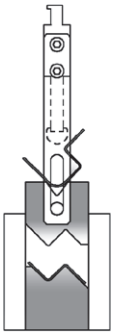
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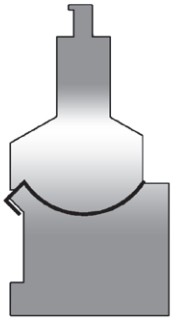
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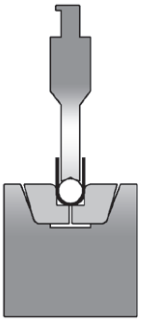
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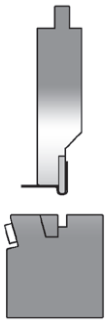
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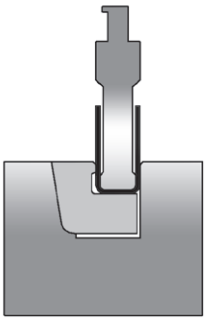
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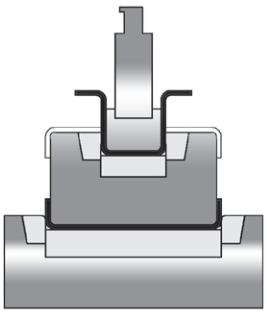
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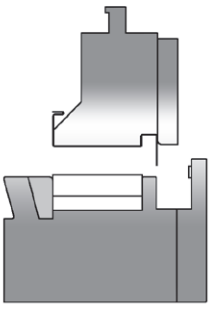
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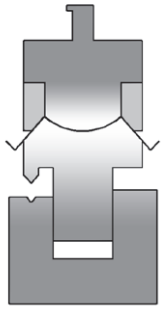
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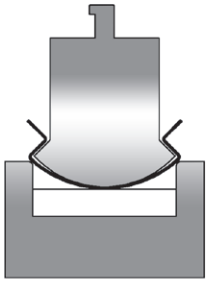
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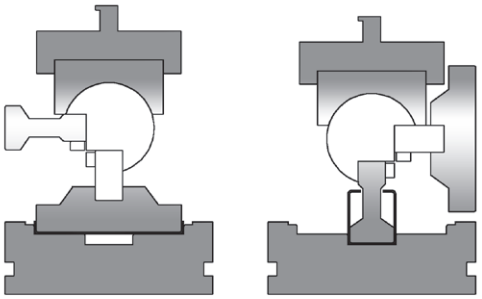
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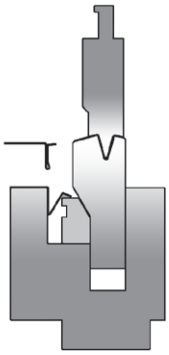
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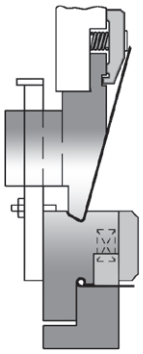
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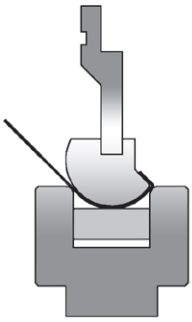
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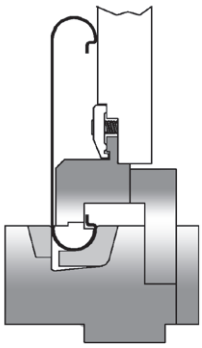
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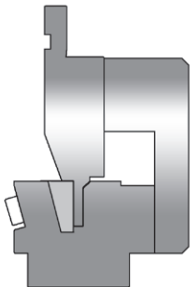
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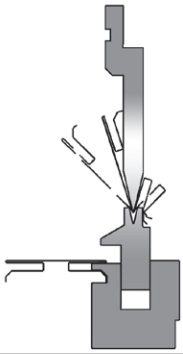
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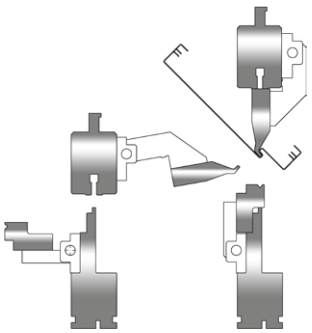
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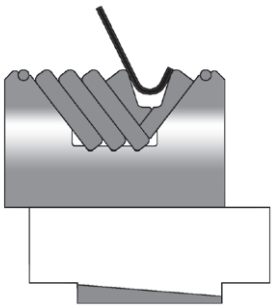
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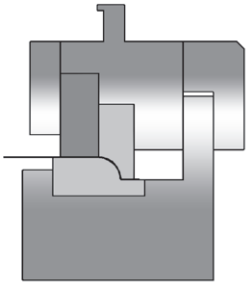
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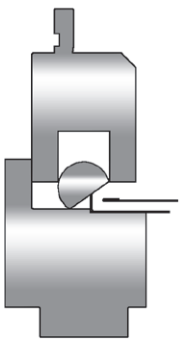
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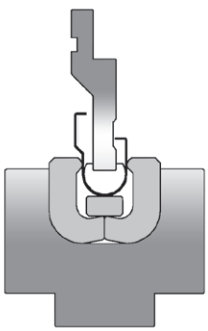
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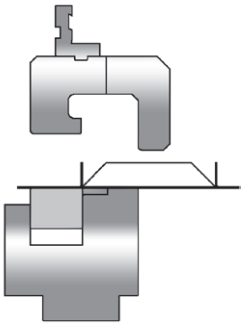
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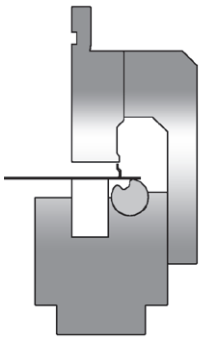
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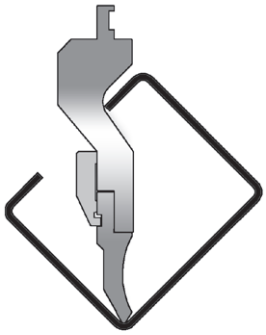
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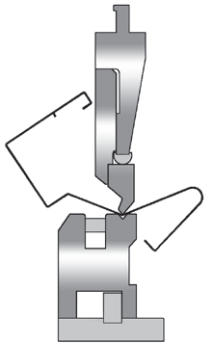
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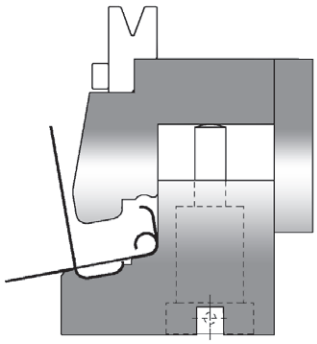
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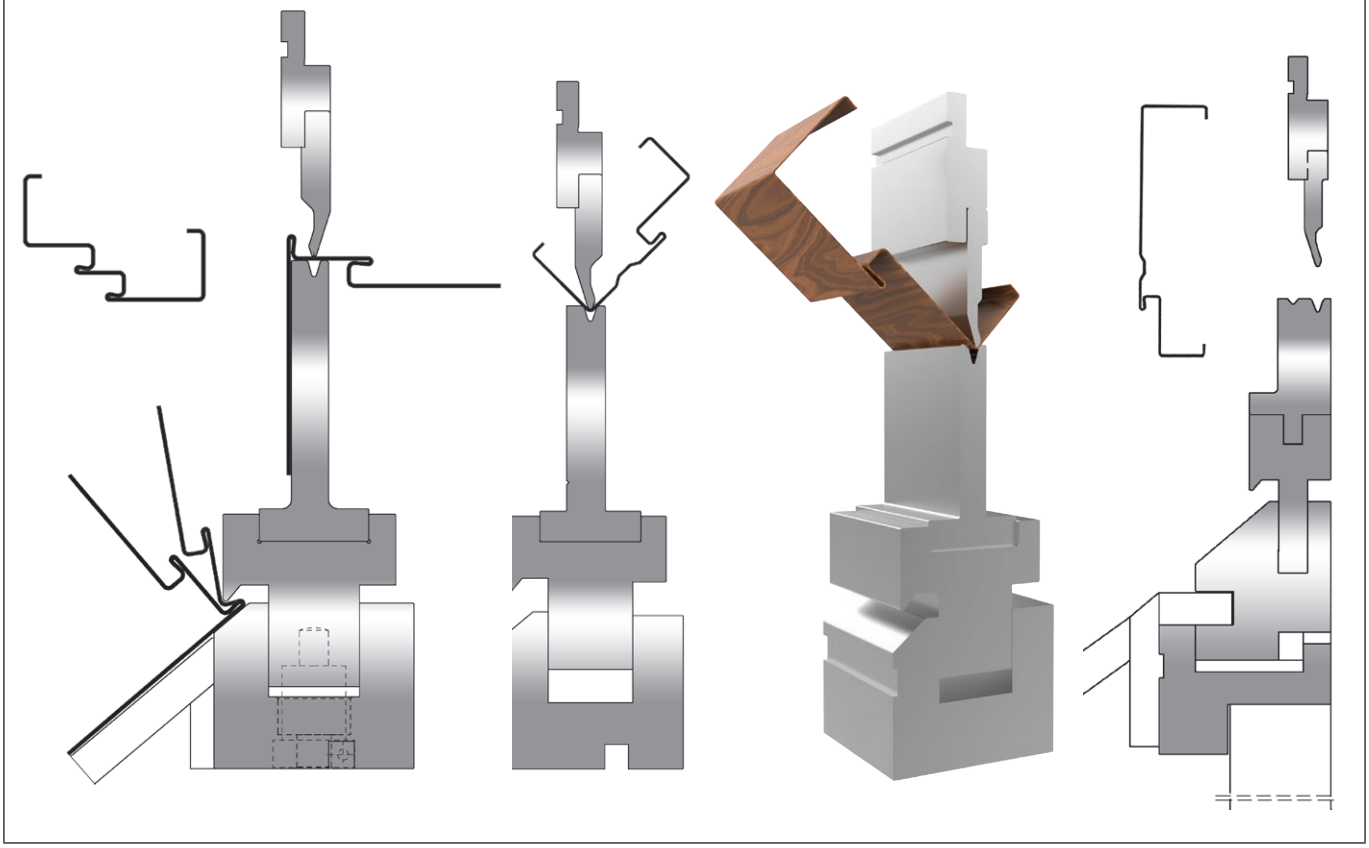
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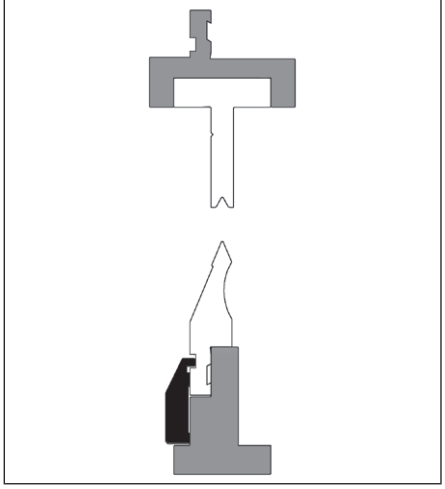
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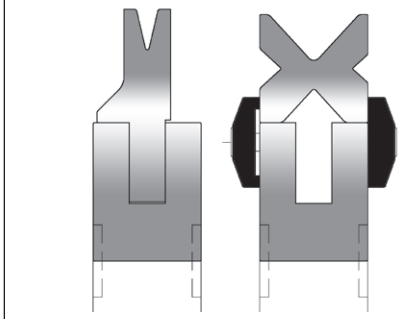
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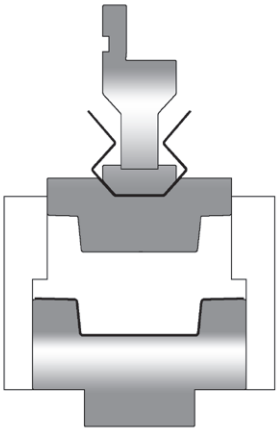
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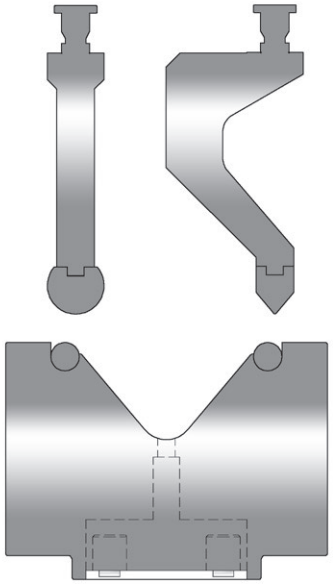
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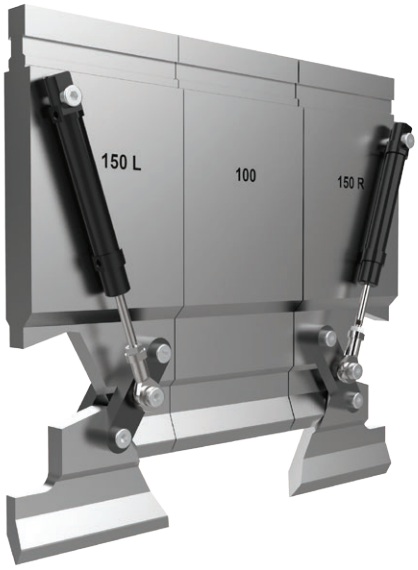
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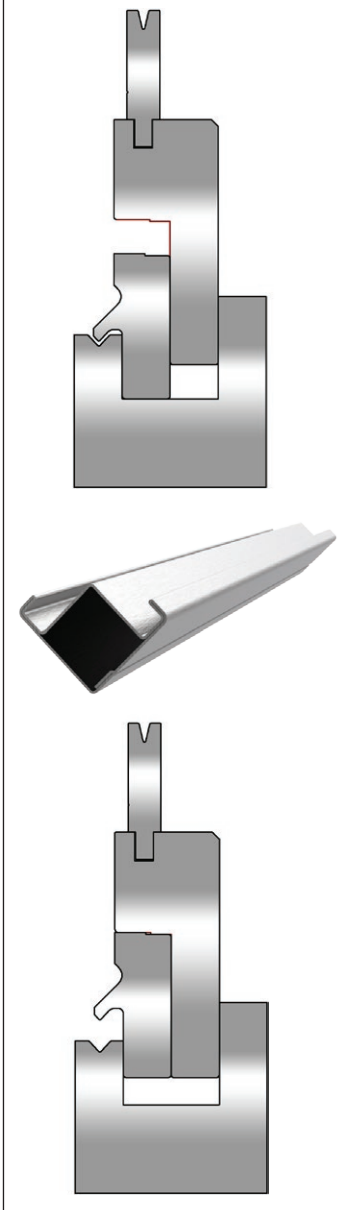
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SCA-MOB-PNEU



