



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

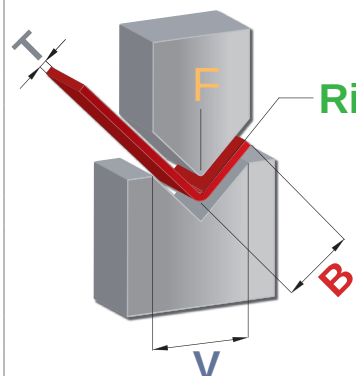


TABELLA DI PIEGATURA / BENDING CHART

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.

WILA STYLE

PUNZONI PUNCHES

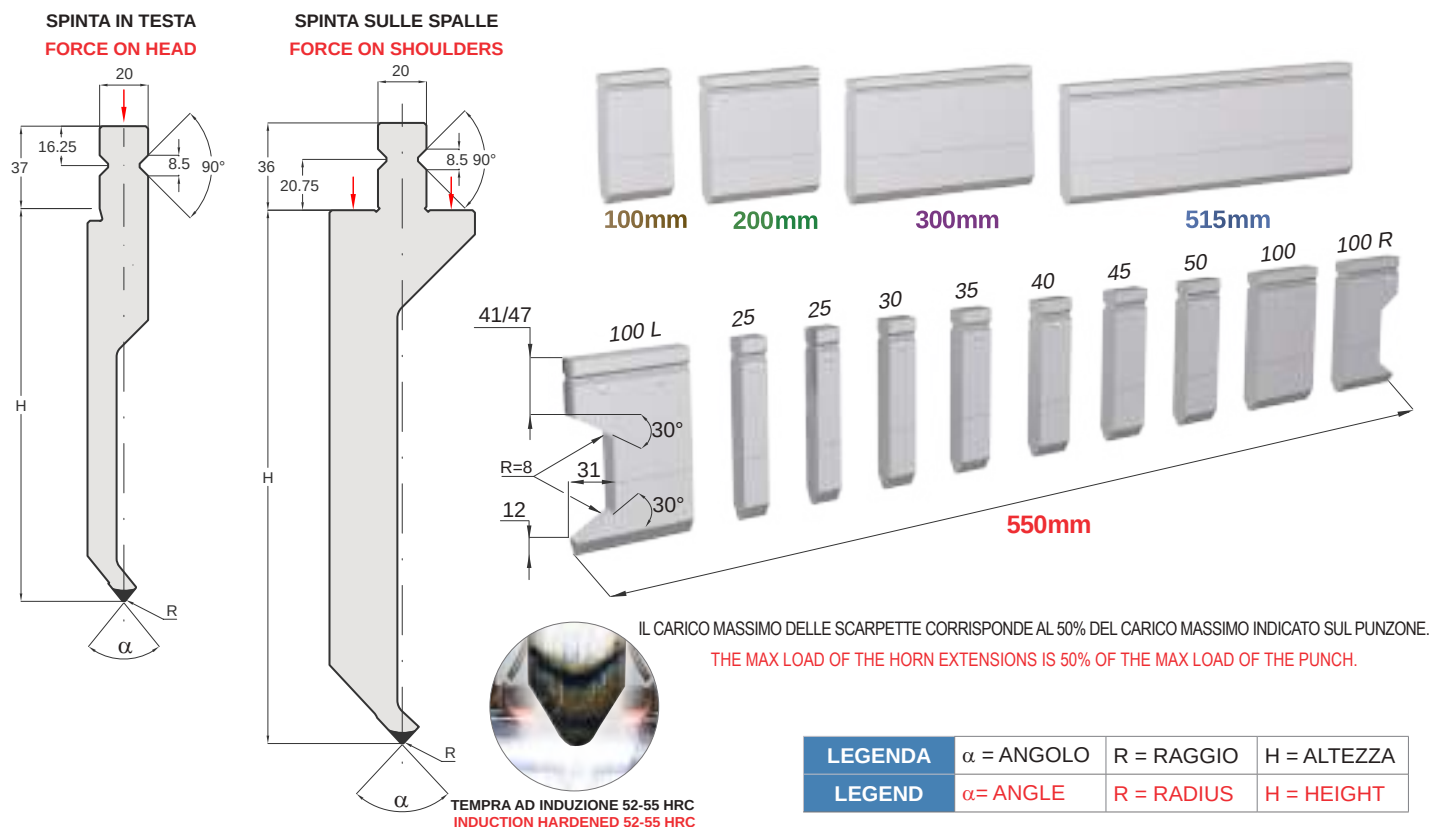


PLATINUM LINE

WILA STYLE

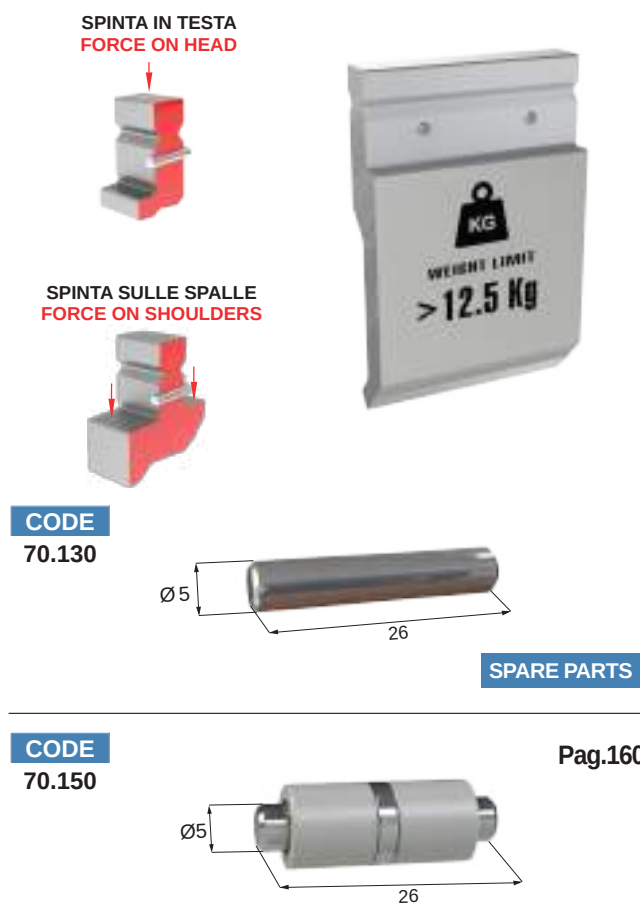


PUNZONI / PUNCHES WILA STYLE



I PUNZONI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 100 / 200 / 300 mm - 515 mm E FRAZIONATI (550 mm)
THE PUNCHES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 100 / 200 / 300 mm - 515 mm AND SECTIONED (550 mm)

