



UTENSILI DI PIEGATURA | BENDING TOOLS

Piegatura | Bending

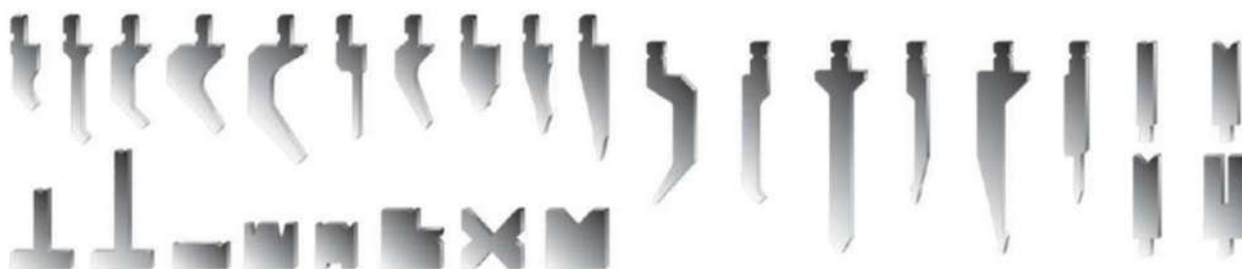
Divisione lamiera
Sheet metal division

www.alloritools.com

PRODUZIONE GENERALE



UTENSILI THICK TURRET – THICK TURRET TOOLS



UTENSILI PIEGATURA AMADA/TRUMPF – AMADA/TRUMPF BENDING TOOLS



UTENSILI TRUMPF STYLE – TRUMPF STYLE TOOLS



UTENSILI SPECIALI – SPECIAL TOOLS



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INTRODUZIONE

- Prima di scegliere quali utensili utilizzare, controllarne le specifiche parallelamente alla verifica del manuale di istruzione della pressa piegatrice onde evitare pericoli al personale, rotture o danneggiamento degli utensili.
- Accertarsi che la portata Ton/m dei punzoni e delle matrici che si intende utilizzare siano compatibili e comunque sempre superiori al tonnellaggio che sarà applicato durante la lavorazione da eseguirsi.
- Su tutti gli utensili è sempre indicata la portata massima sopportata dall'utensile stesso.
- Ricordarsi che le portate indicate sull'utensile sono calcolate per 1 mt. lineare; quindi, lunghezze inferiori devono essere proporzionate di conseguenza alla lunghezza base 1000.

MATERIALI E DUREZZE

TIPO DI MATERIALE	SIGLA CATALOGO	DUREZZA DELLA ZONA SUPERFICIALE (HRC)	RESISTENZA INTERNA N/mm ²
Acciaio C50	C45	temprato 55/60	650/680
	C45-B	bonificato e temprato 55/60	800/900
Acciaio 42CrMo4	42Cr-B	bonificato e temprato 55/60	1000/1100

UTENSILI SPECIALI :

Il nostro Ufficio Tecnico è a completa disposizione dei clienti per lo studio di attrezzature speciali anche per utensili con lunghezza fino a mt. 8.

E' comunque possibile apportare modifiche a raggi, altezze, scarpette e tagli di frazionatura.

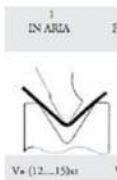
MARCATURA UTENSILI

Sugli utensili standard le marcature vengono effettuate nel modo seguente:



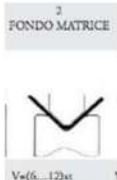
TIPO DI PIEGA ESEGUIBILE

- 1



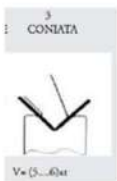
E' la piega che si ottiene quando il lato esterno della lamiera non giunge a contatto con il fondo della matrice. Per questo tipo di piega si utilizzano matrici con una ampiezza della V pari a circa 12 - 15 volte lo spessore della lamiera che occorre piegare. Attenersi ai dati delle tabelle per stabilire la forza da applicare.

- 2



Il lato esterno della lamiera viene spinto a contatto con il fondo della matrice. Il raggio interno ottenibile è uguale o superiore allo spessore della lamiera. Le tabelle di piegatura indicano la forza necessaria per eseguire questo tipo di piega.

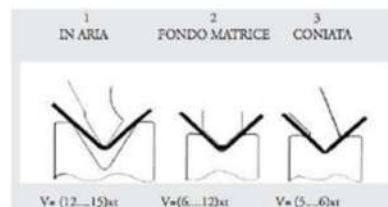
- 3



In questo caso l'ampiezza della V consigliata è 6-12 volte lo spessore della lamiera. Se la V della matrice è pari a 6 volte lo spessore della lamiera il raggio interno che si ottiene è uguale allo spessore. Onde compensare il ritorno elastico della lamiera si consiglia, per ottenere pieghe con angoli di 90°, di utilizzare matrici ad 88° - 86°. In questo caso si esercita una pressione tale da far sì che il raggio interno della piega sia inferiore allo spessore della lamiera ottenendo così la coniatura. In tal modo viene eliminato l'effetto del ritorno elastico della lamiera. L'ampiezza della V della matrice deve essere pari a 5-6 volte lo spessore della lamiera mentre ambedue punzone e matrice dovranno essere a 90°. Si tenga presente che in questo caso la forza da applicare sarà pari a 5-8 volte i valori riportati nella tabella forze di piegatura

CONSEGNA

*Tutti gli articoli esposti in catalogo
sono disponibili a magazzino*



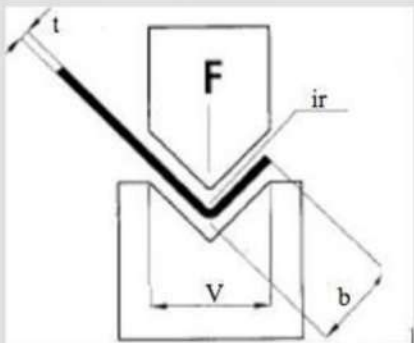
OCCORRE TENERE PRESENTE:

- La piega coniata richiede una forza maggiore ma la precisione dell'angolo ottenibile è molto elevata +/-15'.
- La piega in aria richiede una forza più bassa ma il materiale non viene snervato e mantiene il suo ritorno elastico pertanto si ha una minore precisione dell'angolo ottenuto +/-30'.
- L'ampiezza della V è sempre fondamentale.
- L'angolo del punzone nelle pieghe in aria ed a fondo matrice non ha importanza fondamentale.
- Il raggio del punzone influisce sul raggio interno proporzionalmente all'ampiezza del raggio stesso.
- Il tempo di permanenza in piega influisce sulla precisione del raggio ottenibile.
- La piega coniata causa una maggiore usura utensile, ma è più semplice da ottenere.



RAPPORTO TRA LO SPESSORE MATERIALE E L'AMPIEZZA DELLA "V" DELLA MATRICE

Spessore materiale	0,5-2,5	3,0-8,0	9,0-10,0	12,0 o più
Ampiezza della V	6 x t	8 x t	10 x t	12 x t



$$F = \frac{t^2 \times 2 \times R}{1,4 \times V} = \dots\dots\dots t/mt$$

Alluminio/Aluminium R= 20-25 Kg/mm²
Ferro/Mild Steel R= 40-45 Kg/mm²
Inox/Stainless Steel R= 65-70 Kg/mm²

TABELLA DEL TONNELLAGGIO PER PIEGHE A FONDO MATRICE –
FERRO PER PIEGHE L=1 MT R = 45 kg/mm²

t mm	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	V
2,8	4	5	5,5	7	8,5	10	11	13,5	14	17,5	22	28	35	45	55	71	89	89	b
0,7	1	1,1	1,3	1,6	2	2,3	2,6	3	3,3	4	5	6,5	8	10	13	16	20	20	ir
0,5	4	3																	
0,6	6	4	4	4															
0,8		7	7	5	4														
1		11	10	8	7	6													
1,2			14	12	10	8	7	6											
1,4				15	13	11	10	9	8										
1,6					17	15	13	11	10	9									
2						22	19	17	15	13	11								
2,3							25	23	19	17	15	12							
2,6								28	25	22	18	14							
3									34	30	24	19	15						F
3,2										34	27	22	17	14					
3,5											33	26	20	16	13				
4												43	34	27	21	17			
4,5													44	34	27	21			
5														52	42	33	26	21	
6															60	48	38	30	24
7																	52	41	33
9																		67	54
10																		85	67
12																		96	78

t thickness of material
(forza/force: 45-50 Kg/mm²)
F tonnage for 1 m.
ir internal radius
b minimum edge
V V amplitude

t spessore materiale
(forza/force: 45-50 Kg/mm²)
F tonnellaggio per 1 metro
ir raggio interno
b bordo minimo
V ampiezza della V

VALORI CORRETTIVI

Per Alluminio valore dimezzato – Per Acciaio Inox valore raddoppiato



INTRODUCTION

- Before choosing which tool to use, check the specifications and the instruction manual of the press brake to avoid dangerous situations for operators, the risk of breaking or damaging the tools.
- First step should be check that the maximum load of punch and die in T/m are compatibles and higher than the tonnage needed for working.
- The maximum capacity of the tool is always indicated on it. Note that the capacity of the tool is calculated per 1 linear m and therefore shorter lenghts must be calculated as consequence.

TYPE OF OBTAINED BEND

TYPE OF MATERIAL	CATALOGUE CODE	SURFACE HARDNESS (HRC)	INTERNAL RESISTANCE N/mm ²
C45 Steel	C45	hardened and tempered 55/60	650/680
	C45-B	hardened and tempered 55/60	800/900
42CrMo4 Steel	42Cr-B	hardened and tempered 55/60	1000/1100

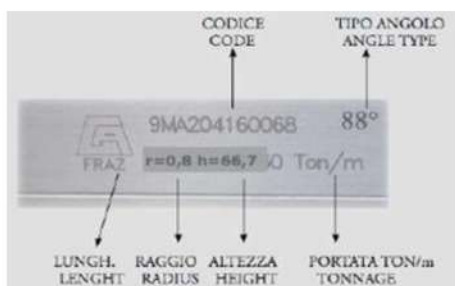
SPECIAL TOOLS

Our technical department is at customer's disposal to study special equipment also for tools with a lenght up to 8 mt. Its' also possible modifications on radius, height, horns and fractionation.

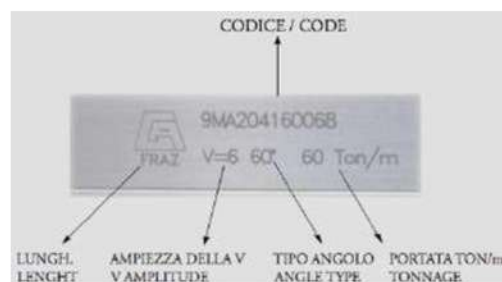
TOOL MARKING

On standard tools the marking are as following:

PUNZONI - PUNCH

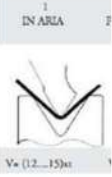


MATRICI - DIE

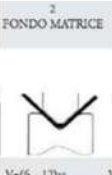


TYPE OF OBTAINED BEND

- 1 **IN ARIA**



This is the bending technique used when the outer edge of the sheet metal doesn't come into contact with the bottom of the die. Dies with an amplitude of the V roughly 12-15 times the thickness of the sheet metal to bend are used for this type of process. See the data in the tables to determinate the force to apply.
- 2 **FONDO MATRICE**



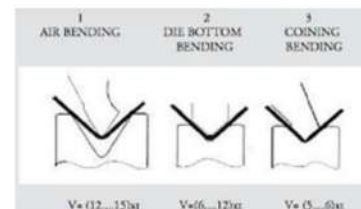
The outer edge of the sheet metal is pushed into contact with the bottom of the die. The internal radius that can be obtained is the same as or greater than the thickness of the sheet metal. The bending tables indicate the force required for this type of bend. In this case the recommended amplitude of the V is 6-12 times the thickness of the sheet metal. If the V of the die is 6 times the thickness of the sheet metal, the internal radius will be the same as the thickness. To compensate the spring back of the sheet metal when bending 90° angles, we recommended use an 88° - 86° dies.
- 3 **CONIATA**



In this case exert a pressure that creates an internal radius smaller than the thickness of the sheet metal, to obtain the coining. This eliminates the spring back of the sheet metal. The amplitude of the die V must be 5-6 times the thickness of the sheet metal, while both punch and die must be 90°. Note that in this case the force to apply will be equal to 5-8 times the values in bending force table.

DELIVERY

*All of the articles present in catalog
are available on stock.*



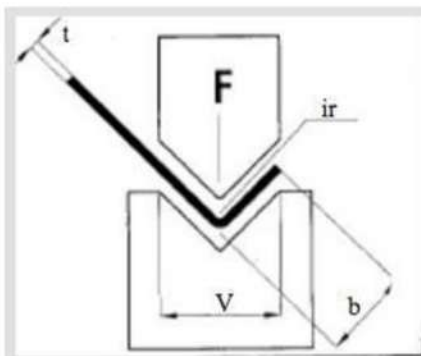
HOWEVER NOTE THAT:

- The coining bend requires a greater force, but you can obtain very high precision angles $\pm 15'$.
- Air bending requires less force, but the material isn't weakened and springs back so the angles obtained are less precise $\pm 30'$.
- The amplitude of the V is always essential.
- The angle of the punch in air bending and die bottom bending isn't that important.
- The radius of the punch affects the internal radius in proportion to the amplitude of the radius itself.
- The bending time affects the precision of the radius that can be obtained.
- The tool is more wear using the coined bend, but the process is easier to execute.



RELATIONSHIP BETWEEN THICKNESS OF MATERIAL AND AMPLITUDE OF DIE V

Thickness of material	0,5-2,5	3,0-8,0	9,0-10,0	12,0 o più
V amplitude	6 x t	8 x t	10 x t	12 x t



$$F = \frac{t^2 \times 2 \times R}{1,4 \times V} = \dots\dots\dots t/mt$$

Alluminio/Aluminium

R= 20-25 Kg/mm²

Ferro/Mild Steel

R= 40-45 Kg/mm²

Inox/Stainless Steel

R= 65-70 Kg/mm²

DIE BOTTOM BENDING TONNAGE CHART MILD STEEL L=1 MT R= 45 kg/mm²

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	V					
mm	2,8	4	5	5,5	7	8,5	10	11	13,5	14	17,5	22	28	35	45	55	71	89	b					
	0,7	1	1,1	1,3	1,6	2	2,3	2,6	3	3,3	4	5	6,5	8	10	13	16	20	ir					
0,5	4	3																						
0,6	6	4	4	4																				
0,8		7	7	5	4																			
1		11	10	8	7	6																		
1,2			14	12	10	8	7	6																
1,4				15	13	11	10	9	8															
1,6					17	15	13	11	10	9														
2						22	19	17	15	13	11													
2,3							25	23	19	17	15	12												
2,6								28	25	22	18	14												
3									34	30	24	19	15						F					
3,2										34	27	22	17	14										
3,5											33	26	20	16	13									
4											43	34	27	21	17									
4,5												44	34	27	21									
5												52	42	33	26	21								
6		t	thickness of material										t	spessore materiale										
			(forza/force: 45-50 Kg/mm ²)												60	48	38	30	24					
7		F	tonnage for 1 m.										F	tonnellaggio per 1 metro										
ir			internal radius										ir	raggio interno										
9		b	minimum edge										b	bordo minimo										
V		V	amplitude										V	ampiezza della V										
10																85	67	53						
12																	96	78						

CORRECTIVE VALUES For Alluminium halved value – For
Stainless Steel dabled value

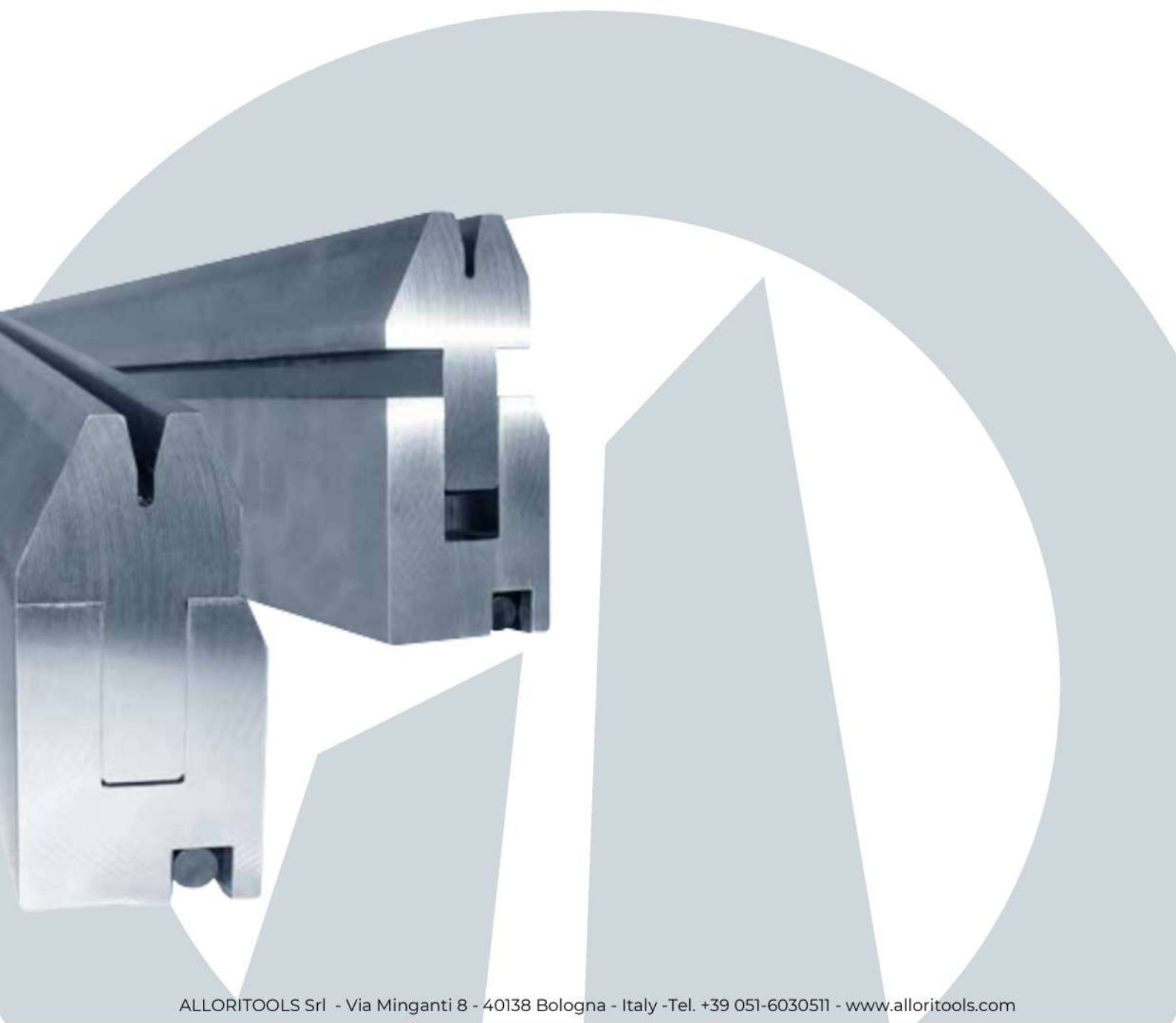


UTENSILI DI PIEGATURA | BENDING TOOLS

Utensili tipo - Tools style

Amada®

Promecam®



USO DEL CATALOGO

Per una corretta consultazione tenere presente le seguenti indicazioni:

1. AMPIEZZA DELL'ANGOLO IN GRADI
2. PORTATA (Tonnellate x 1 metro)
3. RAGGIO DELLA PUNTA
4. ALTEZZA UTENSILE (INDICAZIONE X IL CONTROLLO NUMERICO) VARIA IN FUNZIONE DEL RAGGIO
5. CODICE PER L'ORDINAZIONE
6. LUNGHEZZA DELL'UTENSILE FRAZIONA
7. SPESSORE DELLA PUNTA DEL PUNZONE
8. PESO DELL'UTENSILE
9. AMPIEZZA DEL RAGGIO SPALLA V MATRICE
10. AMPIEZZA DELLA V DELLA MATRICE

PUNZONI - PUNCH

1	2	3	4	5	6
90°	100 T/m	Raggio Radius	Altezza Height	835 mm. 415 mm. FRAZ. SECT. 805 mm.	
		COD.	COD.	COD.	
		0,2	67,00	9PA010109021 9PA010109022	9PA010109028
		0,8	66,70	9PA010109041 9PA010109082	9PA010109088
		-	-	-	-
		PESO Kg.	12	6	12
		€			

MATRICI - DIES

5	1	10	2
COD.	€	90° V12 95T/m	
9MA007590121 835 mm.-Kg. 6,0			
9MA007590122 415 mm.-Kg. 3,0			
9MA007590128 Sec. 805-Kg. 6,0			

CATALOG USE

For a correct use please consider the following indication:

1. AMPLITUDE OF THE ANGLE
2. TONNAGE (Tons for metres)
3. RADIUS OF THE EDGE
4. TOOL HEIGHT
5. ORDER CODE
6. LENGHT OF THE SECT. TOOL
7. THICKNESS OF THE PUNCH
8. TOOL WEIGHT
9. AMPLITUDE DIE V RADIUS
10. AMPLITUDE OF THE DIE V



LUNGHEZZE STANDARD

- Gli utensili AMADA-PROMECAm sono utilizzabili sulle presse dei costruttori che utilizzano attacco punzone tipo Amada-Promecam

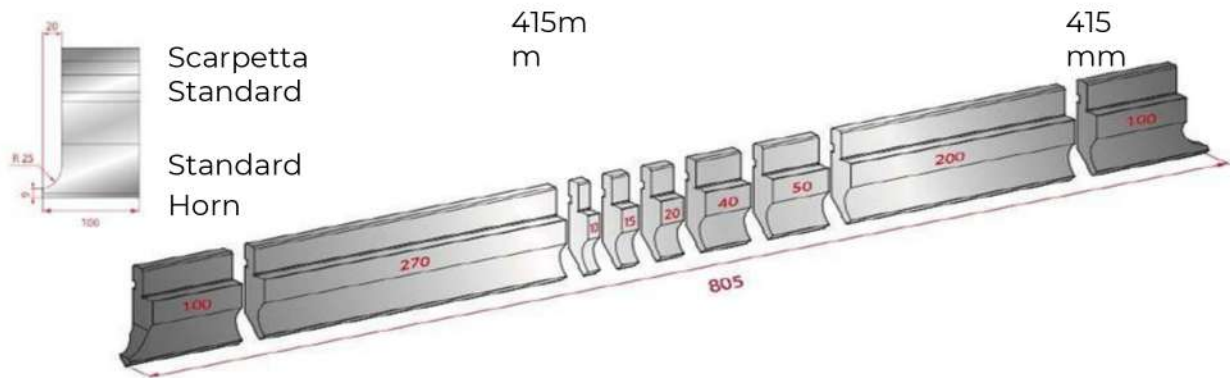
LE LUNGHEZZE STANDARD
DEGLI UTENSILI SONO: 835 MM

STANDARD LENGTHS

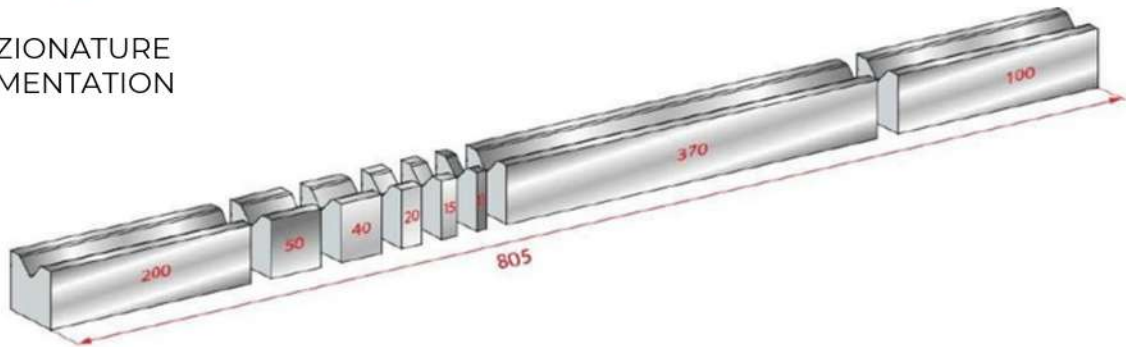
- The AMADA-PROMECAm tools are suitable for press brake that use Amada-Promecam punch tang

THE STANDARD LENGTH OF
THE TOOLS ARE: 835 MM

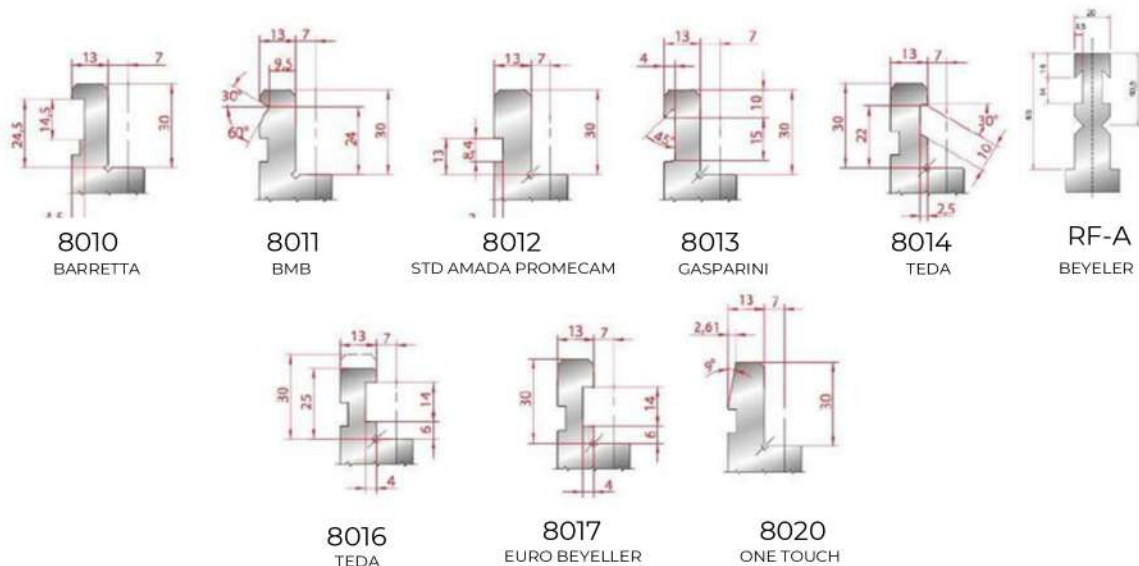
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FRAZIONATURE
SEGMENTATION



ATTACCHI SU RICHIESTA – TANGS ON REQUEST

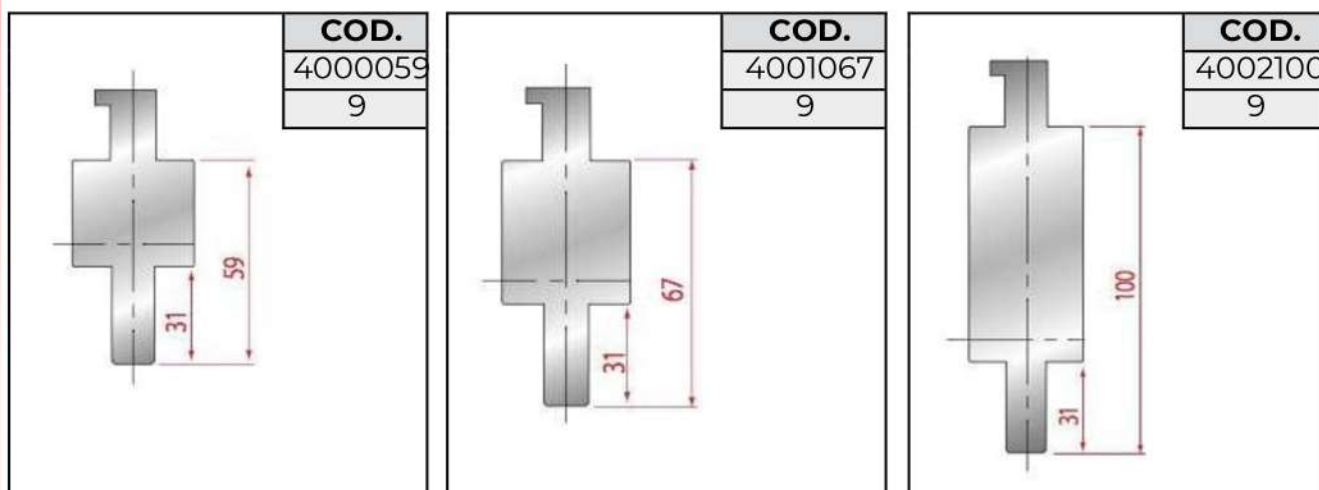


- DISPONIBILI ATTACCHI MATRICE DEI SEGUENTI COSTRUTTORI /
 - AVAILABLE DIE TYPE PRESS BRAKEADAPTORS:
- BYSTRONIC – TRUMPF – LVD – WEINBRENNER - AMERICAN**



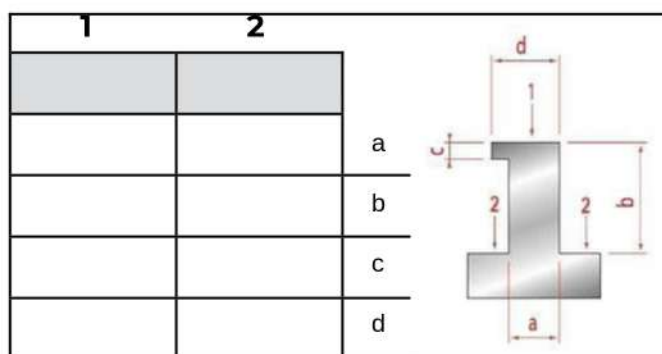
ADATTATORI AMADA L=150

L=150 AMADA ADAPTORS

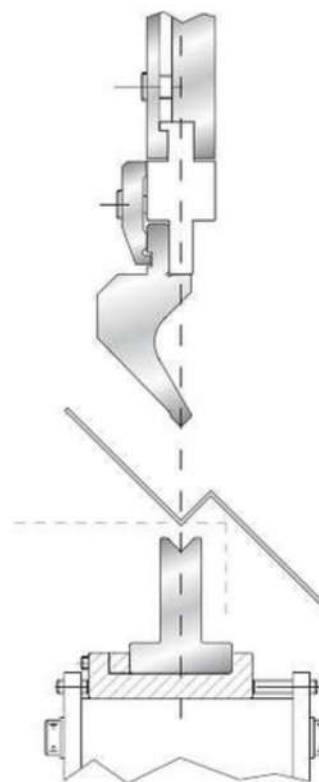
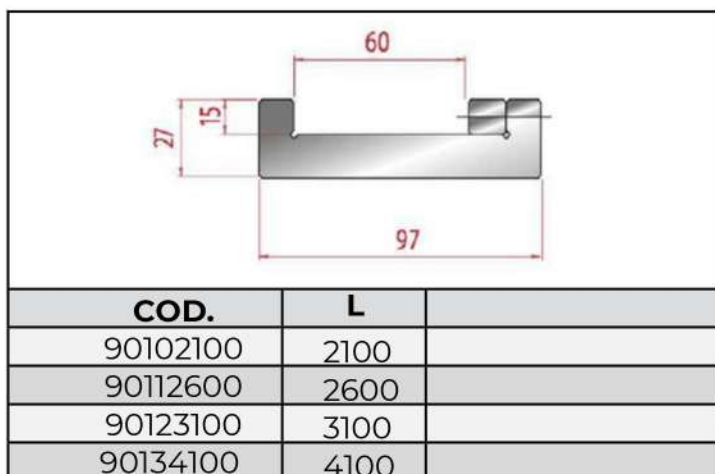


N.B.: ORDINE MINIMO 5 PZ.

