



Tecnostamp



PRESS BRAKE TOOLING
www.tecnostamp.eu

ED26



EXPERIENCE & INNOVATION



TECNOSTAMP, fondata nel 1978 a Piacenza, è diventata nel corso degli anni, una delle più grandi ed affermate aziende italiane nella produzione, progettazione e vendita di utensili di piegatura; in continua espansione grazie ad una capillare rete di rivenditori dislocati in ogni parte del mondo. In questa direzione molti investimenti sono stati fatti: l'acquisto di nuove macchinari e l'esigenza di dotarsi di tecnologie avanzate con lo scopo di incrementare il livello qualitativo e la gamma degli utensili a catalogo. La produzione comprende una vasta gamma di utensili standard – punzoni matrici ed accessori – adatti ai vari tipi di presse piegatrici; tutti i prodotti TECNOSTAMP sono realizzati con acciai di alta qualità temprati ad induzione nelle parti usurabili per una maggiore durata e sottoposti ad un accurato controllo qualità e assistenza post vendita. Non solo prodotti standard ma soluzioni mirate per applicazioni specifiche nei vari settori della lavorazione della lamiera. La chiave del grande successo di TECNOSTAMP è proprio il servizio dedicato ai clienti: il cliente prima di tutto! L'azienda crede fortemente nella forza della sua produzione e nella competenza dei suoi collaboratori che quotidianamente mettono a disposizione le proprie capacità professionali e la propria esperienza per una continua crescita trovando soluzioni mirate e personalizzate in grado di soddisfare le esigenze dei clienti in modo veloce ed efficiente. Ricerca, innovazione, qualità e passione sono i punti forza che hanno costruito negli anni il successo del marchio TECNOSTAMP e accompagnano la sua espansione nel mercato globale.



TECNOSTAMP, founded in 1978 in Piacenza, has become over the years, one of the biggest and most important Italian companies in the production, design and sale of bending tools; It's a world-wide-expanding company with a large network of dealers across the globe. For this purpose many investments have been made: the purchase of new machines and the need to equip with advanced technologies in order to increase quality and expanding range of tools in the catalogue. The production includes a wide range of standard tools- punches, dies and accessories – suitable for all types of Press Brakes; all TECNOSTAMP products are made of high quality hardened steels for induction on wear parts for longer life and subjected to accurate quality control and after sales service. Not only standard products but targeted solutions for specific applications in the various sheet metal processing sectors. The key to great success of TECNOSTAMP is the service dedicated to customers: the customer first of all! The company strongly believes in the strength of its production and the expertise of its employees who daily make available their professional skills and experience for continuous growth by finding targeted and customized solutions that can meet customer needs quickly and efficiently. Research, innovation, quality and passion are the strengths that have built over the years the success of TECNOSTAMP brand and drive its expansion into the global market.



OUR PRODUCT LINES

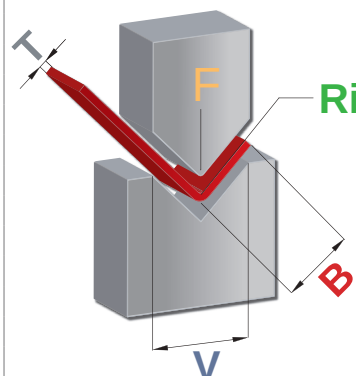


TABELLA DI PIEGATURA / BENDING CHART

FORZA NECESSARIA PER PIEGA A 90° IN ARIA DI LAMIERA CON RESISTENZA
FORCE REQUIRED FOR 90° AIR BENDING, SHEET RESISTANCE

R=45 Kg/mm²

T mm	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
	4	5.5	7	8.5	11	14	17.5	22	28	35	45	55	71	89	113	140	175	B
	1	1.3	1.6	2	2.6	3.3	4	5	6.5	8	10	13	16	20	26	33	41	Ri
0.5	3																	
0.6	4	4																
0.8	7	5	4															
1	11	8	7	6														
1.2	16	12	10	8	6													
1.5		17	15	13	9	8												
2			27	22	17	13	11											
2.5				35	26	21	17	13										
3					38	30	24	19	15									
4						54	42	34	27	21								
5							67	52	42	33	26							
6								75	60	48	38	30						
8									107	85	68	53	43					
10										134	105	85	67	53				
12											153	120	96	78	60			
15												188	150	120	95	75		F
20													270	215	170	135	108	t/m



SPESSORE LAMIERA IN MM
THICKNESS OF THE SHEET IN MM

FORZA IN TON / METRO
FORCE IN TON / METER

RAGGIO INTERNO
INSIDE RADIUS

BORDO MINIMO POSSIBILE
MINIMUM FLANGE LENGHT

LARGHEZZA DEL V
V-OPENING

T

F

Ri

B

V

ALLUMINIO
ALUMINIUM

R=20-25 KG/MMQ

ACCIAIO DOLCE
MILD STEEL

R=40-45 KG/MMQ

INOX
STAINLESS STEEL

R=65-70 KG/MMQ

CALCOLO DELLA FORZA PER PIEGA IN ARIA
CALCULATION OF FORCE FOR AIR BENDING

$$F = \frac{T^2 \times 2 \times R}{1.4 \times V} = \dots\dots\dots \text{Tons/mt}$$

RAPPORTO TRA SPESSORE DI LAMIERA E AMPIEZZA DEL V
SHEET THICKNESS / V- WIDTH

SPESSORE LAMIERA (mm)
SHEET THICKNESS (mm)

0.5 - 2.5

3 - 8

9 - 10

12 OR MORE

AMPIEZZA DEL V (mm)
V - WIDTH (mm)

6 T

8 T

10 T

12 T

LEGENDA DEI MATERIALI

MATERIAL SPECIFICATIONS

	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191). STEEL C45 (UNI EN 10083 W.1. : 1.1191).
	ACCIAIO 42CrMo4 (UNI EN 10083 W.1. : 1.7225). STEEL 42CrMo4 (UNI EN 10083 W.1. : 1.7225).
	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191) TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL C45 (UNI EN 10083 W.1. : 1.1191) INDUCTION TEMPERED (52-55 HRC) ON WEAR PARTS.
	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191) BONIFICATO R=80-85 KG/MMQ TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL C45 (UNI EN 10083 W.1. : 1.1191) HARDENED R=80-85 KG/MMQ INDUCTION TEMPERED (52-55 HRC) ON WEAR PARTS.
	ACCIAIO 42CrMo4 (UNI EN 10083 W.1. : 1.7225) BONIFICATO R=95-105 KG/MMQ TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL 42CrMo4 (UNI EN 10083 W.1. : 1.7225) HARDENED R=95-105 KG/MMQ INDUCTION TEMPERED (52-55 HRC) ON WEAR PART.

TRATTAMENTI TERMICI
HARDENED TREATMENT

GLI UTENSILI STANDARD E SPECIALI SONO TEMPRATI AD INDUZIONE SULLE PARTI USURABILI A 52-55 HRC.
THE STANDARD AND SPECIAL TOOLS ARE INDUCTION HARDENED TO 52-55 HRC ON WEAR PARTS.

TRATTAMENTI ANTIUSURA
ANTIWEAR TREATMENT

A RICHIESTA DEL CLIENTE, SUGLI UTENSILI COSTRUITI IN 42CRM04, PUÒ ESSERE FATTO UN TRATTAMENTO ANTIUSURA DI NITRURAZIONE.
ON REQUEST ON THE TOOLING IN 42CRM04 TECNOSTAMP CAN MAKE AN ANTIWEAR-NITRIDING TREATMENT.

TRATTAMENTI ANTIRUGGINE
RUSTING TREATMENT

A RICHIESTA DEL CLIENTE SUGLI UTENSILI PUÒ ESSERE FATTO IL TRATTAMENTO ANTI RUGGINE DI ZINCATURA.
AN ANTI RUST-GALVANIZED TREATMENT CAN BE MADE ON TOOLS ON REQUEST.

AMADA - PROMECAM STYLE

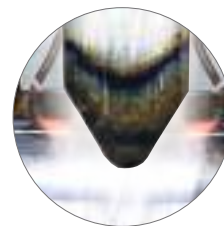
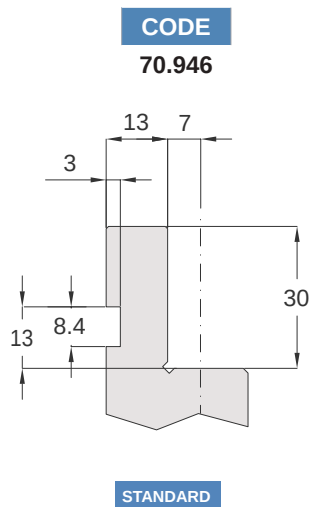
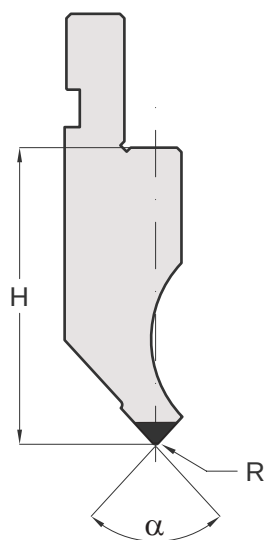
PUNZONI PUNCHES



RED LINE

AMADA - PROMECAM STYLE

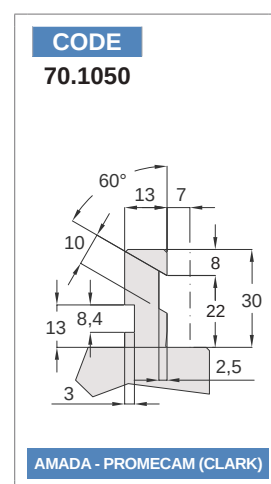
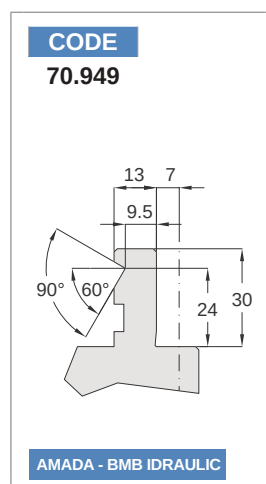
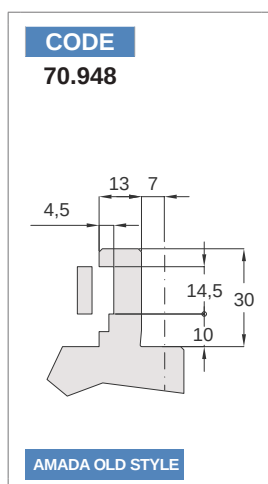
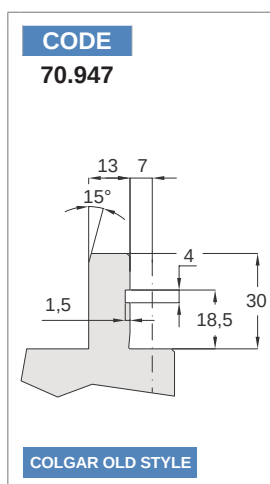
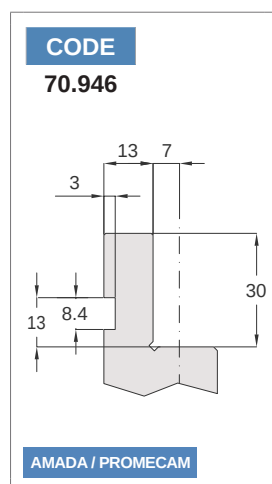
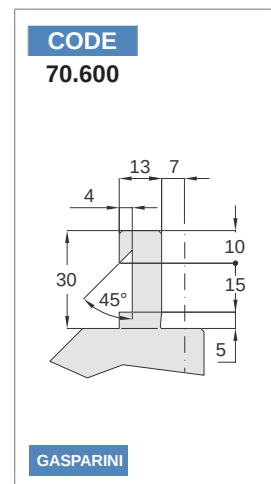
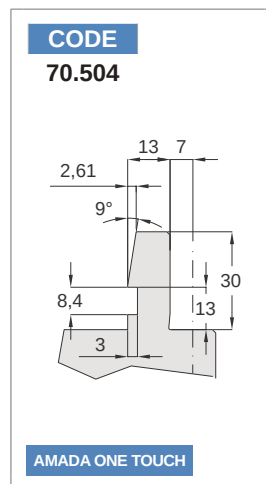
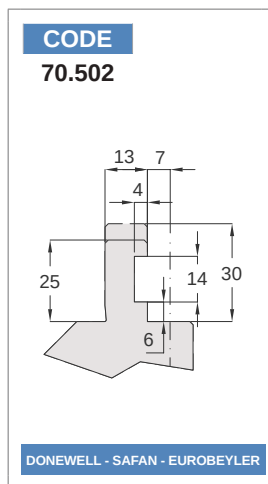
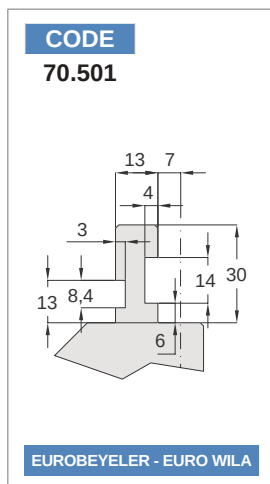
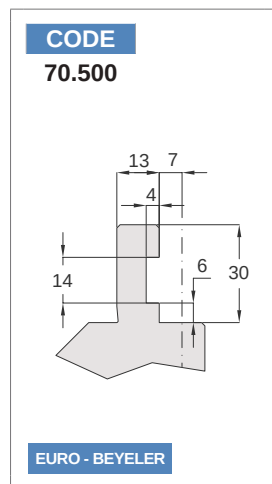




TEMPRA AD INDUZIONE 52-55 HRC
INDUCTION HARDENED 52-55 HRC

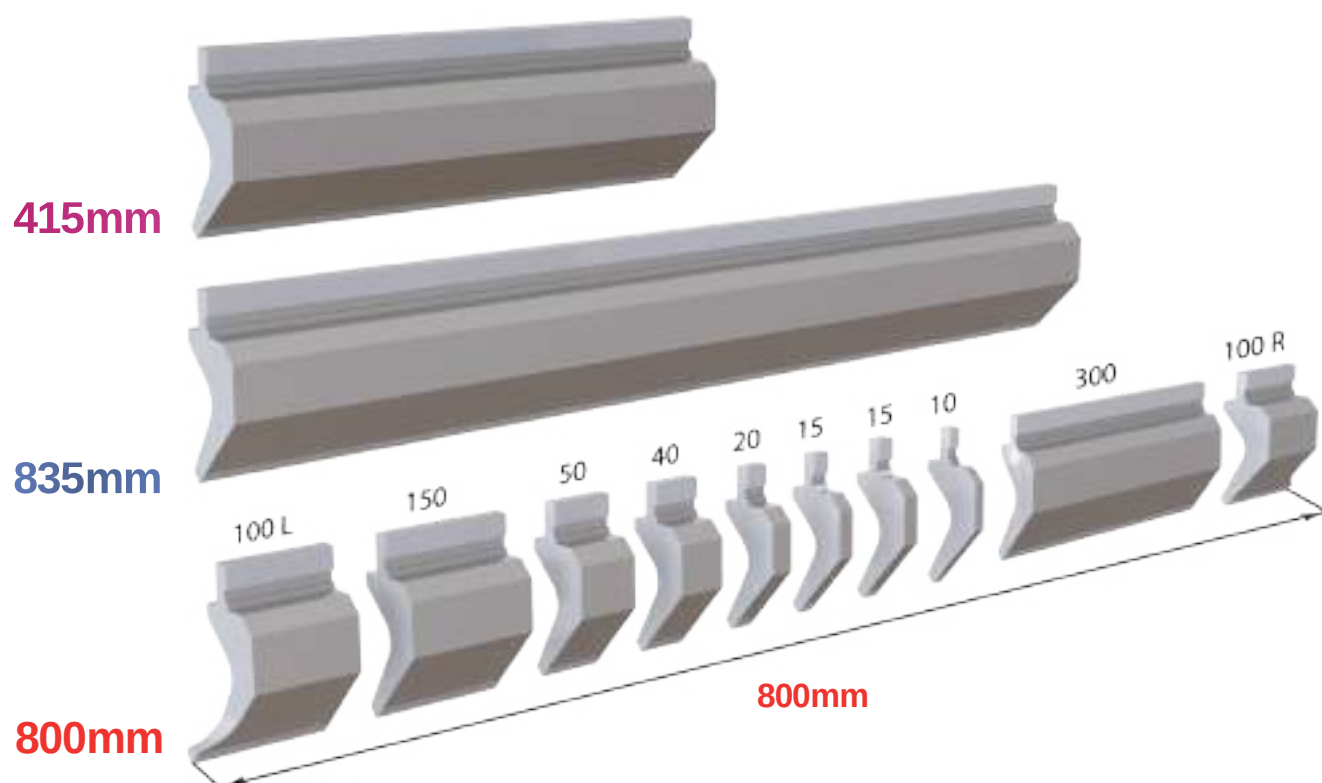
LEGENDA	α = ANGOLO	R = RAGGIO	H = ALTEZZA
LEGEND	α = ANGLE	R = RADIUS	H = HEIGHT

SCANALATURA DI SICUREZZA SU RICHIESTA
SAFETY GROOVE ON REQUEST



PUNZONI / PUNCHES **AMADA - PROMECAM STYLE**

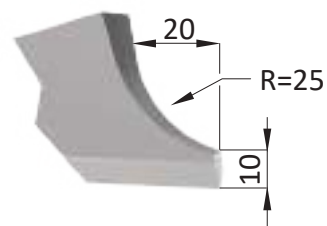
I PUNZONI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 / 835 E FRAZIONATI (800 mm)
 THE PUNCHES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 / 835 AND SECTIONED (800 mm)



IL CARICO MASSIMO DELLE SCARPETTE CORRISPONDE AL 50% DEL CARICO MASSIMO INDICATO SUL PUNZONE.
 THE MAX LOAD OF THE HORN EXTENSIONS IS 50% OF THE MAX LOAD OF THE PUNCH.