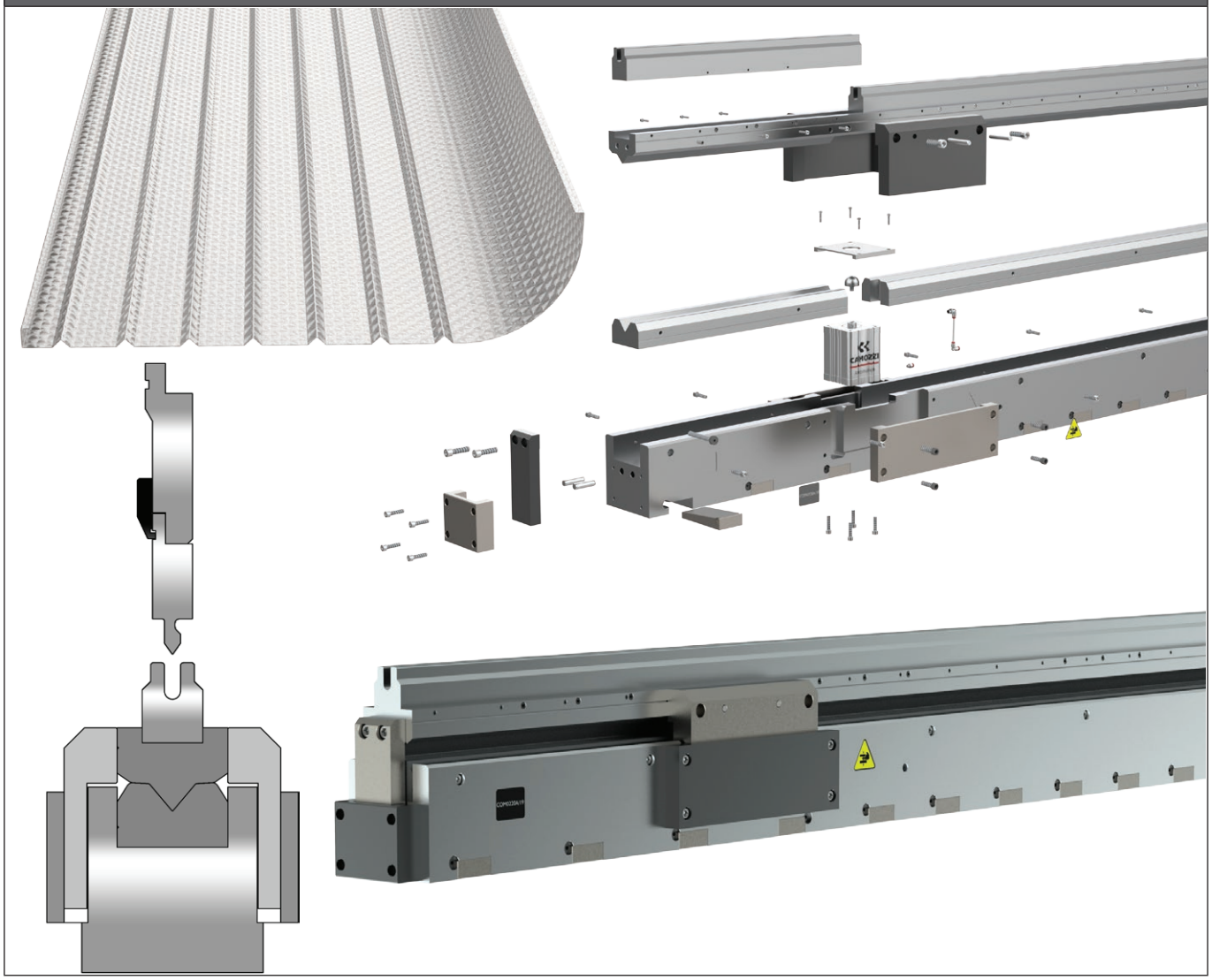
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SP52

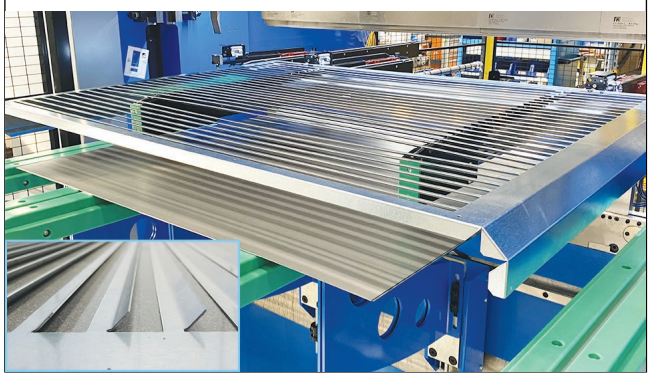


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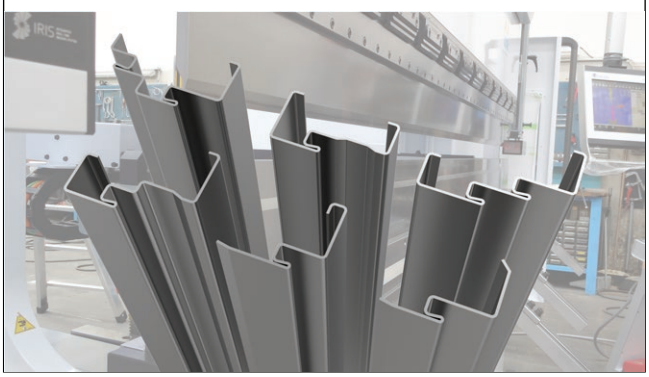


VIDEO VIDEOS

Stampo speciale feritoie
Louvres special tool

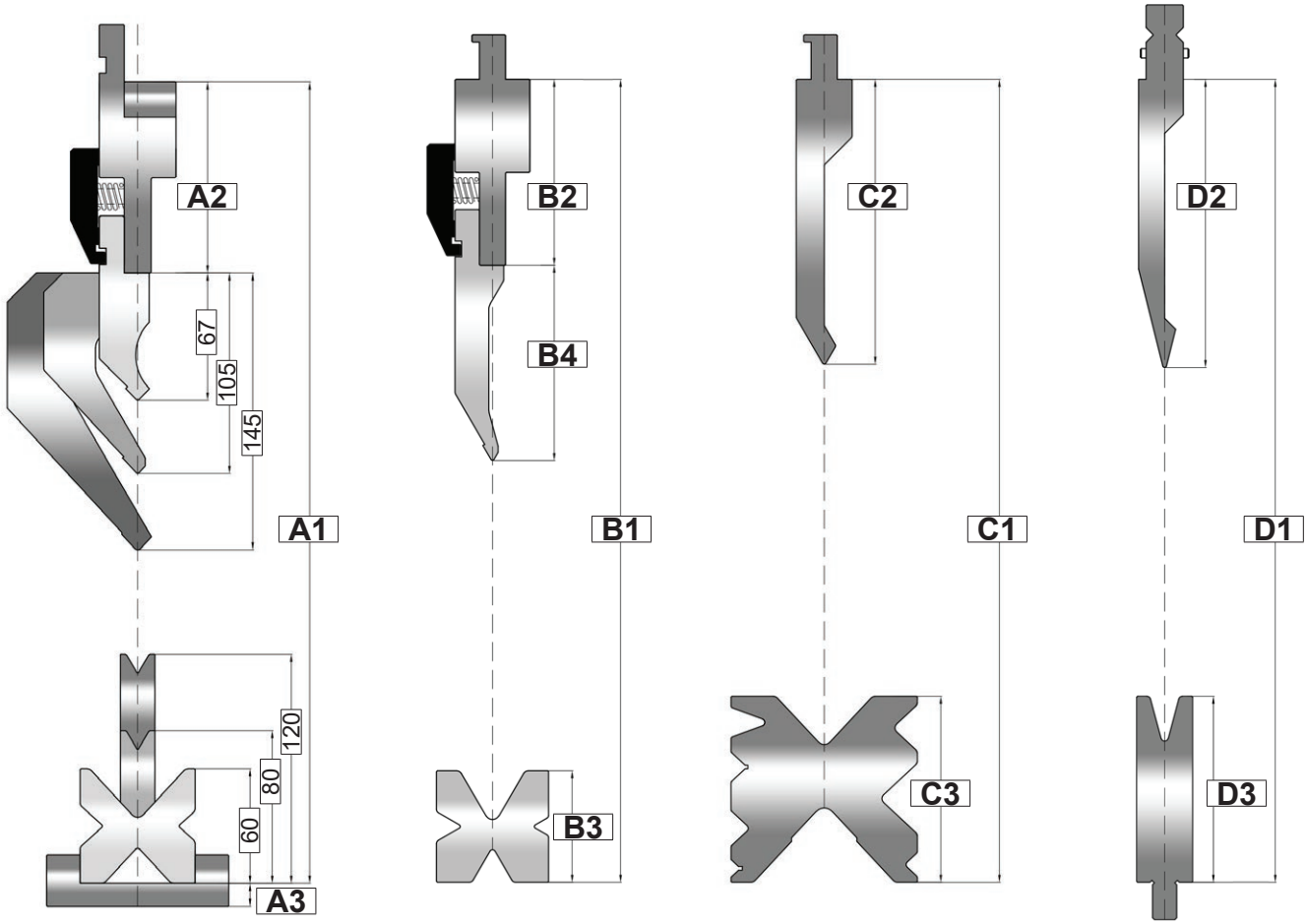


Stampo speciale door frame
Door frame special tool



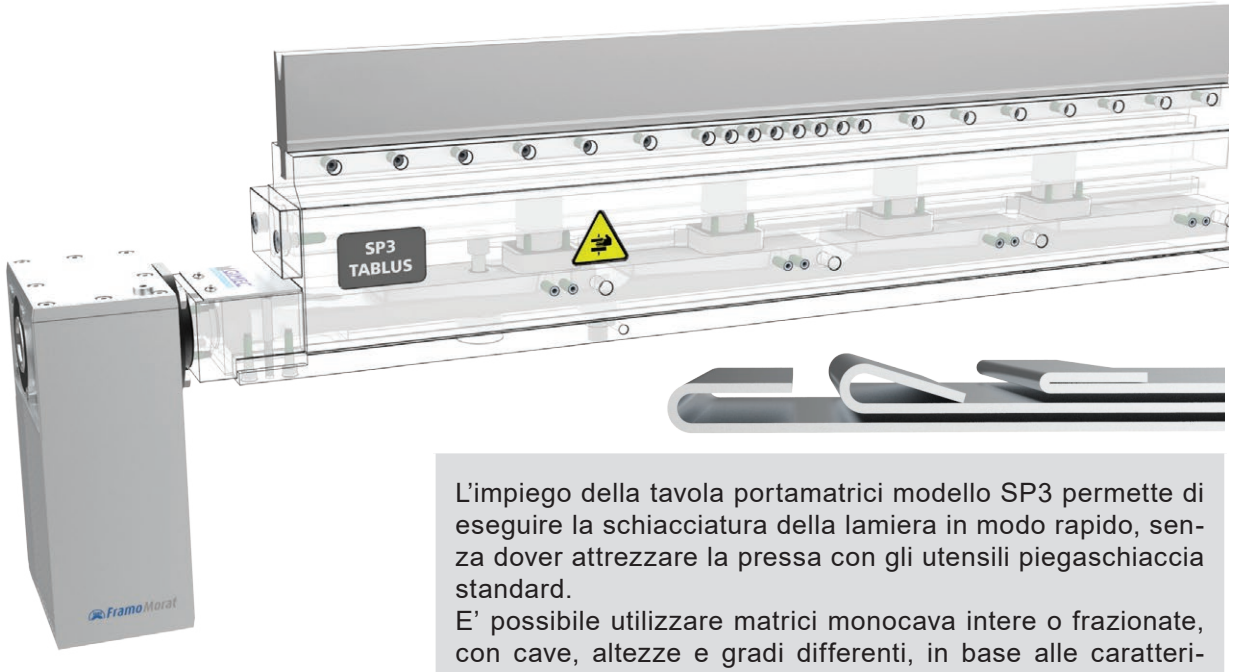
altri video disponibili sul nostro sito internet
other videos available on our website

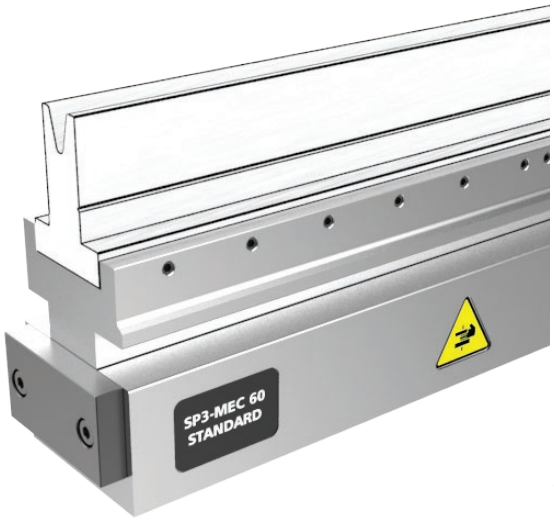
A	B	C	D



A1	mm	**B1**	mm	**C1**	mm	**D1**	mm
A2	mm	**B2**	mm	**C2**	mm	**D2**	mm
A3	mm	**B3**	mm	**C3**	mm	**D3**	mm
		B4	mm				
POTENZA POWER	kN/mt	**POTENZA POWER**	kN/mt	**POTENZA POWER**	kN/mt	**POTENZA POWER**	kN/mt
LUNGHEZZA LEGTHS	mm	**LUNGHEZZA LEGTHS**	mm	**LUNGHEZZA LEGTHS**	mm	**LUNGHEZZA LEGTHS**	mm
CORSA STROKE	mm	**CORSA STROKE**	mm	**CORSA STROKE**	mm	**CORSA STROKE**	mm
INCAVO GAP	mm	**INCAVO GAP**	mm	**INCAVO GAP**	mm	**INCAVO GAP**	mm

TAVOLA PORTAMATRICI CON APERTURA PNEUMATICA PER SCHIACCIATURA LAMIERA
DIE HOLDER TABLE WITH PNEUMATIC OPENING FOR SHEET METAL FLATTENING







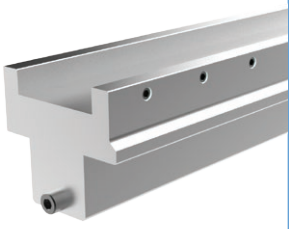
L'impiego della tavola portamatrici modello SP3 permette di eseguire la schiacciatura della lamiera in modo rapido, senza dover attrezzare la pressa con gli utensili piegaschiaccia standard.
E' possibile utilizzare matrici monocava intere o frazionate, con cave, altezze e gradi differenti, in base alle caratteristiche della lamiera. Questo permette di piegare profili con eventuali contropieghe posteriori e/o laterali.
L'apertura del piano di schiacciatura viene gestita da una funzione del CNC ed avviene attraverso cilindri pneumatici speciali a singolo effetto.
Il tempo ciclo di piegatura viene ridotto notevolmente, perché, nella fase di piega, la velocità di discesa della pressa non viene rallentata, come invece accade per gli utensili piegaschiaccia con sollevamento a molle. La tavola viene fornita con sensori di posizione (aperta/chiusa).
E' possibile integrare un sistema di centinatura manuale o automatico nella parte inferiore.
Le parti di scorrimento ed i piani di schiacciatura della tavola sono temprati per evitarne l'usura.
Viene montata su presse di nuova costruzione, ma anche per retrofitting su presse già esistenti.

The use of the model SP3 die holder table allows you to perform the sheet flattening quickly without equipping the press with traditional standard tools.
It is possible to use solid or sectioned mono V dies with different slots, heights, and degrees, based on the characteristics of the sheet. This process allows bending the profiles with possible reverse bending rear or in the side.
The flattening plane's opening is managed by a CNC function and takes place through special single-acting pneumatic cylinders. The bending cycle time is considerably reduced because, in the bending phase, the descent speed of the press does not slow down, as the case with flattening tools with springs. The table is supplied with position sensors (open/closed).
It is possible to integrate a manual or automatic crowning systems in the lower part.
The sliding parts and the flattening surfaces of the table are hardened to avoid wear.
It is installed on new presses, and also for the retrofitting of existing presses.