NOTE: MINIMUM ORDER 5 PCS



CANALINE
DIE SUPPORT

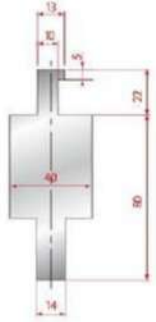
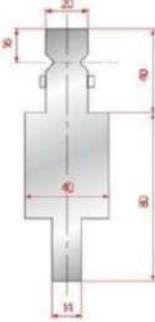
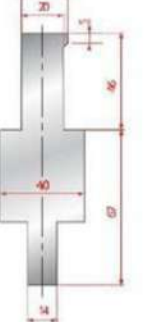
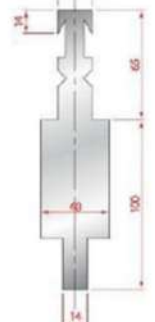
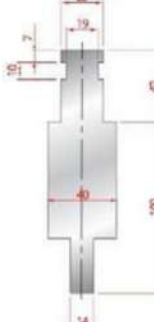
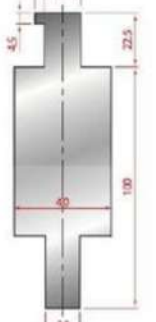
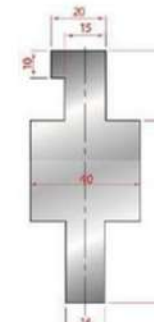


ADATTATORI PER UTENSILI AMADA-PROMECAM PER TUTTI I TIPI DI PRESSE
AMADA-PROMECAM TOOLS ADAPTORS FOR ALL PRESS BRAKE



ADATTATORI L=150

L=150 ADAPTORS

 COD. 41430809 LVD AMADA	 COD. 41910809 TRUMPF AMADA	 COD. 41920679 BISTRONIC R AMADA
 COD. 41930679 BISTRONIC-S AMADA	 COD. 42141009 BISTRONIC RFA AMADA	 COD. 42151009 WEINBRENNER AMADA
 COD. 42161009 CBC AMADA	 COD. 42171009 EHT AMADA	 COD. 42180679 DURMAZLAR AMADA



ADATTATORI L=150 / L=150 ADAPTORS

	COD. 42291009		COD. 42720899		COD. 42731009
DARLEY AMADA		BAYKAL AMADA		COLGAR AMADA	

INTERMEDIARI REGISTRABILI L=150 / ADJUSTABLE INTERMEDIATE L=150

B=27	H=100	H=120	H=150
	42211009	42221209	42231509

B=40	H=100	H=120	H=150
	42241009	42251209	--

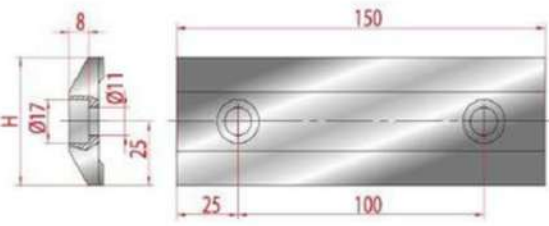
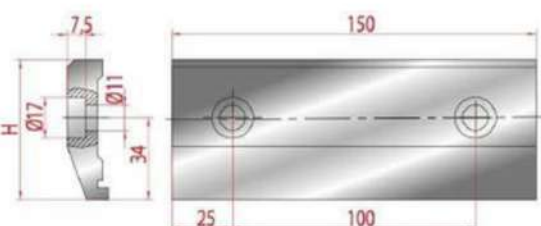
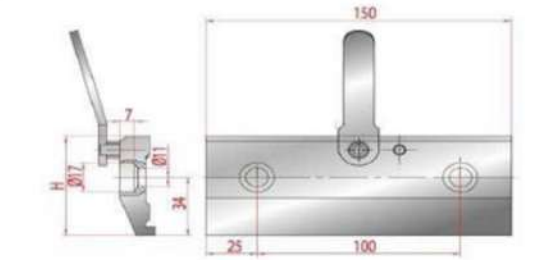
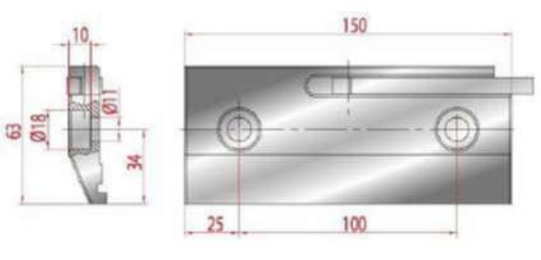
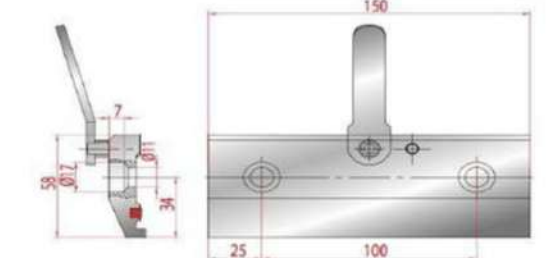
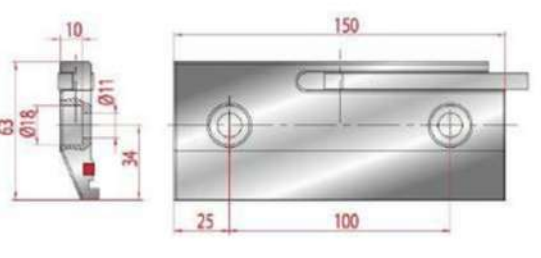
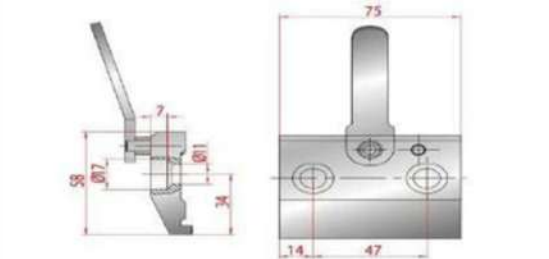
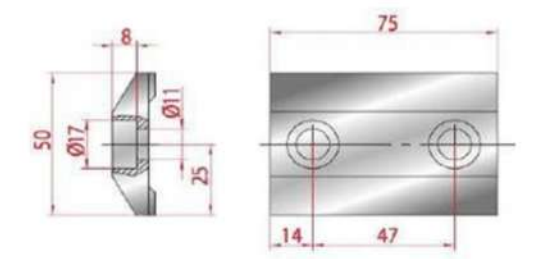
INTERMEDIARI FISSI L=75 / L=75 RETROFIT

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	42261007	--	42271507

B=40	H=100	H=120	H=150
	--	42281207	--

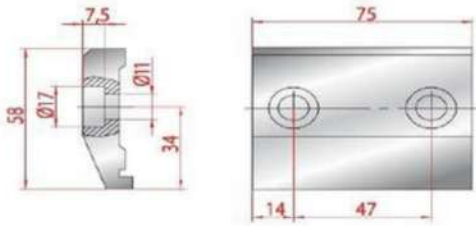
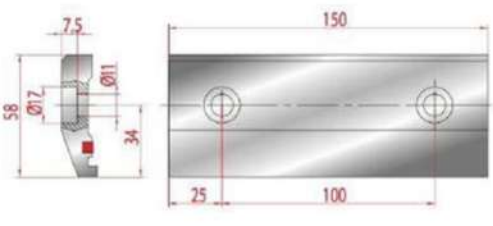


STAFFE - CLAMPS

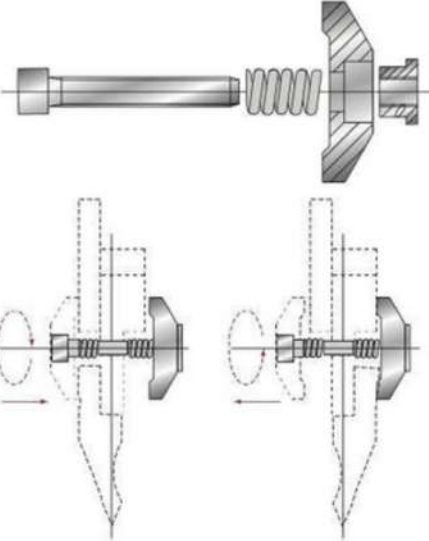
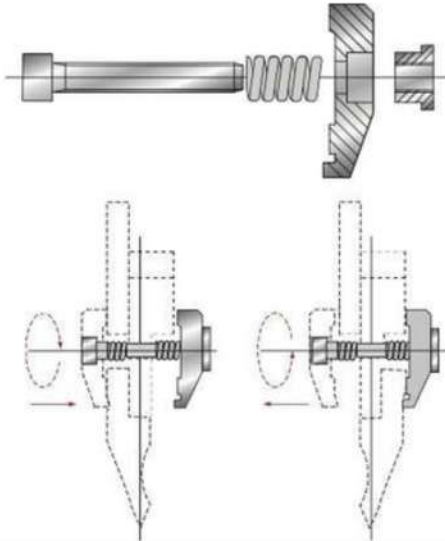
			
H=43		H=50	
50130439		40160509	
			
H=52		H=58	
50110529		40210589	
			
H=58		H=63	
42190589		42200639	
			
H=58		H=50	
40070587		40080507	



STAFFE - CLAMPS

					
H=58			H=58		
40900587			41990589		

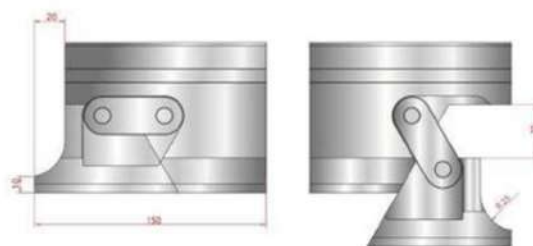
KIT PER DOPPIO STAFFAGGIO -
DOUBLE CLAMPING EQUIPMENT

			
Cod.		Cod.	
40310000		40320000	

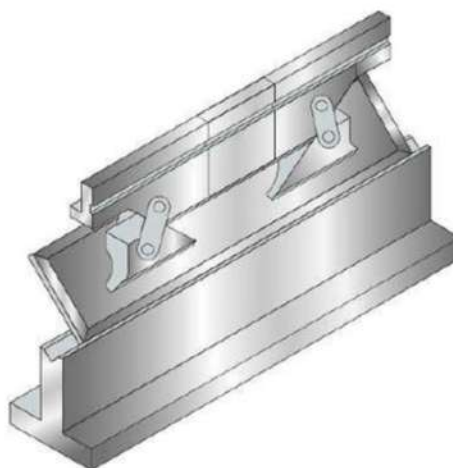


SCARPETTE MOBILI MOVING HORNS

Punzone - Punch	Scarp.Mob - Moving Horns
10109081/2/8	1010S9089 r=0,8 L=150
10118881/2/8	1011S8889 r=0,8 L=150
10649041/2/8	1064S9049 r=0,25 L=150
10658841/2/8	1065S8849 r=0,25 L=150
10473581/2/8	1047S3589 r=0,8 L=150



N.B. Prezzo per una coppia di
scarpette mobili
Note. Price for 1 couple of Moving
Horns



BRIDE E BLOCCAGGI SISTEMA **Jet Clamp**

Il nuovo sistema **Jet Clamp** per il fissaggio meccanico, sulle presse piegatrici, degli utensili tipo Amada-Promecam, presenta alcune innovative soluzioni per velocizzare le operazioni di cambio utensili e riducendo al minimo i tempi di SET-UP e consentendo il carico/scarico frontale degli utensili.



CARATTERISTICHE TECNICHE:

La notevole forza esercitata dalle leve e la brida realizzata a settori, assicurano il serraggio perfetto di elementi frazionati lunghi solo 10 mm, e anche in presenza di differenze di spessore. Le leve di bloccaggio, dal design particolarmente ergonomico, possono essere azionate singolarmente, con la mano destra o sinistra, oppure a coppia con entrambe le mani, ottenendo così un'ulteriore velocizzazione delle operazioni di cambio utensile. Con il sistema **Jet Clamp** non è richiesta l'installazione di impianti idraulici o pneumatici né l'allacciamento alla rete di distribuzione elettrica e pneumatica, e non vi è alcun rischio di perdita d'olio o di pressione; esso consente la riduzione dei consumi energetici e l'eliminazione delle sostanze inquinanti e delle spese di manutenzione. Nel caso di presse con ingombri particolari o per specifiche esigenze dei clienti è possibile lo studio e la realizzazione di leve con profili speciali. Tutti i componenti delle bride e degli intermediari sono rettificati.

- **BRIDE Jet Clamp 150 PER IL RETROFIT SU PRESSE GIA' INSTALLATE:**

Le bride sono state progettate per consentire di velocizzare i cambi utensili, sostituendo le vecchie bride e mantenendo gli intermediari già installati (per intermediari sp. 27 mm. H100 L150).

L'operazione di sostituzione delle bride è estremamente semplice e può essere effettuata dagli stessi tecnici che già operano sulle presse piegatrici.

- **BRIDA Jet Clamp 150 con apertura a 90°, dotata di PIN di sicurezza.**

Consente operazioni di carico e scarico utensile verticale e laterale sul lato anteriore dell'intermediario.

BLOCCAGGI **Jet Clamp**

I bloccaggi sono costruiti nella versione standard di L=150 mm. e nella nuova versione L=200 mm.

Entrambi i bloccaggi vengono prodotti con intermediari regolabili aventi lo spessore di 27 mm. o di 40 mm.

La nuova versione L=200 mm. conferisce continuità di serraggio degli utensili (vedi g. 4) su tutta la lunghezza della tavola, permette inoltre di fissare anche i punzoni frazona più corti in qualsiasi posizione.

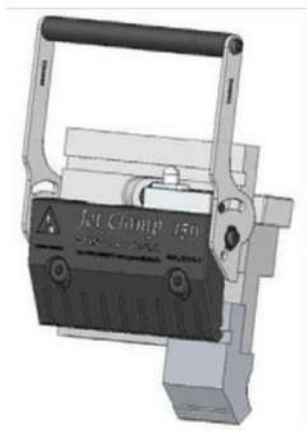
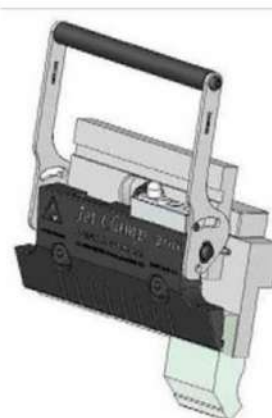


I bloccaggi sono composti da:

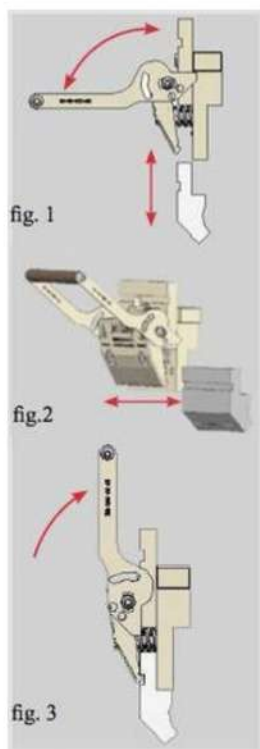
- brida di serraggio anteriore che, azionata da una leva, può aprirsi a 45° e a 90°,
- intermediario con cuneo di regolazione,
- PIN di sicurezza posto su brida che consente l'apertura a 45° e a 90°

DESC	Cod.	
Brida 150	JETC064AB	



BLOCCAGGIO Jet Clamp 150**BLOCCAGGIO Jet Clamp 200**

Descr.	Cod.		Descr.	Cod.	
Intermediario mm 27	JETC064AF		Intermediario mm 27	JETC083AF	
Intermediario mm 40	JETC066AF		Intermediario mm 40	JETC084AF	

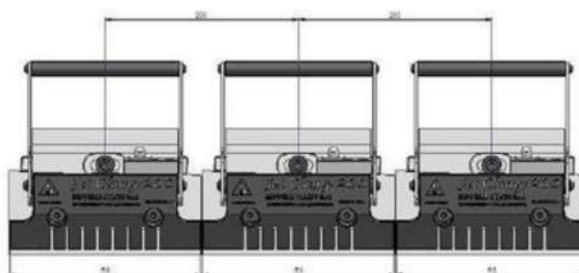
**CARICO E SCARICO VERTICALE DEI PUNZONI**

Questa operazione si effettua il cambio utensili sul lato anteriore del bloccaggio ed evita l'apertura delle barriere e la rimozione delle fotocellule.

- 1) Portare la leva in posizione a 90° (g. 1) per inserire o disinserire il punzone verticalmente sul lato anteriore o posteriore del bloccaggio.
- 2) Portare la leva in posizione a 45° (g.2) per sostenere il punzone senza bloccarlo e muoverlo lateralmente.
- 3) Posizionare la leva in verticale (g.3) per bloccare l'utensile.

CARICO E SCARICO LATERALE DEI PUNZONI

- 1) Portare la leva in posizione di apertura a 45° (g. 2) per inserire o disinserire lateralmente il punzone.
- 2) Posizionare la leva in verticale (g. 3) per bloccare l'utensile.



- I costi contenuti delle nostre soluzioni consentono di ammodernare le presse, ammortizzando la spesa in soli 2/3 mesi.
- Viene reso disponibile, a richiesta, la versione DUAL ovvero con brida per bloccaggio posteriore ad azionamento manuale.

Se desiderate concordare una dimostrazione presso di Voi, contattate il nostro tecnico/commerciale o direttamente i nostri uffici oppure visitate il nostro sito ed inviateci una mail.



CLAMPING SYSTEM **Jet Clamp**

The new **JetClamp** Amada-Promecam tools that allows frontal and lateral loading and unloading of the tooling.



TECHNICAL FEATURES:

The high power of the levers and the bride sectionally realized, assure a perfect locking of sectionalized element 10 mm long, and various sectionalized punches which has different thickness. The locking levers, with their ergonomic design, can be used with both hands or singularly with right or left hand, obtaining further quickening in tool changing. Jet Clamp system does not need the installation of hydraulic or pneumatic locking system avoiding onerous linking to electric and pneumatic net. In case of bending machines with overall dimensions or according to particular customer's requirements, it is possible to study and realize lever with special profile. All the brides and intermediates components are retified.

- **Jet Clamp BRIDES FOR RETROFIT ON MACHINES ALREADY EXISTING:**

The brides have been studied to allow a faster tool changing and a minimum SET-UP time, replacing the old brides and using the intermediates already existing. The brides replacing operation is extremely simple and can be done from the technician who use the bending machine.

- BRIDES Jet Clamp 150 mm with a 45° or 90° opening to load and unload tools laterally and frontally

LOCKING *Jet Clamp 150 - Jet Clamp 200:*

The locking over men oned can be furnished with the locking lenght 150mm. or 200 mm. Both lockings are produced with intermediates having thickness 27 mm. or 40 mm.

The new version 200 mm. lenght, allow to clamp the tooling, also the shortest of only 10 mm., in every position of the table without any interruptions.

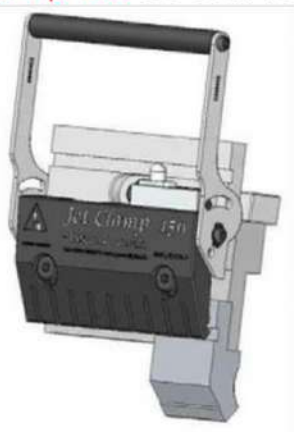
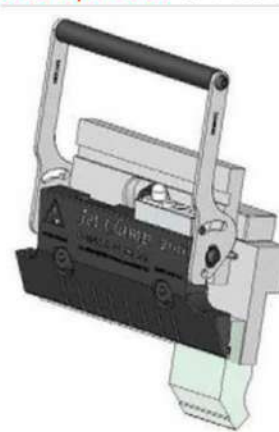
They are composed by:

- frontal clamp with it's proper leverage, adjustable intermediate,
- safety device that allow to have an opening of 45° or of 90,

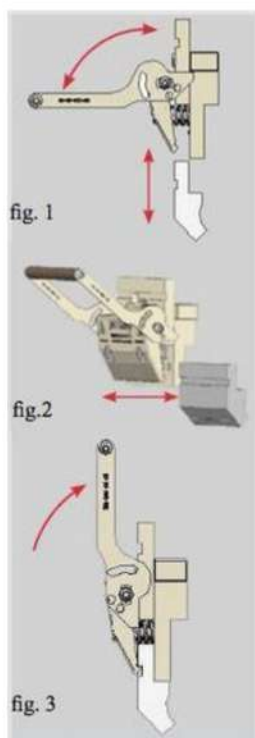


DESC	Cod.	
Brida 150	JETC064AB	



Jet Clamp 150 LOCKING**Jet Clamp 200 LOCKING**

Descr.	Cod.		Descr.	Cod.	
Intermediate mm 27	JETC064AF		Intermediate mm 27	JETC083AF	
Intermediate mm 40	JETC066AF		Intermediate mm 40	JETC084AF	

**VERTICAL TOOLS LOADING AND UNLOADING**

This kind of operation can be done only with the use of B brides and E locking system (avoid the opening of the security barriers or the photoelectric cells removing).

1) Opening the lever at 90° (pict. 1) for loading or unloading vertically the punch.

2) Keep the lever at 45° (pict. 2), to hold the punch without locking it.

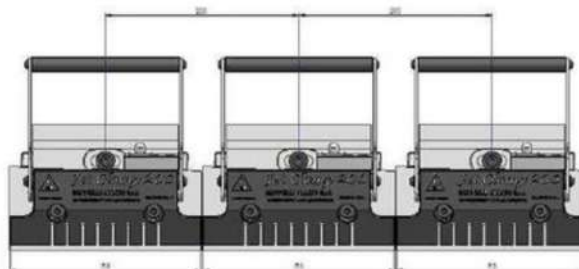
3) Put the lever in vertical position (pict. 3) to lock the tool.

LATERAL TOOLS LOADING AND UNLOADING:

We have this function with all the kind of clamps and locking system.

1) Keep the lever in opening position 45° (pict. 2) for to load or unload laterally the tool.

2) Put the lever in vertical position (bride locking pict. 3) to lock the tool.



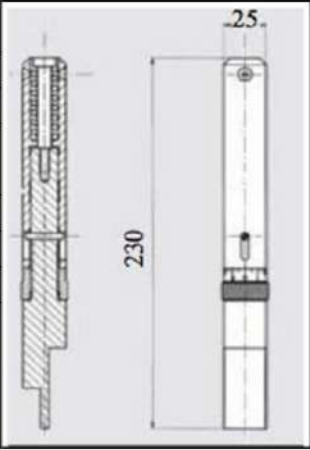
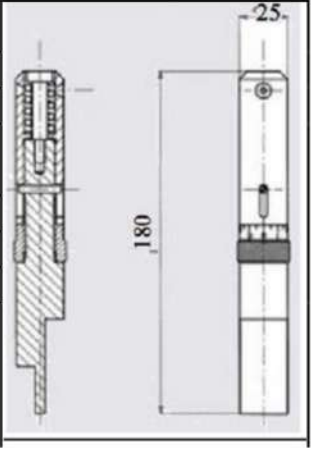
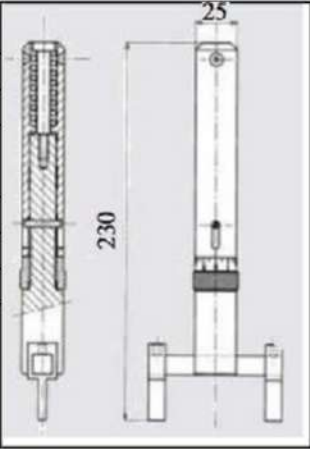
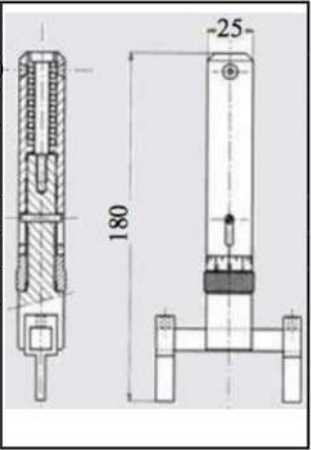
- The low costs of our solutions allow our customers to renew their operating machines with an expense that they can amortize in 3 or 4 months.
- Available, on request, the DUAL version with rear clamp on manual closure.

Please do not hesitate to contact us through our technicians/sales dept or on our web site for any offers or free demonstration on your machines.



BATTUTE PRESSE PIEGATRICI SCHIAVI

PRESS BRAKE ARM GAUGE

Cod.	5535V0252		Cod.	5535V0260	
Art.	Battuta regolabile L=230 Adjustable Back Gauge		Art.	Battuta regolabile L=180 Adjustable Back Gauge	
Note	Attacco Tondo d.25 Round Connection d.25 ad esclusione/except mod. RG25		Note	MOD. RG25 Attacco Tondo d.25 For RG25 whit Round Connection d.25	
Cod.	5535V0264		Cod.	5535V0264 (corta/short)	
Art.	Battuta reg. doppia Double Adj. Back Gauge		Art.	Battuta reg. doppia L=230 Double Adj. Back Gauge	
Note	Attacco Tondo d.25 Round Connection d.25 ad esclusione/except mod. RG25		Note	MOD. RG25 Attacco Tondo d.25 For RG25 whit Round Connection d.25	

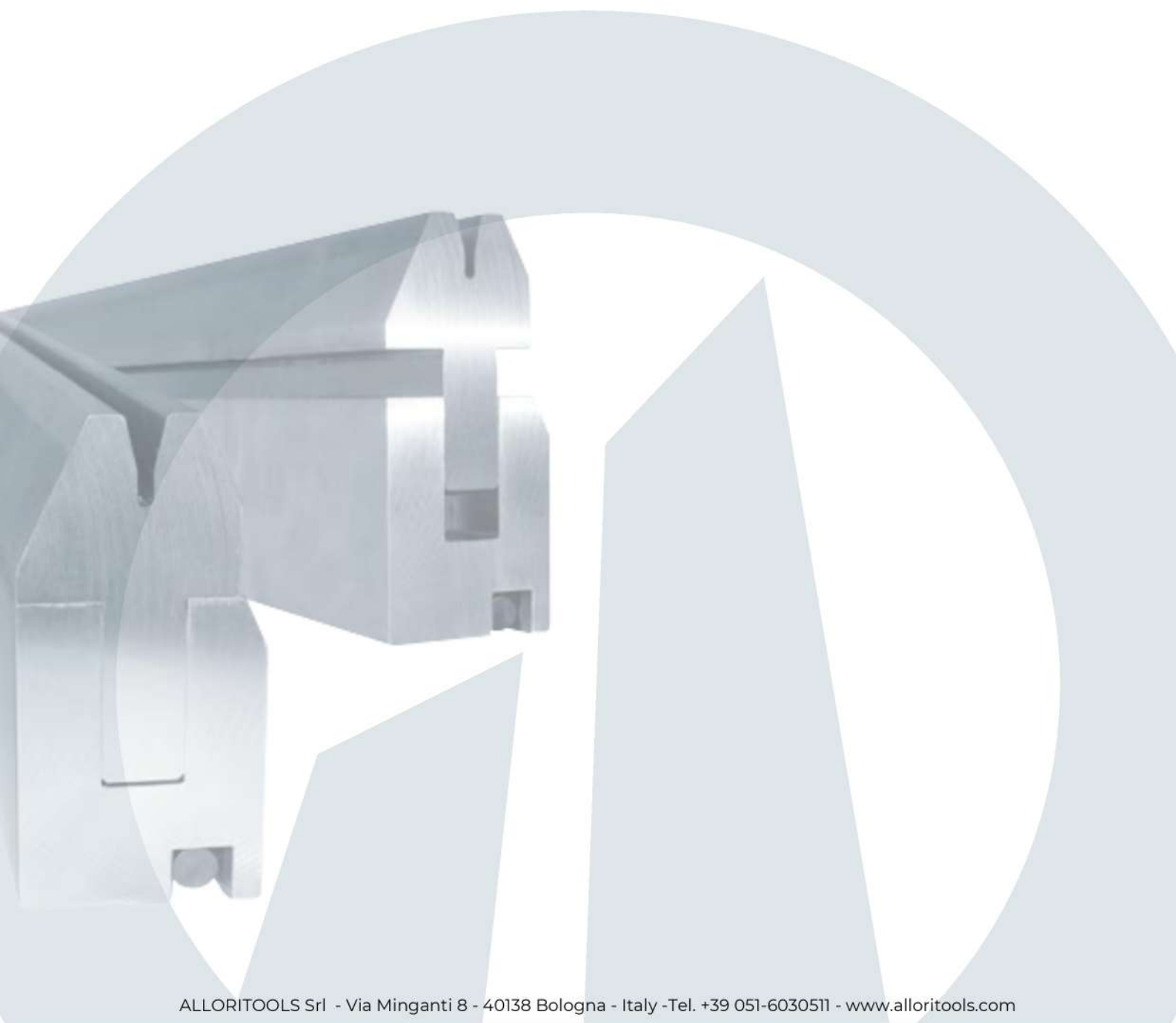


UTENSILI DI PIEGATURA | BENDING TOOLS

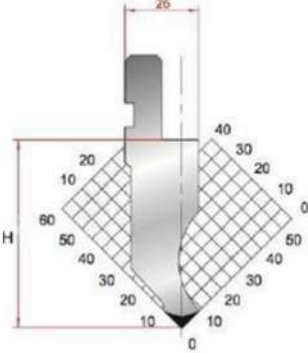
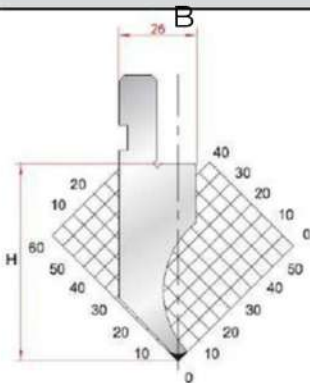
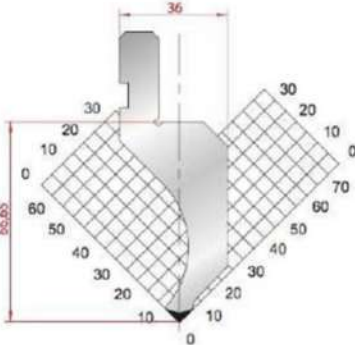
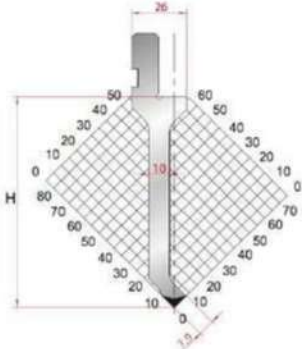
Punzoni -Punches