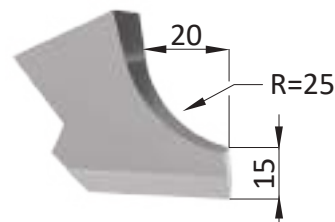
CODE

10.142	10.516	11.201	11.280	11.840	11.857	11.867
10.143	10.517	11.230	11.650	11.848	11.861	11.868
10.170	10.520	11.231	11.660	11.849	11.863	11.869
10.500	10.626	11.232	11.670	11.850	11.864	
10.506	11.151	11.270	11.800	11.853	11.865	
10.510	11.200	11.275	11.835	11.855	11.866	

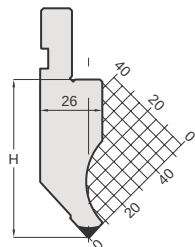


CODE

10.136	11.104	11.530	11.720	11.820	11.914
10.511	11.158	11.540	11.730	11.831	11.916
10.514	11.258	11.545	11.750	11.880	
10.515	11.514	11.600	11.780	11.904	
11.103	11.528	11.710	11.810	11.911	

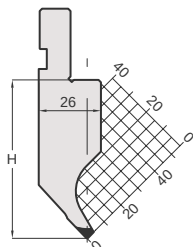


CODE	α	R	H	T/Mt	Mt
11.201	85°	3.00	65.45	100	■
11.200	85°	0.80	66.50	100	■
11.853	85°	0.25	66.50	100	■
11.275	75°	0.80	67.60	100	■



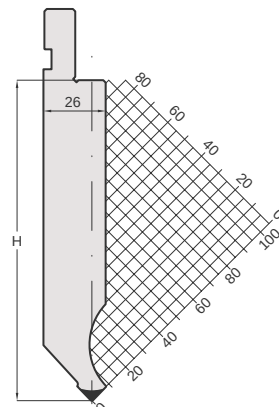
415 mm
835 mm
800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
10.170	85°	0.60	66.74	35	■
11.857	85°	0.25	67.00	35	■



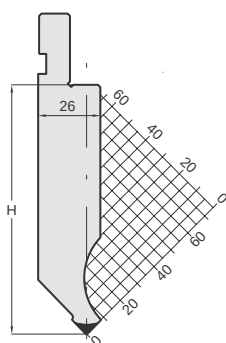
415 mm
835 mm
800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.232	85°	0.80	135.00	100	■



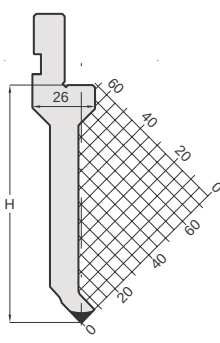
415 mm
835 mm
800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.231	85°	3.00	105.00	100	■
11.230	85°	0.80	105.00	100	■



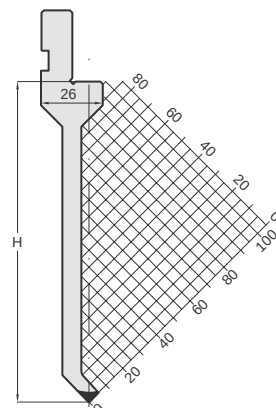
415 mm
835 mm
800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.861	85°	0.60	100.00	50	■
10.626	85°	0.25	100.00	50	■



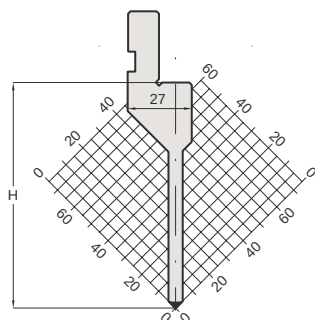
415 mm
835 mm
800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.855	85°	0.60	135.00	40	■



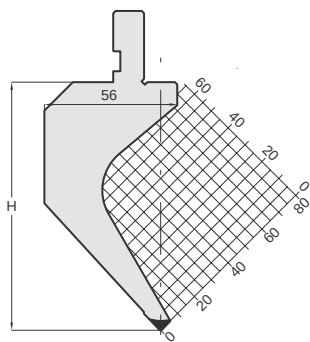
415 mm
835 mm
800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.270	85°	0.60	95.00	50	■



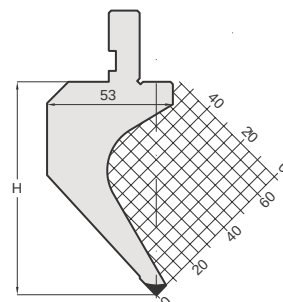
415 mm
835 mm
800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.650	85°	0.80	104.50	50	■
11.868	85°	0.25	104.70	50	■

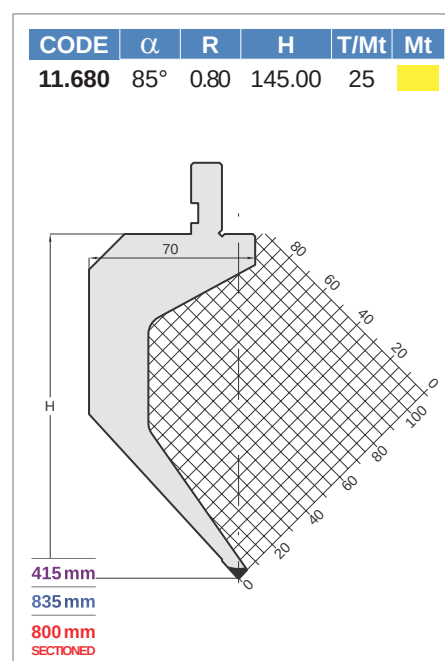
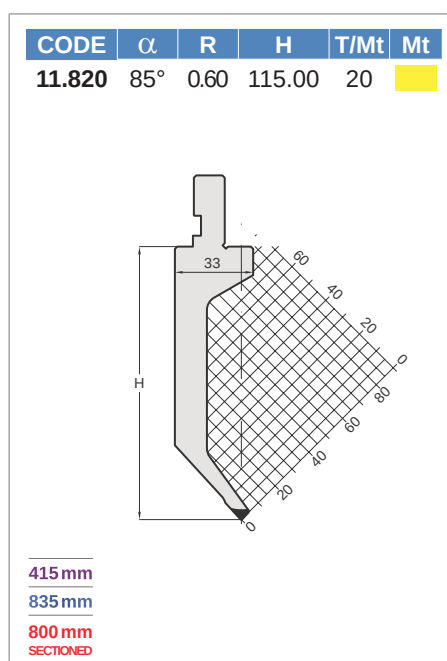
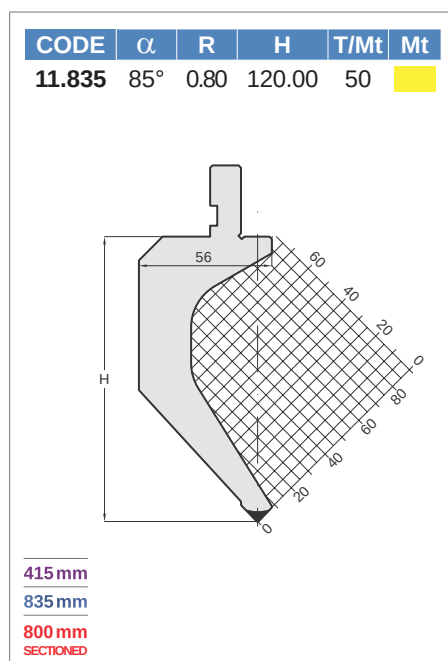
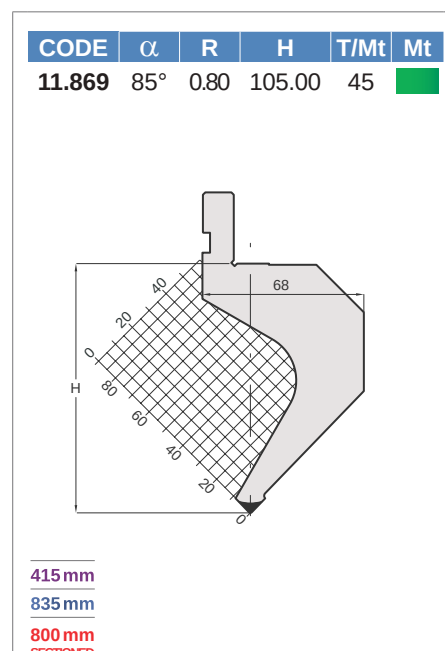
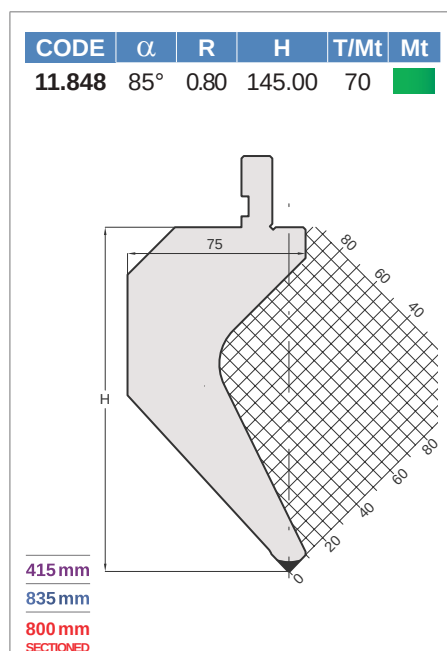
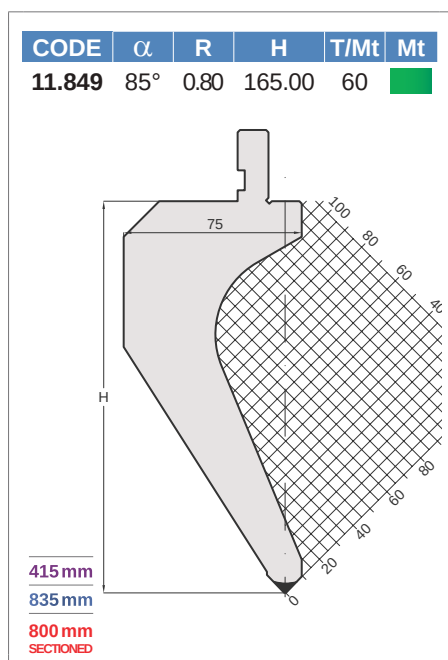
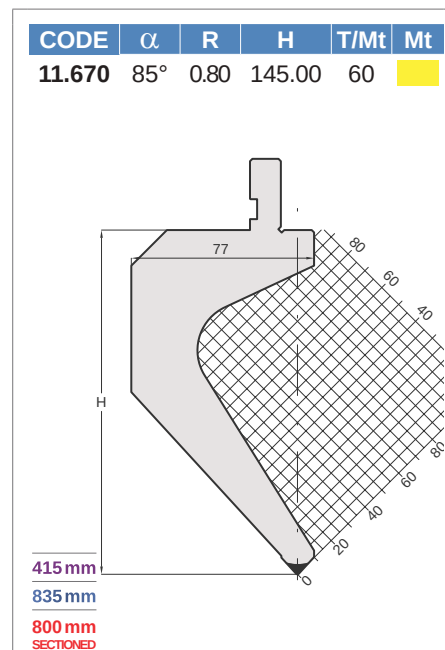
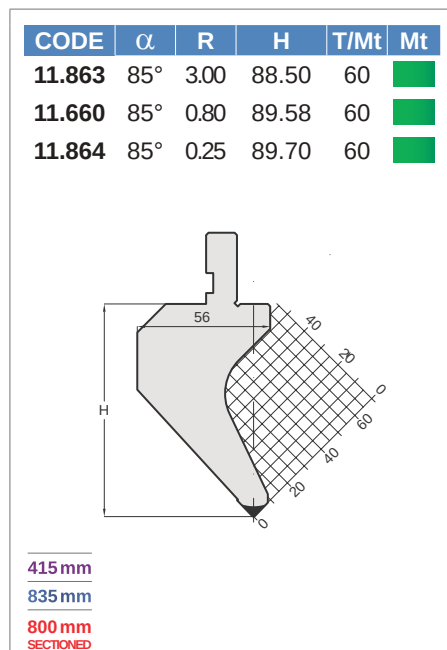
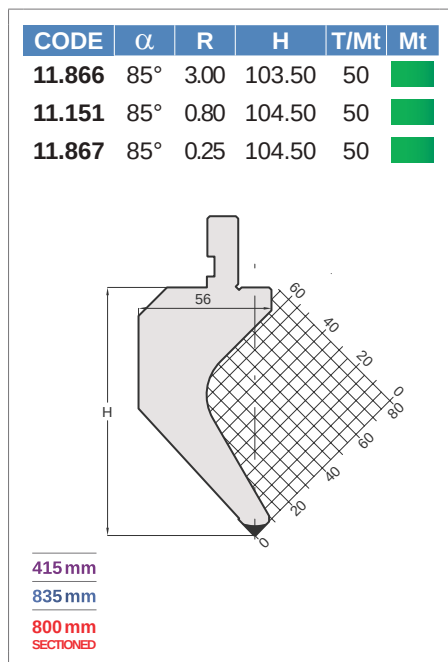


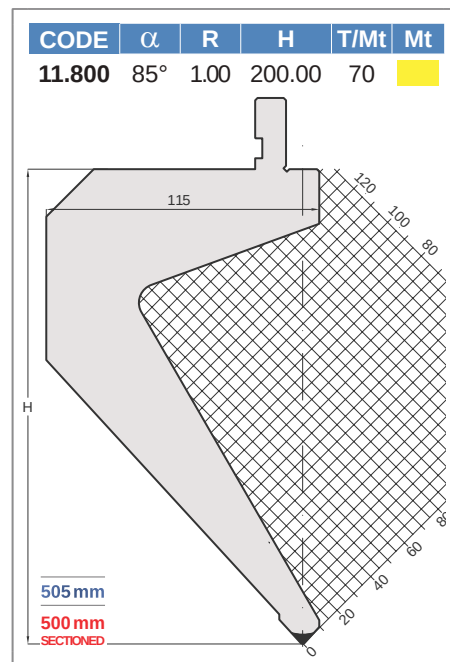
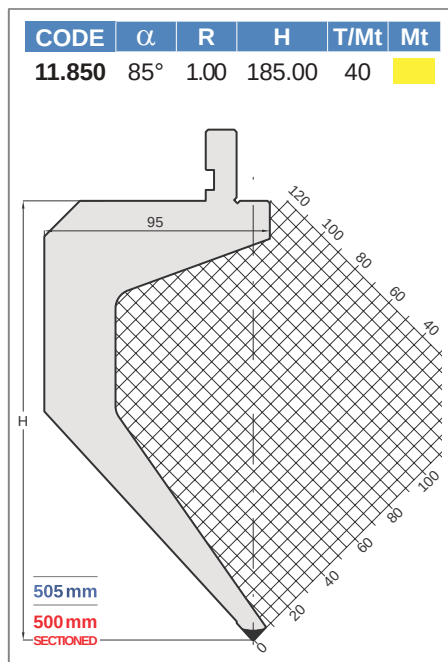
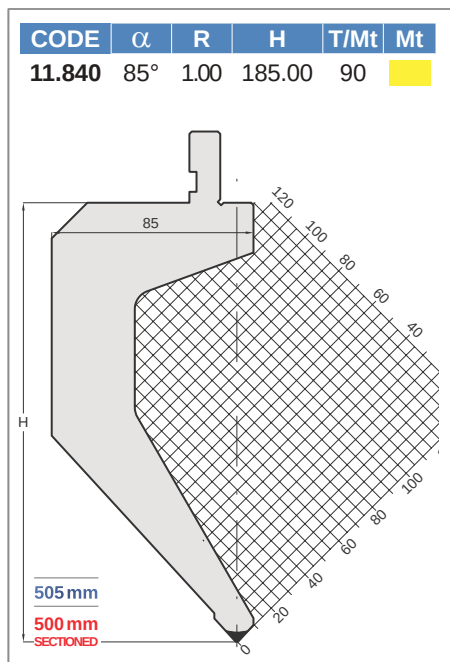
415 mm
835 mm
800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.865	85°	0.80	89.70	50	■
10.672	85°	0.25	90.00	50	■