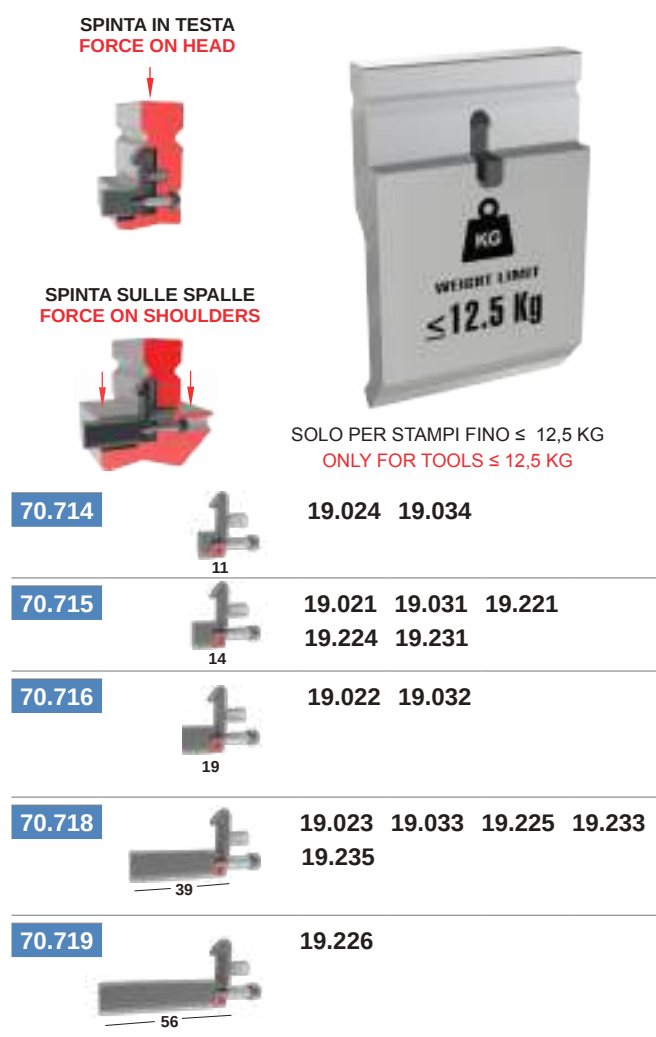
MONTAGGIO E SMONTAGGIO LATERALE DEGLI UTENSILI SIDE INSTALLATION AND DISINSTALLATION OF TOOLS