Amada®

Promecam®

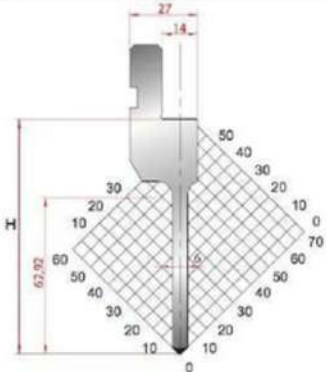
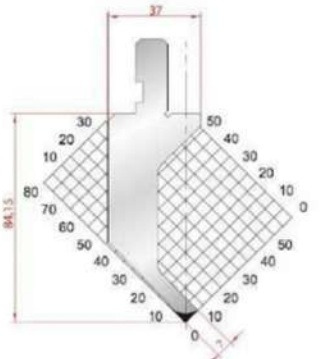
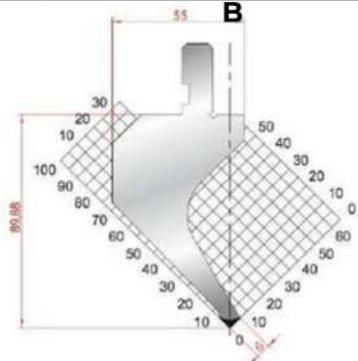
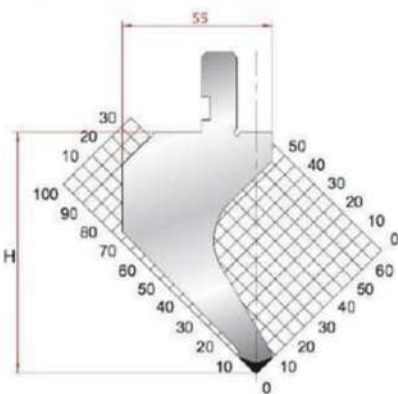


PUNZONI 90°**90 ° PUNCHES**

90° 100T/m C45	R	H	835 mm	415mm	FRAZ/SECT
	0,25	66,6	10649041	10649042	10649048
	0,8	66,65	10109081 -	10109082 -	10109088 -
	-	-			
			-	-	-
	KG		10,5	5,2	9,7
90° 35T/m C45-	R	H	835 mm	415mm	FRAZ/SECT
	0,25	66,35	12639041	12639042	12639048
	0,60	66,40	10489061	10489062 -	10489068
	-	-			
			-	-	-
	KG		10,0	5,0	9,1
90° 60T/m C45	R	H	835 mm	415mm	FRAZ/SECT
	0,80	66,65	10809081	10809082	10809088
	-	-			
	-	-			
			-	-	-
	KG		10,3	5,0	9,3
90° 50T/m C45	R	H	835 mm	415mm	FRAZ/SECT
	0,25	99,35	12619041	12619042	12619048
	0,6	99,4	10289061	10289062	10289068
	-	-			
			-	-	-
	KG		9,7	4,8	8,9

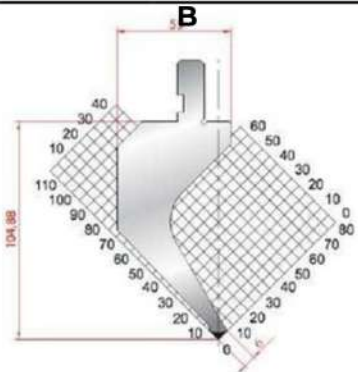
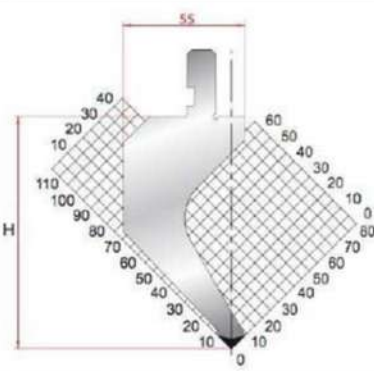
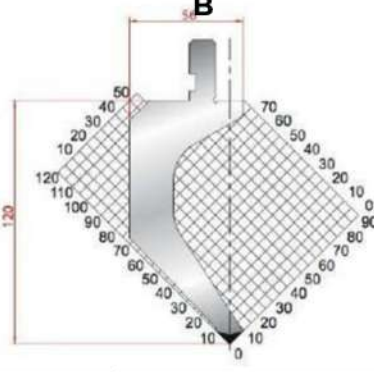
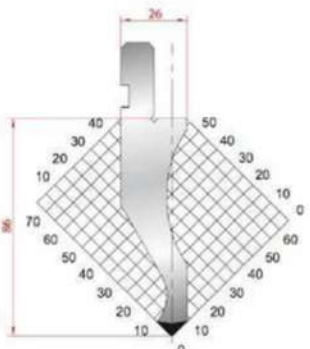


PUNZONI 90°
90 ° PUNCHES

90° 50T/m C45-B	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	94,35	12699041	12699042	12699048
	0,6	94,40	10839061	10839062	10839068
					-
	KG Price		9,7	4,7	8,6
90° 20T/m 42Cr	R	H	835 mm	415 mm	FRAZ/SECT.
	0,60	84,15	10199061	10199062	10199068
		-	-		-
		-	-		-
	KG		12,8	6,4	11,8
90° 50T/m C45-B	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	89,88	11769041	11769042 - -	11769048
		-	-		-
		-			
	KG		18,4	9,1	16,9
90° 60T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	89,6	12659041	12659042	12659048
	0,80	89,65	10139081	10139082	10139088
	-	-			-
	KG		19,4	9,7	17,9

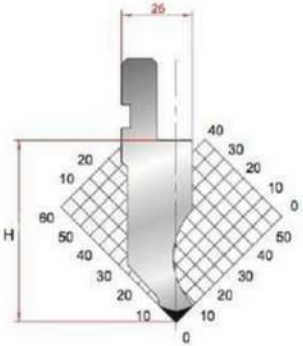
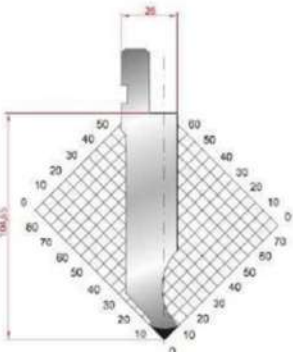
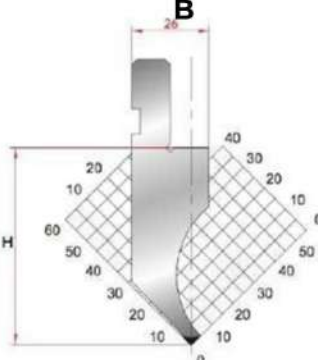
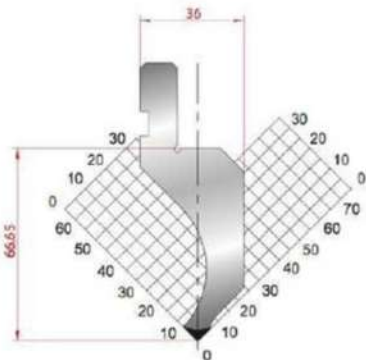


PUNZONI 90°**90 ° PUNCHES**

90° 50T/m C45-	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	104,88	11749041 - -	11749042 - -	11749048 - -
	-	-			
	-	-			
	KG		20,7	10,3	19,0
90° 50T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	104,60	12679041	12679042	12679048
	0,8	104,65	10169081 -	10169082 -	10169088 -
	-				
	KG		21,9	10,9	21,1
90° 50T/m C45-	R	H	835 mm	415 mm	FRAZ/SECT.
	0,80	120,00	10609081 - -	10609082 - -	10609088 - -
	-	-			
	-	-			
	KG		22,0	10,9	20,2
90° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	86,00	10219081 - -	10219082 - -	10219088 - -
	-	-			
	-	-			
	KG		10,9	5,4	10,0

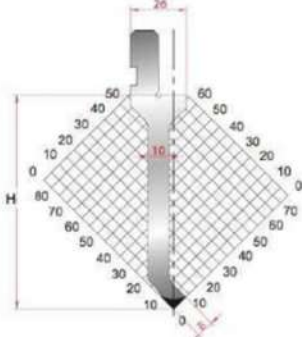
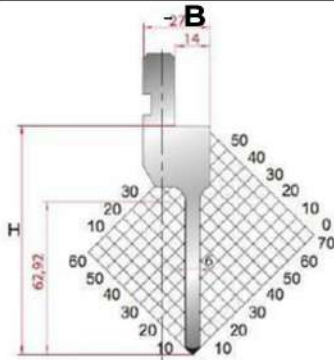
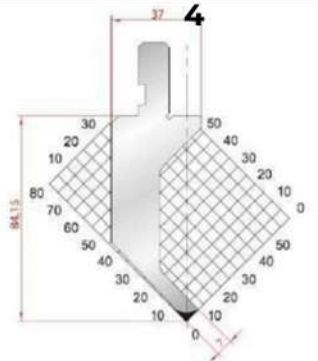
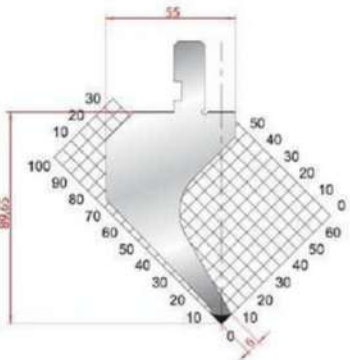


PUNZONI 88°
88 ° PUNCHES

88° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT
	0,25	66,6	10658841	10658842	10658848
	0,8	66,65	10118881	10118882	10118888
	3,0	65,5	10128831	10128832	10128838
			10,5	5,2	9,7
88° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	104,65	10638881 - -	10638882 - -	10638888 - -
	-	-			
	-	-			
	KG		16,4	8,2	15,1
88° 35T/m C45-	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	66,35	12648841	12648842	12648848
	0,60	66,4	10498861 -	10498862 -	10498868 -
	-	-			
	KG		10,0	5,0	10,0
88° 60T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	66,65	10818881 - -	10818882 - -	10818888 - -
	-	-			
	-	-			
	KG		10,1	5,0	9,3

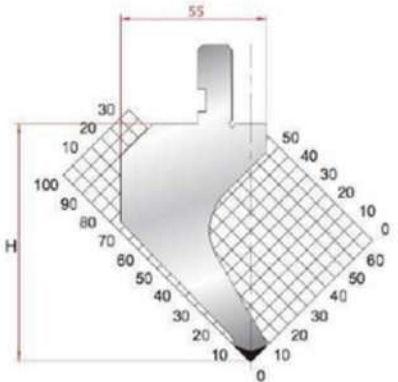
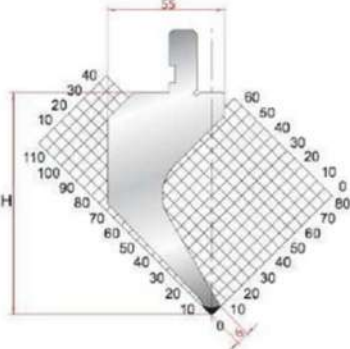
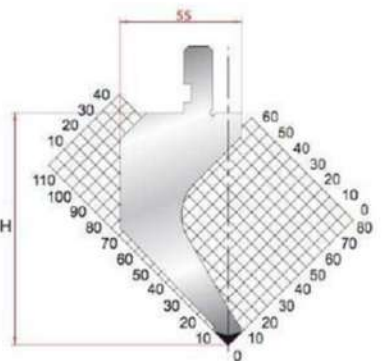
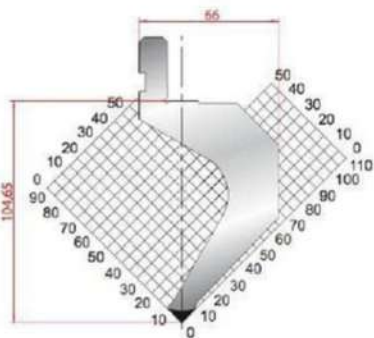


PUNZONI 88°
88 ° PUNCHES

88° 50T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	99,35	12628841	12628842	12628848
	0,6	99,4	10298861 -	10298862 -	10298868 -
	-	-			
	KG		9,7	4,8	8,9
88° 50T/m C45-	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	94,35	12708841	12708842	12708848
	0,6	94,4	10848861 -	10848862 -	10848868 -
	-	-			
	KG		9,4	4,7	8,6
88° 20T/m 42CrMo	R	H	835 mm	415 mm	FRAZ/SECT.
	0,6	84,15	10208861 - -	10208862 - -	10208868 - -
	-	-			
	-	-			
	KG		12,8	5,4	11,8
88° 50T/m C45-B	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	89,65	11758881 - -	11758882 - -	11758888 - -
	-	-			
	-	-			
	KG		18,4	9,1	16,9
	Price				

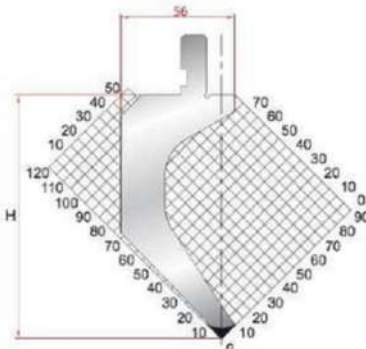
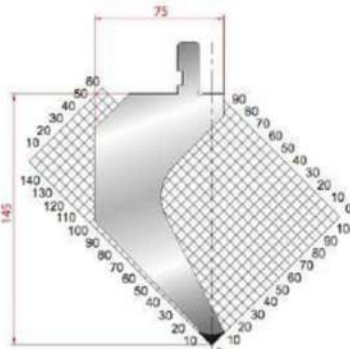
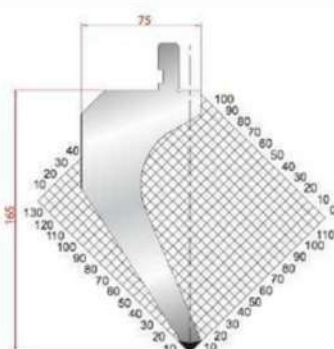
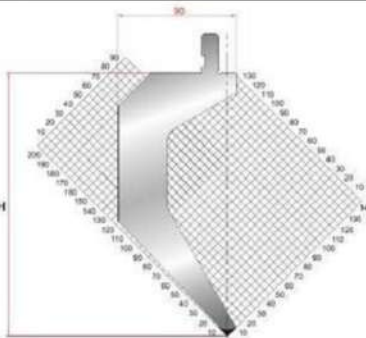


PUNZONI 88°
88 ° PUNCHES

88° 60T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	89,6	12668841	12668842	12668848
	0,8	89,65	10148881	10148882	10148888
	3,0	88,5	10158831	10158832	10158838
	KG		19,5	9,7	17,9
88° 50T/m C45-B	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	104,65	11738881 - -	11738882 - -	11738888 - -
	-	-			
	-	-			
	KG		20,7	10,3	19,0
88° 50T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,25	104,6	12688841	12688842	12688848
	0,8	104,65	10178881	10178882	10178888
	3,0	103,5	10188831	10188832	10188888
	KG		21,8	10,8	20,0
88° 45T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	104,65	10828881 -	10828882 - -	10828888 - -
	-	-			
	-	-			
	KG		21,1	10,5	19,4

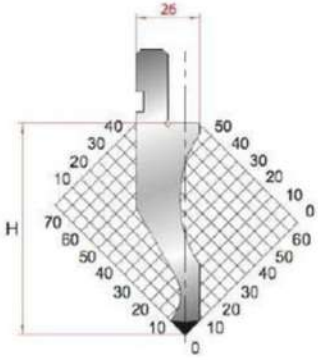
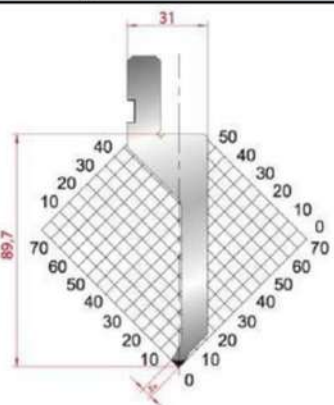


PUNZONI 88°
88 ° PUNCHES

88° 50T/m C45-B	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	120,0	10618881	10618882	10618888
	3,0	119,03	10628831	10628832	10628838
	-	-	-	-	-
	-	-	-	-	-
	KG	22,0	10,9	20,2	
88° 80T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	145,0	10308881	10308882 - -	10308888 - -
	-	-			
	-	-			
	-	-			
	KG	39,0	19,5	36,1	
88° 60T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	165,00	10318881 - -	10318882 - -	10318888 - -
	-	-			
	-	-			
	-	-			
	KG	39,2	19,5	36,0	
88° 85T/m C45-B	R	H	505 mm	FRAZ/SECT. 805	
	0,8	200,0	12918886	12918888	
	3,0	199,03	13018836	13018838	
	-	-			
	KG	32,4	49,2		

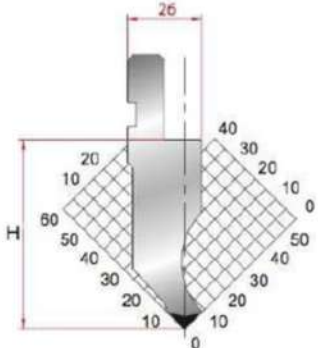
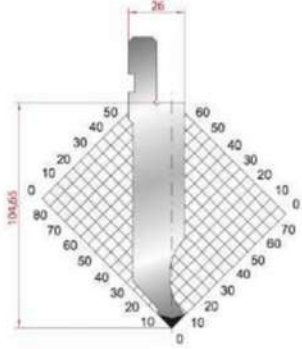
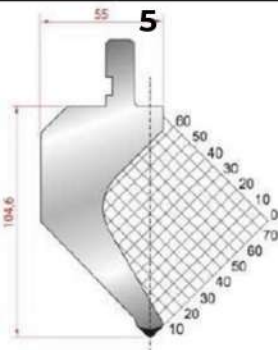
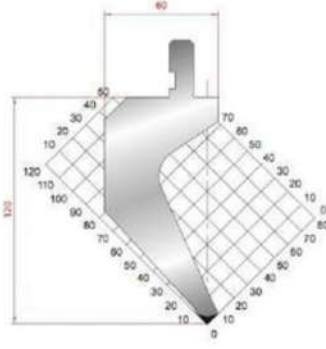


PUNZONI 88°
88 ° PUNCHES

88° 100T/m C45	R	H	835 mm	415 mm	805F/S
	0,8	86,00	10228881	10228882	10228888
	3,0	84,85	10238831 -	10238832 -	10238838 -
	-				
	-				
	KG	10,9	5,4	10,0	
88° 30T/m C45-B	R	H	835 mm	415 mm	805F/S
	0,6	89,7	12908861	12908862	12908868
	-				
	-				
	-		- -	- -	- -
	KG	10,0	5,0	9,3	

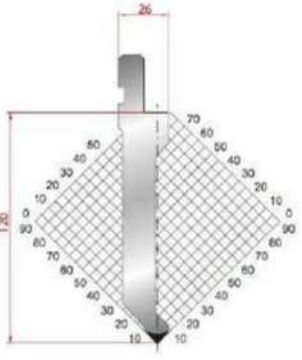
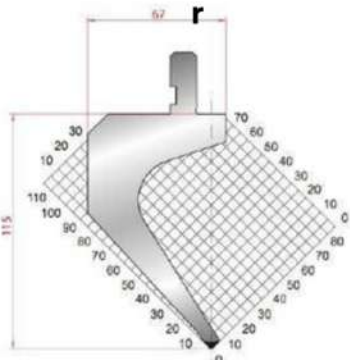
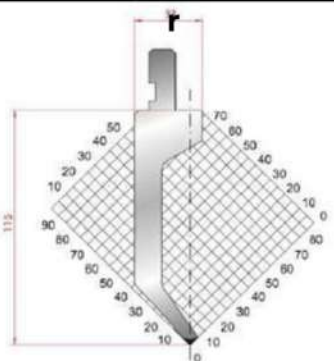


PUNZONI 85° **85 ° PUNCHES**

85° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	66,6	12608581	12608582	12608588
	3,0	65,5	11778531	11778532	11778538 - - -
	-	-			
	KG	11,0	5,0	11,0	
85° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	104,65	12818581 - -	12818582 - -	12818588 - -
	-	-			
	-	-			
	KG	17,0	9,0	17,0	
85° 50T/m C4	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	104,6	11728581 - -	11728582 - -	11728588 - -
	-	-			
	-	-			
	KG	23,0	11,5	23,0	
85° 100T/m 42Cr	R	H	835 mm	415 mm	FRAZ/SECT.
	1,5	120,0	13228581 - -	13228582 - -	13228588 - -
	-	-			
	-	-			
	KG	26,7	13,3	26,7	

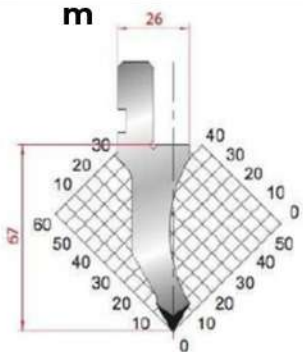
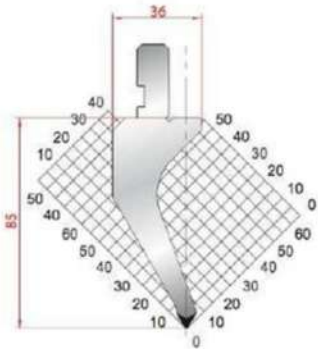
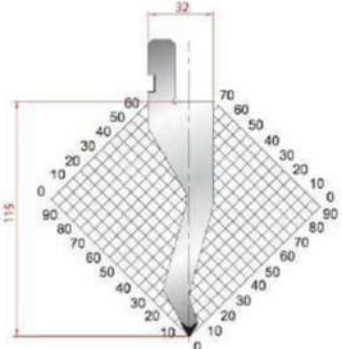
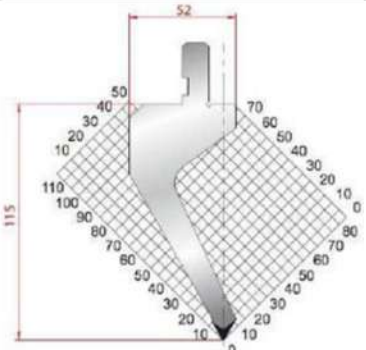


PUNZONI 85°**85 ° PUNCHES**

85° 70T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	120,0	13098581	13098582	13098588
	-	-	-	-	-
	-	-	-	-	-
	KG		15,9	7,8	14,7
85° 35T/m 42C	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	115,0	13108581	13058582	13058588
	-	-	-	-	-
	-	-	-	-	-
	KG		23,0	11,5	23,0
85° 20T/m 42C	R	H	835 mm	415 mm	FRAZ/SECT.
	0,6	115,0	13128581	13128582	13158588
	-	-	-	-	-
	-	-	-	-	-
	KG		14,5	7,2	14,5

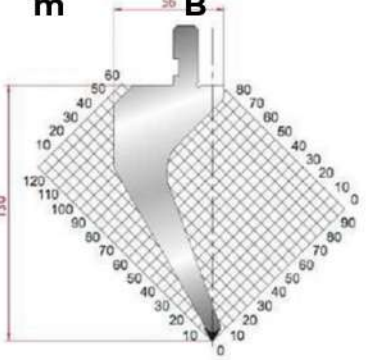
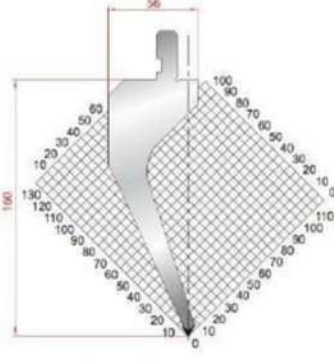
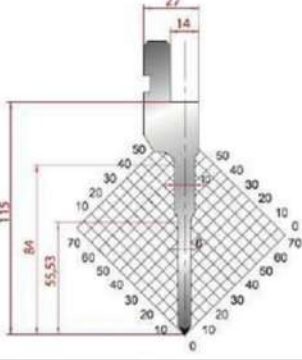
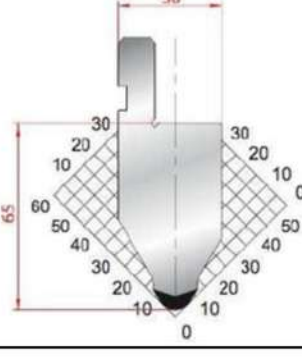


PUNZONI 60° **60 ° PUNCHES**

60° 80T/ C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	67,0	10266081	10266082	10266088
	2,0	67,0	10276021 -	10276022 -	10276028 -
	-	-			
	KG	9,0	4,5	9,0	
60° 40T/m 42Cr	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	85,0	11626081 - -	11626082 - -	11626088 - -
	-	-			
	-	-			
	KG	12,0	6,0	12,0	
60° 60T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	115,0	11916081 - -	11916082 - -	11916088 - -
	-	-			
	-	-			
	KG	15,0	7,5	15,0	
60° 40T/m C45-B	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	115,0	12726081 - -	12726082 - -	12726088 - -
	-	-			
	-	-			
	KG	20,0	10,0	20,0	

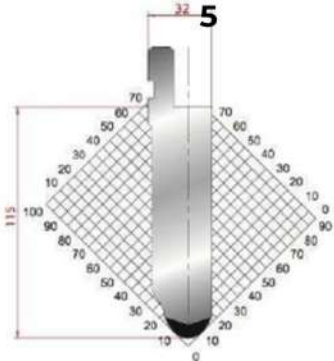
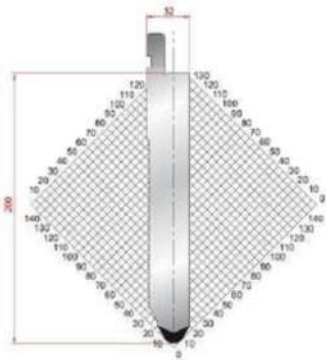
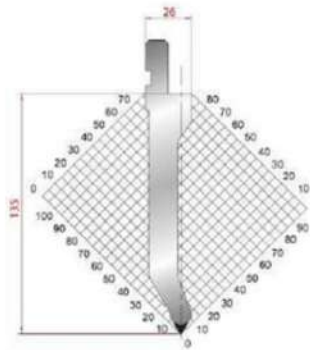


PUNZONI 60° **60 ° PUNCHES**

60° 40T/ C45-	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	130,0	11636081	11636082	11636088
	-	-	-	-	-
	-	-	-	-	-
	KG	23,0	11,5	20,5	
60° 40T/m C45-B	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	160,0	11906081	11906082	11906088
	-	-	-	-	-
	-	-	-	-	-
	KG	23,0	11,5	23,0	
60° 50T/m C45-B	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	115,0	12716081	12716082	12716088
	-	-	-	-	-
	-	-	-	-	-
	KG	9,0	4,5	9,0	
60° 120T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	6,0	65,0	103260A1	103260A2	103260A8
	-	-	-	-	-
	-	-	-	-	-
	KG	15,0	7,5	13,6	

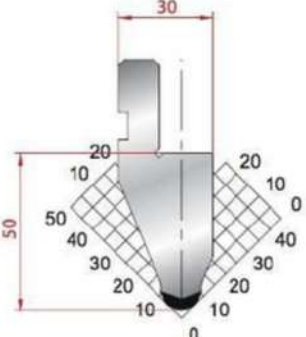
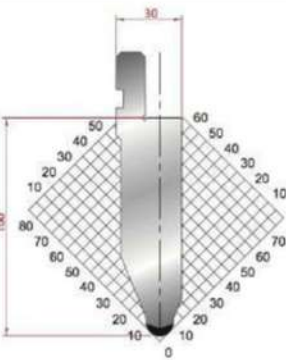
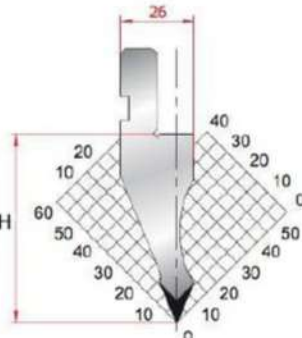


PUNZONI 60°**60 ° PUNCHES**

60° 150T/m C4	R	H	835 mm	415 mm	FRAZ/SECT.
	10,0	115,0	12836001	12836002	12836008
	-	-	-	-	-
	-	-	-	-	-
	KG		23,8	11,8	21,9
60° 150T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	8,0	200,0	129360E1	129360E2	129360E8
	-	-	-	-	-
	-	-	-	-	-
	KG		40,8	20,4	40,8
60° 70T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	135,0	12846081	12846082	12846088
	-	-	-	-	-
	-	-	-	-	-
	KG		19,0	9,0	19,0

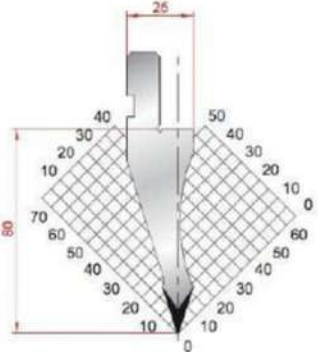
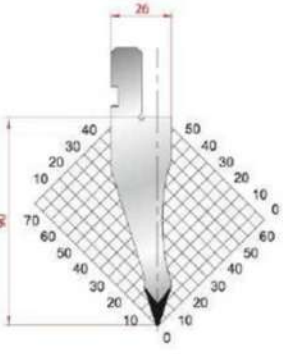
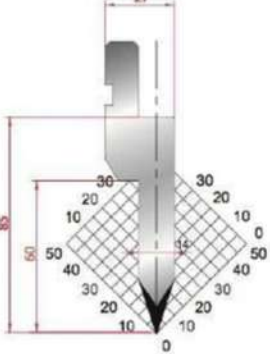


PUNZONI 45° **45 ° PUNCHES**

45° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	6,0	50,0	105445A1 - -	105445A2 - -	105445A8 - -
	-	-			
	-	-			
	KG		9,5	4,75	9,5
45° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	6,0	100,0	105345A1 - -	105345A2 - -	105345A8 - -
	-	-			
	-	-			
	KG		20,0	10,0	20,0
45° 80T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,5	66,4	10244571	10244572	10244578
	1,5	65,2	10254591 -	10254592 -	10254598 -
	-	-			
	KG		10,0	5,0	10,0

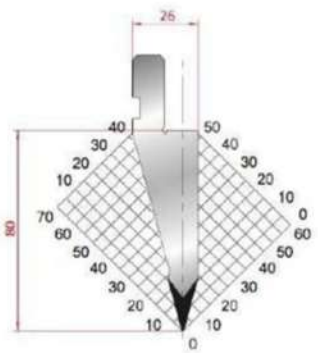
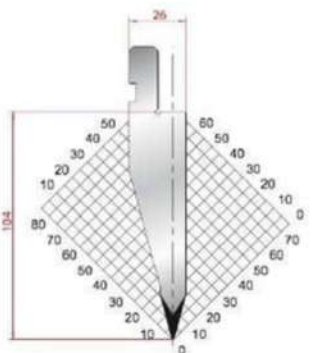
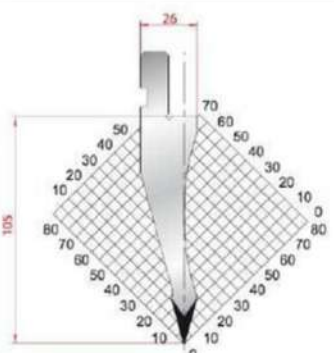
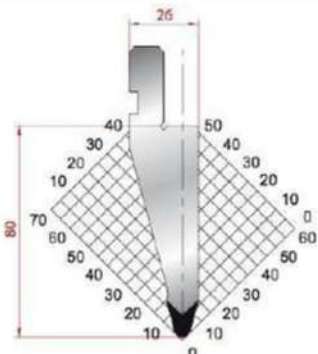