LUNGHEZZE - LENGTHS 2010 - 3060 - 4080 - 5100 mm - oltre/beyond

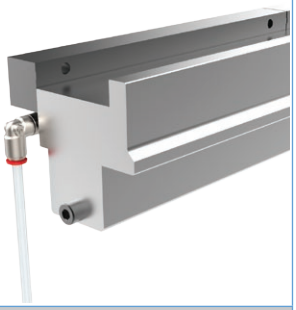
SUPERIORE UPPER

MEC 60



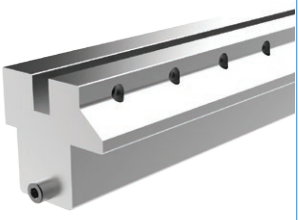
matrici base 60 mm
bloccaggio meccanico
lower tools 60 mm
mechanical clamping

PNE 60



matrici base 60 mm
bloccaggio pneumatico
lower tools 60 mm
pneumatic clamping

MEC 13



matrici base 13 mm
bloccaggio meccanico
lower tools 13 mm
mechanical clamping

IDR 13



matrici base 13 mm
bloccaggio idraulico
lower tools 13 mm
hydraulic clamping

FLATTENING

INFERIORE LOWER

BASE 60



base inferiore con attacco 60 mm
lower clamping base 60 mm

BASE 13



base inferiore con attacco 13 mm
lower clamping base 13 mm

BASE STANDARD



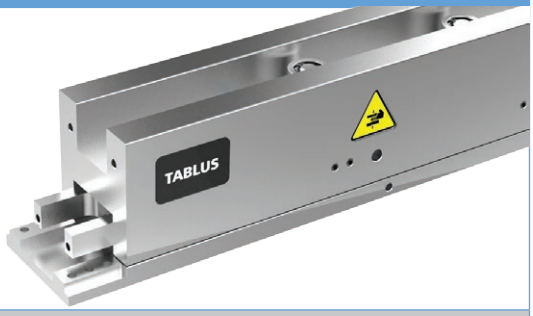
base standard da fissare al banco della pressa
standard base to fix on the lower beam

BASE CUNEI

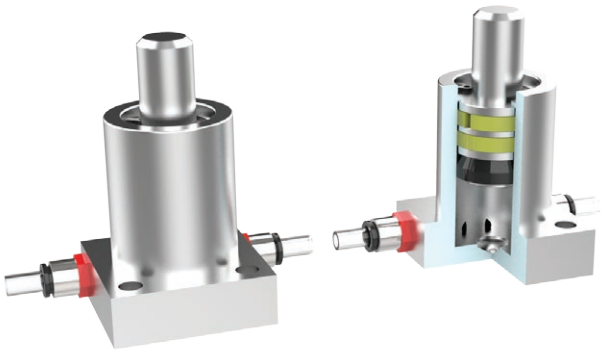


base da fissare al banco con cunei di centinatura manuali
base to fix on lower beam with manual wedges

BASE TABLUS

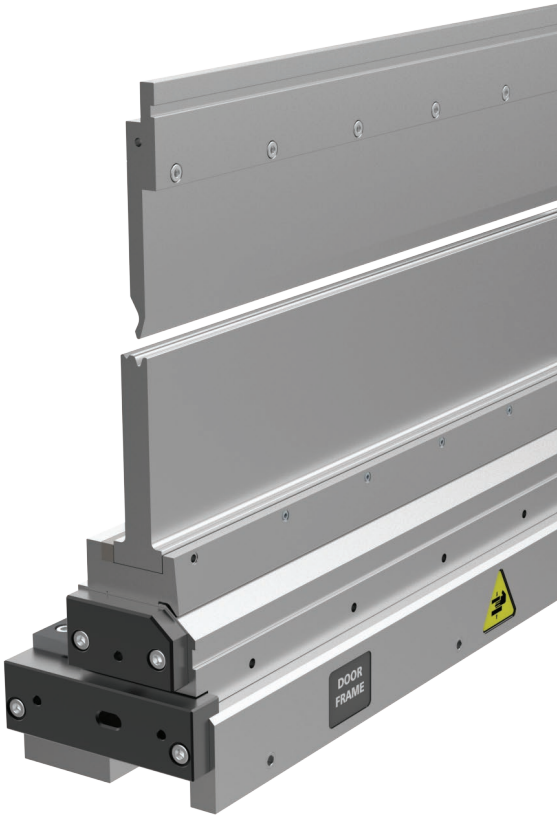


base con sistema automatico di centinatura TABLUS integrato
base with integrated automatic crowning system TABLUS



CILINDRI SPECIALI
SPECIAL CYLINDERS

ATTREZZATURA PER PIEGATURA PROFILI DOOR FRAME
EQUIPMENT FOR BENDING DOOR FRAME PROFILES



La piegatura di profili DOOR FRAME richiede attrezzature speciali con le quali è possibile completare l'intero ciclo di piegatura senza sostituire gli utensili.

L'attrezzatura è composta da una tavola portamatrici con cui è possibile eseguire la schiacciatura e dai relativi utensili (superiore e inferiore). Vengono inoltre forniti supporti frontali per l'appoggio della lamiera nella fase di schiacciatura.

Quando nei profili sono presenti delle lavorazioni nelle vicinanze della linea di piega (asole o tagli), si rende necessario utilizzare una matrice con doppia cava. In questo caso viene realizzato un sistema pneumatico di spostamento.

Le caratteristiche degli utensili vengono definite in base alle dimensioni dei profili.

The bending of DOOR FRAME profiles requires special equipment to complete the entire bending cycle without replacing the tools.

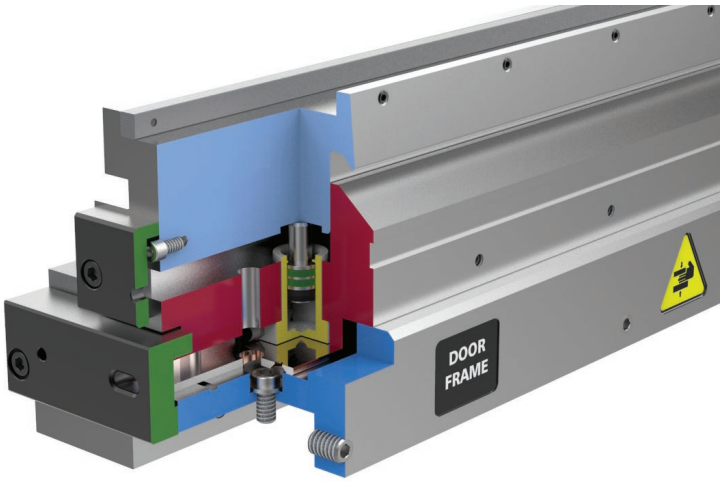
The equipment is made up of a tool holder table with which it is possible to perform the flattening and with the related tools (top and bottom).

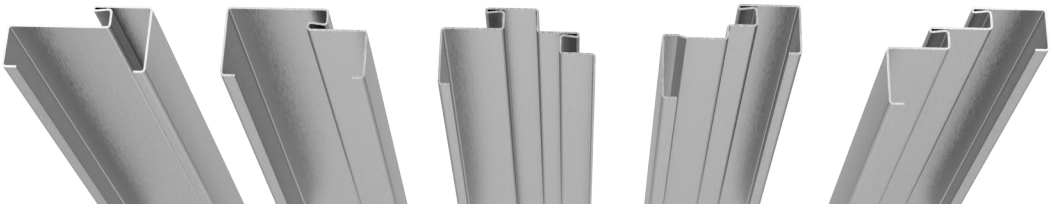
Front arms are also provided for the support of the sheet metal during the flattening phase.

When there are processes in the profiles near to the bending line (slots or cuts), it is necessary to use a die with double V. In this case a pneumatic displacement system is realized.

The characteristics of the tools are defined according to the dimensions of the profiles.







LUNGHEZZE - LENGTHS 2550 - 3050 - 4175 mm

ATTREZZATURA PER PRESSE DA LATTONIERE
EQUIPMENT FOR TINSMITH PRESS BRAKES



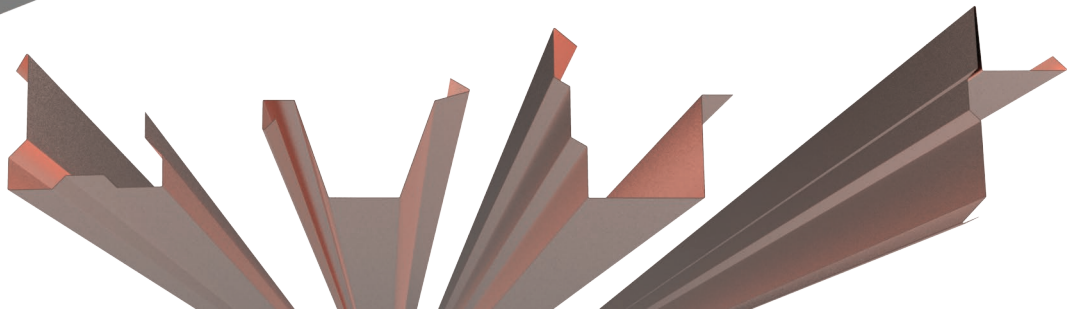
Le lavorazioni di LATTONERIA richiedono attrezzature con lunghezze superiori ai 6 metri, con sagome contenute per permettere di piegare profili tipici di questo settore.

Per maggiore flessibilità nelle varie lavorazioni, a differenza degli utensili tradizionali da lattoneria, abbiamo previsto la possibilità di effettuare il cambio della matrice in base allo spessore da piegare.

The TINSMITH workings require an equipment with lengths over than 6 meters, with small shapes to allow bending profiles typical of this field.

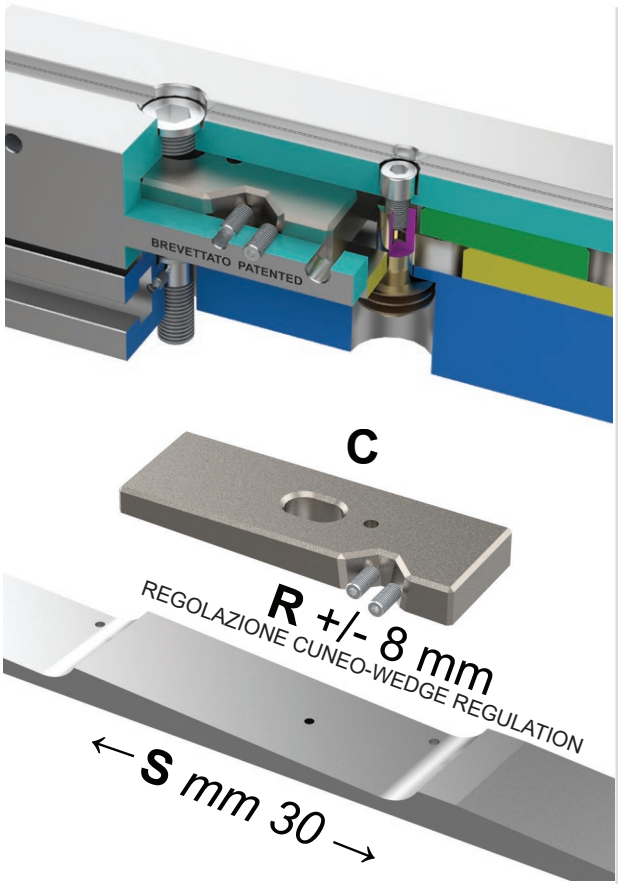
For greater flexibility in the various processes, unlike the traditional tools from tinning, we have provided the possibility to change the die according to the thickness that must be bent.





LUNGHEZZE - LENGTHS 6500 - 8550 - 10050 mm

SISTEMA AUTOMATICO DI CENTINATURA - AUTOMATIC CROWNING SYSTEM

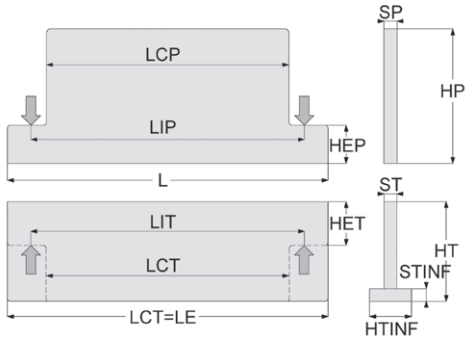


Con l'utilizzo di questo sistema è possibile compensare meccanicamente la flessione che si verifica sulle presse piegatrici durante la fase di piegatura e che determina angoli di piega irregolari. La flessione varia in funzione della lunghezza di piegatura ed in base al rapporto tra la larghezza della cava ed il tipo e spessore della lamiera.
Il sistema TABLUS (***brevettato***) è composto da una barra speciale (***S***) che scorre in contrapposizione a dei cunei (***C)***. Ogni cuneo, se necessario, puo' essere calibrato singolarmente (***R)***. La barra è azionabile manualmente (***sistema TCM-TSM***) oppure attraverso un motoriduttore controllato dal CNC della pressa piegatrice (***sistema TCMR-TSMR***). La regolazione della TABLUS viene effettuata in modo rapido e preciso prima della fase di piegatura. Ogni singola TABLUS e' prodotta in base alle caratteristiche della pressa piegatrice su cui verra' utilizzata, in modo da ottimizzare il suo funzionamento. Questo avviene attraverso l'utilizzo di uno speciale software, denominato ***DATA TABLUS***, che calcola le flessioni della pressa piegatrice e fornisce indicazioni su come realizzare il sistema di centinatura. Si ottiene quindi un sistema in grado di garantire una regolazione centesimale ed accurata.
Esistono più versioni di TABLUS che si differenziano in base al tipo di matrici utilizzate. Le versioni TCM-TCMR vengono fornite complete di staffe per il bloccaggio manuale delle matrici. Su richiesta può essere fornito un sistema pneumatico per il bloccaggio rapido. TABLUS viene fornita pronta per il fissaggio e l'allineamento alla pressa piegatrice.

TABLUS

BREVETTATO PATENTED

DATA TABLUS				esempio - example			
P	forza pressa	kN	**1200**	**L**	* lunghezza pressa	mm	**3100**
PESTONE				TRAVERSA INFERIORE			
LIP	distanza appoggi	mm	2650	LIT	distanza appoggi	mm	2650
LCP	lunghezza centrale	mm	2260	LCT	** lunghezza centrale	mm	2600
HP	altezza centrale	mm	1235	HT	altezza centrale	mm	845
HEP	altezza esterna	mm	495	HET	** altezza esterna	mm	435
SP	spessore pestone	mm	50	ST	spessore traversa	mm	100
				LIPm	LIP<LIPm=cunei negativi limite cunei negativi	mm	2430



* lunghezza L sempre pari a multiplo di 200+100

** per traversa senza rientranze LCT=L e HET=HT

RINFORZO SU TRAVERSA INFERIORE		
STINF	mm	120
HTINF	mm	250

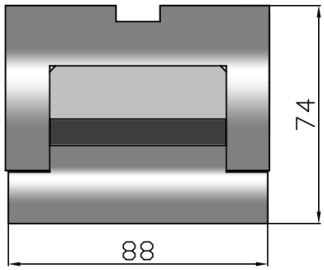
cuneo	distanze	STRISCIA **S** max compensazione con regolazione 30 mm	CUNEO **C** max compensazione con regolazione 8 mm
1	150	0,30 mm	0,08 mm
2	350	0,62 mm	0,17 mm
3	550	0,88 mm	0,24 mm
4	750	1,07 mm	0,28 mm
5	950	1,18 mm	0,32 mm
6	1150	1,27 mm	0,34 mm
7	1350	1,32 mm	0,35 mm
8	1550	1,34 mm	0,36 mm
9	1750	1,32 mm	0,35 mm
10	1950	1,27 mm	0,34 mm
11	2150	1,18 mm	0,32 mm
12	2350	1,07 mm	0,28 mm
13	2550	0,88 mm	0,24 mm
14	2750	0,62 mm	0,17 mm
15	2950	0,30 mm	0,08 mm

This system provides mechanical compensation of deflections appearing during the bending process. Deflection changes depending on bending lenght, die slot width, type of material and its thickness. TABLUS system (***patented***) is composed by a special rod (***S***) which is placed between opposite wedges (***C).*** Every wedge can be calibrated if necessary (***R)***. The rod is driven manually (***TCM-TSM system***) or by a motoreducer controlled by CNC (***TCMR - TSMR system***). The adjustement of TABLUS system is a fast and accurate procedure to execute before bending. Every TABLUS system is produced on the base of the press brake characteristics to optimize its functioning. That is provided by the use of special software ***DATA TABLUS,*** which calculates press brake deflections and provides crowning system throughout control commands. This system grants a very high accuracy. There are more versions of TABLUS system depending on the type of the dies used. TCM and TCMR versions are supplied with manual die clampings. On request we supply pneumatic system for fast clamping.
We provide TABLUS ready for fixing and leveling on the press brake.

