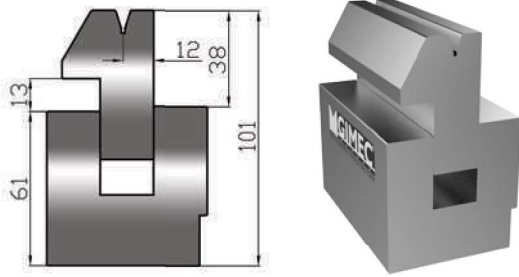


PRESS BRAKE TOOLS FACTORY CATALOGUE

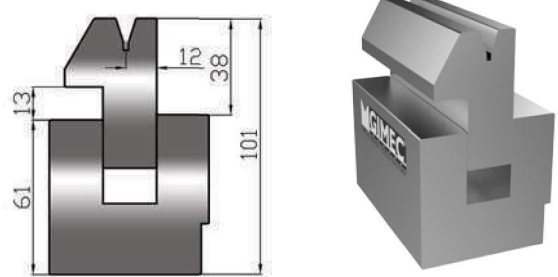


US 303/35° V6



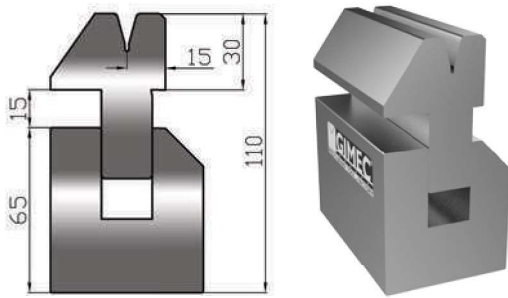
V mm	altezza height	raggio radius	acciaio steel	max kN/mt
6/35°	mm 101-88	1,0	C45 T HRC 52+58	600
lunghezze - lengths		mm 835 - 415		

US 303/35° V8



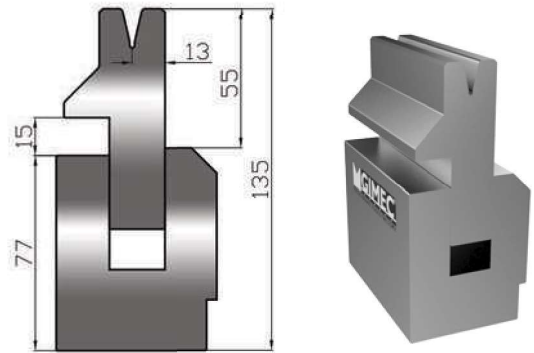
V mm	altezza height	raggio radius	acciaio steel	max kN/mt
8/35°	mm 101-88	1,0	C45 T HRC 52+58	600
lunghezze - lengths		mm 835 - 415		

US 306/30° V8



V mm	altezza height	raggio radius	acciaio steel	max kN/mt
mm 8	mm 110-95	1,5	C45 T HRC 52+58	800
lunghezze - lengths		mm 835 - 415		

US 308/26° V8



V mm	altezza height	raggio radius	acciaio steel	max kN/mt
mm 8	mm 135-120	1,5	42CM4T HRC52+58	400
lunghezze - lengths		mm 835 - 415		

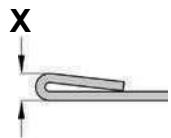
serie 60®

STANDARD TOOLS

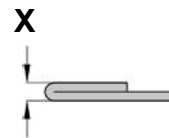


SPESORE THICKNESS

mm	inches
0,6	.024
0,8	.031
1,0	.039
1,2	.047
1,5	.059
2,0	.079
2,5	.098
3,0	.118

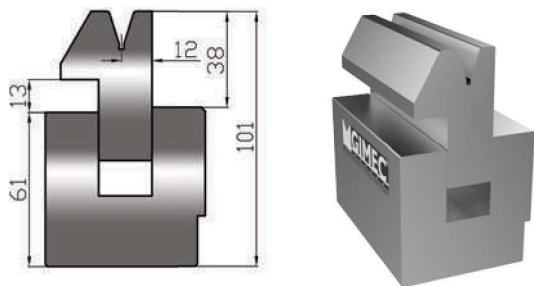


Rm=450 N/mm² Rm=65000 PSI		Rm=700 N/mm² Rm=100000 PSI	
POTENZA POWER			
X mm	inches	kN/mt	US t/ft
3,0	.118	90	3
3,0	.118	120	4
3,5	.137	150	5
3,5	.137	170	6
4,6	.181	220	8
5,5	.216	300	10
6,5	.255	550	18
8,0	.314	700	24



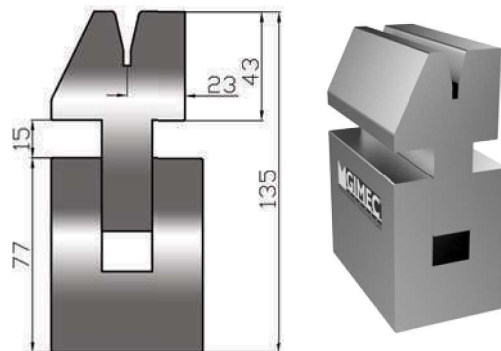
Rm=450 N/mm² Rm=65000 PSI		Rm=700 N/mm² Rm=100000 PSI	
POTENZA POWER			
X mm	inches	kN/mt	US t/ft
1,2	.047	230	8
1,6	.062	320	11
2,0	.078	400	14
2,4	.094	500	17
3,0	.118	630	22
4,0	.157	800	27
5,0	.196	900	31
6,0	.236	1000	34