PUNZONI 35° **35 ° PUNCHES**

35° 70T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,5	80,0	10353571 - -	10353572 - -	10353578 - -
	-	-			
	-	-			
	KG	11,0	5,50	11,0	
35° 70T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	90,0	10473581	10473582	10473588
	1,5	90,0	12823591 -	12823592 -	12823598 -
	-	-			
	KG	12,0	6,0	12,0	
35° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,8	85,0	10343581 - -	10343582 - -	10343588 - -
	-	-			
	-	-			
	KG	11,0	5,5	11,0	

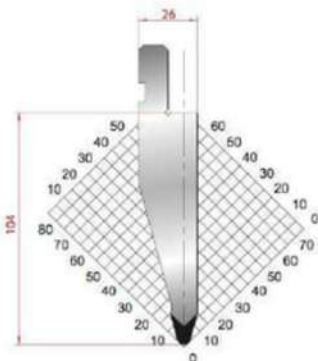
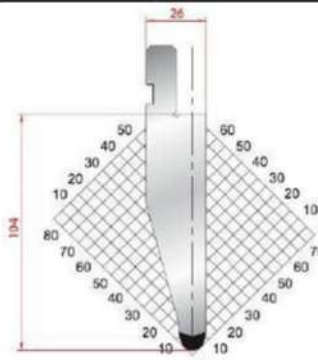
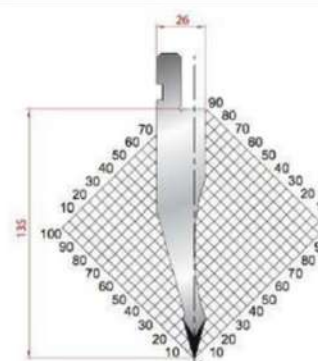
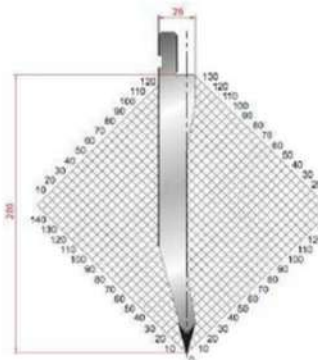


PUNZONI 30° **30 ° PUNCHES**

30° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,5	80,0	10563071 - -	10563072 - -	10563078 - -
	-	-			
	-	-			
	KG	11,0	5,5	11,0	
30° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,6	104,0	11933061 - -	11933062 - -	11933068 - -
	-	-			
	-	-			
	KG	14,6	7,3	13,4	
30° 50T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,5	105,0	10553071 - -	10553072 - -	10553078 - -
	-	-			
	-	-			
	KG	16,0	8,0	16,0	
30° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	3	80,0	10573031 - -	10573032 - -	10573038 - -
	-	-			
	-	-			
	KG	11,0	5,5	11,0	



PUNZONI 30° **30 ° PUNCHES**

30° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	3,0	104,0	12893031 - -	12893032 - -	12893038 - -
	-	-			
	-	-			
	KG	17,0	8,5	17,0	
30° 100T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	5,0	104,0	11943051 - -	11943052 - -	11943058 - -
	-	-			
	-	-			
	KG	17,0	8,5	17,0	
30° 50T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,5	135,0	10523071 - -	10523072 - -	10523078 - -
	-	-			
	-	-			
	KG	20,0	10,0	20,0	
30° 50T/m C45	R	H	835 mm	415 mm	FRAZ/SECT.
	0,5	200,0	12923071 - -	12923072 - -	12923078 - -
	-	-			
	-	-			
	KG	26,0	13,0	26,0	





UTENSILI DI PIEGATURA | BENDING TOOLS

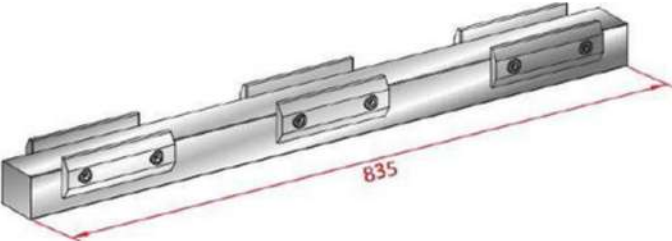
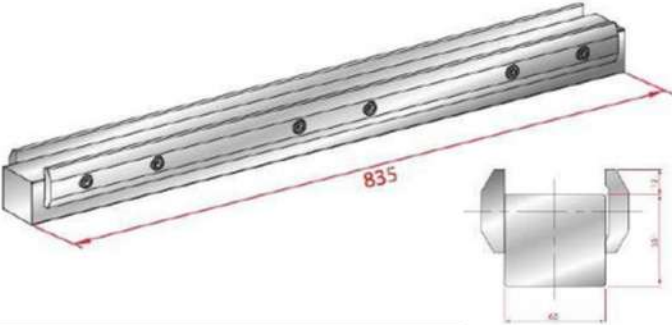
Matrice - Dies

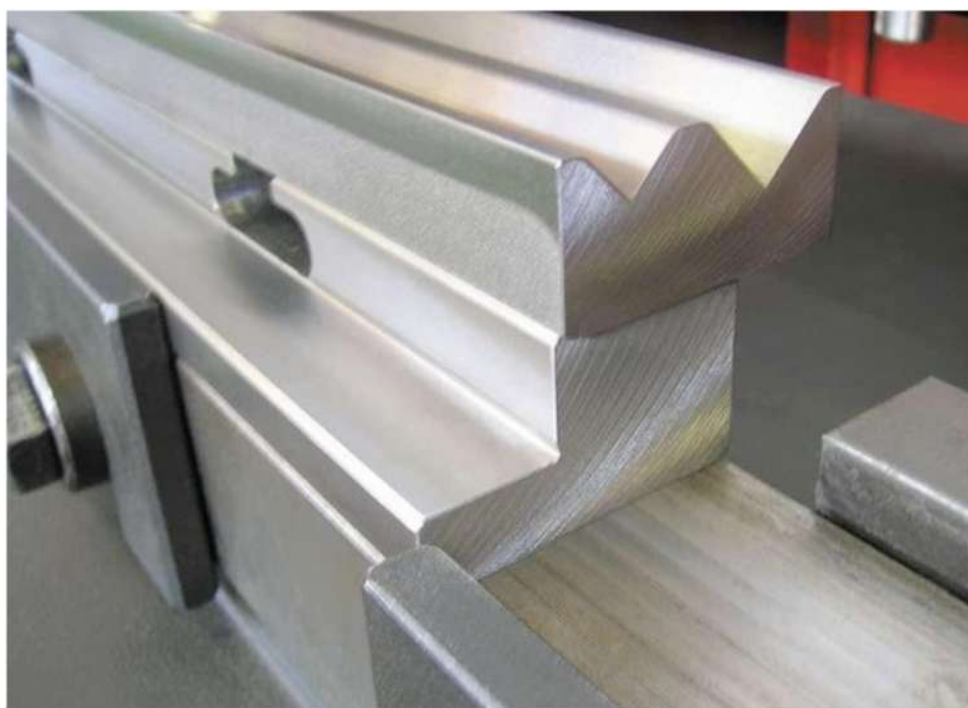
Amada®

Promecam®



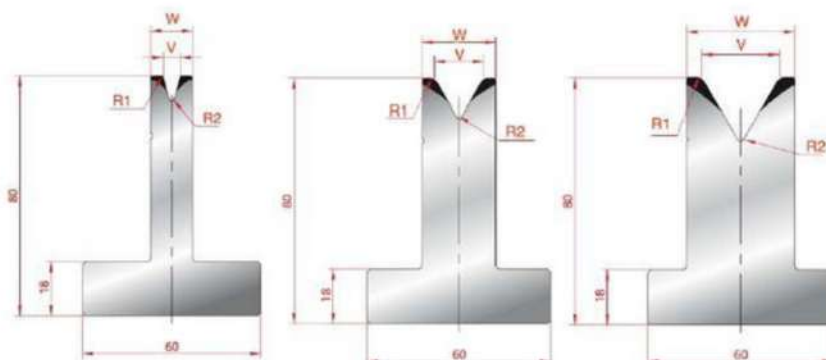
SOVRA TAVOLA TABLE ADAPTER

		415 mm	835 mm
SUPPORTO MATRICE CON BRIDA STD DIE HOLDER STD. CLAMP PLATE		40330552	40330551
	KG	11,0	22,0
	BRIDA L=150		
	Ant		Post
	4016		4034
		415 mm	835 mm
SUPPORTO MATRICE CON BRIDA LUNGA DIE HOLDER LONG CLAMP PLATE		40500552	40500551
	KG	14,0	28,0
	BRIDA L=800		
	Ant		Post
	4040		4041
	BRIDA L=400		
	4040-S		4041-S



MATRICI T H=80 C45

T DIES H=80 C45

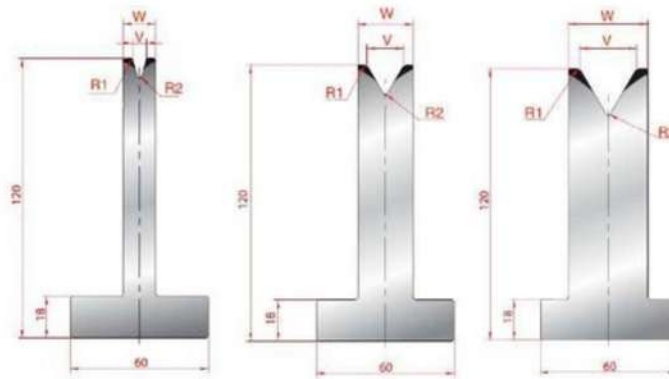


α	V	W	R1	R2	T/m	835 mm.			415 mm.			FRAZ / SECT.		
						Code	Price	KG.	Code	Price	KG.	Code	Price	KG.
30°	6	14	0,6	1	35	304230061		13,0	304230062		6,5	304230068		13,0
30°	8	18	0,8	2	40	304330081		15,0	304330082		7,5	304330088		15,0
30°	10	24	1,0	2	50	304430101		18,0	304430102		9,0	304430108		18,0
30°	12	24	1,5	2	50	304530121		18,0	304530122		9,0	304530128		18,0
30°	16	30	2,0	5	50	304630161		19,0	304630162		9,5	304630168		19,0
30°	20	35	2,5	5	55	304730201		20,0	304730202		10,0	304730208		20,0
30°	25	40	3,0	5	55	304830251		21,0	304830252		10,5	304830258		21,0
45°	6	14	0,6	0,5	50	302645061		13,0	302645062		6,5	302645068		13,0
45°	8	18	0,8	0,5	50	302745081		15,0	302745082		7,5	302745088		15,0
45°	10	18	1,0	0,7	50	302845101		15,0	302845102		7,5	302845108		15,0
45°	12	24	1,5	0,7	50	302945121		18,0	302945122		9,0	302945128		18,0
45°	16	24	2,0	1	50	303045161		18,0	303045162		9,0	303045168		18,0
45°	20	30	2,5	1	50	303145201		19,0	303145202		9,5	303145208		19,0
45°	25	35	3,0	1	50	303245251		20,0	303245252		10,0	303245258		20,0
60°	6	14	0,4	0,5	60	301960061		13,0	301960062		6,5	301960068		13,0
60°	8	14	0,5	0,5	60	302060081		13,0	302060082		6,5	302060088		13,0
60°	10	18	0,6	0,5	60	302160101		15,0	302160102		7,5	302160108		15,0
60°	12	18	0,8	0,5	60	302260121		15,0	302260122		7,5	302260128		15,0
60°	16	24	3,0	0,7	60	302360161		18,0	302360162		9,0	302360168		18,0
60°	20	30	3,0	0,7	60	302460201		19,0	302460202		9,5	302460208		19,0
60°	25	35	3,0	1	60	302560251		20,0	302560252		10,0	302560258		20,0
85°	6	14	0,4	0,5	100	308685061		13,0	308685062		6,0	308685068		13,0
85°	8	14	0,5	0,5	100	308785081		13,0	308785082		6,0	308785088		13,0
85°	10	18	0,6	0,5	100	308885101		15,0	308885102		7,0	308885108		15,0
85°	12	18	2,75	0,5	100	308985121		15,0	308985122		7,0	308985128		15,0
85°	16	24	2,75	0,5	100	309085161		18,0	309085162		9,0	309085168		18,0
85°	20	30	3,0	0,5	100	309185201		19,0	309185202		9,0	309185208		19,0
85°	25	35	3,0	0,5	100	309285251		20,0	309285252		10,0	309285258		20,0
88°	6	14	0,4	0,5	100	308088061		13,0	308088062		6,5	308088068		13,0
88°	8	14	0,5	0,5	100	308188081		13,0	308188082		6,5	308188088		13,0
88°	10	18	0,60	0,5	100	308288101		15,0	308288102		7,5	308288108		15,0
88°	12	18	2,75	0,5	100	301588121		15,0	301588122		7,5	301588128		15,0
88°	16	24	2,75	0,5	100	301688161		16,0	301688162		8,0	301688168		16,0
88°	20	30	3,0	0,5	100	301788201		19,0	301788202		9,5	301788208		19,0
88°	25	35	3,0	0,5	100	301888251		20,0	301888252		10,0	301888258		20,0
90°	6	14	0,4	0,5	100	301090061		13,0	301090062		6,5	301090068		13,0
90°	8	14	0,5	0,5	100	301190081		13,0	301190082		6,5	301190088		13,0
90°	10	18	0,6	0,5	100	301290101		15,0	301290102		7,5	301290108		15,0
90°	12	18	0,8	0,5	100	301390121		15,0	301390122		7,5	301390128		15,0
90°	16	24	1,0	0,5	100	301490161		18,0	301490162		9,0	301490168		18,0



MATRICI T **H=120 C45**

T DIES **H=120 C45**



α	V	W	R1	R2	T/m	835 mm.			415 mm.			FRAZ / SECT.		
						CODE	EURO	KG.	CODE	EURO	KG.	CODE	EURO	KG.
30°	6	14	0,6	1	35	307330061		17,0	307330062		8,5	307330068		17,0
30°	8	18	0,8	2	40	307430081		18,0	307430082		9,0	307430088		18,0
30°	10	24	1,0	2	50	307530101		22,0	307530102		11,0	307530108		22,0
30°	12	24	1,5	2	50	307630121		22,0	307630122		11,0	307630128		22,0
30°	16	30	2,0	5	50	307730161		27,0	307730162		13,5	307730168		27,0
30°	20	35	2,5	5	55	307830201		30,0	307830202		15,0	307830208		30,0
30°	25	40	3,0	5	50	307930251		33,0	307930252		16,5	307930258		33,0
45°	6	14	0,6	0,5	50	306645061		17,0	306645062		8,5	306645068		17,0
45°	8	18	0,8	0,5	50	306745081		18,0	306745082		9,0	306745088		18,0
45°	10	18	1,0	0,7	50	306845101		18,0	306845102		9,0	306845108		18,0
45°	12	24	1,5	0,7	50	306945121		22,0	306945122		11,0	306945128		22,0
45°	16	24	2,0	1	50	307045161		22,0	307045162		11,0	307045168		22,0
45°	20	30	2,5	1	50	307145201		27,0	307145202		13,5	307145208		27,0
45°	25	35	3,0	1	50	307245251		30,0	307245252		15,0	307245258		30,0
60°	6	14	0,4	0,5	60	305960061		16,0	305960062		8,0	305960068		16,0
60°	8	14	0,5	0,7	60	306060081		16,0	306060082		8,0	306060088		16,0
60°	10	18	0,6	0,5	60	306160101		18,0	306160102		9,0	306160108		18,0
60°	12	18	0,8	0,5	75	306260121		18,0	306260122		9,0	306260128		18,0
60°	16	24	3,0	0,7	70	306360161		22,0	306360162		11,0	306360168		22,0
60°	20	30	3,0	0,7	65	306460201		27,0	306460202		13,5	306460208		27,0
60°	25	35	3,0	1	60	306560251		28,0	306560252		14,0	306560258		28,0
85°	6	14	0,4	0,5	100	309385061		17,0	309385062		8,0	309385068		17,0
85°	8	14	0,5	0,5	100	309485081		17,0	309485082		8,0	309485088		17,0
85°	10	18	0,6	0,5	100	309585101		18,0	309585102		9,0	309585108		18,0
85°	12	18	2,75	0,5	100	309685121		18,0	309685122		9,0	309685128		18,0
85°	16	24	2,75	0,5	100	309785161		22,0	309785162		11,0	309785168		22,0
85°	20	30	3,0	0,5	100	309885201		27,0	309885202		13,0	309885208		27,0
85°	25	35	3,0	0,5	100	309985251		30,0	309985252		15,0	309985258		30,0
88°	6	14	0,4	0,5	100	308388061		16,0	308388062		8,0	308388068		16,0
88°	8	14	0,5	0,5	100	308488081		16,0	308488082		8,0	308488088		16,0
88°	10	18	0,6	0,5	100	308588101		18,0	308588102		9,0	308588108		18,0
88°	12	18	2,75	0,5	100	305588121		18,0	305588122		9,0	305588128		18,0
88°	16	24	2,75	0,5	100	305688161		22,0	305688162		11,0	305688168		22,0
88°	20	30	3,0	0,5	100	305788201		27,0	305788202		13,5	305788208		27,0
88°	25	35	3,0	0,5	100	305888251		30,0	305888252		15,0	305888258		30,0
90°	6	14	0,4	0,5	100	305090061		16,0	305090062		8,0	305090068		16,0
90°	8	14	0,5	0,5	100	305190081		16,0	305190082		8,0	305190088		16,0
90°	10	18	0,6	0,5	100	305290101		18,0	305290102		9,0	305290108		18,0
90°	12	18	0,8	0,5	100	305390121		18,0	305390122		9,0	305390128		18,0
90°	16	24	1,0	0,5	100	305490161		22,0	305490162		11,0	305490168		22,0

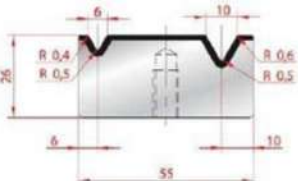
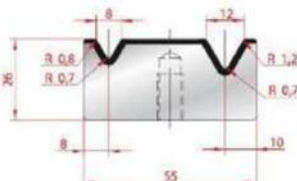
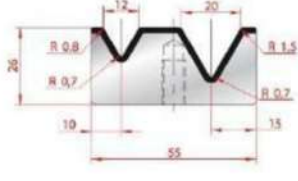
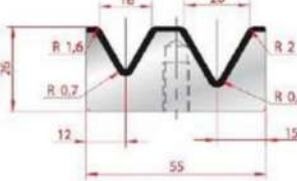
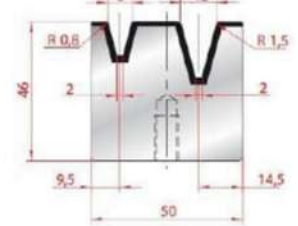
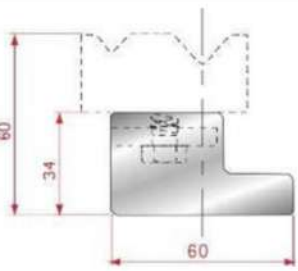
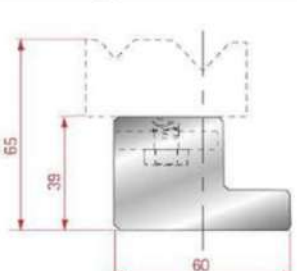
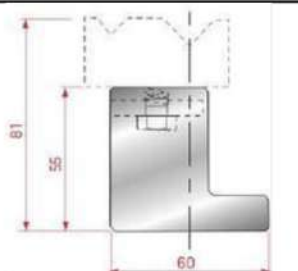
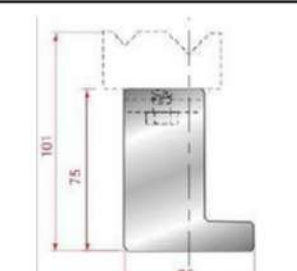


MATRICI 2V
C45
90° - 88°
2 V DIES

COD.		90° V 4 - 7 100 T/m	COD.		88° V 6 - 10 100 T/m
201090991	835 mm-Kg.9,0		204688991	835 mm-Kg.9,0	
201090992	415 mm-Kg. 4		204688992	415 mm-Kg. 4,5	
-	-		-	-	
COD.		90° V 6 - 10 100 T/m	COD.		88° V 8 - 12 100 T/m
201190991	835 mm-Kg.9,0		204188991	835 mm-Kg.9,0	
201090992	415 mm-Kg. 4		204188992	415 mm-Kg. 4,5	
-	-		-	-	
COD.		90° V 8 - 12 100 T/m	COD.		88° V 12 - 20 100 T/m
201290991	835 mm-Kg.9,0		201388991	835 mm-Kg.9,0	
201290992	415 mm-Kg. 4		201388992	415 mm-Kg. 4,5	
-	-		-	-	
			COD.		88° V 14 - 18 100 T/m
			203288991	835 mm-Kg.9,0	
	-		203288992	415 mm-Kg. 4,5	
	-		-	-	
			COD.		88° V 16 - 25 100 T/m
			201488991	835 mm-Kg.8,0	
			201488992	415 mm-Kg. 4	
			-	-	

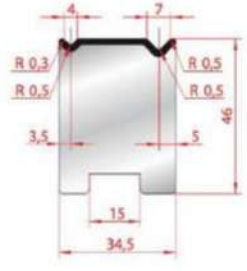
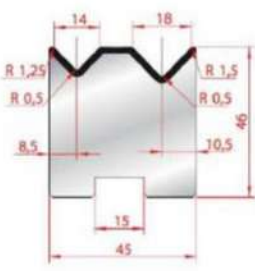
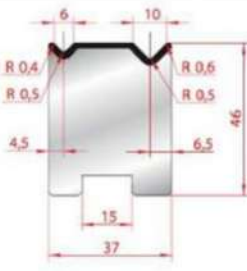
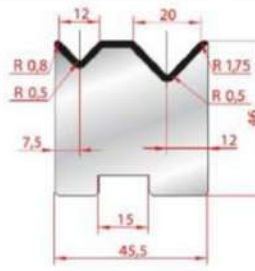
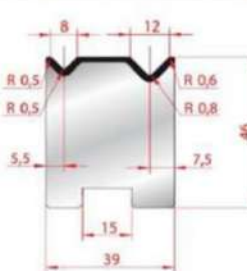
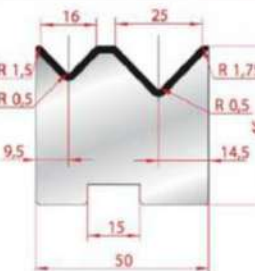
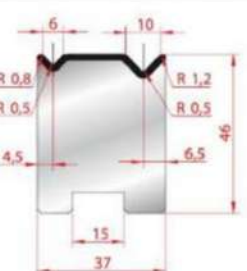
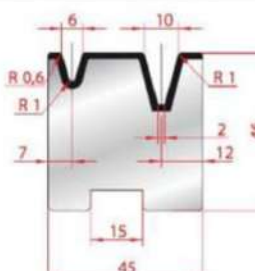
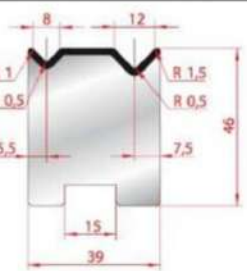
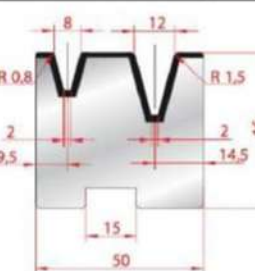


MATRICI 2V
C45
60° - 30°
2 V DIES

COD.		60° V 6 - 10 60 T/m			60° V 8 - 12 60 T/m
201560991	835 mm-Kg.8				
201560992	415 mm-Kg. 4				
-	-				
COD.		60° V 12 - 20 60 T/m	COD		60° V 16 - 20 60 T/m
203360991	835 mm-Kg.8				
203360992	415 mm-Kg. 4				
-	-				
COD.		30° V 8 - 12 40 T/M			
204730991	835 mm-Kg.13				
204730992	415 mm-Kg. 6,5				
-	-				
COD.		Supporto H=34	COD		Supporto H=39
20180341	835 mm - kg. 9				
20180342	415 mm - kg. 4,5				
-	-				
COD.		Supporto H=55	COD.		Supporto H=75
20190551	835 mm-Kg.15,0				
20190552	415 mm-Kg. 7,5				
-	-				



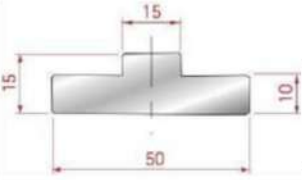
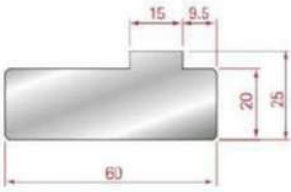
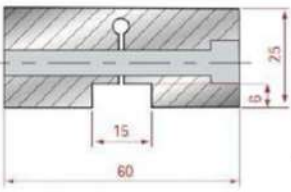
**MATRICI 2V
REVERSIBILI
C45**
**90° - 88° 30°
REVERSIBLE 2 V DIES**

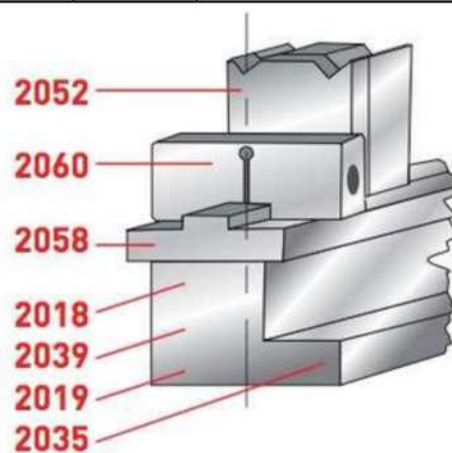
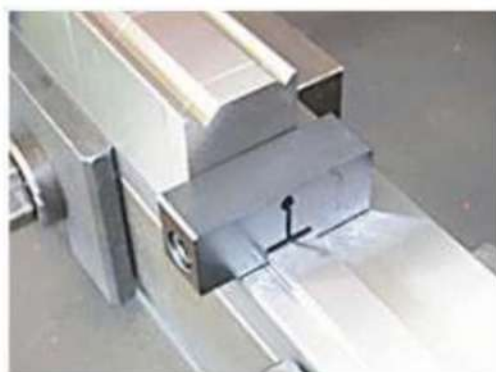
COD.	Price	90° V 4 - 7 80 T/m	COD.	Price	88° V 14 - 18 80 T/m
204890991 835 mm-Kg.9			205388991 835 mm-Kg.12		
204890992 415 mm-Kg. 4,5			205388992 415 mm-Kg. 6		
204890998 805F mm-Kg. 9			205388998 805F mm-Kg. 12		
COD.	Price	90° V 6 - 10 80 T/m	COD.	Price	88° V 12 - 20 80 T/m
204990991 835 mm-Kg.10			205488991 835 mm-Kg.12		
204990992 415 mm-Kg. 5			205488992 415 mm-Kg. 6		
204990998 805F mm-Kg. 10			205488998 805F mm-Kg. 12		
COD.	Price	90° V 8 - 12 80 T/m	COD.	Price	88° V 16 - 25 80 T/m
205190991 835 mm-Kg.11			205588991 835 mm-Kg.13		
205190992 415 mm-Kg. 5,5			205588992 415 mm-Kg. 6,5		
205190998 805F mm-Kg. 11			205588998 805F mm-Kg. 13		
COD.	Price	88° V 6 - 10 80 T/m	COD.	Price	30° V 6 - 10 40 T/m
205088991 835 mm-Kg.10			205730991 835 mm-Kg.13		
205088992 415 mm-Kg. 5,5			205730992 415 mm-Kg. 6,5		
205088998 805F mm-Kg. 10			205730998 805F mm-Kg. 13		
COD.	Price	88° V 8 - 12 80 T/m	COD.	Price	30° V 8 - 12 40 T/m
205288991 835 mm-Kg.11			205630991 835 mm-Kg.13		
205288992 415 mm-Kg. 5,5			205630992 415 mm-Kg. 6,5		
205288998 805F mm-Kg. 11			205630998 805F mm-Kg. 13		



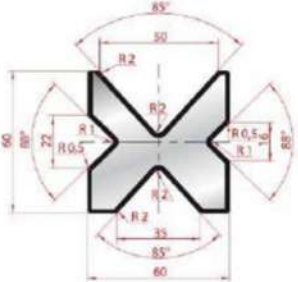
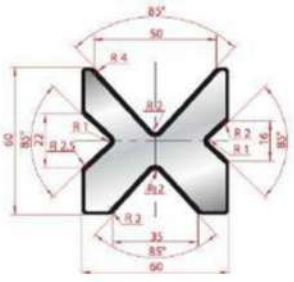
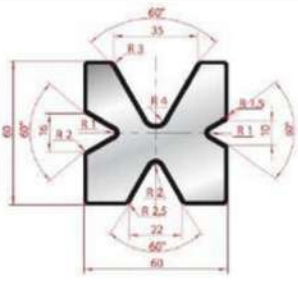
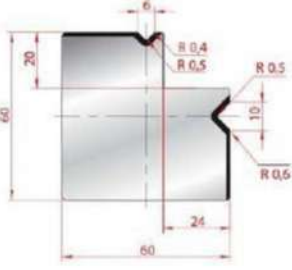
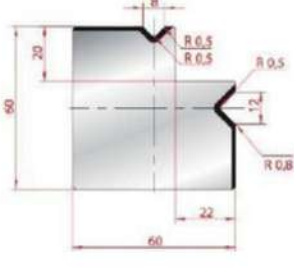
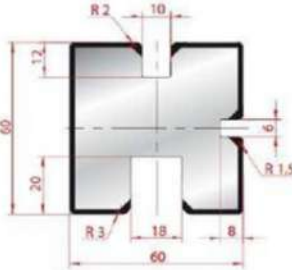
MATRICI 2V REVERSIBILI

REVERSIBLE 2 V DIES

COD.		SUPPORTO/HOLDER H=10	COD.		SUPPORTO/HOLDER
20580101	835 mm-Kg.4		20590201	835 mm-Kg.8	
20580101	415 mm-Kg. 2		20590202	415 mm-Kg. 4	
COD.		FERMO/FIXED BAR			
					
