

PRESS BRAKE TOOLS FACTORY CATALOGUE





Dal 1986 Gimec è tra le aziende più qualificate nella costruzione di utensili ed attrezzature per la lavorazione della lamiera.

In particolare siamo specializzati nella fornitura di utensili per presse piegatrici e lame per cesoia. L'analisi metodica di tutti i materiali impiegati, il controllo accurato del prodotto durante le varie fasi produttive e la continua ricerca innovativa, contribuiscono ad accrescere l'alto livello tecnologico raggiunto dalla Gimec in tale settore.

Siamo un'azienda compatta ed agile, che opera quotidianamente con passione ed entusiasmo, caratteristiche che da sempre ci contraddistinguono sul mercato.

In un'economia sempre più competitiva, cerchiamo di fornire il miglior servizio, con prodotti di alta qualità, progettando e proponendo soluzioni efficaci e funzionali.

Since 1986 Gimec is among the leading companies in the manufacturing of tools and equipment for sheet metal working.

In particular, we are specialized in providing tools for press brake and shear blades.

The methodical analysis of all materials used, the careful monitoring of the product during the various stages of production and continued innovative research, help us to increase the high technological level reached in this area.

We are a compact and agile company, which daily works with passion and enthusiasm, characteristics that have always distinguished us in the market.

In a more and more competitive economy, we try to provide the best service with high quality products, designing and proposing effective and useful solutions.

45°37'05.7"N 9°16'00.6"E
Google plus code J798+8P



UTENSILI SUPERIORI - UPPER TOOLS

tipo Europa [®] type	pag.04	serie US [®]
tipo Trumpf Wila [®] type	pag.34	serie UST [®]
tipo Beyeler Bystronic [®] type	pag.46	serie USB [®]
tipo LVD [®] type	pag.52	serie USL [®]
tipo COLGAR [®] type	pag.58	serie USC [®]

UTENSILI INFERIORI - LOWER TOOLS

tipo Europa [®] type	pag.20	serie 60 [®]
tipo Trumpf Wila [®] type	pag.60	serie 13 UST [®]
tipo Beyeler Bystronic [®] type	pag.62	serie 13 USB [®]
tipo LVD [®] type	pag.64	serie 12,7 USL [®]
tipo ROLLA-V [®] type	pag.66	serie ROLLA-V [®]

UTENSILI - TOOLS

tipo HACO [®] type	pag.70	serie USH [®]
tipo NEWTON [®] type	pag.72	serie USN [®]

stampi per presse piegatrici - press brake tools	pag.75	STAMPI
porta utensili - tools holder	pag.84	PORTA UT
sistema di centinatura - crowning system	pag.88	TABLUS
lame per cesoia - shear blades	pag.92	LAME
attrezzature - fixtures	pag.94	ATTREZZATURE

GET IN TOUCH



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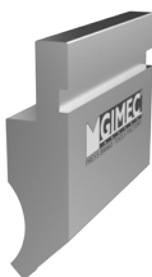
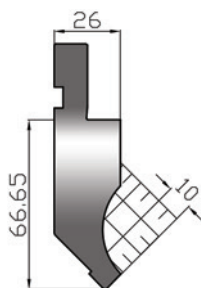
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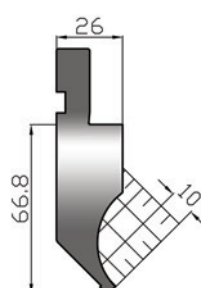


gimec_press_brake_tools
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gimec_press_brake_tools_images

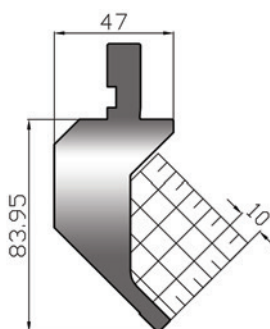
NON ESITARE A CONTATTARCI - PROFESSIONALITA' E COMPETENZA SONO I NOSTRI PUNTI DI FORZA
DON'T HESITATE TO CONTACT US PROFESSIONALISM AND COMPETENCE ARE OUR STRENGTH POINTS

US 110/90° R0,8

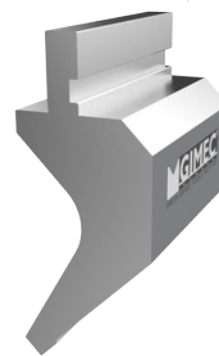
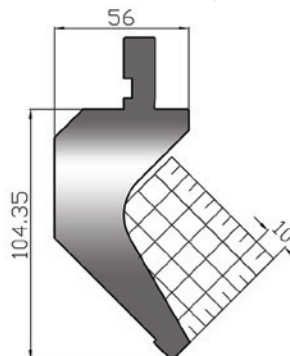
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
66,65	90°	0,8	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 126/90° R0,6

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
66,8	90°	0,6	42CM4 T HRC 52÷58	350
lunghezze - lengths		mm 835 - 415 - fraz		

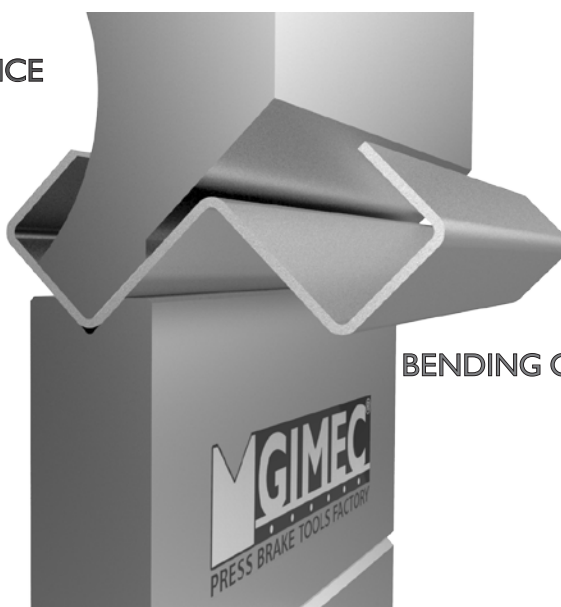
US 117/90° R0,6

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
83,95	90°	0,6	42CM4 T HRC 52÷58	300
lunghezze - lengths		mm 835 - 415 - fraz		

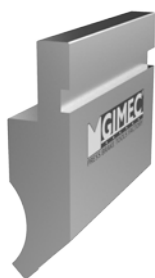
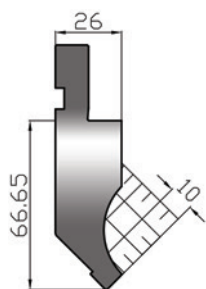
US 115/90° R0,8

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
104,35	90°	0,8	C45 T HRC 52÷58	500
lunghezze - lengths		mm 835 - 415 - fraz		

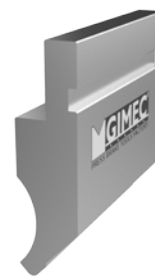
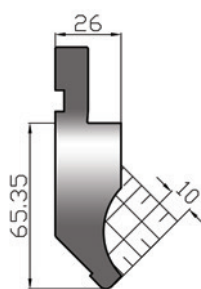
**PIEGATURA A FONDO MATRICE
o CONIATURA**



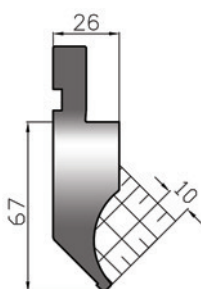
**BENDING ON LOWER TOOL BOTTOM
or COINING**

US 110/88° R0,8

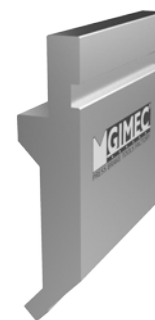
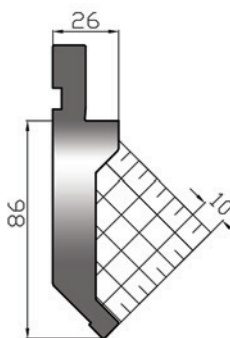
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
66,65	88°	0,8	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 110/88° R3,0

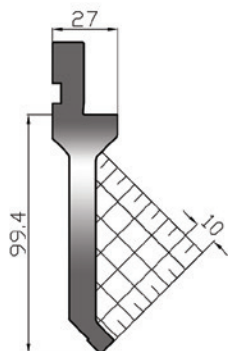
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65,35	88°	3,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 126/88° R0,6

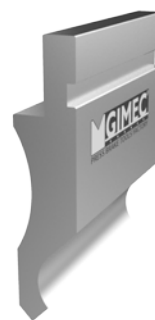
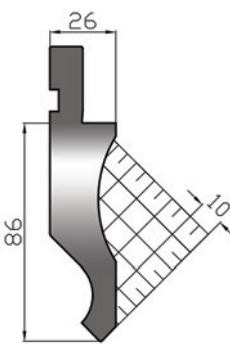
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
67,0	88°	0,6	42CM4 T HRC 52+58	350
lunghezze - lengths		mm 835 - 415 - fraz		

US 125/88° R0,8

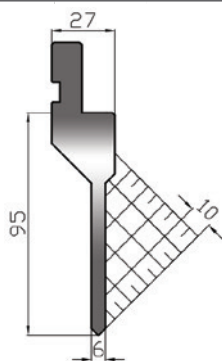
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
86,0	88°	0,8	C45 T HRC 52+58	500
lunghezze - lengths		mm 835 - 415 - fraz		

US 143/88° R0,6

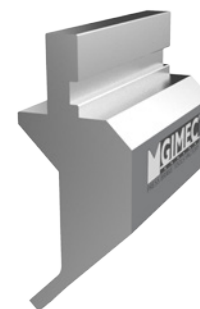
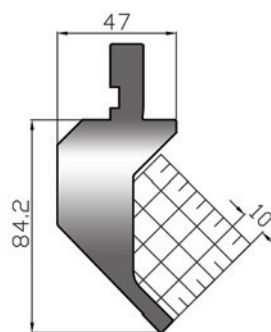
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lunghezze - lengths		mm 835 - 415 - fraz		

US 120/88° R0,8

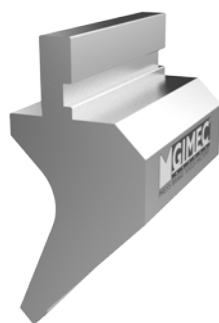
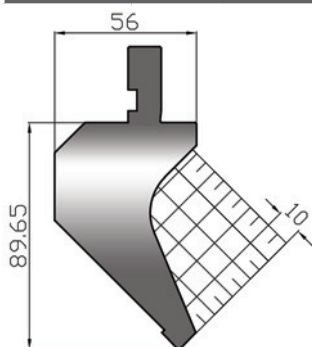
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
86,0	88°	0,8	C45 T HRC 52+58	500
lunghezze - lengths		mm 835 - 415 - fraz		

US 147/88° R0,25

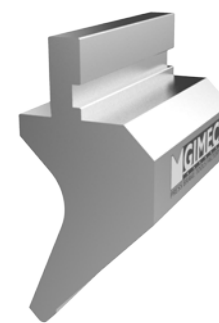
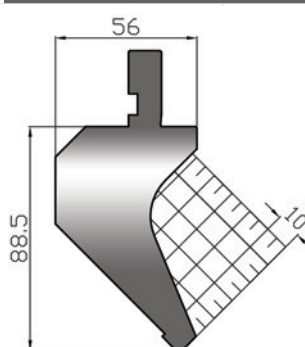
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US 117/88° R0,6

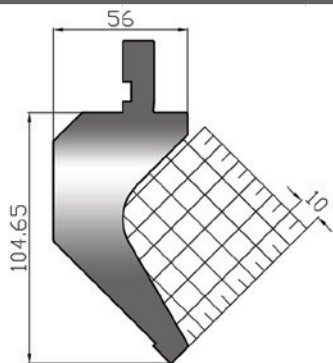
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84,2	88°	0,6	42CM4 T HRC 52+58	300
lunghezze - lengths		mm 835 - 415 - fraz		

US 114/88° R0,8

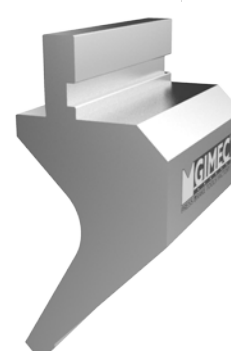
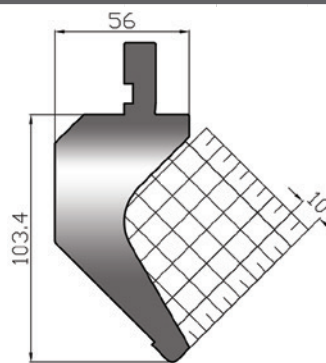
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
89,65	88°	0,8	C45 T HRC 52+58	600
lunghezze - lengths		mm 835 - 415 - fraz		

US 114/88° R3,0

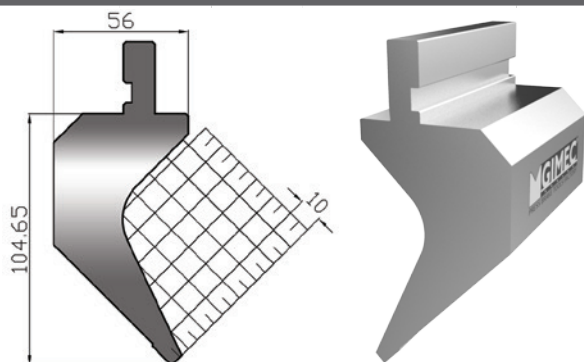
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88,5	88°	3,0	C45 T HRC 52+58	600
lunghezze - lengths		mm 835 - 415 - fraz		

US 115/88° R0,8

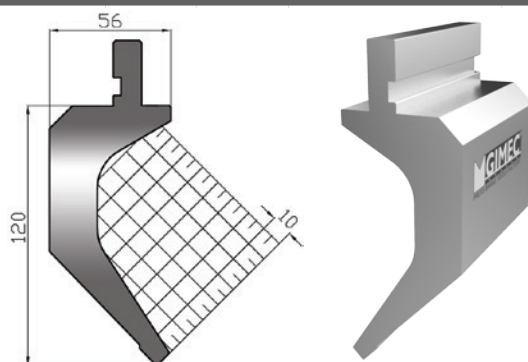
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
104,65	88°	0,8	C45 T HRC 52+58	500
lunghezze - lengths		mm 835 - 415 - fraz		

US 115/88° R3,0

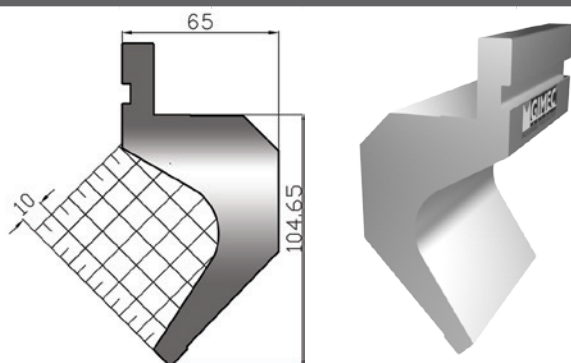
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
103,4	88°	3,0	C45 T HRC 52+58	500
lunghezze - lengths		mm 835 - 415 - fraz		

US 144/88° R0,8

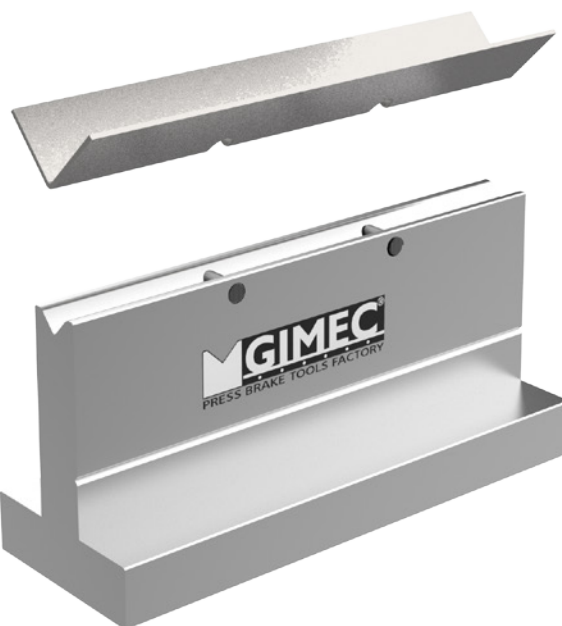
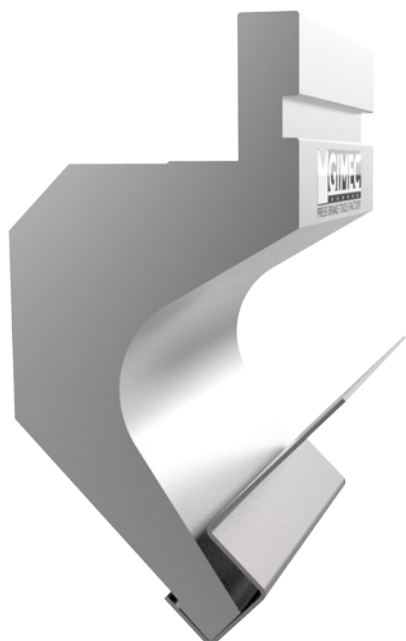
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
104,65	88°	0,8	C45 T HRC 52÷58	450
lunghezze - lengths		mm 835 - 415 - fraz		

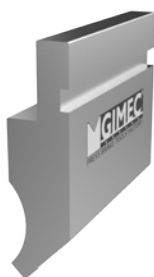
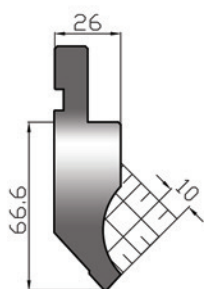
US 152/88° R0,8

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
120,0	88°	0,8	42CM4 T HRC 52÷58	500
lunghezze - lengths		mm 835 - 415 - fraz		

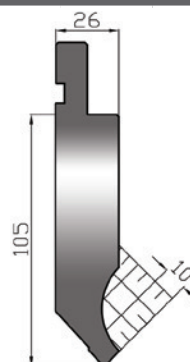
US 158/88° R0,8

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
104,65	88°	0,8	C45 T HRC 52÷58	450
lunghezze - lengths		mm 835 - 415 - fraz		

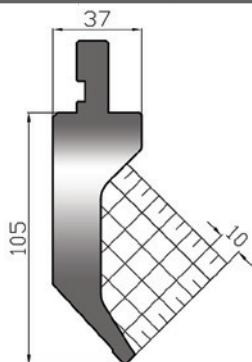


US 110/85° R0,8

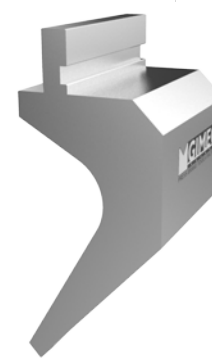
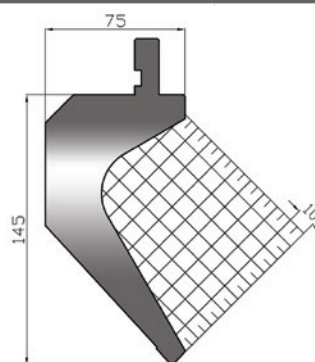
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66,6	85°	0,8	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 110/85° R0,8 h105

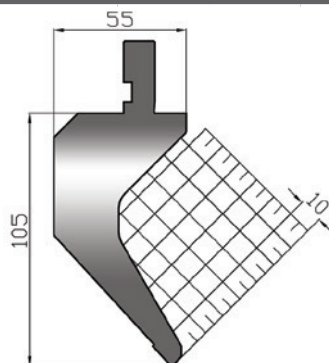
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
105,0	85°	0,8	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 142/85° R0,8

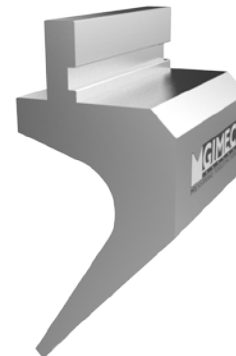
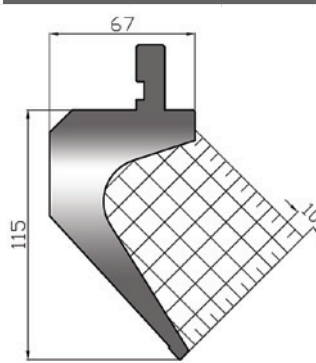
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105,0	85°	0,8	42CM4 T HRC 52+58	600
lunghezze - lengths		mm 835 - 415 - fraz		

US 127/85° R0,8

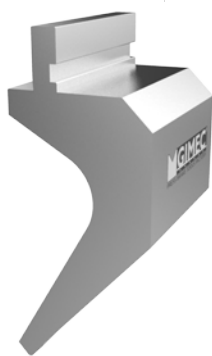
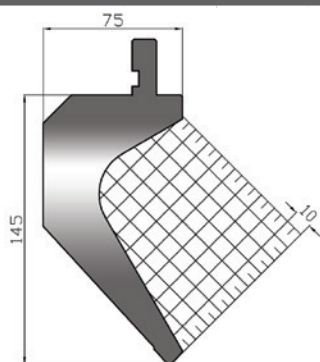
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
145,0	85°	0,8	C45 T HRC 52+58	500
lunghezze - lengths		mm 835 - 415 - fraz		

US 129/85° R0,8

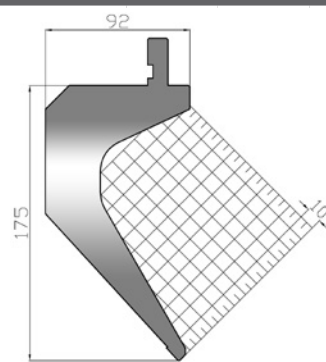
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
105,0	85°	0,8	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 141/85° R0,8

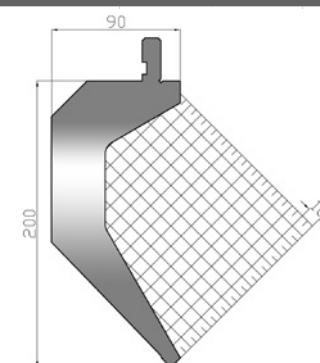
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
115,0	85°	0,8	42CM4 T HRC 52+58	700
lunghezze - lengths		mm 835 - 415 - fraz		

US 145/85° R2,0

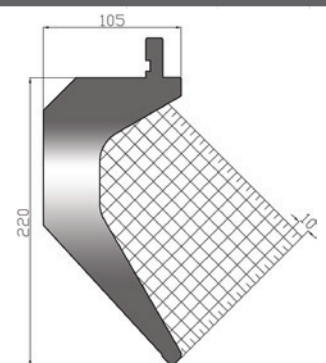
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
145,0	85°	2,0	42CM4 T HRC 52+58	900
lunghezze - lengths		mm 835 - 415 - fraz		

US 146/85° R1,25

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
175,0	85°	1,25	42CM4 T HRC 52+58	900
lunghezze - lengths		mm 835 - 415 - fraz		

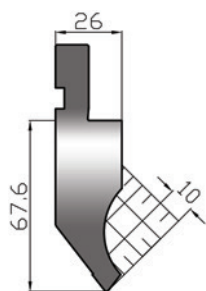
US 153/85° R0,8

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
200,0	85°	0,8	C45 T HRC 52+58	850
lunghezze - lengths		mm 415 - fraz		

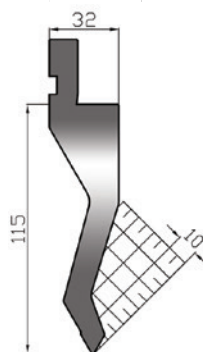
US 156/85° R1,5

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
220,0	85°	1,5	42CM4 T HRC 52+58	850
lunghezze - lengths		mm 415 - fraz		

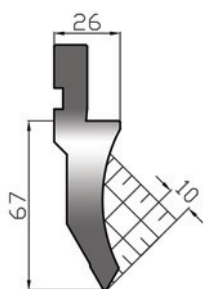


US 110/75° R0,8

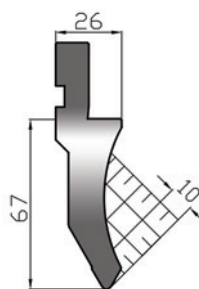
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
67,6	75°	0,8	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 134/60° R0,8

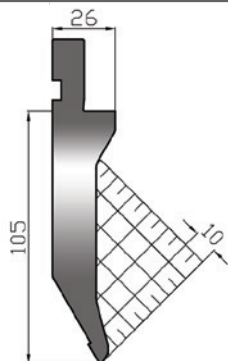
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
115,0	60°	0,8	42CM4 T HRC 52+58	700
lunghezze - lengths		mm 835 - 415 - fraz		

US 124/60° R0,8

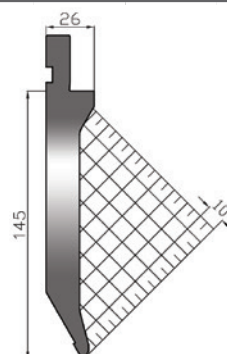
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
67,0	60°	0,8	C45 T HRC 52+58	800
lunghezze - lengths		mm 835 - 415 - fraz		

US 124/60° R2,0

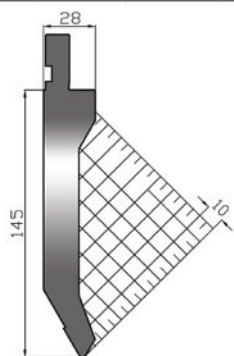
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
67,0	60°	2,0	C45 T HRC 52+58	800
lunghezze - lengths		mm 835 - 415 - fraz		

US 128/60° R0,8

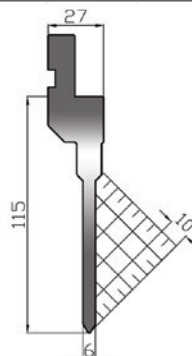
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
105,0	60°	0,8	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 835 - 415 - fraz		

US 135/60° R0,8

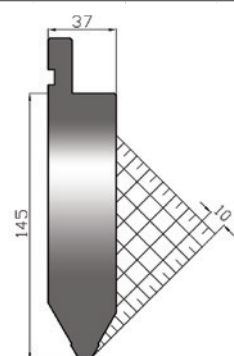
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
145,0	60°	0,8	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 835 - 415 - fraz		

US 136/60° R2,0

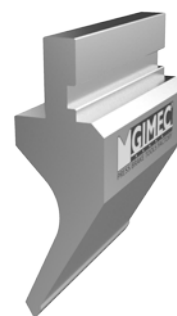
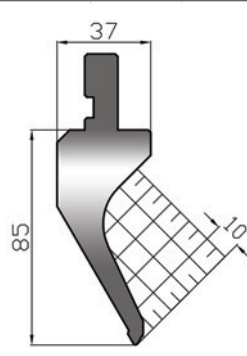
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
145,0	60°	2,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 151/60° R0,8

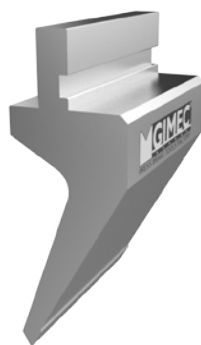
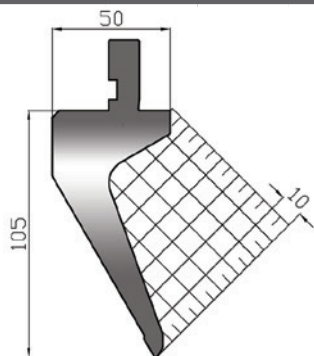
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
115,0	60°	0,8	C45 T HRC 52+58	500
lunghezze - lengths		mm 835 - 415 - fraz		

US 155/60° R5,0

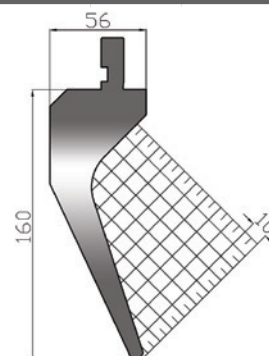
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
145,0	60°	5,0	C45 T HRC 52+58	1600
lunghezze - lengths		mm 835 - 415 - fraz		

US 148/60° R0,8

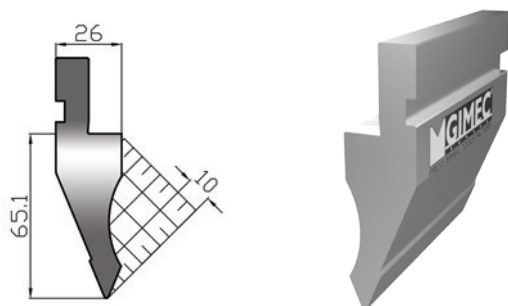
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
85,0	60°	0,8	42CM4 T HRC 52+58	400
lunghezze - lengths		mm 835 - 415 - fraz		

US 132/60° R0,8

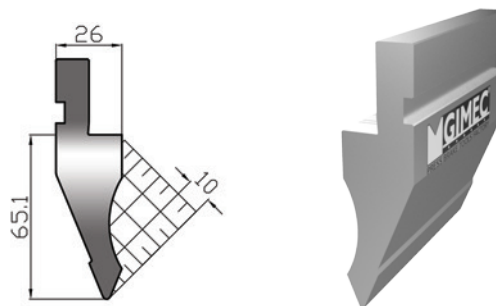
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
105,0	60°	0,8	42CM4 T HRC 52+58	700
lunghezze - lengths		mm 835 - 415 - fraz		

US 150/60° R0,8

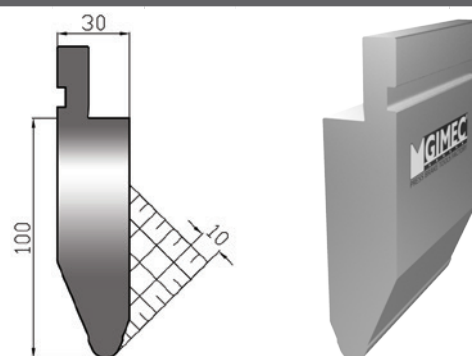
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
160,0	60°	0,8	C45 T HRC 52+58	400
lunghezze - lengths		mm 835 - 415 - fraz		

US 111/45° R0,8

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
65,1	45°	0,8	C45 T HRC 52÷58	800
lunghezze - lengths		mm 835 - 415 - fraz		

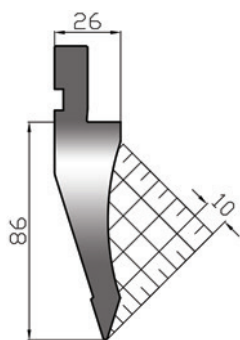
US 111/45° R1,5

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
65,1	45°	1,5	C45 T HRC 52÷58	800
lunghezze - lengths		mm 835 - 415 - fraz		

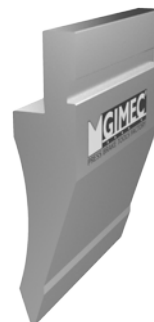
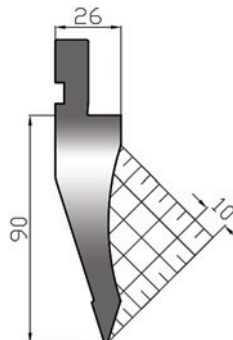
US 149/45° R6,0

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
100,0	45°	6,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

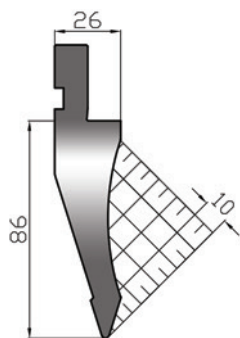


US 112/35° R0,8 h86

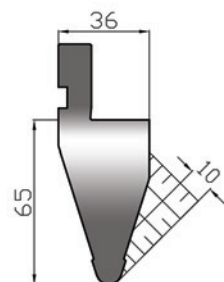
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
86,0	35°	0,8	C45 T HRC 52+58	700
lunghezze - lengths		mm 835 - 415 - fraz		

US 112/35° R0,8 h90

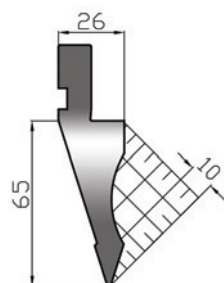
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
90,0	35°	0,8	C45 T HRC 52+58	700
lunghezze - lengths		mm 835 - 415 - fraz		

US 112/35° R1,5 h86

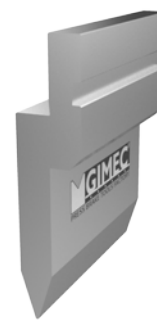
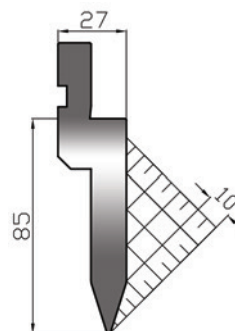
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
86,0	35°	1,5	C45 T HRC 52+58	700
lunghezze - lengths		mm 835 - 415 - fraz		

US 113/35° R5,0

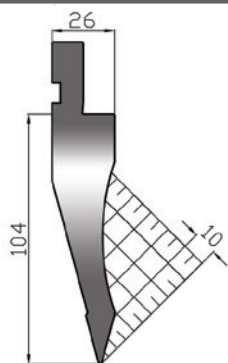
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
65,0	35°	5,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 111/35° R0,8

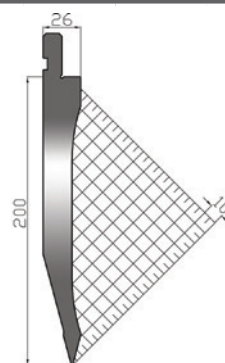
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
65,0	35°	0,8	C45 T HRC 52+58	500
lunghezze - lengths		mm 835 - 415 - fraz		

US 121/35° R0,8

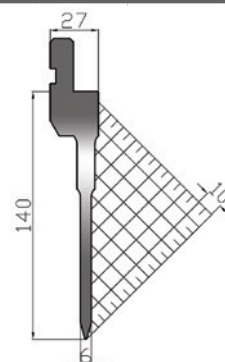
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
85,0	35°	0,8	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 133/30° R0,8

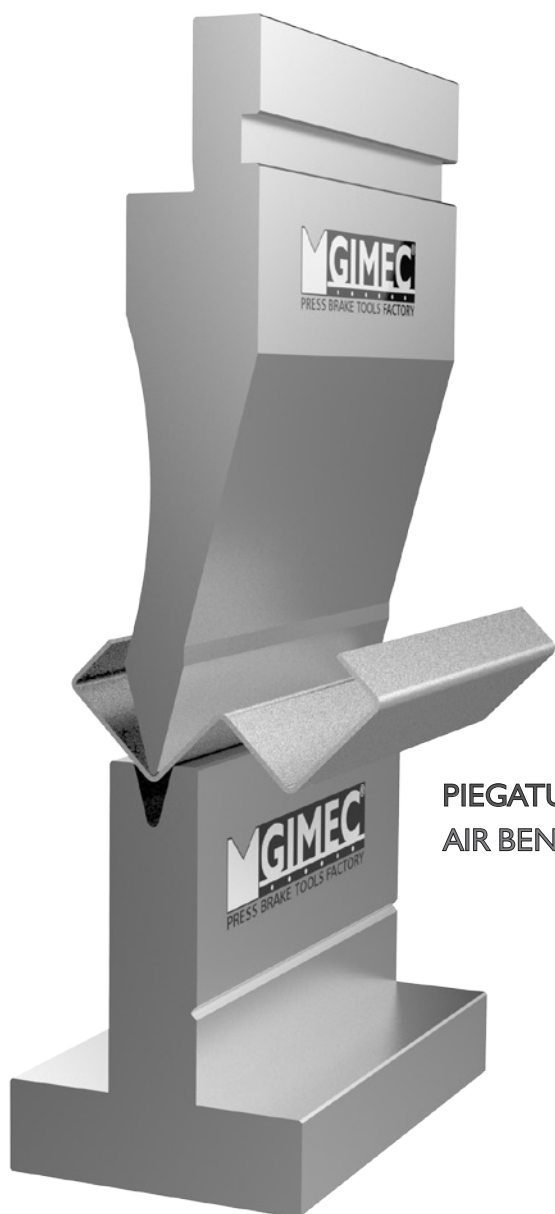
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
104,0	30°	0,8	C45 T HRC 52÷58	700
lunghezze - lengths		mm 835 - 415 - fraz		

US 154/30° R0,5

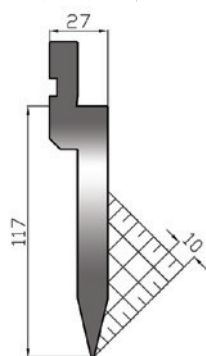
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
200,0	30°	0,5	C45 T HRC 52÷58	500
lunghezze - lengths		mm 835 - 415 - fraz		

US 157/30° R0,6

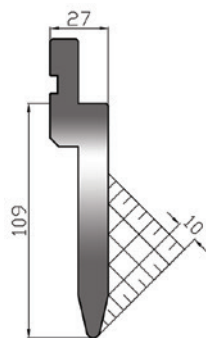
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
140,0	30°	0,6	C45 T HRC 52÷58	400
lunghezze - lengths		mm 835 - 415 - fraz		



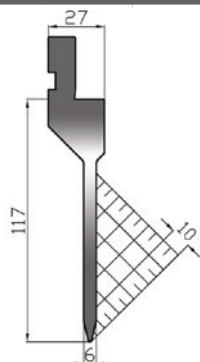
PIEGATURA IN ARIA
AIR BENDING

US 122/26° R0,8

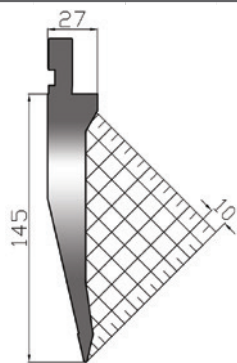
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
117,0	26°	0,8	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 122/26° R3,0

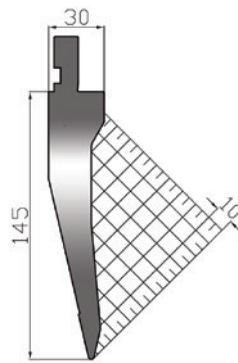
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
109,0	26°	3,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 137/26° R0,8

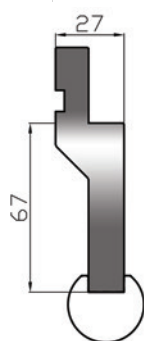
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
117,0	26°	0,8	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 835 - 415 - fraz		

**US 139/26° R0,8**

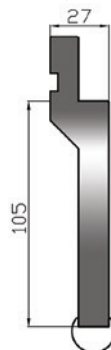
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
145,0	26°	0,8	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 140/26° R1,5

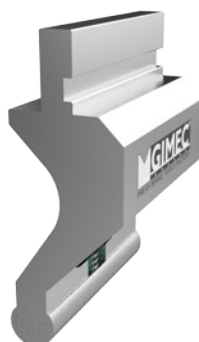
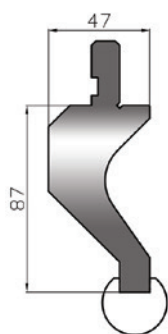
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
145,0	26°	1,5	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 119 h 67

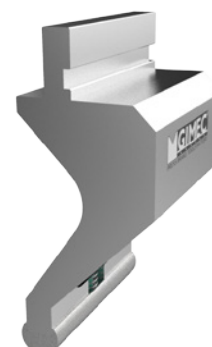
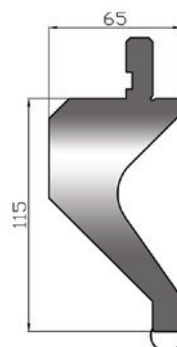
altezza height mm	raggio - radius MIN MAX	acciaio steel	max kN/mt
67,0	8,0 50,0	C45	800
lunghezze - lengths		mm 830 - 412	

US 119 h 105

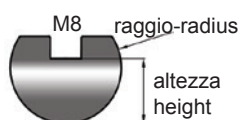
altezza height mm	raggio - radius MIN MAX	acciaio steel	max kN/mt
105,0	8,0 50,0	C45	800
lunghezze - lengths		mm 830 - 412	

US 119 C h 87

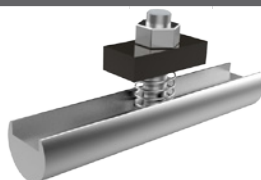
altezza height mm	raggio - radius MIN MAX	acciaio steel	max kN/mt
87,0	8,0 50,0	C45	500
lunghezze - lengths		mm 830 - 412	

US 119 C h 115

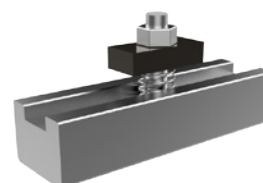
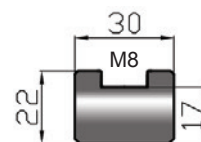
altezza height mm	raggio - radius MIN MAX	acciaio steel	max kN/mt
115,0	8,0 50,0	C45	500
lunghezze - lengths		mm 830 - 412	

US 305 R 8 ÷ 50 mm

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

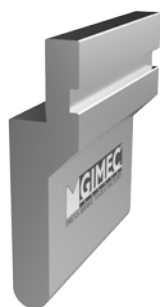
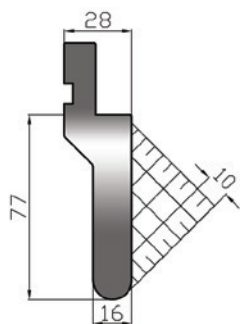


codice articolo item code	raggio radius	altezza height	codice articolo item code	raggio radius	altezza height
US 305/R 8	8	10 mm	US 305/R 25	25	29 mm
US 305/R 9	9	10 mm	US 305/R 27,5	27,5	34 mm
US 305/R 10	10	12 mm	US 305/R 30	30	34 mm
US 305/R 12,5	12,5	17 mm	US 305/R 35	35	45 mm
US 305/R 15	15	20 mm	US 305/R 40	40	44 mm
US 305/R 17,5	17,5	22 mm	US 305/R 45	45	50 mm
US 305/R 20	20	24 mm	US 305/R 50	50	54 mm
US 305/R 22,5	22,5	25 mm			
acciaio - steel			C45 - 39NCM3 nitrurato (N)		
lunghezze - lengths			mm 835 - 415		

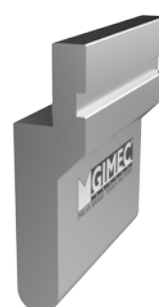
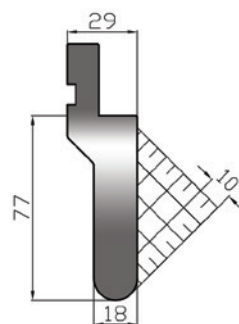
US 310

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

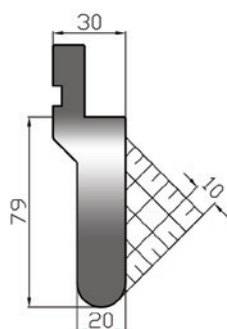
codice articolo item code	acciaio steel
US 310	C45
US 310 T	C45 T HRC 52+58
lunghezze - lengths	mm 835 - 415

US 307 R 8

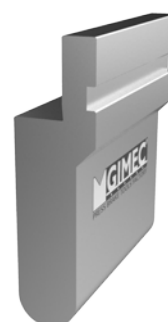
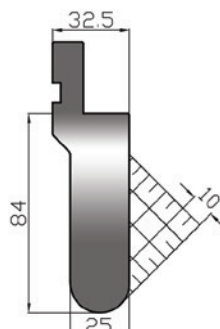
altezza height mm	raggio radius	acciaio steel	max kN/mt
77,0	8,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz	