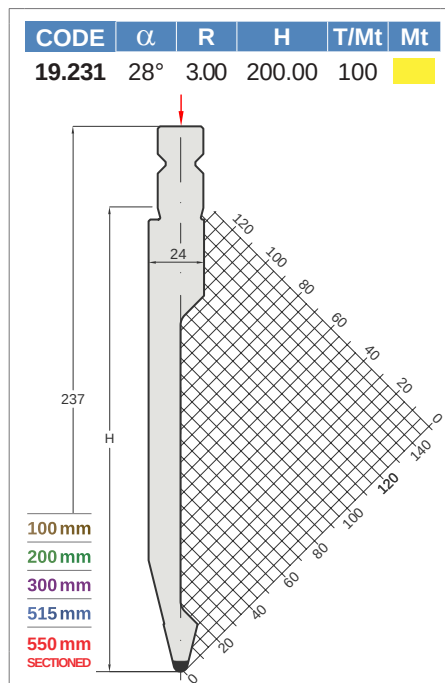
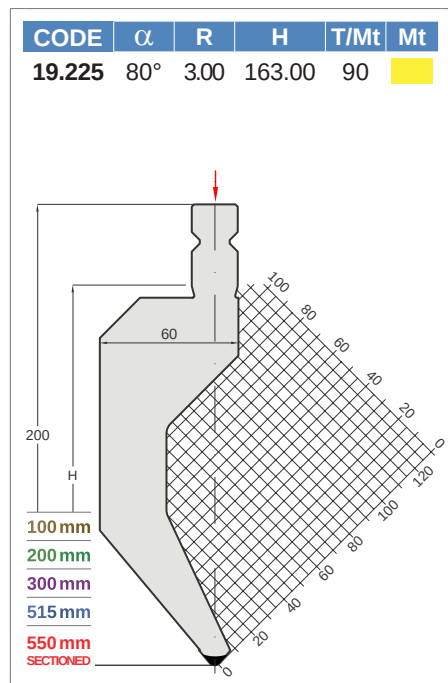
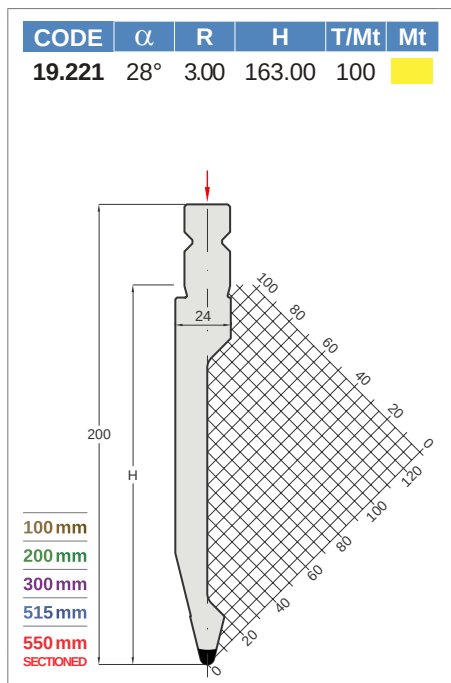
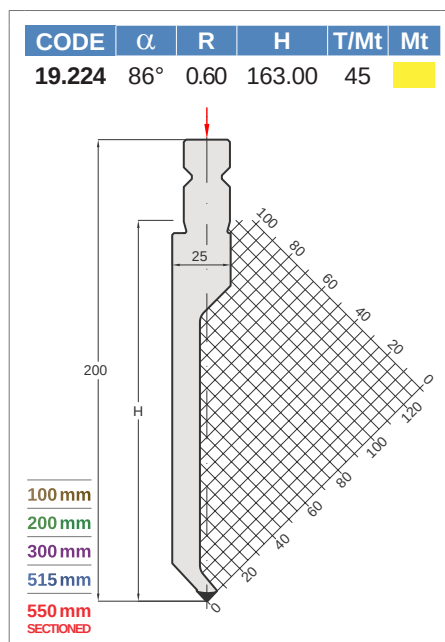
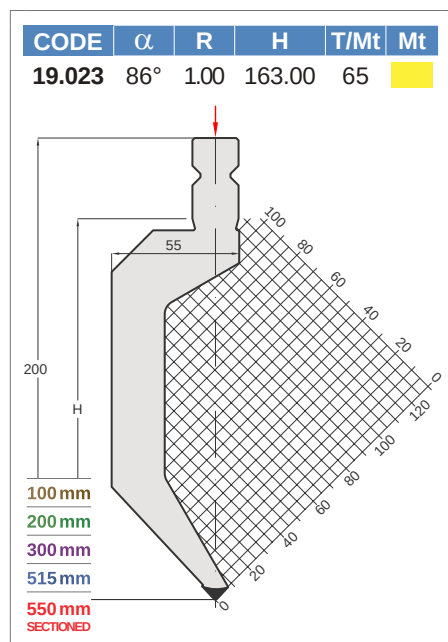
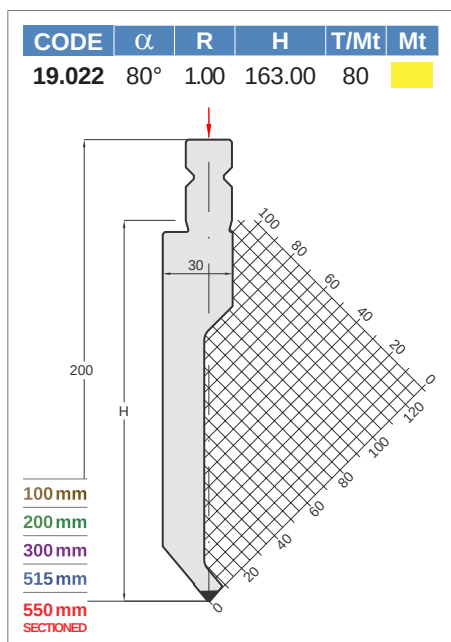
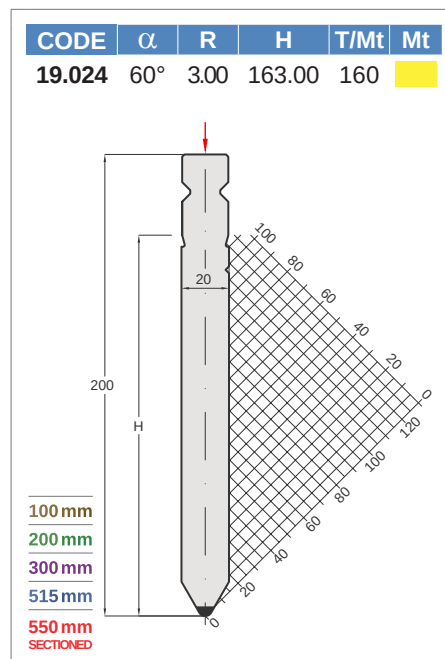
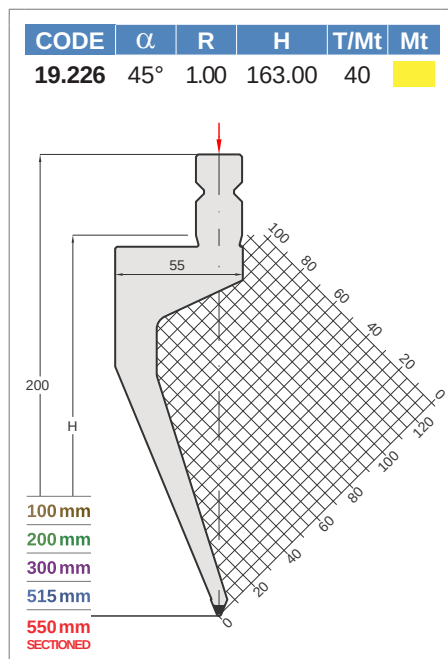
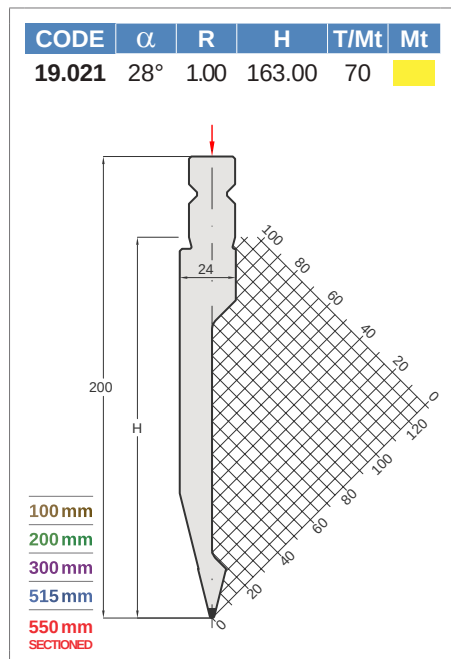