TABLUS tipo/type TC

L mm 3100-4100-5100-6100

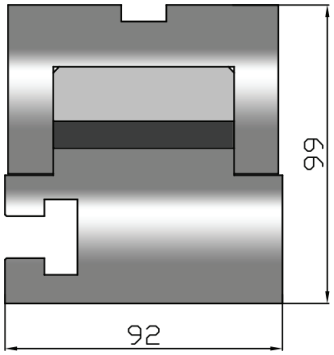




TABLUS tipo/type TC + T

L mm 3100-4100-5100-6100

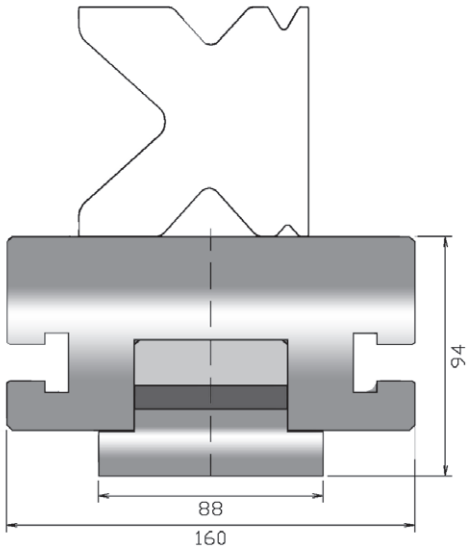




TABLUS tipo/type T160

L mm 3100-4100-5100-6100

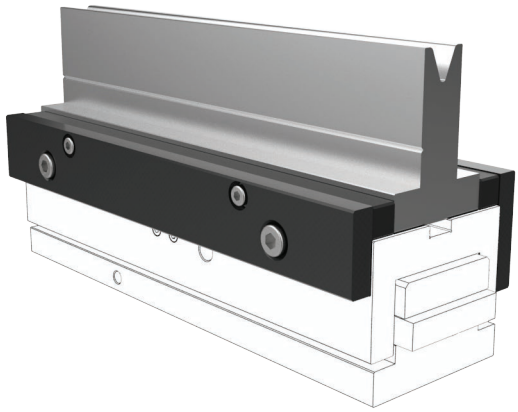


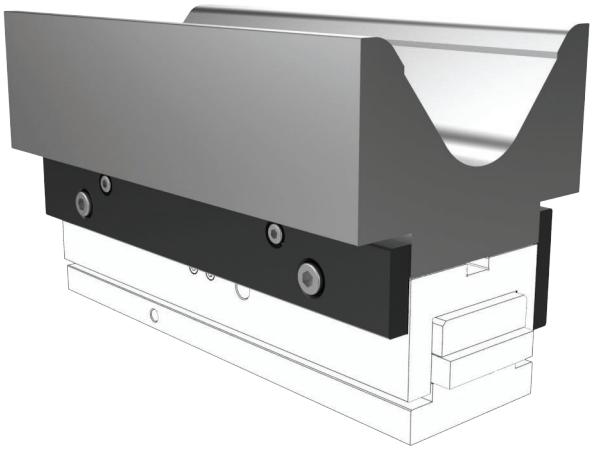


BREVETTATO
PATENTED

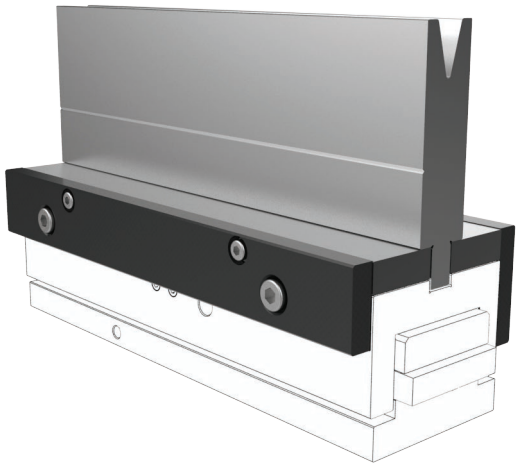
KIT BLOCCAGGIO UTENSILI - TOOLS CLAMPING KIT

utensili inferiori
lower tools **SERIE 60** **Kit 60/90 mm**

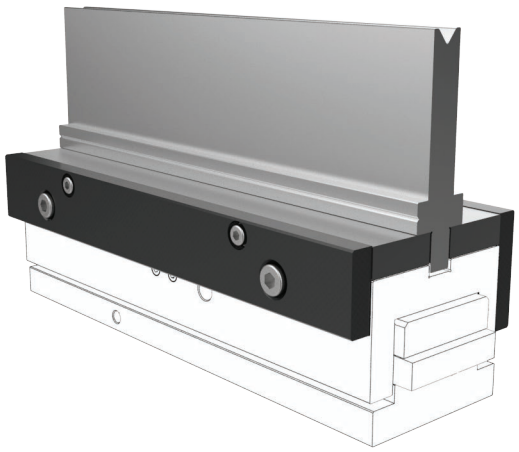




utensili inferiori
lower tools **SERIE 13** **Kit 13,0 mm**



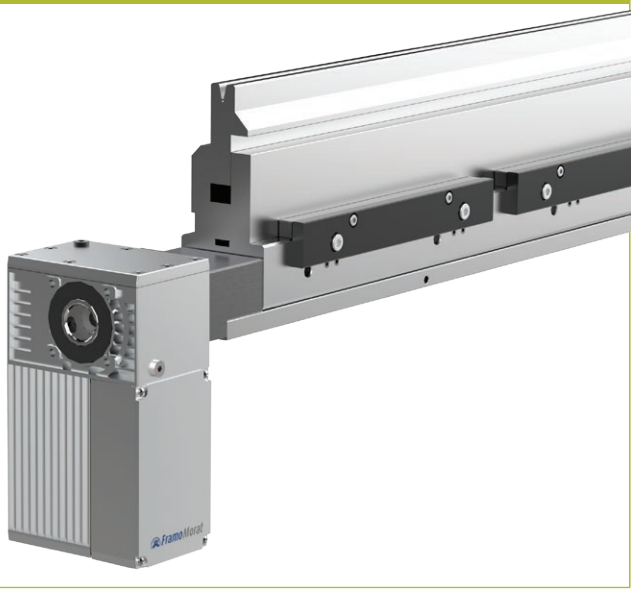
utensili inferiori
lower tools **SERIE 12,7** **Kit 12,7 mm**



MANUALE - MANUAL



MOTORIZZATA-MOTORIZED



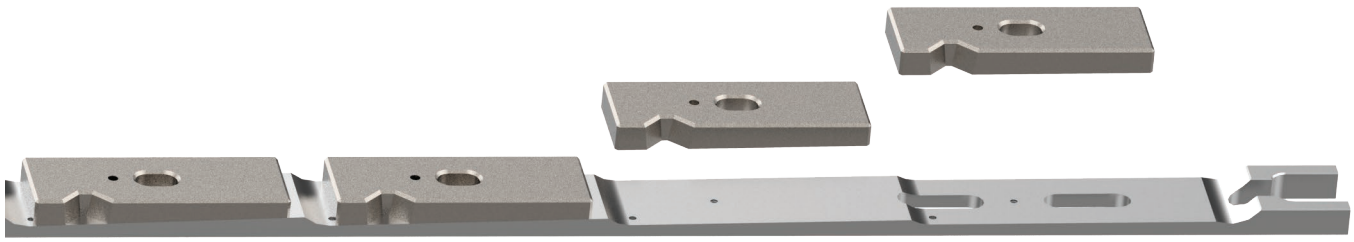
TABLUS

BREVETTATO
PATENTED

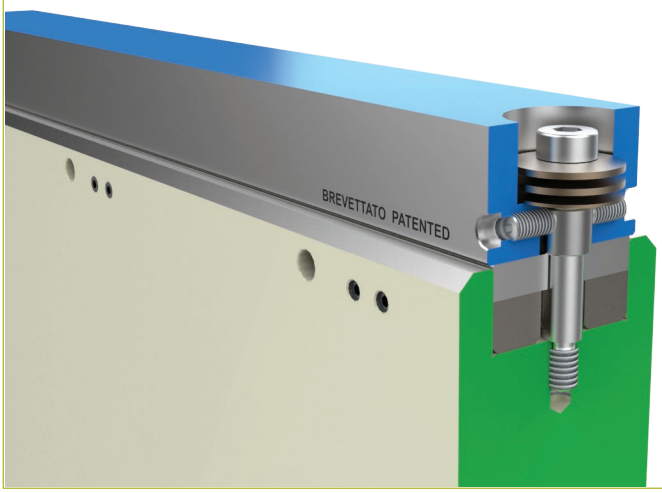
SISTEMA DI CENTINATURA INTEGRATO - INTEGRATED CROWNING SYSTEM

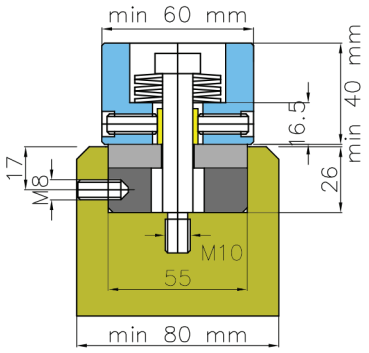
Il sistema di centinatura TABLUS viene fornito per essere integrato nella traversa inferiore della pressa piegatrice.
La tavola portamatrici deve avere le caratteristiche minime sotto indicate. Possiamo fornire la tavola oppure comunicare al cliente le specifiche tecniche di lavorazione sia della tavola che della traversa per l'alloggiamento del sistema di centinatura.

Crowing system TABLUS can be supplied to be integrated inside press brake lower beam.
Die holder table must have the minimum characteristics mentioned below.
We can supply it or we can give to the customer the processing specifications both for the table and the lower beam for the housing of the crowing system.

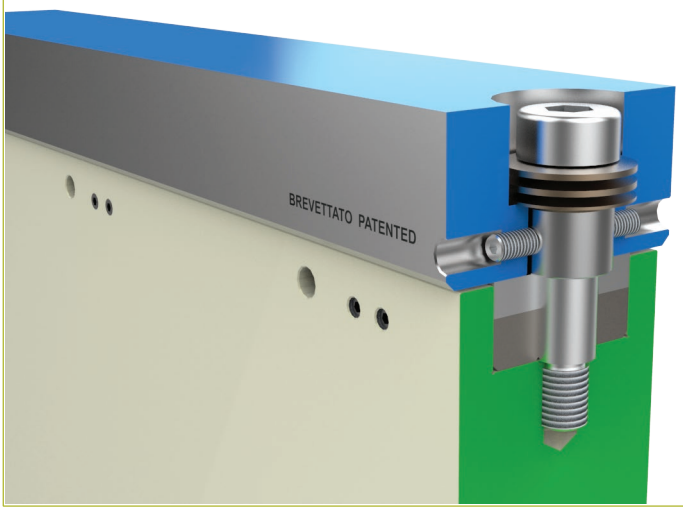


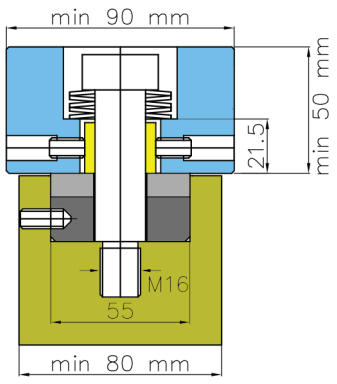
TSM-TSMR 60





TSM-TSMR 90

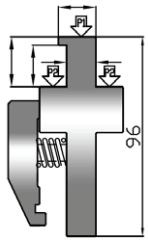




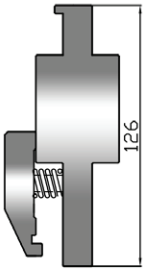
TABLUS

BREVETTATO PATENTED

PL3 h96+ST2

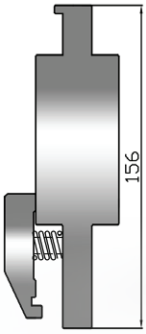


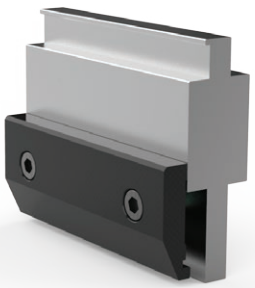
PL3 h126+ST2



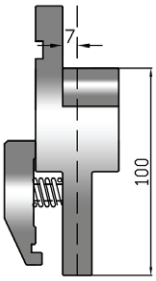
PL3 h156+ST2

L mm 150 - max 200 kN

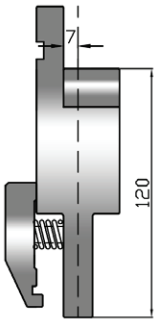




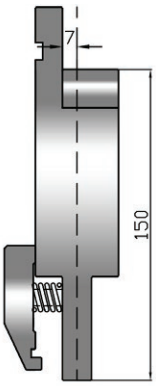
PL5 h100+ST2



PL5 h120+ST2

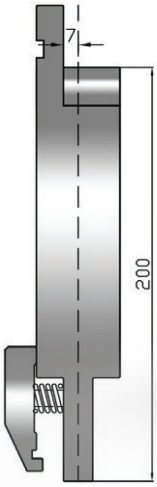


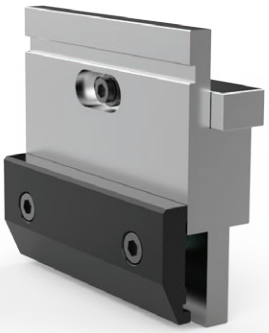
PL5 h150+ST2



PL5 h200+ST2

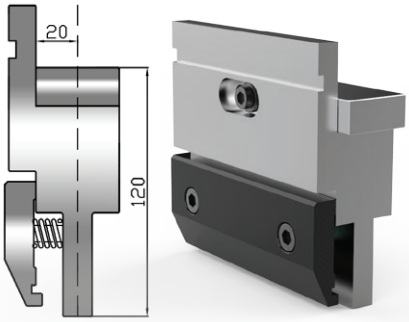
L mm 150 - max 200 kN





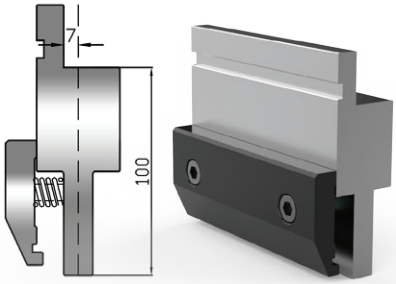
PL7 h120+ST2

L mm 150 - max 200 kN



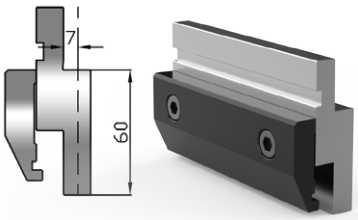
PL8 h100+ST2

L mm 150 - max 200 kN



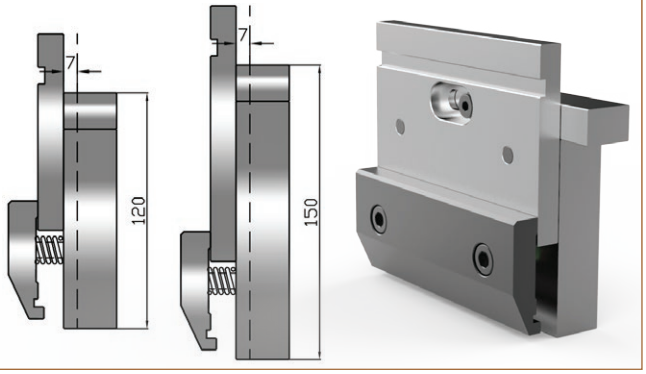
PL14 h60+ST2 h mm 53

L mm 150 - max 200 kN



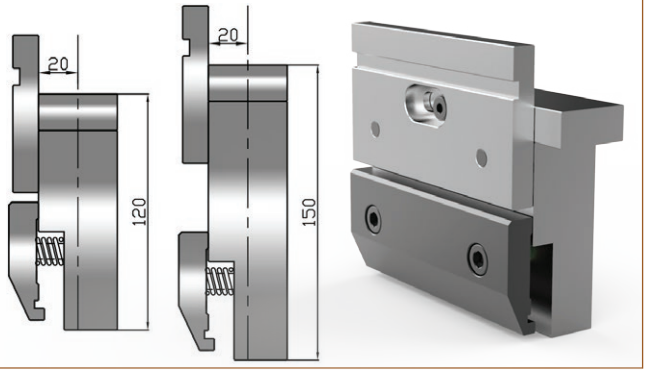
PL5/HT+ST2 h mm 120 h mm 150

L mm 150 - max 320 kN



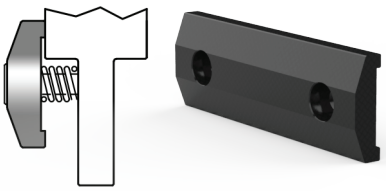
PL7/HT+ST2 h mm 120 h mm 150

L mm 150 - max 320 kN



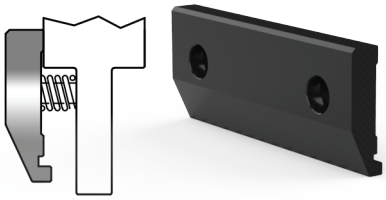
ST1

L mm 150



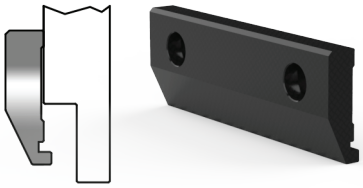
ST2

L mm 150



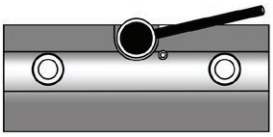
ST2 h mm 53

L mm 150



ST2/L

L mm 150

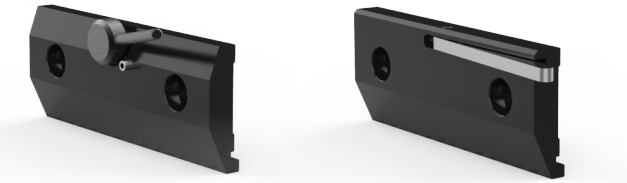


ST2/X

L mm 150

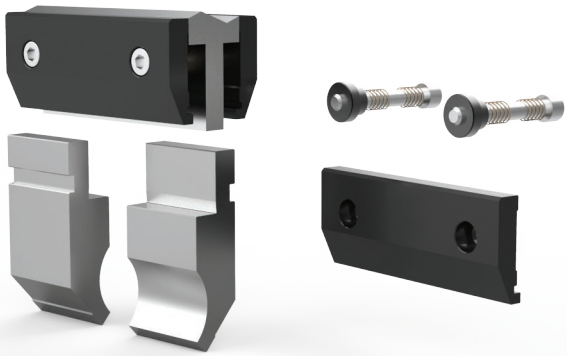


possono essere fornite con inserto in ADIPRENE /G
can be supplied with ADIPRENE /G insert