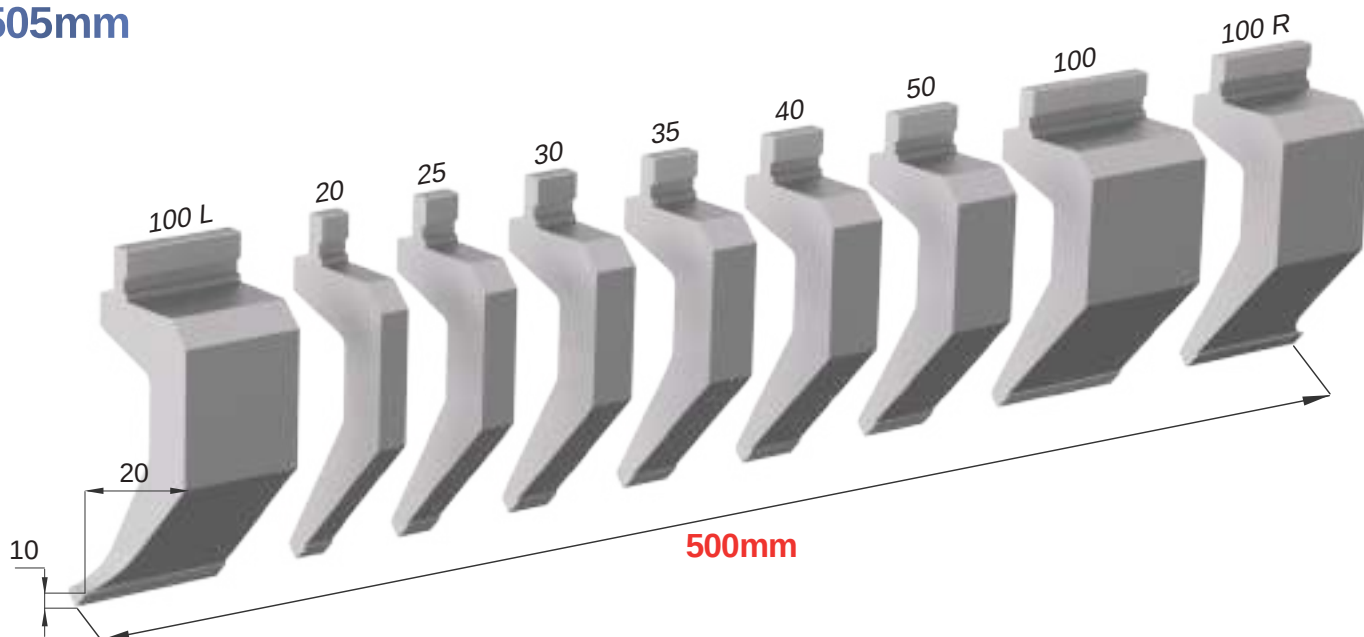


415 mm
835 mm
800 mm
SECTIONED



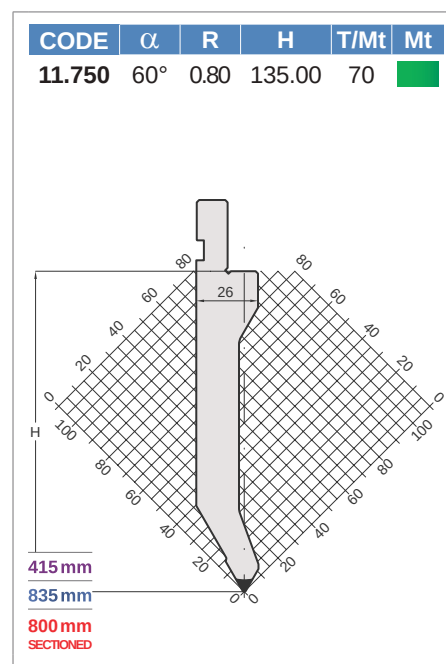
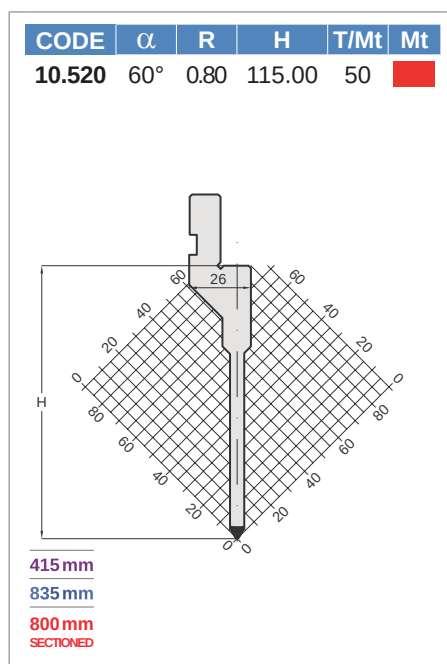
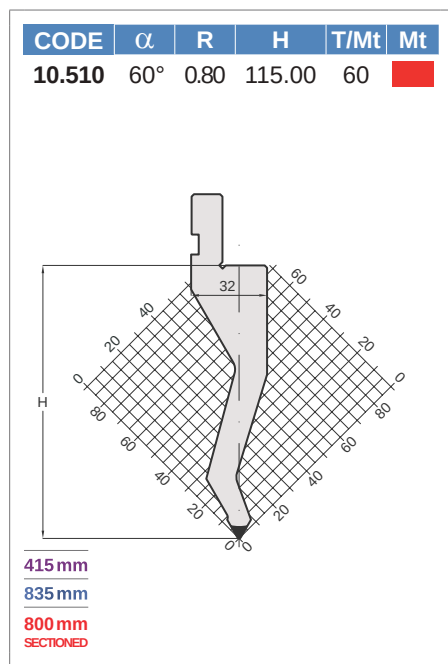
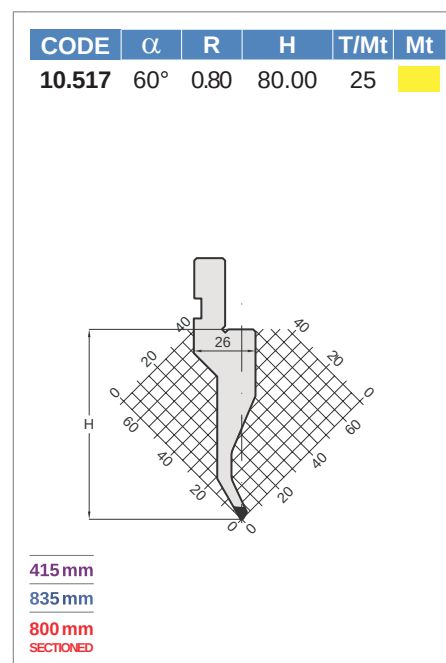
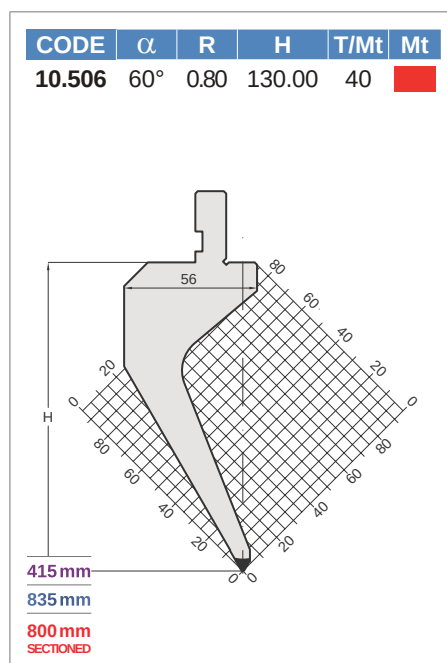
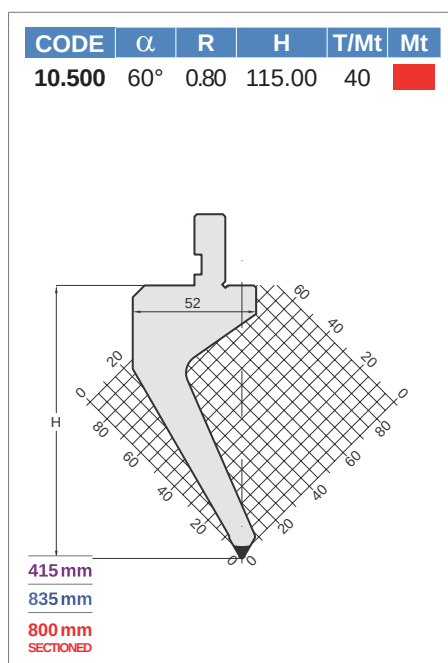
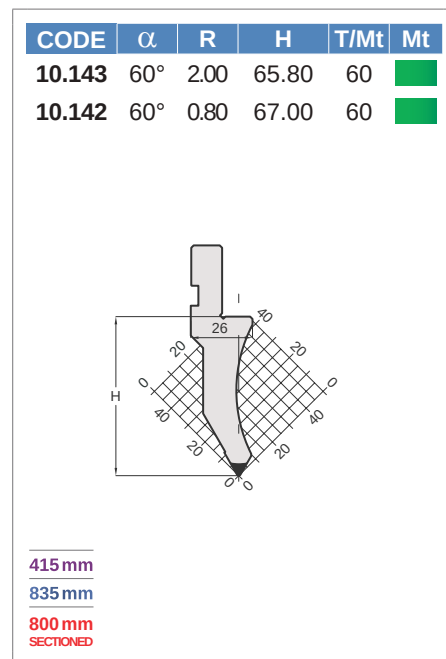
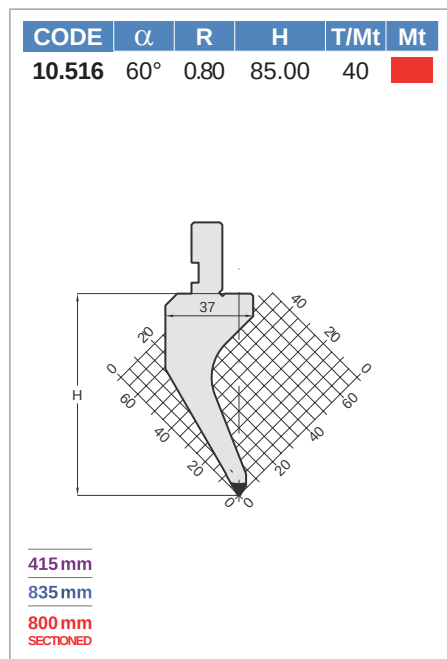
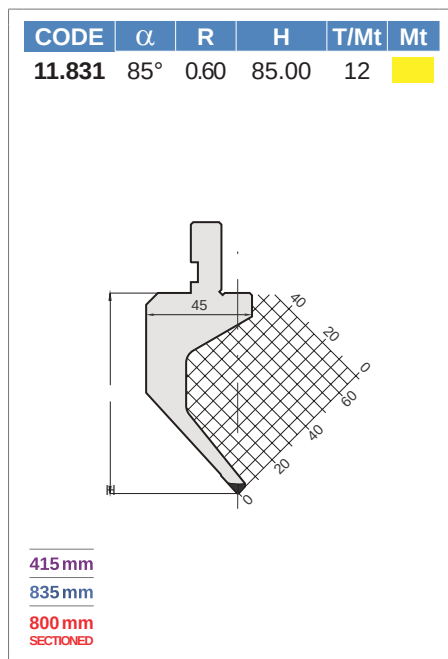


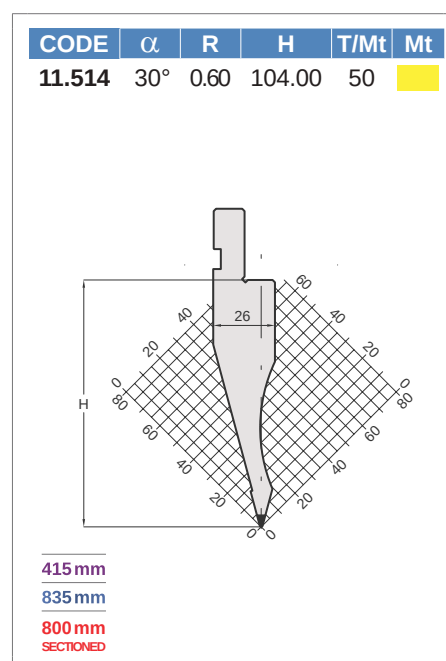
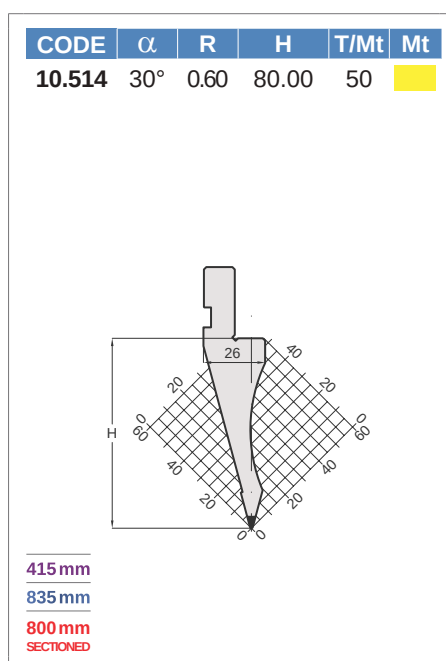
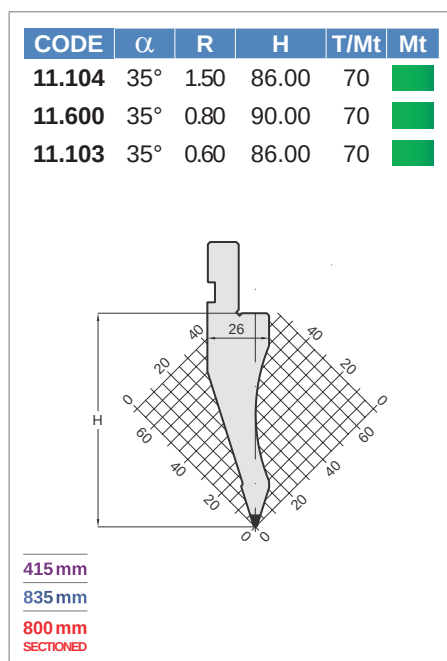
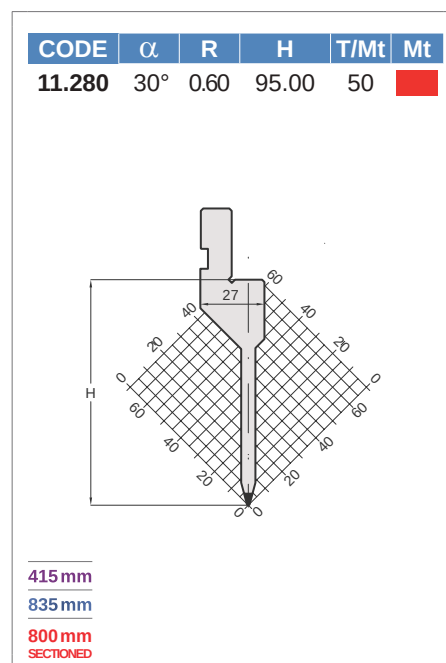
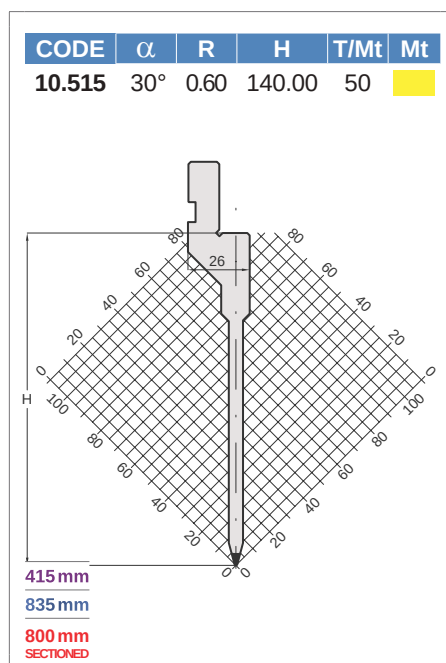
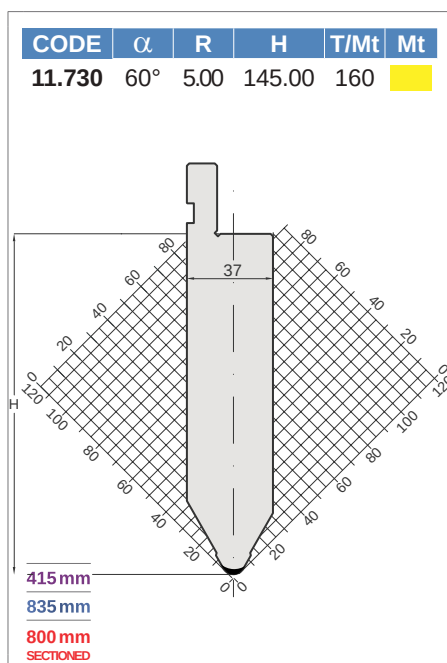
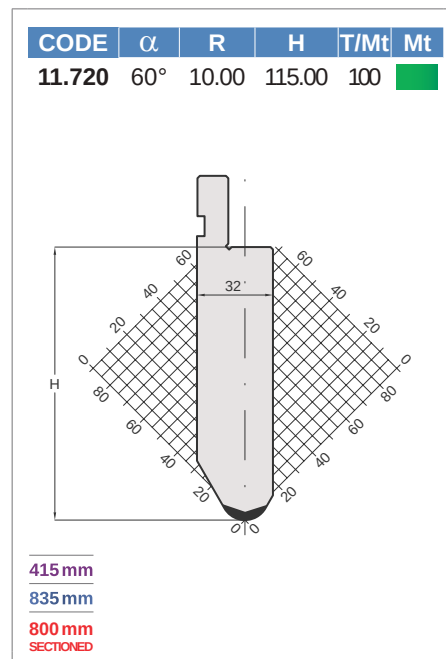
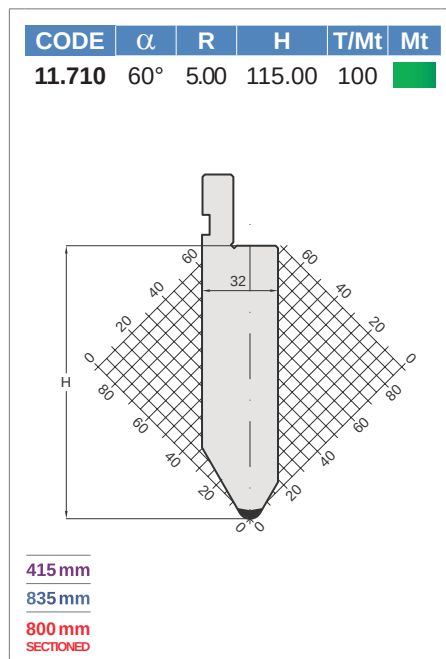
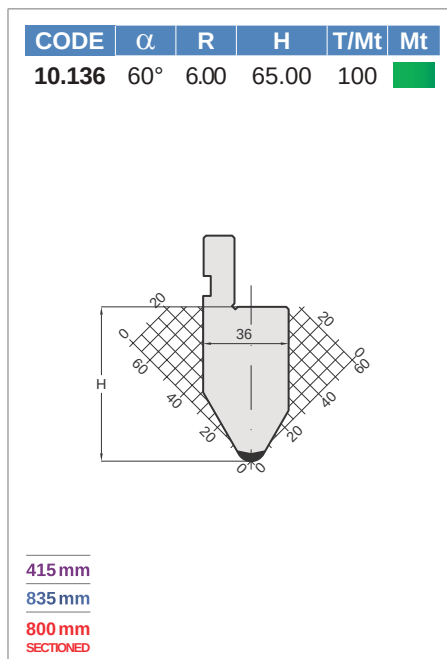
505mm