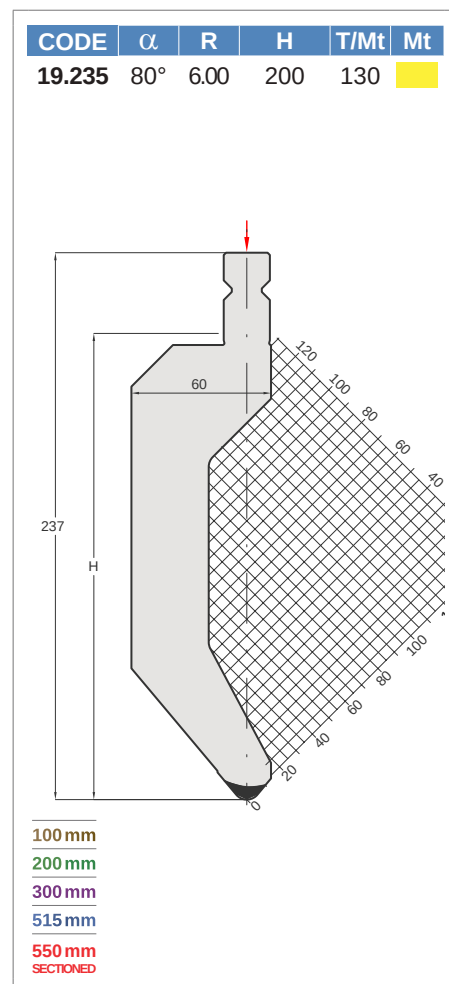
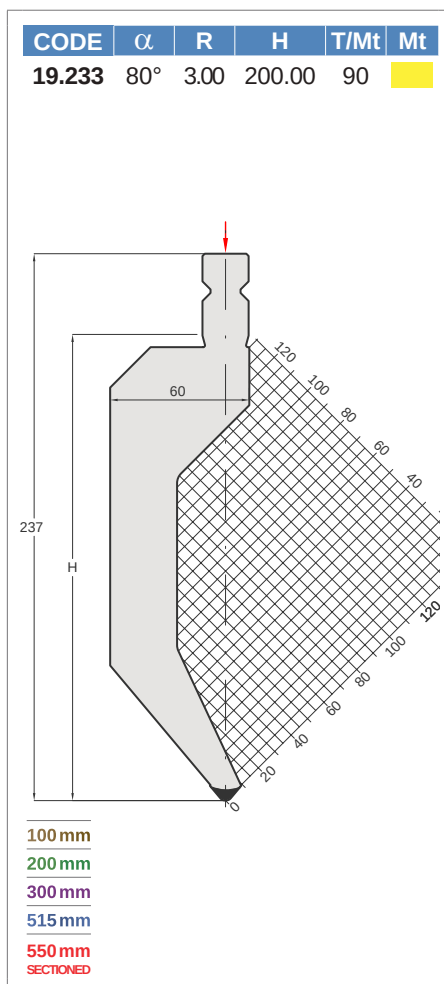
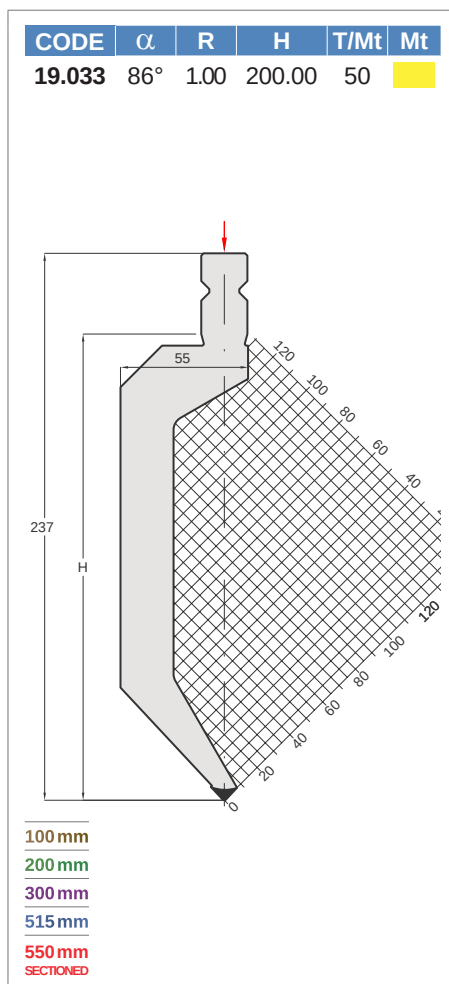