KIT/ST2 h 60 mm

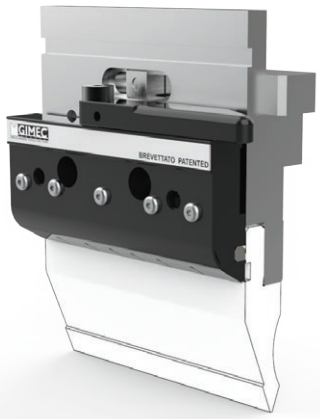
L mm 150 *KIT doppia staffa - double bracket KIT*



FAST LOCK / PL

Bloccaggio manuale per utensili superiori tramite comoda leva ergonomica. Introduzione ed estrazione frontale dell'utensile standard tipo US europeo e richiamo automatico in battuta. Possibilità di montare l'utensile rovesciato, dal fronte pressa utilizzando una staffa manuale completa di viti e molle (non compresa nella fornitura) serraggio tramite viti.

Manual clamping for upper tools by means of a comfortable ergonomic lever. Frontal introduction and extraction of the European-type standard tool and automatic return at the stop. Ability to mount the tool inverted, from the front of the press using a manual bracket complete with screws and springs (not included in the supply) tightening with screws.



FAST LOCK / ST

La staffa FAST LOCK/ST permette di riutilizzare l'intermedio esistente sulla piegatrice, sostituendo esclusivamente la staffa anteriore, ottenendo così, con un investimento minimo, un sistema di cambio rapido.
Introduzione/estrazione frontale dell'utensile standard tipo Europeo e richiamo automatico in battuta. Possibilità di montaggio dell'utensile rovesciato.

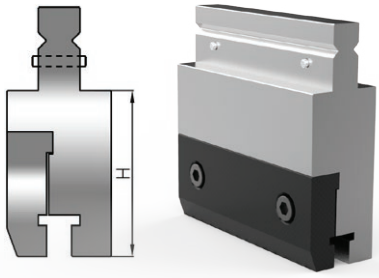
The FAST LOCK/ST clamp allows you to reuse the existing intermediate on the bending machine, replacing only the front bracket, thus obtaining, with a minimum investment, a quick change system. Frontal introduction/extraction of the standard European style tool and automatic return at the stop. Possibility of inverted tool mounting.



Possiamo fornire sistemi PNEUMATICI per il bloccaggio degli utensili superiori. INTERPELLATECI !
We can supply PNEUMATIC systems for clamping upper tools. CONTACT US!

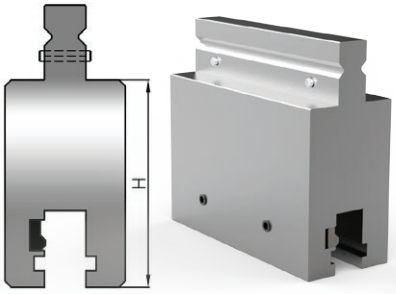
PL4 — Trumpf-Wila ► traditional

L mm 150 - max 400 kN



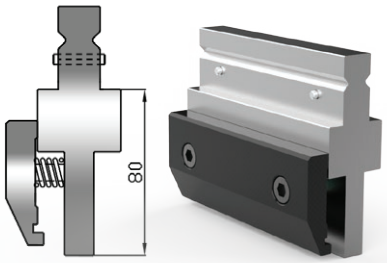
PL6 — Trumpf-Wila ► Trumpf-Wila

L mm 150 - max 400 kN



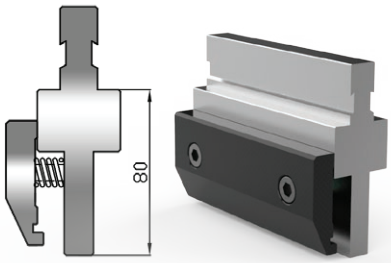
PL9+ST2 — Trumpf-Wila ► Amada

L mm 150 - max 200 kN



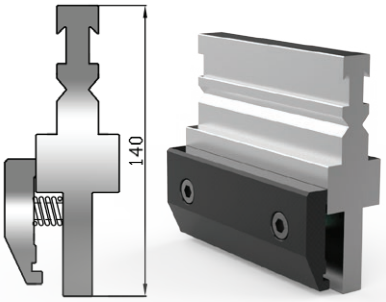
PL10+ST2 — Colgar ► Amada

L mm 150 - max 200 kN



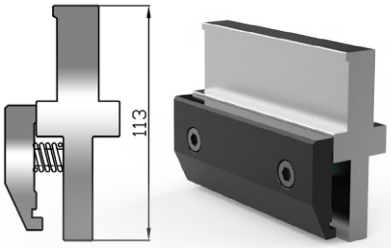
PL11+ST2 — Beyeler RFA►Amada

L mm 150 - max 200 kN



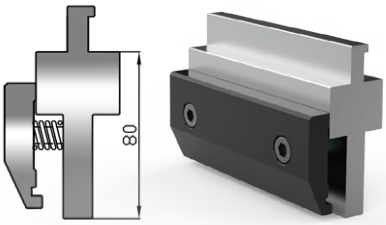
PL12+ST2 — Beyeler S ►Amada

L mm 150 - max 200 kN



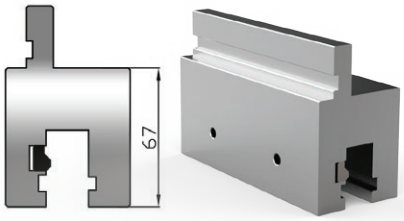
PL13+ST2 — LVD ► Amada

L mm 150 - max 200 kN



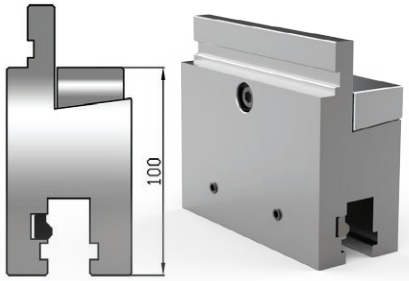
PL16 — Amada ► Trumpf-Wila

L mm 150 - max 400 kN



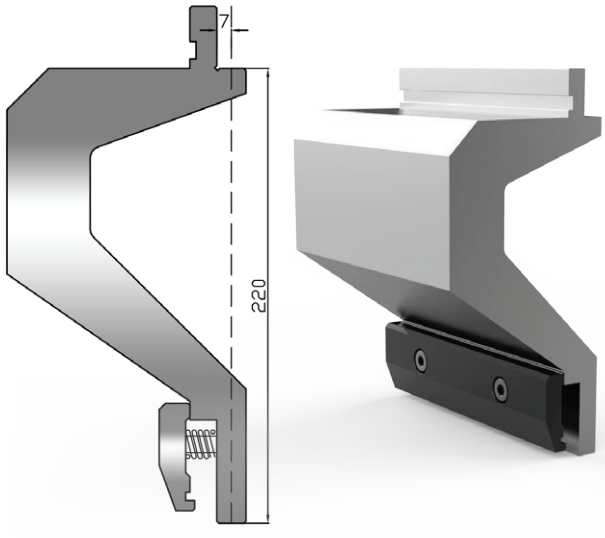
PL17 — Amada ►Trumpf-Wila

L mm 150 - max 400 kN



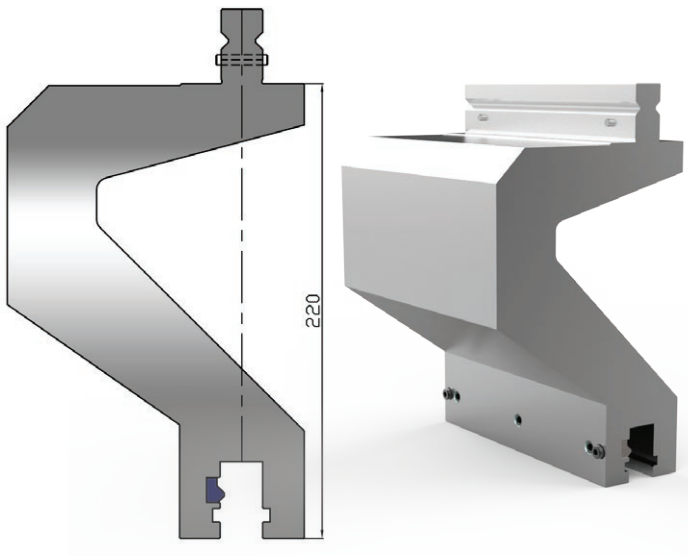
PL18 — Amada ►Trumpf-Wila

L mm 200 - max 180 kN



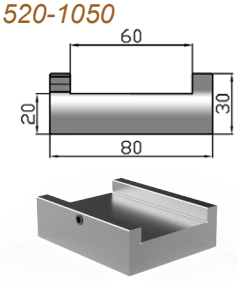
PL20 — Amada ►Trumpf-Wila

L mm 200 - max 180 kN



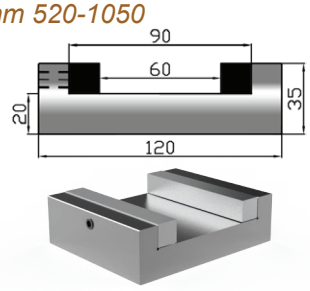
PM6 SHORT mm 60

L mm 520-1050



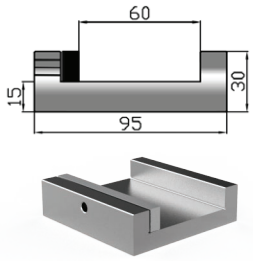
PM6 SHORT mm 60/90

L mm 520-1050



PM7

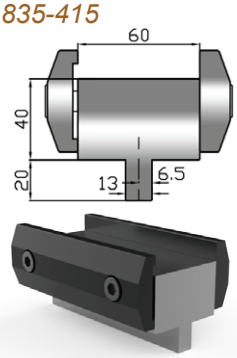
L mm 2100-2600-3100-4100



PM9 / T

Amada ►Trumpf-Wila

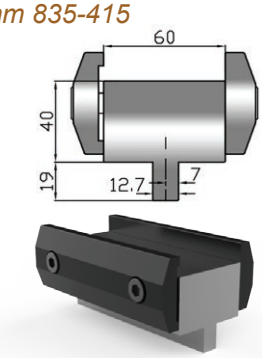
L mm 835-415



PM9 / L

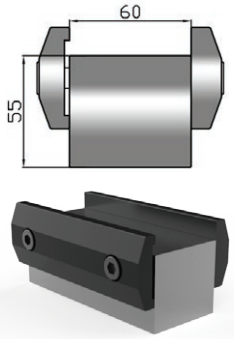
Amada ►LVD

L mm 835-415



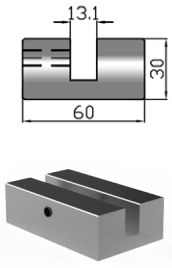
PM9 / 60

L mm 835-415



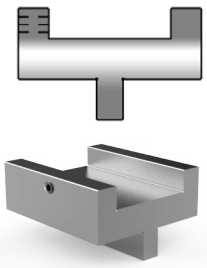
PM10 h 30 mm - h 60 mm

L mm 500-1000

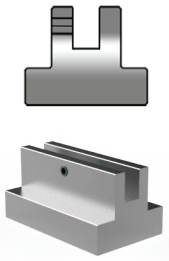


PM8

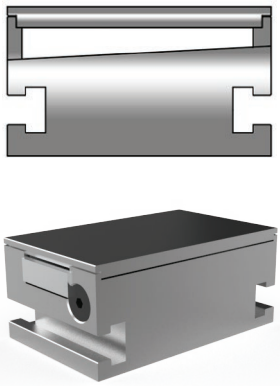
Amada ►LVD



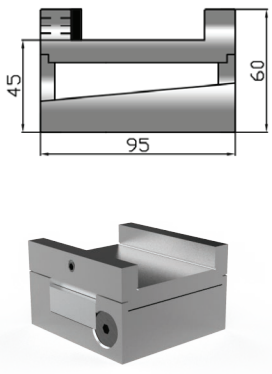
PM11



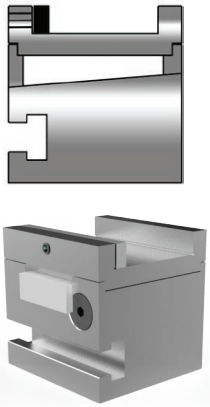
PM5



PM12



PM13



Possiamo fornire sistemi PNEUMATICI o IDRAULICI per il bloccaggio degli utensili inferiori.

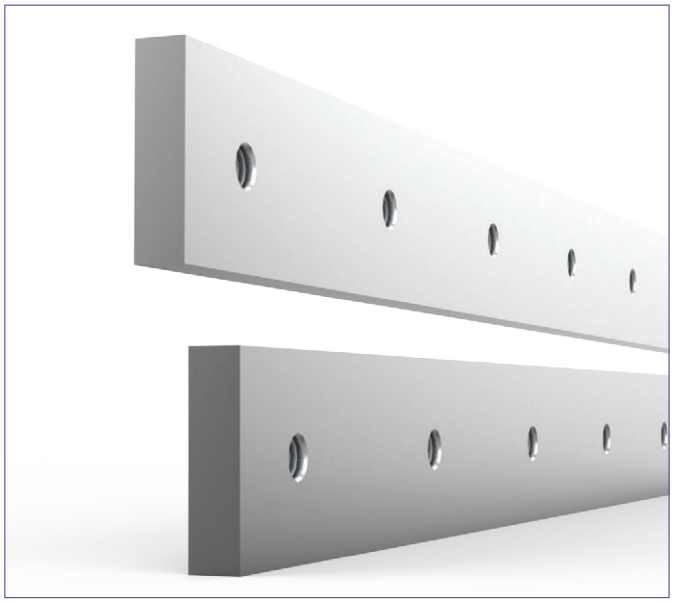
We can supply PNEUMATIC or HYDRAULIC systems for clamping lower tools.

INTERPELLATECI ! CONTACT US!