US 307 R 9

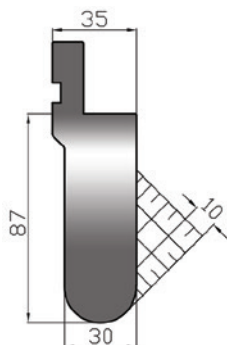
altezza height mm	raggio radius	acciaio steel	max kN/mt
77,0	9,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz	

US 307 R 10

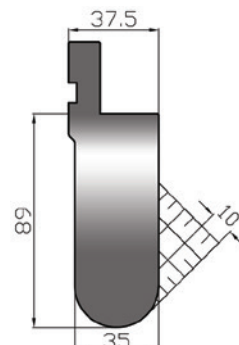
altezza height mm	raggio radius	acciaio steel	max kN/mt
79,0	10,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz	

US 307 R 12,5

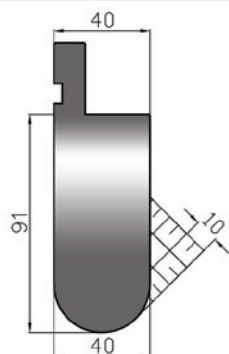
altezza height mm	raggio radius	acciaio steel	max kN/mt
84,0	12,5	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz	

US 307 R 15

altezza height mm	raggio radius	acciaio steel	max kN/mt
87,0	15,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz	

US 307 R 17,5

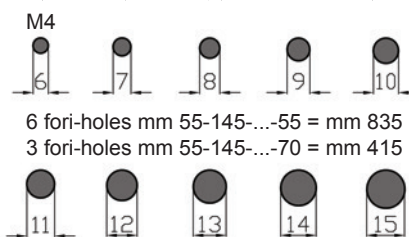
altezza height mm	raggio radius	acciaio steel	max kN/mt
89,0	17,5	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz	

US 307 R 20

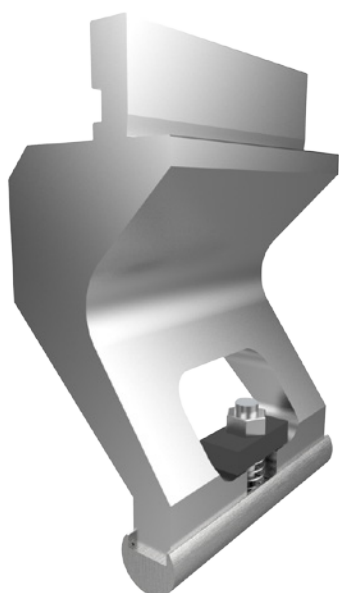
altezza height mm	raggio radius	acciaio steel	max kN/mt
91,0	20,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz	

US 118 h 67 SPESSORE/THICKNESS MAX 3 mm

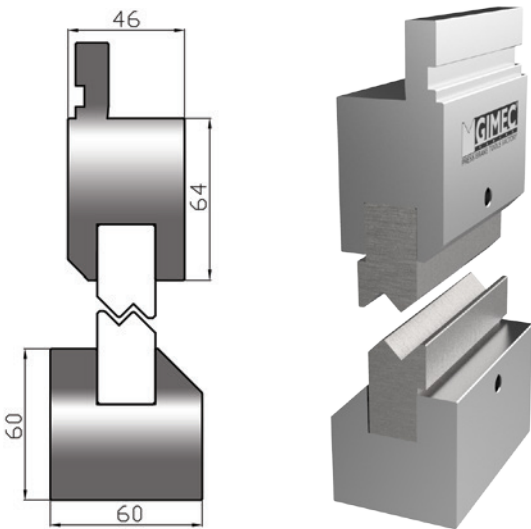
altezza height mm	raggio - radius MIN MAX		acciaio steel	max kN/mt
67,0	3,0	7,5	C45	400
lunghezze - lengths		mm 830 - 412		

US 305 R 3 ÷ 7,5 mm

codice articolo item code	raggio radius	altezza height	codice articolo item code	raggio radius	altezza height
US 305/R 3,0	3,0	6 mm	US 305/R 5,5	5,5	11 mm
US 305/R 3,5	3,5	7 mm	US 305/R 6,0	6,0	12 mm
US 305/R 4,0	4,0	8 mm	US 305/R 6,5	6,5	13 mm
US 305/R 4,5	4,5	9 mm	US 305/R 7,0	7,0	14 mm
US 305/R 5,0	5,0	10 mm	US 305/R 7,5	7,5	15 mm
acciaio - steel			C45		
lunghezze - lengths			mm 835 - 415		

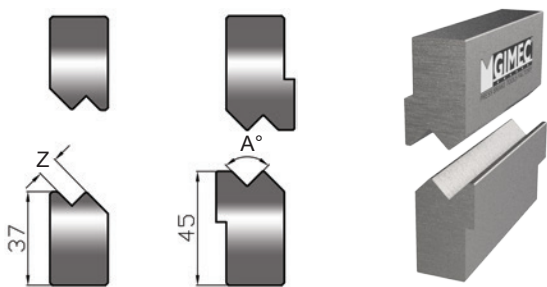


US 130



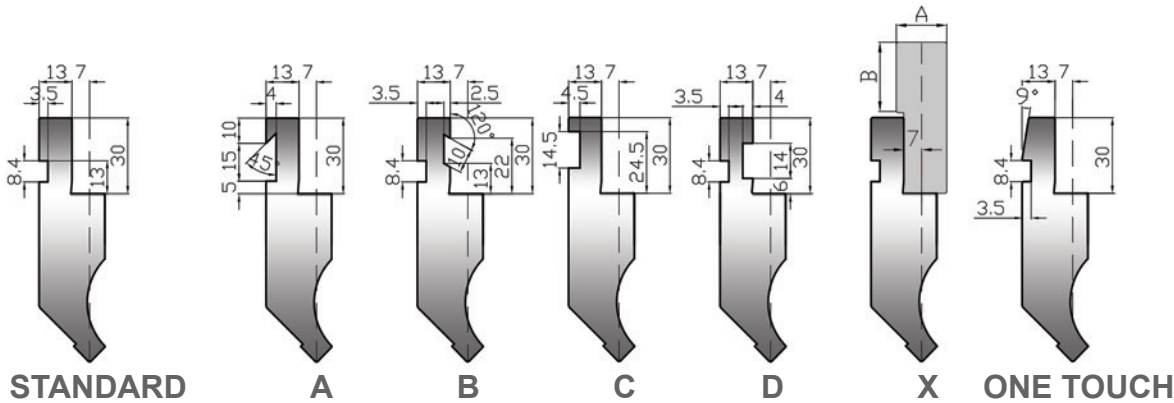
altezza height mm	acciaio steel	max kN/mt
64 + 60	C45	1000
lunghezze - lengths	mm 835 - 415	

US 131 Z 1 ÷ 15 mm

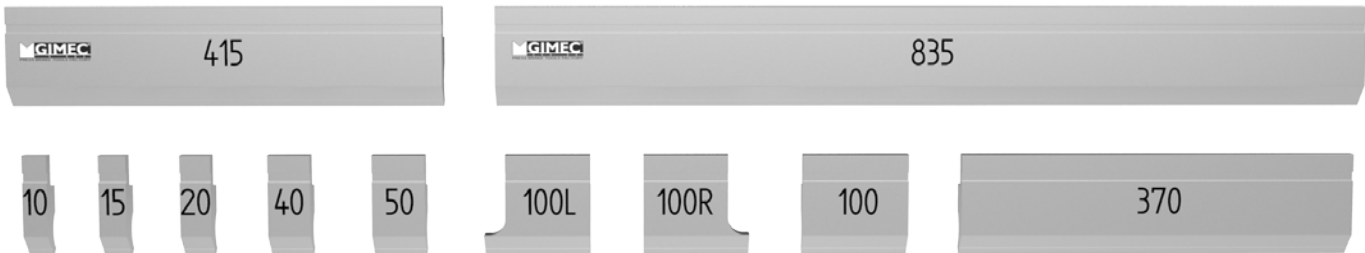


codice articolo item code	Z mm	A°	MAX sp./th.	codice articolo item code	Z mm	A°	MAX sp./th.
US 131 / 1,0	1,0	160°	0,5 mm	US 131 / 6,5	6,5	90°	1,5 mm
US 131 / 1,5	1,5	160°	0,6 mm	US 131 / 7,0	7,0	90°	2,0 mm
US 131 / 2,0	2,0	150°	0,8 mm	US 131 / 7,5	7,5	90°	2,0 mm
US 131 / 2,5	2,5	140°	1,0 mm	US 131 / 8	8	90°	2,5 mm
US 131 / 3,0	3,0	90°	1,0 mm	US 131 / 9	9	90°	2,5 mm
US 131 / 3,5	3,5	90°	1,2 mm	US 131 / 10	10	90°	3,0 mm
US 131 / 4,0	4,0	90°	1,2 mm	US 131 / 11	11	90°	3,0 mm
US 131 / 4,5	4,5	90°	1,5 mm	US 131 / 12	12	90°	3,0 mm
US 131 / 5,0	5,0	90°	1,5 mm	US 131 / 13	13	90°	3,0 mm
US 131 / 5,5	5,5	90°	1,5 mm	US 131 / 14	14	90°	3,0 mm
US 131 / 6,0	6,0	90°	1,5 mm	US 131 / 15	15	90°	3,0 mm
acciaio - steel				C45 T HRC 52÷58			
lunghezze - lengths				mm 835 - 415			

ATTACCHI SPECIALI • SPECIAL CLAMPINGS



LUNGHEZZE • LENGTHS mm 835 - 415 - 805 fraz 10+15+20+40+50+100+100L+100R+370





US 220/26° h.mm.80

26°

US 420/26° h.mm.120



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt	codice articolo item code
US 220/26° V06	6	0,80	16	r 1,0	250	US 420/26° V06
US 220/26° V08	8	1,00	20	r 1,0	250	US 420/26° V08
US 220/26° V10	10	1,20	24	r 1,0	250	US 420/26° V10
US 220/26° V12	12	1,60	26	r 1,0	250	US 420/26° V12



US 220/30° h.mm.80

30°

US 420/30° h.mm.120



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt	codice articolo item code
US 220/30° V06	6	0,60	14	r 1,0	350	US 420/30° V06
US 220/30° V08	8	0,80	18	r 1,2	350	US 420/30° V08
US 220/30° V10	10	1,00	24	r 1,2	500	US 420/30° V10
US 220/30° V12	12	1,50	24	r 1,2	400	US 420/30° V12
US 220/30° V16	16	2,00	30	r 3,0	450	US 420/30° V16
US 220/30° V20	20	2,50	35	r 3,0	500	US 420/30° V20
US 220/30° V25	25	3,00	40	r 3,0	500	US 420/30° V25



US 220/35° h.mm.80

35°

US 420/35° h.mm.120



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt	codice articolo item code
US 220/35° V06	6	0,80	14	r 0,5	350	US 420/35° V06
US 220/35° V08	8	1,00	16	r 0,5	350	US 420/35° V08
US 220/35° V10	10	1,20	20	r 0,5	400	US 420/35° V10
US 220/35° V12	12	1,60	22	r 0,5	400	US 420/35° V12
US 220/35° V16	16	3,00	30	r 2,0	450	US 420/35° V16
US 220/35° V20	20	3,00	35	r 2,0	500	US 420/35° V20
US 220/35° V25	25	3,00	40	r 2,0	500	US 420/35° V25



US 220/45° h.mm.80

45°

US 420/45° h.mm.120



codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt	codice articolo item code
US 220/45° V06	6	0,80	14	r 0,5	500	US 420/45° V06
US 220/45° V08	8	1,00	18	r 0,8	500	US 420/45° V08
US 220/45° V10	10	1,20	18	r 0,8	500	US 420/45° V10
US 220/45° V12	12	1,60	24	r 0,8	500	US 420/45° V12
US 220/45° V16	16	2,75	26	r 2,0	500	US 420/45° V16
US 220/45° V20	20	3,00	30	r 2,0	600	US 420/45° V20
US 220/45° V25	25	3,00	37	r 2,0	700	US 420/45° V25



US 220/60° h.mm.80		60°					US 420/60° h.mm.120	
codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt	codice articolo item code		
US 220/60° V06	6	0,50	14	r 0,5	800	US 420/60° V06		
US 220/60° V08	8	0,80	14	r 0,5	700	US 420/60° V08		
US 220/60° V10	10	0,80	18	r 0,5	800	US 420/60° V10		
US 220/60° V12	12	0,80	18	r 0,5	700	US 420/60° V12		
US 220/60° V16	16	2,75	24	r 2,0	1000	US 420/60° V16		
US 220/60° V20	20	3,00	30	r 2,0	1000	US 420/60° V20		
US 220/60° V25	25	3,00	35	r 2,0	1000	US 420/60° V25		
US 220/60° V06R	6	1,50	14	r 0,5	800	US 420/60° V06R		
US 220/60° V08R	8	1,50	14	r 0,5	700	US 420/60° V08R		
US 220/60° V10R	10	2,75	18	r 0,5	800	US 420/60° V10R		
US 220/60° V12R	12	2,75	18	r 0,5	700	US 420/60° V12R		
US 220/85° h.mm.80		85°					US 420/85° h.mm.120	
codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt	codice articolo item code		
US 220/85° V06	6	2,75	14	r 0,5	1000	US 420/85° V06		
US 220/85° V08	8	2,75	14	r 0,5	1000	US 420/85° V08		
US 220/85° V10	10	2,75	18	r 0,5	1000	US 420/85° V10		
US 220/85° V12	12	2,75	18	r 0,5	1000	US 420/85° V12		
US 220/85° V16	16	2,75	24	r 0,5	1000	US 420/85° V16		
US 220/85° V20	20	3,00	30	r 0,8	1000	US 420/85° V20		
US 220/85° V25	25	3,00	35	r 0,8	1000	US 420/85° V25		
US 220/88° h.mm.80		88°					US 420/88° h.mm.120	
codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt	codice articolo item code		
US 220/88° V06	6	0,40	14	r 0,5	1000	US 420/88° V06		
US 220/88° V08	8	0,50	14	r 0,5	1000	US 420/88° V08		
US 220/88° V10	10	0,80	18	r 0,5	1000	US 420/88° V10		
US 220/88° V12	12	2,75	18	r 0,5	1000	US 420/88° V12		
US 220/88° V16	16	2,75	24	r 0,5	1000	US 420/88° V16		
US 220/88° V20	20	3,00	30	r 0,5	1000	US 420/88° V20		
US 220/88° V25	25	3,00	35	r 0,5	1000	US 420/88° V25		
US 220/88° V06R	6	2,75	14	r 0,5	1000	US 420/88° V06R		
US 220/88° V08R	8	2,75	14	r 0,5	1000	US 420/88° V08R		
US 220/88° V10R	10	2,75	18	r 0,5	1000	US 420/88° V10R		
US 220/90° h.mm.80		90°					US 420/90° h.mm.120	
codice articolo item code	V mm	R mm	S mm	F mm	max kN/mt	codice articolo item code		
US 220/90° V06	6	0,40	14	r 0,5	1000	US 420/90° V06		
US 220/90° V08	8	0,50	14	r 0,5	1000	US 420/90° V08		
US 220/90° V10	10	0,60	18	r 0,5	1000	US 420/90° V10		
US 220/90° V12	12	0,80	18	r 0,5	1000	US 420/90° V12		

acciaio - steel

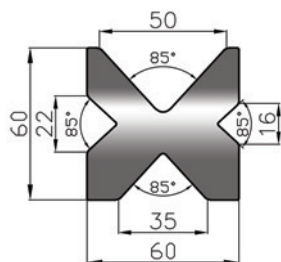
C45 T HRC 52±58

lunghezze - lengths

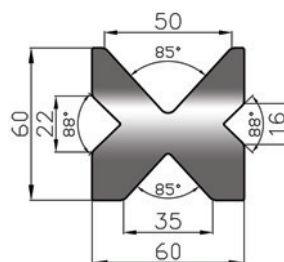
mm 835 - 415 - fraz

serie 60®

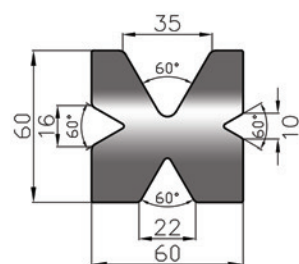
STANDARD TOOLS

US 205/4V (85°)

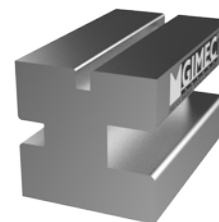
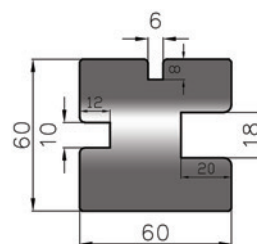
V	16	22	35	50	acciaio steel	max kN/mt
raggio radius	mm 2	mm 2	mm 3	mm 3	C45 T HRC 52+58	800
lunghezze - lengths				mm 835 - 415 - fraz		

US 209/4V (85° 88°)

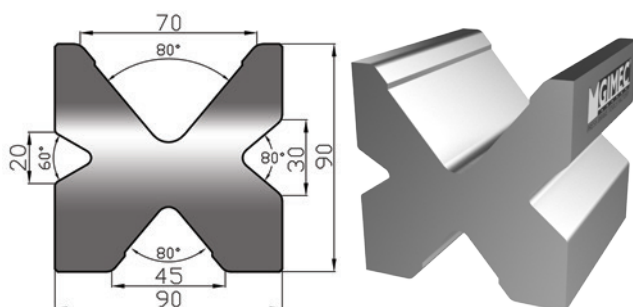
V	16	22	35	50	acciaio steel	max kN/mt
raggio radius	mm 2	mm 2	mm 3	mm 3	C45 T HRC 52+58	800
lunghezze - lengths				mm 835 - 415 - fraz		

US 210/4V (60°)

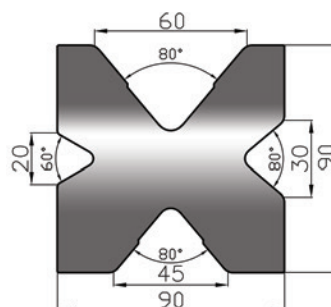
V	10	16	22	35	acciaio steel	max kN/mt
raggio radius	mm 1,5	mm 2	mm 2,5	mm 3	C45 T HRC 52+58	600
lunghezze - lengths				mm 835 - 415 - fraz		

US 208/3U

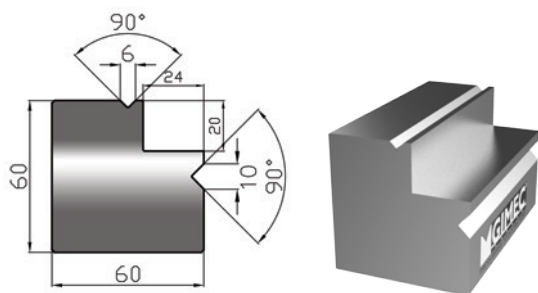
U	6	10	18	acciaio steel	max kN/mt
raggio radius	mm 1,5	mm 2	mm 3,0	C45 T HRC 52+58	1000
lunghezze - lengths				mm 835 - 415 - fraz	

US 203/4V (80° 60°)

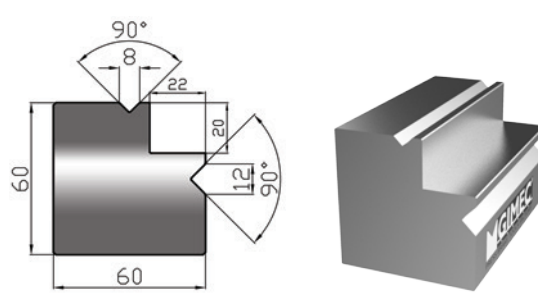
V	20	30	45	70	acciaio steel	max kN/mt
raggio radius	mm 2	mm 4	mm 4	mm 5	C45 T HRC 52+58	600
lunghezze - lengths				mm 835 - 415 - fraz		

US 204/4V (80° 60°)

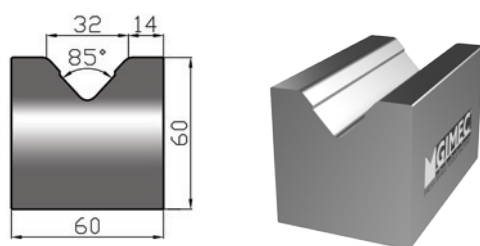
V	20	30	45	60	acciaio steel	max kN/mt
raggio radius	mm 2	mm 4	mm 4	mm 5	C45 T HRC 52+58	1000
lunghezze - lengths				mm 835 - 415 - fraz		

US 216/90° V 6 + 10

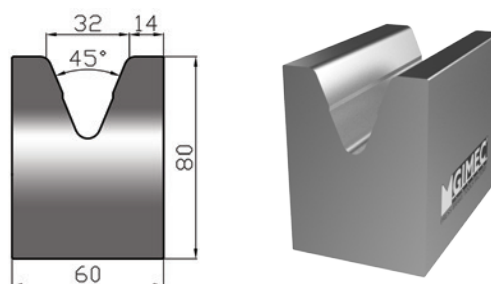
V 90°	mm 6	mm 10	acciaio steel	max kN/mt
raggio radius	mm 0,4	mm 0,6	C45 T HRC 52÷58	800
lunghezze - lengths		mm 835 - 415 - fraz		

US 217/90° V8 + 12

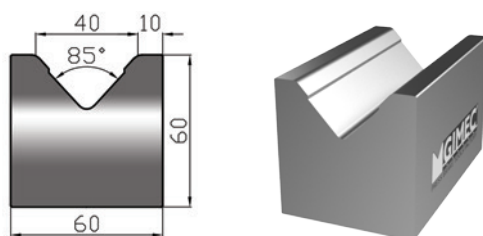
V 90°	mm 8	mm 12	acciaio steel	max kN/mt
raggio radius	mm 0,5	mm 0,8	C45 T HRC 52÷58	800
lunghezze - lengths		mm 835 - 415 - fraz		

US 211/85° V 32

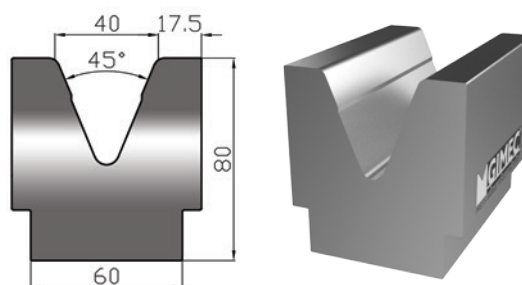
V/85°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 32	mm 60	4,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 220/45° V 32

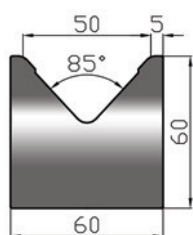
V/45°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 32	mm 80	4,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 211/85° V 40

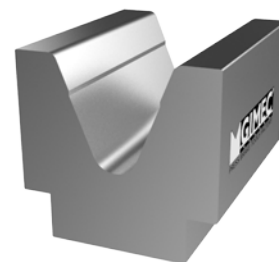
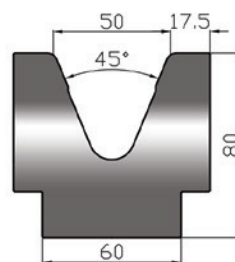
V/85°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 40	mm 60	4,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 220/45° V 40

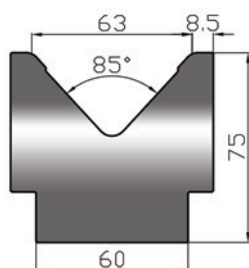
V/45°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 40	mm 80	4,0	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 211/85° V 50

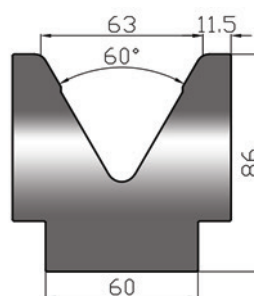
V/85°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 50	mm 60	4,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 220/45° V 50

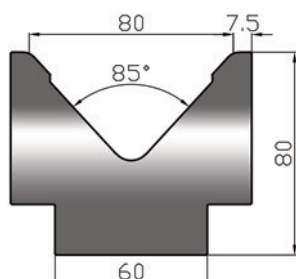
V/45°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 50	mm 80	4,0	C45 T HRC 52+58	900
lunghezze - lengths		mm 835 - 415 - fraz		

US 211/85° V 63

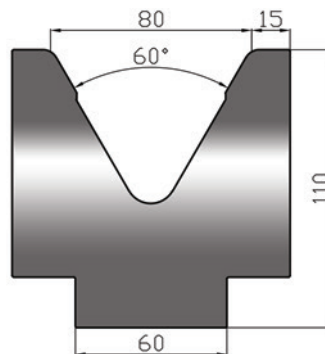
V/85°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 63	mm 75	5,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 220/60° V 63

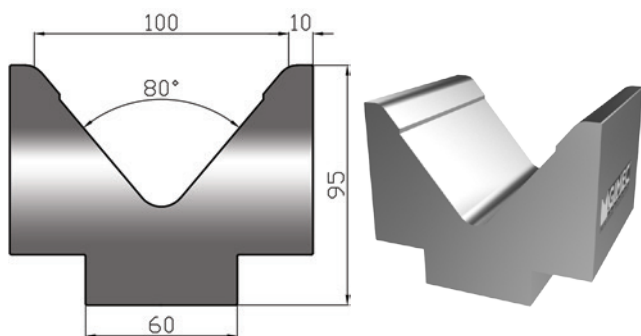
V/60°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 63	mm 86	5,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 211/85° V 80

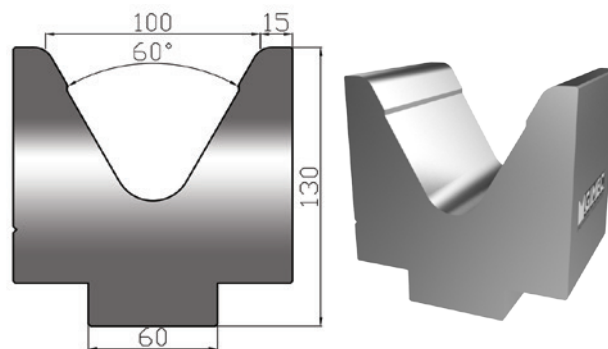
V/85°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 80	mm 80	6,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 220/60° V 80

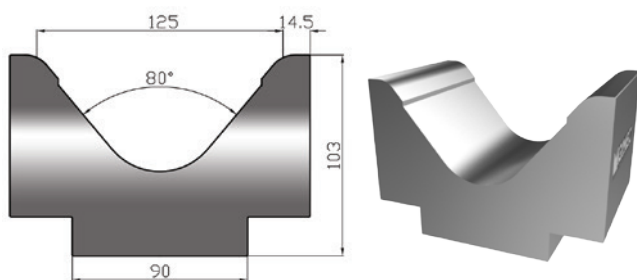
V/60°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 80	mm 110	6,0	C45 T HRC 52+58	1000
lunghezze - lengths		mm 835 - 415 - fraz		

US 211/80° V 100

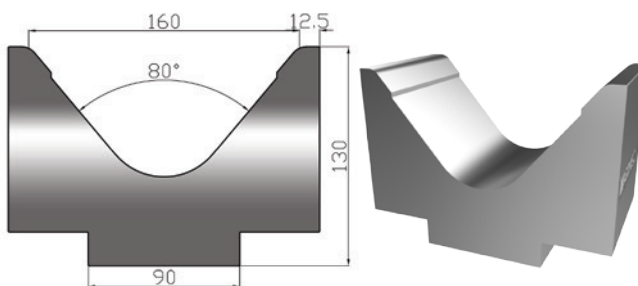
V/80°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 100	mm 95	8,0	C45 T HRC 52÷58	1000
lunghezze - lengths			mm 835 - 415 - fraz	

US 220/60° V 100

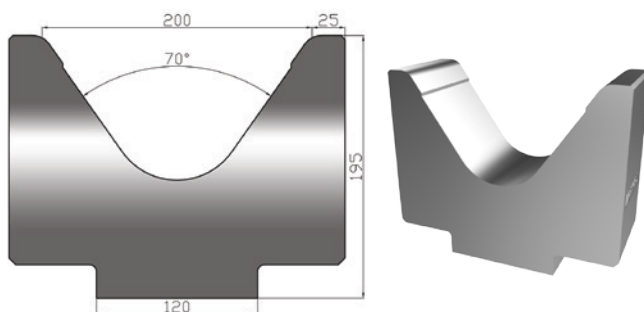
V/60°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 100	mm 130	10,0	C45 T HRC 52÷58	1000
lunghezze - lengths			mm 835 - 415 - fraz	

US 211/80° V 125 base mm 90

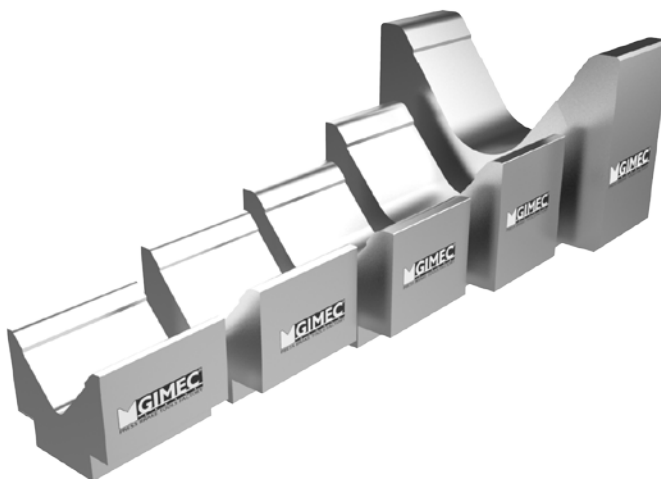
V/80°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 125	mm 103	15,0	C45 T HRC 52÷58	1000
lunghezze - lengths			mm 835 - 415 - fraz	

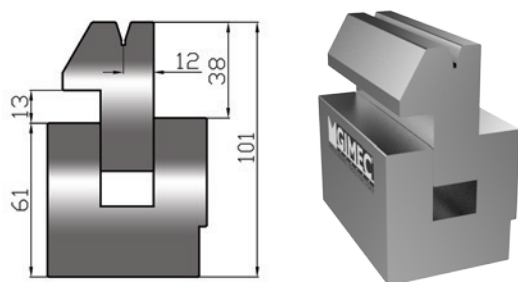
US 211/80° V 160 base mm 90

V/80°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 160	mm 130	10,0	C45 T HRC 52÷58	1000
lunghezze - lengths			mm 835 - 415 - fraz	

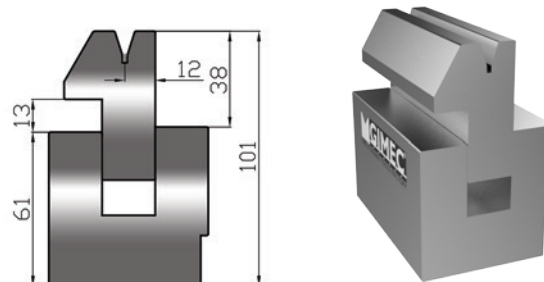
US 211/70° V 200 base mm 120

V/70°	altezza height	raggio radius	acciaio steel	max kN/mt
mm 200	mm 195	15,0	42CM4 T HRC 52÷58	1800
lunghezze - lengths			mm 415 - fraz	

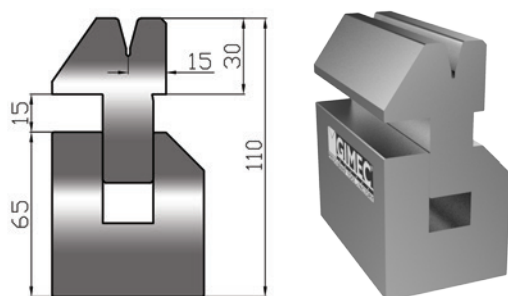


US 303/35° V6

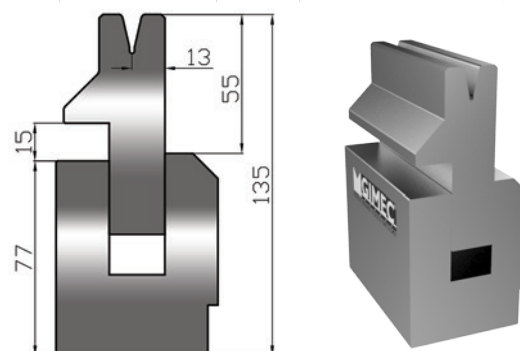
V mm	altezza height	raggio radius	acciaio steel	max kN/mt
6/35°	mm 101-88	1,0	C45 T HRC 52+58	600
lunghezze - lengths			mm 835 - 415	

US 303/35° V8

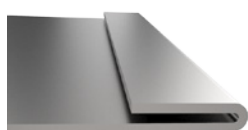
V mm	altezza height	raggio radius	acciaio steel	max kN/mt
8/35°	mm 101-88	1,0	C45 T HRC 52+58	600
lunghezze - lengths			mm 835 - 415	

US 306/30° V8

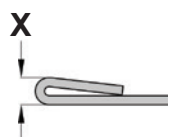
V mm	altezza height	raggio radius	acciaio steel	max kN/mt
mm 8	mm 110-95	1,5	C45 T HRC 52+58	800
lunghezze - lengths			mm 835 - 415	

US 308/26° V8

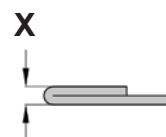
V mm	altezza height	raggio radius	acciaio steel	max kN/mt
mm 8	mm 135-120	1,5	42CM4T HRC52+58	400
lunghezze - lengths			mm 835 - 415	

**SPESSORE 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

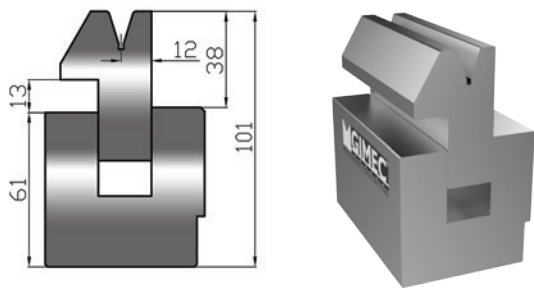
Rm=450 N/mm²
Rm=65000 PSIRm=700 N/mm²
Rm=100000 PSI**POTENZA POWER**

X mm	inches	kN/mt	US t/ft	kN/mt	US t/ft
3,0	.118	90	3	150	5
3,0	.118	120	4	200	7
3,5	.137	150	5	250	8
3,5	.137	170	6	300	9
4,6	.181	220	8	380	13
5,5	.216	300	10	500	17
6,5	.255	550	18	900	31
8,0	.314	700	24	1000	34

Rm=450 N/mm²
Rm=65000 PSIRm=700 N/mm²
Rm=100000 PSI**POTENZA POWER**

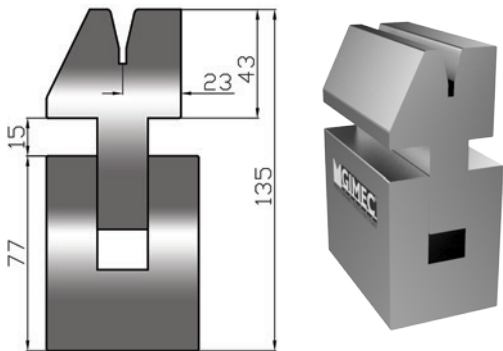
X mm	inches	kN/mt	US t/ft	kN/mt	US t/ft
1,2	.047	230	8	350	12
1,6	.062	320	11	500	17
2,0	.078	400	14	600	21
2,4	.094	500	17	800	27
3,0	.118	630	22	950	32
4,0	.157	800	27	1300	44
5,0	.196	900	31	1800	62
6,0	.236	1000	34	2100	72

US 303/35° V10



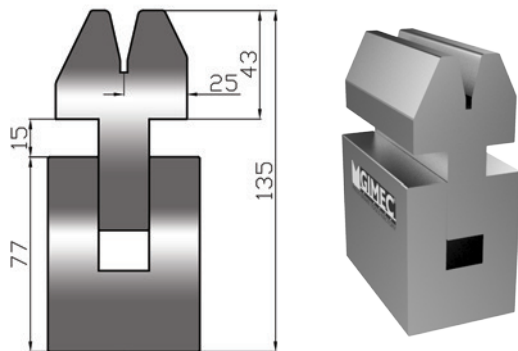
V mm	altezza height	raggio radius	acciaio steel	max kN/mt
10/35°	mm 101-88	1,0	C45 T HRC 52÷58	600
lunghezze - lengths		mm 835 - 415		

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		

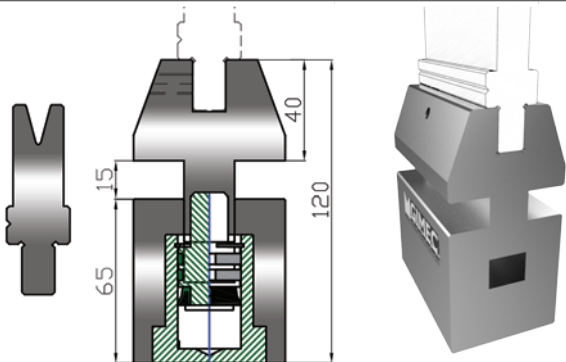
US 300/26° V12



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

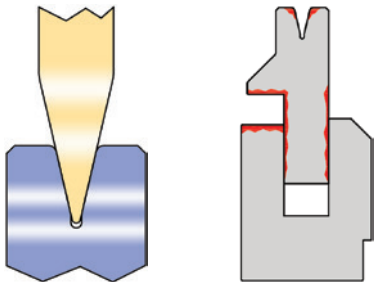


altezza height	acciaio steel	max kN/mt
mm 120-105	C45 T HRC 52÷58	1000
lunghezze - lengths		mm 1000 - 500

AVVERTENZE WARNINGS

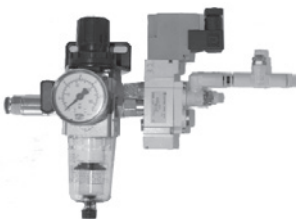
Utilizzare queste matrici con utensili superiori con la stessa gradazione.
La tempra viene eseguita sia sulle parti di lavoro che di scorrimento.

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

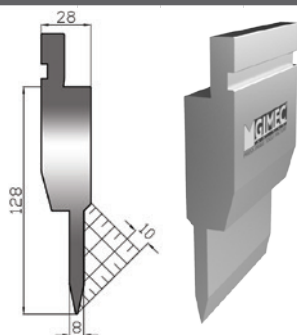


Gli utensili piegasciaccia serie 300 possono essere forniti con cilindri pneumatici per il sollevamento dell'elemento superiore.

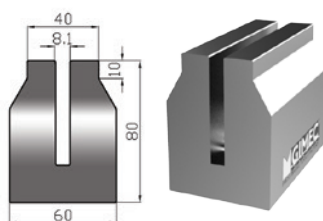
The hemming tools 300 series can be supplied with pneumatic cylinders for moving upper elements.



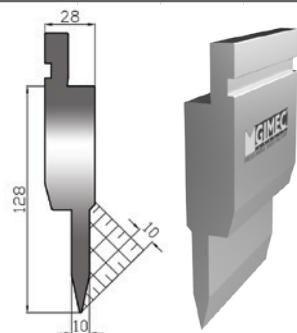
KIT/PNEU

US 138 L 8

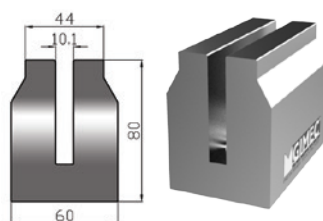
altezza height	angolo degree	raggio radius	max kN/mt
mm 128	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

US 138 M 8

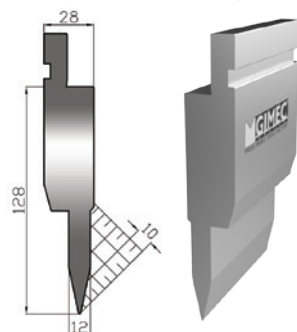
altezza height	V	raggio radius	max kN/mt
mm 80	mm 8	1,0	500
42CM4 T HRC52+58			
mm 835 - 415 - fraz			

US 138 L 10

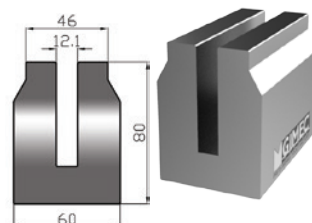
altezza height	angolo degree	raggio radius	max kN/mt
mm 128	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

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.