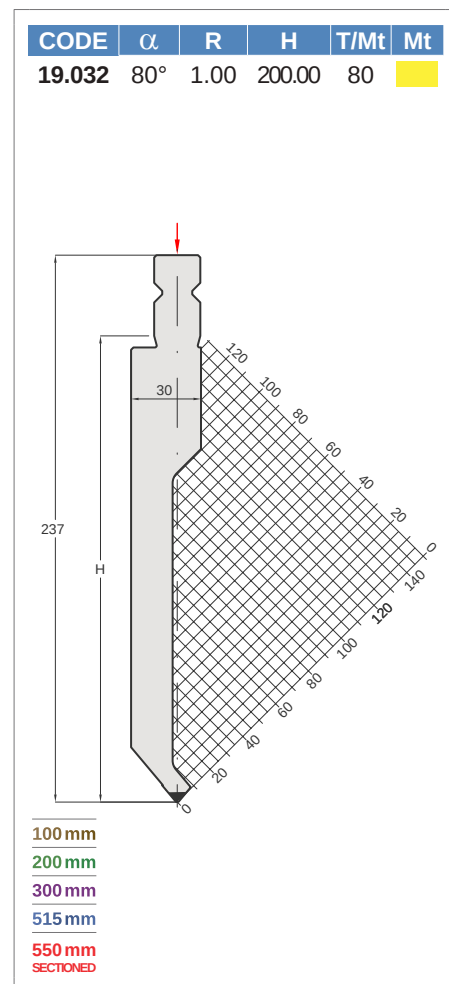
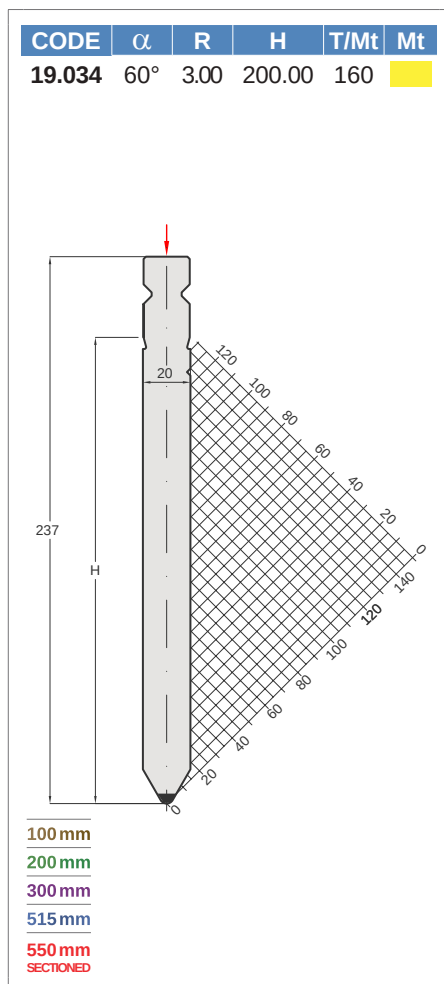
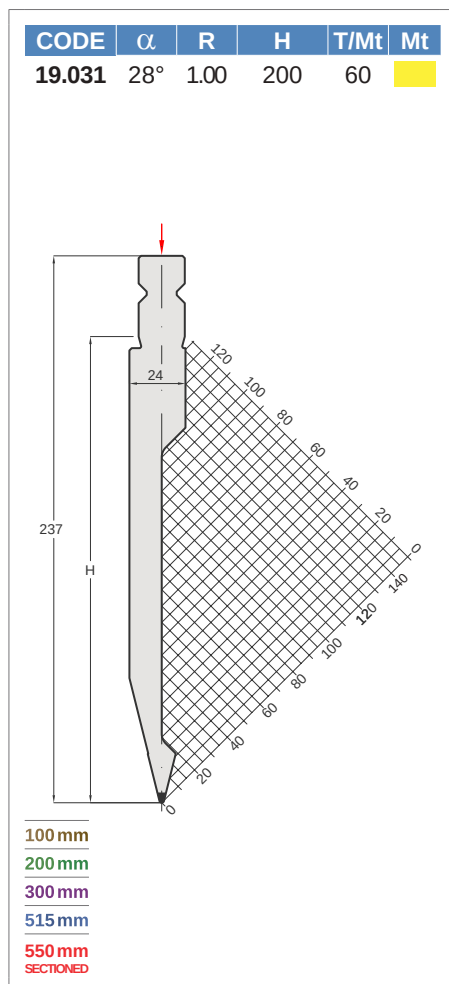
Pag.160