2060000					

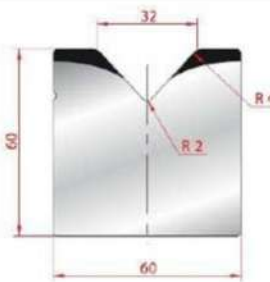
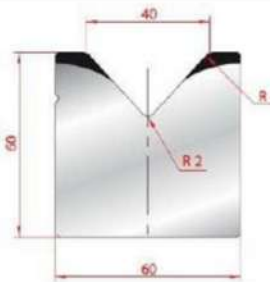
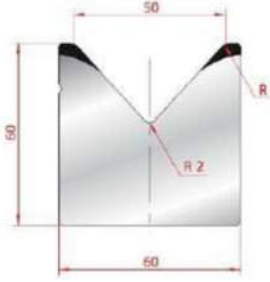
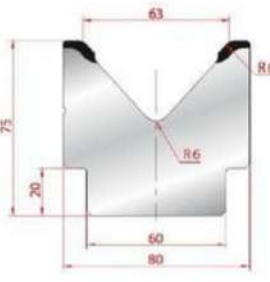
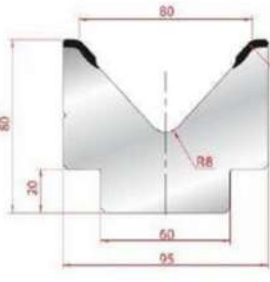
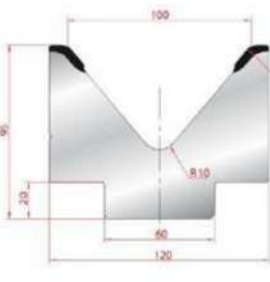
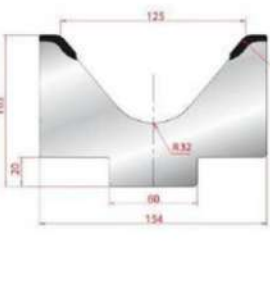
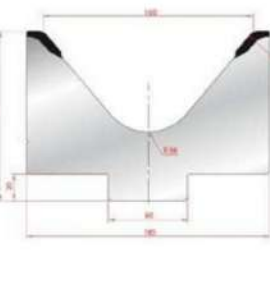
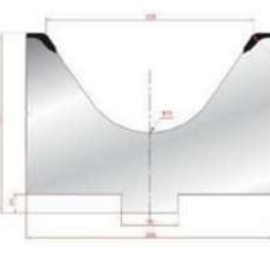


MATRICI 4V - 2V L - 3U**C45****4V - 2V L - 3U****DIES****85° 80 T/mt**

COD		85°-88° 80 T/mt	COD.		
203085991	835 mm-Kg.16		206785991	835 mm-Kg. 16	
203085992	415 mm-Kg. 8		206785992	415 mm-Kg.	
203085998	805F mm-Kg. 16		206785998	805F mm-Kg.	
COD.		60° 60 T/mt	COD.		
203460991	835 mm-Kg.18				
203460992	415 mm-Kg. 9				
206460998	805F mm-Kg. 18				
COD.		90° V6-V10 80 T/mt	COD.		90° V8-V12 80 T/mt
202890991	835 mm-Kg. 20		202990991	835 mm-Kg. 20	
202890992	415 mm-Kg. 10		202990992	415 mm-Kg. 10	
202890998	805F mm-Kg. 20		202990998	805F mm-Kg. 20	
COD.		3U 6-10-18 100 T/mt	COD.		
2031000U1	835 mm-Kg. 20				
2031000U2	415 mm-Kg. 10				
2031000U8	805F mm-Kg. 20				

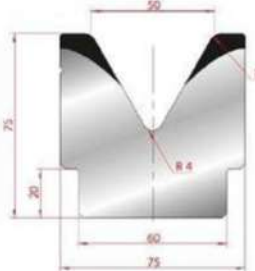
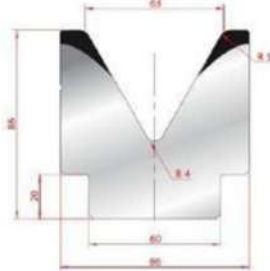
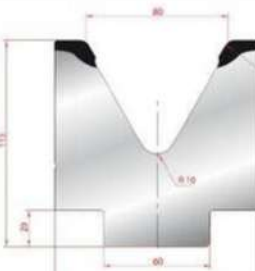
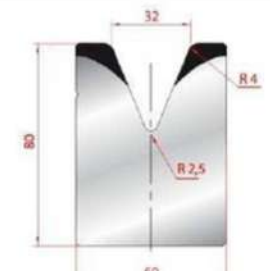
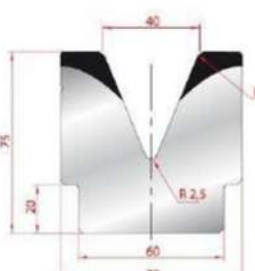
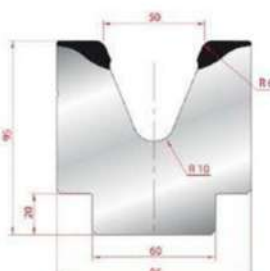
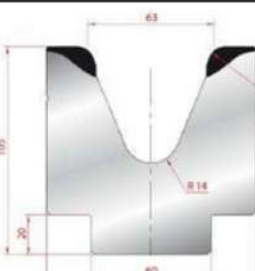
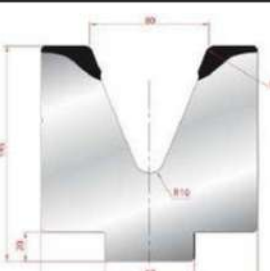
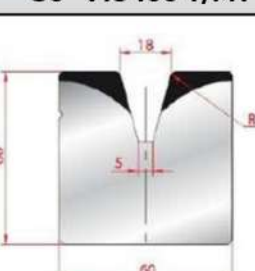
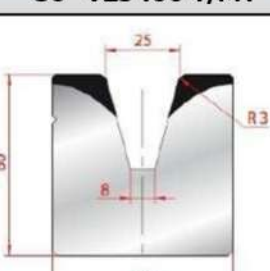


**MATRICI IVGRANDI
C45**
**85°-80°-70°
IV HEAVY DUTY DIES**

COD.		85° V32 100 T/MT	COD.		85° V40 100 T/MT	
202085321 835 mm-Kg. 22			202185401 835 mm-Kg. 21			
202085322 415 mm-Kg. 11			202185402 415 mm-Kg. 10			
202085328 805F - Kg. 22			202185408 805F - Kg. 21			
COD.		85° V50 80 T/MT	COD.		85° V63 100 T/MT	
202285501 835 mm-Kg. 19			202385631 835 mm-Kg. 28,5			
202285502 415 mm-Kg. 9,5			202385632 415 mm-Kg. 15			
202285508 805F - Kg. 19			202385638 805F - Kg. 28,5			
COD.		85° V80 100 T/MT	COD.		80° V100 100 T/MT	
202485801 835 mm-Kg. 38			202580001 835 mm-Kg. 50			
202485802 415 mm-Kg. 19			202580002 415 mm-Kg. 25			
202485808 805F - Kg. 38			202580008 805F - Kg. 50			
COD.		80° V125 120 T/MT	COD.		80° V160 120 T/MT	
202680951 835 mm-Kg. 70			202780961 835 mm-Kg. 91			
202680952 415 mm-Kg. 35			202780962 415 mm-Kg. 51			
202680958 805F - Kg. 70			202780968 805F - Kg. 91			
COD.		70° V220 200 T/MT	COD.			
729070976 505 mm-Kg. 119						
C45 - B						

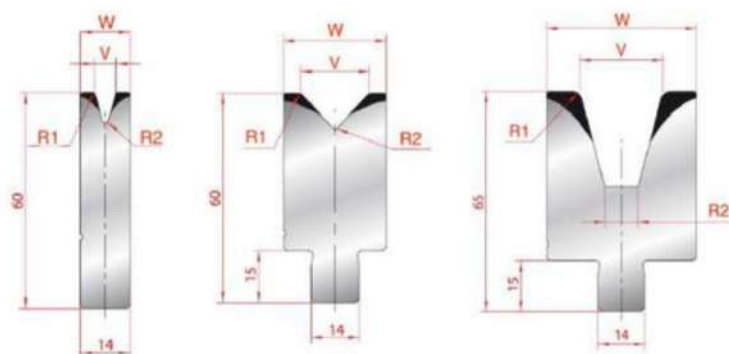


MATRICI IV GRANDI
C45
60°-45°-30°
IV HEAVY DUTY
DIES

COD.		60° V50 100 T/MT	COD.		60° V63 100 T/MT
208260501	835 mm-Kg. 28		208360631	835 mm-Kg. 34	
208260502	415 mm-Kg. 14		208360632	415 mm-Kg. 17	
208260508	805F - Kg. 28		208360638	805F - Kg. 34	
COD.		60° V80 100 T/MT	COD.		45° V32 100 T/MT
208960801	835 mm-Kg. 60		208845321	835 mm-Kg. 28	
208960802	415 mm-Kg. 30		208845322	415 mm-Kg. 14	
208960808	805F - Kg. 60		208845328	805F - Kg. 28	
COD.		45° V40 100 T/MT	COD.		45° V50 100 T/MT
208145401	835 mm-Kg. 33		211845501	835 mm-Kg. 34	
208145402	415 mm-Kg. 16		211845502	415 mm-Kg. 17	
208145408	805F - Kg. 33		211845508	805F - Kg. 34	
COD.		45° V63 100 T/MT	COD.		45° V80 100 T/MT
211745631	835 mm-Kg. 36		208445801	835 mm-Kg. 102	
211745632	415 mm-Kg. 18		208445802	415 mm-Kg. 51	
211745638	805F - Kg. 36		208445808	805F - Kg. 102	
COD.		30° V18 100 T/MT	COD.		30° V25 100 T/MT
208630181	835 mm-Kg. 22		208730251	835 mm-Kg. 23	
208630182	415 mm-Kg. 11		208730252	415 mm-Kg. 11	
208630188	805F - Kg. 22		208730258	805F - Kg. 23	



INSERTI MATRICE **C45** **DIE INSERT**



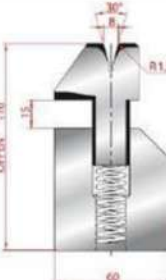
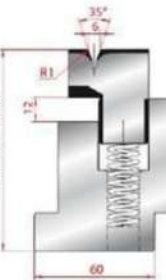
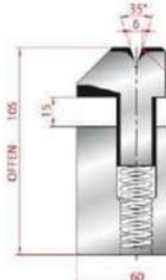
α	V	W	R1	R2	T/m	835 mm.			415 mm.			FRAZ / SECT.		
						Code	Price	KG.	Code	Price	KG.	Code	Price	KG.
30°	6	14	0,6	1	35	316630061		5,0	316630062		2,0	316630068		5,0
30°	8	18	0,8	2	35	316730081		6,0	316730082		3,0	316730088		6,0
30°	10	24	1,0	2	50	316830101		8,0	316830102		4,0	316830108		8,0
30°	12	24	1,5	2	50	316930121		7,0	316930122		3,0	316930128		7,0
30°	16	30	2,0	5	50	317030161		9,0	317030162		4,0	317030168		9,0
30°	20	35	2,5	5	55	317130201		9,0	317130202		4,0	317130208		9,0
30°	25	45	3,0	10	55	317230251		13,0	317230252		6,0	317230258		13,0
60°	6	14	0,6	0,7	100	319360061		5,4	319360062		2,7	319360068		5,4
60°	8	14	0,8	0,7	100	319460081		5,4	319460082		2,7	319460088		5,4
60°	10	18	1,0	0,7	100	319560101		6,4	319560102		3,2	319560108		6,4
60°	12	18	1,2	0,7	100	319660121		6,2	319660122		3,1	319660128		6,2
60°	16	24	1,6	0,7	100	319760161		7,7	319760162		3,9	319760168		7,7
60°	20	30	2,0	0,7	100	319860201		9,0	319860202		4,5	319860208		9,0
60°	25	35	2,5	0,7	100	319960251		10,0	319960252		5,0	319960258		10,0
88°	4	14	0,6	0,5	100	315888041		5,0	315888042		2,0	315888048		5,0
88°	6	14	0,8	0,5	100	315988061		5,0	315988062		2,0	315988068		5,0
88°	8	14	1,0	0,5	100	316088081		5,0	316088082		2,0	316088088		5,0
88°	10	18	1,2	0,5	100	316188101		6,0	316188102		3,0	316188108		6,0
88°	12	18	1,5	0,5	100	316288121		6,0	316288122		3,0	316288128		6,0
88°	16	24	2,0	0,5	100	316388161		8,0	316388162		4,0	316388168		8,0
88°	20	30	2,0	0,5	100	316488201		9,0	316488202		4,0	316488208		9,0
88°	25	35	3,0	0,5	100	316588251		10,0	316588252		5,0	316588258		10,0

COD.	Price	SUPPORTO/HOLDER	COD.	Price	SUPPORTO/HOLDER
31730001 835 mm-Kg. 17			SM000092 450 mm		
31730002 415 mm-Kg. 8,5			SM000091 1050 mm		

COD.	Price	SUPPORTO/HOLDER
SM000093 1050 mm		



PIEGASCHIACCIA FLATTENING-HEMMING TOOL

COD.		26° V10 100 T/MT	COD.		26° V12 100 T/MT
303826101	835 mm-Kg. 42		304026121	835 mm-Kg. 42	
303826102	415 mm-Kg. 21		304026122	415 mm-Kg. 21	
COD.		30° V8 80 T/MT	COD.		
304130081	835 mm-Kg. 34				
304130082	415 mm-Kg. 17				
COD.		35° V6 60 T/MT	COD.		35° V8 60 T/MT
303735061	835 mm-Kg. 34		303735081	835 mm-Kg. 34	
303735062	415 mm-Kg. 17		303735082	415 mm-Kg. 17	
COD.		35° V6 80 T/MT	COD.		
303935061	835 mm-Kg. 32				
303935062	415 mm-Kg. 16				

N.B. Le basi dei Piegaschiaccia sono in acciaio C45 B -

Note. The Hemming Tool lower parts are made in C45B Steel

Sheet Thickness Spessore foglio	Mild Steel/acciaio dolce (400N/mm ²)			Stainless Steel/Inox (600 N/mm ²)		
						
t [mm]	C [mm]	Tonnellaggio [Ton/m]	Tonnellaggio [Ton/m]	C [mm]	Tonnellaggio [Ton/m]	Tonnellaggio [Ton/m]
0,6	3	9	23	3	15	35
0,8	3	12	32	3	20	50
1	3,5	15	40	3,5	25	60
1,25	3,5	17	50	3,5	26	80
1,5	4,6	22	63	3,5	38	95
2	5,5	30	80	5,5	50	130
2,5	6,5	55	90	6,5	60	180
3	8	70	100	8	100	210



PIEGASCHIACCIA PNEUMATICI PNEUMATIC FLATTENING-HEMMING TOOL

COD.	V	A	R	H open/close	Max T/M		
						L=835	L=415
9MA3038PN...	10	26°	1,5	135/120	100		
9MA3039PN...	6	35°	1,3	105/90	80		
9MA3040PN...	12	26°	1,5	135/120	100		
9MA3041PN...	8	30°		110/90	80		



KIT PNEUMATICO COD. 43130000



Scelta coppia Matrice/Punzone e spessore lamiera **Die/Punch Hemming choose and sheet metal thickness**

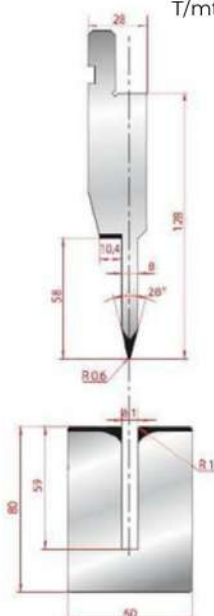
Spess. Massimo Max. Thickness	Matrice/Die	°	V	T/m t	Punzone/Punch	°	R	T/mt
15/10 - 25/10	303826101/2	26°	10	100	10332681/2	26°	P=1	100
15/10 - 30/10	304026121/2	26°	12	100				
15/10	304130081/2	30°	8	80	10553071/2	30°	0,5	50
10/10	303935061/2	35°	6	80	10343581/2	35°	0,8	70
10/10	303735061/2	35°	6	60	10473581/2	35°	0,8	70
12/10	303735081/2	35°	8	60		35°	0,7	70



PIEGASCHIACCIA FLATTENING-HEMMING TOOL

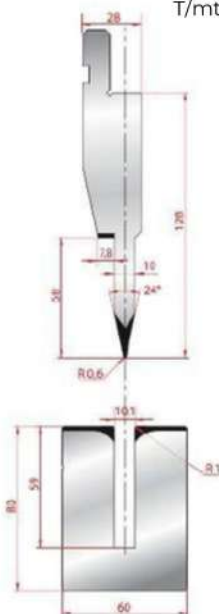
L	COD.	
835	11952861	
415	11952862	
805F	11952868	

max. 80
T/mt *



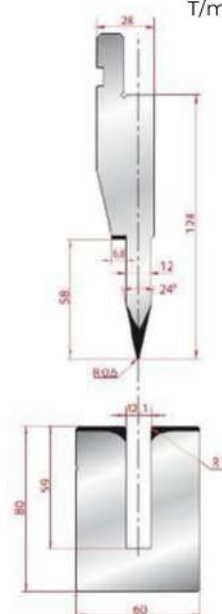
L	COD.	
835	11962461	
415	11962462	
805F	11962468	

max. 80
T/mt *



L	COD.	
835	11972461	
415	11972462	
805F	11972468	

max. 80
T/mt *



L	COD.	
835	31760U0U1	
415	31760U0U2	
805F	31760U0U8	

max. 50
T/mt *

L	COD.	
835	31770U0U1	
415	31770U0U2	
805F	31770U0U8	

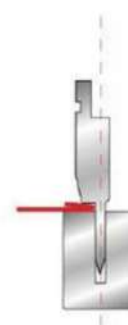
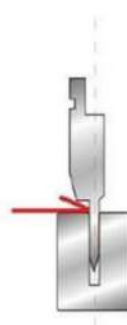
max. 50
T/mt *

L	COD.	
835	31780U0U1	
415	31780U0U2	
805F	31780U0U8	

max. 50
T/mt *

*in piegatura - per schiacciatura considerare 100 T/mt

*bending mode - in flattening mode use 100 T/mt



Tutti gli utensili sono costruiti in acciaio C45 B
All tools are made in C45 B Steel



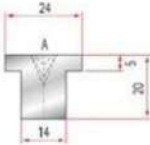
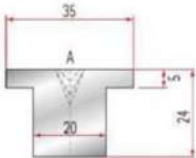
CONTENITORI MATRICI NYLON

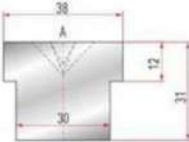
NYLON DIE HOLDER

COD.	Price	SUPPORTO/HOLDER	COD.	Price	SUPPORTO/HOLDER
2109001 835 mm			21100001 835 mm		
21090002 415 mm			21100002 415 mm		
-	-		-	-	
COD.	Price	SUPPORTO/HOLDER			
21110001 835 mm					
21110002 415 mm					
-	-				
COD.	Price	SUPPORTO/HOLDER H=50	COD.	Price	SUPPORTO/HOLDER H=95
21150001 835 mm			21160001 835 mm		
21150002 415 mm			21160002 415 mm		
-	-		-	-	

MATRICI NYLON

NYLON DIE

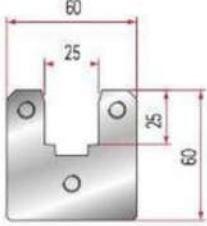
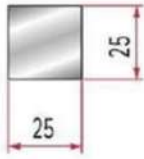
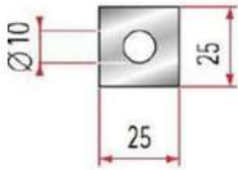
	<table><tr><th>A</th><th colspan="3">V</th></tr><tr><td>88°</td><td>6</td><td>8</td><td>10</td></tr><tr><td>60°</td><td>6</td><td>8</td><td>10</td></tr><tr><td>45°</td><td>6</td><td>8</td><td>10</td></tr><tr><td>30°</td><td>6</td><td>8</td><td></td></tr></table>	A	V			88°	6	8	10	60°	6	8	10	45°	6	8	10	30°	6	8			<table><tr><th>A</th><th colspan="5">V</th></tr><tr><td>88°</td><td>6</td><td>8</td><td>10</td><td>12</td><td>16</td></tr><tr><td>60°</td><td>6</td><td>8</td><td>10</td><td>12</td><td>16</td></tr><tr><td>45°</td><td>6</td><td>8</td><td>10</td><td>12</td><td></td></tr><tr><td>30°</td><td>6</td><td>8</td><td>10</td><td></td><td></td></tr></table>	A	V					88°	6	8	10	12	16	60°	6	8	10	12	16	45°	6	8	10	12		30°	6	8	10		
A	V																																																				
88°	6	8	10																																																		
60°	6	8	10																																																		
45°	6	8	10																																																		
30°	6	8																																																			
A	V																																																				
88°	6	8	10	12	16																																																
60°	6	8	10	12	16																																																
45°	6	8	10	12																																																	
30°	6	8	10																																																		
COD.	21120001		COD.	21130001																																																	
	21120002			21130002																																																	

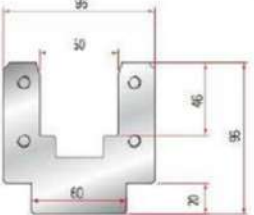
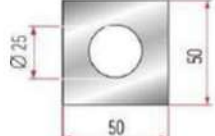
	<table><tr><th>A</th><th colspan="7">V</th></tr><tr><td>88°</td><td>6</td><td>8</td><td>10</td><td>12</td><td>16</td><td>20</td><td>25</td></tr><tr><td>60°</td><td>6</td><td>8</td><td>10</td><td>12</td><td>16</td><td>20</td><td></td></tr><tr><td>45°</td><td>6</td><td>8</td><td>10</td><td>12</td><td>16</td><td>20</td><td></td></tr><tr><td>30°</td><td>6</td><td>8</td><td>10</td><td>12</td><td>16</td><td></td><td></td></tr></table>	A	V							88°	6	8	10	12	16	20	25	60°	6	8	10	12	16	20		45°	6	8	10	12	16	20		30°	6	8	10	12	16			
A	V																																									
88°	6	8	10	12	16	20	25																																			
60°	6	8	10	12	16	20																																				
45°	6	8	10	12	16	20																																				
30°	6	8	10	12	16																																					
COD.	21140001																																									
	21140002																																									

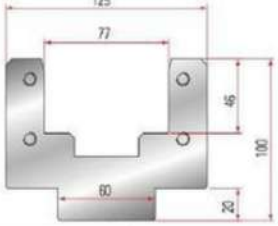
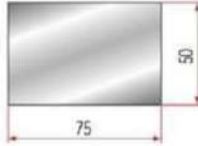
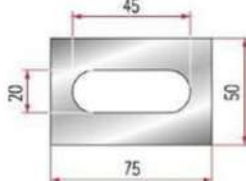


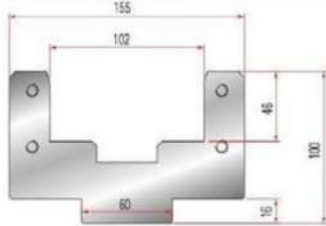
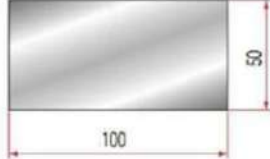
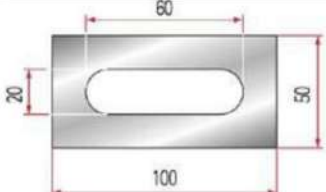
CONTENITORI - INSERTI POLIURETANO

HOLDERS - POLYURETHANE DIE

					
835	415	835	415	835	415
20360001	20360002	21010001	21010002	21050001	21050002

					
835	415	835	415	835	415
20370001	20370002	21020001	21020002	21060001	21060002

					
835	415	835	415	835	415
20380001	20380002	21030001	21030002	21070001	21070002

					
835	415	835	415	835	415
20400001	20400002	21040001	21040002	21080001	21080002

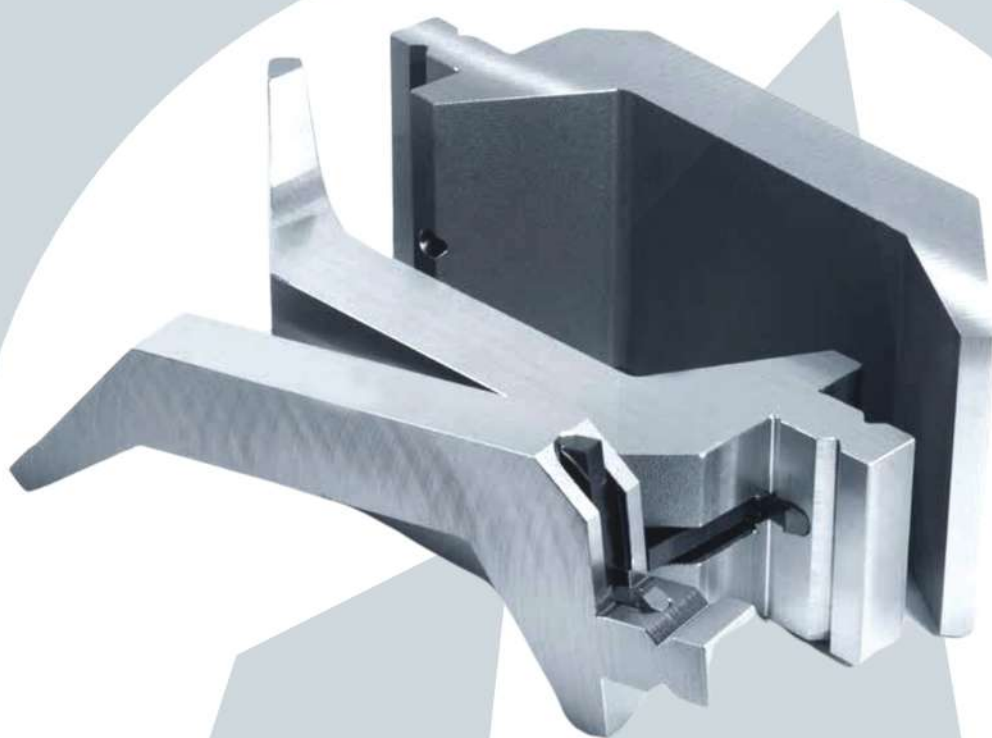


UTENSILI DI PIEGATURA | BENDING TOOLS

Utensili tipo / Style tools

Trumpf®

Wila®



USO DEL CATALOGO

Per una corretta consultazione tenere presente le seguenti indicazioni:

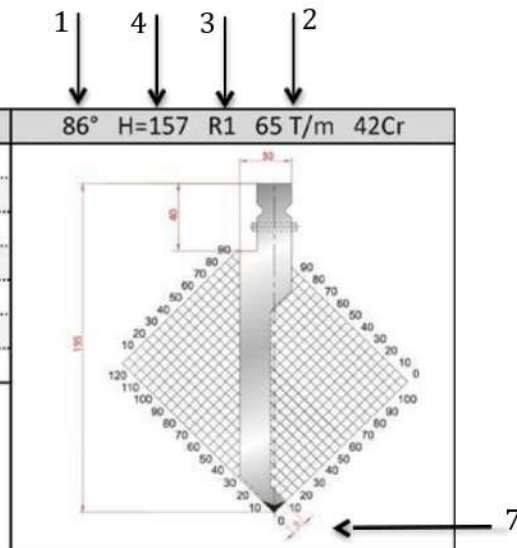
1. AMPIEZZA DELL'ANGOLO PUNZONE/MATRICE IN GRADI
2. PORTATA (Tonnellate x 1 metro)
3. RAGGIO DELLA PUNTA
4. ALTEZZA UTENSILE (PER IL CONTR. NUM.)
VARIA IN FUNZIONE DEL RAGGIO
5. CODICE PER L'ORDINAZIONE
6. LUNGHEZZA DELL'UTENSILE FRAZIONATO
7. SPESSORE DELLA PUNTA DEL PUNZONE(se presente)
8. PESO DELL'UTENSILE
9. RAGGIO SPALLA V MATRICE
10. AMPIEZZA DELLA V DELLA MATRICE
11. RAGGIO FONDO MATRICE
12. LARGHEZZA MATRICE
13. SCARPETTA DESTRA(R) O SINISTRA (L)

PUNZONI - PUNCH

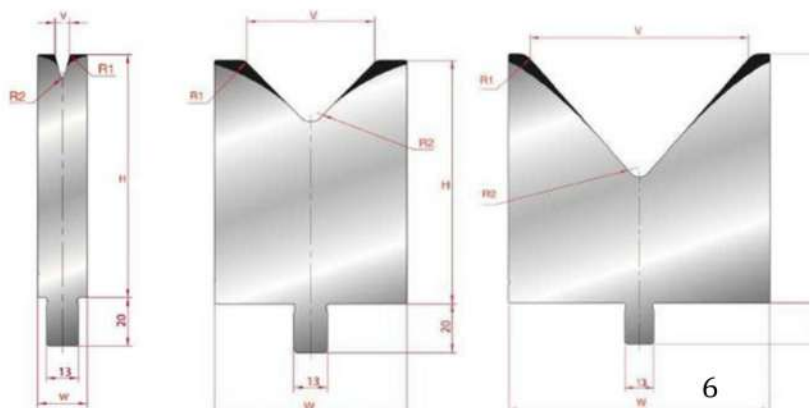
L	Kg	Cod.	Price
500	15	12358684	
300	9	12358686	
200	6	12358687	
100	3	12358689	
550 F	16,5	12358688	
H. R	3		
H. L	3		

13

H.R e H.L = scarpette Destre e Sinistre
H.R & H.L = Right and Left Horns



MATRICI - DIES



α	V	W	R1	R2	H	T/m	Cod e	L	Price	K g	Cod e	L	Price
								500				100	
								300				FR	

↑ 1 ↑ 10 ↑ 12 ↑ 9 ↑ 11 ↑ 2 ↑ 5 ↑ 6 ↑ 8



CATALOG USE

For a correct use please consider the following indication:

1. AMPLITUDE OF THE PUNCH/DIE ANGLE
2. TONNAGE (Tons for meter)
3. RADIUS OF THE EDGE
4. TOOL HEIGHT
5. ORDER CODE
6. LENGHT OF THE SECT. TOOL
7. THICKNESS OF THE PUNCH (if present)
8. TOOL WEIGHT
9. DIE V RADIUS
10. AMPLITUDE OF THE V DIE
11. RADIUS BOTTOM DIE
12. DIE WIDHT
13. RIGHT OR LEFT HORN

FRAZIONATURE STANDARD

- Questo tipo di utensili è utilizzabile sulle presse TRUMPF e per tutte le presse piegatrici che utilizzino attacco WILA.