LAME RETTILINEE PER CESOIA - RECTILINEAR SHEAR BLADES



La nostra azienda vanta un'esperienza pluriennale nella costruzione di lame rettilinee per il taglio di lamiere.
Per la loro costruzione vengono impiegati acciai di alta qualità per permettere il taglio di lamiere ad alta resistenza, quali lamiere in acciaio inox, lamiere al manganese e al silicio.
Eseguiamo il trattamento termico con impianti tecnologicamente avanzati, gestiti da personale altamente qualificato
La rettifica delle superfici avviene mediante l'utilizzo di rettifiche tangenziali , per garantire la massima precisione e per evitare la formazione di micro rotture che potrebbero compromettere la durata delle lame.
Al termine delle lavorazioni di rettifica, le lame vengono accuratamente smagnetizzate.
Siamo inoltre attrezzati per eseguire la loro RIAFFILATURA in tempi brevissimi.



Our company has many years of experience in the production of rectilinear blades for sheet metal cutting.
For their manufacture are used high quality of steels which allow the cutting of high strength sheet metal such as stainless steel sheets, manganese and silicon sheets.
We perform the heat treatment with technologically advanced systems, managed by qualified employees team.
The surface grinding is performed by using tangential grinding to guarantee the maximum precision and to avoid micro-cracks creations that could compromise the duration of the blades.
At the end of the grinding operations the blades are carefully demagnetized.
We are also equipped to perform the blades regrinding in very short time.

PV

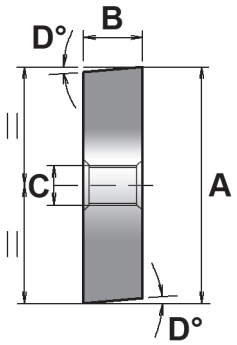
LAME ACCIAIO tipo PV (polivalente)

Questa tipologia di lame è adatta al taglio di lamiera con resistenza fino a 750 kN/mm² (lamiera in ferro e acciaio inox). Per esigenze specifiche, siamo in grado di consigliare e fornire lame con differenti tipologie di acciaio e trattamento termico.

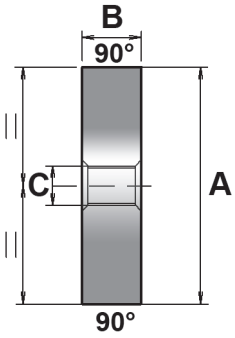
STEEL BLADES type PV (multi-purpose)

This type of blades is suitable for cutting sheets metal with resistance up to 750 kN/mm² (sheet iron and stainless steel). For specific needs, we are able to recommend and supply blades with different types of steel and heat treatment.

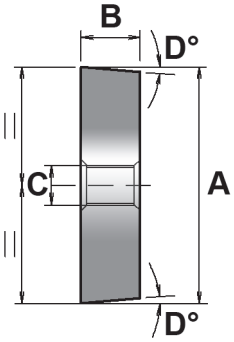
L1



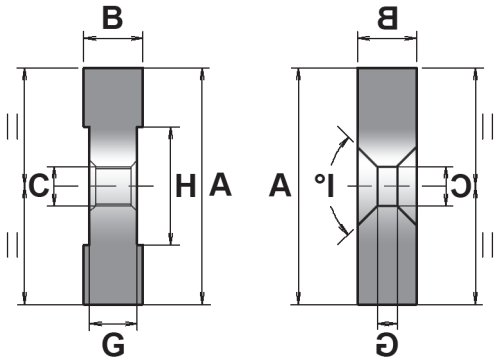
L2



L3

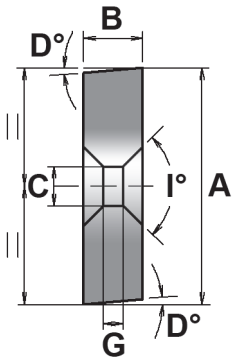


L4

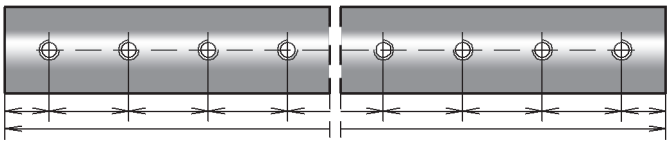


L5

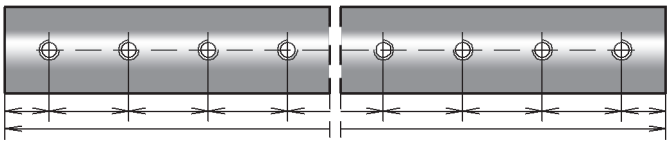
L6



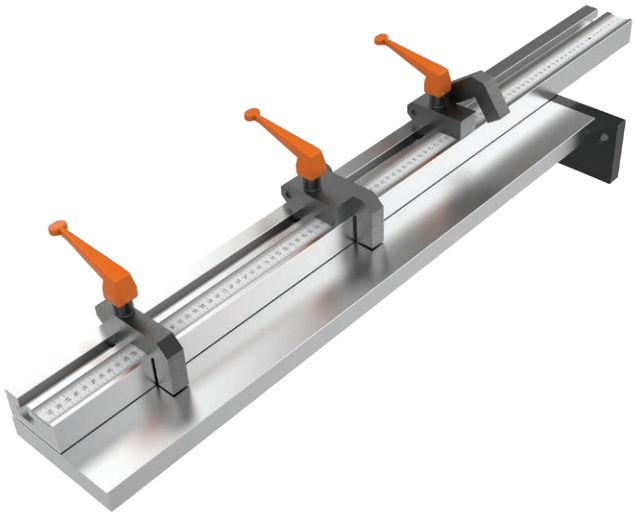
SUPERIORE - UPPER

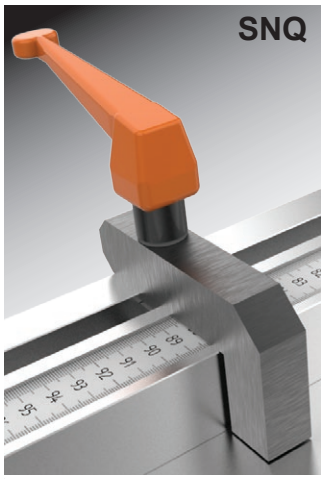


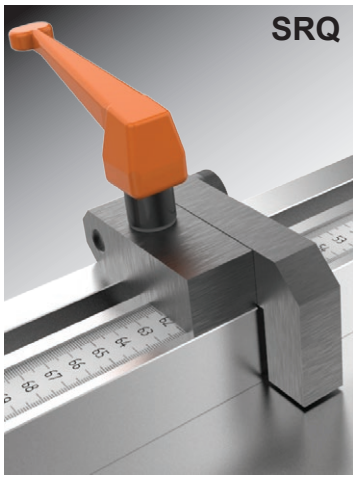
INFERIORE - LOWER



SQUADRA LATERALE PER CESOIA - SQUARING ARM FOR SHEAR SQ





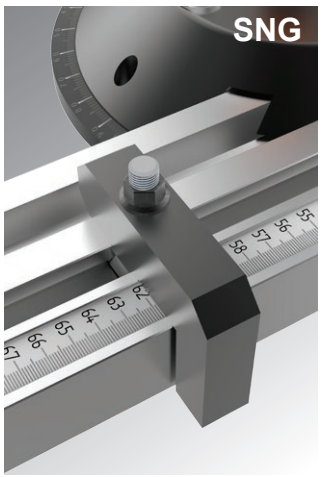


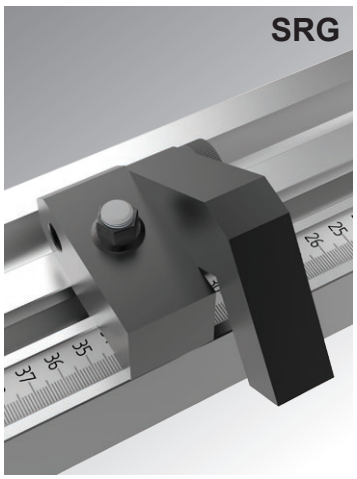
Realizziamo squadre laterali per cesoia di qualunque lunghezza che possono essere utilizzate sul lato sinistro o destro della macchina. La zona di appoggio lamiera è **temprata ad induzione** per evitare l'usura.
Viene fornita completa di piastra applicazione, saltarelli fissi **SNQ**, saltarelli ribaltabili **SRQ** e sostegni regolabili in altezza. La riga millimetrata, incisa con sistema laser, è graduata per la lettura dall'alto al basso, e permette un posizionamento rapido, preciso e ripetitivo delle lamiere da tagliare.

We provide squaring arm for shears of any length which you can use on both sides of the machine.
The sheet metal support area is **induction hardened** to avoid the wear.
It is supplied by an application plate, fixed click **SNQ**, tipping click **SRQ** and height adjustable supports.
The millimeter bar, engraved with a laser system, is graduated to reading from top to bottom.
It allows a rapid, precise and repetitive placement of the sheets to be cut.

GONIOMETRO PER CESOIA - GONIOMETER FOR SHEAR G







L'utilizzo di questo goniometro permette di posizionare la lamiera per tagli angolati. L'applicazione è stata prevista per cesoie con banco di lavoro "pieno".
Su richiesta viene fornito per applicazioni differenti.
E' disponibile in 2 versioni:

MODELLO G1 lunghezza barra a squadrare temprata L.mm.1000, fornito con piastra applicazione, riga millimetrata, 1 saltarello fisso **SNG** e 1 saltarello ribaltabile **SRG**

MODELLO G2 lunghezza barra a squadrare temprata L.mm.500, fornito con piastra applicazione, riga millimetrata, 1 saltarello fisso **SNG**

The use of this goniometer allows the metal sheet angled cut placements. The application has been planned for shears with a "full" workbench.
On request it is supplied for various applications.
The goniometer is available in 2 versions:

G1 MODEL hardened squared bar length mm 1000 supplied with application plate, millimeter bar, 1 fixed click **SNG** and 1 tipper click **SRG**

G2 MODEL hardened squared bar length mm 500 supplied with application plate, millimeter bar, 1 fixed click **SNG**

RIFERIMENTI ANTERIORI PER CESOIA - FRONT REFERENCES FOR SHEAR R

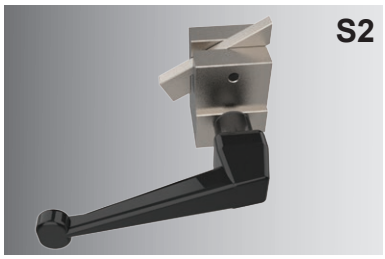
Costruiamo 3 diverse tipologie di profili in acciaio, da utilizzare nella parte anteriore della cesoia, per facilitare la movimentazione e il posizionamento delle lamiere.
I riferimenti vengono forniti con i seguenti accessori:
- saltarelli escludibili o ribaltabili
- saltarelli con regolazione micrometrica della battuta
- blocchetti con sfere per facilitare lo scorrimento della lamiera
- rondelle escludibili per permettere la squadratura lamiera
- riga millimetrata incisa laser, graduata per lettura verticale
- eventuali sostegni regolabili in altezza

L'applicazione varia in funzione delle caratteristiche della cesoia.

We produce 3 different types of steel profiles which are used in the front part of the shears, in order to simplify the handling and the positioning of the sheets.
The references are supplied by the following accessories:
- excludable clicks or tipper clicks
- clicks with micrometric adjustment of the stop
- blocks with spheres to simplify the sliding of the sheet
- excludable washers to allow the squaring of the sheet
- millimetric rule laser engraved, graduated for vertical reading
- height adjustable supports

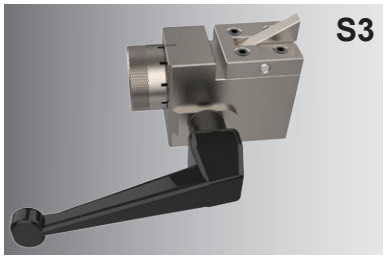
The application methods can change according to the shear features.

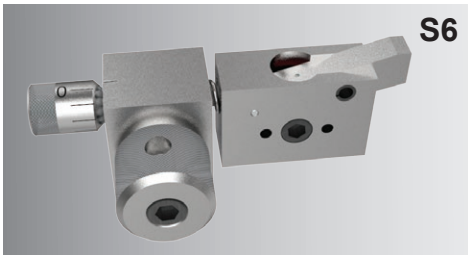




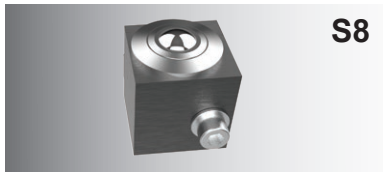








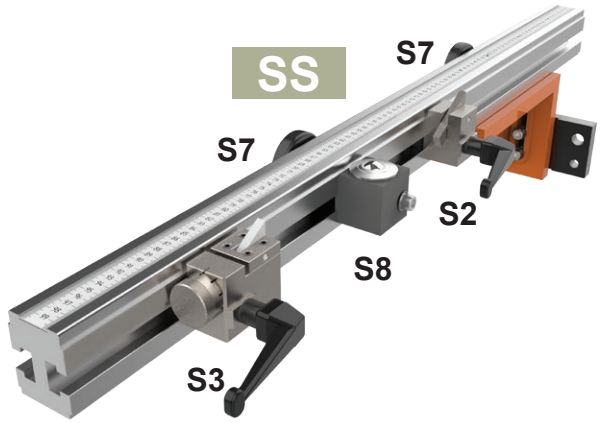




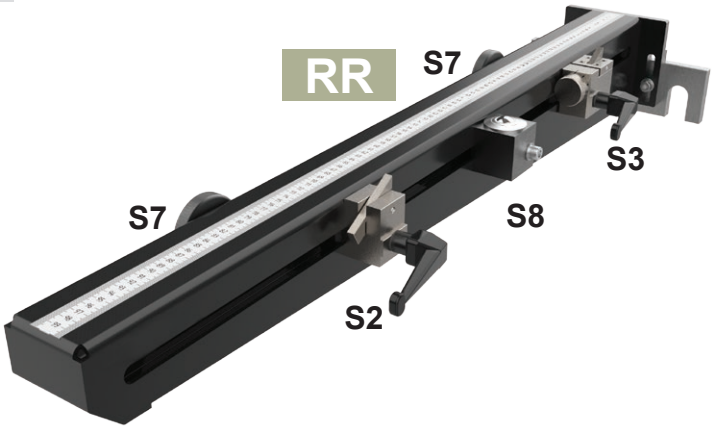
RIFERIMENTI PER PRESSA PIEGATRICE - REFERENCES FOR PRESS BRAKE

Questi riferimenti vengono utilizzati nella parte anteriore della pressa e facilitano la movimentazione e il posizionamento delle lamiere.
I riferimenti vengono forniti con i seguenti accessori:
- saltarelli escludibili o ribaltabili **S2**
- saltarelli con regolazione micrometrica della battuta **S3**
- blocchetti con sfere per facilitare lo scorrimento lamiera **S8**
- rondelle escludibili per permettere la squadratura lamiera **S7**
- riga millimetrata incisa laser, graduata per lettura verticale
- eventuali sostegni regolabili in altezza

This references are used in the front part of the press brake, in order to simplify the handling and the positioning of the sheet metal.
The references are supplied by the following accessories:
- excludable clicks or tipper clicks **S2**
- click with micrometric adjustment of the stop **S3**
- blocks with spheres to simplify the sliding of the sheet **S8**
- excludable washers to allow the squaring of the sheet **S7**
- millimetric rule laser engraved, graduated for vertical reading
- height adjustable supports

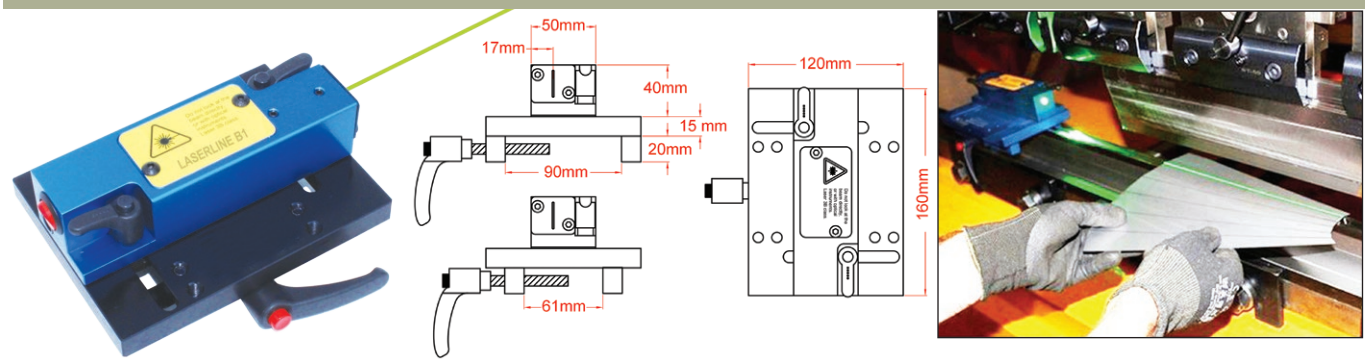


Riferimento in acciaio regolabile in altezza.
E' applicabile a qualsiasi tipo di pressa piegatrice
Steel reference. The height is adjustable and it can be used on any type of press brake