I PUNZONI POSSONO ESSERE FORNITI CON SPINA ROTANTE SU CUSCINETTI - SOLO SU RICHIESTA
PUNCHES CAN BE SUPPLIED WITH ROLL PIN ON BEARINGS - ONLY ON REQUEST

MONTAGGIO E SMONTAGGIO FRONTALE DEGLI UTENSILI FRONT INSTALLATION AND DISINSTALLATION OF TOOLS

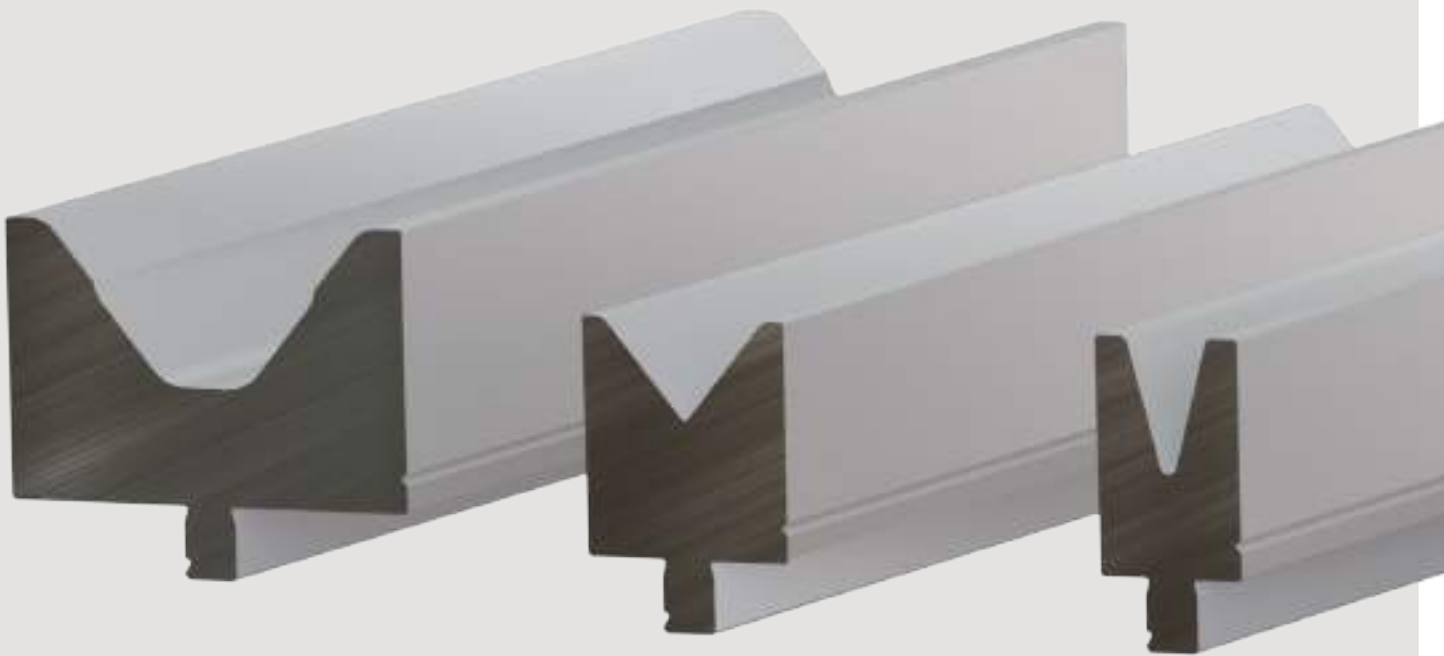






WILA STYLE

MATRICI DIES

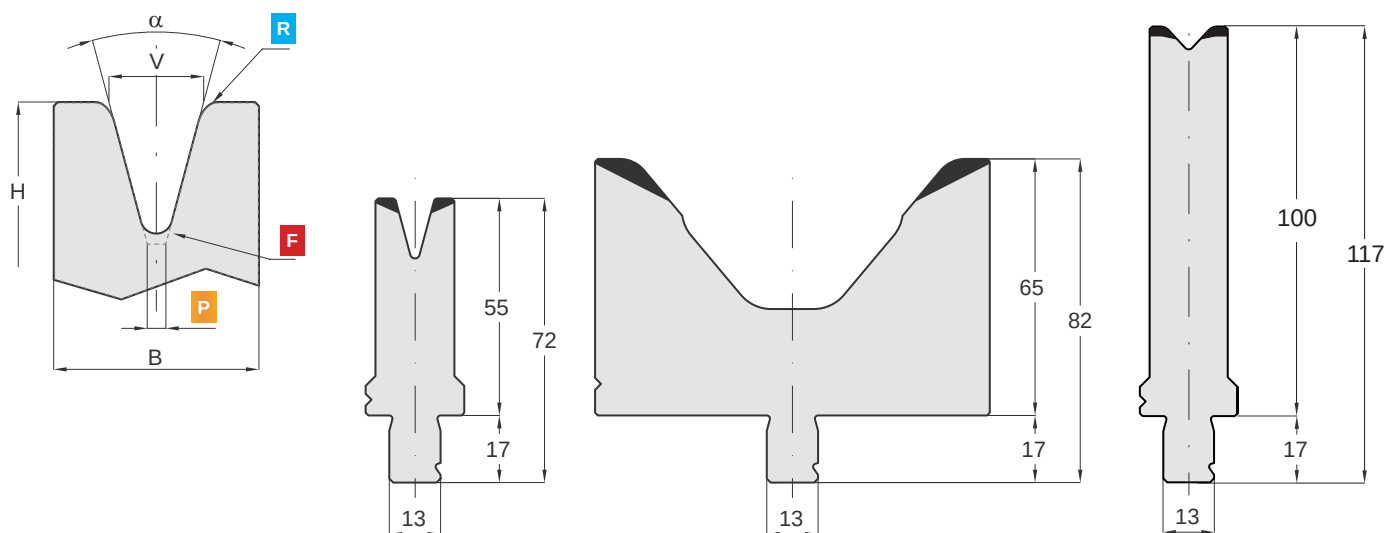


PLATINUM LINE

WILA STYLE



MATRICI / DIES WILA STYLE



100 mm | 200 mm | 300 mm | 515 mm | 550 mm SECTIONED

LE MATRICI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 100 / 200 / 300 mm - 515 mm E FRAZIONATI (550 mm)
THE DIES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 100 / 200 / 300 mm - 515 mm AND SECTIONED (550 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 DIE	P = FLAT	B = WIDTH