US 220 NYL 14

lunghezze - lengths

mm 835 - 415

NYLON 14

V mm	angolo degree	V mm	angolo degree	V mm	angolo degree
6	88°	8	88°	10	88°
6	60°	8	60°	10	60°
6	45°	8	45°	10	45°
6	30°	8	30°		

lunghezze - lengths

mm 835 - 415

US 220 NYL 20

lunghezze - lengths

mm 835 - 415

NYLON 20

V mm	angolo degree	V mm	angolo degree	V mm	angolo degree
6	88°	8	45°	12	88°
6	60°	8	30°	12	60°
6	45°	10	88°	12	45°
6	30°	10	60°	16	88°
8	88°	10	45°	16	60°
8	60°	10	30°		

lunghezze - lengths

mm 835 - 415

US 220 NYL 30

lunghezze - lengths

mm 835 - 415

NYLON 30

V mm	angolo degree	V mm	angolo degree	V mm	angolo degree
6	88°	10	88°	16	88°
6	60°	10	60°	16	60°
6	45°	10	45°	16	45°
6	30°	10	30°	16	30°
8	88°	12	88°	20	88°
8	60°	12	60°	20	60°
8	45°	12	45°	20	45°
8	30°	12	30°	25	88°

lunghezze - lengths

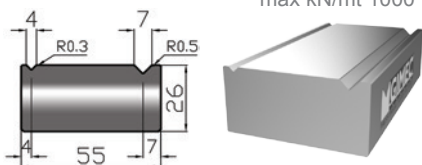
mm 835 - 415

serie 60[®]

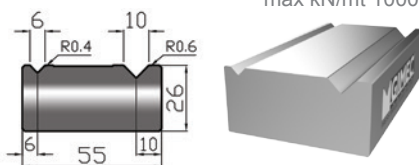
STANDARD TOOLS

US 206/90° V 4 + 7

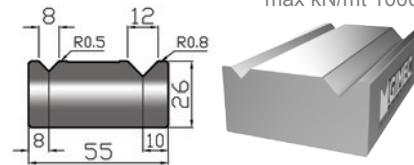
max kN/mt 1000

**US 212/90° V 6 + 10**

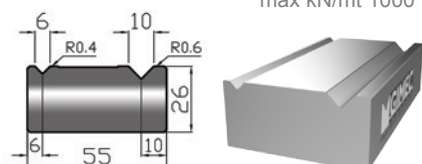
max kN/mt 1000

**US 213/90° V 8 + 12**

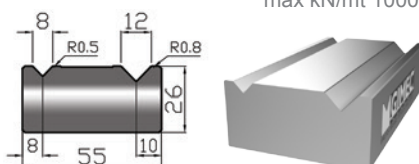
max kN/mt 1000

**US 212/88° V 6 + 10**

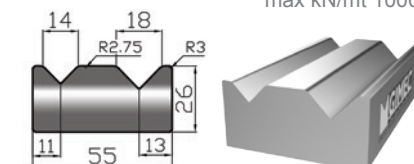
max kN/mt 1000

**US 213/88° V 8 + 12**

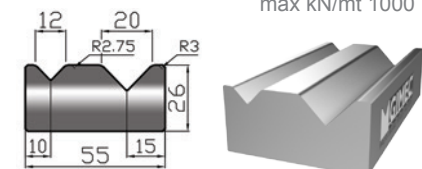
max kN/mt 1000

**US 207/88° V 14 + 18**

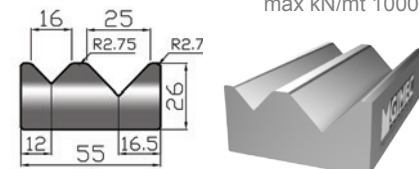
max kN/mt 1000

**US 214/88° V 12 + 20**

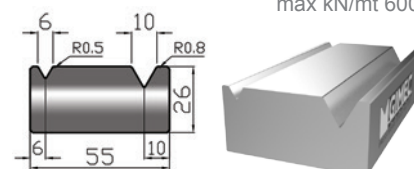
max kN/mt 1000

**US 215/88° V 16 + 25**

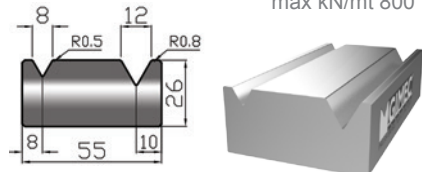
max kN/mt 1000

**US 218/60° V 6 + 10**

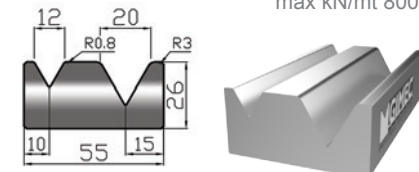
max kN/mt 600

**US 219/60° V 8 + 12**

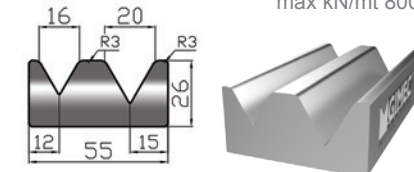
max kN/mt 800

**US 221/60° V 12 + 20**

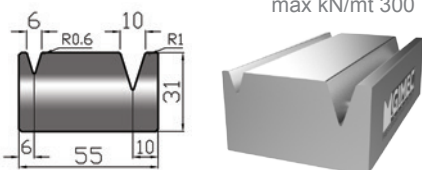
max kN/mt 800

**US 222/60° V 16 + 20**

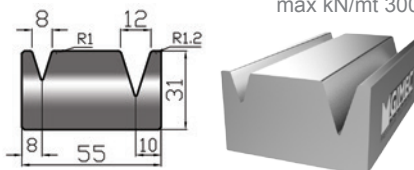
max kN/mt 800

**US 223/35° V 6 + 10**

max kN/mt 300

**US 224/35° V 8 + 12**

max kN/mt 300

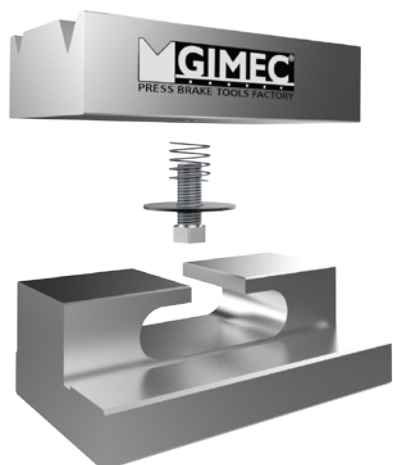
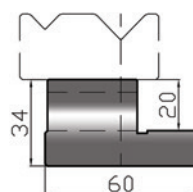


acciaio - steel

C45 T HRC 52+58

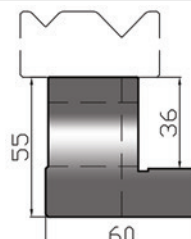
lunghezze - lengths

mm 830 - 412

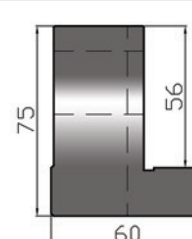
**US 406/34**

altezza - height mm 34

lunghezze - lengths

US 407/55

altezza - height mm 55

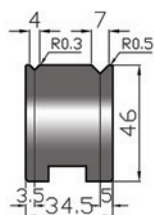
US 408/75

altezza - height mm 75

mm 830 - 410

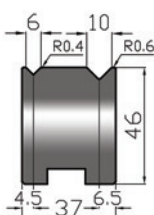
US 510/90° V 4 + 7

max kN/mt 800



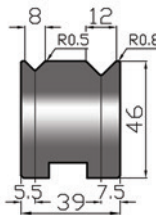
US 520/90° V 6 + 10

max kN/mt 800



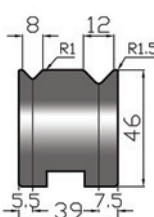
US 530/90° V 8 + 12

max kN/mt 800



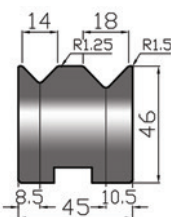
US 540/88° V 8 + 12

max kN/mt 800



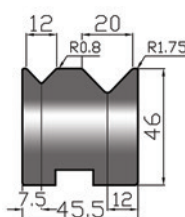
US 550/88° V 14 + 18

max kN/mt 800



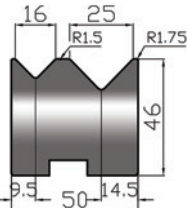
US 560/88° V 12 + 20

max kN/mt 800



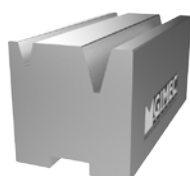
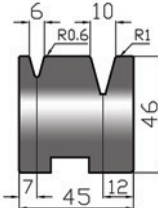
US 570/88° V 16 + 25

max kN/mt 800



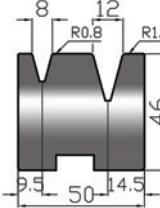
US 580/30° V 6 + 10

max kN/mt 400



US 590/30° V 8 + 12

max kN/mt 400



acciaio - steel

C45 T HRC 52÷58

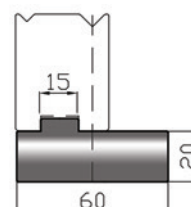
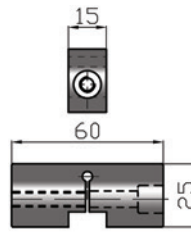
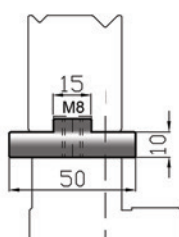
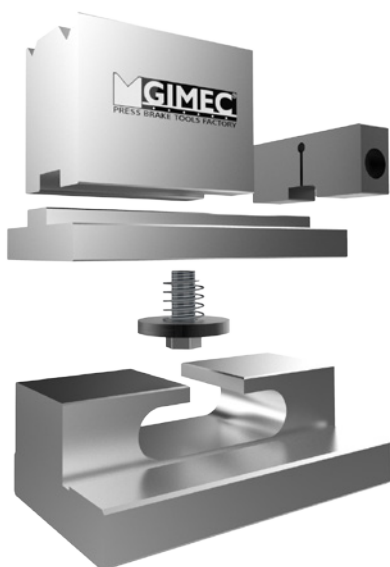
lunghezze - lengths

mm 835 - 415 - fraz

US 500

US 501

US 505

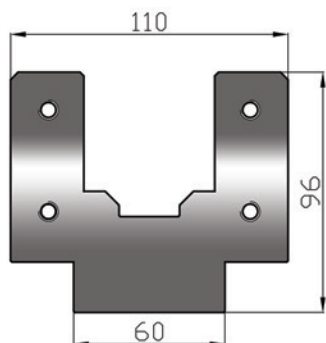


altezza - height mm 34

altezza - height mm 75

lunghezze - lengths

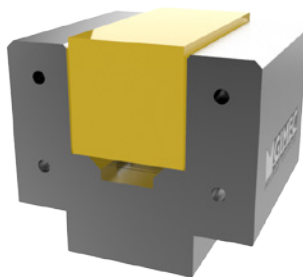
mm 835 - 415

US 250

lunghezze-lengths mm 835 - 415

USG 50

mm 50 x 50

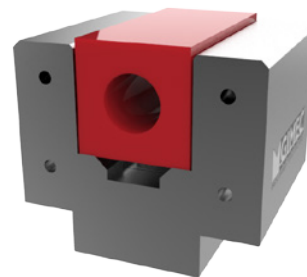


82 Shore (giallo-yellow)

lunghezze-lengths mm 835 - 415

USG 50/F

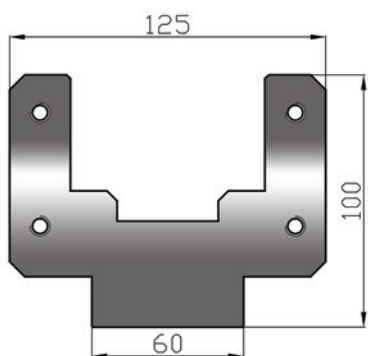
mm 50x50



foro/hole Ø mm 25

92 Shore (rosso-red)

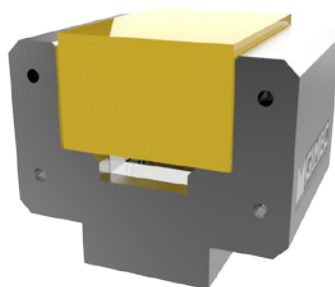
lunghezze-lengths mm 835 - 415

US 275

lunghezze-lengths mm 835 - 415

USG 75

mm 75 x 50

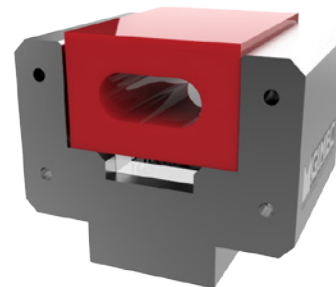


82 Shore (giallo-yellow)

lunghezze-lengths mm 835 - 415

USG 75/F

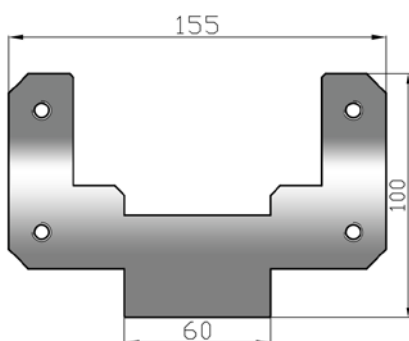
mm 75 x 50



foro/hole mm 20 X 45

92 Shore (rosso-red)

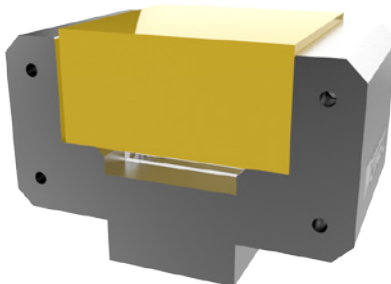
lunghezze-lengths mm 835 - 415

US 2100

lunghezze-lengths mm 835 - 415

USG 100

mm 100 x 50

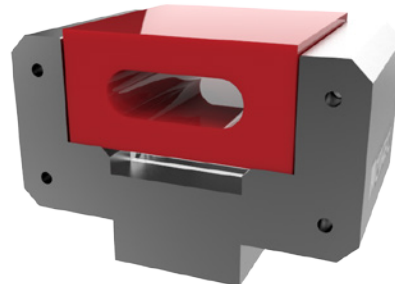


82 Shore (giallo-yellow)

lunghezze-lengths mm 835 - 415

USG 100/F

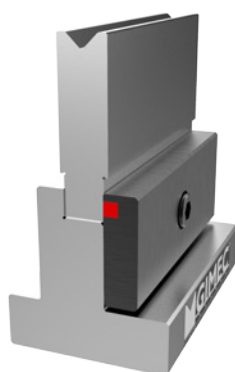
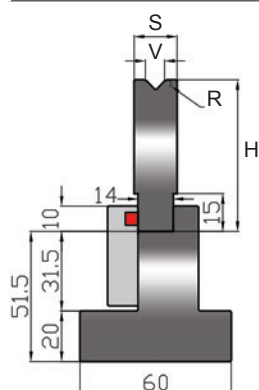
mm 100 x 50



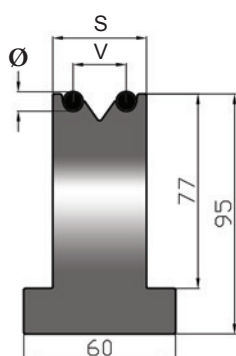
foro/hole mm 20 X 60

92 Shore (rosso-red)

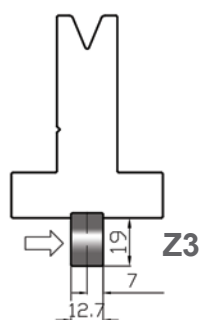
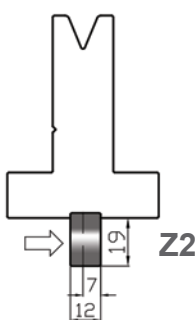
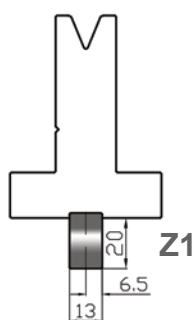
lunghezze-lengths mm 835 - 415

US 600

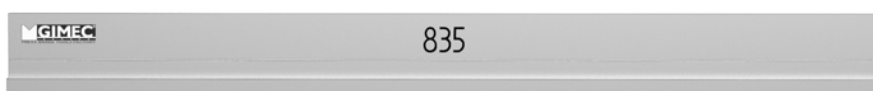
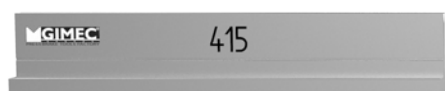
88°	V	H	R	S	max	30°	V	H	R	S	max
mm	mm	mm	mm	mm	kN/mt	mm	mm	mm	mm	mm	kN/mt
US 604/88°	4	60	0,60	14	1000	US 606/30°	6	60	0,60	14	350
US 606/88°	6	60	0,80	14	1000	US 608/30°	8	60	0,80	18	350
US 608/88°	8	60	1,00	14	1000	US 610/30°	10	60	1,00	24	500
US 610/88°	10	60	1,20	18	1000	US 612/30°	12	60	1,50	24	400
US 612/88°	12	60	1,50	18	1000	US 616/30°	16	60	2,00	30	450
US 616/88°	16	60	2,00	24	1000	US 620/30°	20	60	2,50	35	500
US 620/88°	20	60	2,00	30	1000	US 625/30°	25	65	3,00	45	500
US 625/88°	25	60	3,00	35	1000						
lunghezze - lengths mm 835 - 415 - fraz						acciaio - steel C45 T HRC 52÷58					

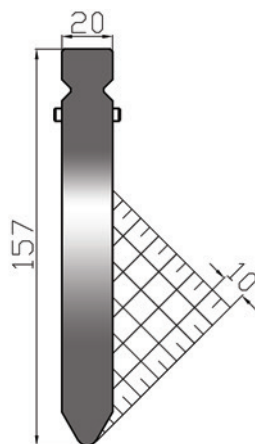
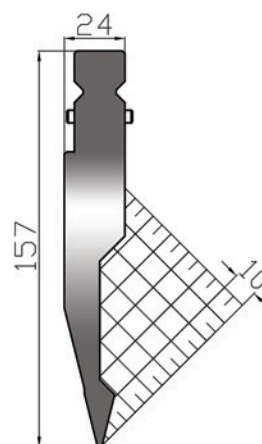
US 700 • MATRICI A RULLI • ROLLER DIES

70°78°30°	V	Ø	S	max	70°78°30°	V	Ø	S	max
mm	mm	mm	mm	kN/mt	mm	mm	mm	mm	kN/mt
US 706/70°	6	6	25	800	US 750/78°	50	10	82	1200
US 708/70°	8	6	26	800	US 760/78°	60	12	102	1300
US 710/70°	10	6	27	800	US 780/78°	80	16	132	1400
US 712/70°	12	6	29	800	US 706/30°	6	6	25	500
US 716/70°	16	8	37	1000	US 708/30°	8	6	26	500
US 720/70°	20	8	42	1000	US 710/30°	10	6	27	500
US 725/70°	25	8	48	1000	US 712/30°	12	6	29	500
US 730/70°	30	8	60	1000	US 716/30°	16	8	40	500
US 740/78°	40	10	72	1100	US 720/30°	20	8	44	500
lunghezze - lengths mm 835 - 415 - fraz					acciaio - steel C45 T HRC 52÷58				

ATTACCHI SPECIALI • SPECIAL CLAMPINGS**LUNGHEZZE • LENGTHS**

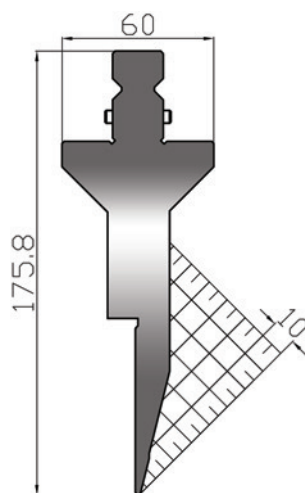
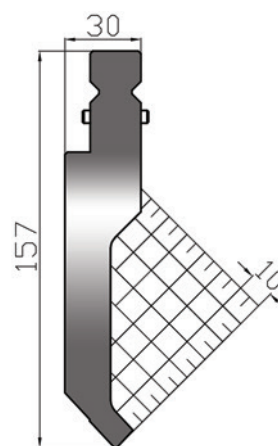
mm 835 - 415 - 805 fraz 10+15+20+40+50+100+200+370



UST 157 S / 60° R4,0**UST 157 X / 28° R1,0****BIU-011/500**

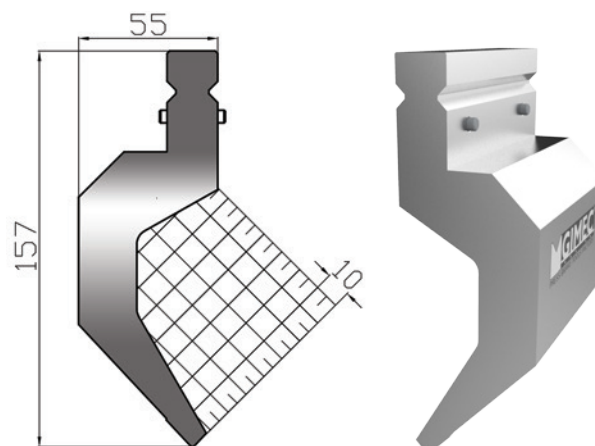
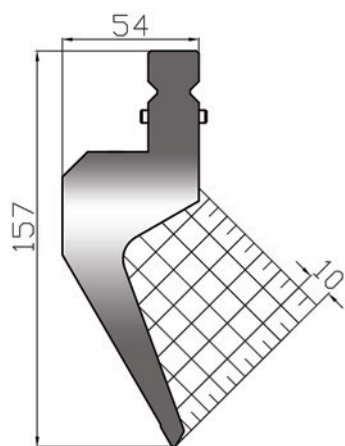
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
157,0	60°	4,0	42CM4 T HRC 52+58	1300
lunghezze - lengths			mm 500 fraz C250 - L550(1A)	

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
157,0	28°	1,0	42CM4 T HRC 52+58	600
lunghezze - lengths			mm 500 fraz C250 - L550(1A)	

UST 176 SP / 28° R1,0**UST 157 D / 86° R1,0****BIU-012/500**

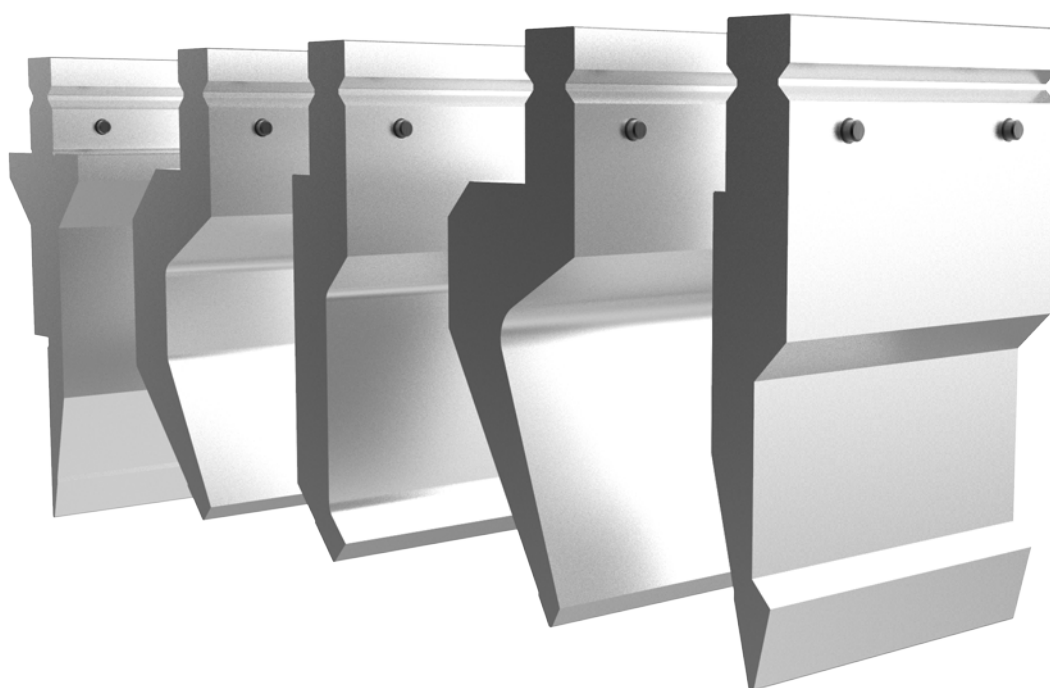
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
175,8	28°	1,0	42CM4 T HRC 52+58	400
lunghezze - lengths			mm 500 fraz C250 - L550(1A)	

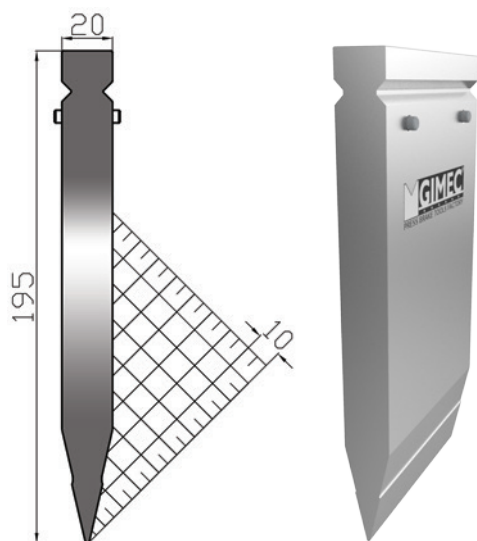
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
157,0	86°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths			mm 500 fraz C250 - L550(1A)	

UST 157 C / 60° R1,0**UST 157 C / 86° R1,0****BIU-013/500**

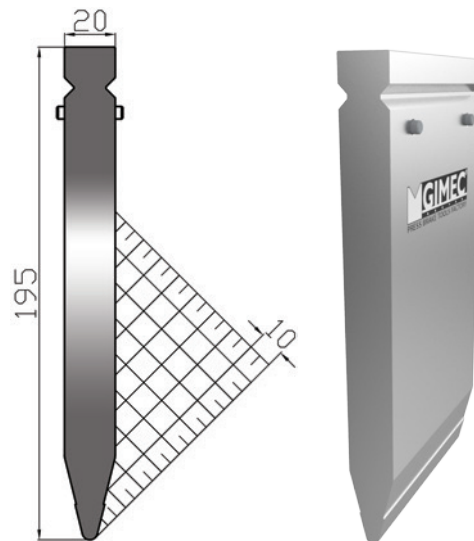
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
157,0	60°	1,0	42CM4 T HRC 52+58	700
lunghezze - lengths		mm 500 fraz C250 - L550(1A)		

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
157,0	86°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500 fraz C250 - L550(1A)		

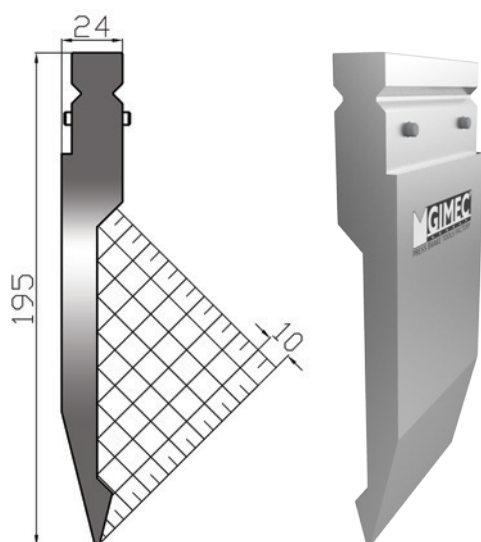
**serie UST®****STANDARD TOOLS**

UST 195 S / 26° R0,8

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	26°	0,8	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500 - fraz P 550		

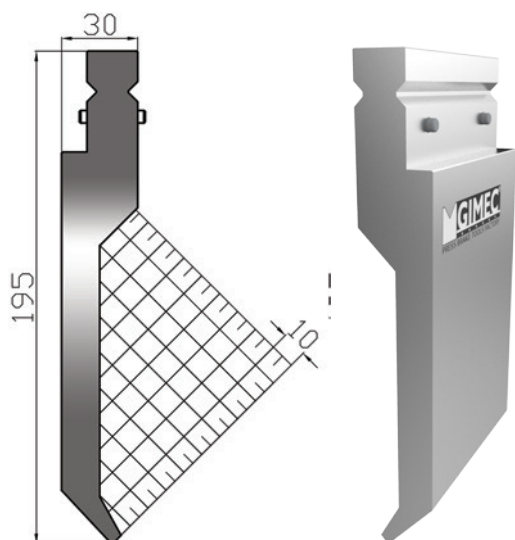
UST 195 S / 28° R3,0

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	28°	3,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500 - fraz P 550		

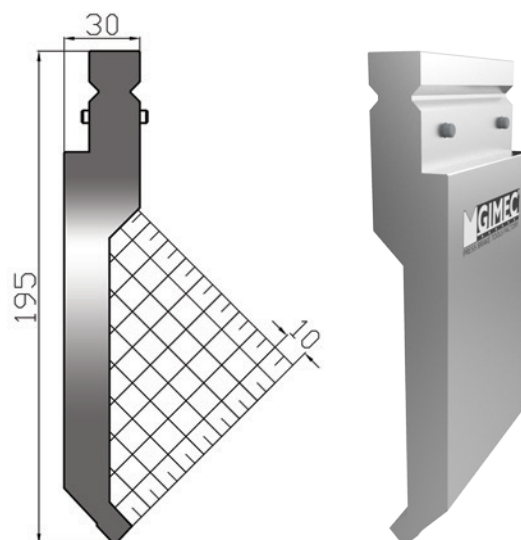
UST 195 X / 28° R1,0

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	28°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500 - fraz P 550		

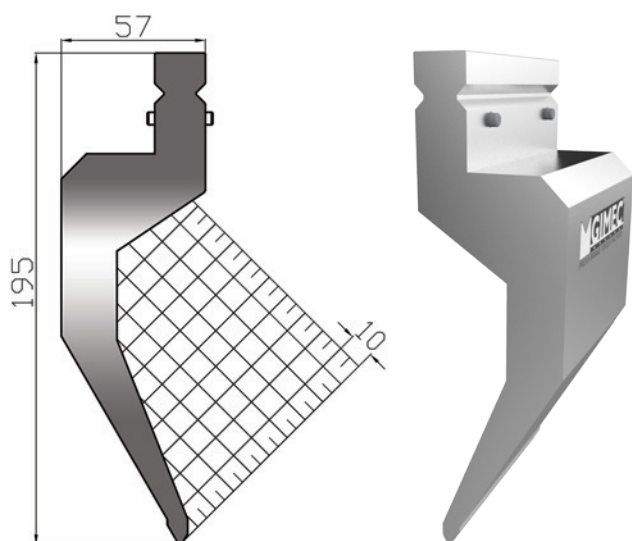


UST 195 D / 86° R0,6

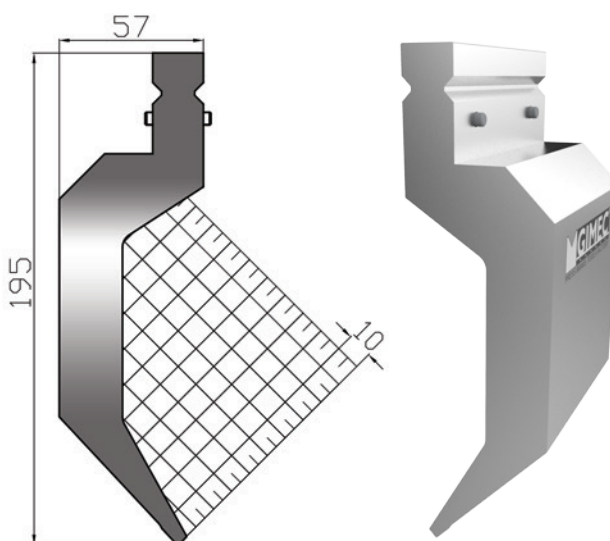
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	86°	0,6	42CM4 T HRC 52+58	300
lunghezze - lengths		mm 500 - fraz P 550		

UST 195 D / 86° R0,8

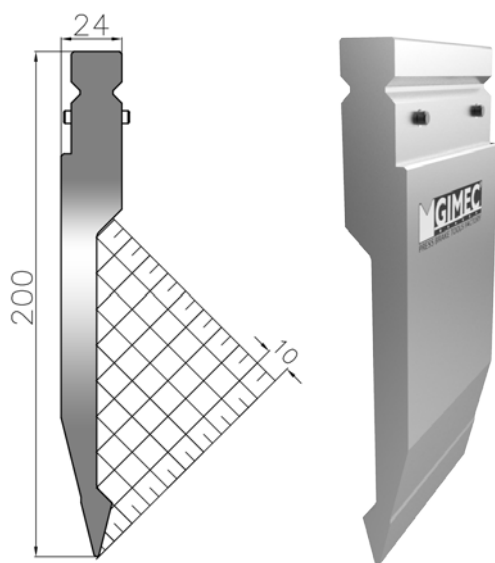
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	86°	0,8	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500 - fraz P 550		

UST 195 C / 60° R0,8

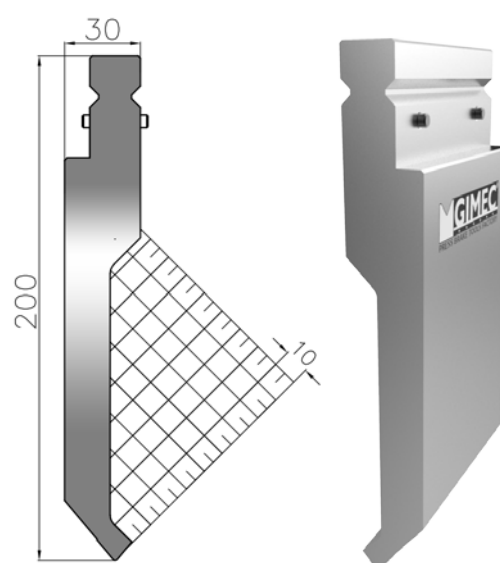
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	60°	0,8	42CM4 T HRC 52+58	400
lunghezze - lengths		mm 500 - fraz P 550		

UST 195 C / 86° R0,8

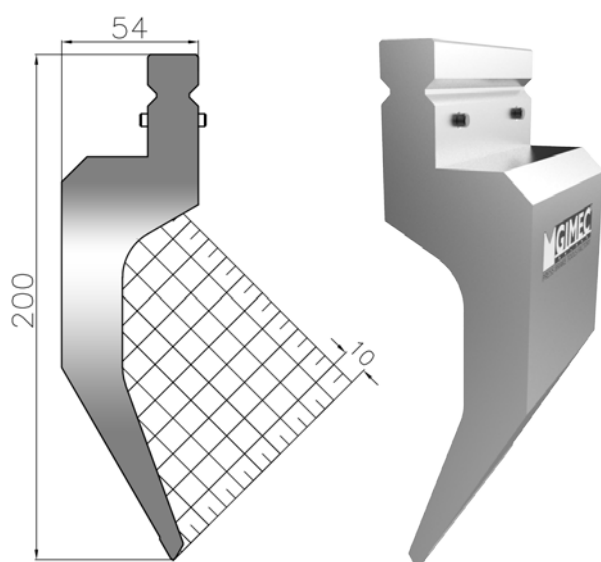
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	86°	0,8	42CM4 T HRC 52+58	400
lunghezze - lengths		mm 500 - fraz P 550		

UST 200 X / 28° R1,0**BIU-021**

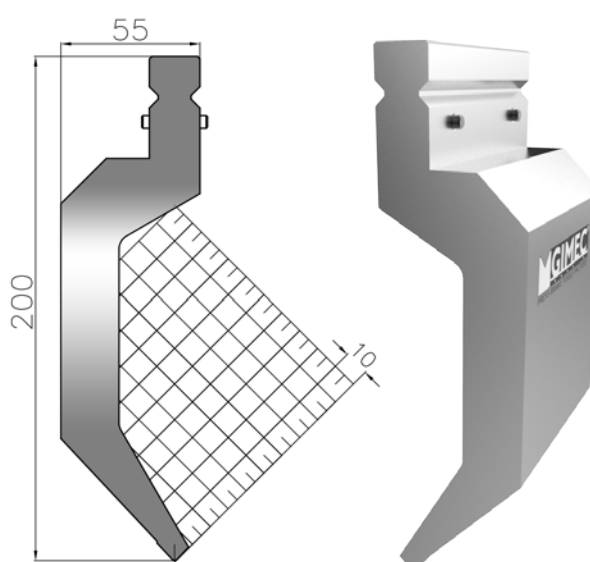
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
200,0	28°	1,0	42CM4 T HRC 52+58	600
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

UST 200 D / 80° R1,0**BIU-022**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
200,0	80°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

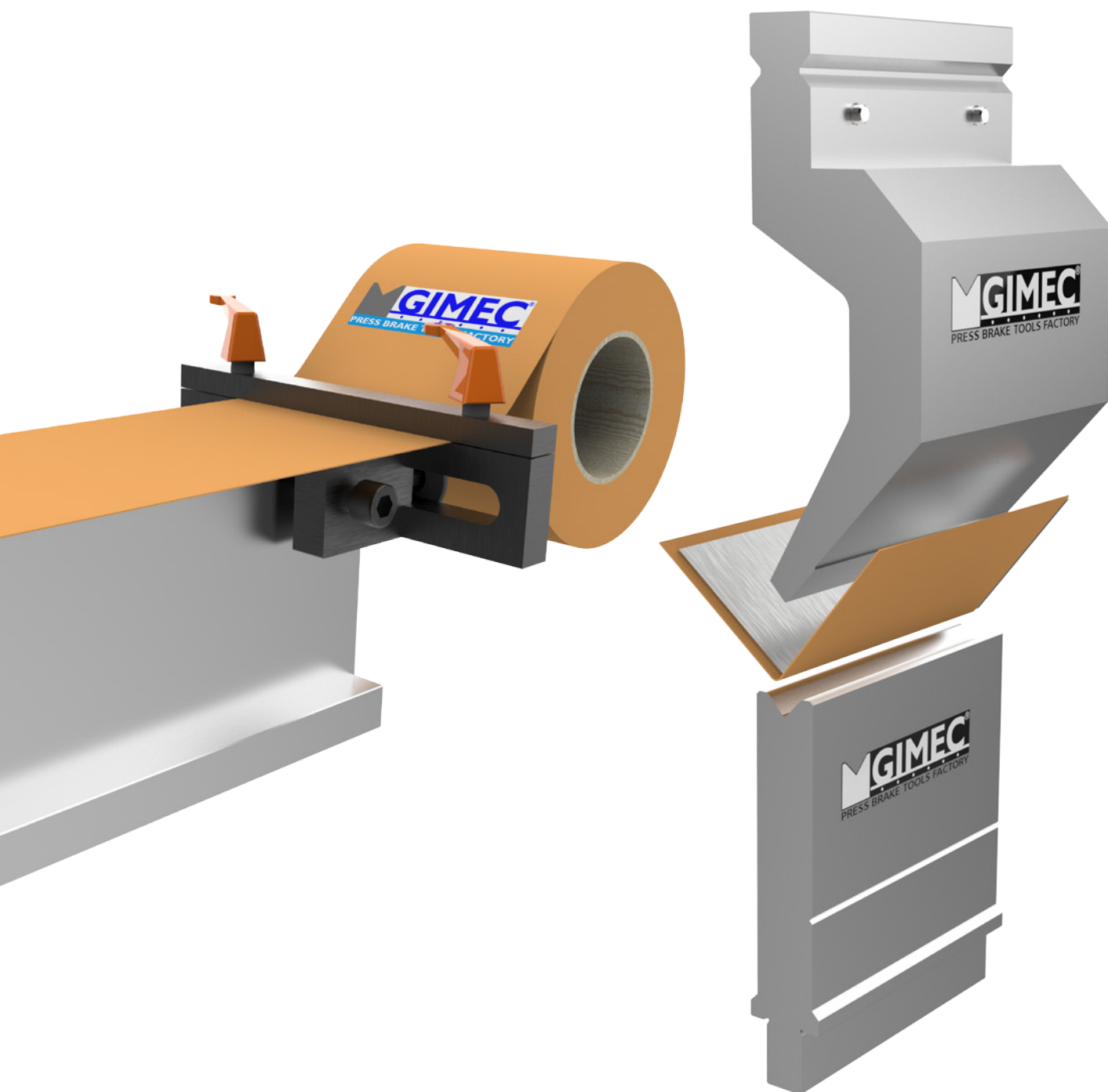
UST 200 C / 60° R1,0

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
200,0	60°	1,0	42CM4 T HRC 52+58	700
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

UST 200 C / 86° R1,0**BIU-023**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
200,0	86°	1,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

GIMEC URET **PELLICOLA ANTIGRAFFIO - DIE COVER FILM**



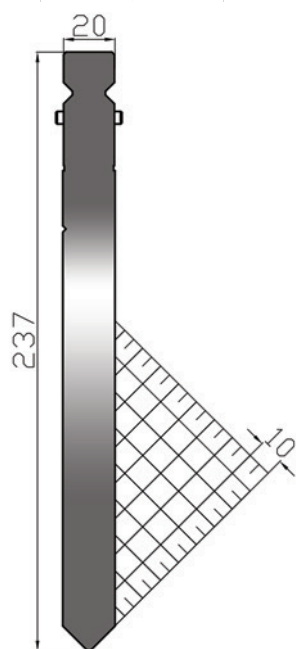
serie UST®

STANDARD TOOLS

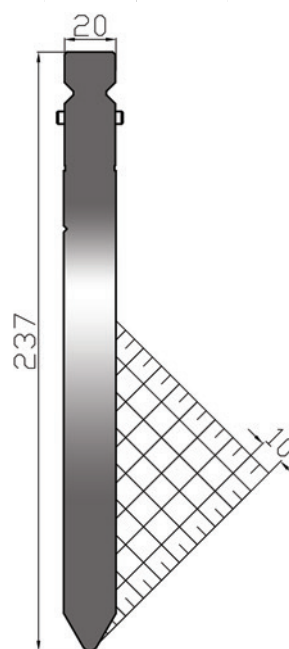
Non troverete in nessun altro luogo una pellicola più tenace e duratura !!!