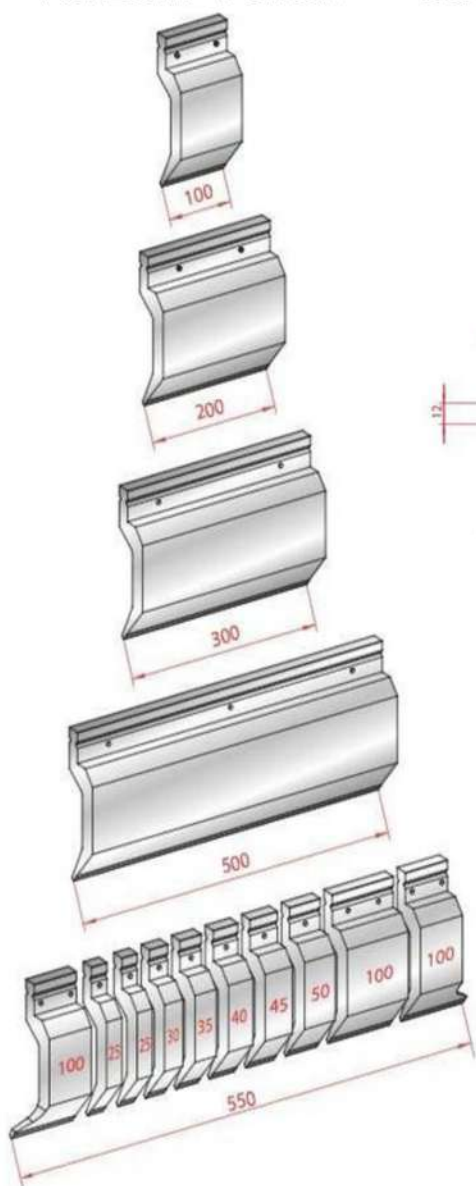
Le lunghezze standard degli utensili sono:
mm 500 – 300 – 200 – 100 - 550 FR

STANDARD SECTIONING

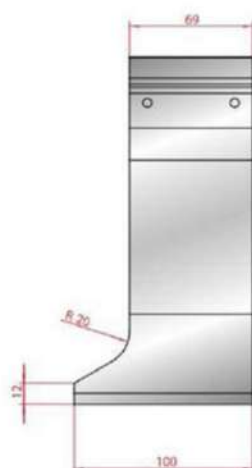
- These tools are suitable for TRUMPF press brake and for all Press Brake that use WILA Style clamp.

The standard length of the tools are:
mm 500 – 300 – 200 – 100 – 550 SEC

PUNZONI - PUNCH

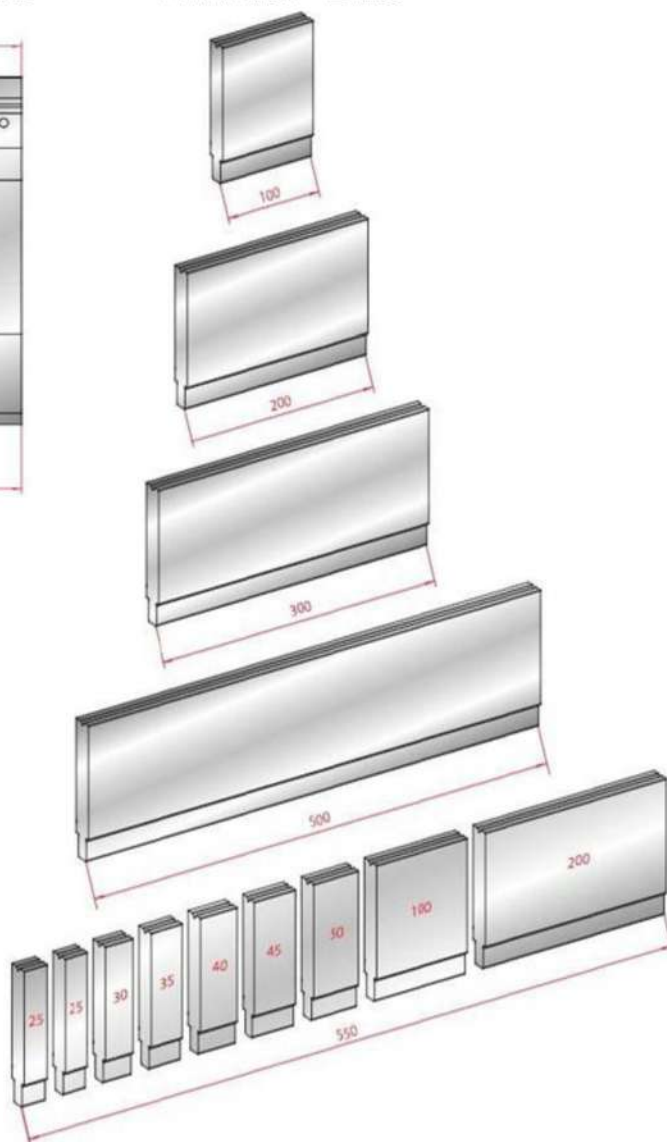


SCARPETTA STD



Standard
HORN

MATRICI - DIES



MODIFICHE A RICESTA

- Scarpette Speciali
- Frazionature speciali
- Modifiche a raggi e angoli
- Modifica stelo matrici

MODIFICATION REQUESTS

- Special Horns
- Special segmentation
- Radius and Angle modification
- Thin body for Dies



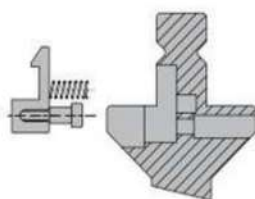
TABELLA LUNGHEZZE TAVOLA LENGHT TABLE CHART

PUNZONI - PUNCHES	FR	100	200	300	500	L	MATRICI - DIES	FR	100	200	300	500
1294 - 1303 1315	1	0	1	1	0	1050	3135 - 3222 - 3223 - 3224 3218-	1	1	2	0	0
Tutti gli altri -	1	1	2	0	0		3219-3220-3221-3132-3133-3134	1	2	0	1	0
Others	1	0	1	1	0		Tutti gli altri - Others	1	2	0	1	0
1294 - 1303 1315	1	0	2	1	0	1250	3135 - 3222 - 3223 - 3224 3218-	1	3	2	0	0
Tutti gli altri -	1	1	3	0	0		3219-3220-3221-3132-3133-3134	1	2	1	1	0
Others	1	0	2	1	0		Tutti gli altri - Others	1	2	1	1	0
1294 - 1303 1315	1	0	3	3	0	2050	3135 - 3222 - 3223 - 3224 3218-	1	5	5	0	0
Tutti gli altri -	1	1	7	0	0		3219-3220-3221-3132-3133-3134	1	2	2	3	0
Others	1	0	1	1	2		Tutti gli altri - Others	1	2	0	1	2
1294 - 1303 1315	1	0	4	4	0	2550	3135 - 3222 - 3223 - 3224 3218-	1	6	7	0	0
Tutti gli altri -	1	0	10	0	0		3219-3220-3221-3132-3133-3134	1	2	3	4	0
Others	1	0	1	1	3		Tutti gli altri - Others	1	2	0	1	3
1294 - 1303 1315	1	0	5	5	0	3050	3135 - 3222 - 3223 - 3224 3218-	1	7	9	0	0
Tutti gli altri -	1	1	12	0	0		3219-3220-3221-3132-3133-3134	1	2	4	5	0
Others	1	0	1	1	4		Tutti gli altri - Others	1	2	0	1	4
1294 - 1303 1315	1	0	7	7	0	4050	3135 - 3222 - 3223 - 3224 3218-	1	9	13	0	0
Tutti gli altri -	1	1	17	0	0		3219-3220-3221-3132-3133-3134	1	2	6	7	0
Others	1	0	1	1	6		Tutti gli altri - Others	1	2	0	1	6

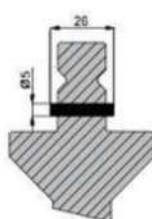
PUNZONI - PUNCHES

- I punzoni con peso superiore a 13,5 Kg sono forniti con FIXED PIN; punzoni con peso inferiore a 13,5 kg possono essere forniti con sistema SAFETY BUTTON.
- Punches with weight superior to 13,5 Kg are supplied with FIXED PIN; punches with weight inferior to 13,5 kg could be supplied with SAFETY BUTTON system.

SAFETY BUTTON

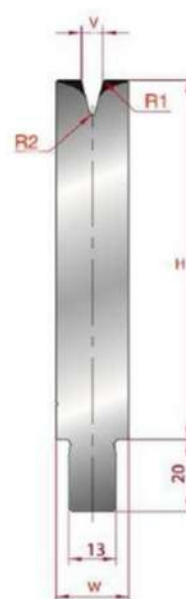


FIXED PIN



MATRICI - DIES

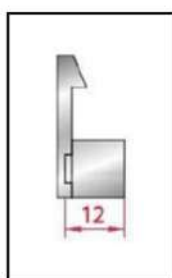
- Le matrici possono essere fornite con altezza H=100 oppure H=150
- Dies height could be ordered with H=100 or H=150





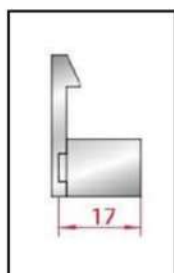
Cod.
82110000

Punzone-Punch
1237 - 1240



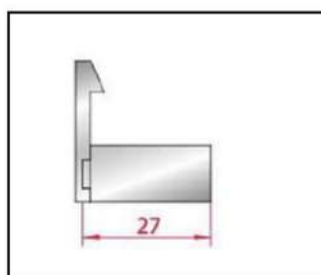
Cod.
82180000

Punzone-Punch
1238 - 1249 1250 -
1251 1313



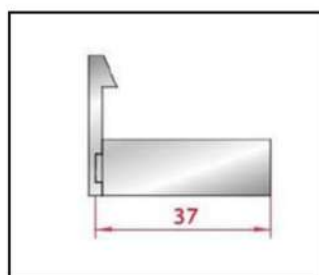
Cod.
82120000

Punzone-Punch
1234 - 1235



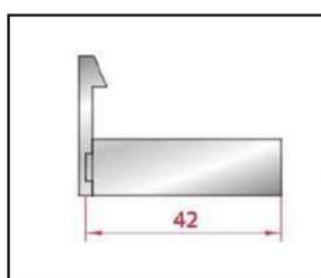
Cod.
82130000

Punzone-Punch
1295 - 1302 1303 -
1308 4361



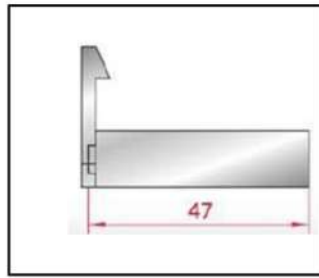
Cod.
82140000

Punzone-Punch
1233 - 1314



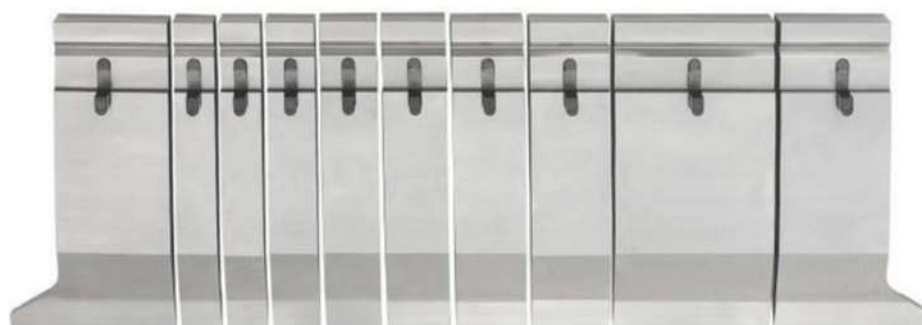
Cod.
82150000

Punzone-Punch
1236



Cod.
82160000

Punzone-Punch
1294





UTENSILI DI PIEGATURA | BENDING TOOLS

Punzoni / Punches

Trumpf®

Wila®



PUNZONI 86°

86°PUNCHES

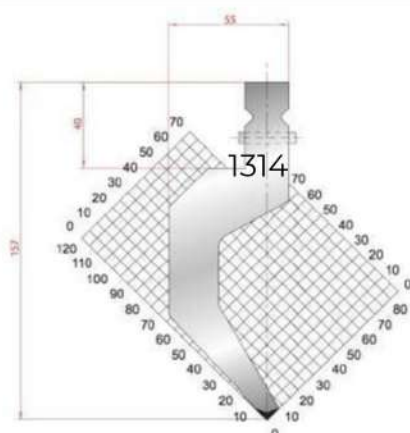
FIXED PIN

L	Kg	Cod.	
500	15	13148614	
300	9	13148616	
200	6	13148617	
100	3	13148619	
550 F	16,5	13148618	
H. R	3	1314861R	
H. L	3	1314861L	

SAFETY BUTTON

Cod.	
-	-
13148616-S	
13148617-S	
13148619-S	
13148618-S	
1314861R-S	
1314861I -S	

86° H=157 R1 65 T/m 42Cr



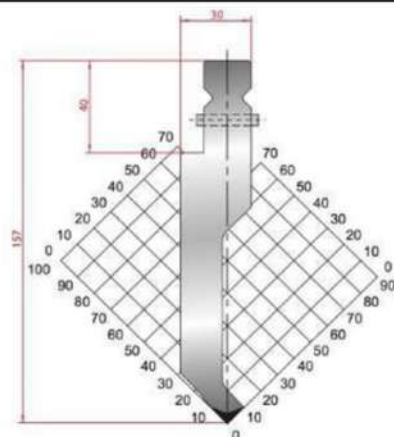
FIXED PIN

L	Kg	Cod	
500	12,1	13178614	
300	7,3	13178616	
200	4,9	13178617	
100	2,4	13178619	
550 F	13,3	13178618	
H. R	2,4	317861R	
H. L	2,4	317861L	

SAFETY BUTTON

Cod.	
13178614-S	
13178616-S	
13178617-S	
13178619-S	
13178618-S	
1317861R-S	
1317861L-S	

86° H=157 R1 100 T/m 42Cr



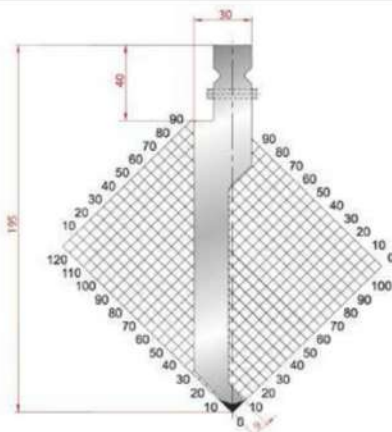
FIXED PIN

I	Kg	Cod.	
500	15	12358684	
300	9	12358686	
200	6	12358687	
100	3	12358689	
550 F	16,5	12358688	
H. R	3	1235868R	
H. L	3	1235868L	

SAFETY BUTTON

Cod.	
-	
12358686-S	
12358687-S	
12358689-S	
12358688-S	
1235868R-S	
1235868L-S	

86 ° H=195 R0,8 100 T/m 42Cr



PUNZONI 86° 86°PUNCHES

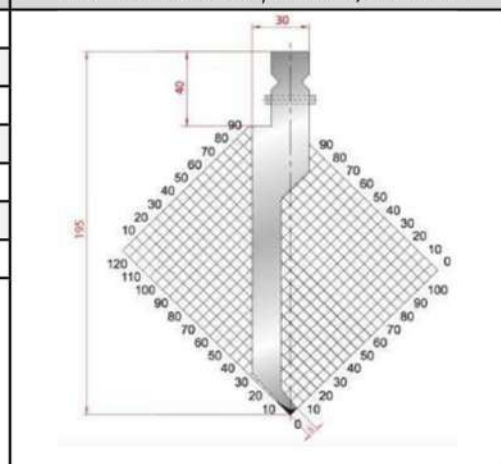
FIXED PIN

L	Kg	Cod.	
500	14,5	12348664	
300	8,7	12348666	
200	5,8	12348667	
100	2,9	12348669	
550 F	16	12348668	
H. R	2,9	1234866R	
H. L	2,9	1234866L	

SAFETY BUTTON

Cod.	
-	-
12348666-S	
12348667-S	
12348669-S	
12348668-S	
1234866R-S	
1234866L-S	

86° H=195 R0,6 30 T/m 42Cr



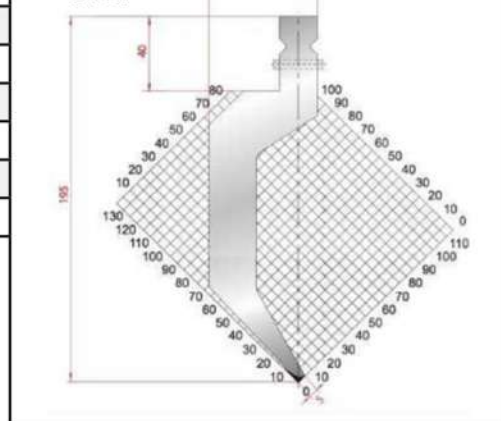
FIXED PIN

L	Kg	Cod.	
500	18,4	12338684	
300	11	12338686	
200	7,4	12338687	
100	3,7	12338689	
50	18,1	12338688	
HFR	2,6	1233868R	
H. L	2,6	1233868L	

SAFETY BUTTON

Cod.	Price
-	-
12338686-S	
12338687-S	
12338689-S	
12338688-S	
1233868R-S	
1233868L-S	

86° H=195 R0,8 40 T/m 42Cr



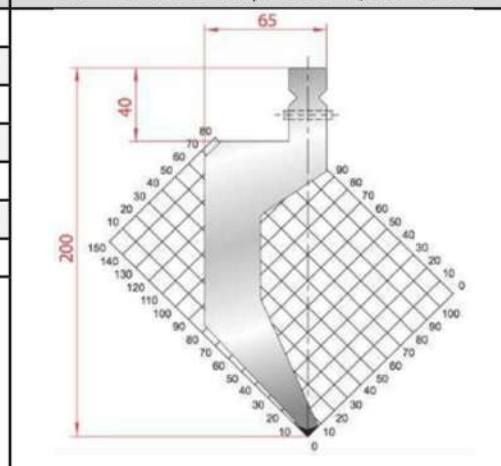
FIXED PIN

L	Kg	Cod.	Price
500	15,4	13208694	
300	9,3	13208696	
200	6,2	13208697	
100	3,1	13208699	
550 F	17	13208698	
H. R	3,1	1320869R	
H. L	3,1	1320869L	

SAFETY BUTTON

Cod.	Price
-	-
13208696-S	
13208697-S	
13208699-S	
13208698-S	
1320869R-S	
1320869L-S	

86° H=200 R1,5 100 T/m 42Cr

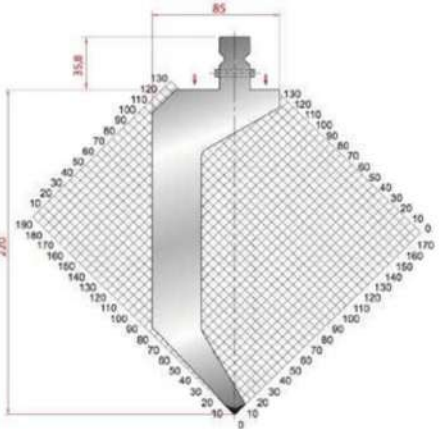


PUNZONI 86° - 80°**86°-80° PUNCHES**

FIXED PIN

L	Kg	Cod.	
500	33,6	12948614	
300	20,1	12948616	
200	13,4	12948617	
100	6,7	12948619	
550 F	29,6	12948618	
H. R	4,7	1294861R	
H. L	4,7	1294861L	

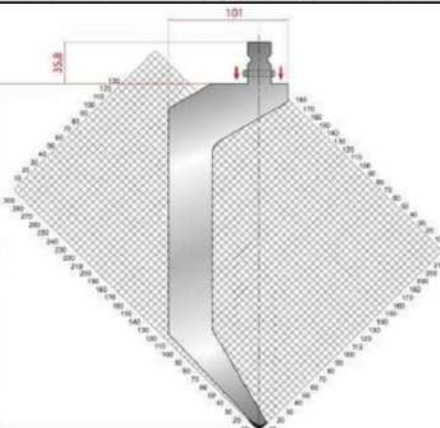
SAFETY BUTTON

Cod.		86° H=220 R1 85 T/m 42Cr
-	-	
-	-	
12948617-S		
12948619-S		
12948618-S		
1294861R-S		
1294861L-S		

FIXED PIN

L	Kg	Cod.	
500	-	-	
300	-	-	-
200	19,6	13158617	
100	9,8	13158619	
550 F	49,6	13158618	
H. R	9,8	1315861R	
H. L	9,8	1315861L	

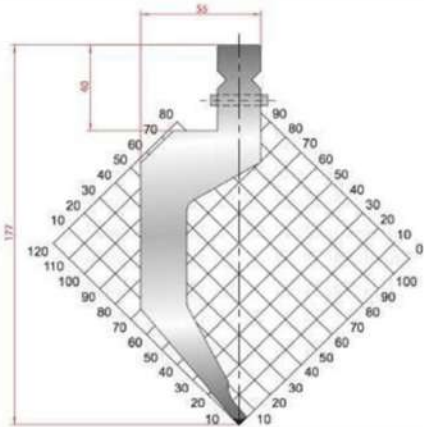
SAFETY BUTTON

Cod.		86° H=300 R1 80 T/m 42Cr
-	-	
-	-	
-	-	
13158619-S		
13158618-S		
1315861R-S		
1315861L-S		

FIXED PIN

L	Kg	Cod.	Price
500	15,4	13198074	
300	9,3	13198076	
200	6,2	13198077	
100	3,1	13198079	
550 F	17	13198078	
H. R	3,1	1319807R	
H. L	3,1	1319807L	

SAFETY BUTTON

Cod.	Price	80° H=177 R0,5 20 T/m 42Cr
-	-	
13198076-S		
13198077-S		
13198079-S		
13198078-S		
1319807R-S		
1319807L-S		



PUNZONI 60° 60° PUNCHES

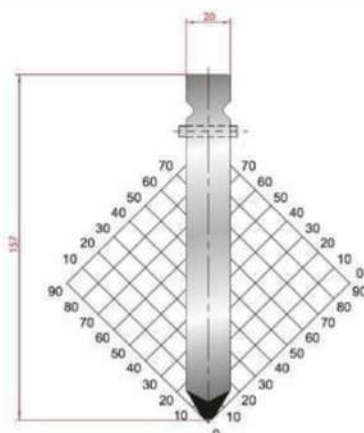
FIXED PIN

L	Kg	Cod.	Price
500	13,5	131860C4	
300	8,1	131860C6	
200	5,4	131860C7	
100	2,7	131860C9	
550 F	14,9	131860C8	
H. R	2,7	131860CR	
H. L	2,7	131860CL	

SAFETY BUTTON

Cod.	
131860C4-S	
131860C6-S	
131860C7-S	
131860C9-S	
131860C8-S	
131860CR-S	
131860CL-S	

60° H=157 R 4 100 T/m 42Cr



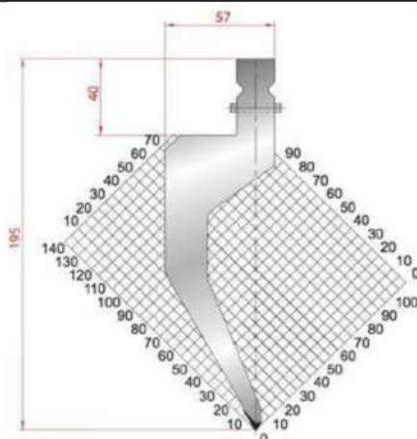
FIXED PIN

L	Kg	Cod.	Price
500	17,5	12366084	
300	10,6	12366086	
200	7	12366087	
100	3,5	12366089	
550 F	19,3	12366088	
H. R	3,5	1236608R	
H. L	3,5	1236608L	

SAFETY BUTTON

Cod.	
-	-
12366086-S	
12366087-S	
12366089-S	
12366088-S	
1236608R-S	
1236608L-S	

60° H=195 R 0,8 40 T/m 42Cr



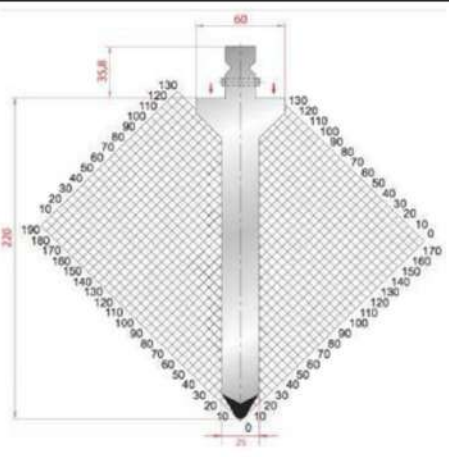
FIXED PIN

L	Kg	Cod.	
500	26	130360C4	
300	15,6	130360C6	
200	10,4	130360C7	
100	5,2	130360C9	
550 F	26,4	130360C8	
H. R	5,2	130360CR	
H. L	5,2	130360CL	

SAFETY BUTTON

Cod.	
-	-
-	-
130360C7-S	
130360C9-S	
130360C8-S	
130360CR-S	
130360CL-S	

60° H=220 R 4 100 T/m 42Cr



PUNZONI 28° 28° PUNCHES

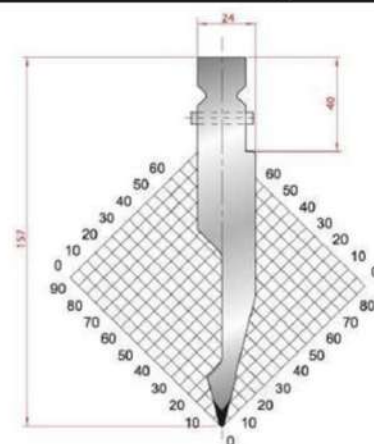
FIXED PIN

L	Kg	Cod.	
500	10	13132814	
300	6	13132816	
200	4	13132817	
100	2	13132819	
550 F	11	13132818	
H. R	1,7	1313281R	
H. L	1,7	1313281L	

SAFETY BUTTON

Cod.	
13132814-S	
13132816-S	
13132817-S	
13132819-S	
13132818-S	
1313281R-S	
1313281L-S	

28° H=157 R 1 80 T/m 42Cr



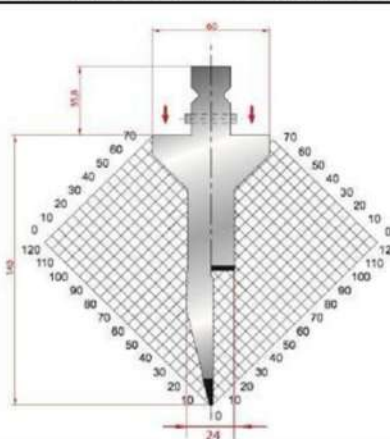
FIXED PIN

L	Kg	Cod.	
500	14,4	13082814	
300	8,7	13082816	
200	5,8	13082817	
100	2,9	13082819	
550 F	14,1	13082818	
H. R	2	1308281R	
H. L	2	1308281L	

SAFETY BUTTON

Cod.	
-	-
13082816-S	
13082817-S	
13082819-S	
13082818-S	
1308281R-S	
1308281L-S	

28° H=140 R 1 40 T/m 42Cr



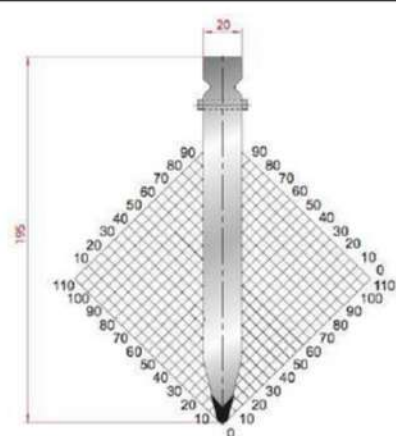
FIXED PIN

L	Kg	Cod.	
500	14	12372834	
300	8,4	12372836	
200	5,6	12372837	
100	2,8	12372839	
550 F	15,4	12372838	
H. R	2,2	1237283R	
H. L	2,2	1237283L	

SAFETY BUTTON

Cod.	
-	-
12372836-S	
12372837-S	
12372839-S	
12372838-S	
1237283R-S	
1237283L-S	

28° H=195 R 3 100 T/m 42Cr



PUNZONI 28° 28° PUNCHES

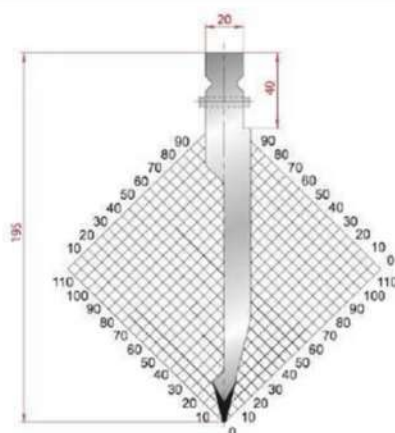
FIXED

L	Kg	PIN Cod.	
500	11,5	12382814	
300	6,9	12382816	
200	4,6	12382817	
100	2,3	12382819	
550 F	12,7	12382818	
H. R	2	1238281R	
H. L	2	1238281L	

SAFETY BUTTON

Cod.	
12382814-S	
12382816-S	
12382817-S	
12382819-S	
12382818-S	
1238281R-S	
1238281L-S	

28° H=195 R 1 80 T/m 42Cr



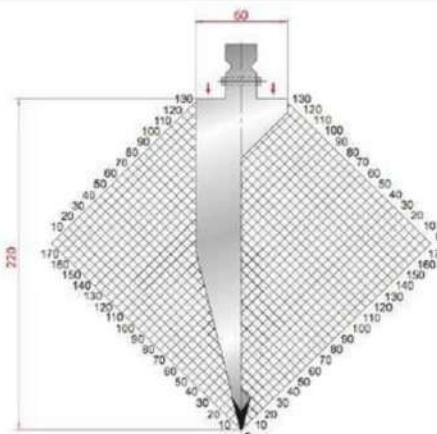
FIXED PIN

L	Kg	Cod.	
500	25	13022814	
300	15	13022816	
200	10	13022817	
100	5	13022819	
550 F	27,5	13022818	
H. R	4,2	1302281R	
H. L	4,2	1302281L	

SAFETY BUTTON

Cod.	
	-
	-
13022817-S	
13022819-S	
13022818-S	
1302281R-S	
1302281L-S	

28° H=220 R 1 80 T/m 42Cr



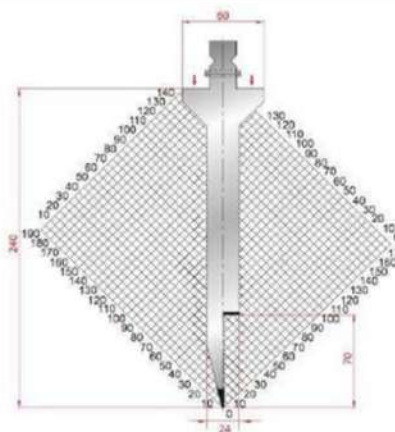
FIXED PIN

L	Kg	Cod.	
500	23,8	12952814	
300	14,3	12952816	
200	9,5	12952817	
100	4,8	12952819	
550 F	23,8	12952818	
H. R	4,2	1295281R	
H. L	4,2	1295281L	

SAFETY BUTTON

Cod.	
	-
- -	-
12952817-S	
12952819-S	
12952818-S	
1295281R-S	
1295281L-S	

28° H=240 R 1 40 T/m 42Cr

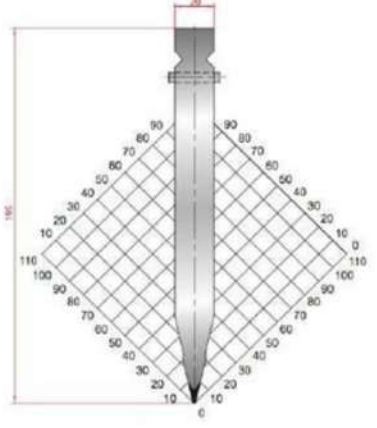


PUNZONI 26°**26° PUNCHES**

FIXED PIN

L	Kg	Cod.	
500	13,5	13162684	
300	8,1	13162686	
200	5,4	13162687	
100	2,7	13162689	
550 F	14,9	13162688	
H. R	2,7	1316268R	
H. L	2,7	1316268L	