100mm



200mm



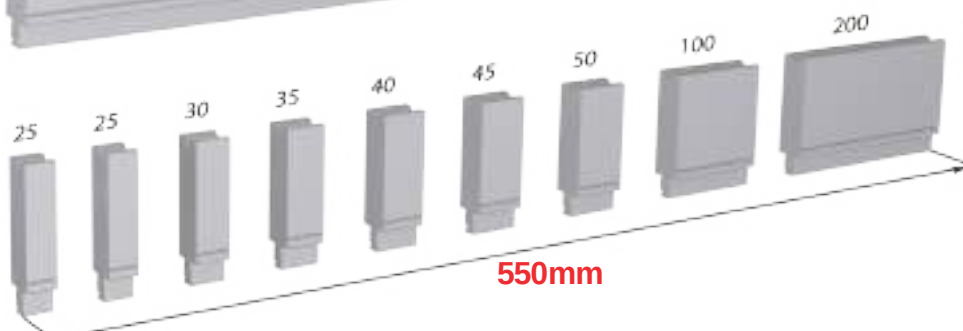
300mm



515mm



550mm

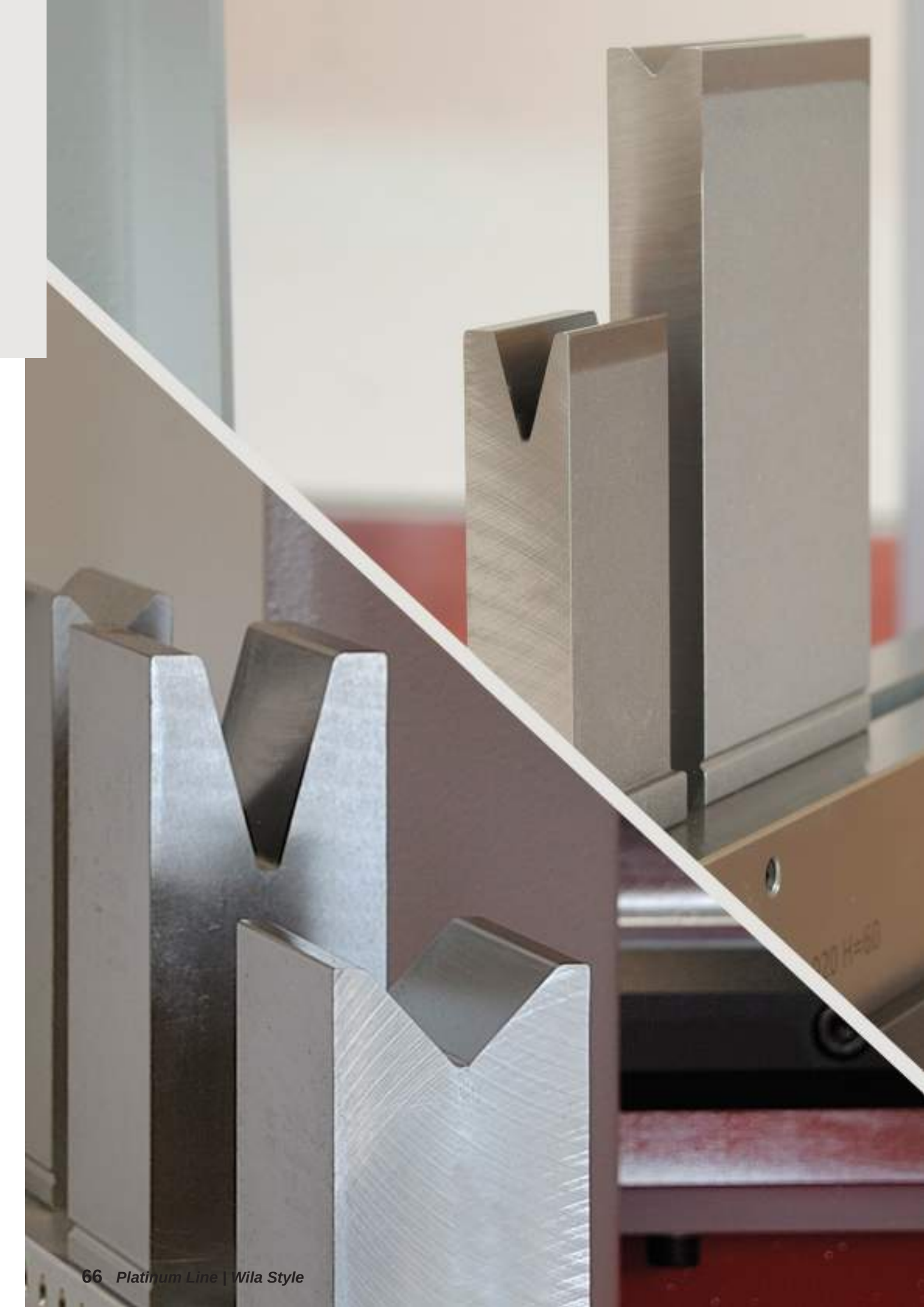


TEMPRA AD INDUZIONE 52-55 HRC
INDUCTION HARDENED 52-55 HRC

MATRICI / DIES WILA STYLE H=55 / 65 / 100

CODE	α	V	R	H	B	T	F	T/mt	Mt
29.524	86°	4	0.40	55	10	25	R0.6	45	
29.521	86°	6	1.00	55	16	25	R0.8	120	
29.510	86°	8	1.00	55	16	25	R0.8	120	
29.522	86°	10	1.00	55	20	25	R1.0	120	
29.511	86°	12	1.00	55	20	25	R1.2	120	
29.512	86°	16	1.50	55	25	25	R1.2	120	
29.523	86°	20	2.00	55	30	30	R1.2	120	
29.513	80°	24	2.50	55	35	35	R1.2	125	
29.514	80°	30	3.00	55	40	40	R1.2	125	
29.515	80°	40	4.00	55	50	50	R1.2	125	
29.535	80°	50	5.00	55	75	75	R6.0	150	
29.517	80°	80	8.00	65	100	100	P20.1	150	
29.561	30°	6	1.00	55	16	25	R1.0	80	
29.551	30°	8	1.00	55	16	25	R1.2	80	
29.562	30°	10	1.00	55	20	25	R1.2	80	
29.552	30°	12	1.00	55	20	25	R1.2	80	
29.553	30°	16	1.50	55	30	30	R1.2	80	
29.563	30°	20	2.00	55	35	35	R2.0	80	
29.554	30°	24	2.50	55	40	40	R4.5	80	
29.336	86°	4	0.80	100	10	25	R0.8	45	
29.321	86°	6	2.00	100	16	25	R0.8	120	
29.290	86°	8	2.50	100	16	25	R1.0	120	
29.322	86°	10	2.50	100	20	25	R1.2	120	
29.291	86°	12	3.00	100	20	25	R1.2	120	
29.292	86°	16	3.50	100	25	25	R1.2	120	
29.323	86°	20	4.00	100	30	30	R1.2	120	
29.293	80°	24	5.00	100	35	35	R1.2	125	
29.324	80°	30	6.00	100	40	40	R1.2	125	
29.325	80°	40	8.00	100	55	55	R1.2	125	
29.326	80°	50	10.00	100	65	65	R6.0	150	
29.297	80°	80	16.00	100	105	105	P20.1	150	
29.361	30°	6	2.00	100	16	25	R1.0	80	
29.351	30°	8	2.50	100	16	25	R1.0	80	
29.362	30°	10	2.50	100	20	25	R1.6	80	
29.352	30°	12	3.00	100	20	25	R1.2	80	
29.353	30°	16	3.50	100	30	30	R1.2	80	
29.363	30°	20	4.00	100	35	35	R2.0	80	
29.354	30°	24	5.00	100	40	40	R4.0	80	
29.330	30°	50	10.00	100	80	80	P22.7	150	