US 303/35° V10



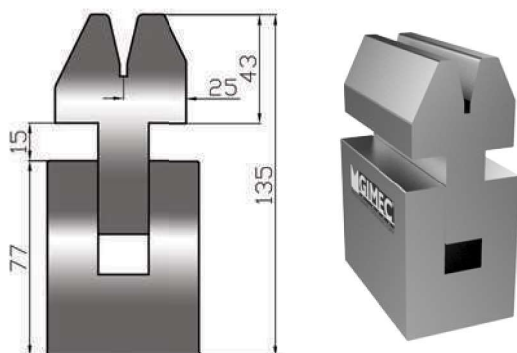
V mm	altezza height	raggio radius	acciaio steel	max kN/mt
10/35°	mm 101-88	1,0	C45 T HRC 52+58	600
lunghezze - lengths		mm 835 - 415		

US 302/26° V10



V mm	altezza height	raggio radius	acciaio steel	max kN/mt
10/26°	mm 135-120	1,5	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415		

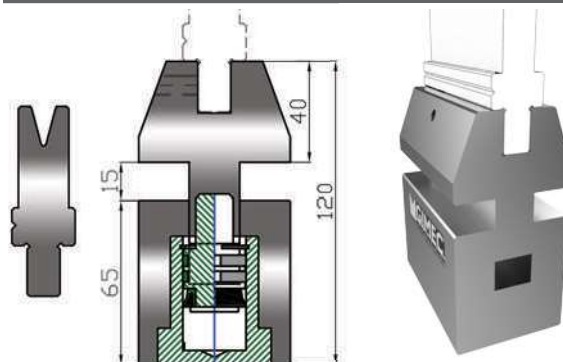
US 300/26° V12



V mm	altezza height	raggio radius	acciaio steel	max kN/mt
12/26°	mm 135-120	2,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415		

US 301 PNEUMATIC

per utensili / for tools serie 13 UST-USB

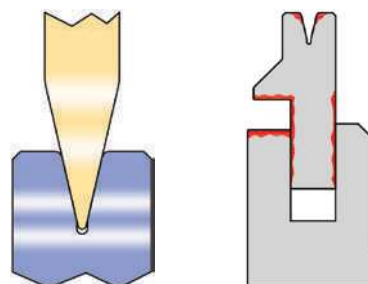


altezza height	acciaio steel	max kN/mt
mm 120-105	C45 T HRC 52+58	1000
lunghezze - lengths		mm 1000 - 500

AVVERTENZE WARNINGS

Utilizzare queste matrici con utensili superiori con la stessa gradazione. La tempra viene eseguita sia sulle parti di lavoro che di scorrimento.

Employ these hemming tools with upper tool having the same degree. Induction hardened is applied on working surfaces and flowing parts.



Gli utensili piegaschiaccia serie 300 possono essere forniti con cilindri pneumatici per il sollevamento dell'elemento superiore.

The hemming tools 300 series can be supplied with pneumatic cylinders for moving upper elements.

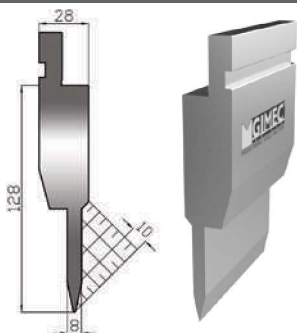


KIT/PNEU

serie 60®

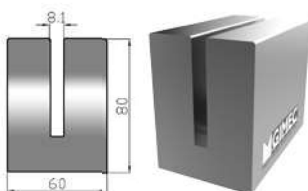
STANDARD TOOLS

US 138 L 8



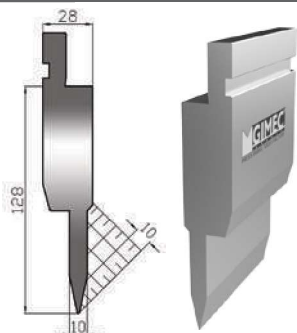
altezza height	angolo degree	raggio radius	max kN/mt
mm 128	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

US 138 M 8



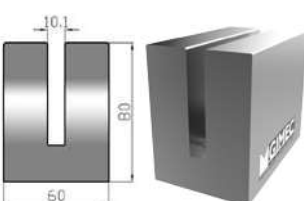
altezza height	V	raggio radius	max kN/mt
mm 80	mm 8	1,0	500
42CM4 T HRC52+58			
mm 835 - 415 - fraz			

US 138 L 10



altezza height	angolo degree	raggio radius	max kN/mt
mm 128	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

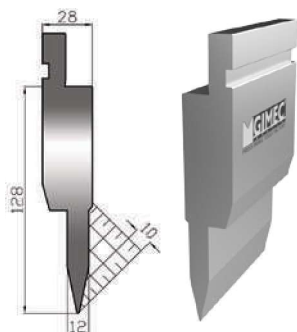
US 138 M 10



altezza height	V	raggio radius	max kN/mt
mm 80	mm10	1,0	500
42CM4 T HRC52+58			
mm 835 - 415 - fraz			

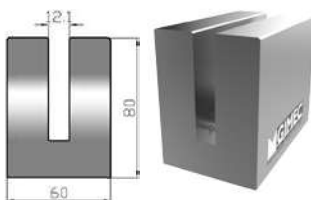


US 138 L 12



altezza height	angolo degree	raggio radius	max kN/mt
mm 128	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

US 138 M 12



altezza height	V	raggio radius	max kN/mt
mm 80	mm12	1,0	500
42CM4 T HRC52+58			
mm 835 - 415 - fraz			

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

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