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

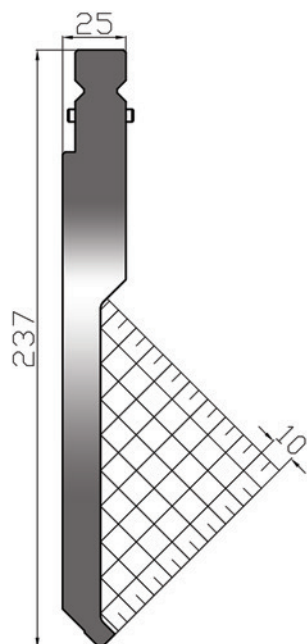
trovala a pagina - find it on page 98

UST 237 S / 90° R1,2**BIU-036**

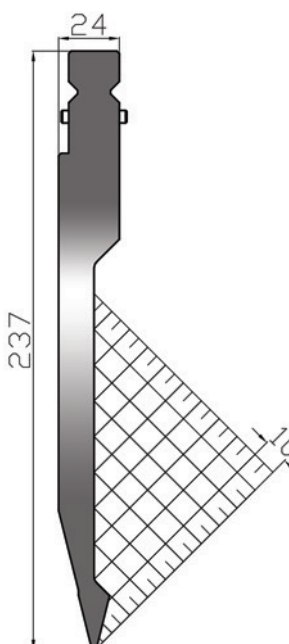
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
237,0	90°	1,2	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

UST 237 S / 60° R3,0**BIU-034**

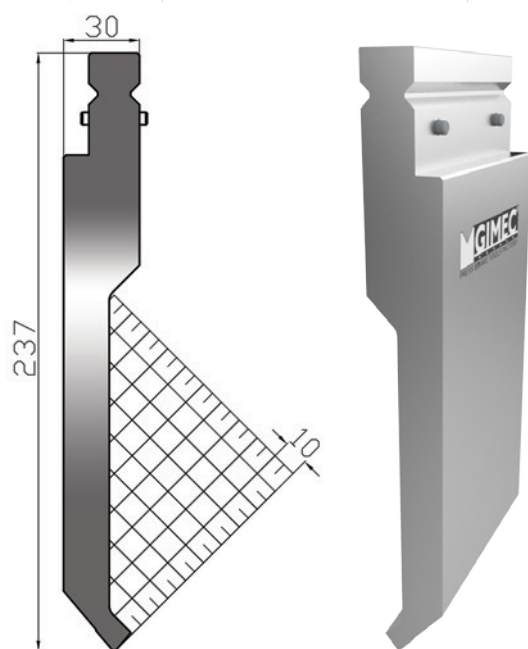
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
237,0	60°	3,0	42CM4 T HRC 52+58	1300
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

UST 237 D / 90° R0,6**BIU-035**

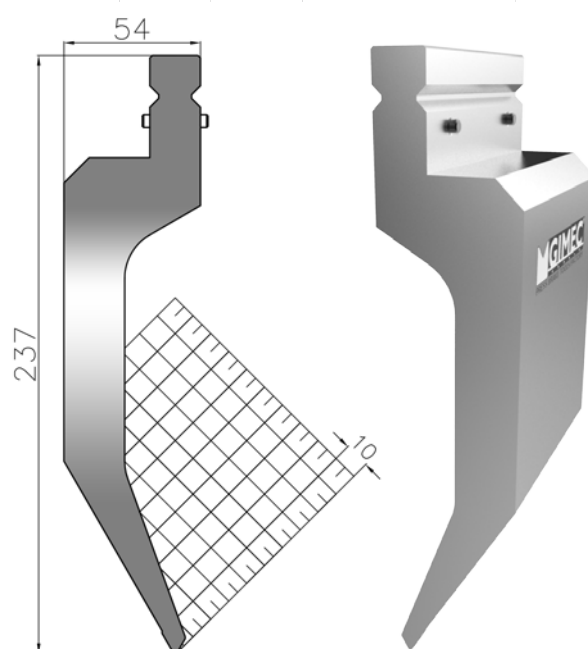
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
237,0	90°	0,6	42CM4 T HRC 52+58	600
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

UST 237 X / 28° R1,0**BIU-031**

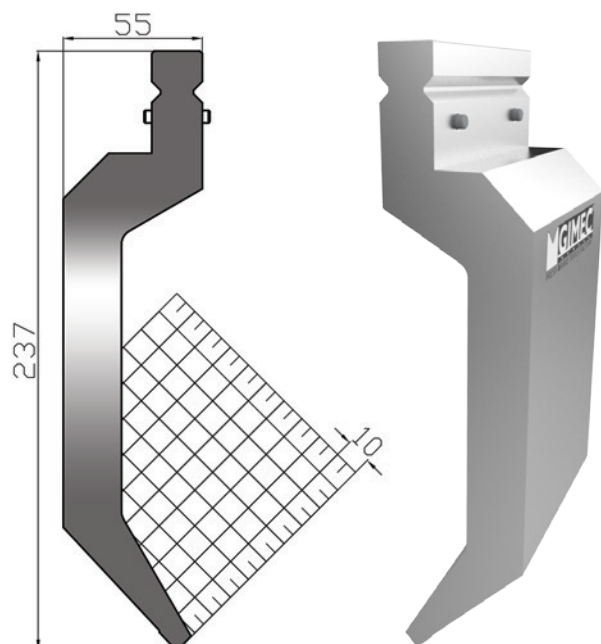
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
237,0	28°	1,0	42CM4 T HRC 52+58	600
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

UST 237 D / 80° R1,0**BIU-032**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
237,0	80°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

UST 237 C / 60° R1,0

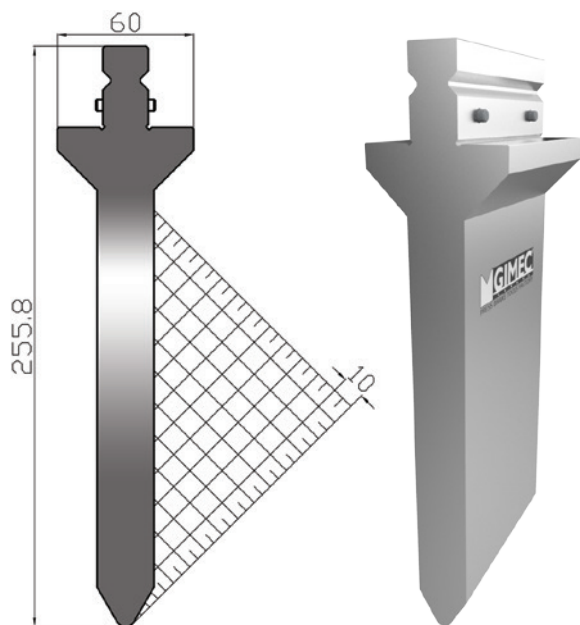
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
237,0	60°	1,0	42CM4 T HRC 52+58	700
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

UST 237 C / 86° R1,0**BIU-033**

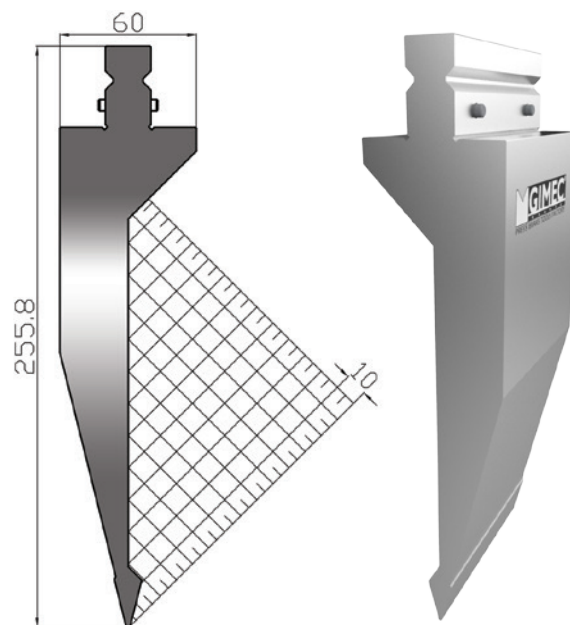
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
237,0	86°	1,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 500-fraz C250 - L550 (2)		

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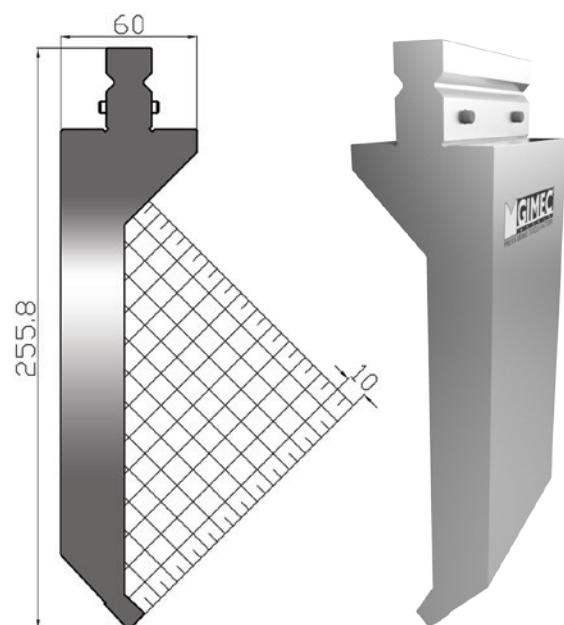
STANDARD TOOLS

UST 60° R4,0/S

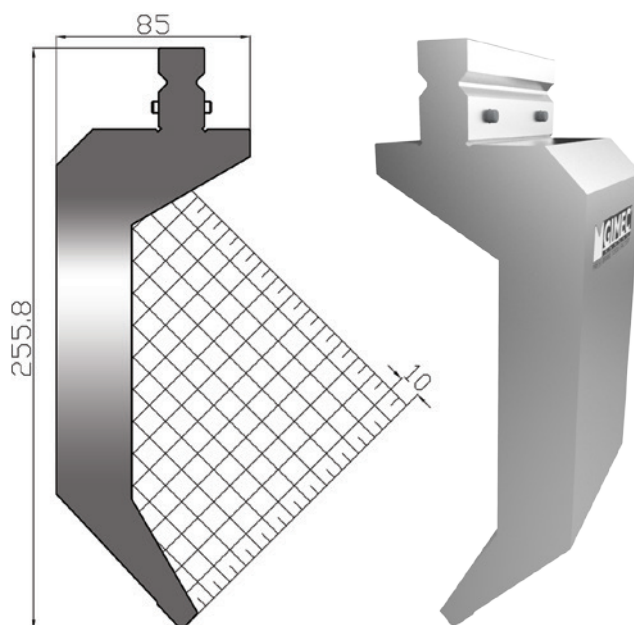
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
255,8	60°	4,0	42CM4 T HRC 52+58	1300
lunghezze - lengths		mm 500-fraz C250 - L550 (1)		

UST 28° R1,0/S

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
255,8	28°	1,0	42CM4 T HRC 52+58	600
lunghezze - lengths		mm 500-fraz C250 - L550 (1)		

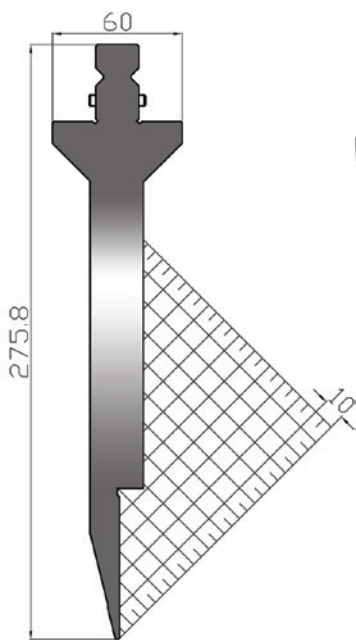
UST 86° R1,0/A

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
255,8	86°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500-fraz C250 - L550 (1)		

UST 86° R1,0/S

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
255,8	86°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500-fraz C250 - L550 (1)		

UST 28° R1,0/SP

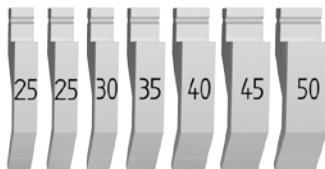
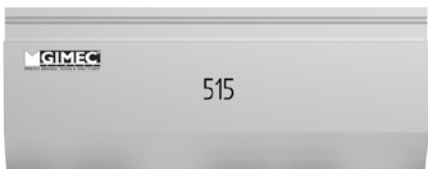
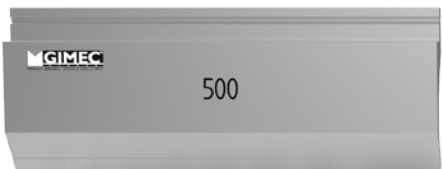


altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
275,8	28°	1,0	42CM4 T HRC 52+58	400
lunghezze - lengths		mm 500-fraz C250 - L550 (1)		

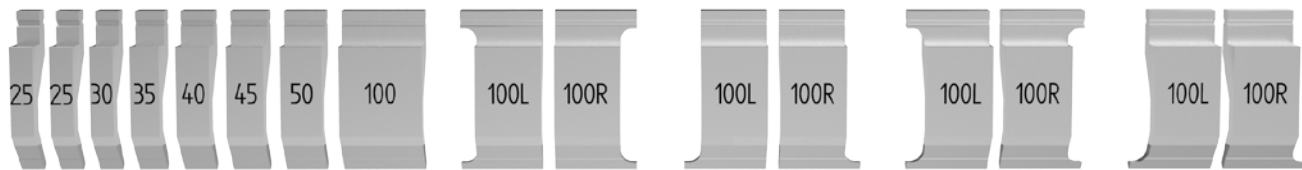
Gli utensili con peso inferiore a 12,5 kg vengono forniti con singolo o doppio pulsante.
Oltre tale peso l'utensile viene fornito con spine.
Tools with total weight inferior to 12,5 kg will be supplied with a single or double push button.
Beyond such weight tool will be supplied with pins.

LUNGHEZZE • LENGTHS mm 500 - 515 - fraz C250 - L550 - P550

L mm	25	30	35	40	45	50	100L	100R	100	200	tot.pz/pcs
fraz C	250	2	1	1	1	1					7
fraz L (1)	550	2	1	1	1	1	1	1	1		10
fraz L (1A)	550	2	1	1	1	1	1	1	1		10
fraz L (2)	550	2	1	1	1	1	1	1	1		10
fraz P	550	2	1	1	1	1	1	1	1		10



fraz C 250



fraz 550

L(1)

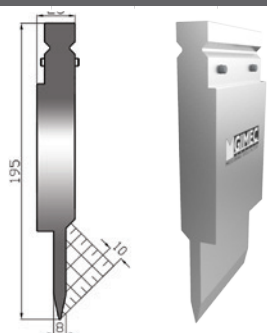
L(1A)

L(2)

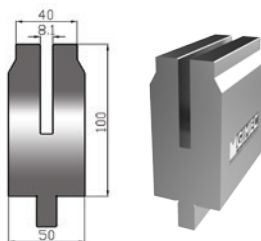
P

serie UST®

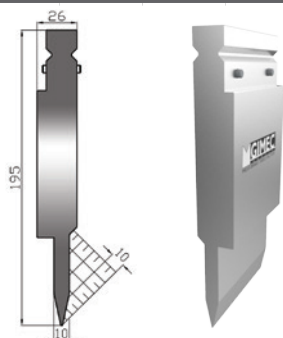
STANDARD TOOLS

UST 138 L 8

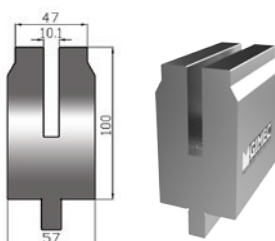
altezza height	angolo degree	raggio radius	max kN/mt
mm 195	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

UST 138 M 8

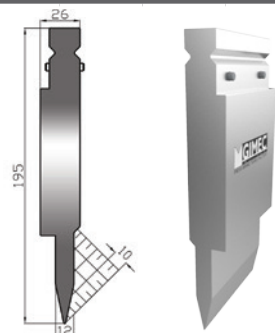
altezza height	V	raggio radius	max kN/mt
mm 100	mm 8	1,0	500
42CM4 T HRC52+58			
mm 500 - 550 fraz L			

UST 138 L 10

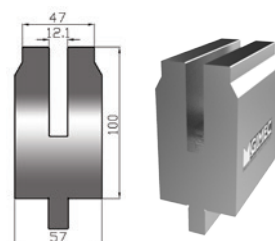
altezza height	angolo degree	raggio radius	max kN/mt
mm 195	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

UST 138 M 10

altezza height	V	raggio radius	max kN/mt
mm 100	mm 10	1,0	500
42CM4 T HRC52+58			
mm 500 - 550 fraz L			

UST 138 L 12

altezza height	angolo degree	raggio radius	max kN/mt
mm 195	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

UST 138 M 12

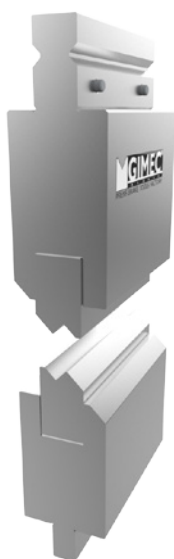
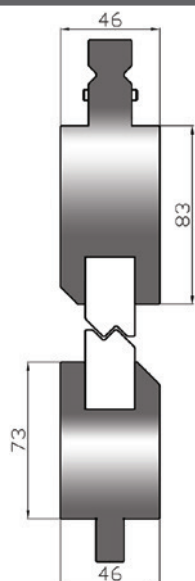
altezza height	V	raggio radius	max kN/mt
mm 100	mm 12	1,0	500
42CM4 T HRC52+58			
mm 500 - 550 fraz L			



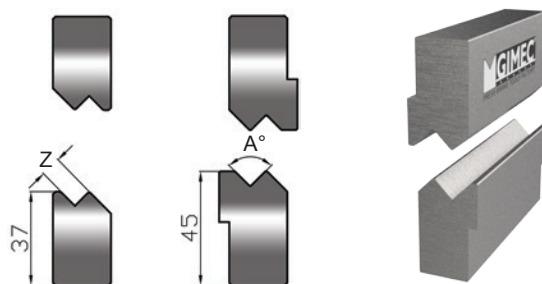
Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura.

Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.

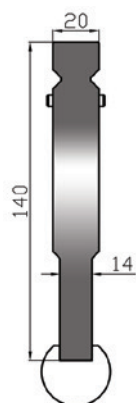
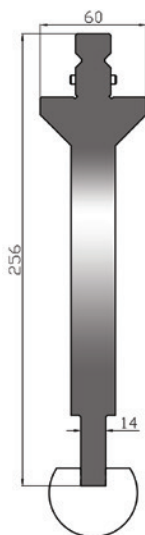
We suggest to use these tools on synchronized press brakes as it is necessary to change quickly press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on bend crushed.

UST 130

altezza height mm	acciaio steel	max kN/mt
73 + 83	C45	1000
lunghezze - lengths	mm 835 - 415	

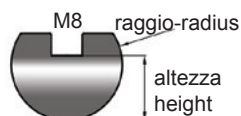
US 131 Z 1 ÷ 15 mm

codice articolo item code	Z mm	A°	MAX sp./th.	codice articolo item code	Z mm	A°	MAX sp./th.
US 131 / 1,0	1,0	160°	0,5 mm	US 131 / 6,5	6,5	90°	1,5 mm
US 131 / 1,5	1,5	160°	0,6 mm	US 131 / 7,0	7,0	90°	2,0 mm
US 131 / 2,0	2,0	150°	0,8 mm	US 131 / 7,5	7,5	90°	2,0 mm
US 131 / 2,5	2,5	140°	1,0 mm	US 131 / 8	8	90°	2,5 mm
US 131 / 3,0	3,0	90°	1,0 mm	US 131 / 9	9	90°	2,5 mm
US 131 / 3,5	3,5	90°	1,2 mm	US 131 / 10	10	90°	3,0 mm
US 131 / 4,0	4,0	90°	1,2 mm	US 131 / 11	11	90°	3,0 mm
US 131 / 4,5	4,5	90°	1,5 mm	US 131 / 12	12	90°	3,0 mm
US 131 / 5,0	5,0	90°	1,5 mm	US 131 / 13	13	90°	3,0 mm
US 131 / 5,5	5,5	90°	1,5 mm	US 131 / 14	14	90°	3,0 mm
US 131 / 6,0	6,0	90°	1,5 mm	US 131 / 15	15	90°	3,0 mm
acciaio - steel				C45 T HRC 52+58			
lunghezze - lengths				mm 835 - 415			

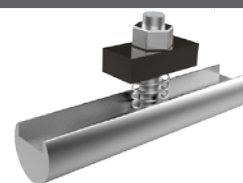
UST 140**UST 256**

altezza height mm	140
raggio-radius MIN - MAX	8 ÷ 50 mm
acciaio steel	C45
lunghezze lengths	mm 830 - 412
max kN/mt	800

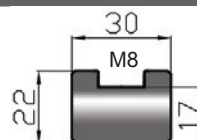
altezza height mm	256
raggio-radius MIN - MAX	8 ÷ 50 mm
acciaio steel	C45
lunghezze lengths	mm 830 - 412
max kN/mt	800

US 305 R 8 ÷ 50 mm

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



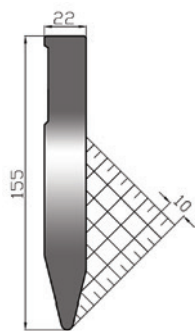
codice articolo item code	raggio radius	altezza height	codice articolo item code	raggio radius	altezza height
US 305/R 8	8	10 mm	US 305/R 25	25	29 mm
US 305/R 9	9	10 mm	US 305/R 27,5	27,5	34 mm
US 305/R 10	10	12 mm	US 305/R 30	30	34 mm
US 305/R 12,5	12,5	17 mm	US 305/R 35	35	45 mm
US 305/R 15	15	20 mm	US 305/R 40	40	44 mm
US 305/R 17,5	17,5	22 mm	US 305/R 45	45	50 mm
US 305/R 20	20	24 mm	US 305/R 50	50	54 mm
US 305/R 22,5	22,5	25 mm			
acciaio - steel			C45 - 39NCM3 nitratato (N)		
lunghezze - lengths			mm 835 - 415		

US 310

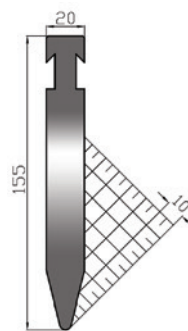
4 fori-holes mm 104-209-...-104 = mm 835
2 fori-holes mm 103-209-...-103 = mm 415



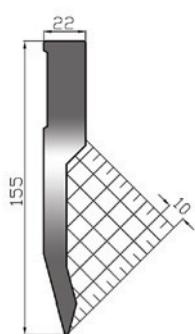
codice articolo item code	acciaio steel
US 310	C45
US 310 T	C45 T HRC 52+58
lunghezze - lengths	mm 835 - 415

USB 155/28° R3,0 / S

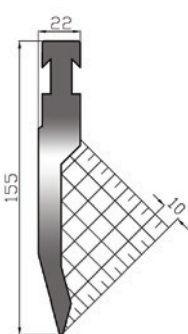
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	28°	3,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/28° R3,0 / R

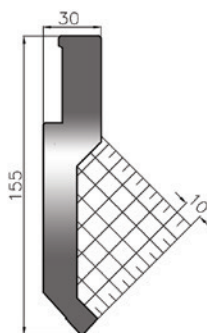
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	28°	3,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/30° R1,0 / S

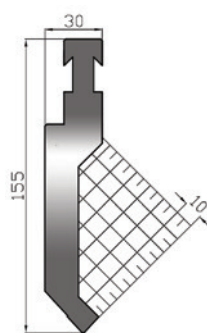
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	30°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/30° R1,0 / R

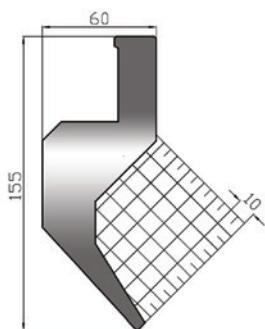
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	30°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/85° D R1,0 / S

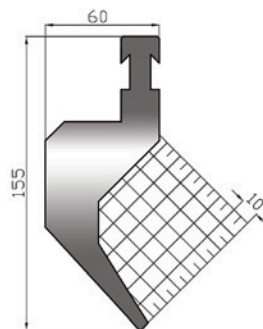
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	85°	1,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/85° D R1,0 / R

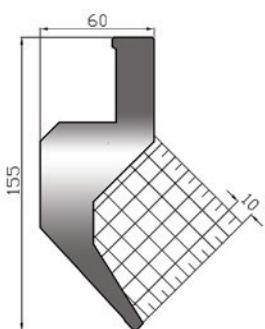
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	85°	1,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/85° C R0,8 / S

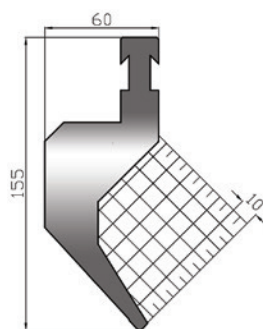
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	85°	0,8	42CM4 T HRC 52÷58	500
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/85° C R0,8 / R

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	85°	0,8	42CM4 T HRC 52÷58	500
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/85° C R1,5 / S

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	85°	1,5	42CM4 T HRC 52÷58	500
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 155/85° C R1,5 / R

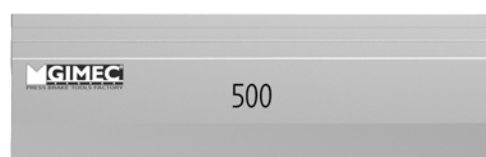
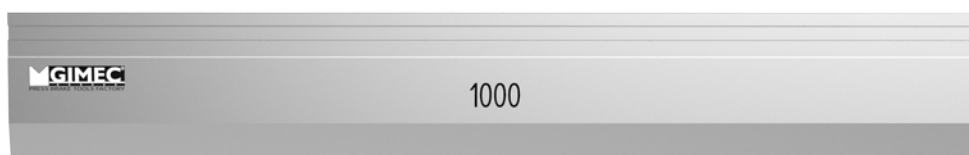
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
155,0	85°	1,5	42CM4 T HRC 52÷58	500
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

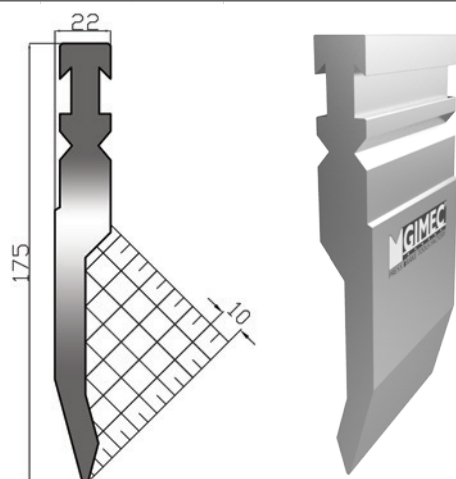
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STANDARD TOOLS

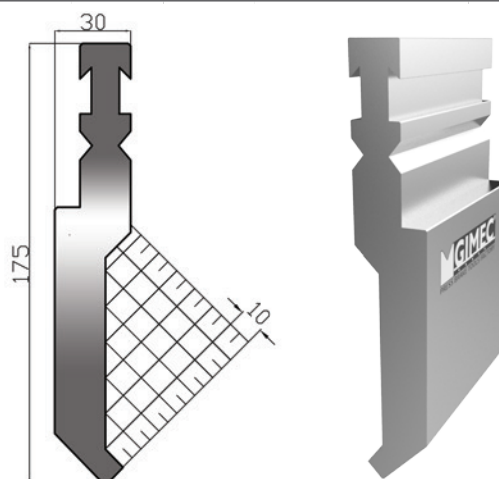
USB 155 LUNGHEZZE • LENGTHS

mm 1000 - 500 - fraz 1100 (1) mm10+15+20+30+40+50+60+75+100+100L+100R+200+300

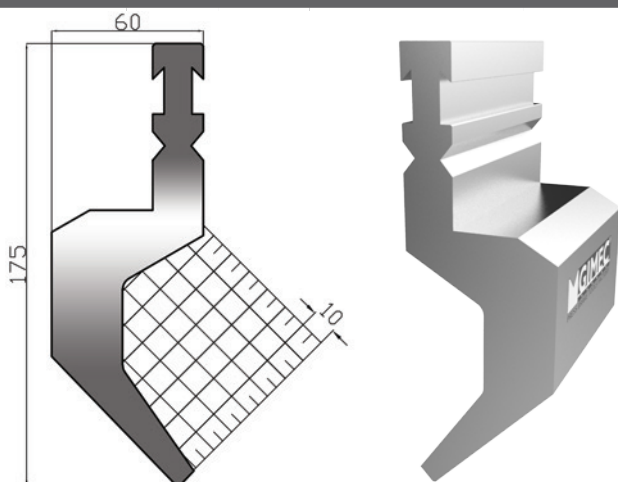


USB 175/30° R1,0 / RFA

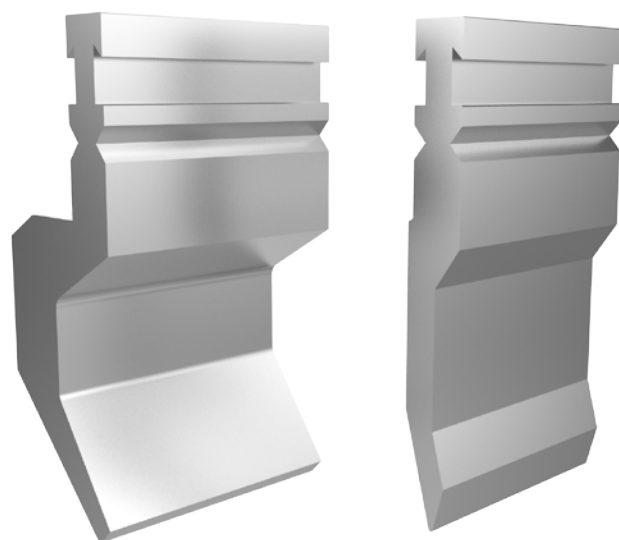
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
175,0	30°	1,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 175/88° D R1,0 / RFA

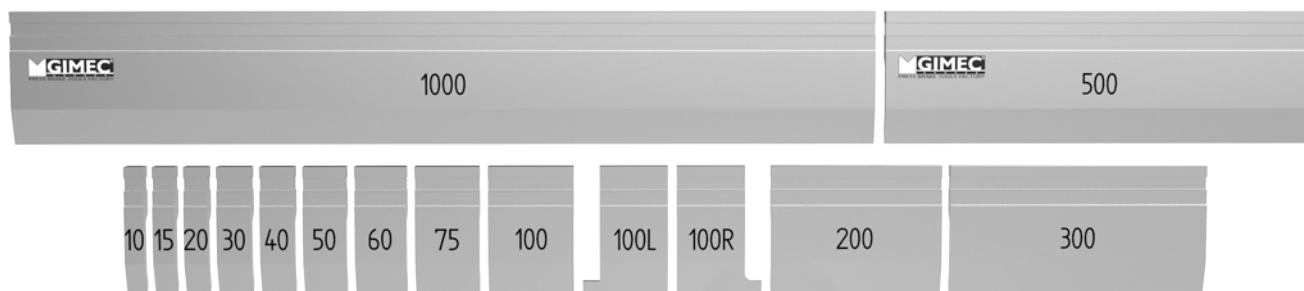
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
175,0	88°	1,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

USB 175/88° C R1,5 / RFA

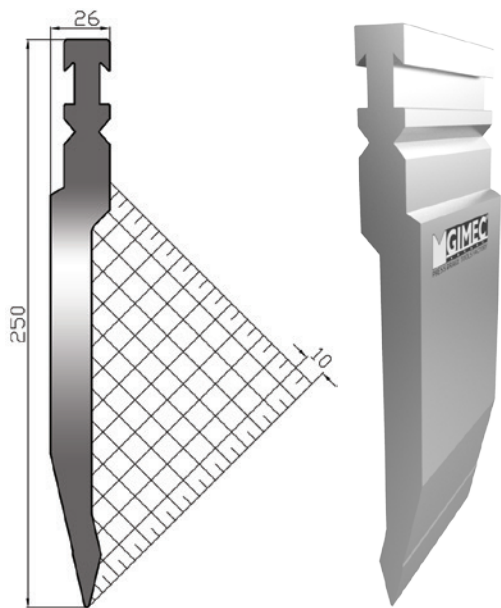
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
175,0	88°	1,5	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 500 - 1000 - 1100 fraz (1)		

**USB 175 LUNGHEZZE • LENGTHS**

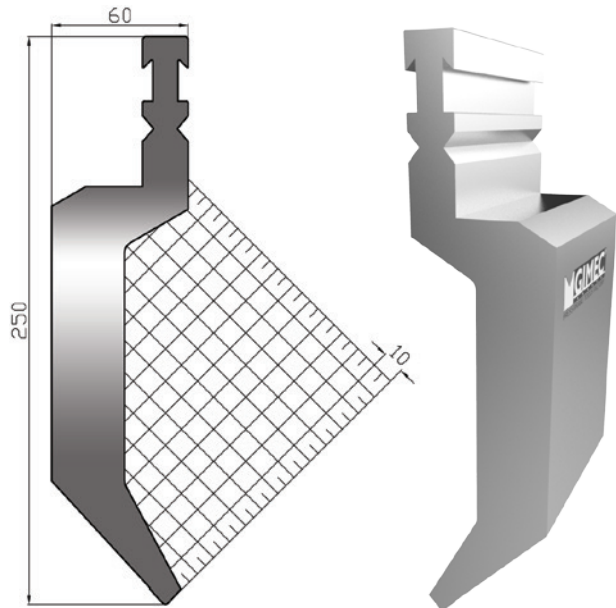
mm 1000 - 500 - fraz 1100 (1) mm10+15+20+30+40+50+60+75+100+100L+100R+200+300



USB 250/26° R1,0 / RFA



USB 250/85° R1,5 / RFA



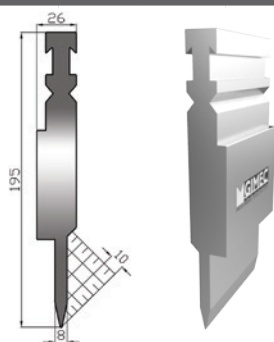
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
250,0	26°	1,0	42CM4 T HRC 52÷58	900
lunghezze - lengths		mm 508 - 1100 fraz (2)		

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
250,0	85°	1,5	42CM4 T HRC 52÷58	1000
lunghezze - lengths		mm 508 - 1100 fraz (2)		

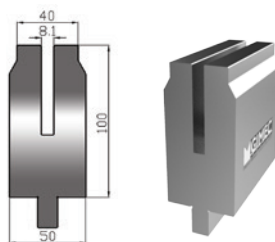
USB 250 LUNGHEZZE • LENGTHS

mm 508 - fraz 1100 (2) mm 10+15+20+30+50+200L+100R+300+375

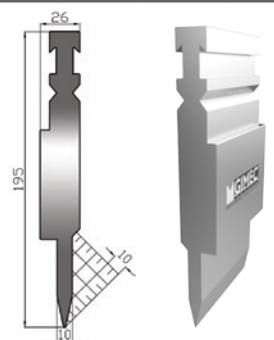


USB 138 L 8

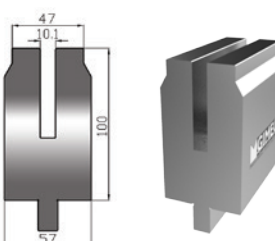
altezza height	angolo degree	raggio radius	max kN/mt
mm 195	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

USB 138 M 8

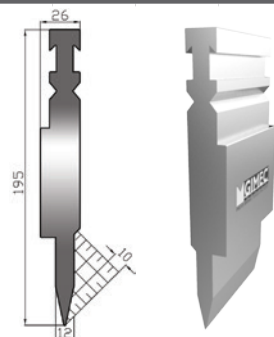
altezza height	V	raggio radius	max kN/mt
mm 100	mm 8	1,0	500
42CM4 T HRC52+58			
mm 500 - 550 fraz			

USB 138 L 10

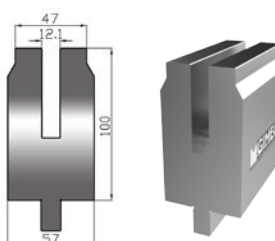
altezza height	angolo degree	raggio radius	max kN/mt
mm 195	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

USB 138 M 10

altezza height	V	raggio radius	max kN/mt
mm 100	mm10	1,0	500
42CM4 T HRC52+58			
mm 500 - 550 fraz			

USB 138 L 12

altezza height	angolo degree	raggio radius	max kN/mt
mm 195	24°	0,6	800
acciaio - steel			
lunghezze - lengths			

USB 138 M 12

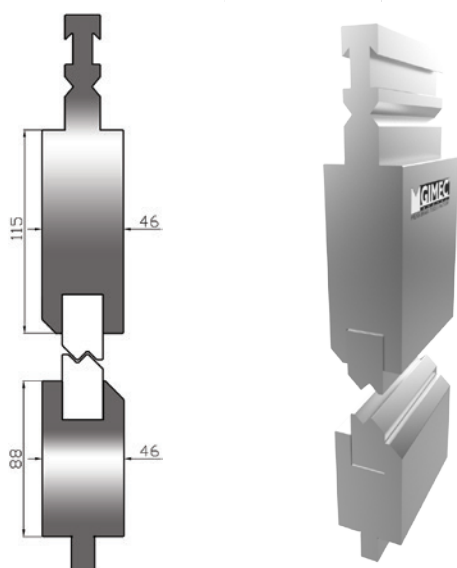
altezza height	V	raggio radius	max kN/mt
mm 100	mm12	1,0	500
42CM4 T HRC52+58			
mm 500 - 550 fraz			



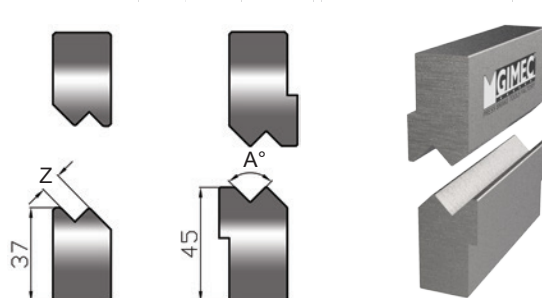
Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura.

Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.

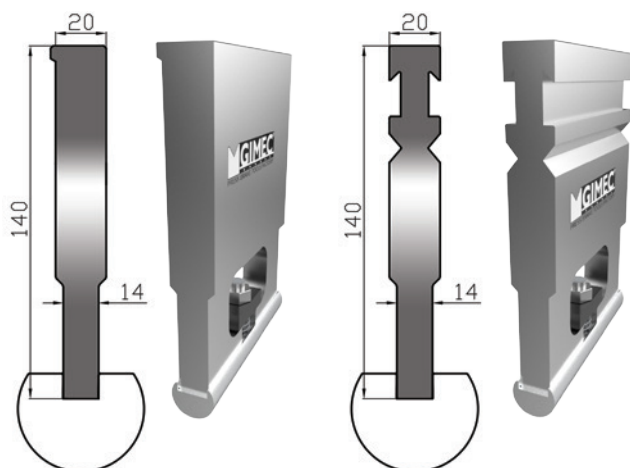
We suggest to use these tools on synchronized press brakes as it is necessary to change quickly press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on bend crushed.

USB 130

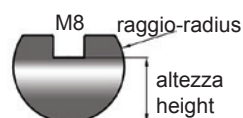
altezza height mm	acciaio steel	max kN/mt
115 + 88	C45	1000
lunghezze - lengths	mm 835 - 415	

US 131 Z 1 ÷ 15 mm

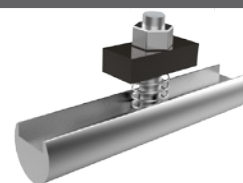
codice articolo item code	Z mm	A°	MAX sp./th.	codice articolo item code	Z mm	A°	MAX sp./th.
US 131 / 1,0	1,0	160°	0,5 mm	US 131 / 6,5	6,5	90°	1,5 mm
US 131 / 1,5	1,5	160°	0,6 mm	US 131 / 7,0	7,0	90°	2,0 mm
US 131 / 2,0	2,0	150°	0,8 mm	US 131 / 7,5	7,5	90°	2,0 mm
US 131 / 2,5	2,5	140°	1,0 mm	US 131 / 8	8	90°	2,5 mm
US 131 / 3,0	3,0	90°	1,0 mm	US 131 / 9	9	90°	2,5 mm
US 131 / 3,5	3,5	90°	1,2 mm	US 131 / 10	10	90°	3,0 mm
US 131 / 4,0	4,0	90°	1,2 mm	US 131 / 11	11	90°	3,0 mm
US 131 / 4,5	4,5	90°	1,5 mm	US 131 / 12	12	90°	3,0 mm
US 131 / 5,0	5,0	90°	1,5 mm	US 131 / 13	13	90°	3,0 mm
US 131 / 5,5	5,5	90°	1,5 mm	US 131 / 14	14	90°	3,0 mm
US 131 / 6,0	6,0	90°	1,5 mm	US 131 / 15	15	90°	3,0 mm
acciaio - steel				C45 T HRC 52+58			
lunghezze - lengths				mm 835 - 415			

USB 140 / S**UST 140 / RFA**

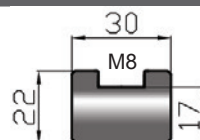
altezza height mm	140	altezza height mm	140
raggio-radius MIN - MAX	8 ÷ 50 mm	raggio-radius MIN - MAX	8 ÷ 50 mm
acciaio steel	C45	acciaio steel	C45
lunghezze lengths	mm 830 - 412	lunghezze lengths	mm 830 - 412
max kN/mt	800	max kN/mt	800

US 305 R 8 ÷ 50 mm

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



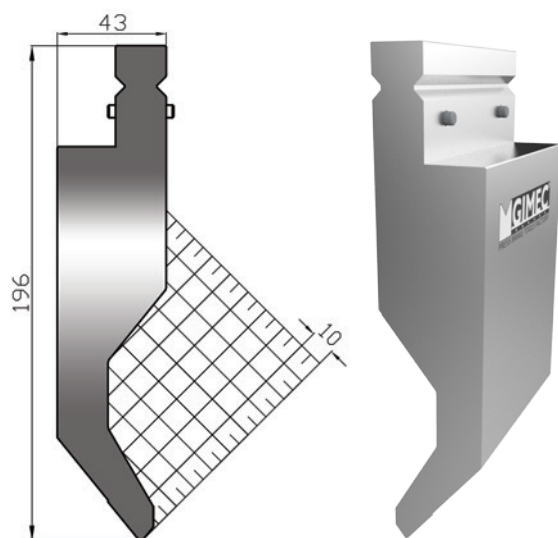
codice articolo item code	raggio radius	altezza height	codice articolo item code	raggio radius	altezza height
US 305/R 8	8	10 mm	US 305/R 25	25	29 mm
US 305/R 9	9	10 mm	US 305/R 27,5	27,5	34 mm
US 305/R 10	10	12 mm	US 305/R 30	30	34 mm
US 305/R 12,5	12,5	17 mm	US 305/R 35	35	45 mm
US 305/R 15	15	20 mm	US 305/R 40	40	44 mm
US 305/R 17,5	17,5	22 mm	US 305/R 45	45	50 mm
US 305/R 20	20	24 mm	US 305/R 50	50	54 mm
US 305/R 22,5	22,5	25 mm			
acciaio - steel			C45 - 39NCM3 nitratato (N)		
lunghezze - lengths			mm 835 - 415		

US 310

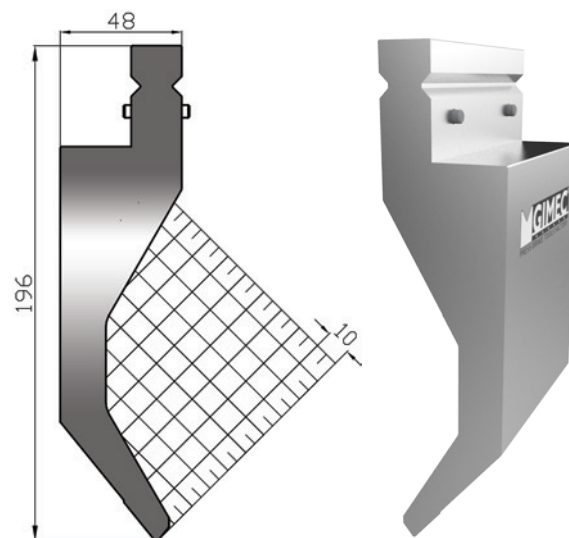
4 fori-holes mm 104-209-...-104 = mm 835
2 fori-holes mm 103-209-...-103 = mm 415



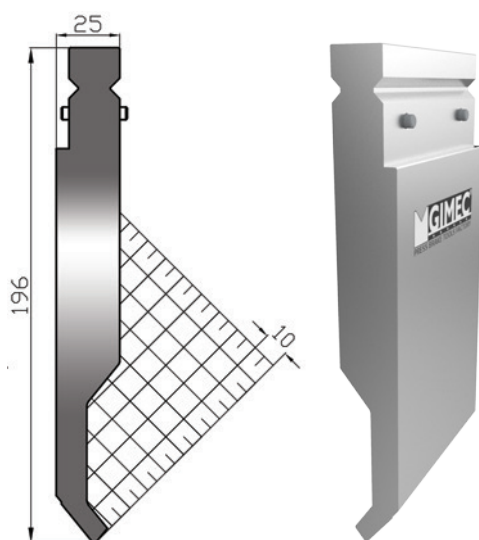
codice articolo item code	acciaio steel
US 310	C45
US 310 T	C45 T HRC 52+58
lunghezze - lengths	mm 835 - 415

USL 196/78° AW R1,0**C10W**

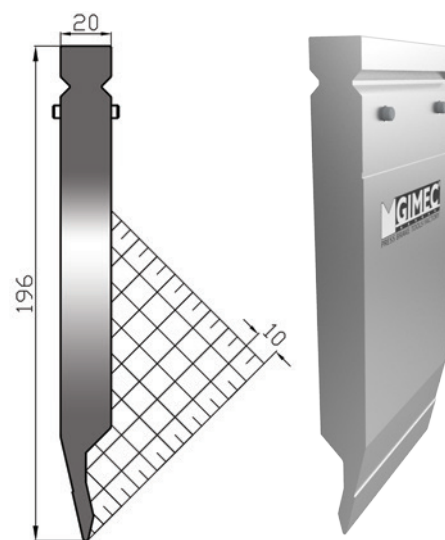
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
196,0	78°	1,0	42CM4 T HRC 52+58	700
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 196/78° BW R1,0**D10W**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
196,0	78°	1,0	42CM4 T HRC 52+58	450
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

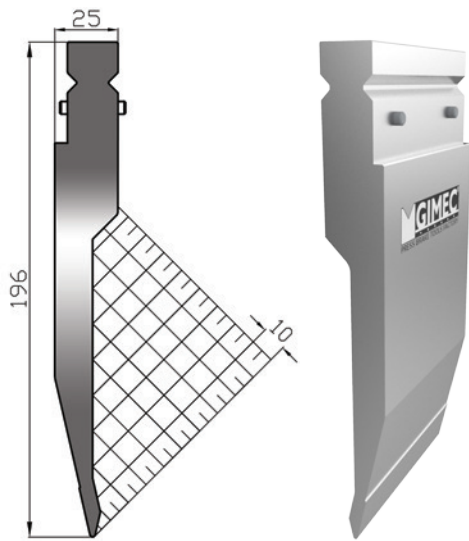
USL 196/78° CW R1,0**E10W**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
196,0	78°	1,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 196/26° EW R1,0**F10W**

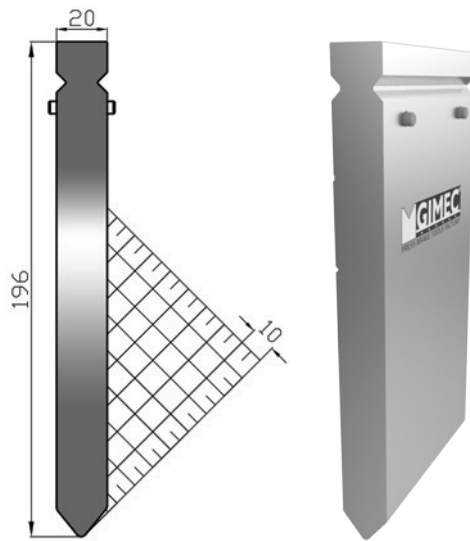
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
196,0	26°	1,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 196/26° FW R1,0 J10W



altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
196,0	26°	1,0	42CM4 T HRC 52+58	400
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 196/78° DW R2,0 R10W



altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
196,0	78°	2,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

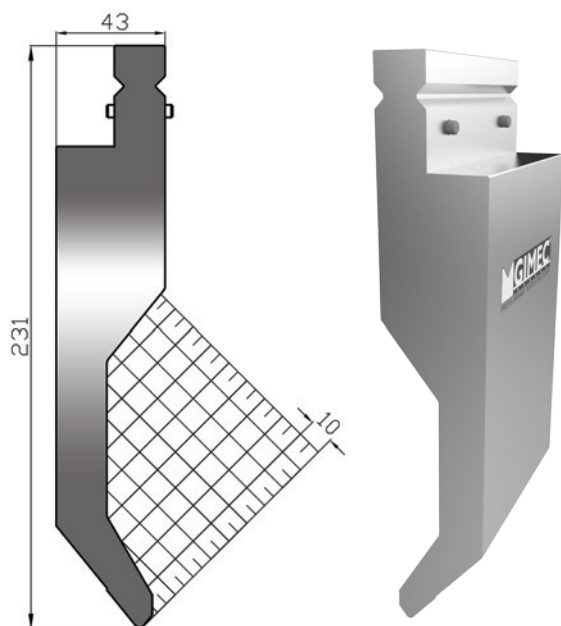
Gli utensili con peso inferiore a 12,5 kg vengono forniti con singolo o doppio pulsante.
Oltre tale peso l'utensile viene fornito con spine.