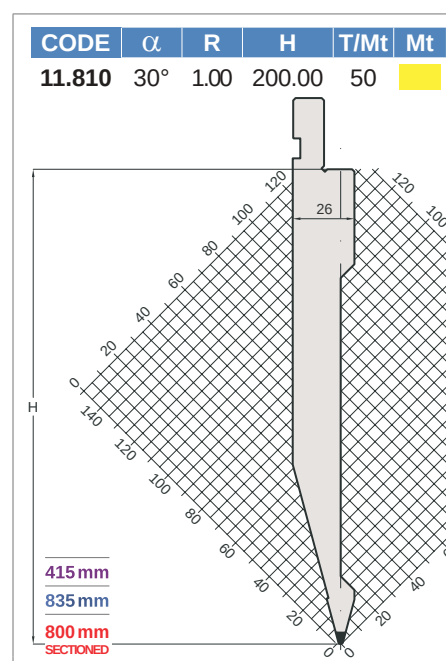
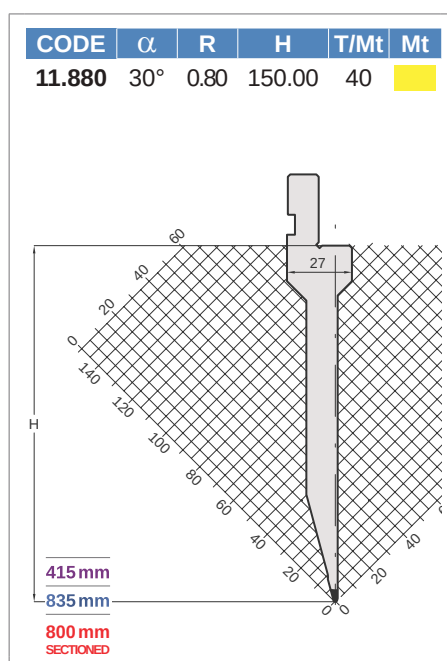
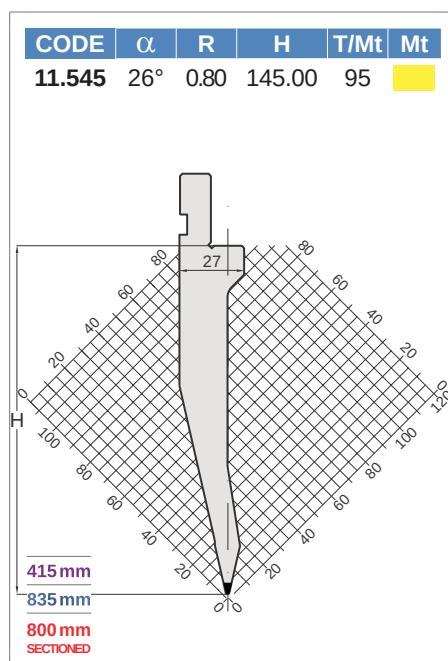
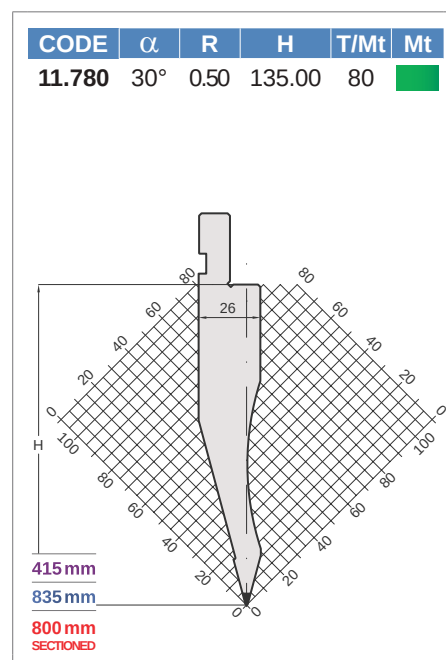
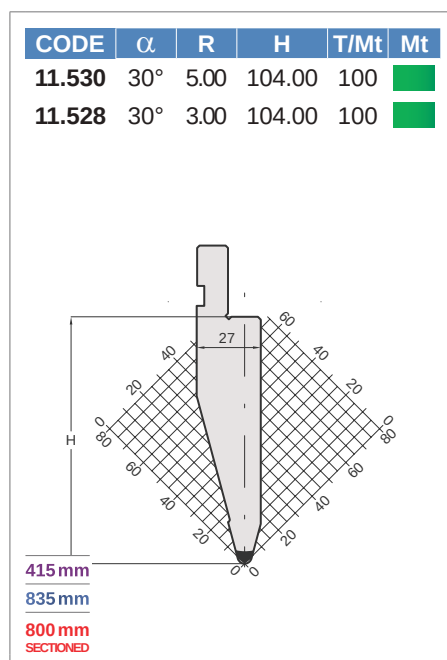
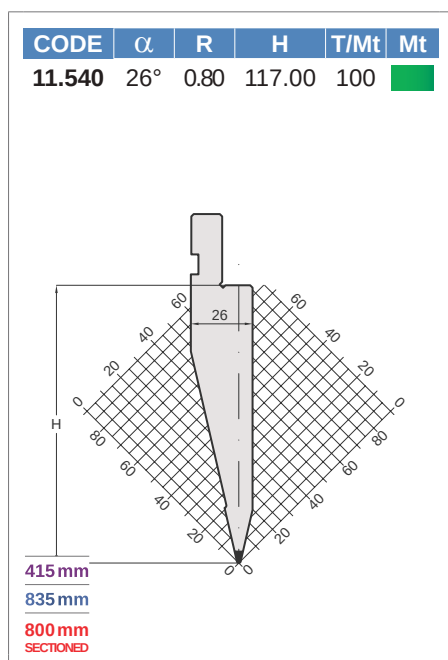
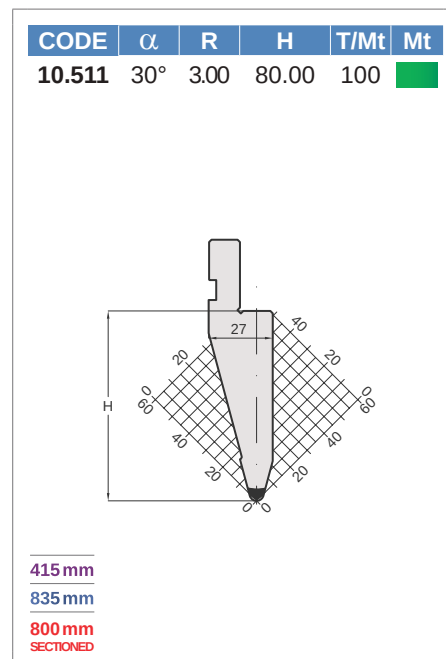
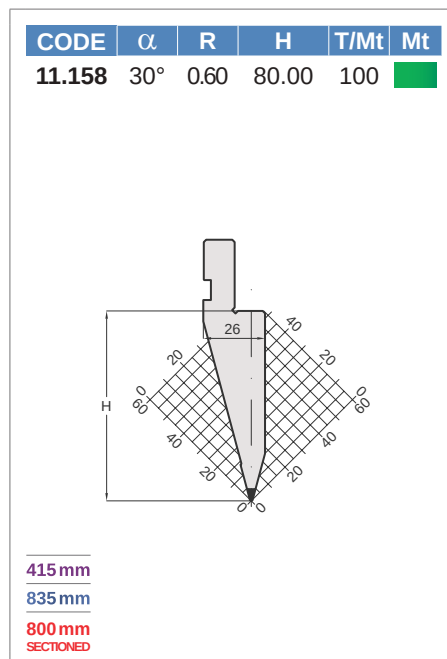
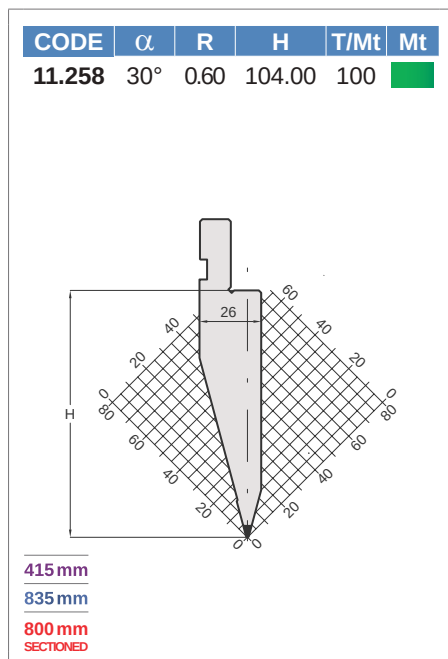


500mm

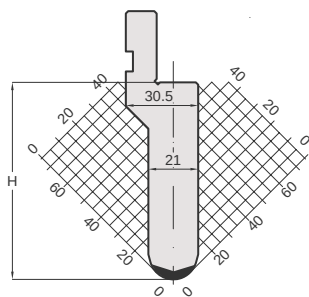
IL CARICO MASSIMO DELLE SCARPETTE CORRISPONDE AL 50% DEL CARICO MASSIMO INDICATO SUL PUNZONE.
 THE MAX LOAD OF THE HORN EXTENSIONS IS 50% OF THE MAX LOAD OF THE PUNCH.







CODE	α	R	H	T/Mt	Mt
11.904	30°	10.00	83.00	100	

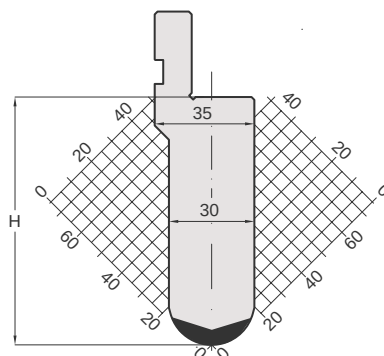


415 mm

835 mm

800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.911	30°	15.00	87.00	100	

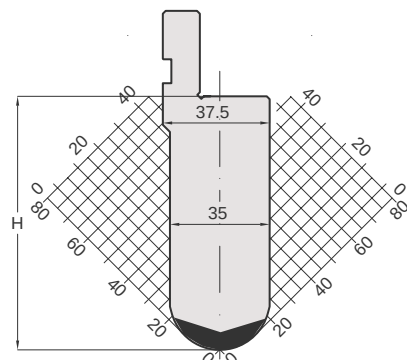


415 mm

835 mm

800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.914	30°	17.50	89.00	100	

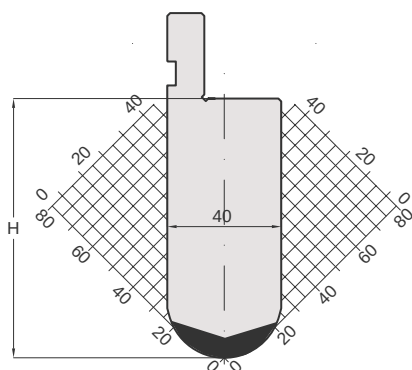


415 mm

835 mm

800 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
11.916	30°	20.00	91.00	100	



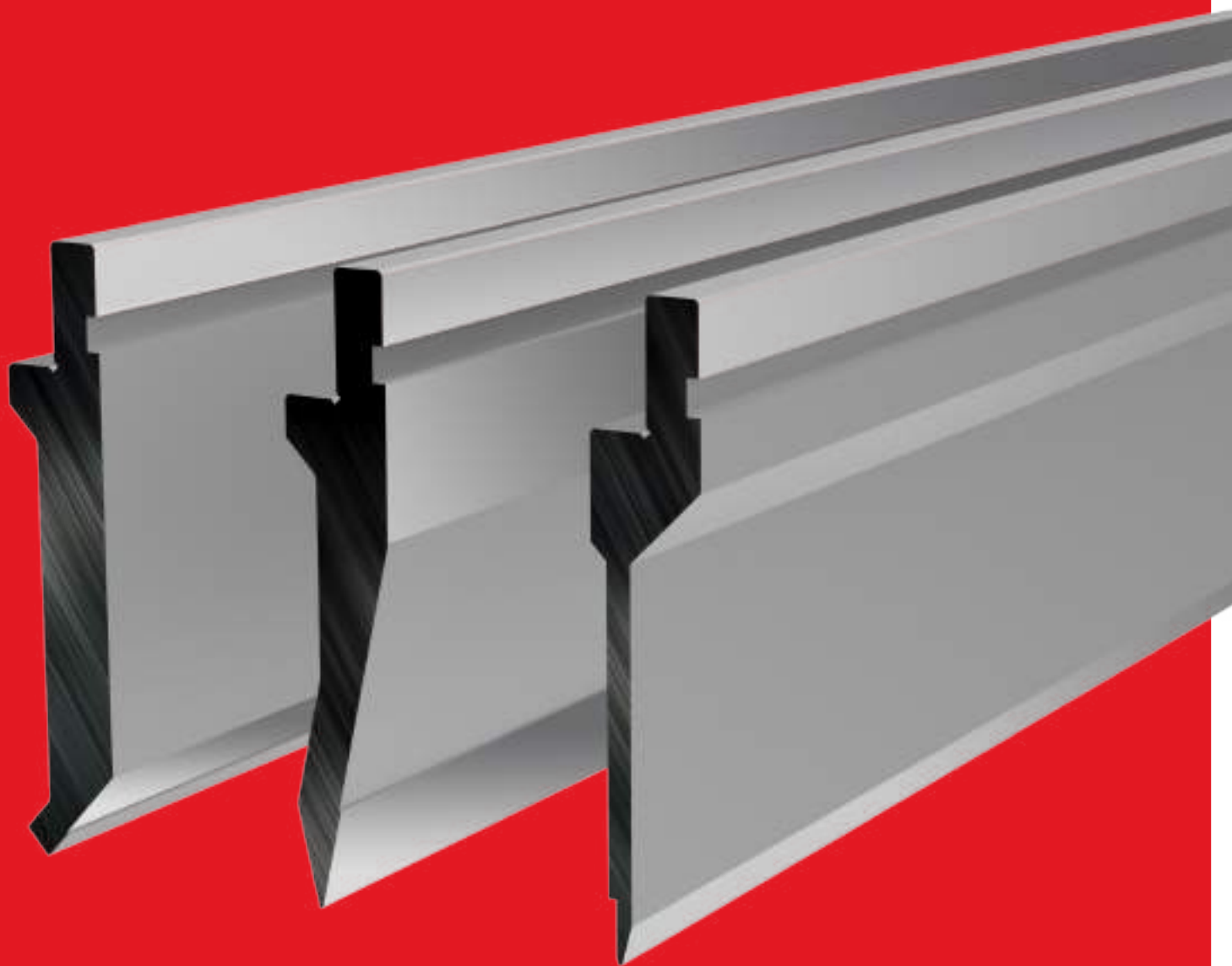
415 mm

835 mm

800 mm
SECTIONED

AMADA - AFH STYLE

PUNZONI PUNCHES



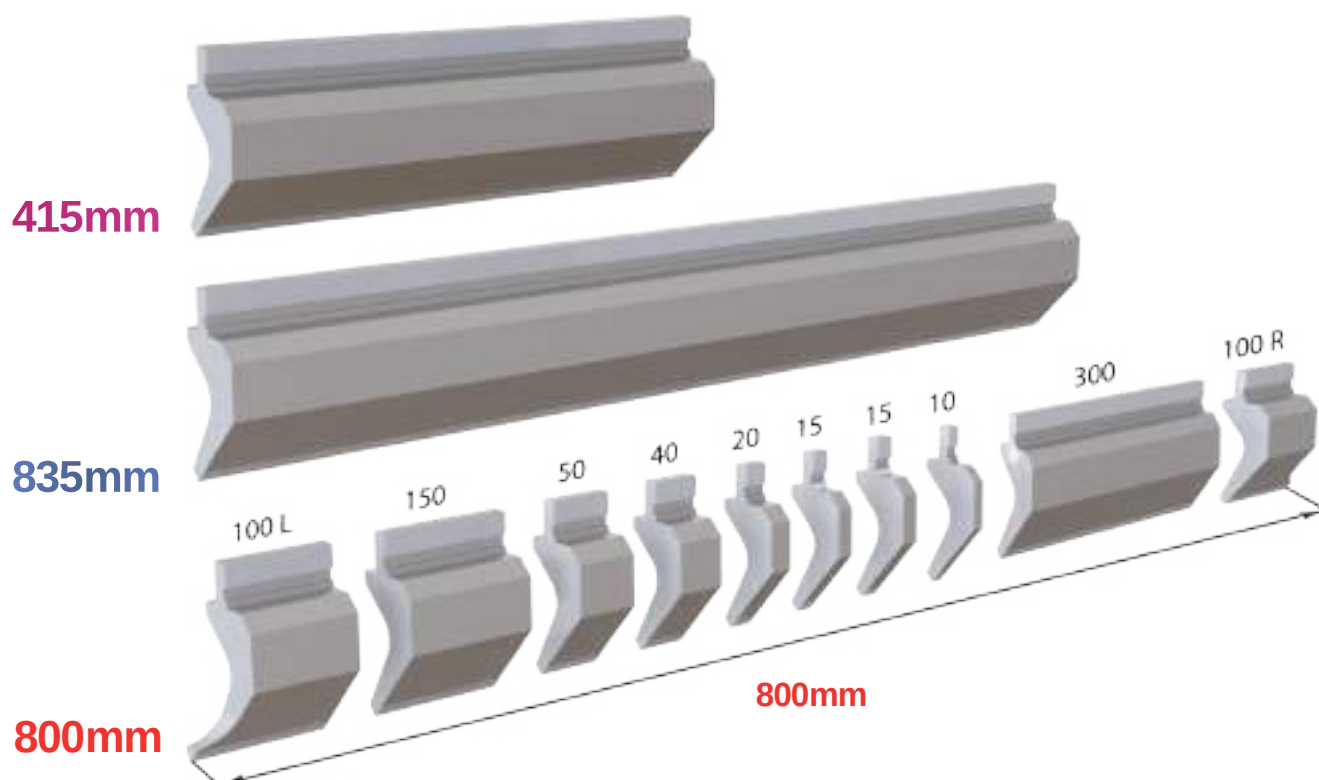
RED LINE

AMADA - AFH STYLE



PUNZONI / PUNCHES **AMADA - AFH STYLE**

I PUNZONI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 / 835 E FRAZIONATI (800 mm)
 THE PUNCHES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 / 835 AND SECTIONED (800 mm)



IL CARICO MASSIMO DELLE SCARPETTE CORRISPONDE AL 50% DEL CARICO MASSIMO INDICATO SUL PUNZONE.
 THE MAX LOAD OF THE HORN EXTENSIONS IS 50% OF THE MAX LOAD OF THE PUNCH.

CODE			
12.022	12.023	12.024	
12.027	12.028	12.029	
12.035	12.039	12.040	
12.041	12.042		

Technical drawing of a punch horn extension. The drawing shows a 3D perspective view of the part. The dimensions are: top width 35, bottom width 35, height 10, and a fillet radius R5. The drawing is oriented with the top width dimension at the top, the bottom width dimension at the bottom, and the height dimension on the left side. The fillet radius R5 is indicated on the top surface of the horn.

CODE			
12.032	12.033	12.043	

CODE			
12.037			

CODE			
12.044	12.045	12.046	
12.047	12.048		

Technical drawing of a mechanical part, likely a punch horn extension, showing dimensions: 20 (top width), R8 (radius), 18 (total height), and 12 (lower section height).