Riferimento in lamiera. Si consiglia l'applicazione su presse piegatrici tipo AMADA/SCHIAVI (L.mm 500-1000-1500)
Sheet reference. The use is recommended on AMADA / SCHIAVI press brakes type (L.mm 500-1000-1500)

LASER BENDING LINE



Il dispositivo LASER BENDING LINE 30mW disegna una linea Laser visibile di oltre 6 metri (con poca luce esterna),aiutando l'operatore nell'operazione di piegatura per poter posizionare ed allineare le lamiere. Viene utilizzato su matrici con larghezza massima di mm 90.
Si fissa e si allinea rapidamente alla matrice mediante delle maniglie. Comprende il modulo Laser conforme alla norma CEI EN60825-1/A2

CARATTERISTICHE:
- Corpo in alluminio con dimensioni 18 x 75 mm
- Tensione operativa 5 Volts CC
- Corrente operativa 220-260 Volts (alimentatore)
- Potenza in uscita 30mW
- Lunghezza d'onda 532 nm
- Durata della vita > 8000 ore con un uso corretto
- Temperatura di lavoro da -10 a 40°

The LASER BENDING LINE 30mW draws a visible laser line of over 6 meters (with little outside light), assisting the operator in the bending to be able to position and align the sheet metal.
It is used on dies with a maximum width of mm 90.
Attaches and aligns quickly to the die by handles.
Includes the Laser module compliant with the regulations CEI EN60825-1/A2

FEATURES:
- Aluminium body with dimensions 18 x 75 mm
- Operating voltage 5 Volts CC
- Operating current 220-260 Volts (power supply)
- Output power 30mw
- Wavelength 532 nm
- Lifespan > 8000 hours with proper use
- Working temperature from -10° to 40°

SQUADRA PER PRESSA PIEGATRICE - PRESS BRAKE SQUARING



SPQ 30°÷90°

Questa attrezzatura è da posizionare direttamente sull'utensile inferiore e può essere utilizzata per la piegatura in squadra (90°) di particolari di lamiera di piccole dimensioni, oppure, montando l'apposito goniometro, si ha la possibilità di regolare l'appoggio da 90° a 30°, quando il pezzo da piegare non è perpendicolare all'asse di piegatura.

This equipment needs to be placed directly on the lower tool and it allows the square bending (90°) of small sheet metal part, otherwise, setting up the dedicated goniometer be able to adjust the support from 90° to 30° when the piece to bending is not perpendicular to the bending axis.



SPQ/G 30°÷90°

Questa attrezzatura è da posizionare sull'utensile inferiore e permette la piegatura di particolari di lamiera di piccole dimensioni, con la possibilità di regolare l'appoggio da 90° a 30°, quando il pezzo ha un appoggio non perpendicolare all'asse di piegatura.

This equipment needs to be placed directly on the lower tool and it allows the bending of small sheet metal parts, with the possibility to adjust the support from 90° to 30°, when the piece to produce has a support not perpendicular to the bending axis.

UNITA' DI PIEGATURA - BENDING UNIT

UP



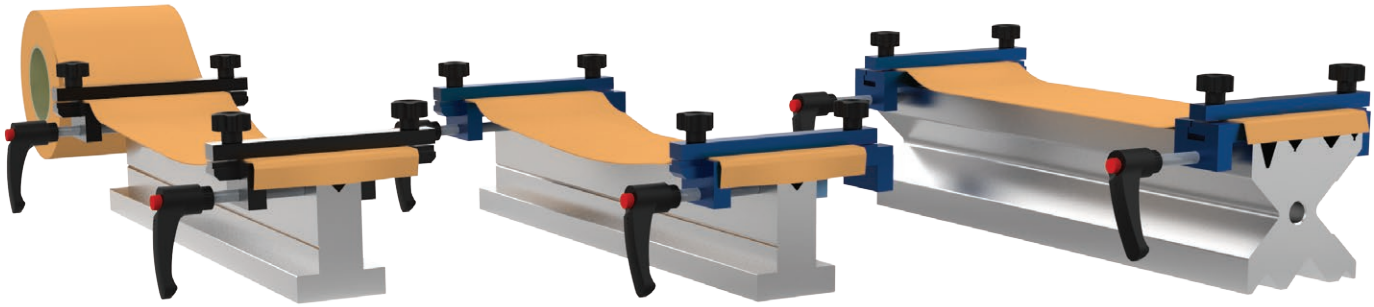
Questa attrezzatura può essere utilizzata su presse idrauliche o meccaniche, per eseguire la piegatura di particolari di piccole dimensioni.
In questo modo è possibile evitare di impiegare presse piegatrici di lunghezze superiori.
E' disponibile in 2 differenti lunghezze utili di piegatura : mm 415 - mm.835.
Per la scelta degli utensili occorre prendere visione della serie standard tipo EUROPA.

This equipment can be used on hydraulic or mechanical presses and it allows to perform the bending of small details. In this way it's not possible to use the longer length bending presses.
The bending unit is available in 2 different lengths : mm. 835 - mm. 415. For the selection of the tools you need to take a look at the
EUROPE standard series.

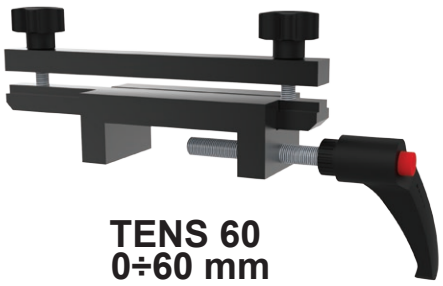
PELLICOLA ANTIGRAFFIO - DIE COVER FILM — URET

Non troverete in nessun altro luogo una pellicola più tenace e duratura !!!

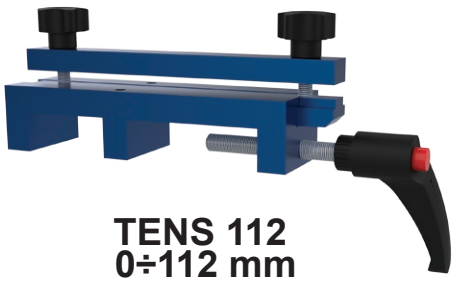
Nowhere else you can find a more strong and lasting film !!!



L'utilizzo di questo prodotto permette di eseguire la piegatura di acciaio inox, alluminio o altro, evitando graffi e segni di piegatura sul pezzo piegato, coprendo semplicemente gli utensili con la pellicola antigraffio. Durante l'utilizzo la pellicola agisce come protezione tra lo stampo ed il materiale da piegare proteggendo quest'ultimo da graffi o segni di piegatura.
La pellicola URET viene fornita in rotoli standard con una lunghezza di mt 30 e sezione mm 100 x 0,5.
Per ottimizzare la durata della pellicola, seguire la seguente procedura:
- regolate la pressa piegatrice fino ad ottenere l'angolo di piega desiderato
- alzate la pressa approssimativamente di mm 0,4 MOLTO IMPORTANTE !
- coprite la matrice con la pellicola
(utilizzando la coppia di tenditori TENS)
- iniziate la piegatura
La durata della pellicola dipende da molteplici fattori quali il tipo di lamiera utilizzata, lo spessore, l'angolo di piega, la larghezza e i raggi della cava. Controllate la pellicola per eventuali segni di deterioramento e sostituitela quando è usurata.
Con l'utilizzo dei tenditori è possibile far scorrere la pellicola in modo da riposizionarla nei punti in cui non risulta usurata. Questo permette di poterla sfruttare totalmente nella sua larghezza.

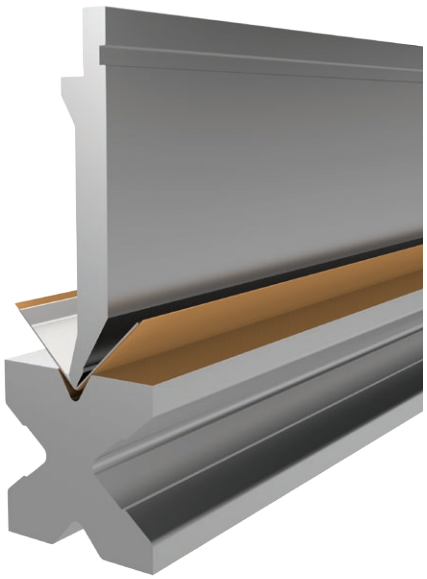


TENS 60
0÷60 mm



TENS 112
0÷112 mm

This product allows you to bend stainless steel, aluminum and more materials avoiding scratches and bending marks just covering the tools with this anti-scratch film.
The film acts as a protection between the die radius and the material to bend, preserving it from scratches or bending marks.
The URET film is supplied by standard rolls of 30 meters length and cross section of 100 x 0.5 mm.
To optimize the endurance please follow the following procedures:
- adjust the bending press to obtain the desired bending angle
- raise the press approximately by mm 0.4 VERY IMPORTANT !
- cover the die with the film
(using the pair of tensioners TENS)
- start bending
The cover film lifetime depends on many factors such as the type of sheet metal used, thickness, angle of the bend, dimension of the V slot and radius of the die. Check the film for any signs of deterioration and replace it when it is worn.
Using the tensioners, it is possible to slide the film to reposition it in the points where it is not worn. This allows it to be fully exploited in its width.



ARMADIO UTENSILI APERTO - OPEN TOOLS CABINET ARM-OPEN2/835

Idoneo per lo stoccaggio di utensili tipo **EUROPA** con lunghezza mm 835 - 415 - 805 frazionati.

L'utilizzo di questo armadio facilita l'operatore nella movimentazione degli utensili e permette una rapida visualizzazione delle tipologie disponibili.

Caratteristiche:

- 6 ripiani con traversini per alloggiare sia utensili superiori che inferiori.
  i ripiani sono regolabili in altezza
  portata singolo ripiano 190 kg (n°11 binari)

- 2 cassetti per riporre gli utensili frazionati
  portata singolo cassetto 75 kg
  altezza max utensile 130 mm

- Capienza ripiani + cassetti : max 74 utensili

- Dimensioni : cm 86 x 86 altezza cm 161,5

- Verniciato monocolore Ral 7016 grigio antracite bucciato

It is suitable for the storage of **EUROPA** tools with a length of mm 835 - 415 - 805 sect.

The use of this cabinet helps the operator in the handling of the tools and it allows a quick display of the available tools.

Features:

- 6 shelves with crossbars to store both upper and lower tools.
  the shelves are adjustable in height
  single load capacity of 190 kg (n°11 tracks)

- 2 drawers to store tools in section
  single drawer capacity 75 kg
  max tool height 130 mm

- Capacity shelves + drawers: max 74 tools

- Size: 86 x 86 cm height 161,5 cm

- One-color painted anthracite gray peel Ral 7016





CARRELLO PORTA UTENSILI - TOOLS TROLLEY

ARM-WHEELS

L'utilizzo di questo carrello ha i seguenti vantaggi:
- facilità nel riporre gli utensili
- rapida visualizzazione delle tipologia di utensili a disposizione dell'operatore
- praticità negli spostamenti essendo dotato di ruote

E' disponibile in 3 versioni :

ARM / WHEELS US
idoneo per stoccaggio utensili tipo **EUROPA**
con lunghezza mm 835 - 415 - frazionati
Capacità : 34 ripiani

ARM / WHEELS UST
idoneo per stoccaggio utensili tipo **TRUMPF WILA ®**
con lunghezza mm 500 - 515 - frazionati
Capacità : 34 ripiani

Dimensioni : cm 120 x 95 altezza cm 130
Portata max : kg.600

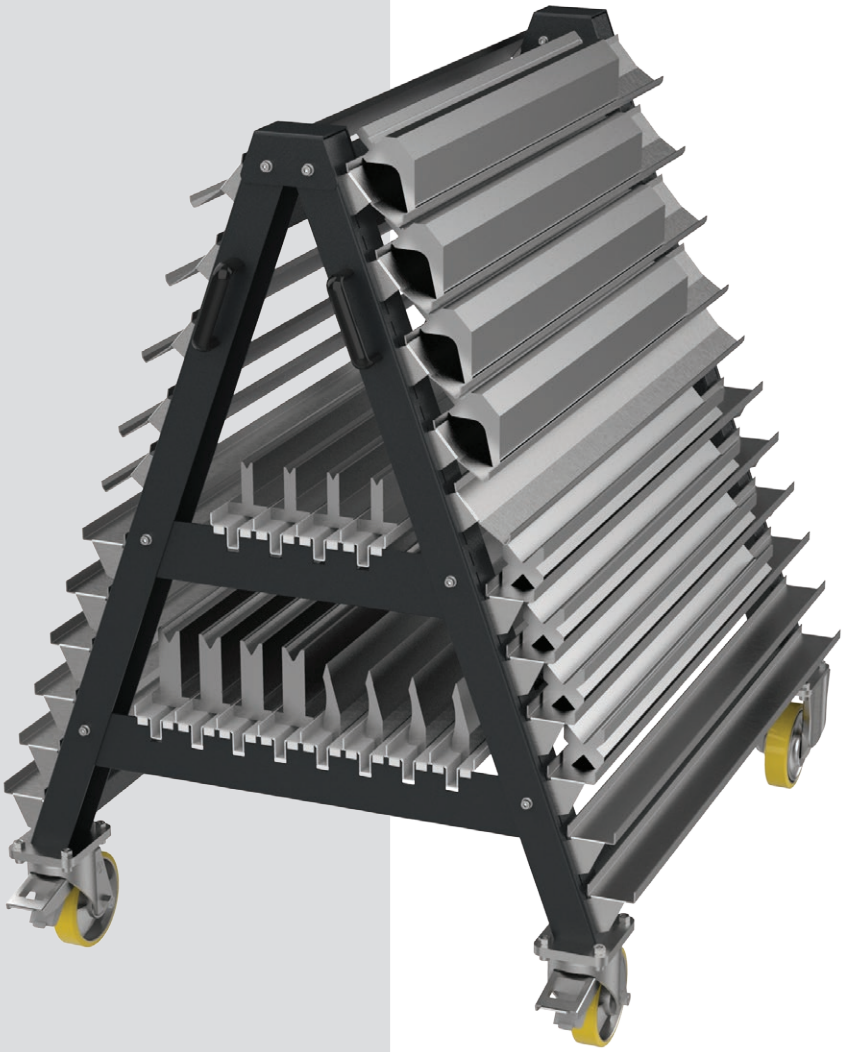
The open tools cabinet has several advantages:
- easy storage of tools
- quick display of the different types of tools available to the operator
- easy to move being equipped with wheels

It is available in 2 versions:

ARM / WHEELS US
It is suitable for the storage of **EUROPA** tools
with length mm 835 - 415 - 805 sect.
Capacity: 34 shelves

ARM / WHEELS UST
It is suitable for the storage of **TRUMPF WILA ®** tools
with length mm 500 - 515 - sect.
Capacity: 34 shelves

Dimensions : 120 x 95 cm height 130 cm
Max capacity : 600 kg



ARMADIO PORTA UTENSILI - TOOLS CABINET

ARM 4-5

L'utilizzo di questo armadio ha i seguenti vantaggi :
- struttura molto robusta con cassetti verticali dotati di ruote
- facilità di posizionamento degli utensili
- possibilità di posizionare i ripiani all'interno dei cassetti secondo le proprie esigenze
- l'armadio è predisposto con delle scanalature nella parte inferiore per facilitare il sollevamento e spostamento

E' disponibile in diverse versioni, con le seguenti caratteristiche standard:

ARMADI idonei per UTENSILI tipo EUROPA
- **ARM4/835/13** con 4 cassetti (16 supporti+4 vaschette) capacità: circa 20 metri di utensili - cm 85Lx105Px124H
- **ARM5/835/13** con 5 cassetti (20 supporti+5 vaschette) capacità: circa 25 metri di utensili - cm 104Lx105Px124H
- **ARM4/1060/13** con 4 cassetti (20 vaschette) capacità: circa 30 metri di utensili - cm 85Lx136Px124H
- **ARM5/1060/13** con 5 cassetti (25 vaschette) capacità: circa 38 metri di utensili - cm 85Lx136Px124H

ARMADI IDONEI PER UTENSILI tipo TRUMPF WILA ® and BEYELER BYSTRONIC ®
- **ARM4/1060/20** con 4 cassetti - cm 104Lx136Px124H
- **ARM5/1060/20** con 5 cassetti - cm 104Lx136Px124H

L'allestimento interno dei supporti e delle vaschette viene proposto in base agli utensili da alloggiare

By using this cabinet you will get the following benefits:
- very strong structure with vertical wheeled drawers
- easy storage of tools
- the possibility to place shelves inside the drawers according to your needs
- the cabinet is equipped with grooves in the lower part to allow you to lift and move it.