Tools with total weight inferior to 12,5 kg will be supplied with a single or double push button.
Beyond such weight tool will be supplied with pins.

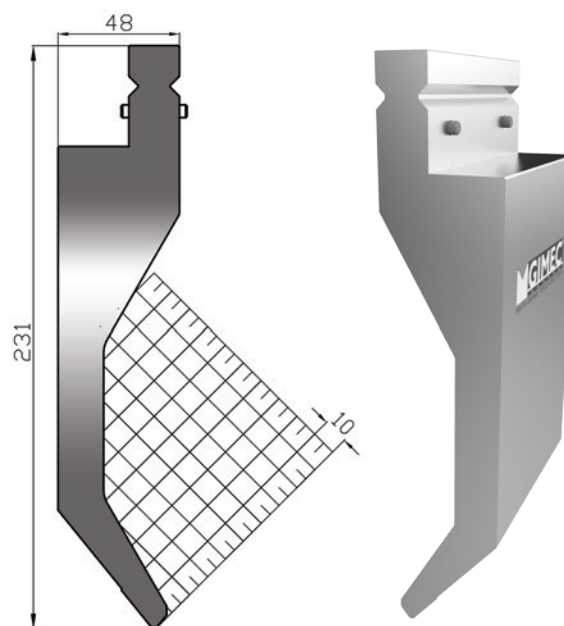


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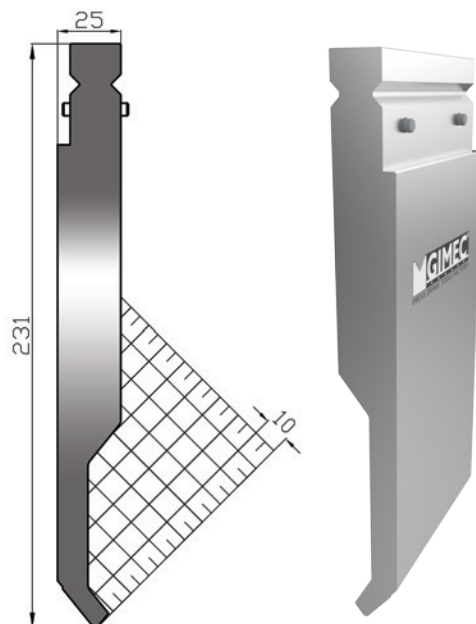
STANDARD TOOLS

USL 231/78° AW R2,0**C15W**

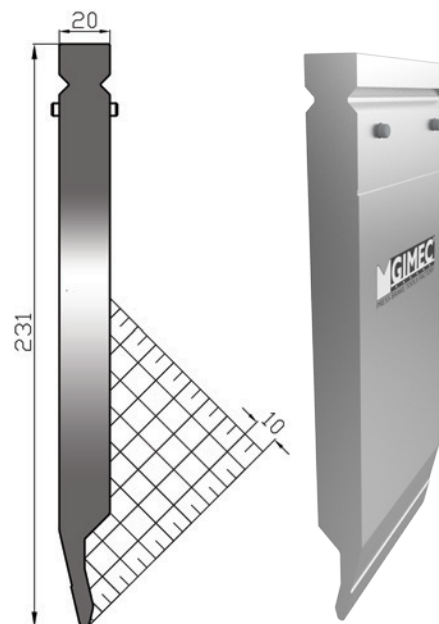
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
231,0	78°	2,0	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 231/78° BW R2,0**D15W**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
231,0	78°	2,0	42CM4 T HRC 52+58	750
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

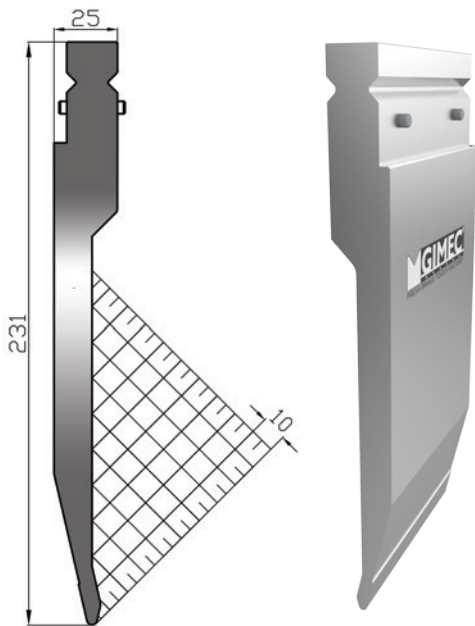
USL 231/78° CW R2,0**E15W**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
231,0	78°	2,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 231/26° EW R2,0**F15W**

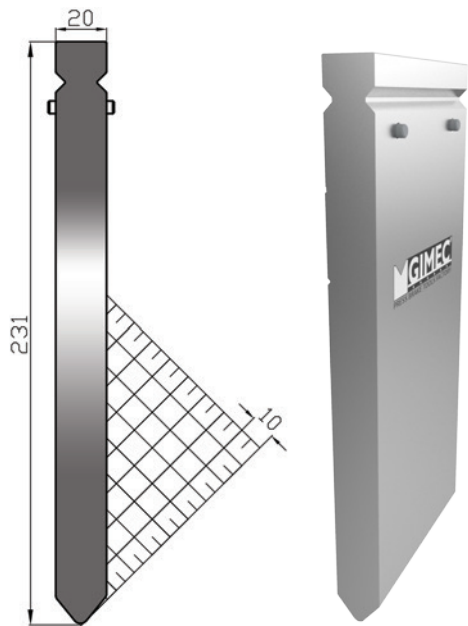
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
231,0	26°	2,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 231/26° FW R2,0 J15W



altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
231,0	26°	2,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 231/78° DW R3,0 R15W



altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
231,0	78°	3,0	42CM4 T HRC 52+58	1200
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

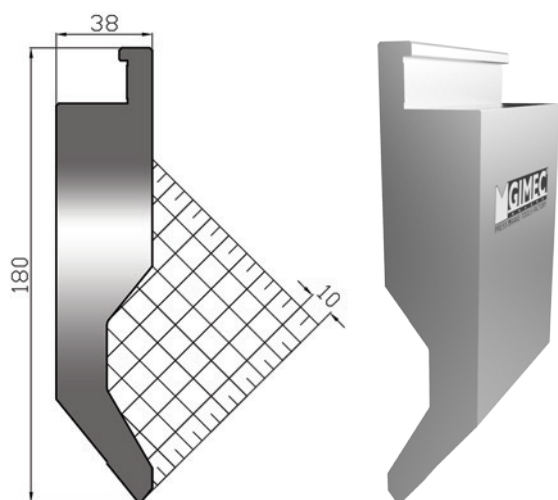


Gli utensili con peso inferiore a 12,5 kg vengono forniti con singolo o doppio pulsante.
Oltre tale peso l'utensile viene fornito con spine.

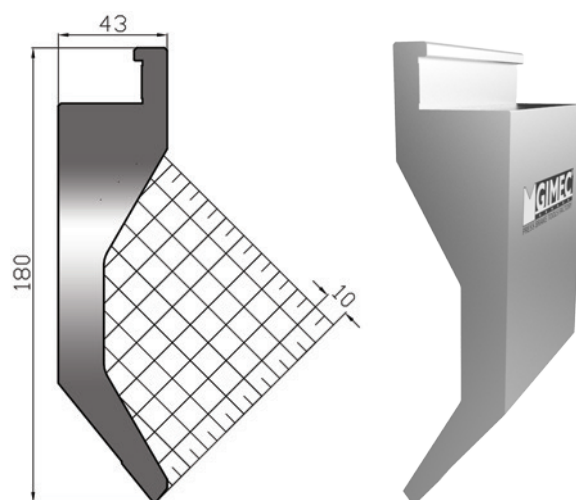
Tools with total weight inferior to 12,5 kg will be supplied with a single or double push button.
Beyond such weight tool will be supplied with pins.

serie **USL**®

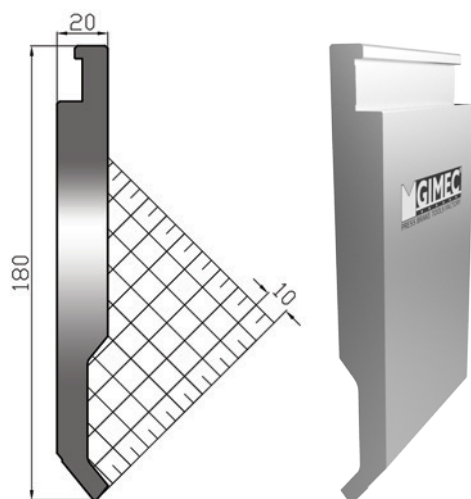
STANDARD TOOLS

USL 180/78° A R1,0**C10**

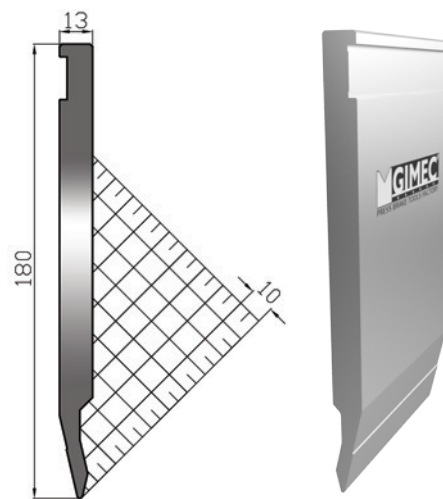
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
180,0	78°	1,0	42CM4 T HRC 52+58	700
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 180/78° B R1,0**D10**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
180,0	78°	1,0	42CM4 T HRC 52+58	450
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 180/78° C R1,0**E10**

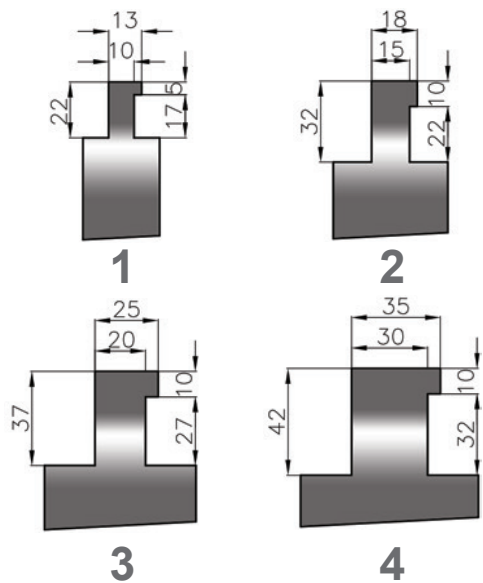
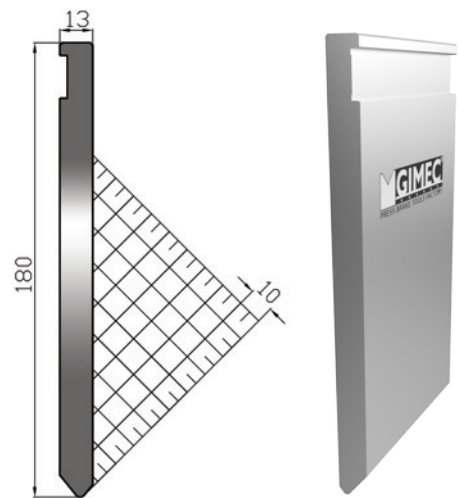
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
180	78°	1,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 180/26° E R1,0**F10**

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
180,0	26°	1,0	42CM4 T HRC 52+58	500
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

USL 180/78° D R2,0 **R10**

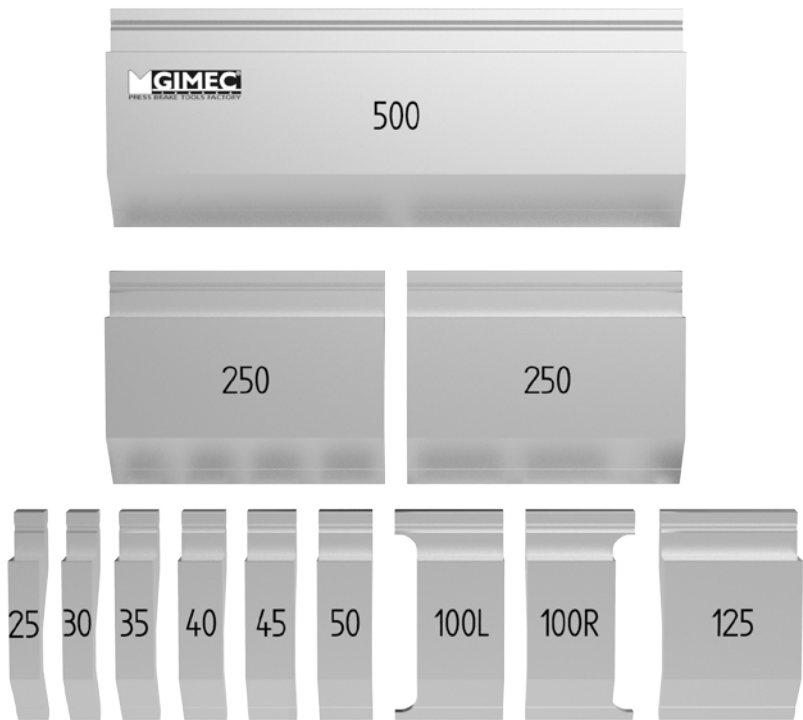
ATTACCO UTENSILI • CLAMPING TOOLS



altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
180	78°	2,0	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 508 - fraz 500 / 550 (1)		

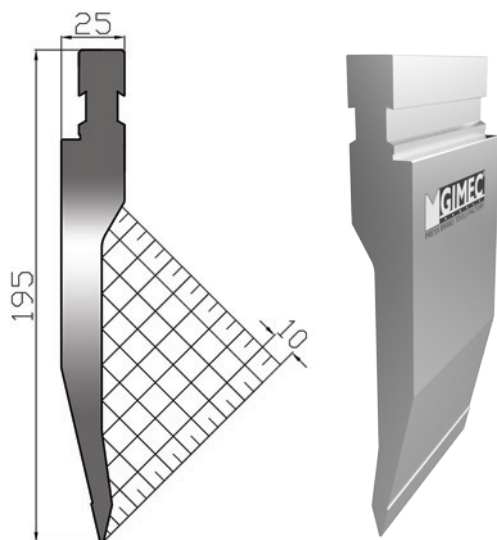
C10	D10	E10	F10	R10
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LUNGHEZZE • LENGTHS
mm 508 - fraz 500 mm 250+250 - fraz 550 (1) mm 25+30+35+40+45+50+100L+100R+125

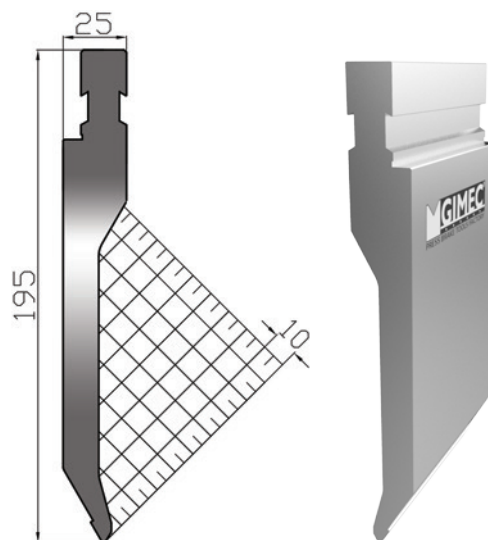


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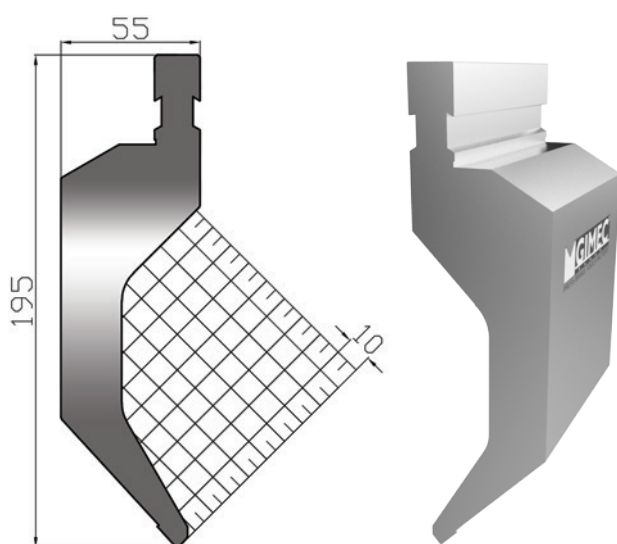
STANDARD TOOLS

USC 195/26° R0,8

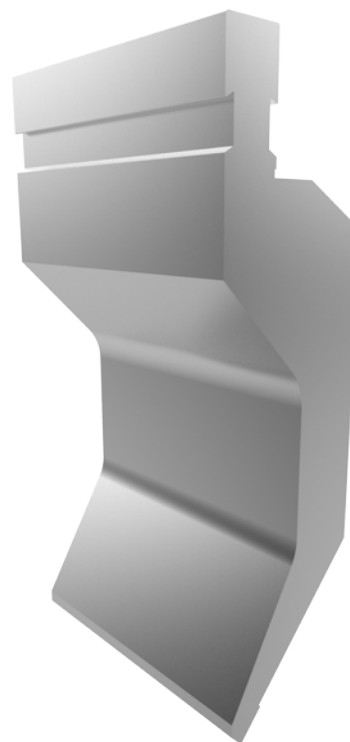
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	26°	0,8	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 525 - fraz A - fraz B		

USC 195/60° R0,8

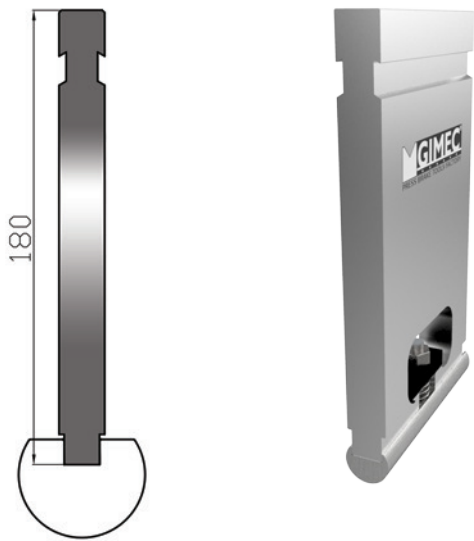
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	60°	0,8	42CM4 T HRC 52+58	800
lunghezze - lengths		mm 525 - fraz A - fraz B		

USC 195/85° R0,8

altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
195,0	85°	0,8	42CM4 T HRC 52+58	1000
lunghezze - lengths		mm 525 - fraz A - fraz B		

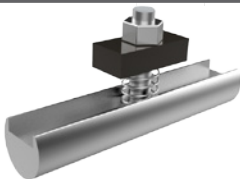
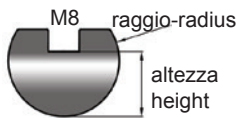


USC 180



altezza - height mm	180
raggio-radius MIN - MAX	8 ÷ 50 mm
acciaio - steel	C45
lunghezze - lengths	mm 522
max kN/mt	500

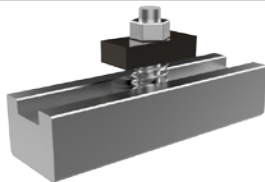
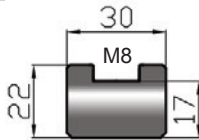
USC 305 R 8 ÷ 50 mm



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

codice articolo item code	raggio radius	altezza height	codice articolo item code	raggio radius	altezza height
USC 305/R 8	8	10 mm	USC 305/R 25	25	29 mm
USC 305/R 9	9	10 mm	USC 305/R 27,5	27,5	34 mm
USC 305/R 10	10	12 mm	USC 305/R 30	30	34 mm
USC 305/R 12,5	12,5	17 mm	USC 305/R 35	35	45 mm
USC 305/R 15	15	20 mm	USC 305/R 40	40	44 mm
USC 305/R 17,5	17,5	22 mm	USC 305/R 45	45	50 mm
USC 305/R 20	20	24 mm	USC 305/R 50	50	54 mm
USC 305/R 22,5	22,5	25 mm			
acciaio - steel			C45 - 39NCM3 nitratato (N)		
lunghezze - lengths			mm 525		

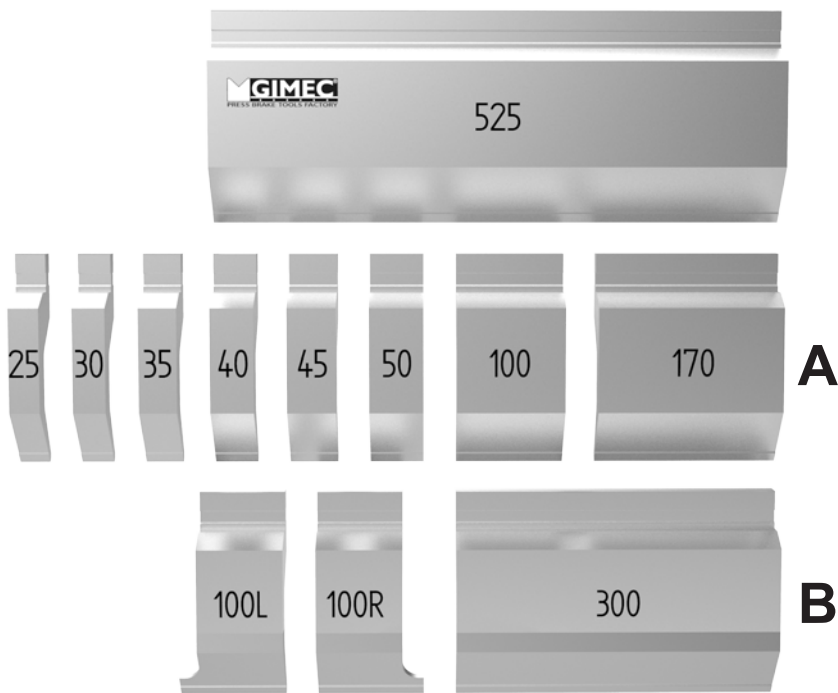
USC 310

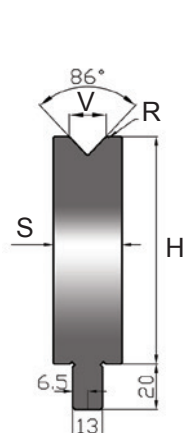


3 fori-holes mm 53,5-209-209-53,5 = mm 525

codice articolo item code	acciaio steel
USC 310	C45
USC 310 T	C45 T HRC 52+58
lunghezze - lengths	mm 525

LUNGHEZZE • LENGTHS mm 525 - fraz A 495 mm - fraz B 500 mm



86°

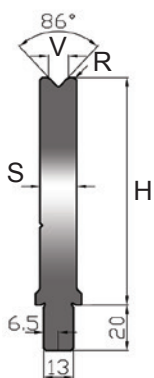
codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
UST100N-S/86°V04	4	0,6	100	8	250
UST100 N / 86° V06	6	0,6	100	20	1200
UST100 N / 86° V08	8	0,8	100	20	1150
UST100 N / 86° V10	10	1,0	100	20	1100
UST100 N / 86° V12	12	1,0	100	25	1200
UST100 N / 86° V16	16	1,6	100	30	1200
UST100 N / 86° V20	20	2,0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

acciaio - steel

42CM4 T HRC 52÷58

lunghezze - lengths

mm 500 - fraz C - M

86°

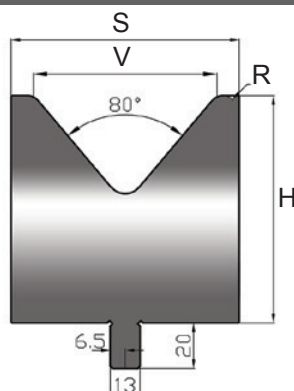
codice articolo tem code	V mm	R mm	H mm	S mm	max kN/mt
UST100N-S/86°V08	8	2,5	100	16	400
UST150N-S/86°V12	12	3,0	100	20	1200

acciaio - steel

42CM4 T HRC 52÷58

lunghezze - lengths

mm 515 - fraz M

80° 60°

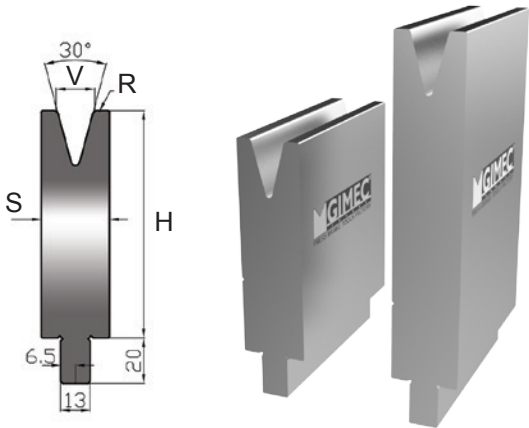
codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
UST150 N / 80° V24	24	2,0	150	35	1000
UST150 N / 80° V30	30	5,0	150	45	900
UST150 N / 80° V40	40	5,0	150	55	1200
UST150 N / 80° V50	50	5,0	150	75	1500
UST100 N / 80° V60	60	5,0	100	75	1500
UST100 N / 80° V70	70	5,0	100	85	1500
UST100 N / 80° V80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

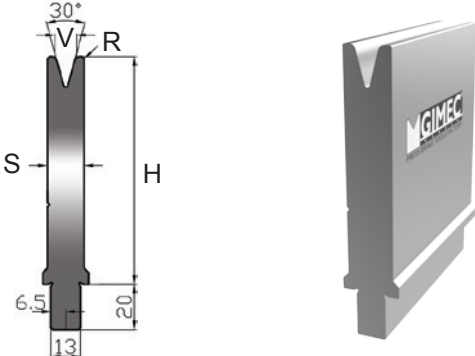
acciaio - steel

42CM4 T HRC 52÷58

lunghezze - lengths

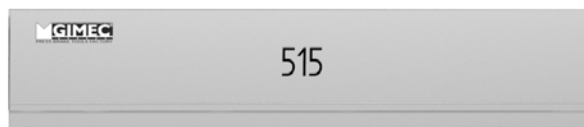
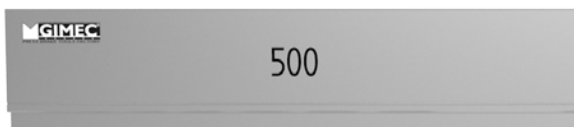
mm 500 - fraz C - M

30°		codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
	UST100 N / 30° V06	6	0,6	100	20	400	
	UST100 N / 30° V08	8	1,0	100	20	400	
	UST100 N / 30° V10	10	1,0	100	20	400	
	UST100 N / 30° V12	12	1,0	100	25	400	
	UST100 N / 30° V16	16	1,6	100	30	500	
	UST100 N / 30° V20	20	2,0	100	35	600	
	UST100 N / 30° V24	24	2,5	100	40	650	
	UST100 N / 30° V30	30	3,0	100	55	900	
	UST100 N / 30° V40	40	5,0	100	60	900	
	UST150 N / 30° V06	6	0,6	150	20	400	
	UST150 N / 30° V08	8	1,0	150	20	400	
	UST150 N / 30° V10	10	1,0	150	20	400	
	UST150 N / 30° V12	12	1,0	150	25	400	
	UST150 N / 30° V16	16	1,6	150	30	500	
	UST150 N / 30° V20	20	2,0	150	35	600	
	UST150 N / 30° V24	24	2,5	150	40	650	
	UST150 N / 30° V30	30	3,0	150	55	900	
	UST150 N / 30° V40	40	5,0	150	60	900	
	acciaio - steel		42CM4 T HRC 52÷58	lunghezze - lengths		mm 500 - fraz C - M	

30°		codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
		UST100N-S/30°V06	6	2,0	100	16	400
		UST100N-S/30°V08	8	2,5	100	16	400
		UST100N-S/30°V10	10	2,5	100	20	400
		UST100N-S/30°V12	12	3,0	100	20	400
acciaio - steel		42CM4 T HRC 52÷58	lunghezze - lengths		mm 515 - fraz M		

LUNGHEZZE • LENGTHS mm 500 - 515 - fraz C250 - M550

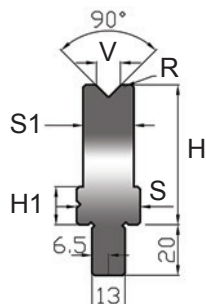
L mm	25	30	35	40	45	50	100	200				tot.pz/pcs
fraz C	250	2	1	1	1	1	1					7
fraz M	550	2	1	1	1	1	1	1	1			9



fraz C



fraz M

90°

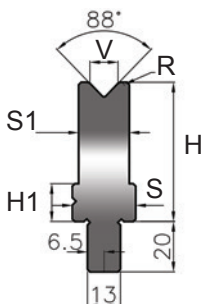
codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USB55 / 90° V06	6	0,4	55-15	25-15	1150
USB55 / 90° V08	8	0,5	55-15	25-15	1100
USB55 / 90° V10	10	1,0	55-15	25-20	1100
USB55 / 90° V12	12	1,5	55-15	25-20	1200
USB55 / 90° V16	16	2,0	55	30	1200

acciaio - steel

42CM4 T HRC 52+58

lunghezze - lengths

mm 500 - 1000 - fraz 1100

88°

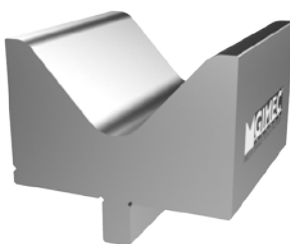
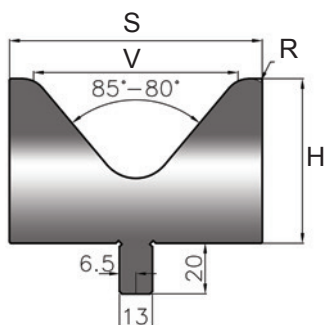
codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USB55 / 88° V10	10	1,0	55-15	25-20	1100
USB55 / 88° V12	12	1,5	55-15	25-20	1200
USB55 / 88° V16	16	2,0	55	30	1200
USB55 / 88° V20	20	2,0	55	30	1100
USB55 / 88° V24	24	3,0	55	40	1200

acciaio - steel

42CM4 T HRC 52+58

lunghezze - lengths

mm 500 - 1000 - fraz 1100

85° 80°

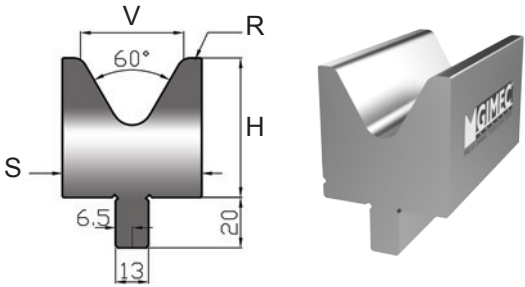
codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
USB55 / 85° V32	32	4,0	55	50	1200
USB55 / 85° V40	40	4,0	55	55	1200
USB55 / 80° V80	80	10,0	65	100	1700
USB85 / 80° V100	100	12,0	85	125	2300

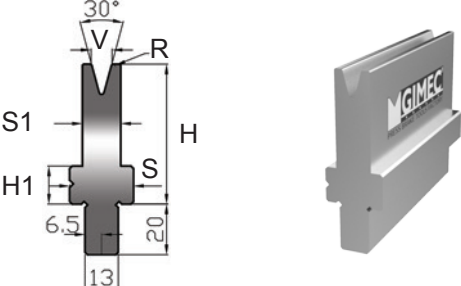
acciaio - steel

42CM4 T HRC 52+58

lunghezze - lengths

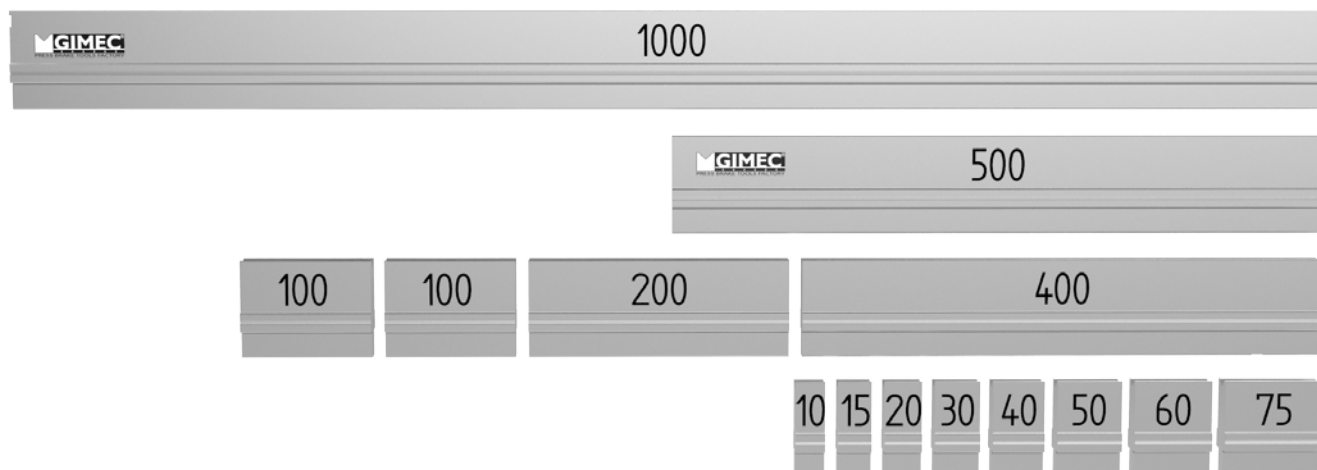
mm 500 - 1000 - fraz 1100

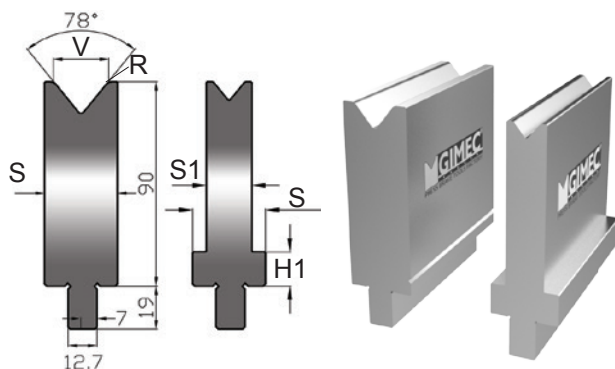
60°		codice articolo item code	V mm	R mm	H mm	S mm	max kN/mt
		USB55 / 60° V40	40	5,0	55	55	1300
		USB55 / 60° V50	50	5,0	55	70	1200
		USB65 / 60° V60	60	7,0	65	80	1100
acciaio - steel	42CM4 T HRC 52÷58	lunghezze - lengths	mm 500 - 1000 - fraz 1100				

30°		codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
		USB55 / 30° V06	6	0,6	55-15	25-15	350
		USB55 / 30° V08	8	0,8	55-15	25-15	200
		USB70 / 30° V08	8	0,7	70-15	25-20	200
		USB55 / 30° V10	10	1,0	55-15	25-20	350
		USB70 / 30° V10	10	1,0	70-15	25-20	350
		USB55 / 30° V12	12	1,5	55-15	25-20	300
		USB70 / 30° V12	12	1,5	70	25-25	300
		USB55 / 30° V16	16	2,0	55	30	450
		USB70 / 30° V16	16	2,0	70	30	450
		USB55 / 30° V20	20	2,5	55	35	500
		USB55 / 30° V24	24	3,0	55	40	550
		USB60 / 30° V32	32	4,0	60	60	650
acciaio - steel	42CM4 T HRC 52÷58	lunghezze - lengths	mm 500 - 1000 - fraz 1100				

LUNGHEZZE • LENGTHS

mm 500 - 1000 - fraz 1100 mm 10+15+20+30+40+50+60+75+100+100+200+400



78°

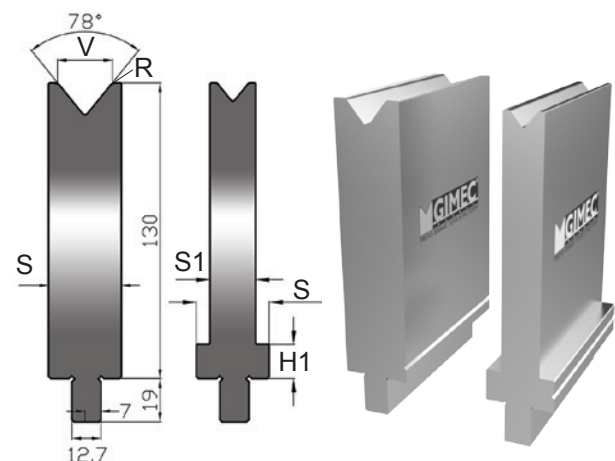
codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USL109/78° V06	6	1,0	90-15	32-12	400
USL109/78° V08	8	1,0	90-15	32-12	400
USL109/78° V10	10	1,0	90-15	32-14	500
USL109/78° V12	12	2,0	90-15	32-18	600
USL109/78° V16	16	2,5	90-15	32-25	800
USL109/78° V20	20	3,0	90	32	1000
USL109/78° V24	24	3,0	90	32	1000
USL109/78° V30	30	3,0	90	40	1100
USL109/78° V40	40	4,0	90	50	1300
USL109/78° V50	50	4,0	90	60	1500
USL109/78° V60	60	4,0	90	70	1500
USL109/78° V80	80	5,0	90	90	1500
USL109/78° V100	100	8,0	90	120	1200

acciaio - steel

42CM4 T HRC 52÷58

lunghezze - lengths

mm 508 - fraz 500 - 550

78°

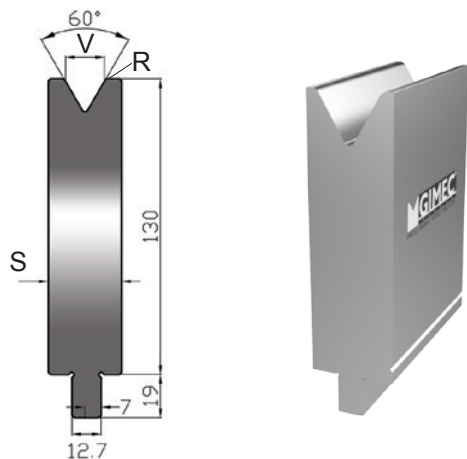
codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USL149/78° V06	6	1,0	130-15	32-12	400
USL149/78° V08	8	1,0	130-15	32-12	400
USL149/78° V10	10	1,0	130-15	32-14	500
USL149/78° V12	12	2,0	130-15	32-18	600
USL149/78° V16	16	2,5	130-15	32-25	800
USL149/78° V20	20	3,0	130	32	1000
USL149/78° V24	24	3,0	130	32	1000
USL149/78° V30	30	3,0	130	40	1100
USL149/78° V40	40	4,0	130	50	1300
USL149/78° V50	50	4,0	130	70	1500
USL149/78° V60	60	4,0	130	70	1500
USL149/78° V80	80	5,0	130	95	1500

acciaio - steel

42CM4 T HRC 52÷58

lunghezze - lengths

mm 508 - fraz 500 - 550

60°

codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
USL149/60° V30	30	4	30	40	500
USL149/60° V40	40	5	40	55	660
USL149/60° V50	50	5	50	70	1050
USL149/60° V60	60	5	60	80	1200
USL149/60° V80	80	6	80	102	1750
USL149/60° V100	100	8	100	120	1600
USL149/60° V120	120	8	120	145	1300

acciaio - steel

42CM4 T HRC 52÷58

lunghezze - lengths

mm 508 - fraz 500 - 550

30°		codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
		USL109/30° V06	6	0,8	90-15	32-16	200
		USL109/30° V08	8	1,0	90-15	32-18	220
		USL109/30° V10	10	1,2	90-15	32-25	300
		USL109/30° V12	12	1,6	90	32	380
		USL109/30° V16	16	3,0	90	32	380
		USL109/30° V20	20	3,0	90	40	380
		USL109/30° V24	24	3,0	90	50	550
acciaio - steel	42CM4 T HRC 52÷58	lunghezze - lengths	mm 508 - fraz 500 - 550				

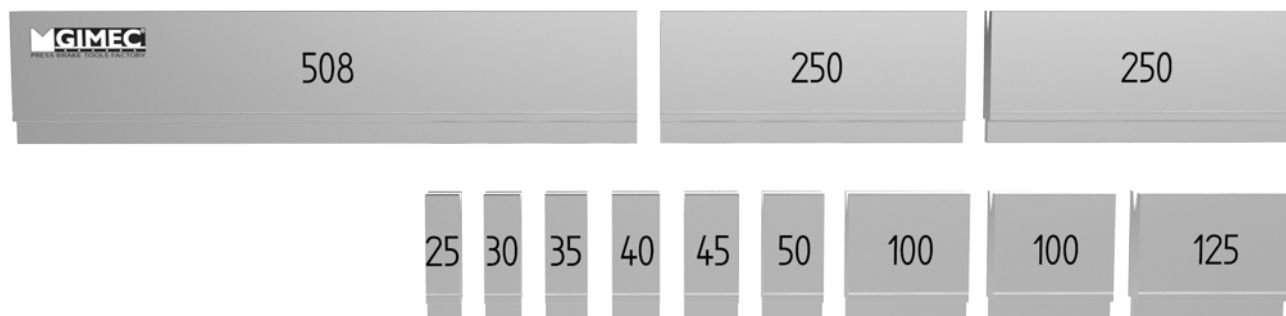
30°		codice articolo item code	V mm	R mm	H-H1 mm	S-S1 mm	max kN/mt
		USL149/30° V06	6	0,8	130-15	32-16	200
		USL149/30° V08	8	1,0	130-15	32-18	220
		USL149/30° V10	10	1,2	130-15	32-25	300
		USL149/30° V12	12	1,6	130	32	380
		USL149/30° V16	16	3,0	130	40	380
		USL149/30° V20	20	3,0	130	40	380
acciaio - steel		lunghezze - lengths	mm 508 - fraz 500 - 550				