SAFETY BUTTON

Cod.		26° H=195 R 0,8 100 T/m 42Cr
13162684-S		
13162686-S		
13162687-S		
13162689-S		
13162688-S		
1316268R-S		
1316268L-S		





UTENSILI DI PIEGATURA | BENDING TOOLS

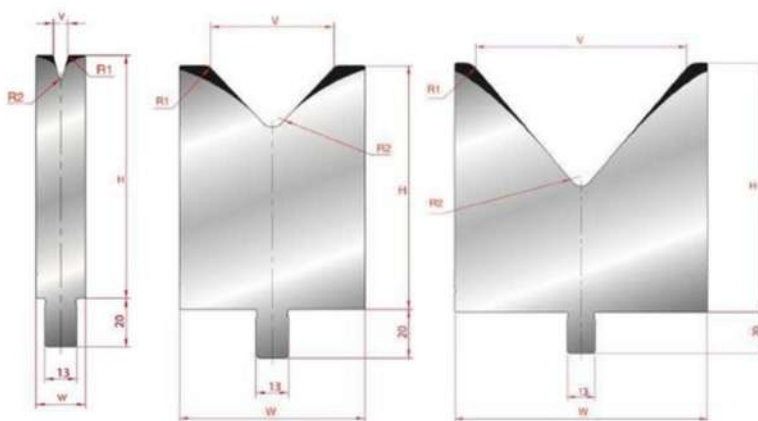
Matrici / Dies

Trumpf®

Wila®



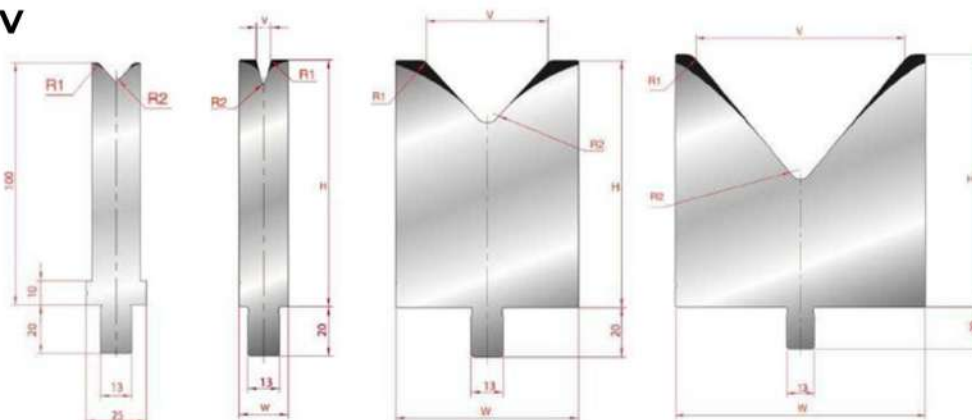
MATRICI IV
IV DIE
C45
86°-80°-30°
H=100



α	V	W	R1	R2	H	T/m	Code	L	Kg	Code	L	Kg
86	6	20	0,6	0,5	100	100	312386064	500	9,0	312386069	100	1,8
							312386066	300	5,4	312386068	FR	9,0
86	8	20	0,8	0,5	100	100	312486084	500	8,8	312486089	100	1,8
							312486086	300	5,3	312486088	FR	9,7
86	10	20	1,0	0,5	100	100	312586104	500	9,0	312586109	100	1,8
							312586106	300	5,4	312586108	FR	9,0
86	12	25	1,0	0,5	100	100	312686124	500	10,6	312676129	100	2,1
							312686126	300	6,4	312686128	FR	11,7
86	16	30	1,6	0,5	100	100	312786164	500	12,0	312786169	100	2,4
							312786166	300	7,8	312786168	FR	12,0
86	20	30	2,0	0,5	100	100	312886204	500	12,0	312886209	100	2,4
							312886206	300	7,8	312886208	FR	12,0
86	24	35	2,5	0,5	100	100	312986244	500	14,0	312986249	100	2,8
							312986246	300	8,4	312986248	FR	14,0
86	30	45	3,0	3,0	100	100	313086304	500	18,0	313086309	100	3,6
							313086306	300	10,8	313086308	FR	18,0
86	40	55	3,0	3,0	100	100	313186404	500	21,0	313186409	100	4,2
							313186406	300	12,6	313186408	FR	21,0
86	50	75	3,0	3,0	100	100	313286504	500	28,0	313286509	100	5,6
							313286506	300	16,8	313286508	FR	28,0
80	60	75	5,0	5,0	100	100	313380604	500	26,0	313380609	100	5,2
							313380606	300	15,6	313380608	FR	26,0
80	80	100	5,0	8,0	100	100	313480804	500	32,0	313480809	100	6,4
							313480806	300	19,2	313480808	FR	32,0
80	100	120	8,0	10,0	100	100	313580944	500	44,9	313580949	100	9,0
							313580946	300	26,9	313580948	FR	49,3
30	6	20	0,6	1,0	100	50	313630064	500	8,7	313630069	100	1,7
							313630066	300	5,2	313630068	FR	9,6
30	8	20	1,0	2,0	100	40	313730084	500	9,0	313730089	100	1,8
							313730086	300	5,4	313730088	FR	9,0
30	10	20	1,0	2,0	100	40	313830104	500	9,0	313830109	100	1,8
							313830106	300	5,4	313830108	FR	9,0
30	12	25	1,0	2,0	100	50	313930124	500	10,0	313930129	100	2,0
							313930126	300	6,0	313930128	FR	10,0
30	16	30	1,6	5,0	100	45	314030164	500	12,0	314030169	100	2,4
							314030166	300	7,2	314030168	FR	13,2
30	20	35	2,0	5,0	100	50	314130204	500	13,0	314130209	100	2,6
							314130206	300	7,8	314130208	FR	14,3
30	24	40	2,5	5,0	100	50	314230244	500	15,0	314230249	100	3,0
							314230246	300	9,0	314230248	FR	15,0



MATRICI IV**IV DIE
42Cr****86°-84°****H=100**

3244


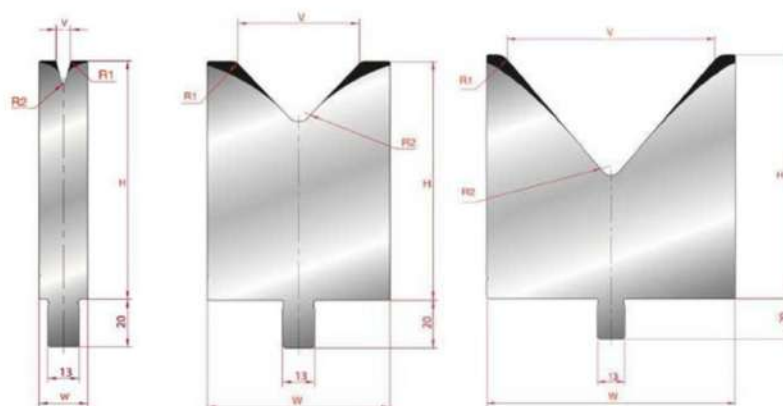
α	V	W	R1	R2	H	T/m	Code	L		Kg	Code	L		Kg
86	6	20	0,6	0,6	100	100	320086064	500		9,0	320086069	100		1,8
							320086066	300		5,4	320086068	FR		9,9
86	8	20	0,8	0,8	100	100	320186084	500		9,0	320186089	100		1,8
							320186086	300		5,4	320186088	FR		9,9
86	10	20	1,0	1,0	100	100	320286104	500		9,0	320286109	100		1,8
							320286106	300		5,4	320286108	FR		9,9
86	12	25	1,0	1,0	100	100	320386124	500		10,5	320386129	100		2,0
							320386126	300		6,3	320386128	FR		11,6
86	16	30	1,6	1,6	100	100	320486164	500		12,5	320486169	100		2,5
							320486166	300		7,5	320486168	FR		13,7
86	20	30	2,0	2,0	100	100	320586204	500		12,5	320586209	100		2,5
							320586206	300		7,5	320586208	FR		13,8
86	24	35	2,5	2,5	100	100	321586244	500		14,0	321586249	100		2,8
							321586246	300		8,4	321586248	FR		15,4
86	30	45	3,0	3,0	100	100	321686304	500		17,6	321686309	100		3,5
							321686306	300		10,6	321686308	FR		19,4
86	40	55	3,0	3,0	100	120	321786404	500		20,0	321786409	100		4,0
							321786406	300		12,0	321786408	FR		22,0
86	50	75	3,0	5,0	100	150	321886504	500		27,5	321886509	100		5,5
							321886506	300		16,5	321886508	FR		30,3
84	6	20	0,6	0,6	100	130	322584064	500		8,8	322584069	100		1,8
							322584066	300		5,3	322584068	FR		9,7
84	8	20	0,8	0,8	100	100	322684084	500		8,8	322684089	100		1,8
							322684086	300		5,3	322684088	FR		9,7
84	10	20	1,0	1,0	100	100	322784104	500		8,8	322784109	100		1,8
							322784106	300		5,3	322784108	FR		9,7
84	12	25	1,0	1,0	100	100	322884124	500		10,5	322884129	100		2,0
							322884126	300		6,3	322884128	FR		11,6
84	14	20	1,6	1,6	100	90	324484144	500		8,8	324484149	100		1,8
							324484146	300		5,3	324484148	FR		9,7
84	16	30	1,6	1,6	100	100	322984164	500		12,5	322984169	100		2,5
							322984166	300		7,5	322984168	FR		13,8
84	20	30	2,0	2,0	100	100	323084204	500		12,5	323084209	100		2,5
							323084206	300		7,5	323084208	FR		13,8
							N.B. cod. 3244xxxx esecuzione speciale.Vedi indicazione							
							N.B. cod. 3244xxxx special execution. See note							



MATRICI 1V

1V DIE 42Cr
80°-60°

H=100 H=120

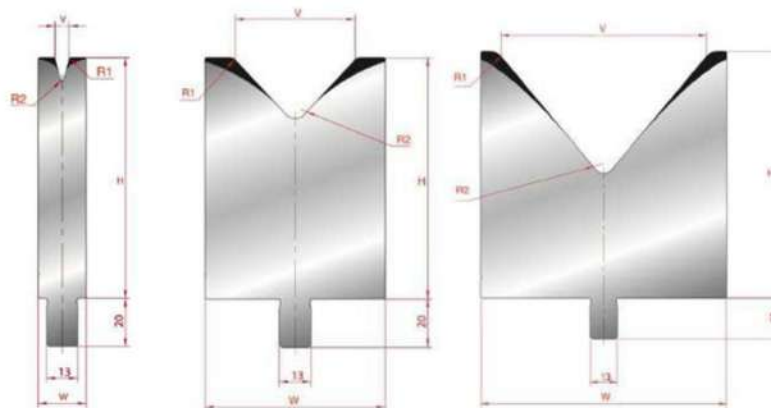


α	V	W	R1	R2	H	T/m	Code	L		Kg	Code	L		Kg
80	24	35	2,5	2,5	100	100	323180244	500		14,0	323180249	100		2,8
							323180246	300		8,4	323180248	FR		15,4
80	30	45	5,0	3,0	100	120	323280304	500		17,5	323280309	100		3,5
							323280306	300		10,5	323280308	FR		19,3
80	40	55	5,0	3,0	100	150	323380404	500		20,6	323380409	100		4,1
							323380406	300		12,3	323380408	FR		22,7
80	50	65	5,0	5,0	100	150	323480504	500		23,0	323480509	100		4,6
							323480506	300		13,8	323480508	FR		25,3
80	60	75	5,0	5,0	100	150	321980604	500		25,8	321980609	100		5,2
							321980606	300		15,6	321980608	FR		28,4
80	70	85	5,0	5,0	100	150	-	-		-	322080709	100		5,6
							322080706	300		16,8	322080708	FR		30,9
80	80	100	5,0	5,0	100	150	-	-		-	322180809	100		6,4
							322180806	300		19,2	322180808	FR		35,2
80	90	110	8,0	5,0	120	150	-	-		-	322280909	100		8,5
							322280907	200		17,0	322280908	FR		46,6
80	100	120	8,0	5,0	120	150	-	-		-	322380949	100		8,9
							322380947	200		17,8	322380948	FR		49,0
60	120	145	8,0	F	120	160	-	-		-	322460939	100		9,1
							322460937	200		18,2	322460938	FR		50,0



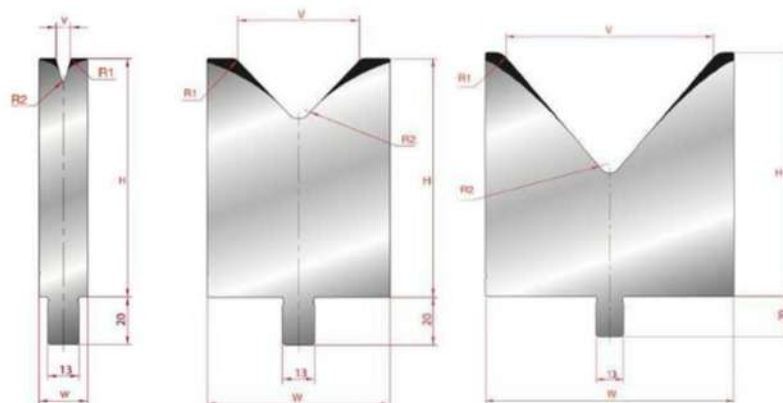
MATRICI 1V **1V DIE 42Cr** **30°**

H=100



α	V	W	R1	R2	H	T/m	Code	L	Kg	Code	L	Kg
30	6	20	0,6	0,6	100	60	320630064	500	8,7	320630069	100	1,8
							320630066	300	5,4	320630068	FR	9,6
30	8	20	1,0	1,0	100	50	320730084	500	8,6	320730089	100	1,7
							320730086	300	5,1	320730088	FR	9,5
30	10	20	1,0	1,0	100	50	320830104	500	8,4	320830109	100	1,7
							320830106	300	5,1	320830108	FR	9,3
30	12	25	1,0	1,0	100	56	320930124	500	10,2	320930129	100	2,0
							320930126	300	6,2	320930128	FR	11,3
30	16	30	1,6	1,6	100	68	321030164	500	11,8	321030169	100	2,4
							321030166	300	7,2	321030168	FR	13,0
30	20	35	2,0	2,0	100	50	321130204	500	13,0	321130209	100	2,6
							321130206	300	7,8	321130208	FR	14,3
30	24	40	2,5	2,5	100	55	321230244	500	14,5	321230249	100	2,9
							321230246	300	8,7	321230248	FR	16,0
30	30	55	3,0	3,0	100	85	321330304	500	19,0	321330309	100	3,8
							321330306	300	11,4	321330308	FR	20,9
30	40	60	5,0	5,0	100	73	321430404	500	18,5	321430409	100	3,7
							321430406	300	11,1	321430408	FR	20,4
30	50	75	5,0	FL	100	100	323530504	500	23,0	323530509	100	4,6
							323530506	300	13,8	323530508	FR	25,3
30	6	20	3,0	0,6	100	45	323630064	500	8,7	323630069	100	1,8
							323630066	300	5,4	323630068	FR	9,6
30	8	20	3,0	1,0	100	40	323730084	500	8,6	323730089	100	1,7
							323730086	300	5,1	323730088	FR	9,5
30	10	20	3,0	1,0	100	30	323830104	500	8,4	323830109	100	1,7
							323830106	300	5,1	323830108	FR	9,3
30	12	25	3,0	2,0	100	40	323930124	500	10,2	323930129	100	2,0
							323930126	300	6,2	323930128	FR	11,3
30	16	30	3,0	1,6	100	40	324030164	500	11,8	324030169	100	2,4
							324030166	300	7,2	324030168	FR	13,0



MATRICI 1V**1V DIE
C45****86°-30°
H=150**

α	V	W	R1	R2	H	T/m	Code	L	Price	Kg	Code	L	Price	Kg
86	6	20	0,6	0,5	150	100	314386064	500		13,0	314386069	100		2,6
							314386066	300		7,8	314386068	FR		14,0
86	8	20	0,8	0,5	150	100	314486084	500		13,0	314486089	100		2,6
							314486086	300		7,8	314486088	FR		14,0
86	10	20	1,0	0,5	150	100	314586104	500		13,0	314586109	100		2,6
							314586106	300		7,8	314586108	FR		14,0
86	12	25	1,0	0,5	150	100	314686124	500		16,0	314686129	100		3,2
							314686126	300		9,6	314686128	FR		17,3
86	16	30	1,6	0,5	150	100	314786164	500		18,0	314786169	100		3,6
							314786166	300		10,8	314786168	FR		20,2
86	20	30	2,0	0,5	150	100	314886204	500		18,0	314886209	100		3,6
							314886206	300		10,8	314886208	FR		20,0
86	24	35	2,5	0,5	150	100	314986244	500		21,0	314886249	100		3,6
							314986246	300		10,8	314886248	FR		23,1
30	6	20	0,6	1,0	150	50	315030064	500		13,0	315030069	100		2,6
							315030066	300		7,8	315030068	FR		13,9
30	8	20	1,0	2,0	150	40	315130084	500		12,5	315130089	100		2,5
							315130086	300		7,5	315130088	FR		13,8
30	10	20	1,0	2,0	150	40	315230104	500		13,0	315230109	100		2,6
							315230106	300		7,8	315230108	FR		19,6
30	12	25	1,0	2,0	150	50	315330124	500		15,0	315330129	100		3,0
							315330126	300		9,0	315330128	FR		16,7
30	16	30	1,6	5,0	150	45	315430164	500		18,0	315430169	100		3,6
							315430166	300		10,8	315430168	FR		19,6
30	20	35	2,0	5,0	150	50	315530204	500		20,0	315530209	100		4,0
							315530206	300		12,0	315530208	FR		22,0
30	24	40	2,5	5,0	150	50	315630244	500		22,0	315630249	100		4,4
							315630246	300		13,2	315630248	FR		24,7

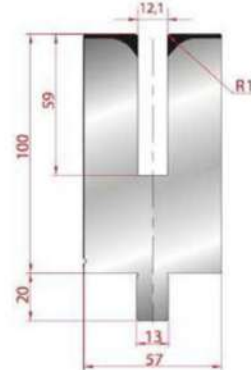
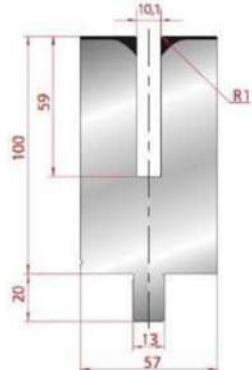
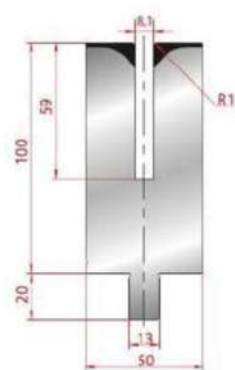
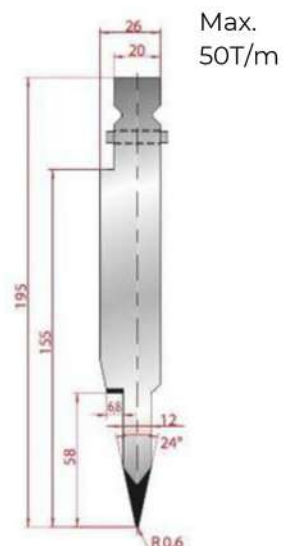
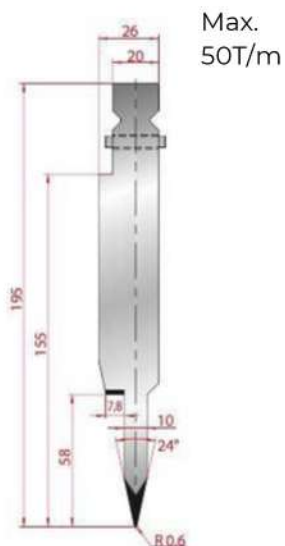
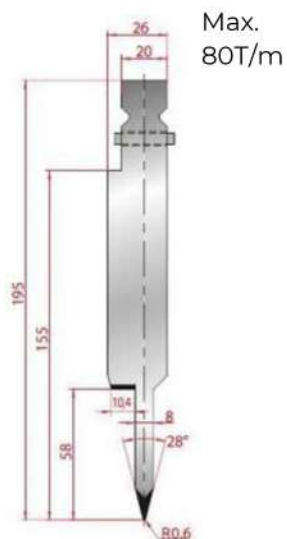


PIEGASCHIACCIA FLATTENING-HEMMING TOOL

L	COD.	
500	12492864	
550F	12492868	

L	COD.	
500	12502464	
550F	12502468	

L	COD.	
500	12512464	
550F	12512468	



L	COD.	
500	31572864	
550F	31572868	

L	COD.	
500	31742464	
550F	31742468	

L	COD.	
500	31752464	
550F	31752668	

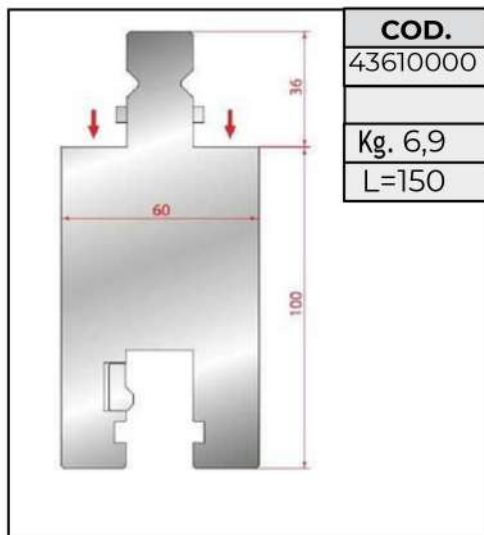


UTENSILI DI PIEGATURA | BENDING TOOLS

Accessori / Accessories

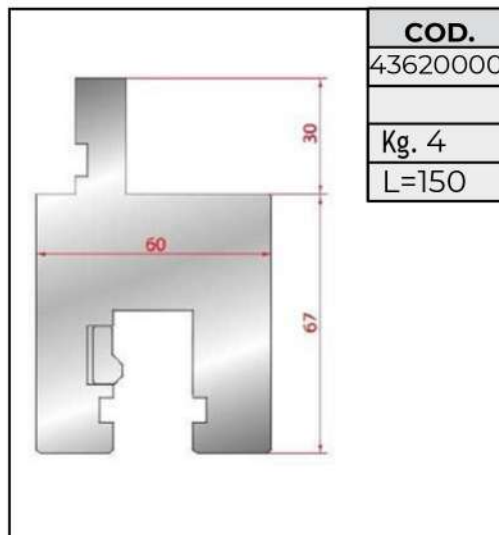


PROLUNGA TRUMPF TRUMPF EXTENSION



PROTEZIONE ANTIGRAFFIO MARKING PROTECTION

ADATTATORE AMADA-TRUMP AMADA-TRUMP ADAPTORS

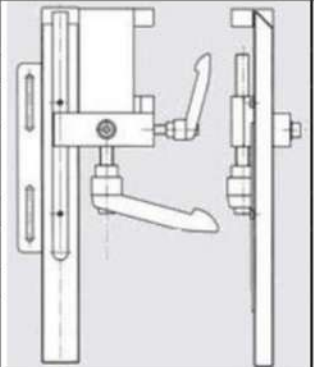
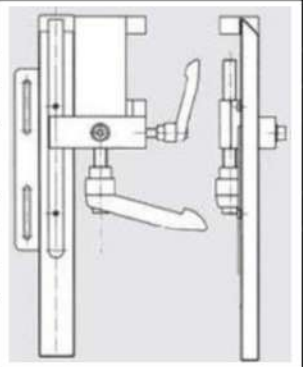
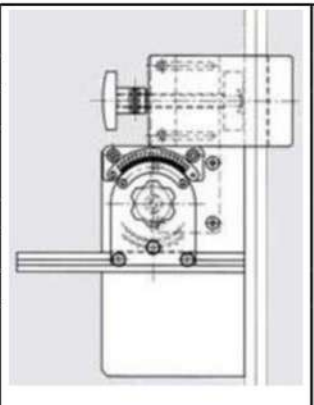
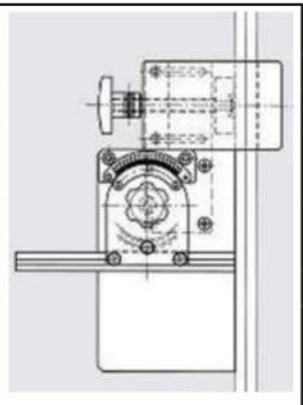


TENDITORI TIGHTENERS

	COD.	COD.		COD.
	4308M30	4314M30		43090000
	Mt.30 H=100 T=0,5	Mt.30 H=100 T=0,8		(coppia/pair)

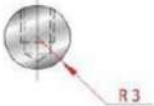
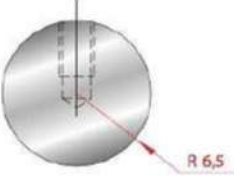
BATTUTE MATRICI

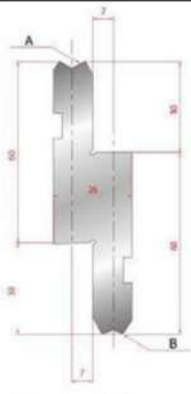
SIDE GAUGE FOR DIE

Cod. 5535V0263 (lunga/long) Art. Battuta a squadra per matrice Side Gauge for Dies *** Note Tutti i modelli - All type Per matrici da 60 a 90 mm For Dies from 60 to 90 mm *** Prezzo a richiesta *** Price on request		Cod. 5535V0263 (corta/short) Art. Battuta a squadra per matrice Side Gauge for Dies *** Note Tutti i modelli - All type Per matrici fino a 60 mm For Dies up to 60 mm *** Prezzo a richiesta *** Price on request	
Cod. 5535V0265 (60 mm) Art. Battuta a squadra Graduato Adjustable side gauge *** Note Tutti i modelli - All type Per matrici fino a 60 mm For Dies up to 60 mm *** Prezzo a richiesta *** Price on request		Cod. 5535V0265 (90 mm) Art. Battuta a squadra Graduato Adjustable side gauge *** Note Tutti i modelli - All type Per matrici da 60 a 90 mm For Dies from 60 to 90 mm *** Prezzo a richiesta *** Price on request	



PUNZONI RAGGIATI MULTI RADIUS PUNCHES C45

DA : FROM 	Raggio Radius mm.	L=835 COD.	L=415 COD.
A : TO 	3	11800301	11800302
	3,5	11810351	11810352
	4	11820401	11820402
	4,5	11830451	11830452
	5	11840501	11840502
	5,5	11850551	11850552
	6	11860601	11860602
	6,5	11870651	11870652

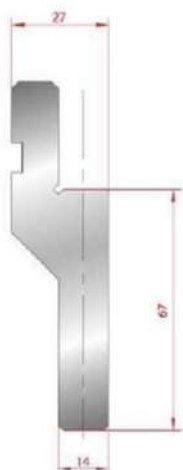
	L=835	L=415	
COD.	11550001	11550002	
Kg.	9,00	4,00	
Pos. A R= 3 - 3,5 - 4 - 4,5			
Pos. B R= 5 - 5,5 - 6 - 6,5			

GRUPPO MOLLA	
SPRING	
SET COD	42750000
.	