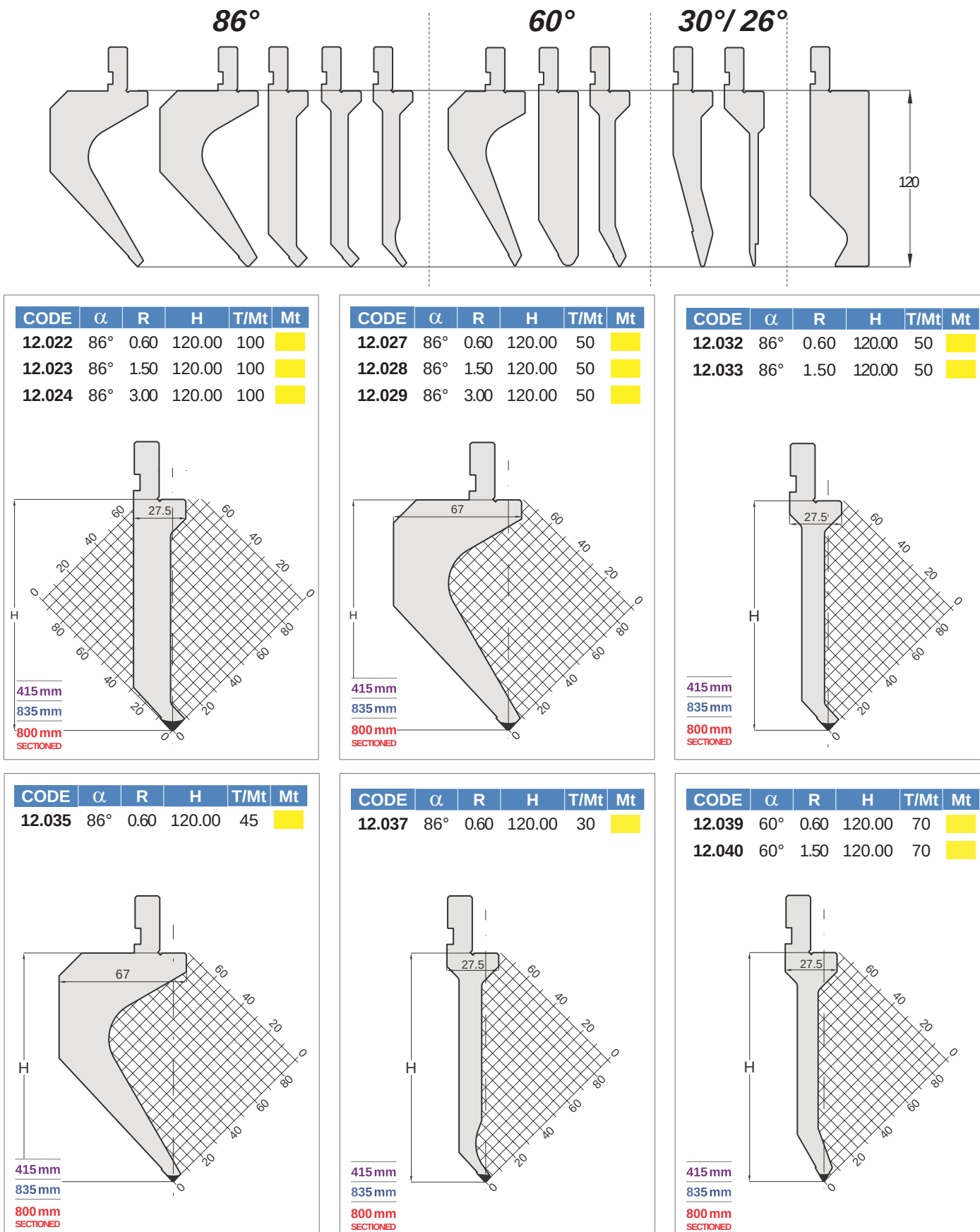
CODE			
12.049	12.050		

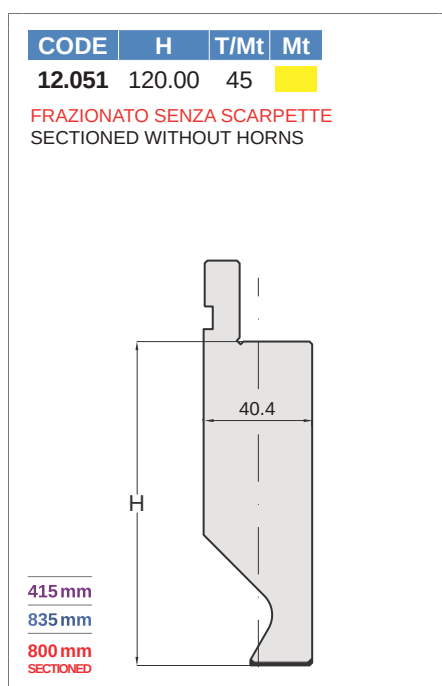
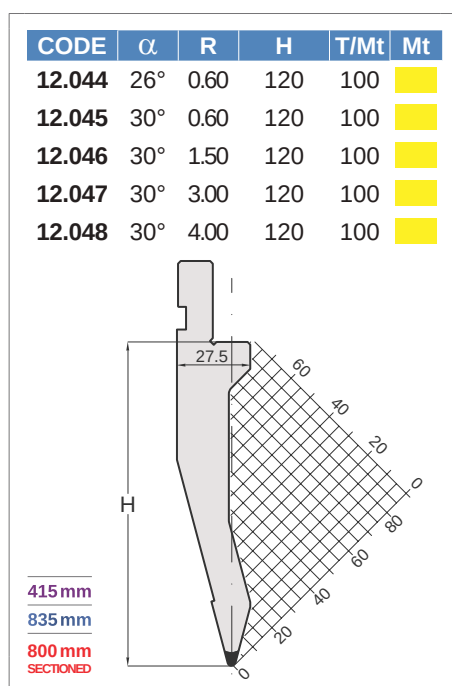
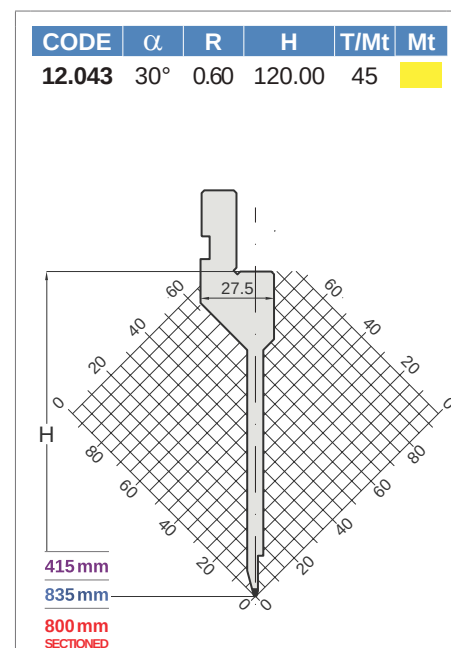
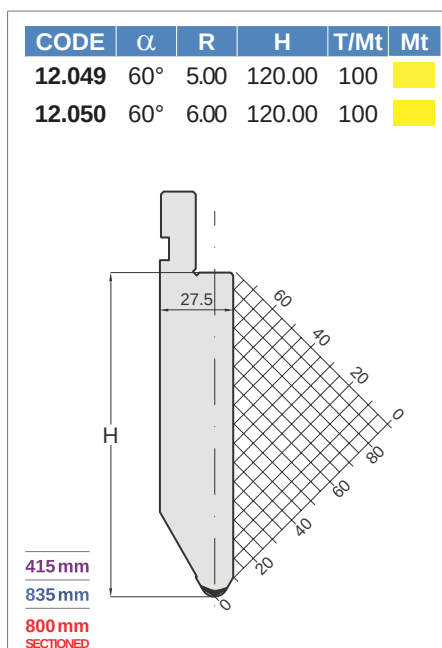
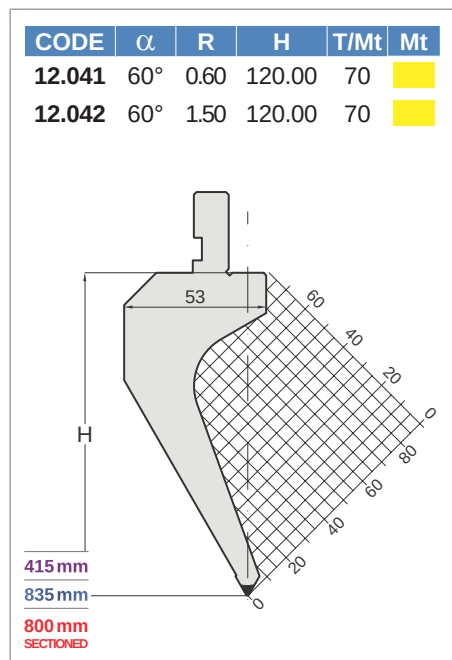
VANTAGGI UTENSILI AMADA AFH:

Gli utensili "AFH" sono progettati per consentire all'operatore di fabbricare prodotti che richiedono punzoni con profili diversi montandoli affiancati su un'unica tavola. Inoltre scegliendo di utilizzare la nostra gamma di inserti matrice (Pag.37), sarà possibile incrementare l'efficienza e ridurre i costi di produzione per piccoli lotti, semplificando complicate sequenze di piega e maneggiando il prodotto una sola volta.

ADVANTAGES OF AMADA AFH TOOLS:

Our "AFH" tools are designed in order to enable the operator to setup multiple bends within one brake bed. Also by choosing our range of inserts dies (Pag.37), it will be possible to increase efficiency and reduce production costs for small batches, simplifying complicated bending sequences and handling the product only once.

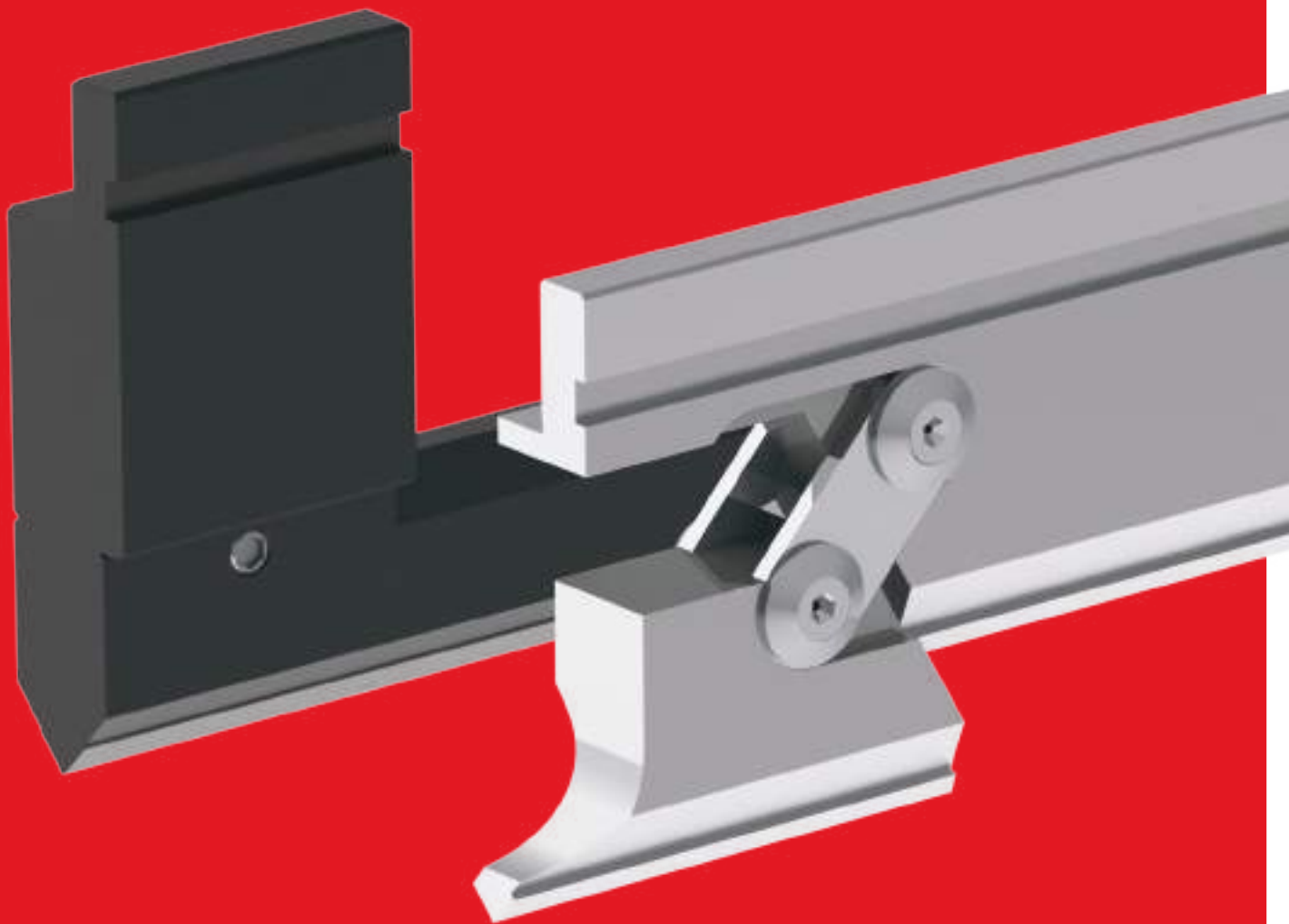




AMADA - PROMECAM STYLE

PUNZONE ROTANTE
E SCARPETTE MOBILI

ROTARY PUNCH
AND MOVING HORNS



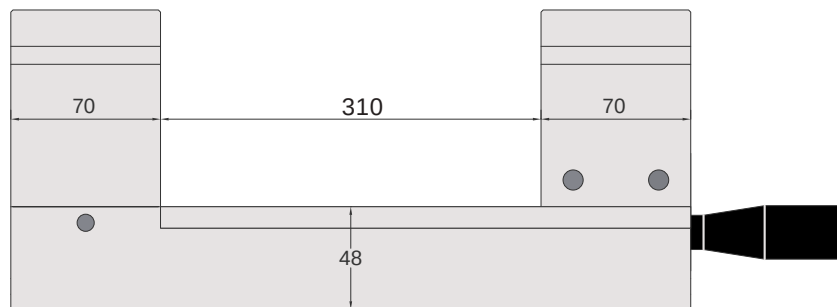
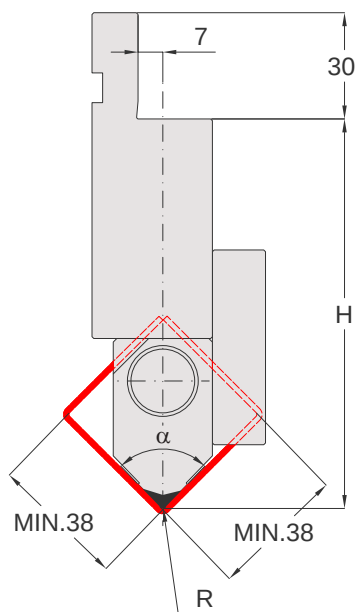
RED LINE

AMADA - PROMECAM STYLE



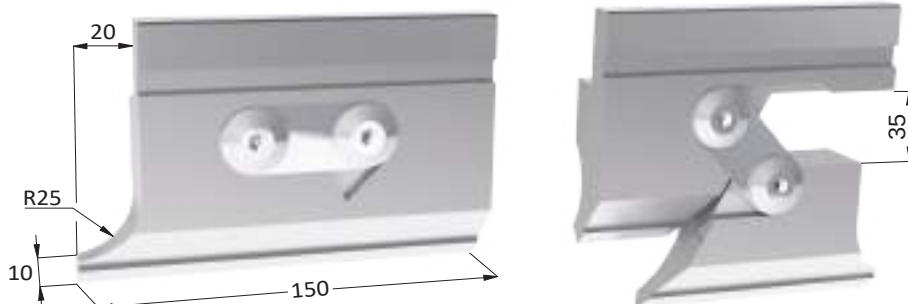
PUNZONE ROTANTE / ROTARY PUNCH **AMADA - PROMECAM STYLE**

CODE	α	R	H	T/Mt	Mt
40.680	85°	0.80	110.00	15	



SCARPETTE MOBILI / MOVING HORNS **AMADA - PROMECAM STYLE**

SCARPETTE MOBILI MOVING HORNS		PUNZONI PUNCHES
40.114	➡	11.200
40.116	➡	11.201
40.122	➡	10.170



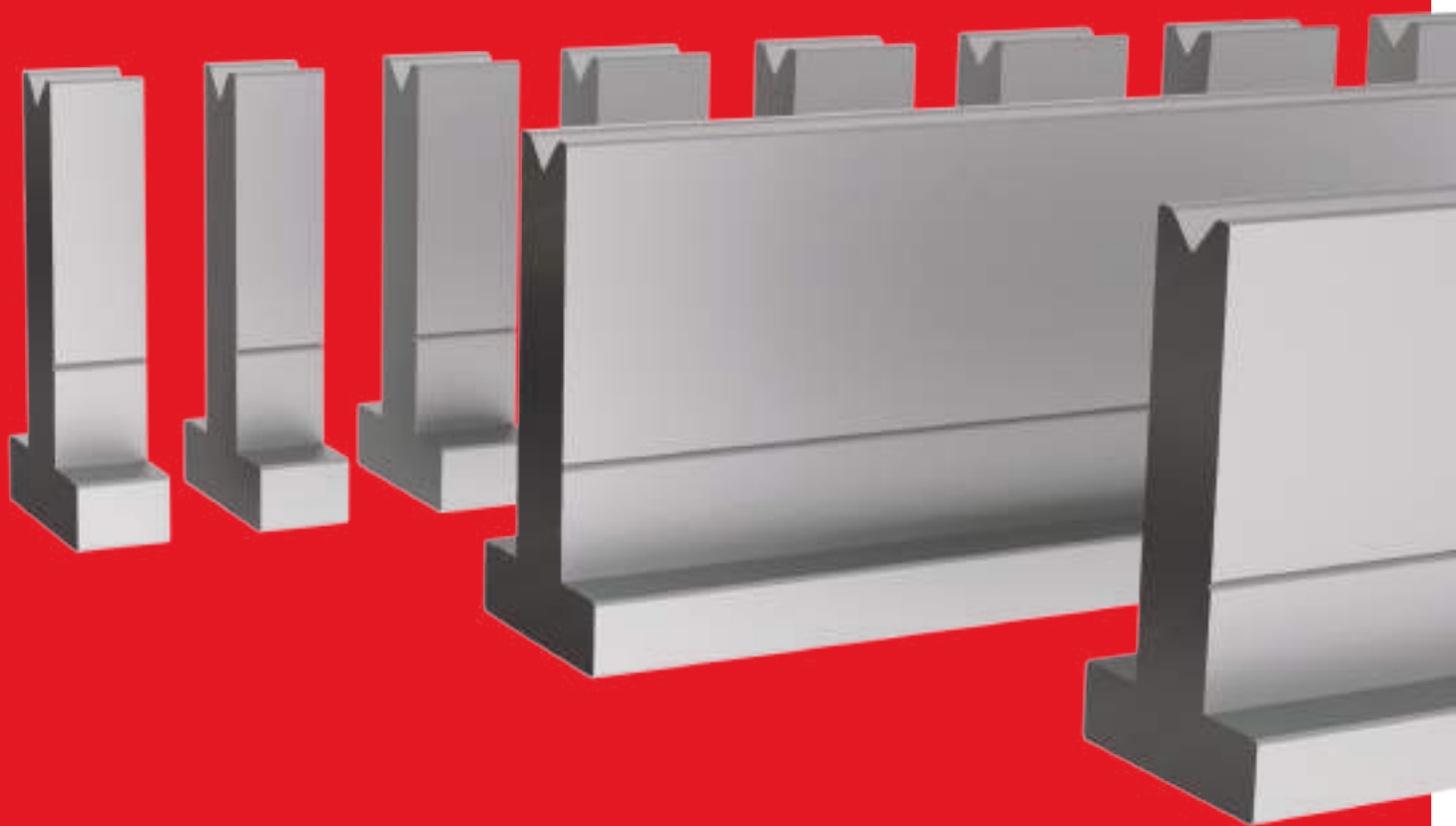
IL CARICO MASSIMO DELLE SCARPETTE CORRISPONDE AL 50% DEL CARICO MASSIMO INDICATO SUL PUNZONE.
THE MAX LOAD OF THE HORN EXTENSIONS IS 50% OF THE MAX LOAD OF THE PUNCH.