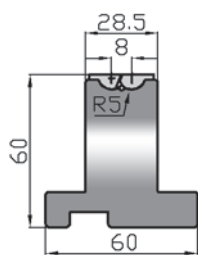
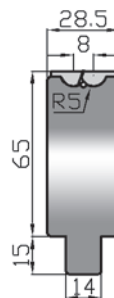
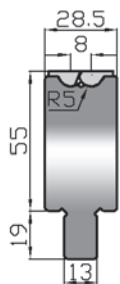
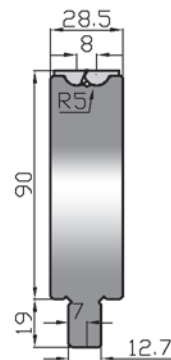
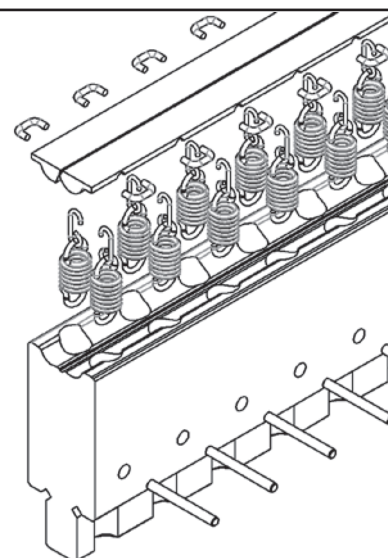
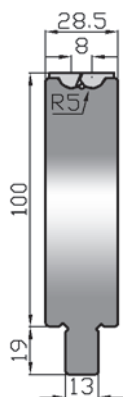
serie 12,7 USL®

STANDARD TOOLS

LUNGHEZZE • LENGTHS

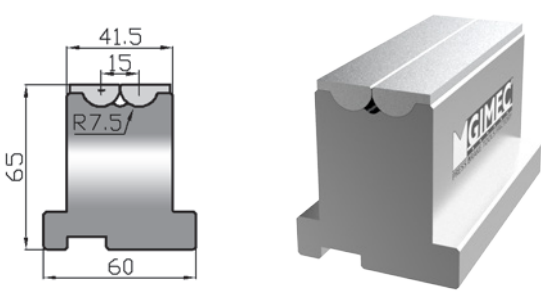
mm 508 - fraz 500 mm 250+250 - fraz 550 mm 25+30+35+40+45+50+100+100+125



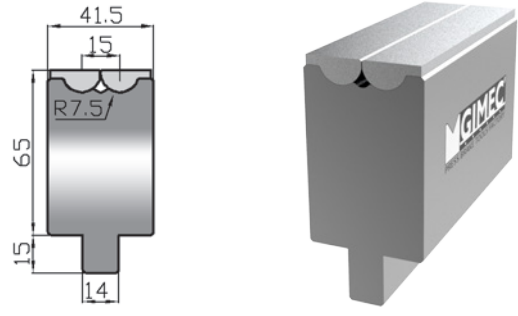
RVP 60-1**RVS 65-1****RVT 55-1****RVT 90-1****RVT 100-1**

type 1 (rel.8)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	Rm 420N/mm ² forza force kN/mt	carico load max kN/mt	lunghezze - lengths
V mm 8	1,5	0,7	40°	5,1	3	50	1000	mm 500
		1,0	35°	5,1	2,7	110		mm 440 fraz
		1,5	35°	5,1	2,2	280		(mm10-20-25-30-50-100-200)

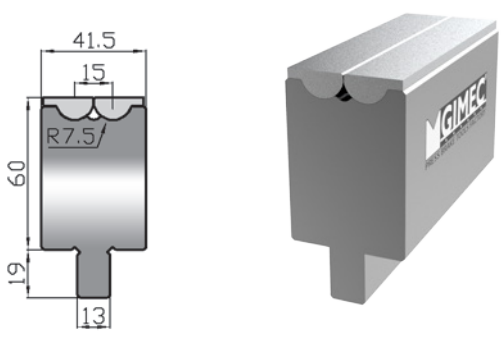
RVP 65-2



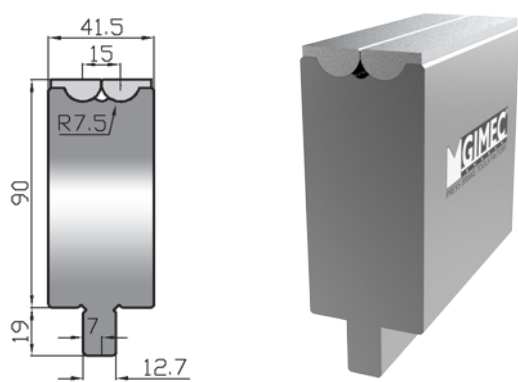
RVS 65-2



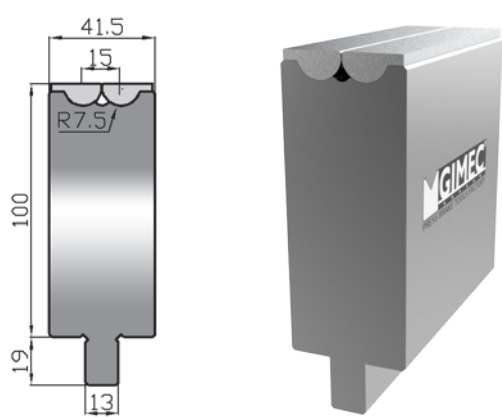
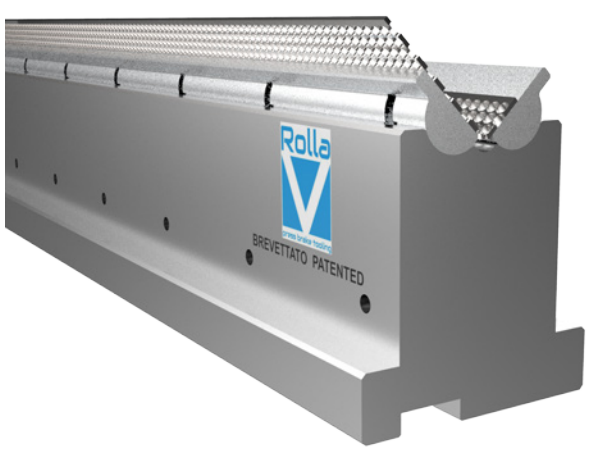
RVT 60-2



RVT 90-2



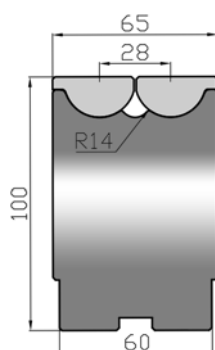
RVT 100-2



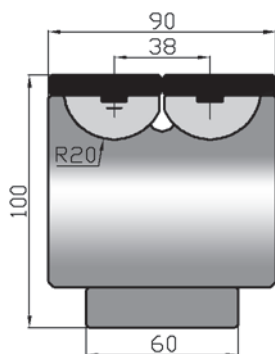
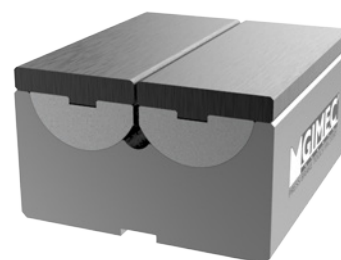
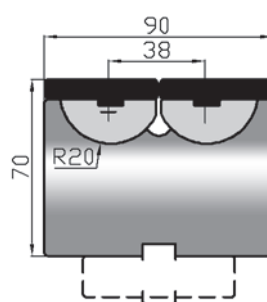
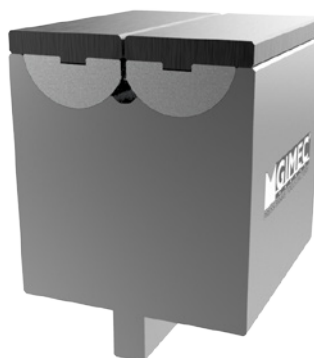
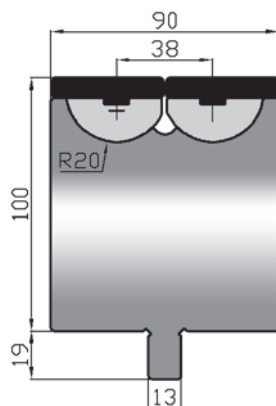
type 2 (rel.2)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	Rm 420N/mm² forza force kN/mt	carico load max kN/mt	lunghezze - lengths
V mm 15	3,2	2,0	59°	9,8	6	210	1500	mm 500
		3,0	47°	9,8	5	550		mm 450 fraz
		3,2	47°	9,8	4,8	650		(mm 20-25-30-35-40-100-200)

ROLLA-V®

TIPO TYPE 2

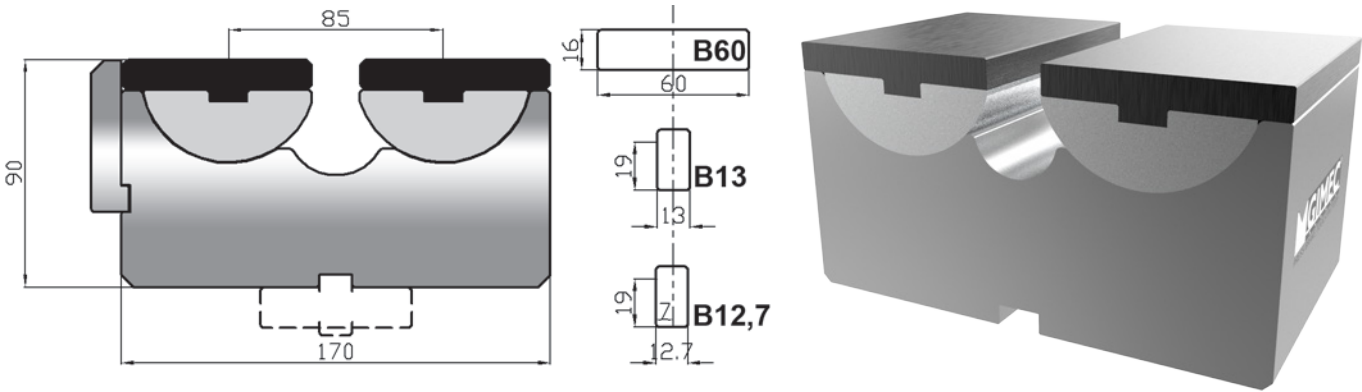
RVM 100-2.5

type 2.5 (rel.1)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	Rm 420N/mm ² forza force kN/mt	carico load max kN/mt	lunghezze - lengths
V mm 28	6,0	2,0	46°	18,6	13,8	100	2500	mm 500
		4,0	46°	18,6	11,8	450		mm 470 fraz
		6,0	55°	18,6	9,8	1200		(mm 35-40-45-50-100-200)

RVP 100-3**RVM 70-3****RVT 100-3**

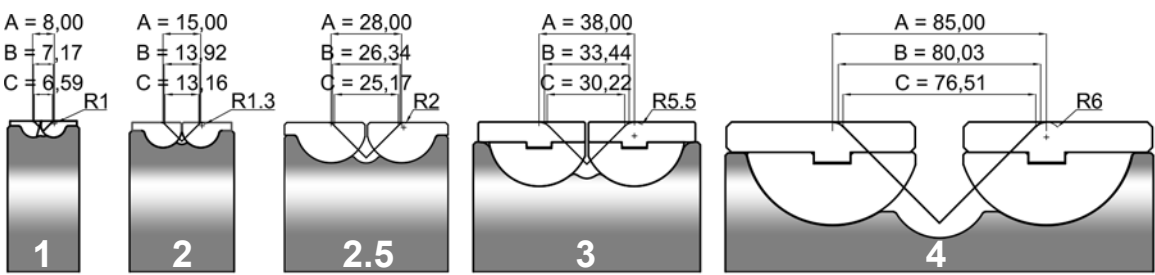
type 3 (rel.3)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	Rm 420N/mm ² forza force kN/mt	carico load max kN/mt	lunghezze - lengths
V mm 38	6,0	2,0	68°	23,6	13,9	70	2500	mm 500
		4,0	47°	23,6	11,9	340		mm 455 fraz
		6,0	50°	23,6	9,9	900		(mm 45-50-60-100-200)

RVM 90-4



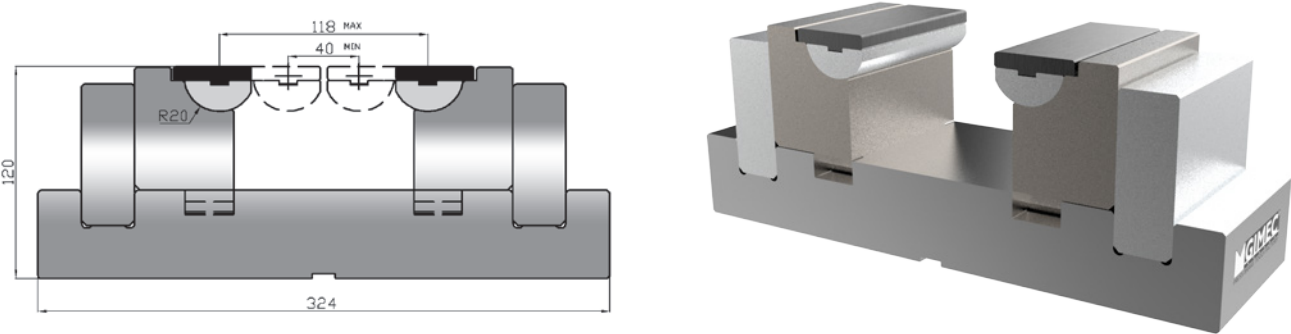
type 4 (rel.2)	max thickness mm	spessore thickness mm	angolo angle min.	bordo flange min. mm	max raggio est. out.radius	Rm 420N/mm² forza force kN/mt	carico load max kN/mt	lunghezze - lengths
V mm 85	12,0	6,0	78°	56,6	42,1	260	3000	mm 500 mm 200
		8,0	76°	56,6	40,1	500		
		12,0	73°	56,6	36,1	1290		

CARATTERISTICHE TECNICHE - TECHNICAL FEATURES



A	distanza dal centro di rotazione - rotor centre distance	
B	valore per calcolo bordo - value for calculating flange sizes	(DNC valore/value)
C	valore per calcolo tonnellaggio - value for calculating tonnages	
R	raggio cava - corner radius	(DNC valore/value)

RVHD3

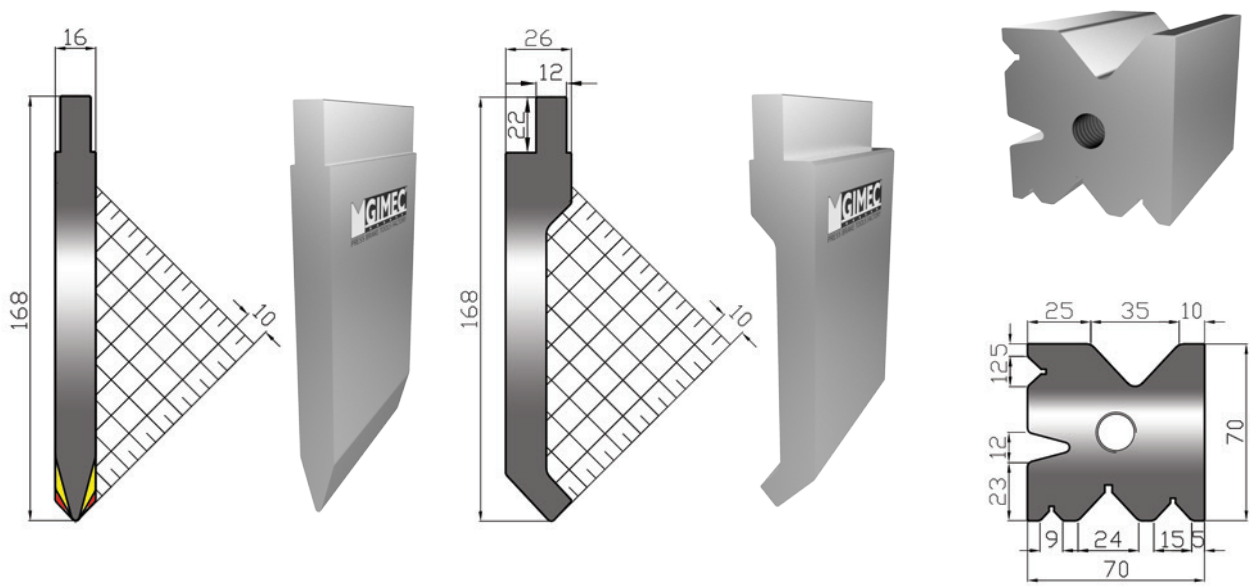


V mm	40 ÷ 118	max kN/mt	3500	lunghezze - lengths	mm 500 - 200
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ROLLA-V®

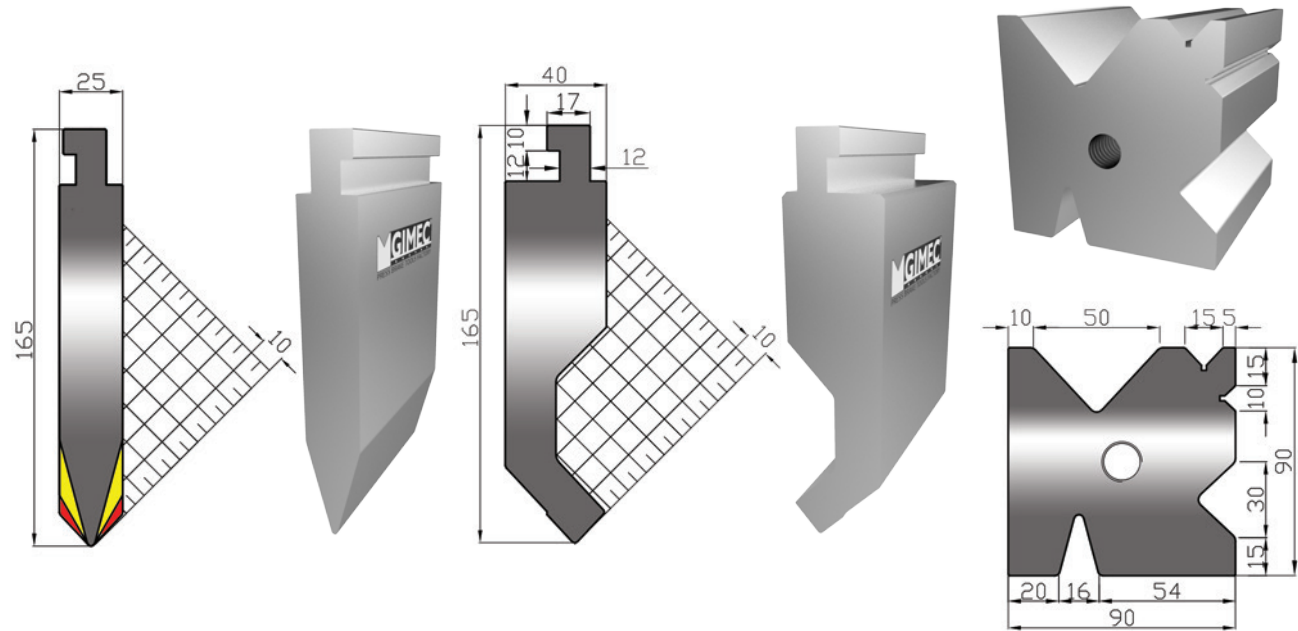
TIPO TYPE 4

kN 300 - 600



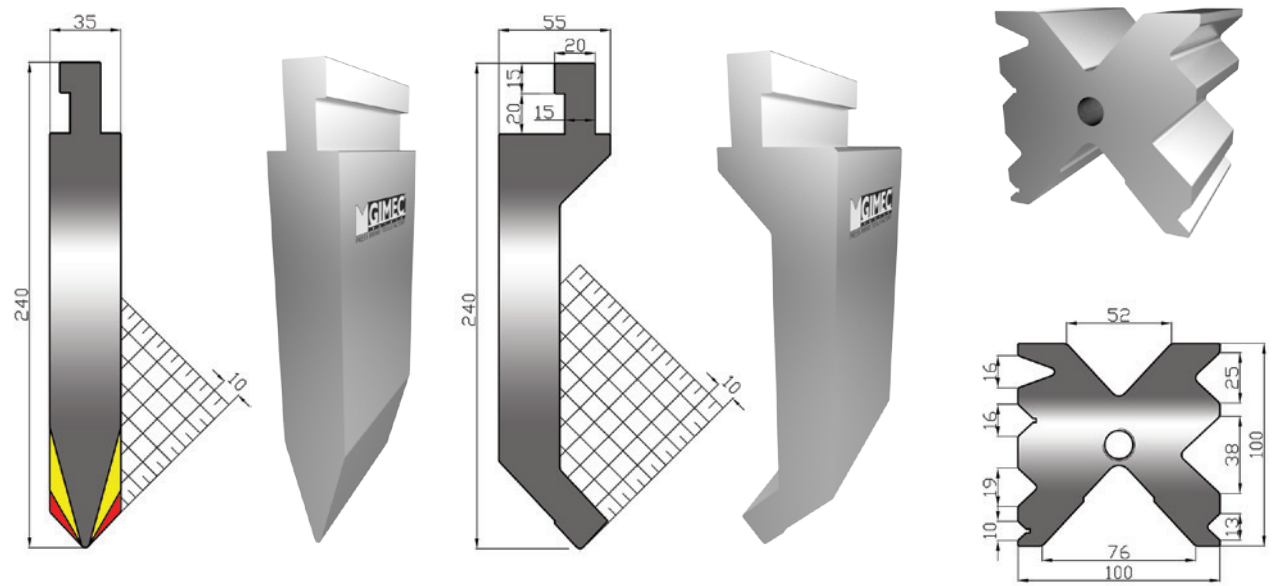
USH 168	USH 168	USH M 70
B=86° C=60° D=30° R1,5	A = 86° R1,5	V9-12-15-24-35/86°+V12/30°

kN 800 - 1350



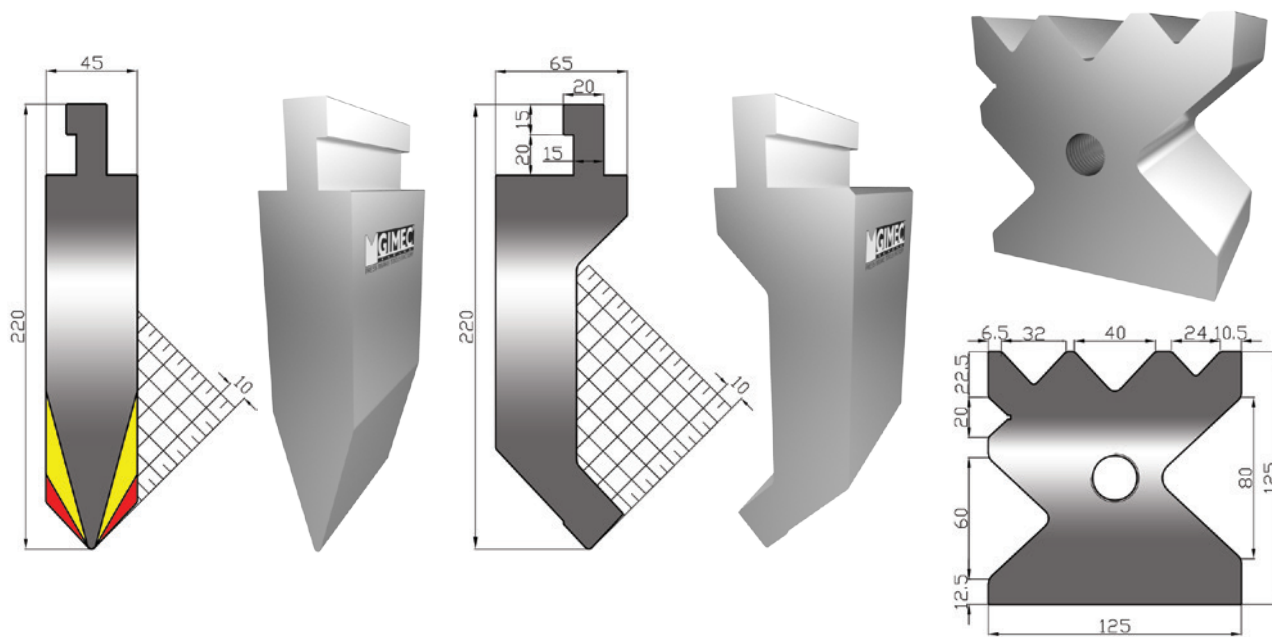
USH 165	USH 165	USH M 90
B=86° C=60° D=30° R1,5	A = 86° R1,5	V10-15-30-50/86°+V16/30°

kN 1600 - 2800



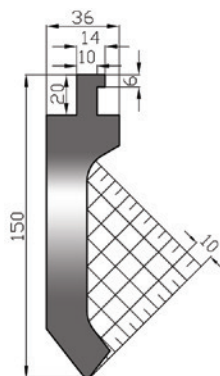
USH 240	USH 240	USH M 100
B=86° C=60° D=30° R2,0	A = 86° R2,0	V10-13-16-19-25-38-52-76/86°+V16/40°

kN 3000 - 4000

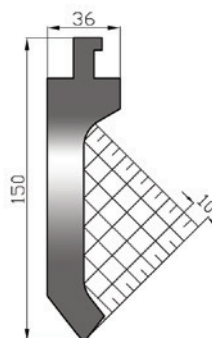


USH 220	USH 220	USH M 125
B=86° C=60° D=30° R2,0	A = 86° R2,0	V20-24-32-40-60-80/86°

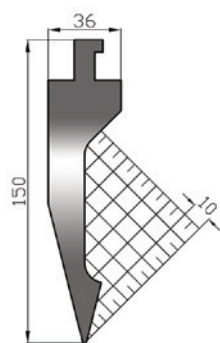
serie USH®

USN-PN-165

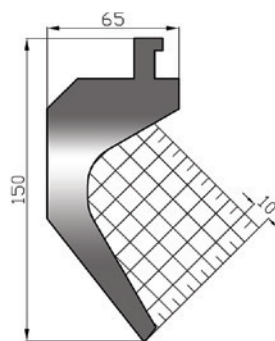
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
150,0	76°	2,0	42CM4 T HRC 52+58	1000

USN-PN-160

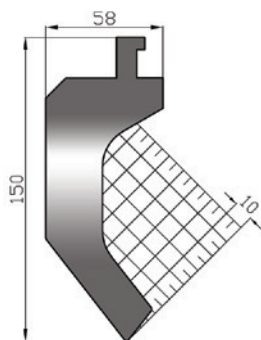
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
150,0	76°	1,0	42CM4 T HRC 52+58	800

USN-PN-150

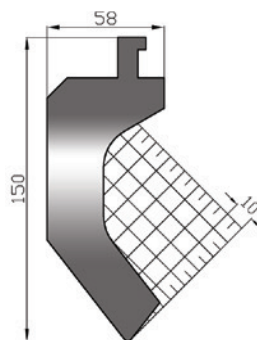
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
150,0	28°	1,0	42CM4 T HRC 52+58	800

USN-PN-190

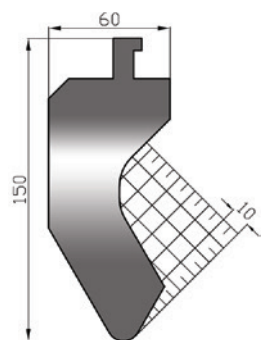
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
150,0	76°	1,0	42CM4 T HRC 52+58	500

USN-PN-140

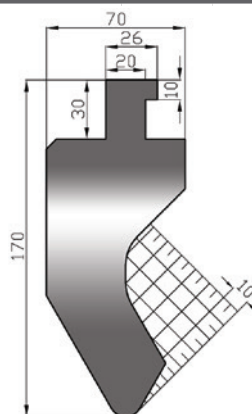
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
150,0	76°	1,0	42CM4 T HRC 52+58	1000

USN-PN-145

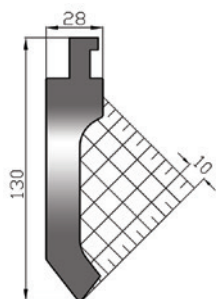
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
150,0	76°	2,0	42CM4 T HRC 52+58	1200

USN-PN-170

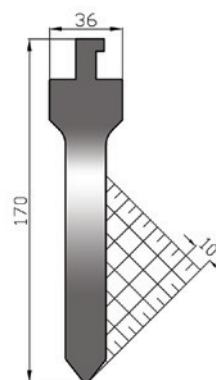
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
150,0	60°	8,0	42CM4 T HRC 52+58	2000

USN-PN-180

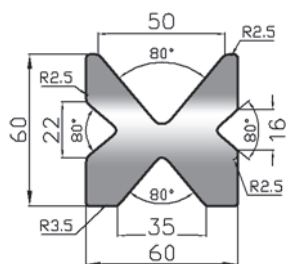
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
170,0	60°	8,0	42CM4 T HRC 52+58	2000

USN-PN-110

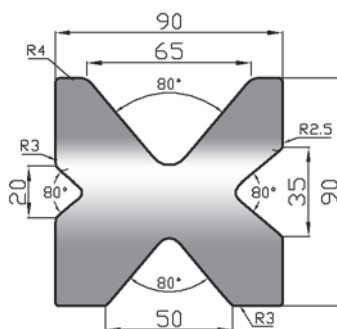
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
130,0	76°	1,0	42CM4 T HRC 52+58	600

USN-PN-195

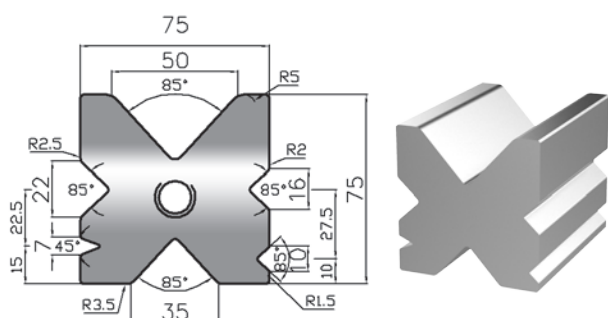
altezza height mm	angolo degree	raggio radius	acciaio steel	max kN/mt
170,0	76°	2,0	42CM4 T HRC 52+58	1000

USN-MN-925

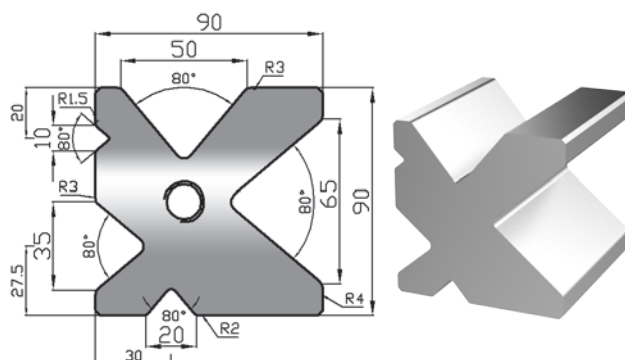
dimensioni dimensions	numero di cave number of vee	acciaio steel
mm 60 x 60	4	42CM4 T HRC 52+58

USN-MN-155

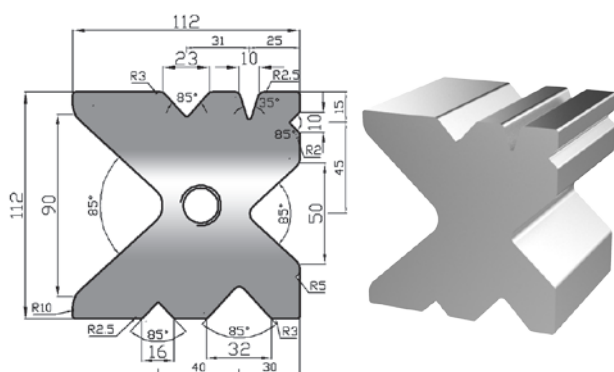
dimensioni dimensions	numero di cave number of vee	acciaio steel
mm 90 x 90	4	42CM4 T HRC 52+58

USN-MN-1000

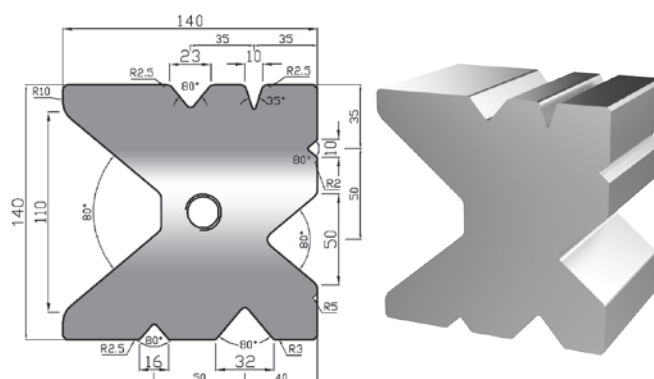
dimensioni dimensions	numero di cave number of vee	acciaio steel
mm 75 x 75	6	42CM4 T HRC 52+58

USN-MN-135

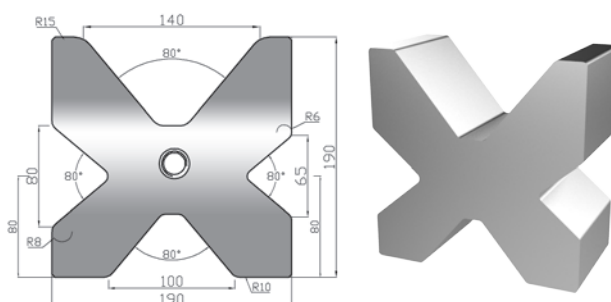
dimensioni dimensions	numero di cave number of vee	acciaio steel
mm 90 x 90	5	42CM4 T HRC 52+58

USN-MN-915

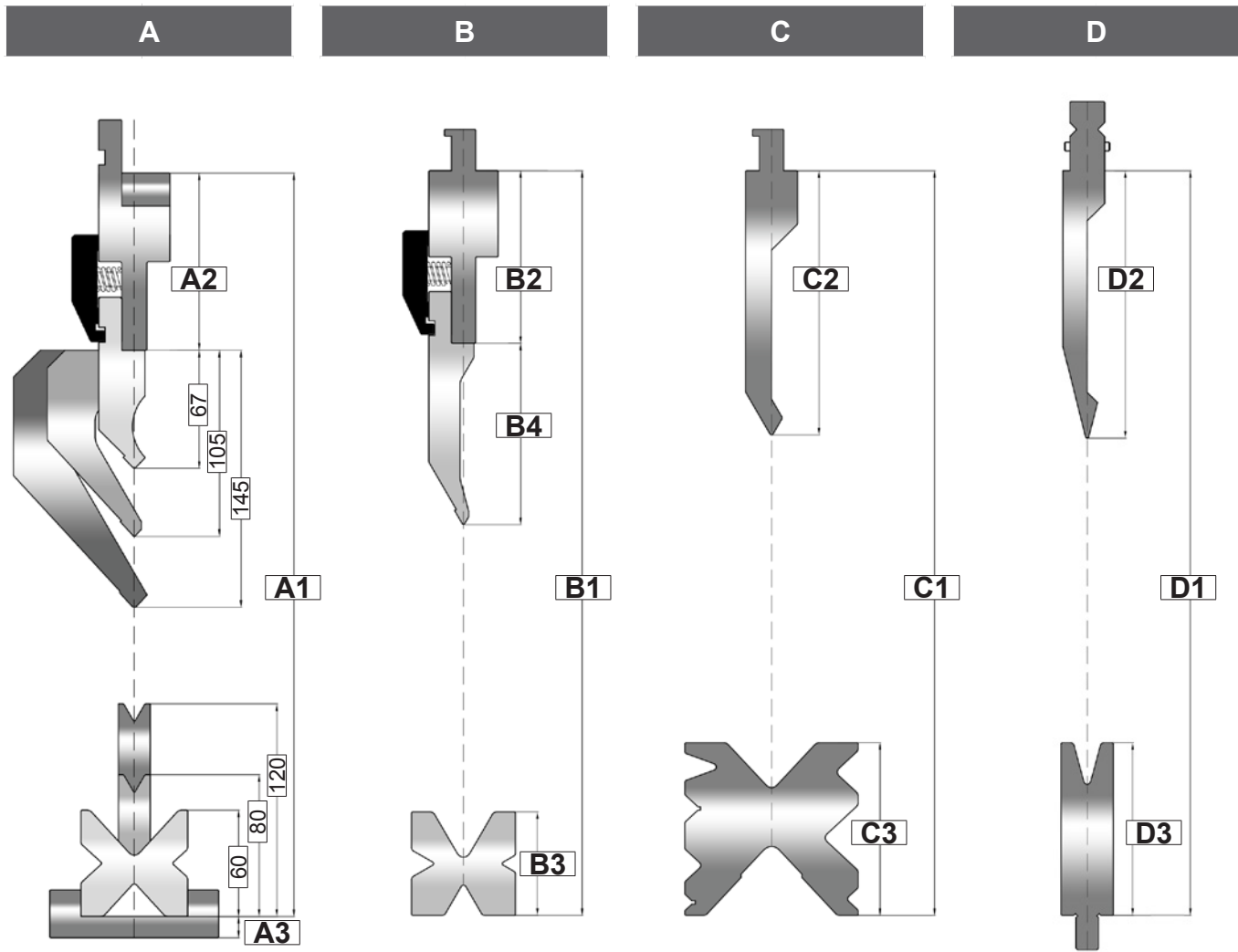
dimensioni dimensions	numero di cave number of vee	acciaio steel
mm 112 x 112	7	42CM4 T HRC 52+58

USN-MN-920

dimensioni dimensions	numero di cave number of vee	acciaio steel
mm 140 x 140	7	42CM4 T HRC 52+58

USN-MN-159

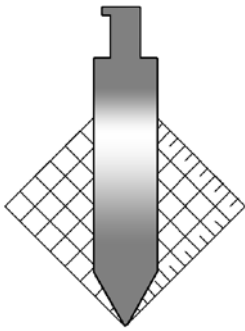
dimensioni dimensions	numero di cave number of vee	acciaio steel
mm 190 x 190	4	42CM4 T HRC 52+58



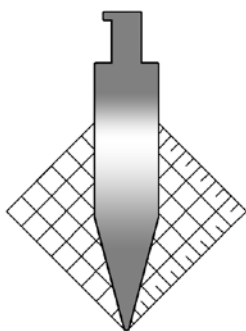
STAMPI

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

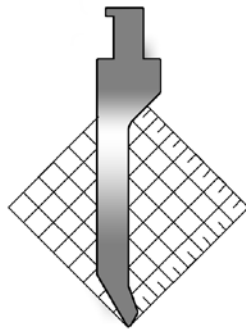
LS 60°



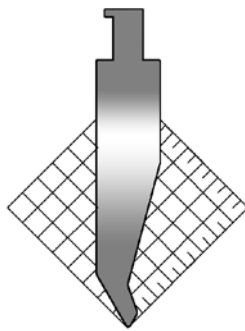
LS 30°



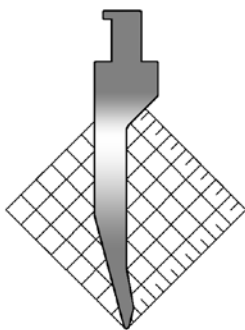
LD 60°



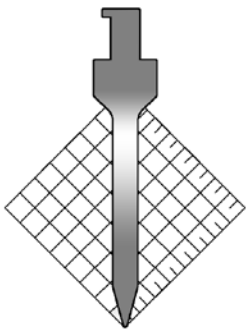
LDN 60°



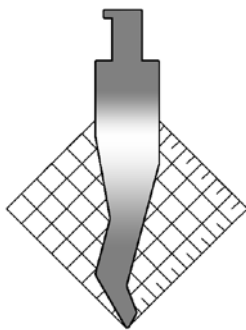
LX 30°



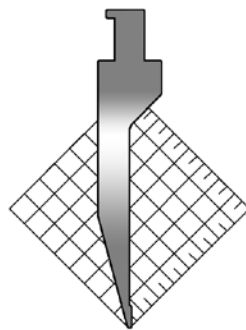
LDP 30°



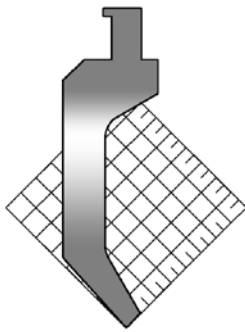
LDS 60°



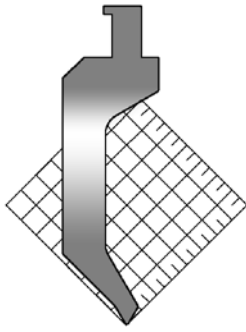
LUP 15°



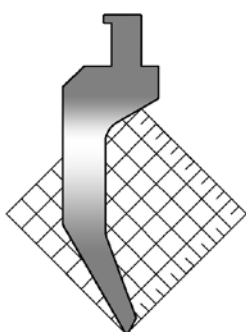
LSCC 84°



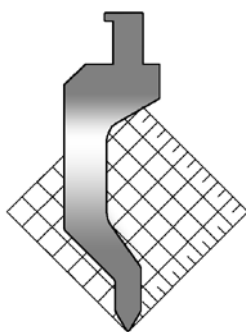
LSCC 60°



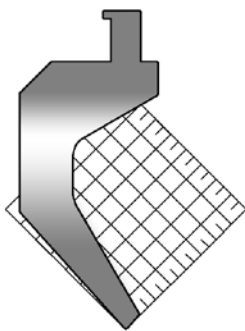
LSCZ 60°



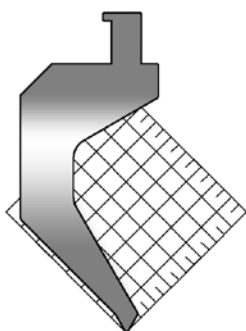
LSCY 60°



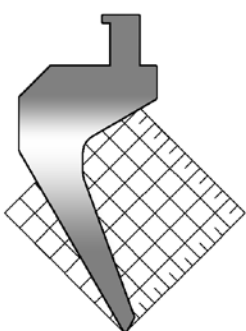
LCC 84°



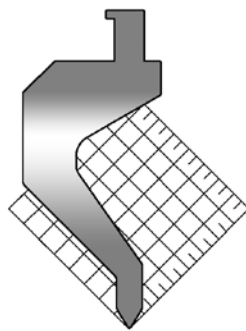
LCC 60°



LCZ 60°

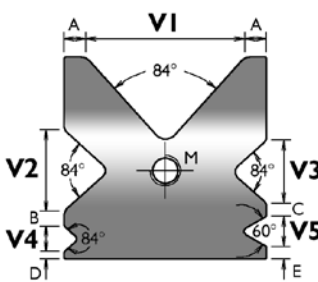


LCY 60°



STAMPI

UPPER TOOLS

M	tipo type	dimensioni dimensions mm	84°				60°	A	B	C	D	E	M
			V1	V2	V3	V4	V5						
	M 60	60 x 60	40	25	20	10	12	10	6	5	3	5	
	M 70	70 x 70	50	32	25	10	12	10	6	5	3	5	M12
	M 80	80 x 80	63	32	25	10	12	8,5	6	5	3	5	M12
	M 90	90 x 90	70	40	25	10	12	10	6	5	3	5	M16
	M 100	100 x 100	80	40	32	10	12	10	9	5	3	5	M16
	M 110	110 x 110	90	50	32	10	12	10	9	5	3	5	M16
	M 120	120 x 120	90	50	40	12	16	15	10	10	5	5	M16
	M 130	130 x 130	110	50	40	12	16	10	10	10	5	5	M16
	M 140	140 x 140	110	50	40	16	20	15	10	10	5	5	M20