It is available in different versions, with the following standard features:

CABINET suitable for EUROPEAN TOOLS
- **ARM4 / 835/13** with 4 drawers (16 supports + 4 trays) capacity: about 20 meters of tools - cm 85Lx105Px124H
- **ARM5 / 835/13** with 5 drawers (20 supports+5 trays) capacity: about 25 meters of tools - cm 104Lx105Px124H
- **ARM4/1060/13** with 4 drawers (20 trays) capacity: about 30 meters of tools - cm 85Lx136Px124H
- **ARM5/1060/13** with 5 drawers (25 trays) capacity: about 38 meters of tools - cm 85Lx136Px124H

CABINET suitable for TOOLS TRUMPF WILA ® and **BEYELER BYSTRONIC ®**
- ARM4 / 1060/20 with 4 drawers - cm104Lx136Px124H
- ARM5 / 1060/20 with 5 drawers - cm 104Lx136Px124H

The internal set-up of the supports and trays is proposed to you according to the tools to be housed.





ACCIAI

Per la costruzione vengono impiegati acciai di primissima qualità, sottoponendoli ad accurati controlli prima e durante le varie fasi di lavorazione.

STEEL

We use the highest quality steels, subjecting them to accurate checks before and during the various stages of processing.

C45	C45	W 1.1191	R 600 / 750 N/mm²
42CR	42CrMo4	W 1.7225	R 850/1000 N/mm²
2311	40CrMnMo7	W 1.2311	R 950/1100 N/mm²
2312	40CrMnMoS8,6	W 1.2312	R 950/1050 N/mm²
PV	X155CrVMo12-1	W 1.2379	

TRATTAMENTI TERMICI

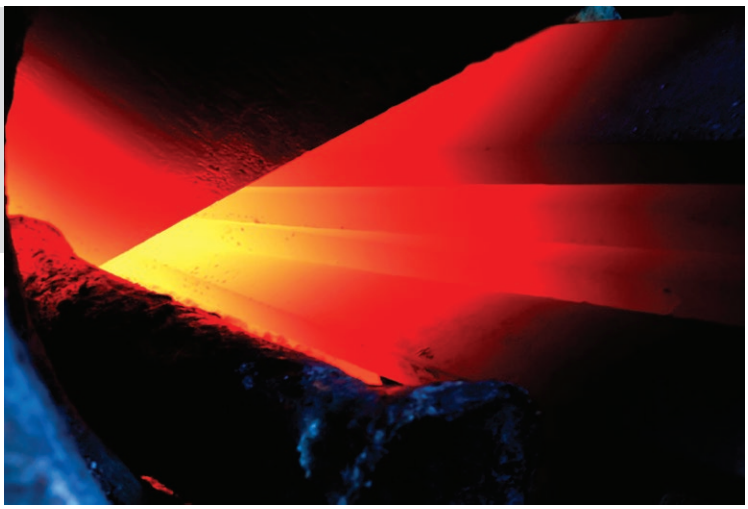
Tutti i trattamenti termici sono eseguiti con impianti tecnologicamente avanzati, gestiti da personale altamente qualificato :

- tempra laser
- tempra ad alta frequenza
- tempra a cuore

HEAT TREATMENTS

All heat treatments are performed with technologically advanced systems and managed by highly qualified employees:

- laser hardening
- high frequency service
- fully hardening



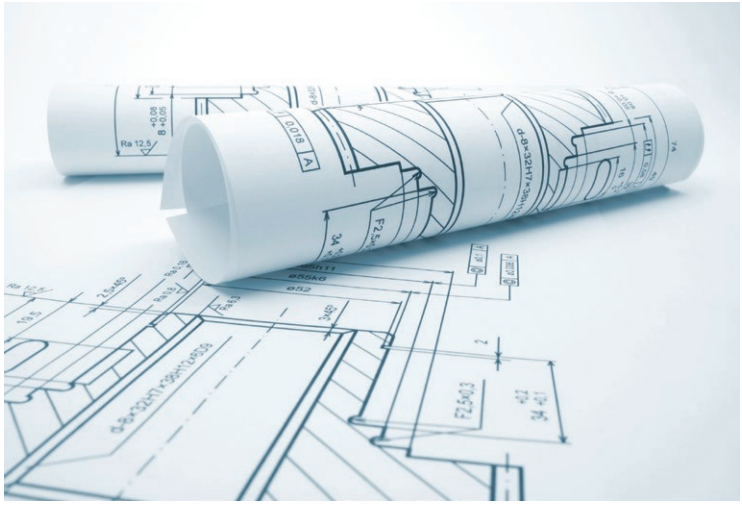


LAVORAZIONI MECCANICHE

Siamo attrezzati con moderni macchinari che ci permettono di eseguire, con la massima precisione, le principali lavorazioni di fresatura CNC, rettifica tangenziale CNC e ogni altra lavorazione complementare.

MECHANICAL WORKING

We are equipped with modern processing systems, which allow us to provide the main CNC milling operations, CNC tangential grinding and any other complementary operations with the highest precision.



PROGETTAZIONE & OFFERTE
I nostri uffici tecnico-commerciali sono in grado di fornire, in tempi brevi, una soluzione tecnica ai vostri problemi di piegatura.
Ogni offerta viene accompagnata da disegni tecnici esemplificativi affinchè possiate comprendere al meglio quanto proposto.

TECHNICAL DESIGN & OFFERS
Our technical and commercial offices are able to provide technical solutions to solve your bending problems very quickly.
In each offer will be included example technical drawings in order to let you better understand what we propose you.

REVISIONE STAMPI
Siamo attrezzati per eseguire la revisione di stampi per presse piegatrici con consegna rapidissima per evitare fermi macchina.

PRESS BRAKE TOOLS RECONDITIONING
We are equipped to perform the reconditioning for press brakes tools with a very fast delivery to avoid machine downtime.

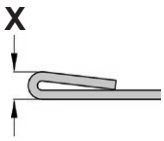
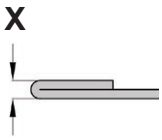




RIAFFILATURA LAME
Eseguiamo in tempi rapidi la riaffilatura delle lame per cesoia. La riaffilatura viene eseguita con rettifiche tangenziali per mantenere inalterate le caratteristiche delle lame. Tutte le lame dopo la riaffilatura vengono smagnetizzate.

SHEAR BLADES REGRINDING
We can quickly regrind your shear blades.
The regrinding is performed by tangential grinding machine to preserve the original blades features.
After this process all the blades are demagnetized.

TAVOLA DI PIEGATURA UTENSILI PIEGASCHIACCIA - HEMMING TOOL BENDING CHART

 SPESSORE THICKNESS	 X	Rm=450 N/mm²	Rm=700 N/mm²	 X	Rm=450 N/mm²	Rm=700 N/mm²
		POTENZA POWER			POTENZA POWER	
mm	X mm	kN/mt	kN/mt	X mm	kN/mt	kN/mt
0,6	3,0	90	150	1,2	230	350
0,8	3,0	120	200	1,6	320	500
1,0	3,5	150	250	2,0	400	600
1,2	3,5	170	300	2,4	500	800
1,5	4,6	220	380	3,0	630	950
2,0	5,5	300	500	4,0	800	1300
2,5	6,5	550	900	5,0	900	1800
3,0	8,0	700	1000	6,0	1000	2100



PIEGATURA IN ARIA - AIR BENDING

Nella piegatura in aria l'angolo di piega è determinato dalla posizione che la punta dell'utensile superiore raggiunge rispetto ai due spigoli della matrice, posizione variabile a seconda dello spessore, della resistenza e dell'elasticità della lamiera. I vantaggi nell'utilizzo di questa tecnica di piegatura consistono nell'impiego di una minima forza di piegatura e nella possibilità di piegare qualsiasi spessore, compatibilmente al tipo di pressa ed utensili disponibili.
Inoltre gli stessi utensili possono essere utilizzati per differenti tipi di materiale e si possono ottenere angoli inferiori ai 90°e raggi interni di piegatura variabili in proporzione alla larghezza della matrice. Gli svantaggi consistono nel dover utilizzare lamiere con spessore e resistenza costanti per ottenere risultati soddisfacenti.

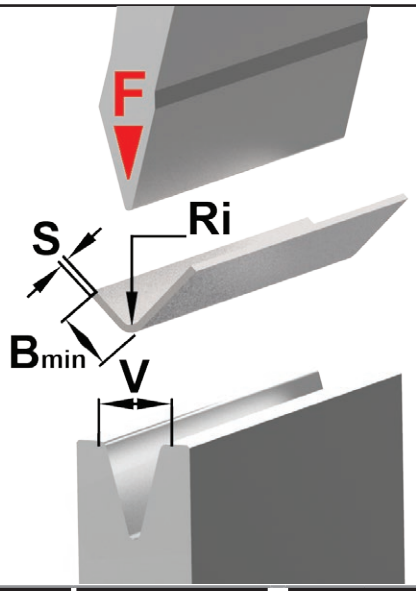
During the air bending the bending angle is determined by the position reached by the upper tool end position in relation to the die edges. The position changes in connection to thickness, resistance and stretch of material. The adavntages in the use of this method are in the use min bending force and in the possibility to bend any thickness being subject to press brake type and tool types. Moreover, the same tools can be used for different material types, for angles lower than 90 degrees and inner radius changeable proportionally to the die slot width. The disadvantages are in the use of metal sheet having exact thickness and resistance in order to get profitable results.



PIEGATURA A FONDO MATRICE - BENDING ON LOWER TOOL BOTTOM

La piegatura a fondo matrice opera, nella fase iniziale, come per la piegatura in aria, mentre nella fase finale preme sul raggio interno della lamiera piegata determinando l'angolo di piegatura. Praticamente l'angolo di piegatura viene raggiunto agendo sulla forza applicata alla punta dell'utensile superiore nella fase di chiusura.Essendo il raggio di curvatura della lamiera variabile infunzione dello spessore e dell'apertura della matrice, diventa necessario variare la forma degli utensili, anche in considerazione dei diversi ritorni elastici tra i vari materiali. Nell'utilizzo di questa tecnica di piegatura le irregolarità dello spessore e le variazioni della resistenza della lamiera hanno una minima influenza. Pertanto con un corretto accoppiamento degli utensili ed una costante forza di piegatura si può ottenere una sicura ripetibilità dell'angolo di piega. Gli aspetti negativi consistono in un leggero aumento della forza di piegatura (+20% rispetto alla piegatura in aria, a parità di condizioni), nella impossibilità di ottenere angoli inferiori ai 90° e nel utilizzo di lamiere con spessore massimo di mm.5

Die bottom bending is carried out at its first stage in the same way as air bending, while during the final stage the upper tool presses the sheet against the die bottom forming final angle. The bending angle is achieved by acting on the force applied on the upper tool end during the final stage. Since the die radius changes in relation to the thickness and opening of the die, it becomes necessary to hange the shape of the tools,also in cosideration of the different elastic stretches between the materials. In the use of this bending methods, the differences of sheet thickness and strength are minimal. Therefore, with a correct combination of tool and costant bending force you can get a good repeatability of bent angle. The disadvantages are in a small increasing of the bending force (+20% more than in the air bending method in presence of the same conditions), in the impossibility to get angles lower than 90 degrees and in the use of sheets with max. thickness 5 mm



PIEGATURA IN ARIA AIR BENDING

F	kN al metro-kN for meter	**B**	bordo minimo-minimun flange
S	spessore-thickness	**Ri**	raggio interno-internal radius
V	apertura cava-V opening	**R**	resistenza-resistance

AVVERTENZE WARNINGS

NON SUPERARE IL CARICO MASSIMO AMMESSO DAGLI UTENSILI , IN QUANTO POSSONO DANNEGGIARSI O CAUSARE DANNI FISICI ALL'OPERATORE.
Il carico massimo ammissibile varia in base al tipo di utensili utilizzati.
Calcolare sempre una pressione inferiore rispetto al carico indicato.

EXCEEDING THE MAXIMUM ALLOWABLE TONNAGE FOR THE TOOLING CAN BE VERY DANGEROUS AND MAY RESULT IN TOOLING DAMAGE OR MAY CAUSE BODILY INJURY BY SPLINTERING.
The maximum allowable pressure may vary, depending on the punch and die used.
Always calculate the maximum pressure with the lowest rating of the punch or die.

S	mm	0,6		0,8		1,0		1,2		1,5		2,0	
V	mm	6	8	6	8	6	8	8	10	10	12	12	16
F kN/mt	R 200 N/mm²	20	10	30	20	60	40	60	40	70	60	110	80
	R 450 N/mm²	40	30	70	50	130	80	130	100	160	130	250	170
	R 700 N/mm²	60	40	110	80	190	130	200	150	250	200	390	260
Ri	Ri mm	1,0	1,3	1,0	1,3	1,0	1,3	1,3	1,7	1,7	2,0	2,0	2,7
B	90° B min mm	4,3	5,7	4,3	5,7	4,3	5,7	5,7	7,1	7,1	8,5	8,5	11,4
	60° B min mm	4,9	6,6	4,7	6,5	4,6	6,3	6,2	8,0	7,7	9,5	9,1	12,6
	30° B min mm	7,3	10,2	6,7	9,7	6,2	9,1	8,6	11,5	10,7	13,7	12,3	18,2

S	mm	2,5		3		4		5		6		8	
V	mm	16	20	20	25	32	40	40	50	50	63	63	80
F kN/mt	R 200 N/mm²	130	90	140	110	150	110	190	140	210	160	310	220
	R 450 N/mm²	290	210	320	240	340	250	420	320	480	360	690	500
	R 700 N/mm²	440	330	500	370	530	390	660	490	750	550	1070	780
Ri	Ri mm	2,7	3,3	3,3	4,2	5,3	6,7	6,7	8,3	8,3	10,5	10,5	13,3
B	90° B min mm	11,4	14,2	14,2	17,7	22,7	28,3	28,3	35,4	35,4	44,6	44,6	56,6
	60° B min mm	12,3	15,8	15,4	19,8	25,2	32,2	31,5	40,3	39,6	51,0	49,5	64,6
	30° B min mm	16,8	22,8	21,4	28,8	36,4	48,2	45,5	60,2	57,5	76,7	71,2	96,3

S	mm	10		12		15		20		25		30	
V	mm	80	100	100	125	160	200	200	250	250	320	320	400
F kN/mt	R 200 N/mm²	380	280	430	320	390	290	560	420	700	510	770	590
	R 450 N/mm²	840	630	960	720	870	660	1260	950	1580	1150	1740	1320
	R 700 N/mm²	1310	980	1490	1120	1350	1020	1960	1480	2450	1790	2710	2050
Ri	Ri mm	13,3	16,7	16,7	20,8	26,7	33,3	33,3	41,7	41,7	53,3	53,3	66,7
B	90° B min mm	56,6	70,8	70,8	88,4	113,2	141,5	141,5	176,8	176,8	226,3	226,3	282,9
	60° B min mm	63,0	80,5	79,1	101,0	129,5	164,7	161,0	204,9	201,2	262,7	259,0	329,3
	30° B min mm	90,9	120,4	114,9	151,8	195,3	254,4	240,7	314,5	300,9	404,2	390,6	508,7

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