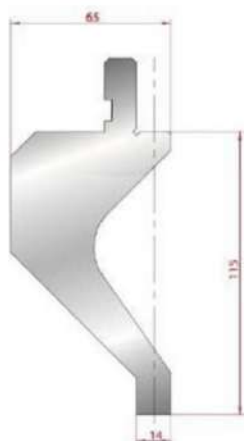
SUPPORTI PUNZONI RAGGIATI-PIATTI

RADIUS-FLAT PUNCHES HOLDERS



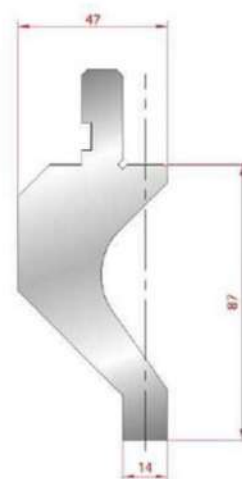
	L=830	L=410
COD.	10360671	10360672
. Kg.	10,00	5,00

	L=830	L=410
COD.	10961001	10961002
Kg.	13,00	6,00

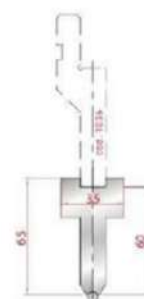


	L=830	L=410
COD.	109061151	10901152
Kg.	26,00	13,00

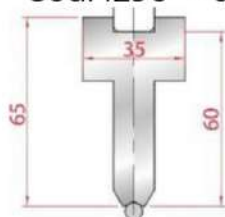
	L=830	L=410
COD.	10910871	10910872
Kg.	16,00	8,00



	L=830	L=410
COD.	12400001	12400002
Kg.	16,00	8,00

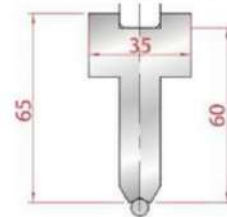


Cod. 1296 - d. 3 - 4,5

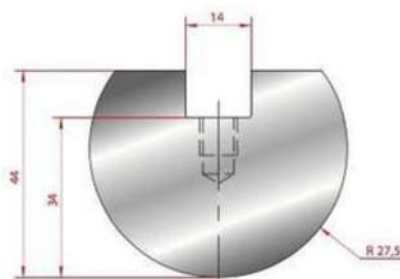
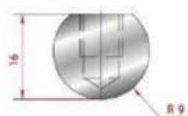


	835	415
COD.	12960001	12960002
COD.	12970001	12970002

Cod. 1297 - d. 5 - 6,5



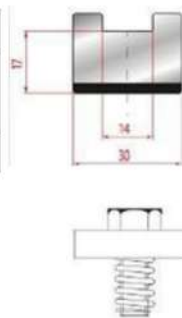
PUNZONI RAGGIATI-PIATTI **RADIUS FLAT PUNCHES C45**



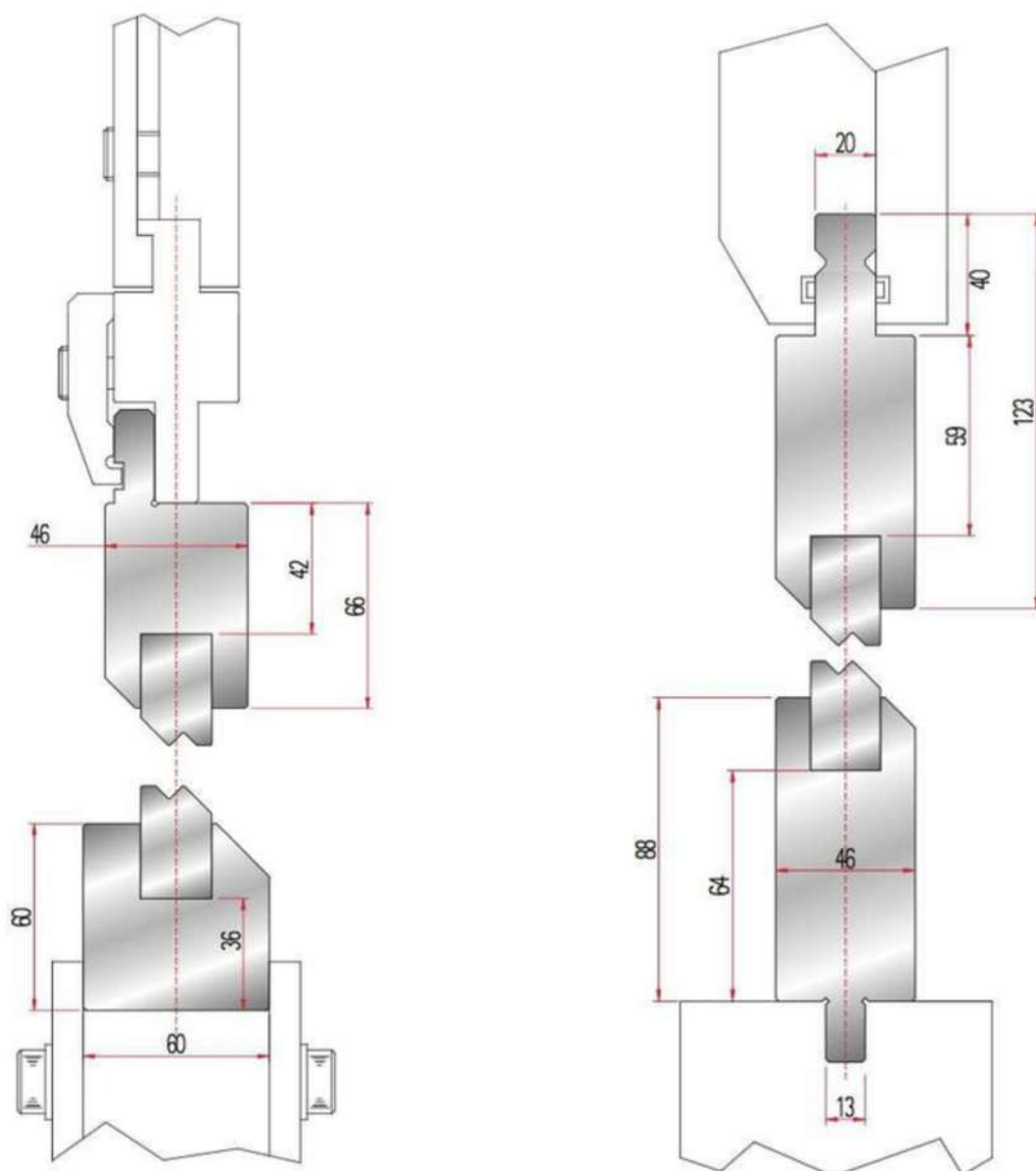
R	H	835 mm.	415 mm.	R	H	835 mm.	415 mm.
		COD.	COD.			COD.	COD.
7	11,5	11000701	11000702	17	21,5	11111701	11111702
7,5	11,5	11010751	11010752	17,5	22,0	10391751	10391752
8	13,0	11020801	11020802	19	25,0	11121901	11121902
9	16,0	11030901	11030902	20	24,0	10402001	10402002
10	16,0	10371001	10371002	22,5	25,0	11132251	11132252
11	16,0	11041101	11041102	25	29,0	10412501	10412502
11,5	16,0	11051151	11051152	27,5	34,0	11142751	11142752
12	20,0	11061201	11061202	30	34,0	10423001	10423002
12,5	16,0	11071251	11071252	35	45,0	11153501	11153502
13	17,0	11081301	11081302	40	45,0	11164001	11164002
14	19,0	11091401	11091402	45	50,0	11174501	11174502
15	20,0	10381501	10381502	50	54,0	11185001	11185002
16	21,0	11101601	11101602				
DISPONIBILE VERSIONE NITRURATA - PREZZO SU RICHIESTA HARDNESS VERSION AVAILABLE - PRICE ON REQUEST							

PUNZONE PIATTO / FLATTENING PUNCH		
COD.	10430001	10430002
	835mm- Kg. 5,0	415mm.-Kg. 2,5

GRUPPO MOLLA SPRING SET	
COD.	9AA042740000



CONTENITORI PER INSERTI A Z JOGGLE TOOL HOLDERS



ATTACCO - TAGS	835 mm.			415 mm.		
AMADA	Code	Price	KG.	Code		KG.
TRUMPF	11500001		38,5	11500002		19,2
	12420001		40,0	12420002		20,0



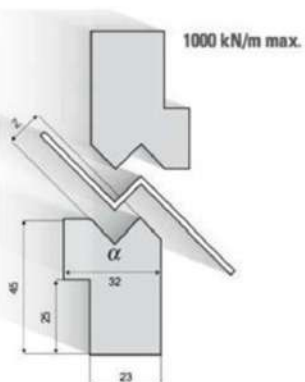
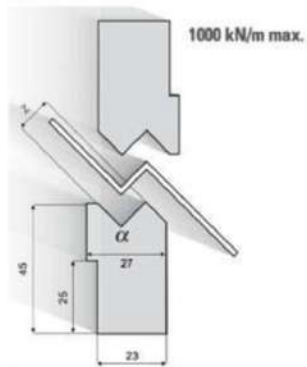
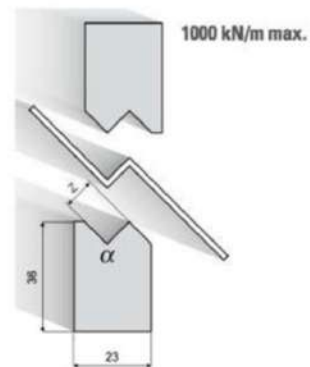
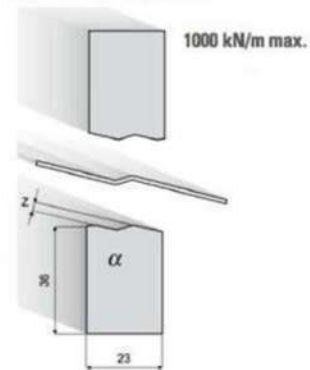
INSERTI A Z

α	Z	835 mm.			415 mm.		
		Code		KG.	Code		KG.
160°	1,0	11300001		10,0	11300002		5,0
160°	1,5	11310001		10,0	11310002		5,0
160°	2,0	11320001		10,0	11320002		5,0
160°	2,5	11330001		10,0	11330002		5,0

α	Z	835 mm.			415 mm.		
		Code		KG.	Code		KG.
90°	1,0	12760001		10,0	12760002		5,0
90°	1,5	12770001		10,0	12770002		5,0
90°	2,0	12740001		10,0	12740002		5,0
90°	2,5	12750001		10,0	12750002		5,0
90°	3,0	11340001		10,0	11340002		5,0
90°	3,5	11350001		10,0	11350002		5,0
90°	4,0	11360001		10,0	11360002		5,0
90°	4,5	11370001		10,0	11370002		5,0
90°	5,0	11380001		10,0	11380002		5,0
90°	5,5	11390001		10,0	11390002		5,0
90°	6,0	11400001		10,0	11400002		5,0
90°	6,5	11410001		10,0	11410002		5,0
90°	7,0	11420001		10,0	11420002		5,0
90°	7,5	11430001		10,0	11430002		5,0
90°	8,0	11440001		10,0	11440002		5,0

α	Z	835 mm.			415 mm.		
		Code		KG.	Code		KG.
90°	9	11450001		13,5	11450002		6,7
90°	10	11460001		13,5	11460002		6,7
90°	11	11470001		13,5	11470002		6,7
90°	12	11480001		13,5	11480002		6,7

α	Z	835 mm.			415 mm.		
		Code	Price	KG.	Code	Price	KG.
90°	13	12780001		14,5	12780002		7,3
90°	14	12790001		14,5	12790002		7,3
90°	15	12800001		14,5	12800002		7,3

JOGGLE INSERT

SISTEMA ACTIVE BEND**ACTIVE BEND SYSTEM****Active Bend**

garantisce prestazioni che le matrici standard non consentono:

- pieghe fino a 40°
- bordi minimi ridotti
- piegare lamiere forate senza deformazione
- marcatura ridotta

Active Bend

provides advantages that the standard dies can't perform:

- 40° acute bending narrow
- minimum edges
- no strain with perforated sheets
- reduction of bending mark

**ACTIVE BEND - AMADA PROMECAM**

L	Cod.		AB200
500	330600004		
200	330600007		
100	330600009		
50	33060000A		
30	33060000B		
25	33060000C		
20	33060000D		
15	33060000E		
L	Cod.		AB450
500	33080000A		
200	330800007		
100	330800009		
50	33080000A		

L	Cod.		AB300
500	330700004		
200	330700007		
100	330700009		
50	33070000A		
30	33070000B		
25	33070000C		
20	33070000D		
15	33070000E		



ACTIVE BEND - TRUMPF

L	Cod.		AB200
500	330000004		
200	330000007		
100	330000009		
50	33000000A		
30	33000000B		
25	33000000C		
20	33000000D		
15	33000000E		
L	Cod.		AB600
500	330200004		
200	330200007		
100	330200009		
50	33020000A		

L	Cod.		AB300
500	330100004		
200	330100007		
100	330100009		
50	33010000A		
30	33010000B		
25	33010000C		
20	33010000D		
15	33010000E		
L	Cod.		AB1000
200	331200007		

ACTIVE BEND - AMADA PROMECAM

L	Cod.		AB20
500	330300004		
200	330300007		
100	330300009		
50	33030000A		
30	33030000B		
25	33030000C		
20	33030000D		
15	33030000E		
L	Cod.		AB60
500	330500004		
200	330500007		
100	330500009		
50	33050000A		

L	Cod.		AB300
500	330400004		
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50	33040000A		
30	33040000B		
25	33040000C		
20	33040000D		
15	33040000E		
L	Cod.		AB1000
200	331300007		



Armadio portautensili con dotazioni standard per i cassetti:

- 2 ripiani fissi, 4 ripiani a mensole
- per utensili interi, 2 ripiano
- continuo per utensili frazionati

I cassetti verticali scorrevoli sono dotati di supporti utensili posizionabili in altezza (secondo la propria necessità) che garantiscono un'estrema praticità d'uso. Inoltre tali supporti sono adibiti sia per utensili interi che frazionati.

TOOLS CABINETS

Tooling cabinet with standard features:

- 2 fixed shelves, 4 shelf sections
- for full-length tools, 1 full-length shelf for sectioned tools,

The vertical slinding drawers with height adjustable tools supports (for specific needs) guarantee an extremely easy to use, moreover these support are wheter for full-length than for sectioned tools.

Carrello portautensili
Mobile trolley for tools

Codice	Cassetto Drawer	Attacco/Tags	Alt./Height	Larg./Width	Prof./Depth	L. Max	Colore/Color
ARMPR31	3	Promecam	1240	660	1050	Ut. 835	Nero-Rosso
ARMPR41	4	Promecam	1240	850	1050	835	Black-Red
ARMPR51	5	Promecam	1240	1040	1050	835	RAL9005 RAL3000
ARMWI38	3	Wila	1240	660	800	600	Nero- Rosso Black- Red RAL9005 RAL3000
ARMWI48	4	Wila	1240	850	800	600	
ARMWI58	5	Wila	1240	1040	800	600	
ARMWI31	3	Wila	1240	660	1300	1100	
ARMWI41	4	Wila	1240	850	1300	1100	
ARMWI51	5	Wila	1240	1040	1300	1100	
CRPR5		5 ripiani L=835 - 5 floors L=835					
PREZZO SU RICHIESTA - PRICE ON REQUEST							

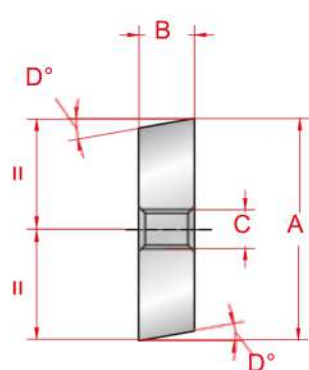


LAME PER CESOIA

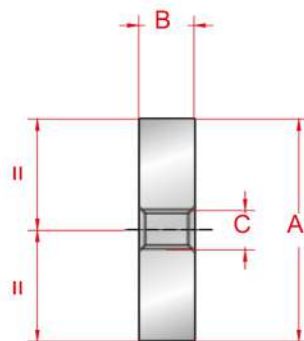
A richiesta eseguiamo lame per cesoia a disegno del cliente. Si prega di contattare il nostro ufficio tecnico indicando la tipologia di profilo e di fissaggio.

SHEAR BLADES

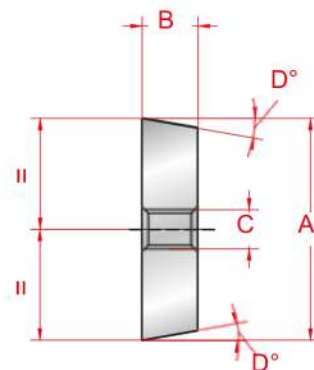
On request we can build shear blades on customer drawing. Please contact our Technical Department showing profile type and fixing.



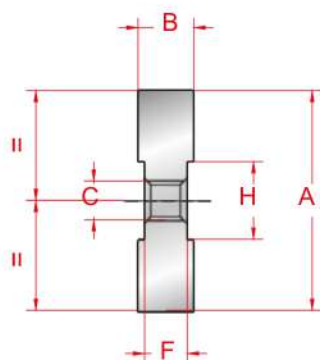
Type
A



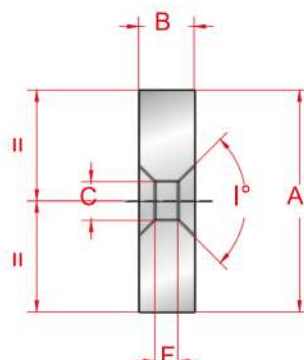
Type
B



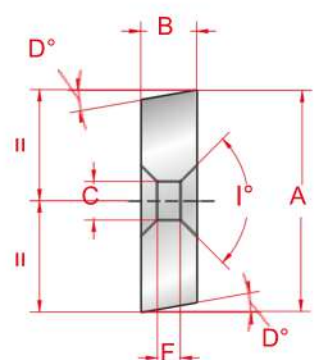
Type
C



Type
D



Type
E

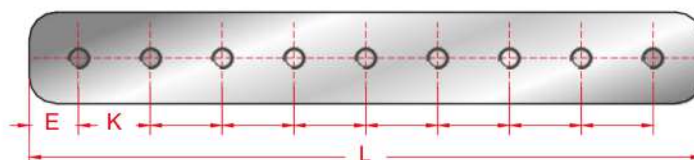


Type
F

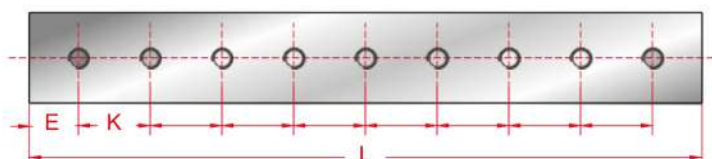
Model
1



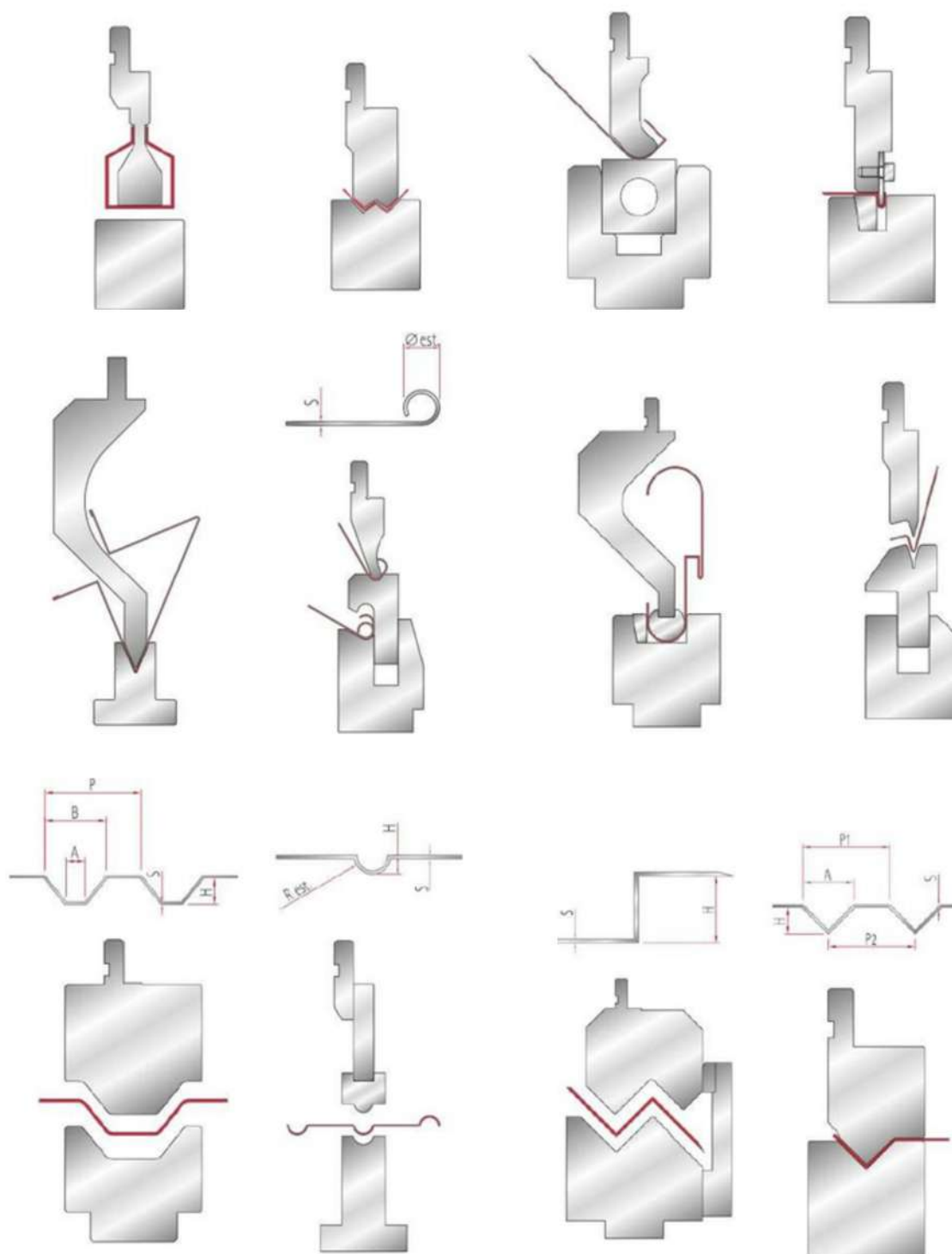
Model
2



Model
3



UTENSILI SPECIALI A RICHIESTA SPECIAL TOOLS ON REQUEST



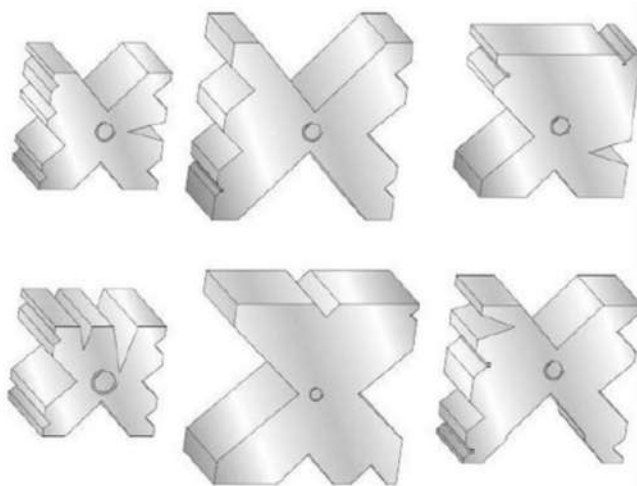
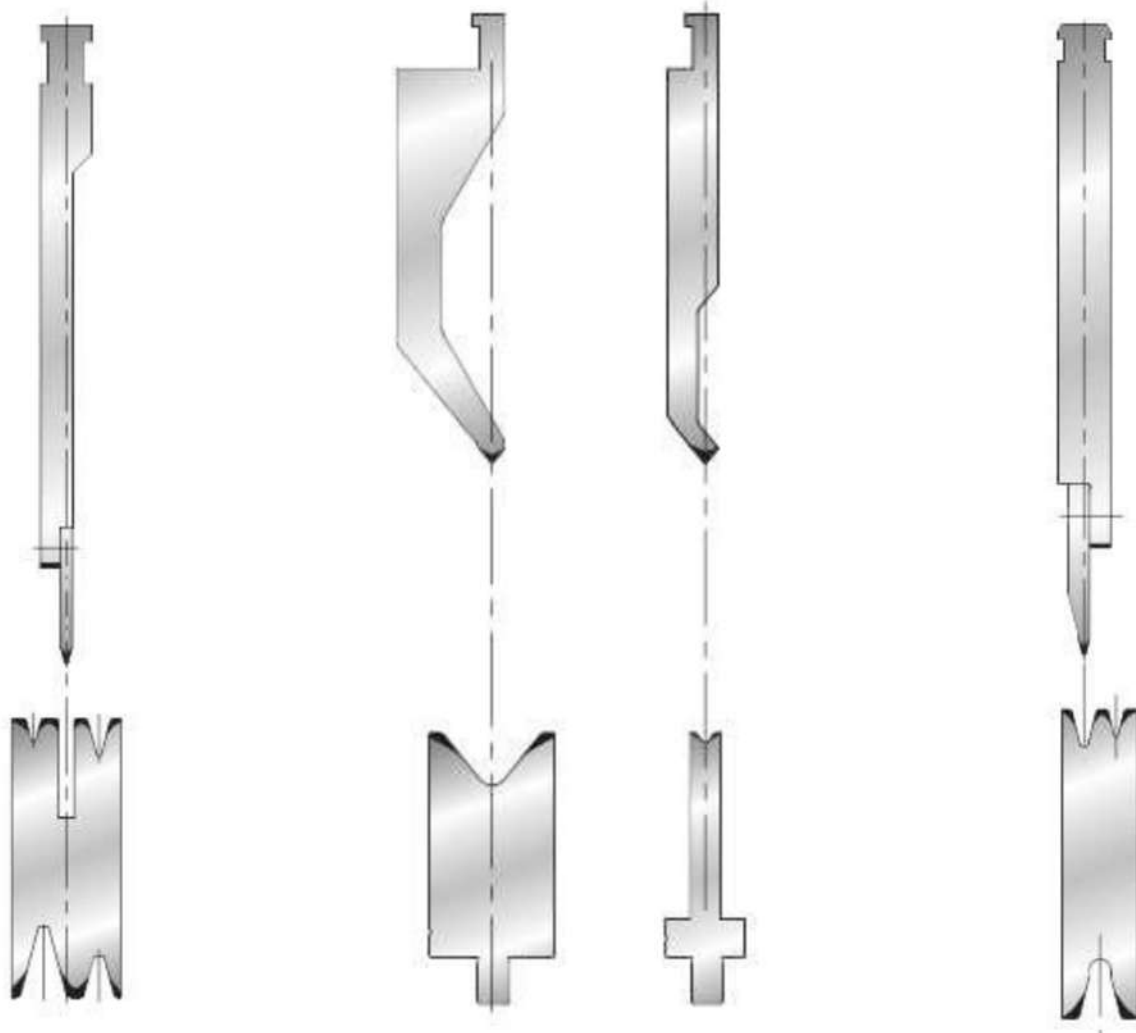
A RICHIESTA SI ESEGUONO UTENSILI PER IMPIEGHI SPECIALI CON
ATTACCHI DEI PRINCIPALI COSTRUTTORI.

ON REQUEST WE CAN PRODUCE SPECIAL TOOLS WITH HOOKS OF
MAIN PRESS BRAKE MANUFACTURER.

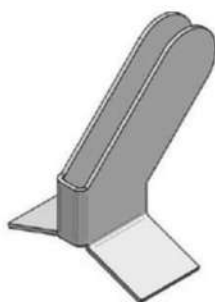


UTENSILI SPECIALI A RICHIESTA
SPECIAL TOOLS ON REQUEST

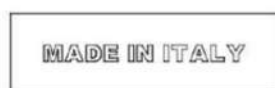
LVD – BEYELER/BISTRONIC –
WEINBRENNER – EHT



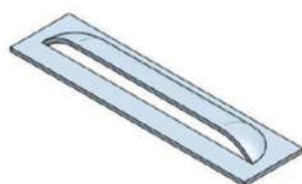
DEFORMAZIONE SPECIALE IN 2 FASI
SPECIAL 2 STEP BENDING



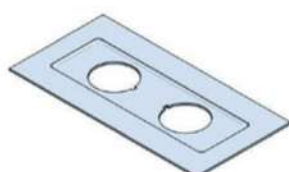
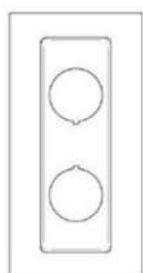
MARCATURA LOGO
LOGO MARKING



ALETTA DI VENTILAZIONE WING
VENTILATION - LOUVER



DEFORMAZIONE PROFONDA GUIDATA
GUIDED DEEP DEFORMATION



Produzione generale – General productions

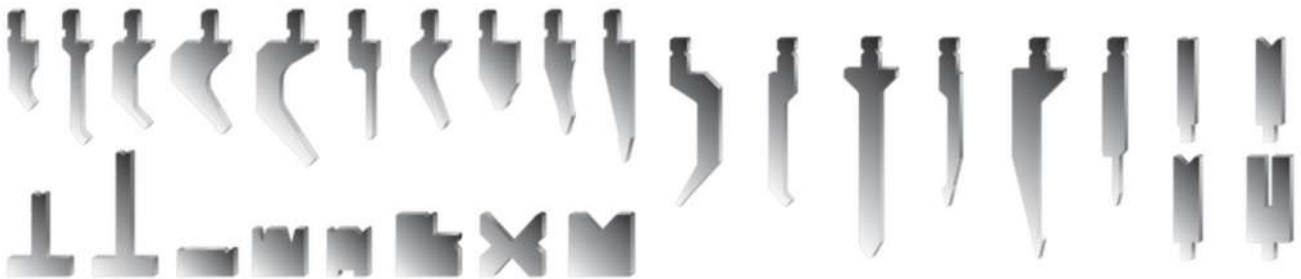
- UTENSILI PUNZONATURA TRUMPF
- TRUMPF PUNCHING TOOLS
- UTENSILI PUNZONATURA AMADA
- AMADA PUNCHING TOOLS
- UTENSILI PIEGATURA TRUMPF
- TRUMPF BENDING TOOLS
- UTENSILI PIEGATURA AMADA
- AMADA BENDING TOOLS
- SISTEMI CAMBIO RAPIDO UTENSILI PIEGATURA
- FAST CLAMPING/UNCLAMPING SYSTEM FOR BENDING TOOLS
- UTENSILI PUNZONATURA RAINER
- RAINER PUNCHING TOOLS
- UTENSILI PUNZONATURA TECHNOLOGY
- TECHNOLOGY PUNCHING TOOLS
- AFFILATRICE PER UTENSILI
- PUNCHING TOOLS GRINDER



PRODUZIONE GENERALE



UTENSILI THICK TURRET – THICK TURRET TOOLS



UTENSILI PIEGATURA AMADA/TRUMPF – AMADA/TRUMPF BENDING TOOLS



UTENSILI TRUMPF STYLE – TRUMPF STYLE TOOLS



UTENSILI SPECIALI – SPECIAL TOOLS



Azienda

Nuovo brand, eccellenza storica.

Nel 1967, nasce a Bologna l'azienda Gennelli Allori.

Fin da subito si distingue per la grande attenzione allo sviluppo e alla ricerca di soluzioni ottimali per implementare i processi produttivi dei clienti.

L'azienda, tecnologicamente avanzata, produce utensili, attrezzature e accessori di altissima qualità per i macchine industriali per macchine CNC come presse piegatrici e punzonatrici.

Nel corso del tempo, continua la sua crescita garantendo ai clienti punzoni e matrici temprate e rettifiche, alette, adattatori e altri ricambi sia in misura standard che speciali.

Alla produzione, si affianca da sempre il servizio di manutenzione e assistenza per garantire al cliente il supporto giusto al momento giusto e un servizio a 360°. Gennelli Allori diventa un punto di riferimento per le aziende che lavorano lamiera di ogni settore.

Nel 1998, Bologna vede nascere una nuova azienda: Microtools.

Microtools diventa subito leader nel settore degli utensili per i macchinari macchine curvatubi e sagomatubi.

La qualità imbattibile dei suoi prodotti, ottenuta attraverso la predisposizione di un processo di progettazione 3D, e la realizzazione su misura di matrici, tasselli, slitte, anime, morse, punzoni e attrezzature di deformazione testa di tubi rastrematura, la rendono un punto di riferimento importante per le aziende del settore.

Microtools non si pone solo come fornitore ma come partner dei propri clienti.

La scrupolosa attenzione alle esigenze del cliente e le severe procedure di controllo e collaudo dei prodotti assicurano livelli di performance elevati.

Dall'unione di queste due aziende, nasce AlloriTools.

Un'azienda unica e completa che garantisce ai propri clienti una vasta gamma di prodotti per la lavorazione di tubi e lamiera.

Gennelli Allori porta l'esperienza di più di 50 anni di attività nel settore metalmeccanico, diventando oggi la Divisione Lamiera di AlloriTools.

Microtools, più giovane ma forte della sua competenza nella lavorazione del tubo, diventa oggi la Divisione Tubo di AlloriTools.

Due eccellenze, una nuova e grande forza.

Company

New brand, historic excellence.

In 1967, the Gennelli Allori company was founded in Bologna. From the outset, it distinguished itself by its great attention to development and the search for optimal solutions to improve customers' production processes. The technologically advanced company produces tools, equipment, and accessories of the highest quality for industrial CNC machines such as press brakes and punching machines. Over time, it has continued its growth, guaranteeing customers hardened and ground punches and dies, louvers, adapters, and other spare parts in both standard and special sizes. Production has always been supported by a maintenance and assistance service to ensure customers receive the right support at the right time and a 360° service. Gennelli Allori has become a benchmark for companies working with sheet metal in every sector.

In 1998, a new company, Microtools, was founded in Bologna. Microtools quickly became a leader in the field of tools for tube bending and shaping endforming machinery.

The unbeatable quality of its products, achieved through a 3D design process and the custom manufacturing of dies, segments, slides, clamps, pressure dies, wiper dies, mandrels, collets clamps, punches, and tube end forming equipment, makes it an important point of reference for companies in the sector.

Microtools positions itself not only as a supplier but also as a partner to its customers. Scrupulous attention to customer needs and strict product control and testing procedures ensure high levels of performance.

From the union join of these two companies, AlloriTools is born. A unique and complete company that guarantees its customers a wide range of products for tube and sheet metal processing.

Gennelli Allori brings the experience of more than 50 years of activity in the metalworking sector, today becoming the Sheet Metal Division of AlloriTools. Microtools, younger but strong in its expertise in tube processing, today becomes the Tube Division of AlloriTools.

Two excellences, a new great strength.





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