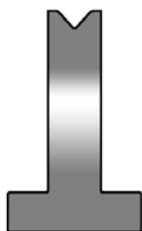
M1	M2	M3	M4
----	----	----	----



M5	M8	M9	M10
----	----	----	-----



M11	M12	M13	M14
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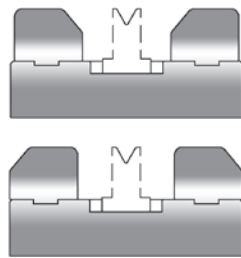
STAMPI

LOWER TOOLS

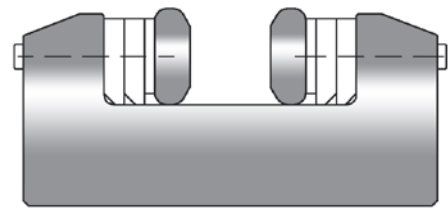
M19



M20 A-B

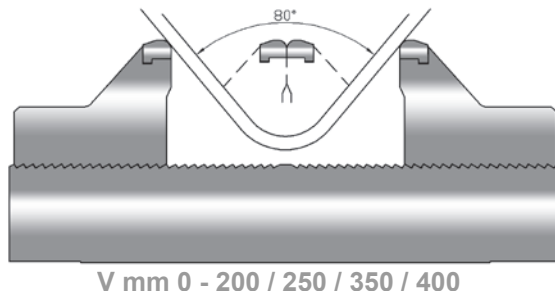


M16



V-MUTABILIS matrice regolabile - adjustable die

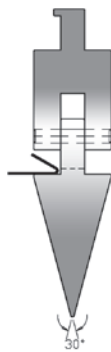
carico-load max 4000 kN/mt



V mm 0 - 200 / 250 / 350 / 400



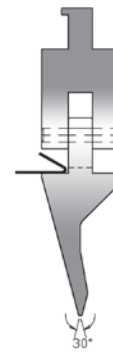
SP



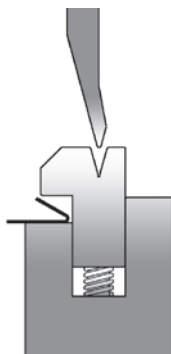
SPD



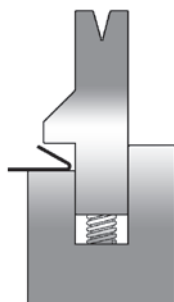
SPX



MP



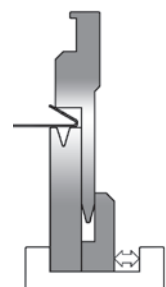
MPS

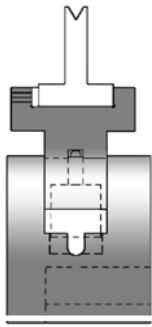
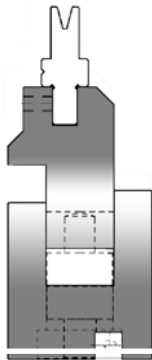
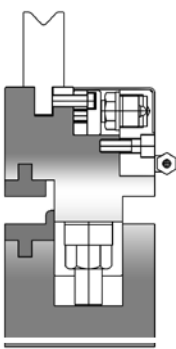
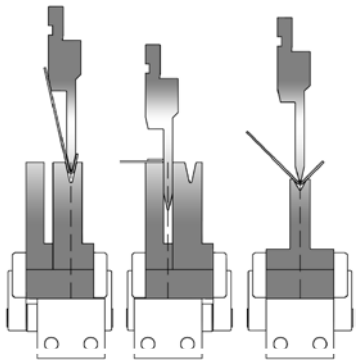
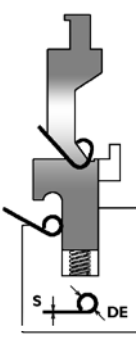
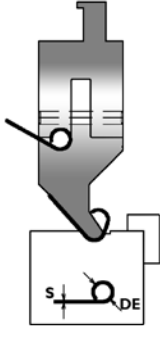
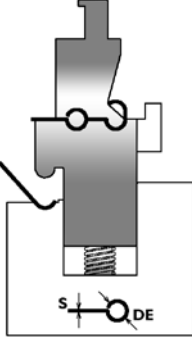
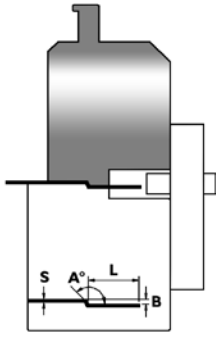
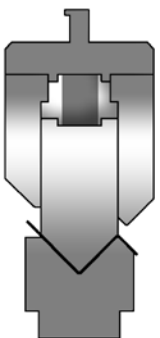
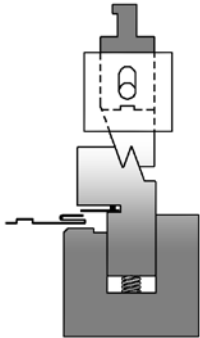
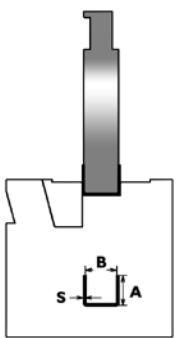
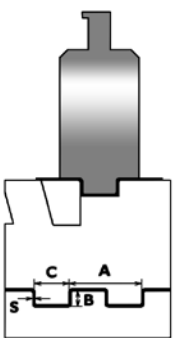
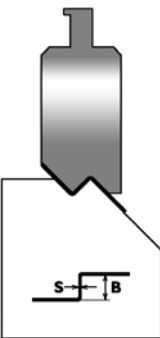
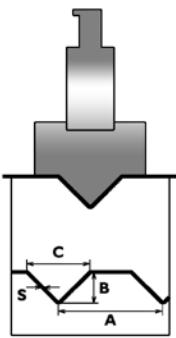
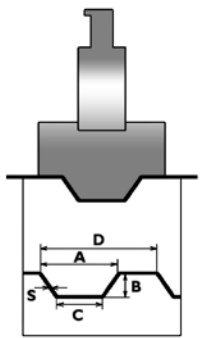
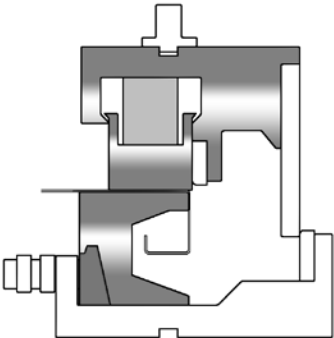


SP1



SP2

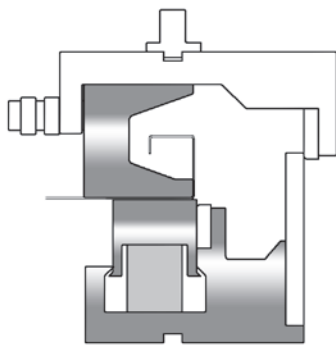


SP3 A 	SP3 B 	SP3 C 	DUO 
SP4 	SP5 	SP6 	SP7 
SP8 	SP9 	SP10 	SP11 
SP12 	SP13 	SP14 	SP15/S 

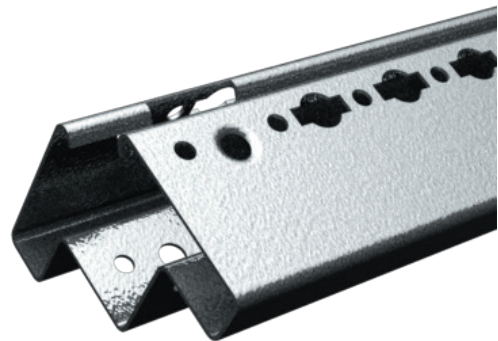
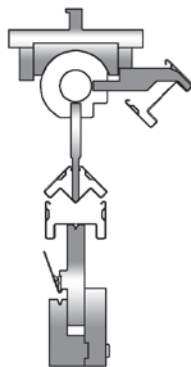
STAMPI

SPECIAL TOOLS

SP15/E



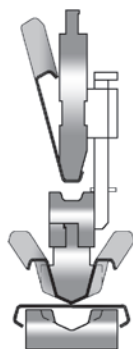
SP16



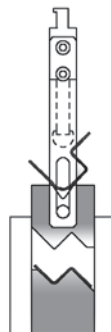
SP17



SP18



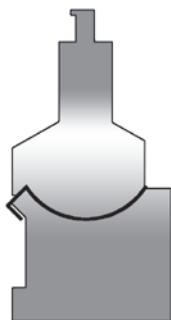
SP19



SP20



SP21



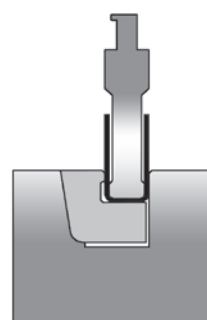
SP22



SP23



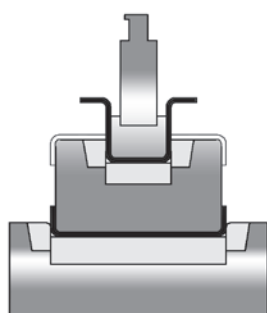
SP24



SP25



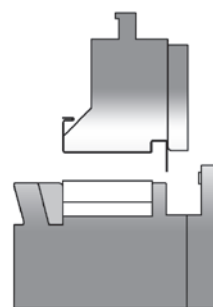
SP26



SP27

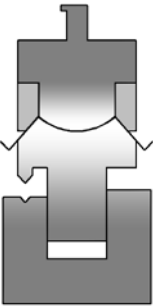
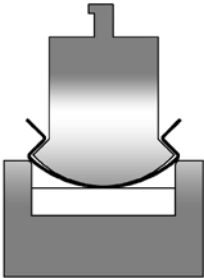
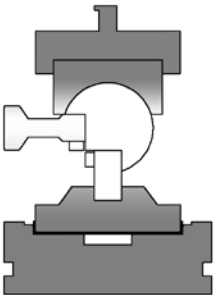
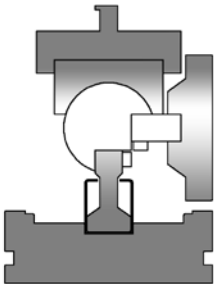
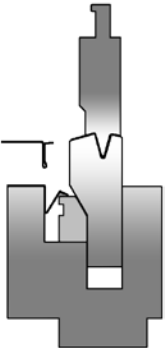
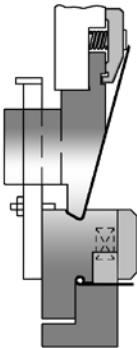
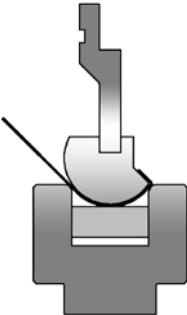
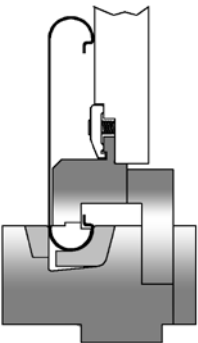
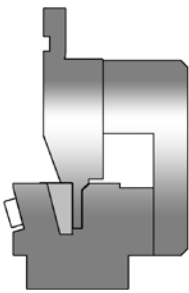
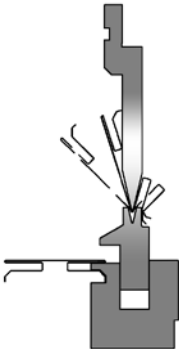
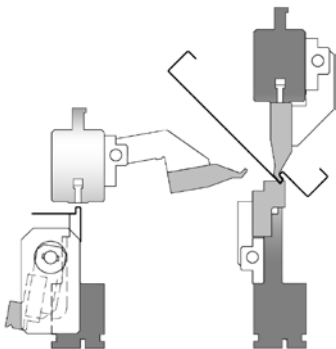
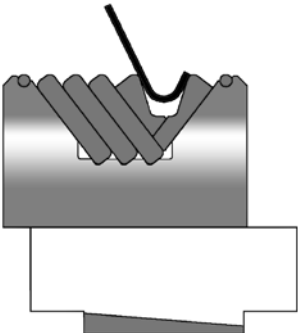
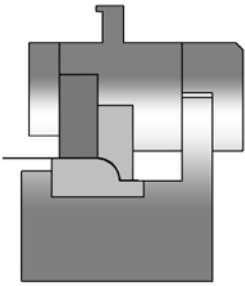
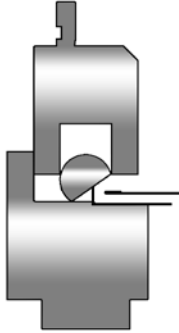
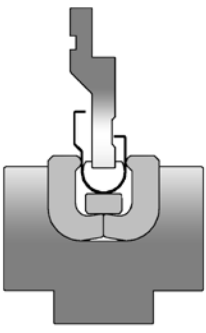


SP28



STAMPI

SPECIAL TOOLS

SP29	SP30	SP31	
			
SP32	SP33	SP34	SP35
			
SP36	SP37	SP38	SP39
			
SP40	SP42	SP43	SP44
			

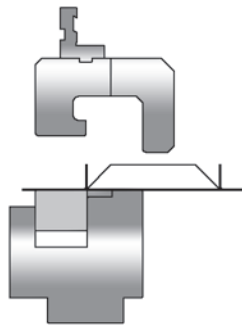
STAMPI

SPECIAL TOOLS

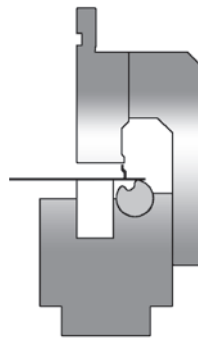
SP45



SP46



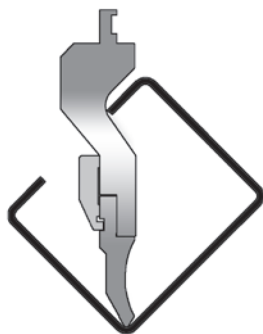
SP47



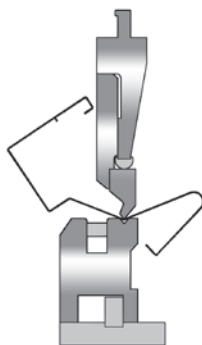
SP48



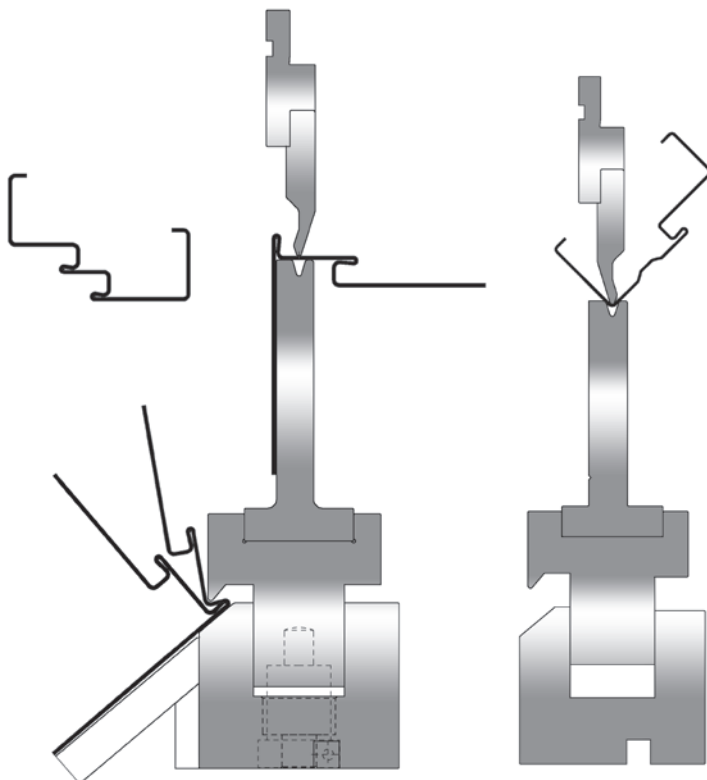
SP49



SP50



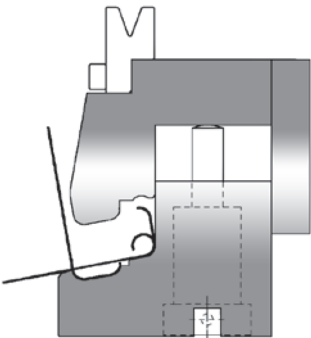
SP55



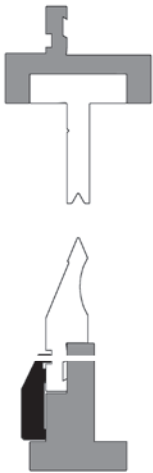
STAMPI

SPECIAL TOOLS

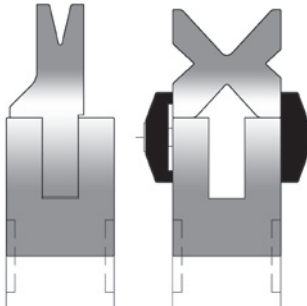
SP53



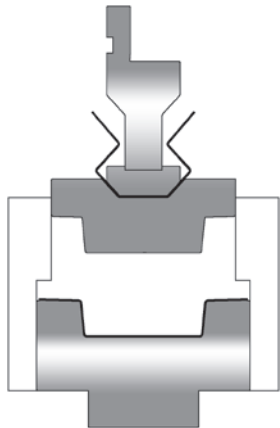
SP56



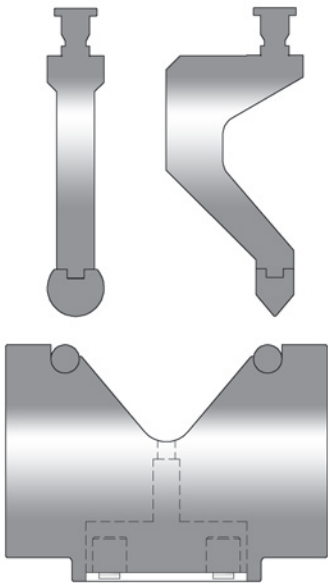
SP57



SP59



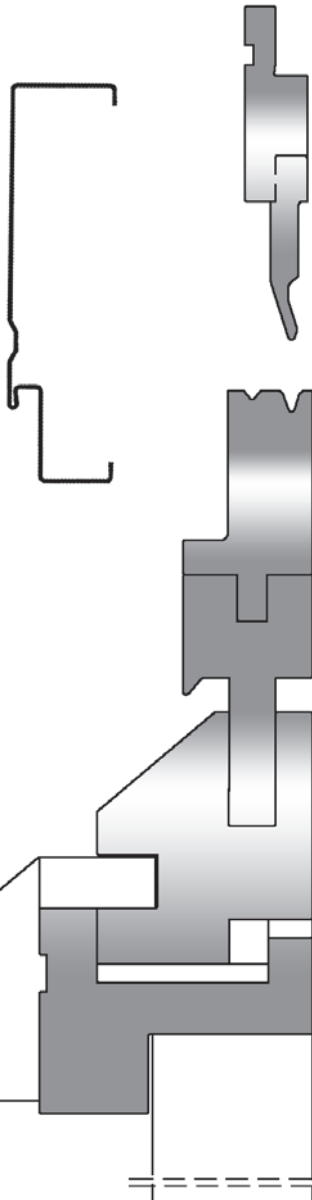
SP60



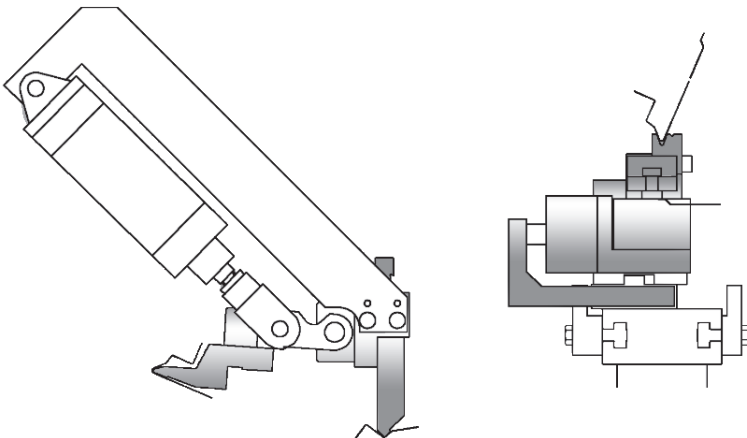
SCA-MOB-PNEU



SP62

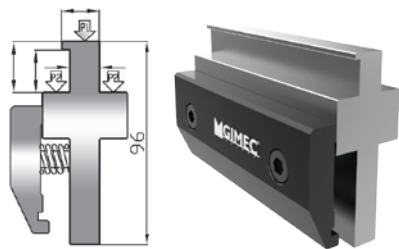
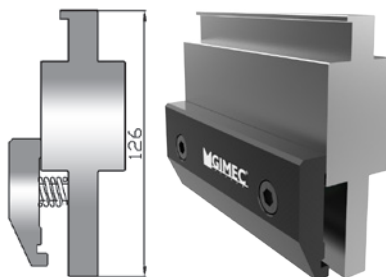
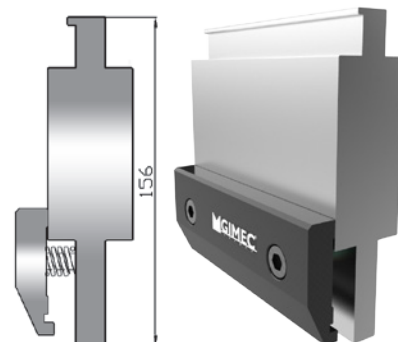
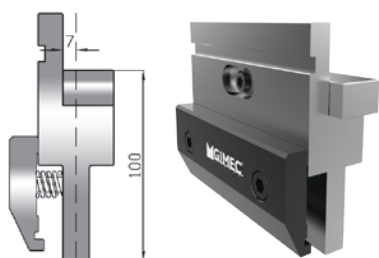
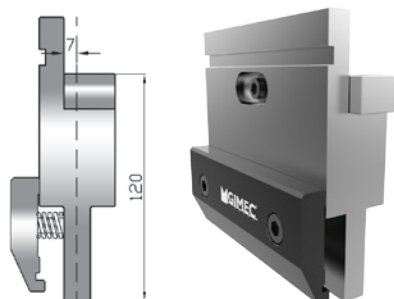
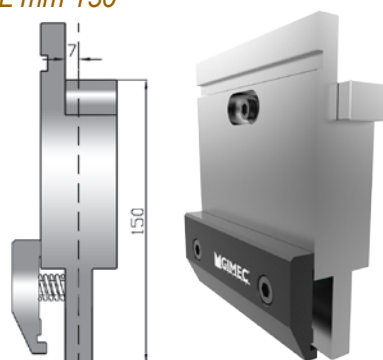
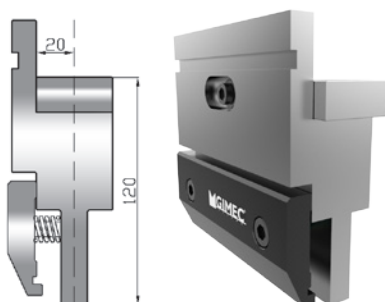
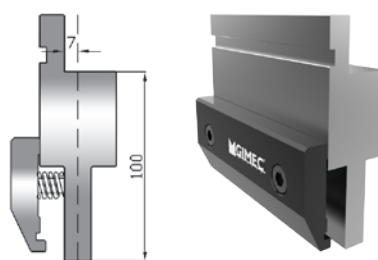
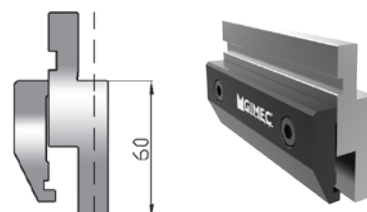
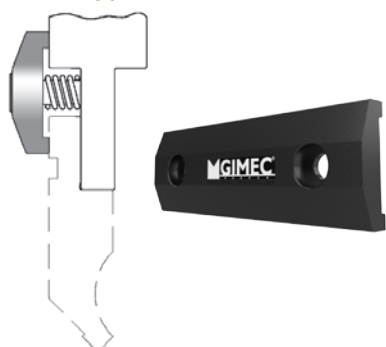
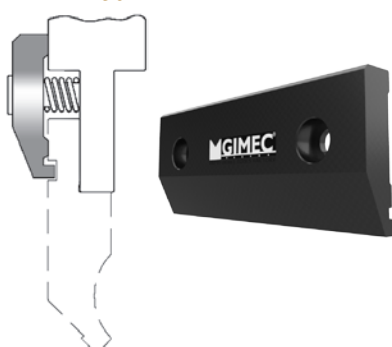
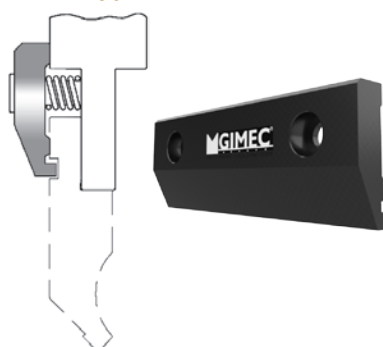


SP52



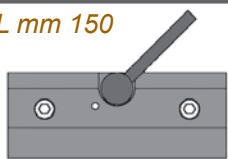
STAMPI

SPECIAL TOOLS

PL3 h96 + ST2
L mm 150

PL3 h126 + ST2
L mm 150

PL3 h156 + ST2
L mm 150

PL5 h100 + ST2
L mm 150

PL5 h120 + ST2
L mm 150

PL5 h150 + ST2
L mm 150

PL7 h120 + ST2
L mm 150

PL8 h100 + ST2
L mm 150

PL14 h60 + ST2 h mm 53
L mm 150

ST1
L mm 150

ST2
L mm 150

ST2 h mm 53
L mm 150


ST2/L

L mm 150



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

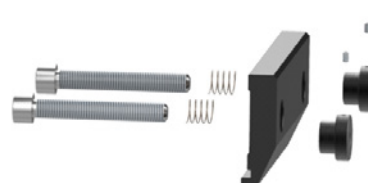
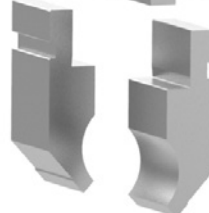
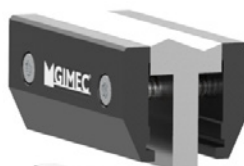


ST2/X

L mm 150



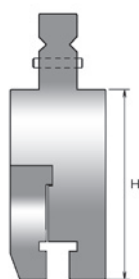
KIT/ST2 h 60 mm



PL4

L mm 150

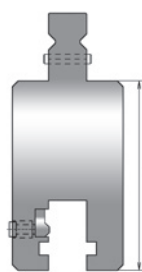
Trumpf-Wila ► traditional



PL6

L mm 150

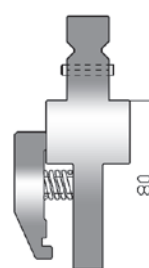
Trumpf-Wila ► Trumpf-Wila



PL9 + ST2

L mm 150

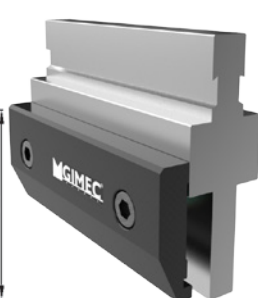
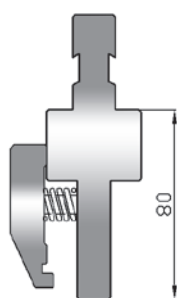
Trumpf-Wila ► Amada



PL10 + ST2

L mm 150

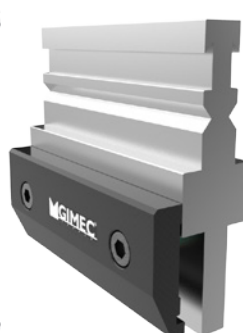
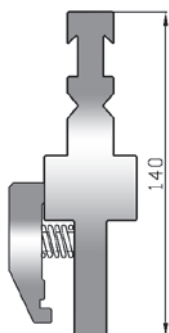
COLGAR ► Amada



PL11 + ST2

L mm 150

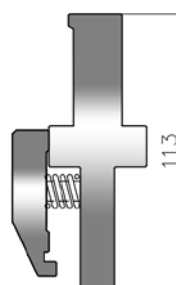
Beyeler RFA ► Amada



PL12 + ST2

L mm 150

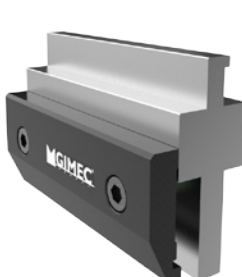
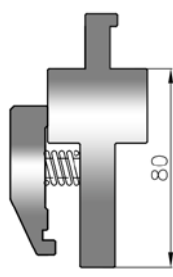
Beyeler S ► Amada



PL13 + ST2

L mm 150

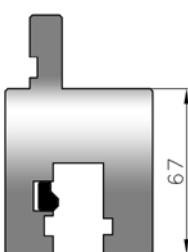
LVD ► Amada



PL16

L mm 150

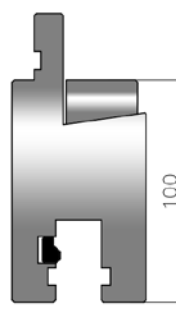
Amada ► Trumpf-Wila

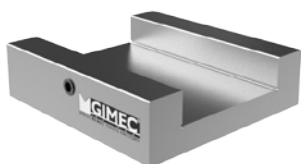
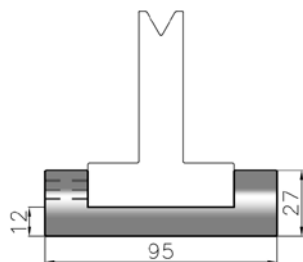
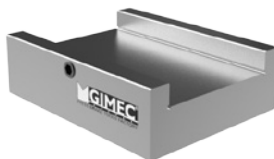
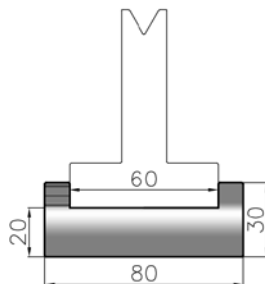
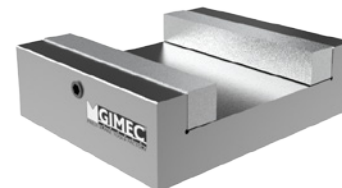
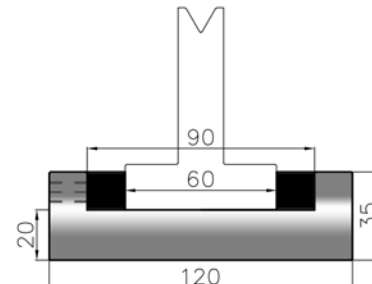
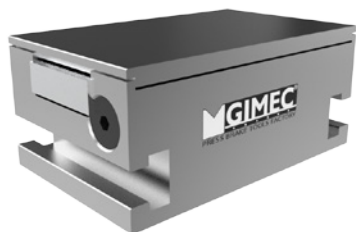
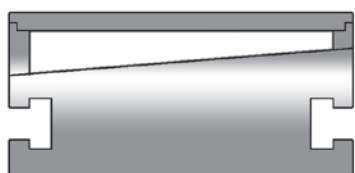
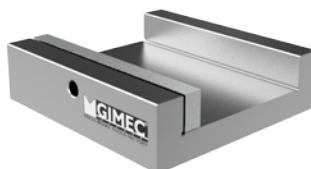
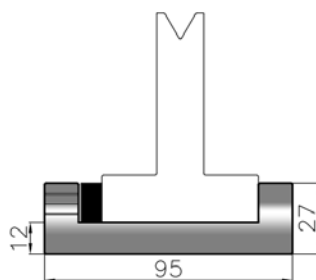
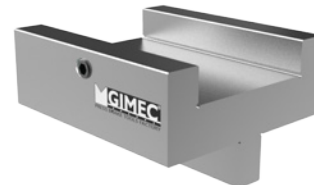
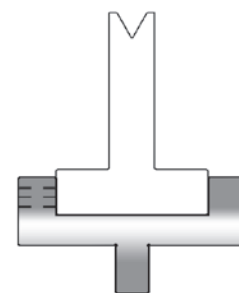
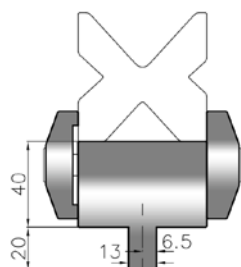
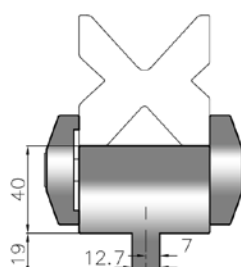
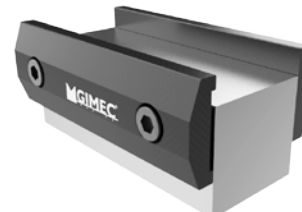
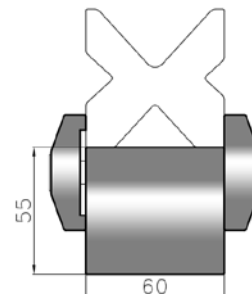


PL17

L mm 150

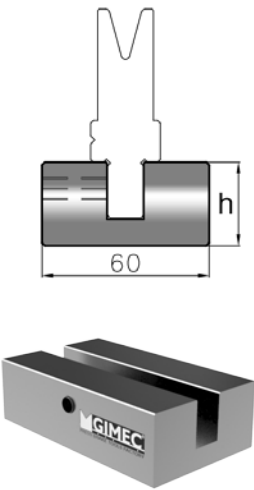
Amada ► Trumpf-Wila



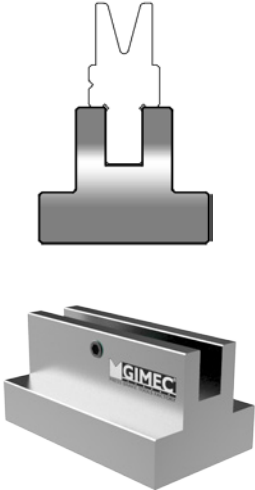
PM6*L mm 2100-2600-3100-4200***PM6 SHORT mm 60***L mm 520-1050***PM6 SHORT mm 60/90***L mm 520-1050***PM5****PM7***L mm 2100-2600-3100-4200***PM8****PM9 / T***L mm 835 - 415 Amada ▶ Trumpf-Wila***PM9 / L***L mm 835 - 415 Amada ▶ LVD***PM9 / 60***L mm 835 - 415*

PM10 - h 30 - h 60 mm

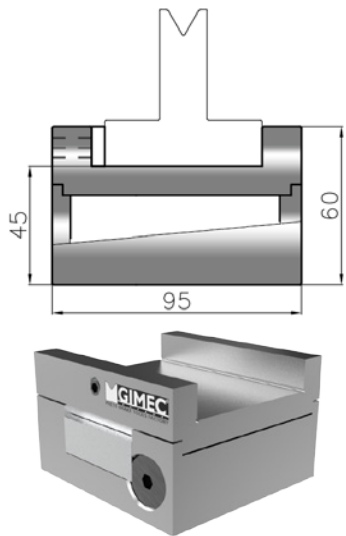
L mm 500-1000



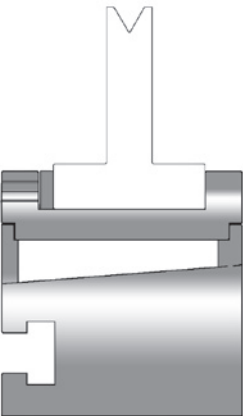
PM11



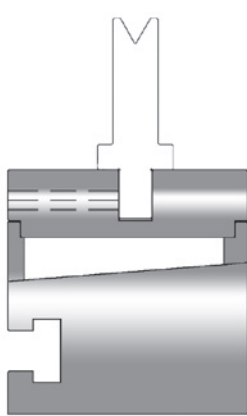
PM12



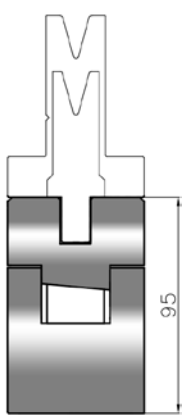
PM13



PM14



PM15



PORTA UT

SISTEMA AUTOMATICO DI CENTINATURA - AUTOMATIC CROWNING SYSTEM

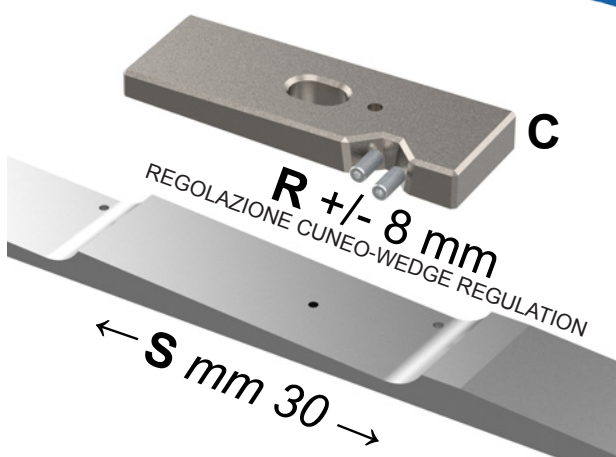


Con l'utilizzo di questo sistema è possibile compensare meccanicamente la flessione che si verifica sulle presse piegatrici durante la fase di piegatura e che determina angoli di piega irregolari. La flessione varia in funzione della lunghezza di piegatura ed in base al rapporto tra la larghezza della cava ed il tipo e spessore della lamiera.

Il sistema TABLUS (**brevettato**) è composto da una barra speciale (**S**) che scorre in contrapposizione a dei cunei (**C**). Ogni cuneo, se necessario, può essere calibrato singolarmente (**R**). La barra è azionabile manualmente (**sistema TCM-TSM**) oppure attraverso un motoriduttore controllato dal DNC della pressa piegatrice (**sistema TCMR-TSMR**). La regolazione della TABLUS viene effettuata in modo rapido e preciso prima della fase di piegatura. Ogni singola TABLUS è prodotta in base alle caratteristiche della pressa piegatrice su cui verrà utilizzata, in modo da ottimizzare il suo funzionamento. Questo avviene attraverso l'utilizzo di uno speciale software, denominato **DATA TABLUS**, che calcola le flessioni della pressa piegatrice e fornisce indicazioni su come realizzare il sistema di centinatura. Si ottiene quindi un sistema in grado di garantire una regolazione centesimale ed accurata.

Esistono più versioni di TABLUS che si differenziano in base al tipo di matrici utilizzate. Le versioni TCM-TCMR vengono fornite complete di staffe per il bloccaggio manuale delle matrici. Su richiesta può essere fornito un sistema pneumatico per il bloccaggio rapido. TABLUS viene fornita pronta per il fissaggio e l'allineamento alla pressa piegatrice.

TABLUS



DATA TABLUS

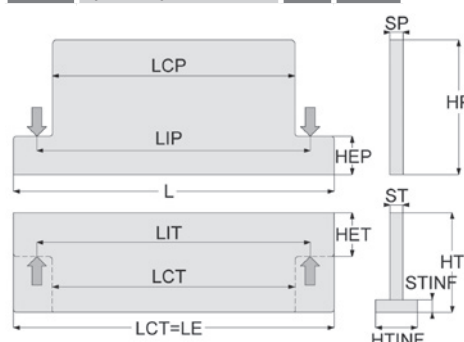
P	forza pressa	kN	1200
PESTONE			
LIP	distanza appoggi	mm	2650
LCP	lunghezza centrale	mm	2260
HP	altezza centrale	mm	1235
HEP	altezza esterna	mm	495
SP	spessore pestone	mm	50

esempio - example

L	* lunghezza pressa	mm	3100
TRAVERSA INFERIORE			
LIT	distanza appoggi	mm	2650
LCT	** lunghezza centrale	mm	2600
HT	altezza centrale	mm	845
HET	** altezza esterna	mm	435
ST	spessore traversa	mm	100
LIPm	LIP<LIPm=cunei negativi limite cunei negativi	mm	2430

* lunghezza L sempre pari a multiplo di 200+100

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



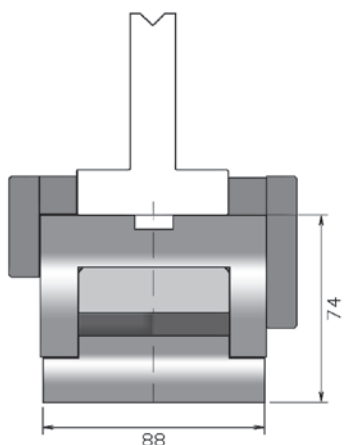
RINFORZO SU TRAVERSA INFERIORE

STINF	mm	120
HTINF	mm	250

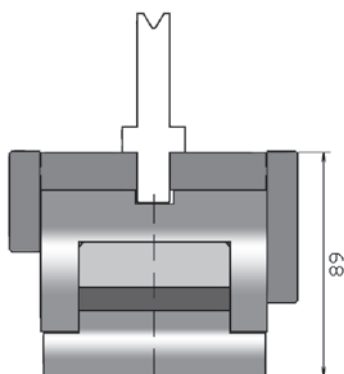
cuneo	distanze	STRISCIA S max compensazione con regolazione 30 mm	CUNEO C max compensazione con regolazione 8 mm
1	150	0,30 mm	0,08 mm
2	350	0,62 mm	0,17 mm
3	550	0,88 mm	0,24 mm
4	750	1,07 mm	0,28 mm
5	950	1,18 mm	0,32 mm
6	1150	1,27 mm	0,34 mm
7	1350	1,32 mm	0,35 mm
8	1550	1,34 mm	0,36 mm
9	1750	1,32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

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

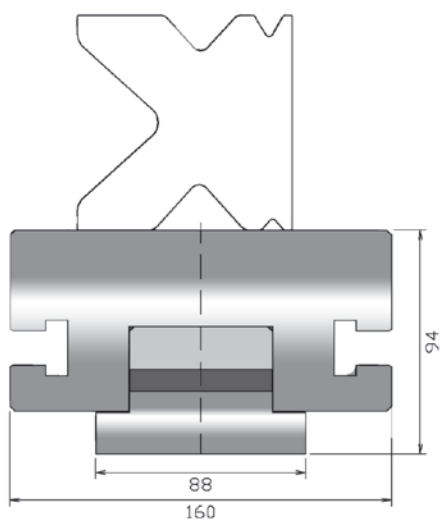
TCM-TCMR 60/90

L mm 3100-4100-5100-6100

TCM-TCMR 13

L mm 3100-4100-5100-6100

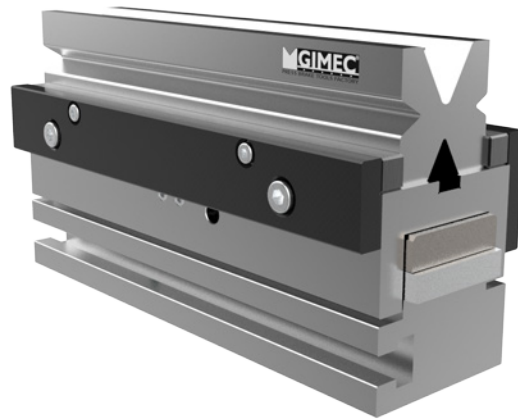
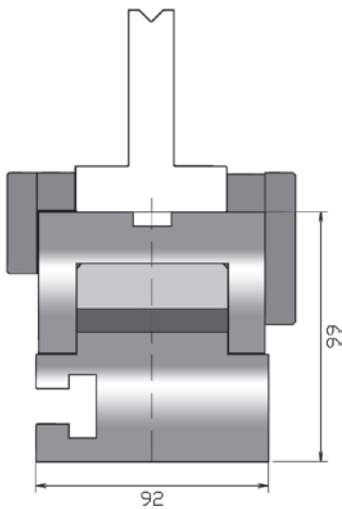
TM-TMR 160

L mm 3100-4100-5100-6100

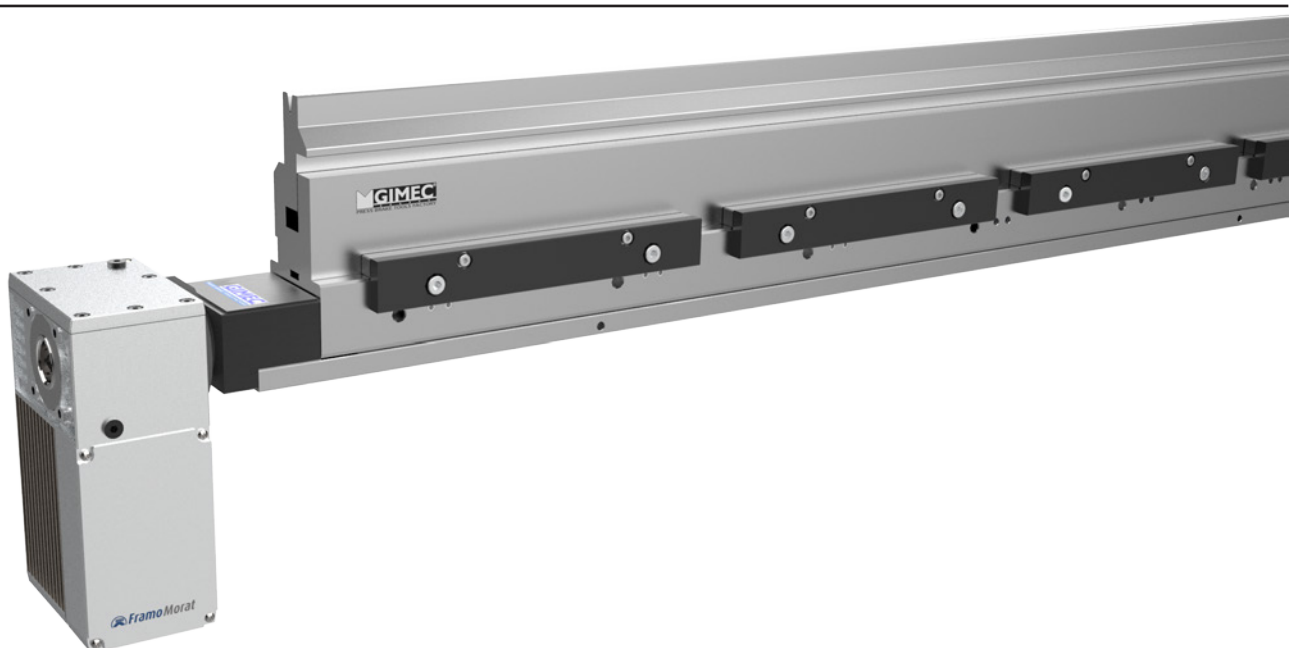
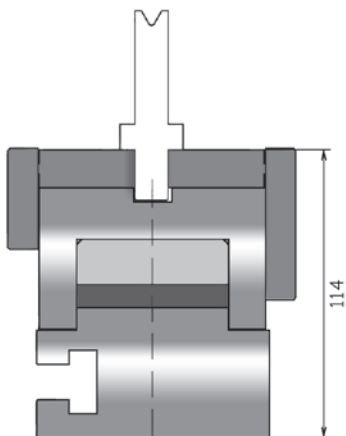
TABLUS

BREVETTATO
PATENTED

TCM-TCMR 60/90 + T SLOT

L mm 3100-4100-5100-6100

TCM-TCMR 13 + T SLOT

L mm 3100-4100-5100-6100

SISTEMA DI CENTINATURA INTEGRATO - INTEGRATED CROWNING SYSTEM

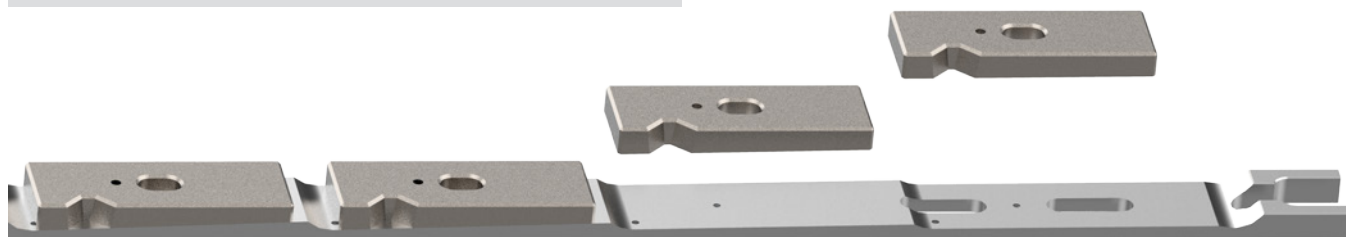
Il sistema di centinatura TABLUS viene fornito anche per essere integrato nella traversa inferiore della pressa piegatrice.