ADATTE ALL'ESECUZIONE DI SCATOLE E IDONEE PER LE ISOLE ROBOTIZZATE
SUITABLE TO BOXES PRODUCTION AND ROBOT BENDING CELLS

AMADA - PROMECAM STYLE

MATRICI
DIES



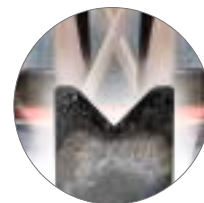
RED LINE

AMADA - PROMECAM STYLE

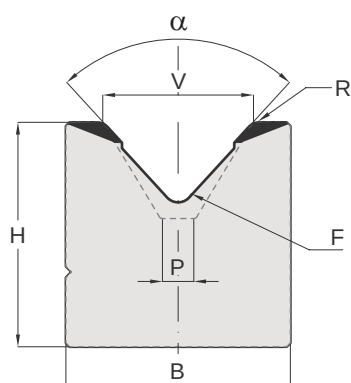


MATRICI / DIES *AMADA - PROMECAM STYLE 2V / 4V*

LE MATRICI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 / 835 E FRAZIONATI (800 mm)
THE DIES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 / 835 AND SECTIONED (800 mm)



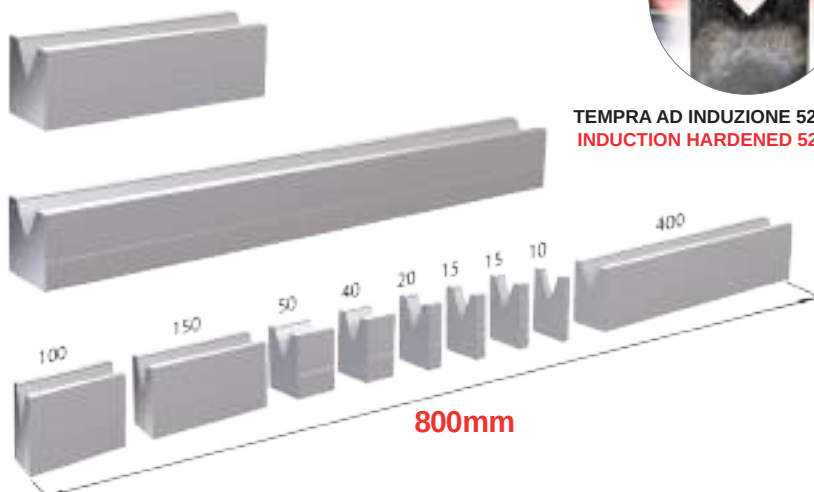
TEMPRA AD INDUZIONE 52-55 HRC
INDUCTION HARDENED 52-55 HRC



415mm

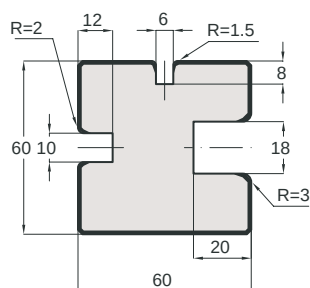
835mm

800mm



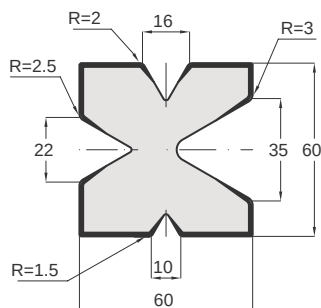
LEGENDA	α = ANGOLO	V = AMPIEZZA CAVA	R = RAGGIO	H = ALTEZZA	F = FONDO MATRICE	P = PIANO	B = BASE
LEGEND	α = ANGLE	V = DIE OPENING	R = RADIUS	H = HEIGHT	F = BOTTOM DIES	P = FLAT	B = BASE

CODE	T/Mt	Mt
21.209	100	



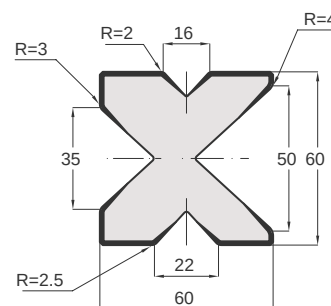
415 mm
835 mm
800 mm
SECTIONED

CODE	α	T/Mt	Mt
20.350	60°	60	



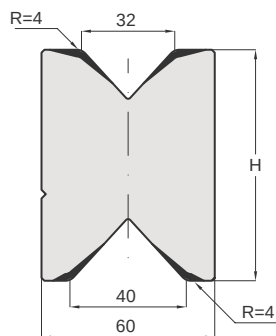
415 mm
835 mm
800 mm
SECTIONED

CODE	α	T/Mt	Mt
21.207	85°	80	



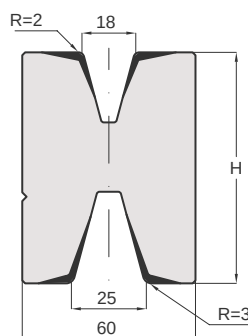
415 mm
835 mm
800 mm
SECTIONED

CODE	α	H	T/Mt	Mt
20.820	85°	80.00	100	



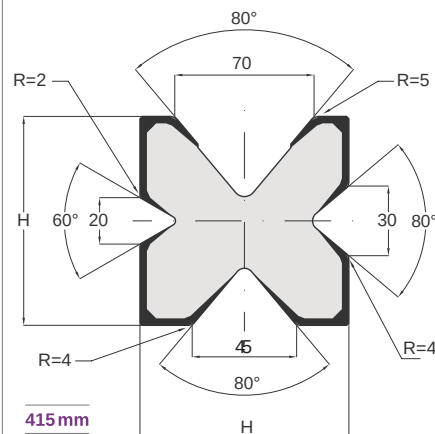
415 mm
835 mm
800 mm
SECTIONED

CODE	α	H	T/Mt	Mt
20.830	30°	80.00	100	



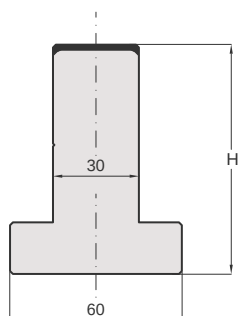
415 mm
835 mm
800 mm
SECTIONED

CODE	α	H	T/Mt	Mt
28.820	60°-80°	90	80	



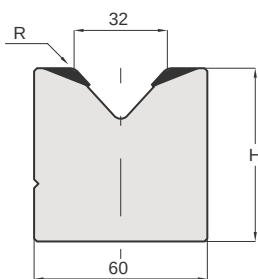
415 mm
835 mm
800 mm
SECTIONED

CODE	H	T/Mt	Mt
20.240	80.00	100	



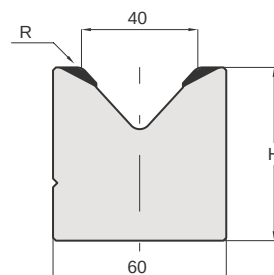
415 mm
835 mm
800 mm
SECTIONED

CODE	α	V	R	H	T/Mt	Mt
20.210	85°	32	4.00	60.00	100	



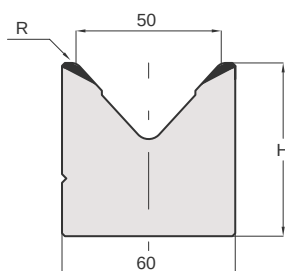
415 mm
835 mm
800 mm
SECTIONED

CODE	α	V	R	H	T/Mt	Mt
20.211	85°	40	4.00	60.00	100	



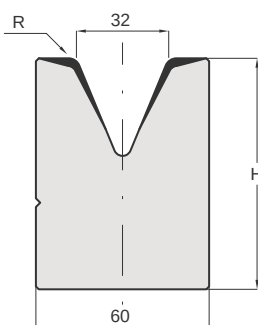
415 mm
835 mm
800 mm
SECTIONED

CODE	α	V	R	H	T/Mt	Mt
20.212	85°	50	4.00	60.00	100	



415 mm
835 mm
800 mm
SECTIONED

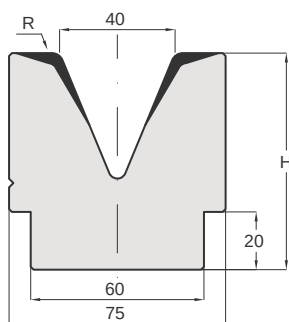
CODE	α	V	R	H	T/Mt	Mt
20.484	45°	32	4.00	80.00	100	



415 mm
835 mm
800 mm
SECTIONED

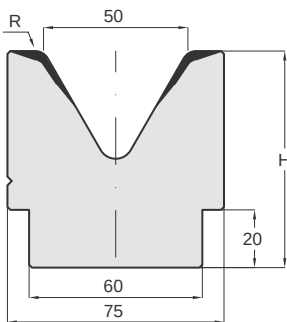


CODE	α	V	R	H	T/Mt	Mt
20.440	45°	40	4.00	75.00	100	



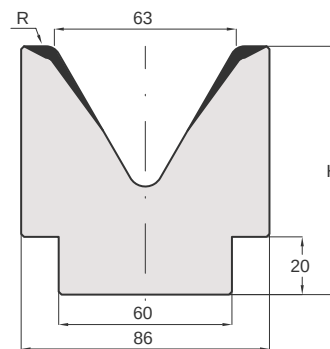
415 mm
835 mm
800 mm
SECTIONED

CODE	α	V	R	H	T/Mt	Mt
20.650	60°	50	5.00	75.00	100	

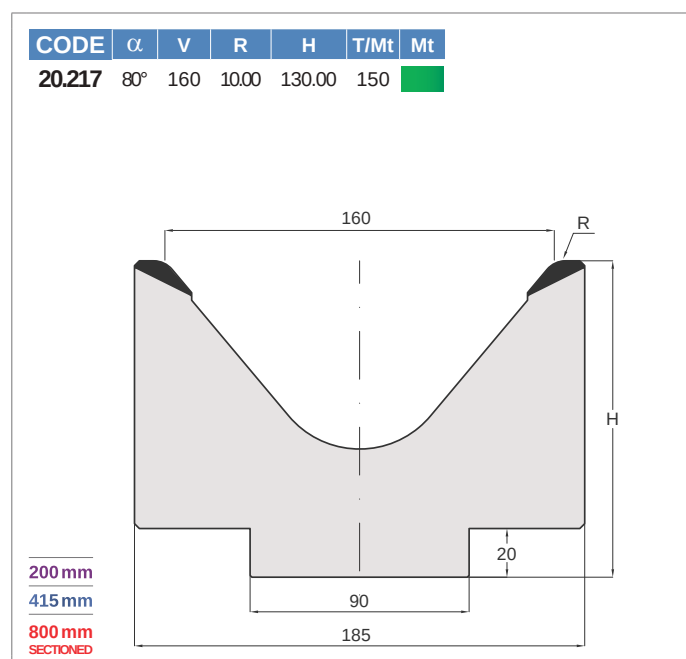
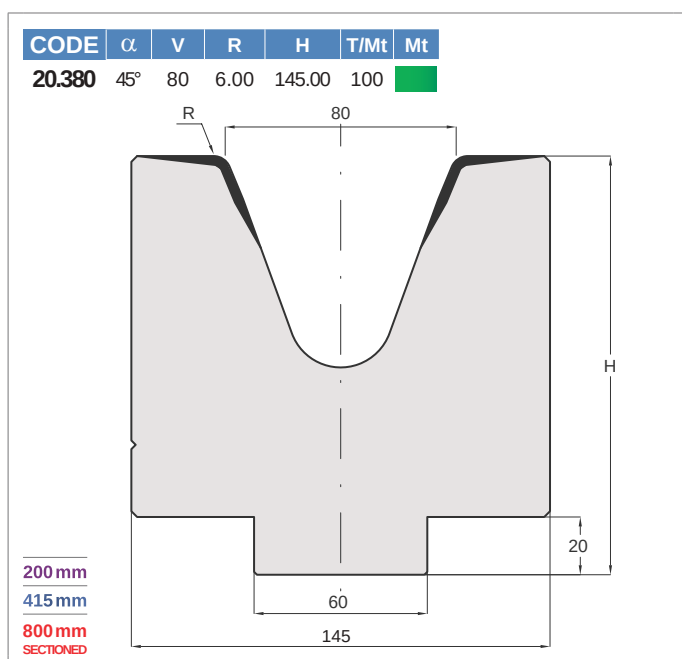
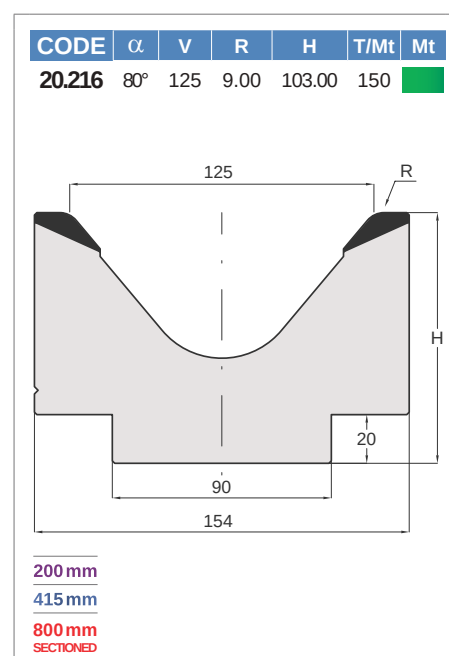
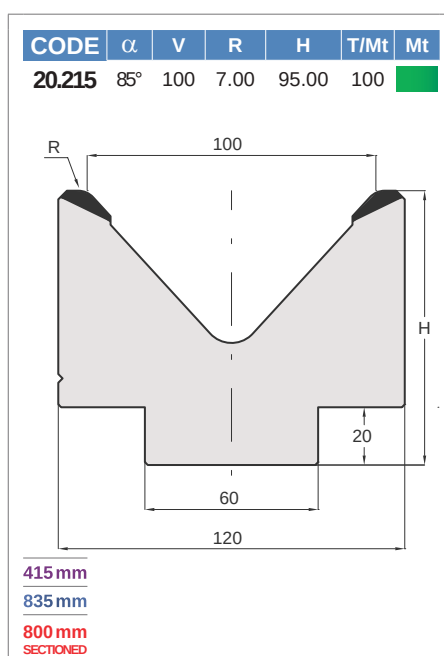
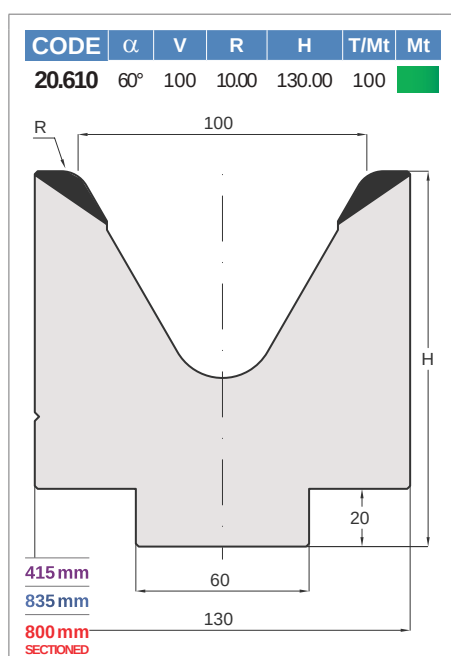
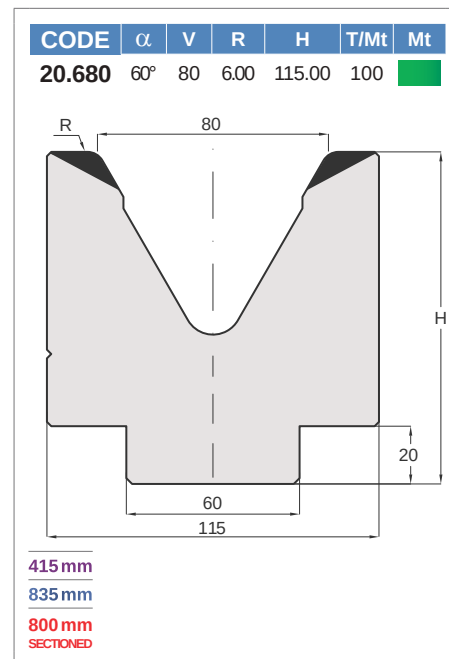
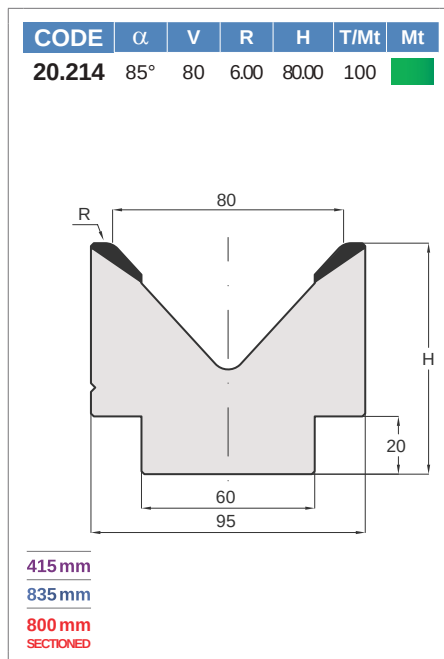
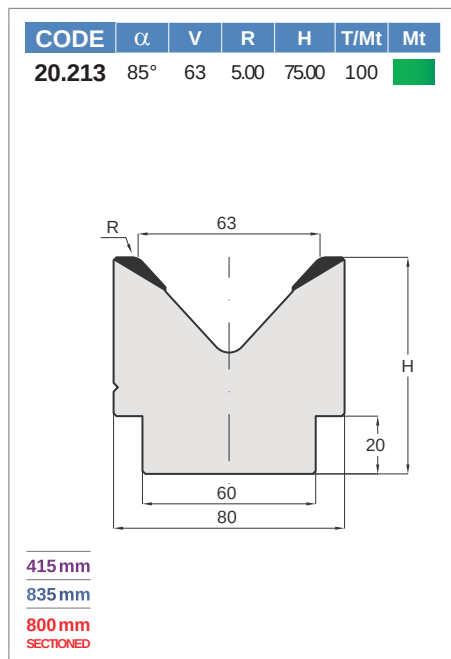


415 mm
835 mm
800 mm
SECTIONED

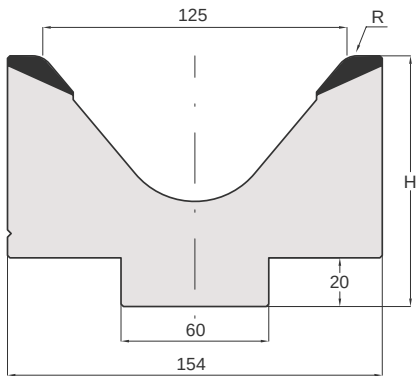
CODE	α	V	R	H	T/Mt	Mt
20.370	60°	63	5.00	86.00	100	



415 mm
835 mm
800 mm
SECTIONED

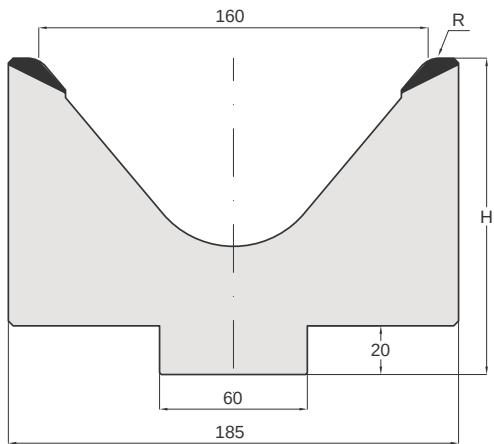


CODE	α	V	R	H	T/Mt	Mt
21.125	80°	125	9.00	103.00	150	



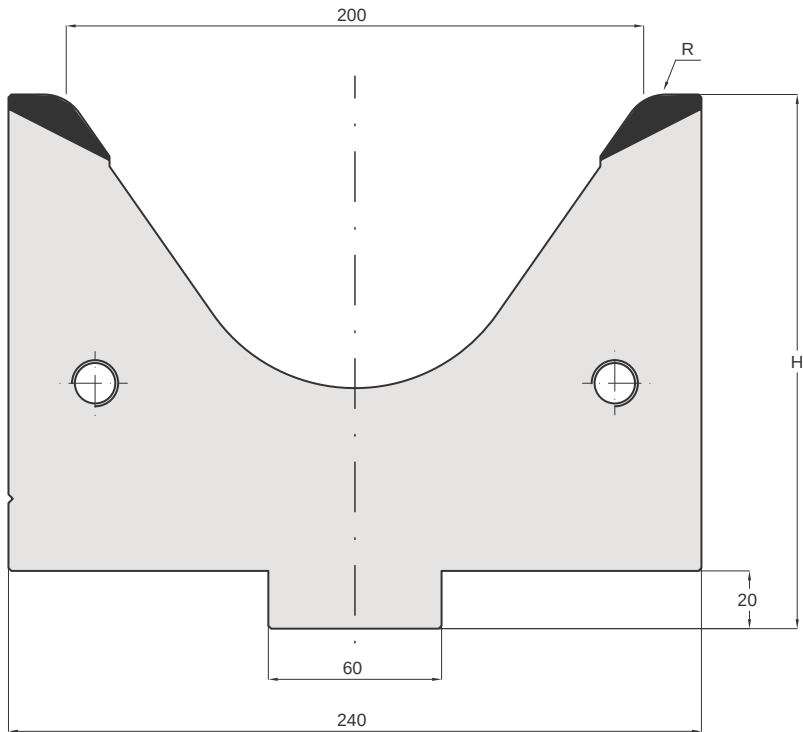
200 mm
415 mm
800 mm
SECTIONED

CODE	α	V	R	H	T/Mt	Mt
21.160	80°	160	10.00	130.00	150	

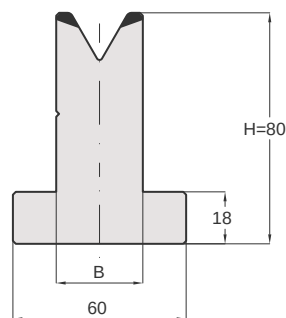
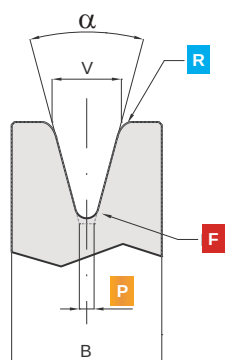


200 mm
415 mm
800 mm
SECTIONED

CODE	α	V	R	H	T/Mt	Mt
21.200	70°	200	15.00	185.00	200	



200 mm
415 mm

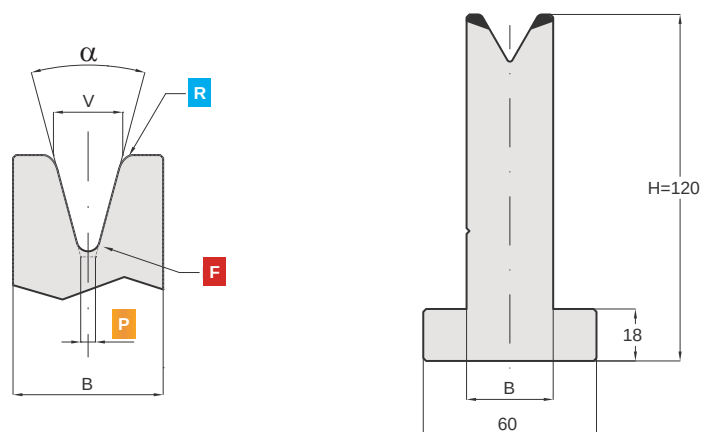


415 mm | 835 mm | 800 mm SECTIONED

LE MATRICI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 mm - 835 mm E FRAZIONATI (800 mm)
THE DIES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 mm - 835 mm AND SECTIONED (800 mm)

LEGENDA	α = ANGOLO	V = AMPIEZZA CAVA	R = RAGGIO	H = ALTEZZA	F = FONDO MATRICE	P = PIANO	B = BASE
LEGEND	α = ANGLE	V = DIE OPENING	R = RADIUS	H = HEIGHT	F = BOTTOM DIES	P = FLAT	B= BASE

CODE	α	V	R	H	B	F	T/mt	Mt
20.506	85°	6	1.50	80	14	R0.5	100	
20.508	85°	8	2.00	80	14	R0.5	100	
20.510	85°	10	2.50	80	18	R0.5	100	
20.512	85°	12	3.00	80	18	R0.5	100	
20.516	85°	16	3.50	80	24	R0.5	100	
20.520	85°	20	4.00	80	30	R1.0	100	
20.525	85°	25	5.00	80	35	R1.0	100	
20.297	60°	6	0.40	80	14	R0.5	60	
20.298	60°	8	0.50	80	14	R0.5	60	
20.299	60°	10	0.60	80	18	R0.5	60	
20.300	60°	12	0.80	80	18	R0.5	60	
20.301	60°	16	1.60	80	24	R0.7	60	
20.308	60°	20	2.00	80	30	R1.0	60	
20.311	60°	25	3.00	80	35	R1.0	60	
20.406	35°	6	1.50	80	14	R1.0	40	
20.408	35°	8	2.00	80	18	P2.0	40	
20.410	35°	10	2.50	80	24	P2.0	55	
20.412	35°	12	3.00	80	24	P2.0	45	
20.416	35°	16	3.50	80	30	P2.0	50	
20.420	35°	20	4.00	80	35	P5.0	60	
20.425	35°	25	5.00	80	40	P5.0	60	
20.317	30°	6	0.60	80	14	R1.0	35	
20.318	30°	8	0.80	80	18	P2.0	35	
20.319	30°	10	1.00	80	24	P2.0	50	
20.320	30°	12	1.50	80	24	P2.0	40	
20.321	30°	16	2.00	80	30	P5.0	45	
20.322	30°	20	2.50	80	35	P5.0	50	
20.323	30°	25	3.00	80	40	P5.0	50	



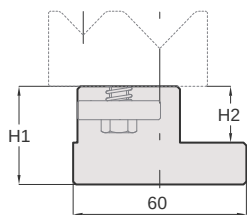
415 mm | 835 mm | 800 mm SECTIONED

LE MATRICI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 mm - 835 mm E FRAZIONATI (800 mm)
THE DIES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 mm - 835 mm AND SECTIONED (800 mm)

LEGENDA	α = ANGOLO	V = AMPIEZZA CAVA	R = RAGGIO	H = ALTEZZA	F = FONDO MATRICE	P = PIANO	B = BASE
LEGEND	α = ANGLE	V = DIE OPENING	R = RADIUS	H = HEIGHT	F = BOTTOM DIES	P = FLAT	B = BASE

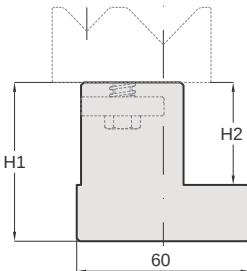
CODE	α	V	R	H	B	F	T/mt	Mt
21506	85°	6	1.50	120	14	R0.5	100	
21508	85°	8	2.00	120	14	R0.5	100	
21510	85°	10	2.50	120	18	R0.5	100	
21512	85°	12	3.00	120	18	R0.5	100	
21516	85°	16	3.50	120	24	R0.5	100	
21520	85°	20	4.00	120	30	R1.0	100	
21525	85°	25	5.00	120	35	R1.0	100	
20386	60°	6	0.40	120	14	R0.5	60	
20387	60°	8	0.50	120	14	R0.5	60	
20388	60°	10	0.60	120	18	R0.5	60	
20389	60°	12	0.80	120	18	R0.5	60	
20390	60°	16	1.60	120	24	R0.7	60	
20391	60°	20	2.00	120	30	R1.0	60	
20392	60°	25	3.00	120	35	R1.0	60	
21406	35°	6	1.50	120	14	R1.0	40	
21408	35°	8	2.00	120	18	P2.0	40	
21410	35°	10	2.50	120	24	P2.0	55	
21412	35°	12	3.00	120	24	P2.0	45	
21416	35°	16	3.50	120	30	P2.0	50	
21420	35°	20	4.00	120	35	P5.0	60	
21425	35°	25	5.00	120	40	P5.0	60	
20351	30°	6	0.60	120	14	R1.0	35	
20352	30°	8	0.80	120	18	P2.0	35	
20353	30°	10	1.00	120	24	P2.0	50	
20354	30°	12	1.50	120	24	P2.0	40	
20401	30°	16	2.00	120	30	P5.0	45	
20402	30°	20	2.50	120	35	P5.0	50	
20403	30°	25	3.00	120	40	P5.0	50	

CODE	H1	H2	T/Mt	Mt
20.200	34.00	20.00	100	



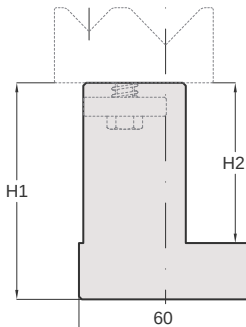
412 mm
830 mm

CODE	H1	H2	T/Mt	Mt
20.201	55.00	35.00	100	



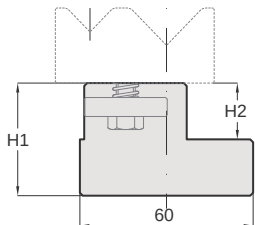
412 mm
830 mm

CODE	H1	H2	T/Mt	Mt
20.306	75.00	55.00	100	



412 mm
830 mm

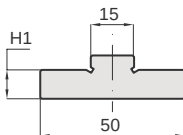
CODE	H1	H2	T/Mt	Mt
20.316	39.00	20.00	100	



412 mm
830 mm

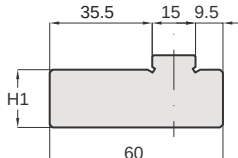
CODE	H1	T/Mt	Mt
20.287	10.00	100	

KIT 40.001 INCLUSO
KIT 40.001 INCLUDED



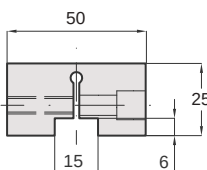
415 mm
835 mm

CODE	H1	T/Mt	Mt
20.400	20.00	100	



415 mm
835 mm

CODE	Mt
20.336	



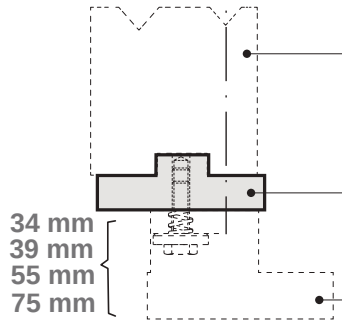
CODE
40.001



KIT MONTAGGIO PER SUPPORTO 20.287
ASSEMBLY KIT FOR HOLDER 20.287

SPARE PARTS

SCHEMA DI MONTAGGIO - ASSEMBLY SCHEME



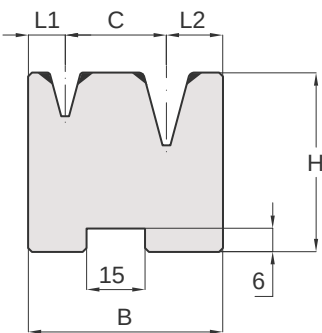
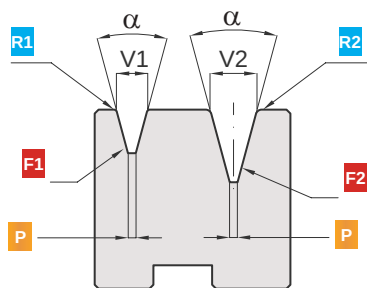
Matrice autocentrante
Self centering die

Supporto per matrice autocentrante 2V
Rail for self centering 2V dies

Supporto per matrice
Die Holder

34 mm
39 mm
55 mm
75 mm



415 mm | 835 mm | 800 mm SECTIONED

LE MATRICI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 mm - 835 mm E FRAZIONATI (800 mm)
THE DIES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 mm - 835 mm AND SECTIONED (800 mm)

LEGENDA	α = ANGOLO	V = AMPIEZZA CAVA	R1/R2 = RAGGIO	H = ALTEZZA	F1/F2 = FONDO MATRICE	P = PIANO
LEGEND	α = ANGLE	V = DIE OPENING	R1/R2 = RADIUS	H = HEIGHT	F1/F2 = BOTTOM DIES	P = FLAT

CODE	α	V1	V2	R1	R2	F1	F2	L1	L2	H	B	C	T/Mt	Mt
20.344	85°	4	7	0.60	1.00	R0.5	R0.5	3.50	5.00	46	34.5	26	80	
20.345	85°	6	10	1.00	1.50	R0.5	R0.5	4.50	6.50	46	37	26	80	
20.346	85°	8	12	1.20	1.75	R0.5	R0.5	5.50	7.50	46	39	26	80	
20.347	85°	12	20	1.75	2.50	R0.5	R0.5	7.50	12.00	46	45.5	26	80	
20.349	85°	14	18	1.50	2.00	R0.5	R0.5	8.50	10.50	46	45	26	80	
20.348	85°	16	25	2.00	3.00	R0.5	R1.0	9.50	14.50	46	50	26	80	
20.438	30°	6	10	0.60	1.00	R1.0	P2.0	7.00	12.00	46	45	26	40	
20.478	30°	8	12	0.80	1.50	P2.0	P2.0	9.50	14.50	46	50	26	40	

ELENCO - LIST

20.344



20.347



20.438



20.345



20.348



20.478



20.346



20.349

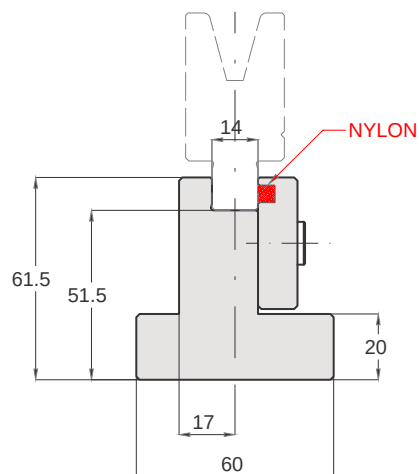


SUPPORTI MATRICE / DIE HOLDERS **AMADA - PROMECAM STYLE**

BLOCCAGGIO STANDARD - 8 VITI

NORMAL LOCKING - 8 SCREWS

CODE	Mt
22.010	



415 mm
835 mm



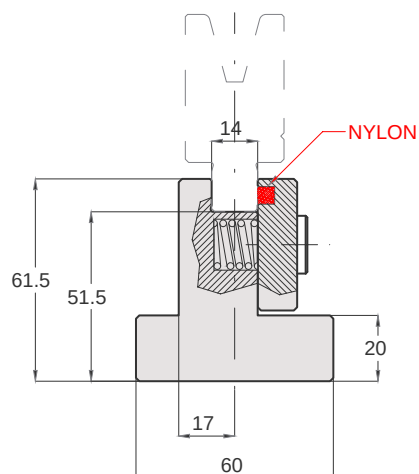
BLOCCAGGIO VELOCE - 2 VITI

FAST LOCKING - 2 SCREWS

CODE	Mt
22.020	

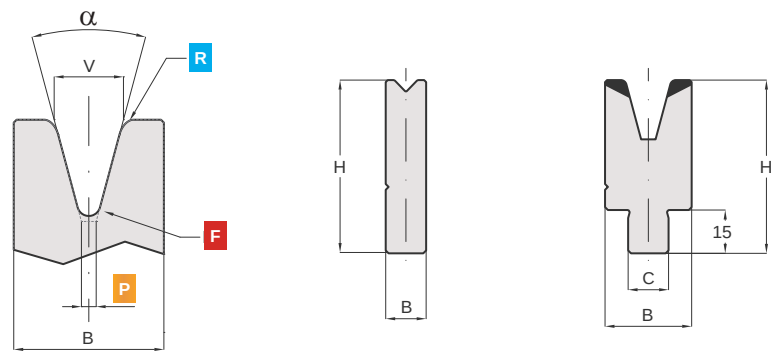


BLOCCAGGIO RAPIDO
FAST LOCKING



415 mm
835 mm





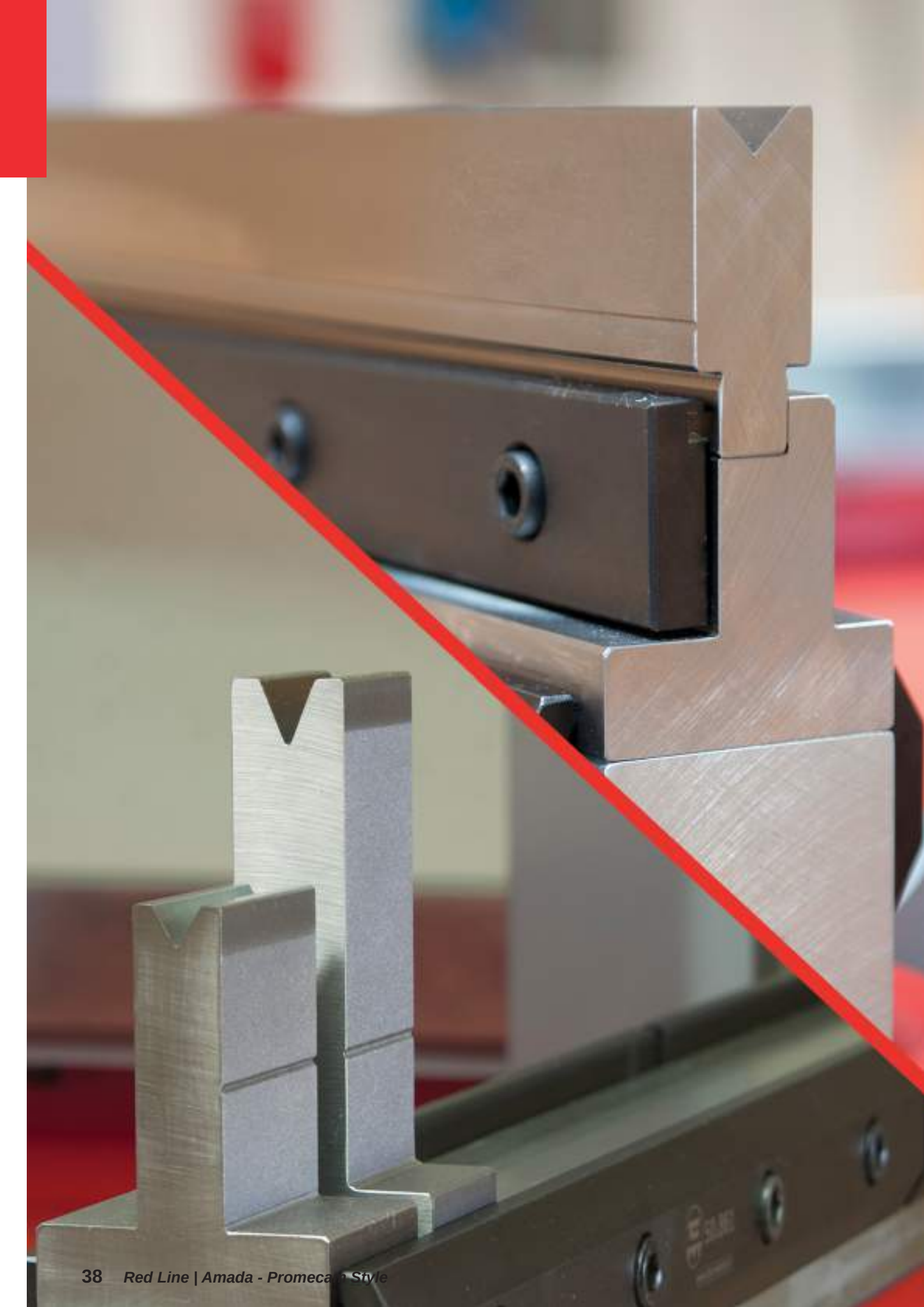
415 mm | 835 mm | 800 mm SECTIONED

LE MATRICI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 mm - 835 mm E FRAZIONATI (800 mm)
 THE DIES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 mm - 835 mm AND SECTIONED (800 mm)