La tavola portamatrici deve avere le caratteristiche minime sotto indicate. Possiamo fornire la tavola oppure comunicare al cliente le specifiche tecniche di lavorazione sia della tavola che della traversa per l'alloggiamento del sistema di centinatura.

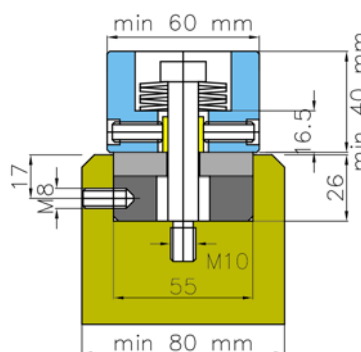
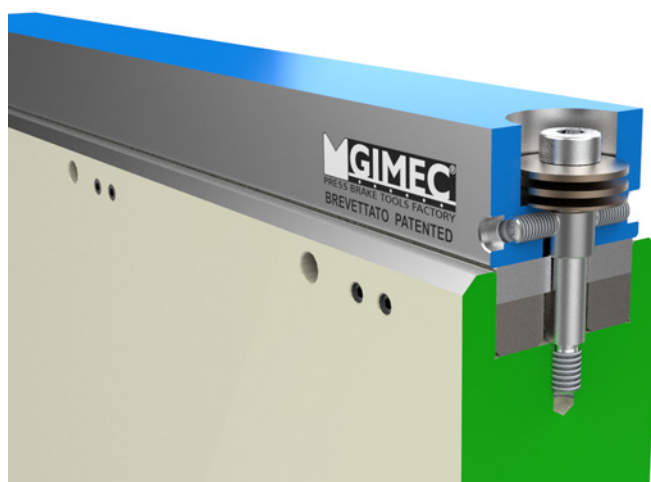
Crowning system TABLUS can be supplied also to be integrated inside press brake lower beam.

The holder table must have the minimum characteristics mentioned below.

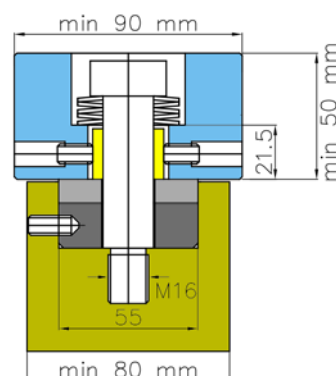
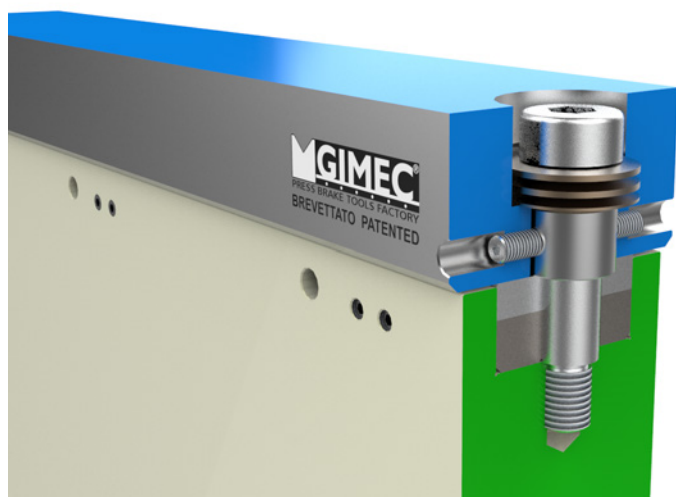
We can supply it or we can give to the customer the processing specifications both for the table and the lower beam for the housing of the crowning system.



TSM-TSMR 60



TSM-TSMR 90



TABLUS

BREVETTATO
PATENTED

LAME RETTILINEE PER CESCOIA - RECTILINEAR SHEAR BLADES



LAME

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



Gimec has many years of experience in the production of rectilinear blades for sheet metal cutting.

For their manufacture are used high quality of steels which allow the cutting of high strength sheet metal such as stainless steel sheets, manganese and silicon sheets.

We perform the heat treatment with technologically advanced systems, managed by qualified employees team.

The surface grinding is performed by using tangential grinding to guarantee the maximum precision and to avoid micro-cracks creations that could compromise the duration of the blades.

At the end of the grinding operations the blades are carefully demagnetized.

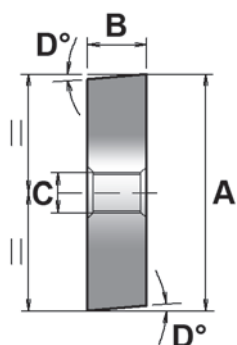
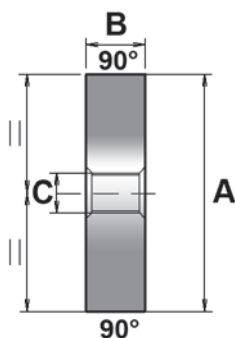
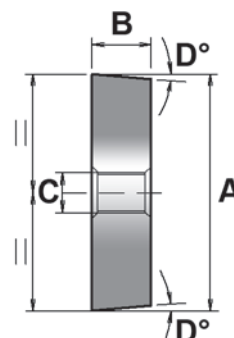
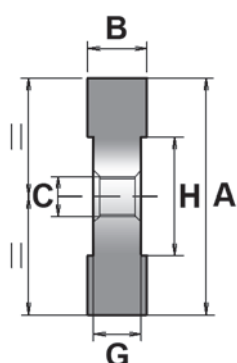
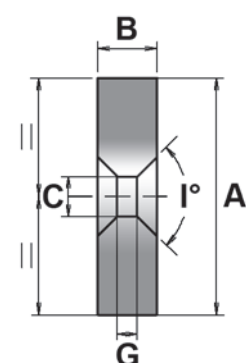
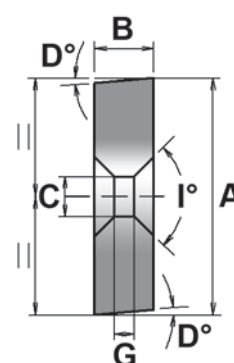
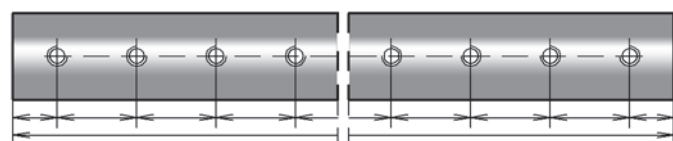
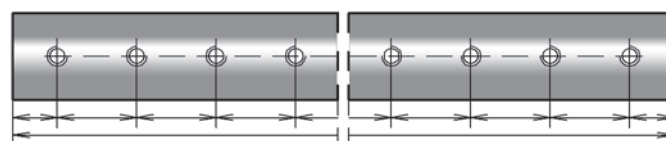
We are also equipped to perform the blades regrinding in very short time.

LAME ACCIAIO tipo PV (polivalente)

Questa tipologia di lame è adatta al taglio di lamiera con resistenza fino a 750 kN/mm^2 (lamiera in ferro e acciaio inox). Per esigenze specifiche, siamo in grado di consigliare e fornire lame con differenti tipologie di acciaio e trattamento termico.

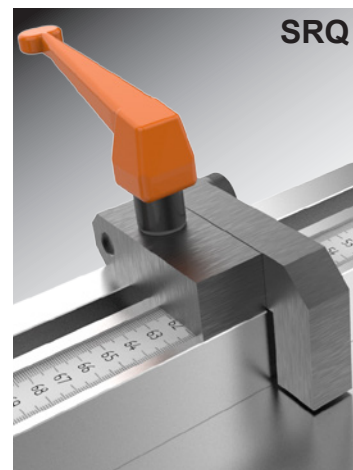
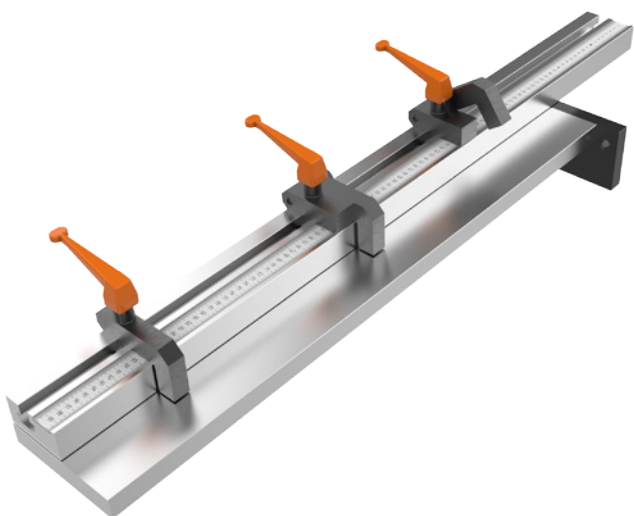
STEEL BLADES type PV (polivalent)

This type of blades is suitable for cutting sheets metal with resistance up to 750 kN/mm^2 (sheet iron and stainless steel). For specific needs, we are able to recommend and supply blades with different types of steel and heat treatment.

L1**L2****L3****L4****L5****L6****SUPERIORE - UPPER****INFERIORE - LOWER**

SQUADRA LATERALE PER CESCOIA - SQUARING ARM FOR SHEAR

SQ

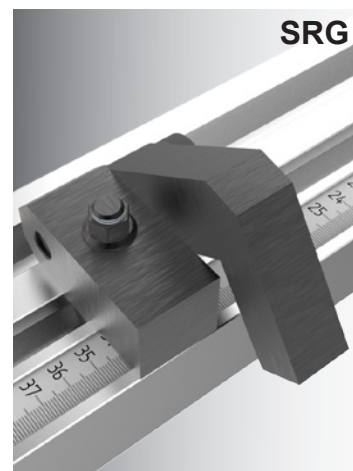
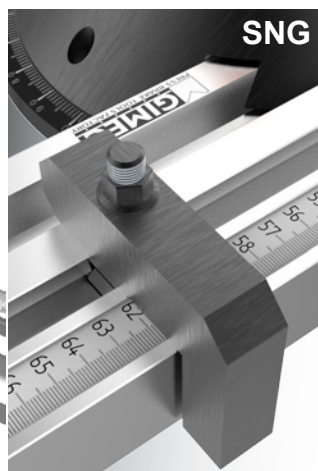


Realizziamo squadre laterali per cesoia di qualunque lunghezza che possono essere utilizzate sul lato sinistro o destro della macchina. La zona di appoggio lamiera è **temprata ad induzione** per evitare l'usura. Viene fornita completa di piastra applicazione, saltarelli fissi **SNQ**, saltarelli ribaltabili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

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

GONIOMETRO PER CESCOIA - GONIOMETER FOR SHEAR

G



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

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

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

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

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

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

RIFERIMENTI ANTERIORI PER CESCOIA - FRONT REFERENCES FOR SHEAR

R

Costruiamo 3 diverse tipologie di profili in acciaio, da utilizzare nella parte anteriore della cesoia, per facilitare la movimentazione e il posizionamento delle lamiera.

I riferimenti vengono forniti con i seguenti accessori:

- saltarelli escludibili o ribaltabili
- saltarelli con regolazione micrometrica della battuta
- blocchetti con sfere per facilitare lo scorrimento della lamiera
- rondelle escludibili per permettere la squadratura lamiera
- riga millimetrata incisa laser, graduata per lettura verticale
- eventuali sostegni regolabili in altezza

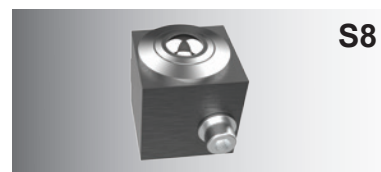
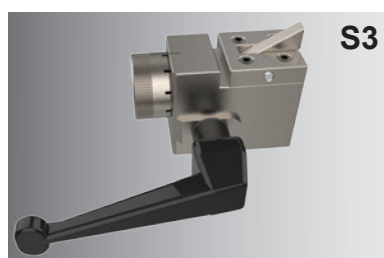
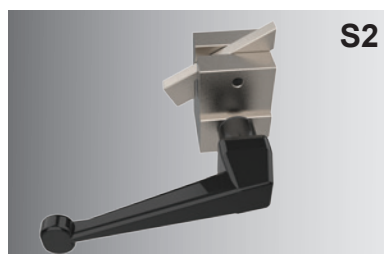
L'applicazione varia in funzione delle caratteristiche della cesoia.

We produce 3 different types of steel profiles which are used in the front part of the shears, in order to simplify the handling and the positioning of the sheets.

The references are supplied by the following accessories:

- excludable clicks or tipper clicks
- clicks with micrometric adjustment of the stop
- blocks with spheres to simplify the sliding of the sheet
- excludable washers to allow the squaring of the sheet
- millimetric rule laser engraved, graduated for vertical reading
- height adjustable supports

The application methods can change according to the shear features.



RIFERIMENTI PER PRESSA PIEGATRICE - REFERENCES FOR PRESS BRAKE

Questi riferimenti vengono utilizzati nella parte anteriore della pressa e facilitano la movimentazione e il posizionamento delle lamiere.

I riferimenti vengono forniti con i seguenti accessori:

- saltarelli escludibili o ribaltabili **S2**
- saltarelli con regolazione micrometrica della battuta **S3**
- blocchetti con sfere per facilitare lo scorrimento lamiera **S8**
- rondelle escludibili per permettere la squadratura lamiera **S7**
- riga millimetrata incisa laser, graduata per lettura verticale
- eventuali sostegni regolabili in altezza

This references are used in the front part of the press brake, in order to simplify the handling and the positioning of the sheet metal.

The references are supplied by the following accessories:

- excludable clicks or tipper clicks **S2**
- click with micrometric adjustment of the stop **S3**
- blocks with spheres to simplify the sliding of the sheet **S8**
- excludable washers to allow the squaring of the sheet **S7**
- millimetric rule laser engraved, graduated for vertical reading
- height adjustable supports

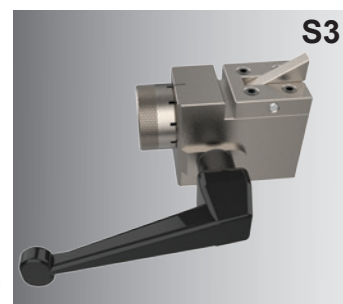
SS



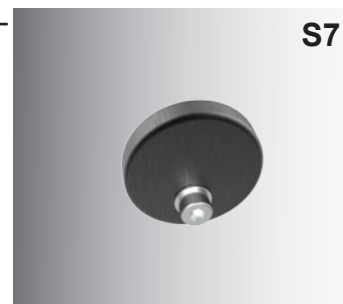
S2



S3



S7



S8



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

RR



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

SQUADRA PER PRESSA PIEGATRICE - PRESS BRAKE SQUARING



SPQ 90°

Questa attrezzatura è da posizionare direttamente sull'utensile inferiore e permette la piegatura in squadra (90°) di particolari di lamiera di piccole dimensioni.

This equipment needs to be placed directly on the lower tool and it allows the square bending (90°) of small sheet metal parts.



SPQ/G 30°÷90°

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

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

UNITA' DI PIEGATURA - FORMING DIE

UP



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

This equipment can be used on hydraulic or mechanical presses and it allows to perform the bending of small details. In this way it's not possible to use the longer length bending presses.

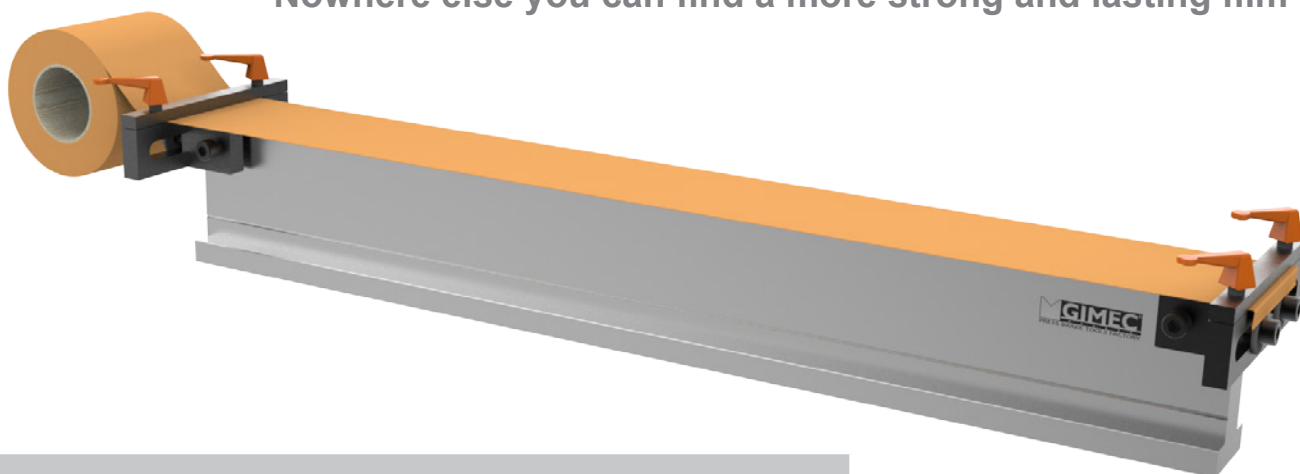
The bending unit is available in 2 different lengths : mm. 835 - mm. 415. For the selection of the tools you need to take a look at the EUROPE standard series.

PELLICOLA ANTIGRAFFIO - DIE COVER FILM

GIMEC-URET

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

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



L'utilizzo di questo prodotto permette di eseguire la piegatura di acciaio inox, alluminio o altro, evitando graffi e segni di piegatura sul pezzo piegato, coprendo semplicemente gli utensili con la pellicola antigraffio. Durante l'utilizzo la pellicola agisce come protezione tra lo stampo ed il materiale da piegare proteggendo quest'ultimo da graffi o segni di piegatura.

La pellicola GIMEC-URET viene fornita in rotoli standard con una lunghezza di mt 30 e sezione mm 100 x 0,5.

Per ottimizzare la durata della pellicola, seguire la seguente procedura:

- regolate la pressa piegatrice fino ad ottenere l'angolo di piega desiderato
- alzate la pressa approssimativamente di mm 0,4 MOLTO IMPORTANTE !
- coprite la matrice con la pellicola (utilizzando la coppia di tenditori GIMEC-TENS)
- iniziate la piegatura

La durata della pellicola dipende da molteplici fattori quali il tipo di lamiera utilizzata, lo spessore, l'angolo di piega, la larghezza e i raggi della cava. Controllate la pellicola per eventuali segni di deterioramento e sostituirla quando è usurata.

This product allows you to bend stainless steel, aluminum and more materials avoiding scratches and bending marks just covering the tools with this anti-scratch film.

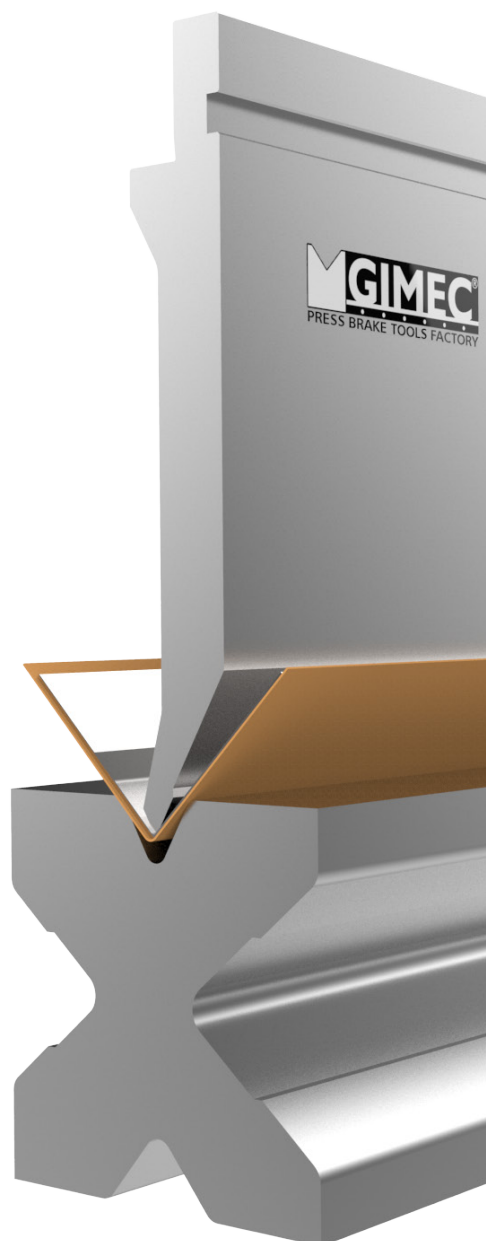
The film acts as a protection between the die radius and the material to bend, preserving it from scratches or bending marks.

The GIMEC-URET film is supplied by standard rolls of 30 meters length and cross section of 100 x 0.5 mm.

To optimize the endurance please follow the following procedures:

- adjust the bending press to obtain the desired bending angle
- raise the press approximately by mm 0.4 VERY IMPORTANT !
- cover the die with the film (using the pair of tensioners GIMEC-TENS)
- start bending

The cover film lifetime depends on many factors such as the type of sheet metal used, thickness, angle of the bend, dimension of the V slot and radius of the die. Check the film for any signs of deterioration and replace it when it is worn.



ARMADIO PORTA UTENSILI APERTO - OPEN TOOLS CABINET **ARM-OPEN**

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

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

Caratteristiche:

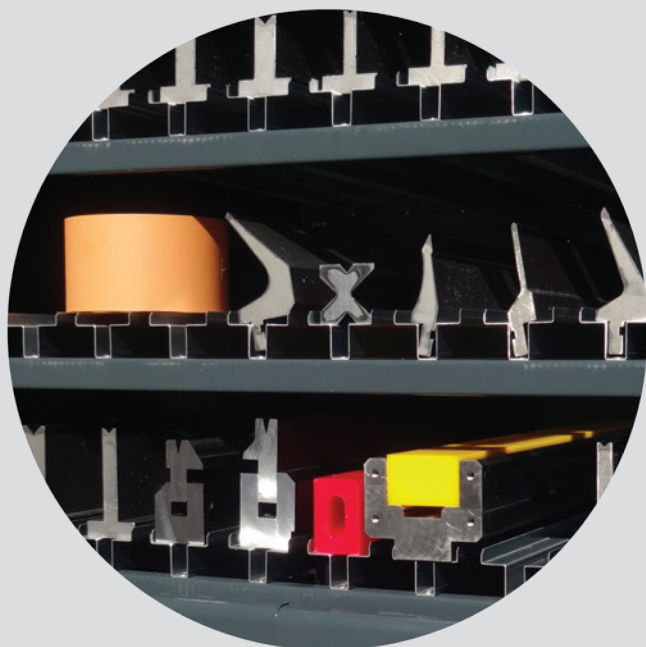
- 6 ripiani con traversini per alloggiare sia utensili superiori che inferiori.
i ripiani sono regolabili in altezza
portata singolo ripiano 190 kg (n°8 binari)
altezza massima utensile su ripiano 155 mm
- 2 cassetti per riporre gli utensili frazionati
portata singolo cassetto 75 kg
altezza max utensile 145 mm
- Capienza ripiani + cassetti : max 54 utensili
- Dimensioni : cm 86 x 86 altezza cm 158
- Verniciato monocoloro Ral 7016 grigio antracite bucciato

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

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

Features:

- 6 shelves with crossbars to store both upper and lower tools.
the shelves are adjustable in height
single load capacity of 190 kg (n°8 tracks)
maximum tool height on shelf 155 mm
- 2 drawers to store tools in section
single drawer capacity 75 kg
max tool height 145 mm
- Capacity shelves + drawers: max 54 tools
- Size: 86 x 86 cm height 158 cm
- One-color painted anthracite gray peel Ral 7016



CARRELLO PORTA UTENSILI - TOOLS TROLLEY

ARM-WHEELS

L'utilizzo di questo carrello ha i seguenti vantaggi:

- facilità nel riporre gli utensili
- rapida visualizzazione delle tipologia di utensili a disposizione dell'operatore
- praticità negli spostamenti essendo dotato di ruote

E' disponibile in 3 versioni :

ARM / WHEELS 1

idoneo per stoccaggio utensili tipo **EUROPA**
con lunghezza mm 835 - 415 - frazionati
Capacità : 30 ripiani

ARM / WHEELS 2

idoneo per stoccaggio utensili tipo **TRUMPF WILA®**
con lunghezza mm 500 - 515 - frazionati
Capacità : 21 ripiani

ARM / WHEELS 3

idoneo per stoccaggio utensili tipo **BEYELER BYSTRONIC®**
con lunghezza mm 500 - 508 - 1000 - frazionati
Capacità : 21 ripiani

Dimensioni : cm 116 x 106 altezza cm 152
Portata max : kg.1000

The open tools cabinet has several advantages:

- easy storage of tools
- quick display of the different types of tools available to the operator
- easy to move being equipped with wheels

It is available in 3 versions:

ARM / WHEELS 1

It is suitable for the storage of **EUROPA** tools
with length mm 835 - 415 - 805 sect.
Capacity: 30 shelves

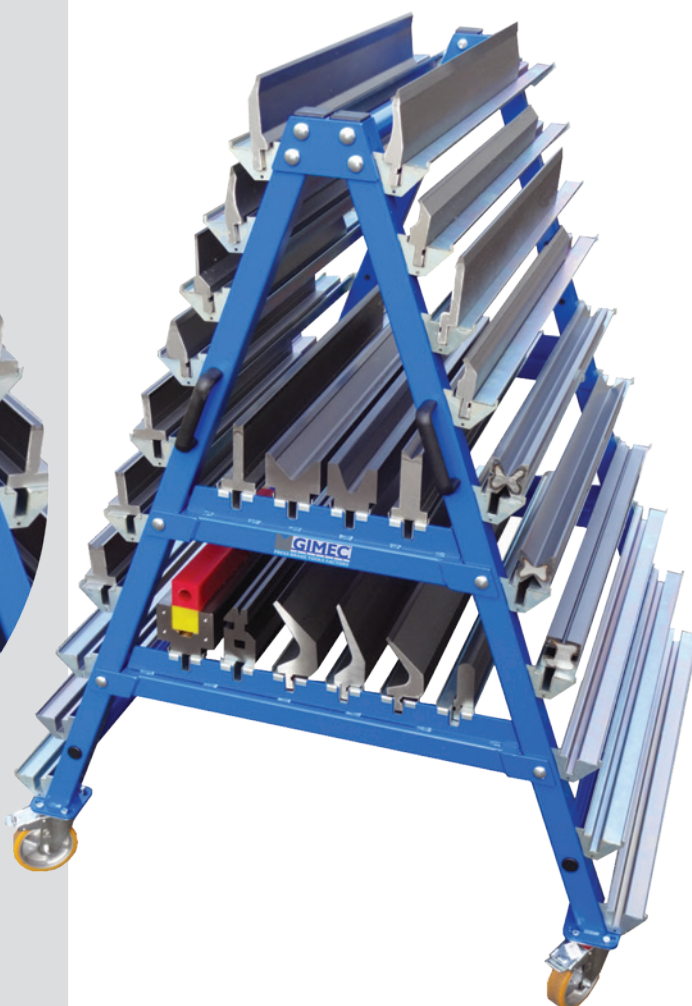
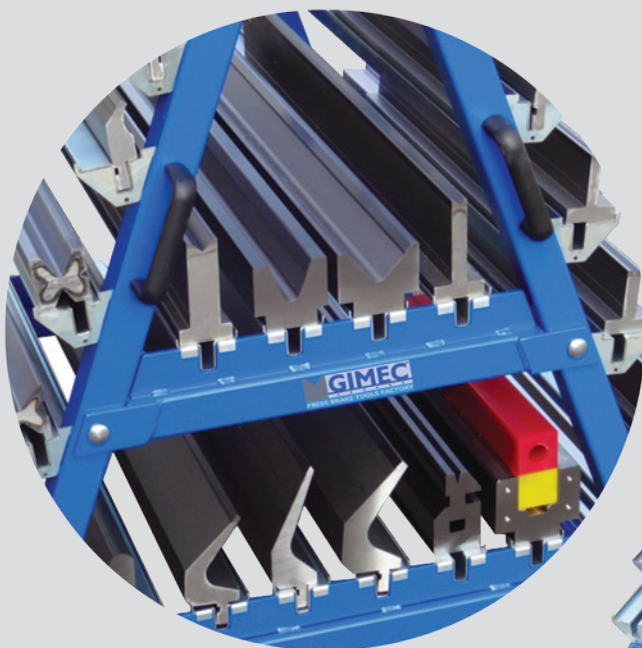
ARM / WHEELS 2

It is suitable for the storage of **TRUMPF WILA®** tools
with length 500 - 515 mm - sect.
Capacity: 21 shelves

ARM / WHEELS 3

It is suitable for storage of **BEYELER BYSTRONIC®** tools
with 500 - 508 - 1000 mm length - sect
Capacity: 21 shelves

Dimensions : 116 x 106 cm height 152 cm
Max capacity : 1000 kg



ARMADIO PORTA UTENSILI - TOOLS CABINET

ARM 4-5

L'utilizzo di questo armadio ha i seguenti vantaggi :

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

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

ARMADI idonei per UTENSILI tipo EUROPA

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

ARMADI IDONEI PER UTENSILI tipo TRUMPF WILA ® and BEYELER BYSTRONIC ®

- **ARM4/1060/20** con 4 cassetti - cm 85Lx136Px124H
 - **ARM5/1060/20** con 5 cassetti - cm 104Lx136Px124H
- L'allestimento interno dei supporti e delle vaschette viene proposto in base agli utensili da alloggiare

By using this cabinet you will get the following benefits:

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

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

CABINET suitable for EUROPEAN TOOLS

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

CABINET suitable for TOOLS TRUMPF WILA ® and BEYELER BYSTRONIC ®

- **ARM4 / 1060/20** with 4 drawers - cm 85Lx136Px124H
 - **ARM5 / 1060/20** with 5 drawers - cm 104Lx136Px124H
- The internal set-up of the supports and trays is proposed to you according to the tools to be housed.





ACCIAI

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

STEEL

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

C45	C45	W 1.1191	R 600 / 750 N/mm ²
42CR	42CrMo4	W 1.7225	R 850/1000 N/mm ²
2311	40CrMnMo7	W 1.2311	R 950/1100 N/mm ²
2312	40CrMnMoS8,6	W 1.2312	R 950/1050 N/mm ²
PV	X155CrVMo12-1	W 1.2379	

TRATTAMENTI TERMICI

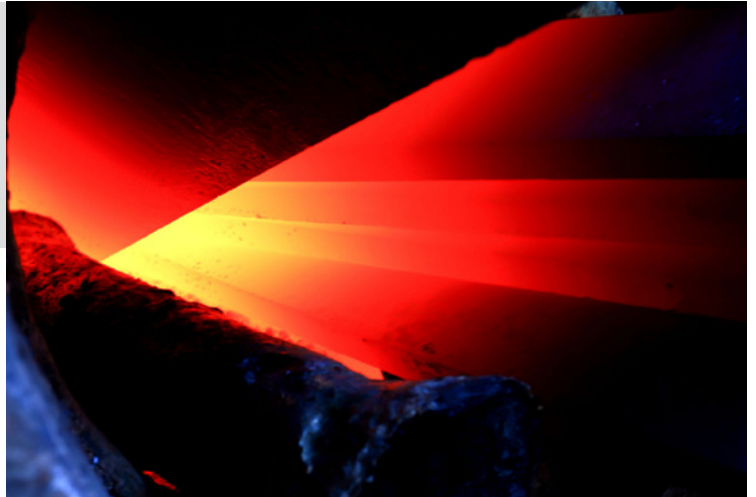
Tutti i trattamenti termici sono eseguiti con impianti tecnologicamente avanzati, gestiti da personale altamente qualificato :

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

HEAT TREATMENTS

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

- laser hardening
- high frequency service
- fully hardening

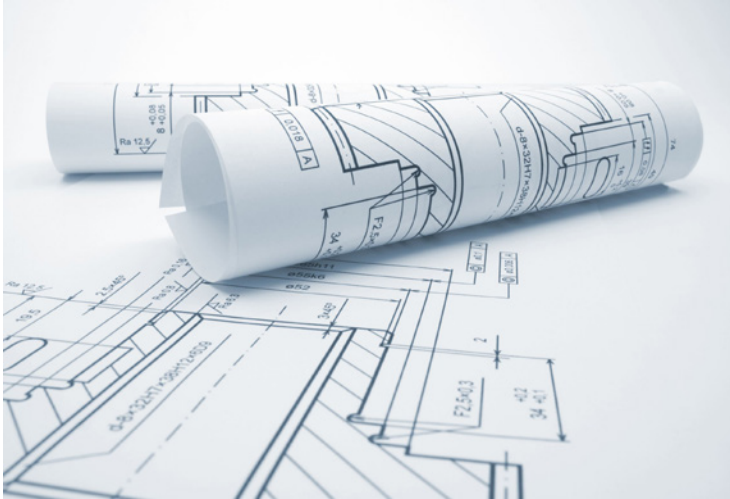


LAVORAZIONI MECCANICHE

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

MECHANICAL WORKING

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



PROGETTAZIONE & OFFERTE

I nostri uffici tecnico-commerciali sono in grado di fornire, in tempi brevi, una soluzione tecnica ai vostri problemi di piegatura.

Ogni offerta viene accompagnata da disegni tecnici esemplificativi affinché possiate comprendere al meglio quanto proposto.

TECHNICAL DESIGN & OFFERS

Our technical and commercial offices are able to provide technical solutions to solve your bending problems very quickly.

In each offer will be included example technical drawings in order to let you better understand what we propose you.

REVISIONE STAMPI

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

PRESS BRAKE TOOLS RECONDITIONING

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



RIAFFILATURA LAME

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

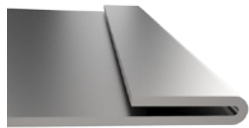
SHEAR BLADES REGRINDING

We can quickly regrind your shear blades.

The regrinding is performed by tangential grinding machine to preserve the original blades features.

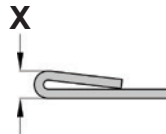
After this process all the blades are demagnetized.

TAVOLA DI PIEGATURA UTENSILI PIEGASCHIACCIA - HEMMING TOOL BENDING CHART



SPESSORE THICKNESS

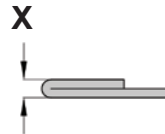
mm	inches
0,6	.024
0,8	.031
1,0	.039
1,2	.047
1,5	.059
2,0	.079
2,5	.098
3,0	.118



Rm=450 N/mm ² Rm=65000 PSI	Rm=700 N/mm ² Rm=100000 PSI
--	---

POTENZA POWER

X mm	inches	kN/mt	US t/ft	kN/mt	US t/ft
3,0	.118	90	3	150	5
3,0	.118	120	4	200	7
3,5	.137	150	5	250	8
3,5	.137	170	6	300	9
4,6	.181	220	8	380	13
5,5	.216	300	10	500	17
6,5	.255	550	18	900	31
8,0	.314	700	24	1000	34



Rm=450 N/mm ² Rm=65000 PSI	Rm=700 N/mm ² Rm=100000 PSI
--	---

POTENZA POWER

X mm	inches	kN/mt	US t/ft	kN/mt	US t/ft
1,2	.047	230	8	350	12
1,6	.062	320	11	500	17
2,0	.078	400	14	600	21
2,4	.094	500	17	800	27
3,0	.118	630	22	950	32
4,0	.157	800	27	1300	44
5,0	.196	900	31	1800	62
6,0	.236	1000	34	2100	72

PIEGATURA IN ARIA - AIR BENDING

Nella piegatura in aria l'angolo di piega è determinato dalla posizione che la punta dell'utensile superiore raggiunge rispetto ai due spigoli della matrice, posizione variabile a seconda dello spessore, della resistenza e dell'elasticità della lamiera. I vantaggi nell'utilizzo di questa tecnica di piegatura consistono nell'impiego di una minima forza di piegatura e nella possibilità di piegare qualsiasi spessore, compatibilmente al tipo di pressa ed utensili disponibili.

Inoltre gli stessi utensili possono essere utilizzati per differenti tipi di materiale e si possono ottenere angoli inferiori ai 90° e raggi interni di piegatura variabili in proporzione alla larghezza della matrice. Gli svantaggi consistono nel dover utilizzare lamiere con spessore e resistenza costanti per ottenere risultati soddisfacenti.

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

CONIATURA - COINING

La coniatura è un procedimento di piegatura che permette di ottenere pieghe perfettamente a 90° anche in presenza di consistenti differenze di spessore e di resistenza della lamiera. Per contro richiede una forza superiore rispetto alle altre tecniche di piegatura, quantificabile da 5 a 7 volte quella necessaria per la piegatura in aria. Infatti la punta dell'utensile superiore deve coniare il normale raggio di piegatura facendolo combinare con la forma dell'utensile stesso.

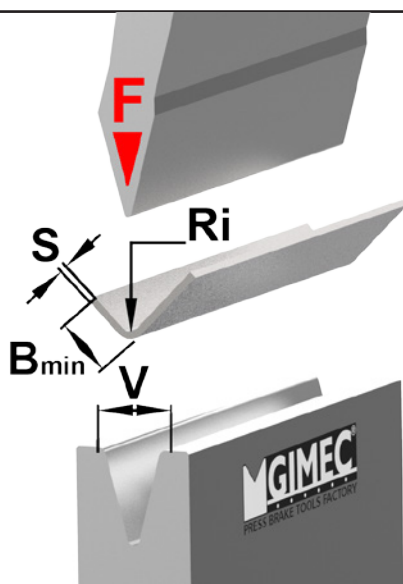
Si possono pertanto ottenere pieghe perfette con raggi di curvatura molto piccoli. Gli utensili devono essere calibrati in base allo spessore ed al tipo di lamiera, che non deve comunque superare il limite massimo di mm.2

Forming is a bending method which allows to obtain exact 90 degrees angles even if when thickness and resistance are very different. The method demands max force in comparison to the other bending methods, 5-7 times more than in the air bending. As a matter of fact, the upper tool end has to form the normal bending radius by matching it with the shape of the same tool. This method grants optimal results with very little inner radius. The tools shall be calibrated depending on material thickness and type. Nevertheless the sheet thickness shall not exceed max. 2 mm.

PIEGATURA A FONDO MATRICE - BENDING ON LOWER TOOL BOTTOM

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

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



PIEGATURA IN ARIA AIR BENDING

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

AVVERTENZE WARNINGS

NON SUPERARE IL CARICO MASSIMO AMMESSO DAGLI UTENSILI, IN QUANTO POSSONO DANNEGGIARSI O CAUSARE DANNI FISICI ALL'OPERATORE.

Il carico massimo ammissibile varia in base al tipo di utensili utilizzati.

Calcolare sempre una pressione inferiore rispetto al carico indicato.

EXCEEDING THE MAXIMUM ALLOWABLE TONNAGE FOR THE TOOLING CAN BE VERY DANGEROUS AND MAY RESULT IN TOOLING DAMAGE OR MAY CAUSE BODILY INJURY BY SPLINTERING.

The maximum allowable pressure may vary, depending on the punch and die used.

Always calculate the maximum pressure with the lowest rating of the punch or die.

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

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

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

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