LEGENDA	α = ANGOLO	V = AMPIEZZA CAVA	R = RAGGIO	H = ALTEZZA	B = STELO	C = CODOLO	F = FONDO MATRICE	P = PIANO
LEGEND	α = ANGLE	V = DIE OPENING	R = RADIUS	H = HEIGHT	B = BODY	C = TANG	F = BOTTOM DIE	P = FLAT

CODE	α	V	R	H	B	C	F	T/mt	Mt
22.904	86°	4	1.00	60	10	14	R0.5	75	
22.906	86°	6	1.50	60	11	14	R0.5	80	
22.908	86°	8	1.50	60	12	14	R1.0	90	
22.910	86°	10	2.00	60	13.5	14	R1.0	100	
22.912	86°	12	2.50	60	15	14	R1.0	100	
22.914	86°	14	2.50	60	17	14	R1.0	100	
22.916	86°	16	2.50	60	20	14	R1.0	100	
22.918	86°	18	2.50	60	22	14	R1.0	100	
22.920	86°	20	2.50	60	24.4	14	R1.0	100	
22.925	86°	25	3.00	60	29.6	14	R2.0	100	
22.832	84°	32	4.00	60	38	14	R2.0	100	
22.840	84°	40	4.00	60	46	14	R2.0	100	
22.606	60°	6	0.60	60	12	14	R0.6	38	
22.608	60°	8	0.80	60	13.5	14	R0.8	45	
22.610	60°	10	1.00	60	16	14	R1.0	55	
22.612	60°	12	1.20	60	17	14	R1.0	55	
22.616	60°	16	1.60	60	22	14	R1.0	65	
22.620	60°	20	2.00	60	28	14	R1.0	85	
22.625	60°	25	2.50	60	31	14	R1.0	85	
22.432	45°	32	5.00	80	50	14	R5.0	100	
22.440	45°	40	5.00	80	60	14	R5.0	100	
22.306	30°	6	0.60	60	14	14	R1.0	35	
22.308	30°	8	0.80	60	18	14	P2.0	35	
22.310	30°	10	1.00	60	24	14	P2.0	50	
22.312	30°	12	1.50	60	24	14	P2.0	40	
22.316	30°	16	2.00	60	30	14	P5.0	45	
22.320	30°	20	2.50	60	35	14	P5.0	50	
22.325	30°	25	3.00	65	45	14	P8.0	50	





AMADA - PROMECAM STYLE

PIEGASCHIACCIA
HEMMING TOOLS

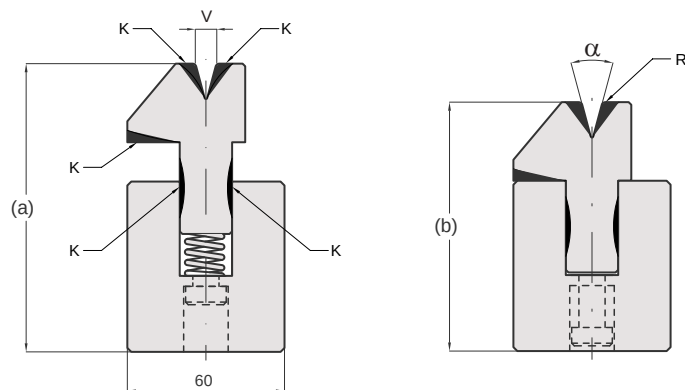


RED LINE

AMADA - PROMECAM STYLE

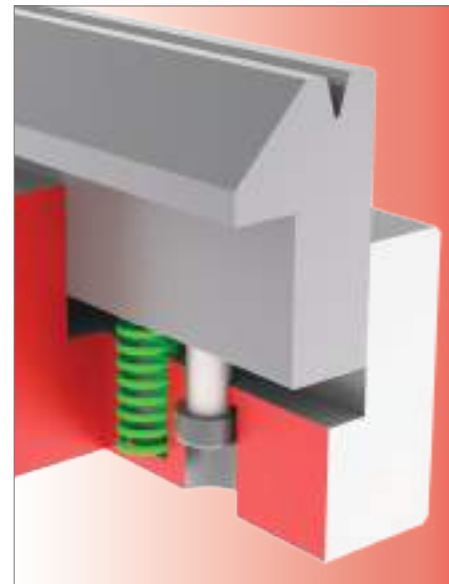
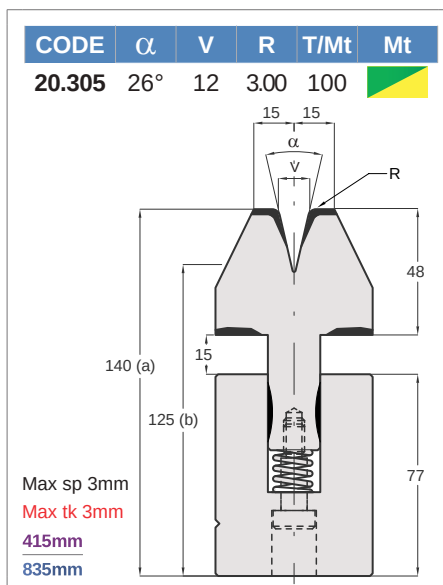
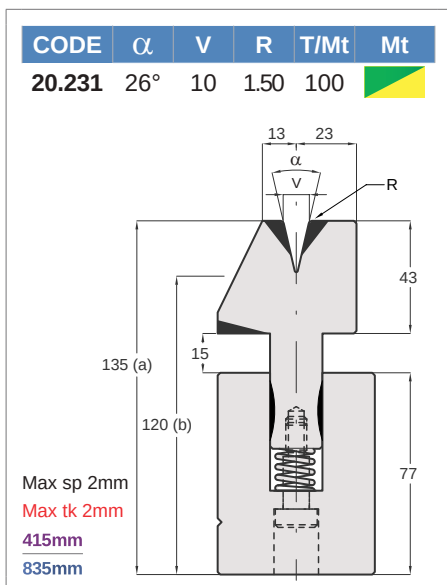
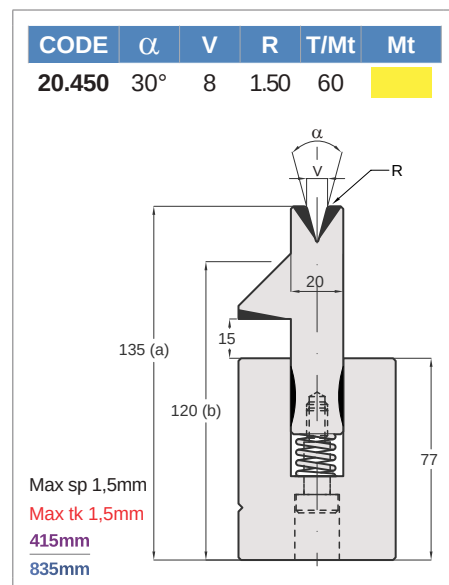
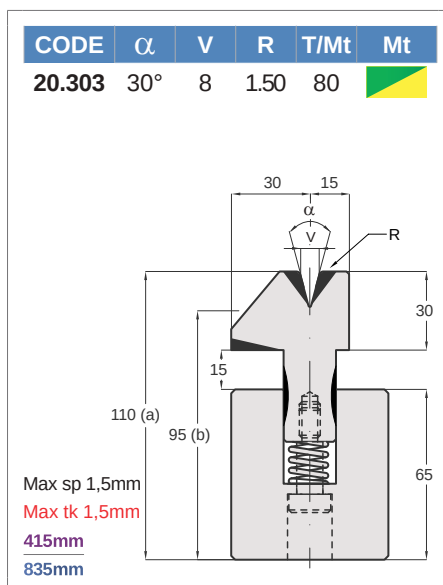
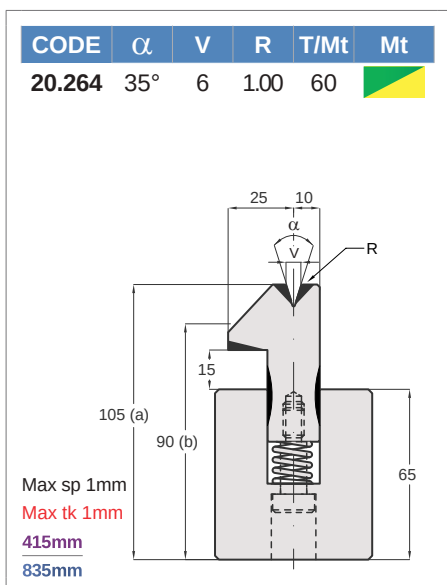


MATRICI PIEGASCHIACCIA / HEMMING DIES **AMADA STYLE**



LEGENDA	(a) = APERTO	(b) = CHIUSO	(α) = ANGOLO	V = AMPIEZZA CAVA	R = RAGGIO	K = PARTI USURABILI
LEGEND	(a) = OPEN	(b) = CLOSED	(α) = ANGLE	V = DIE OPENING	R = RADIUS	K = WEAR PARTS

415 mm | 835 mm



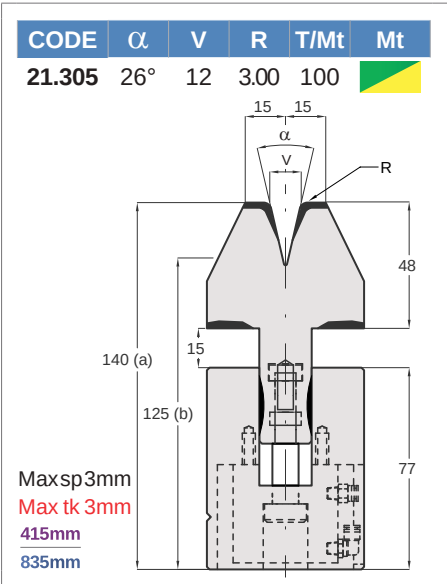
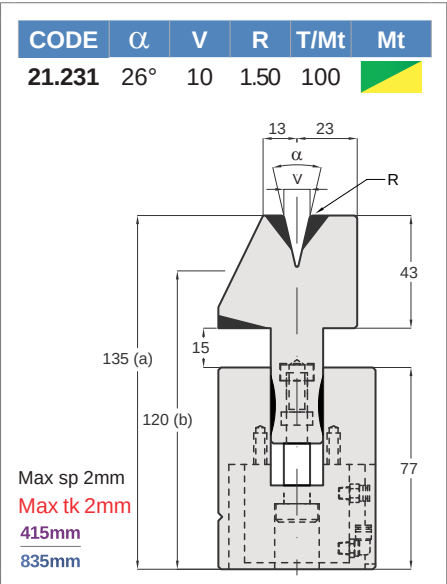
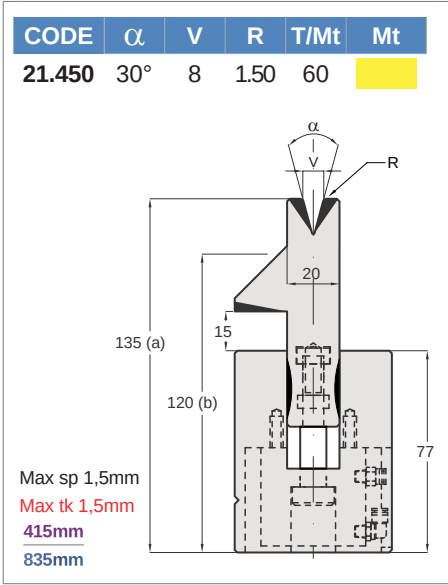
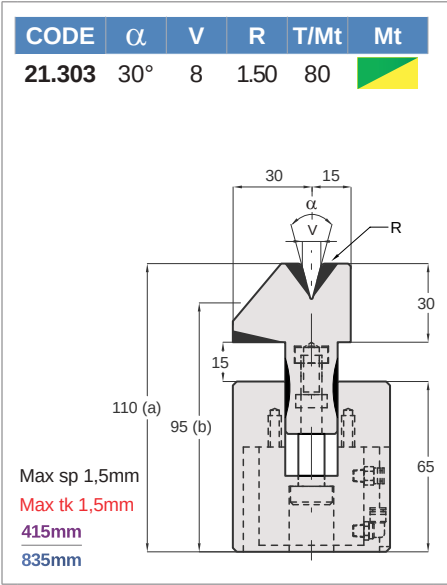
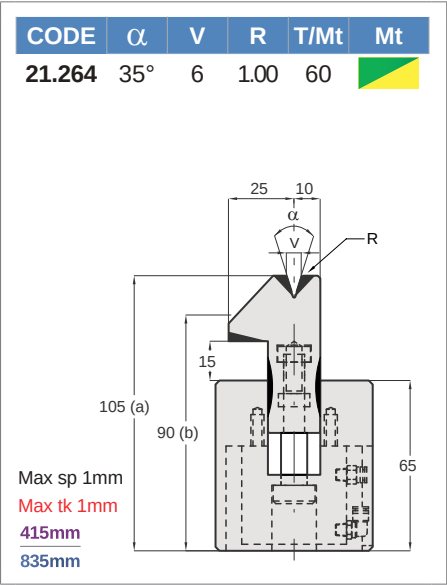
MATRICI PIEGASCHIACCIA PNEUMATICHE / PNEUMATIC HEMMING DIES **AMADA STYLE**

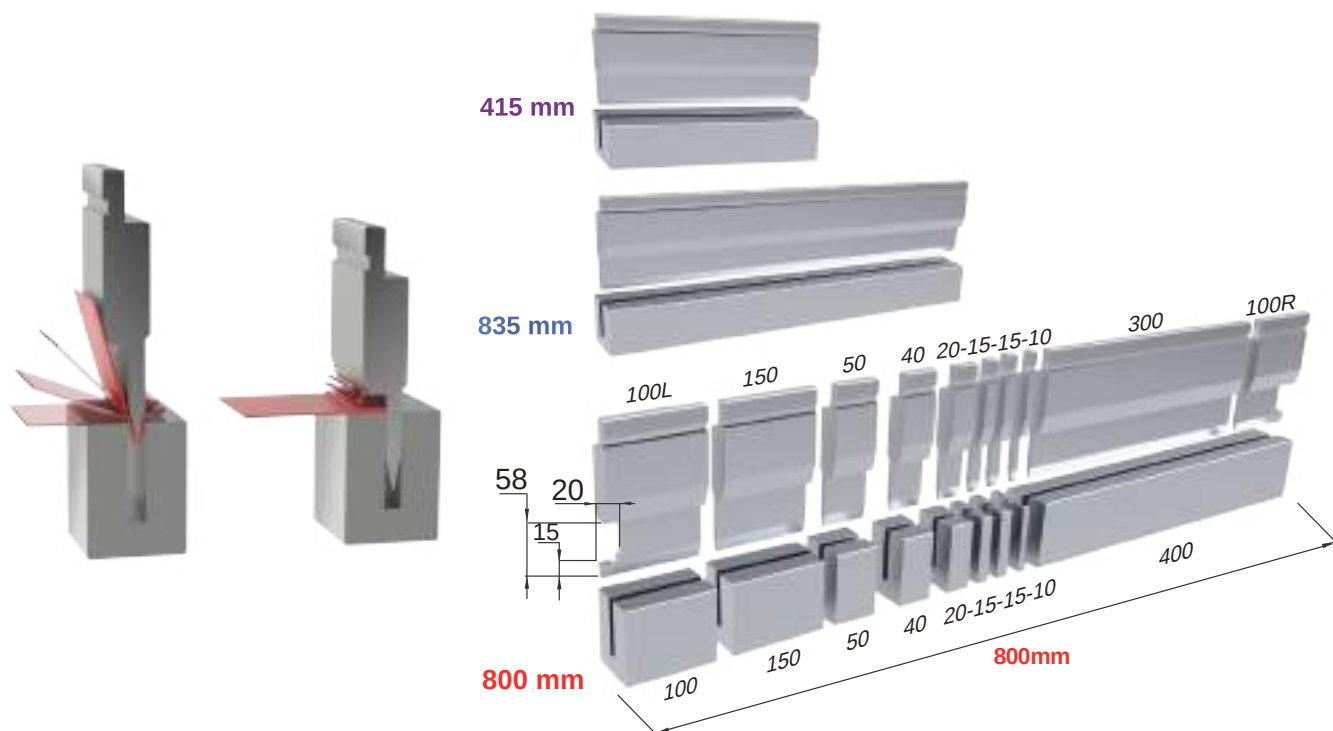
- I PIEGASCHIACCIA PNEUMATICI SONO EQUIPAGGIATI CON CILINDRI AD ARIA, RICAVANDONE I SEGUENTI VANTAGGI:
- A) RECUPERO DI 15 MM DI LUCE E DI CORSA CON CONSEGUENTE RIDUZIONE DEI TEMPI DI LAVORAZIONE.
 - B) MAGGIOR PRECISIONE DI PIEGA
 - C) MINOR USURA DEGLI UTENSILI
 - D) COLLEGAMENTO AL CNC



PNEUMATIC FLATTENING DIES ARE EQUIPPED WITH AIR CYLINDERS, GETTING THE FOLLOWING BENEFITS:

- A) SAVING 15 MM LIGHT AND STROKE WITH REDUCTION OF WORKING TIME.
- B) MORE PRECISE BENDING
- C) LESS WEAR
- D) CONNETTABLE TO EXISTING FREE CONTROL-OUTPUT I/O





IL CARICO MASSIMO DELLE SCARPETTE CORRISPONDE AL 50% DEL CARICO MASSIMO INDICATO SUL PUNZONE.
THE MAX LOAD OF THE HORN EXTENSIONS IS 50% OF THE MAX LOAD OF THE PUNCH.

MATERIAL ACC.R ~ 40 Kg/MM ²				
S (mm)	(t/m)	T (mm)	(t/m)	2S(mm)
0,6	9	3	23	1,2
0,8	12	3	32	1,6
1,0	15	3,5	40	2,0
1,25	17	3,5	50	2,5
1,5	22	4,6	63	3,0
2,0	30	5,5	80	4,0
2,5	55	6,5	90	5,0
3,0	70	8,0	100	6,0

MATERIAL ACC.R ~ 70 Kg/MM ²				
S (mm)	(t/m)	T (mm)	(t/m)	2S(mm)
0,6	15	3	35	1,2
0,8	20	3	50	1,6
1,0	25	3,5	60	2,0
1,25	26	3,5	80	2,5
1,5	38	4,6	95	3,0
2,0	50	5,5	130	4,0