WILA STYLE

PIEGASCHIACCIA

HEMMING TOOLS

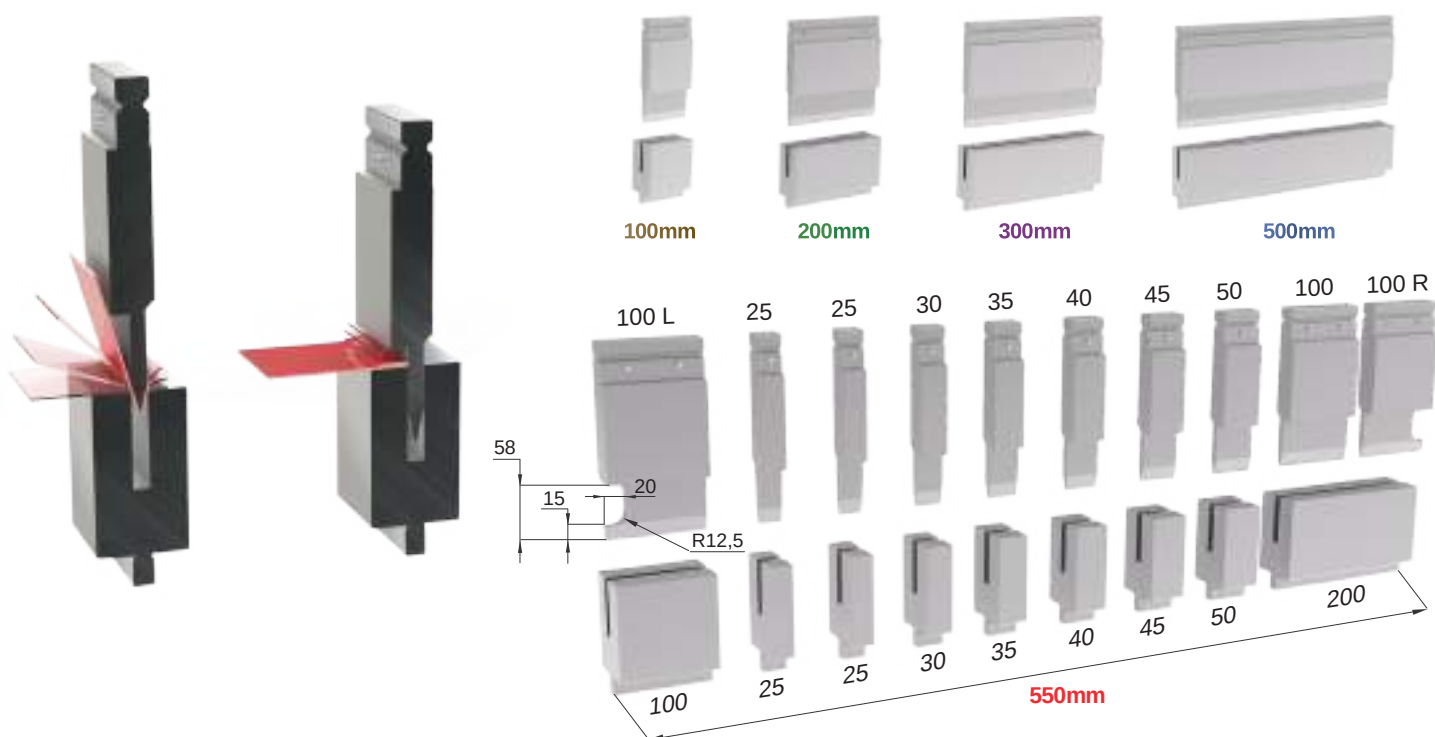


PLATINUM LINE

WILA STYLE



PIEGASCHIACCIA / HEMMING TOOLS WILA STYLE



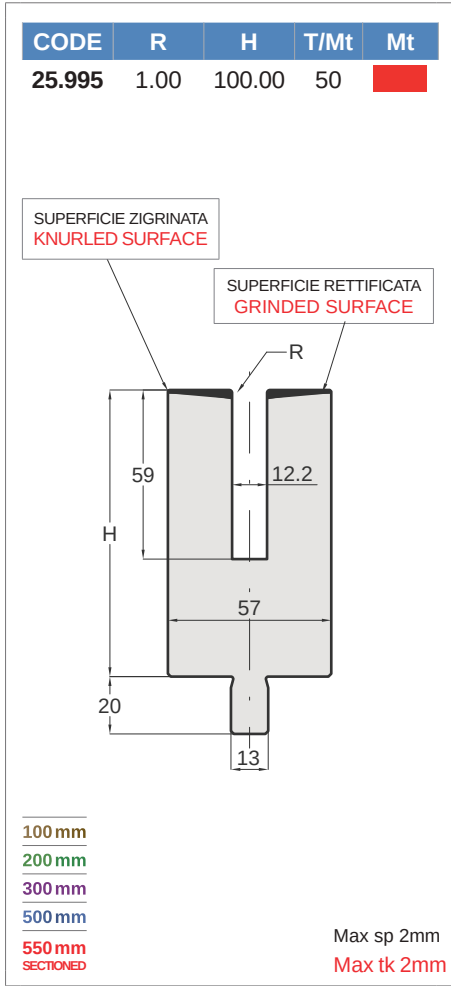
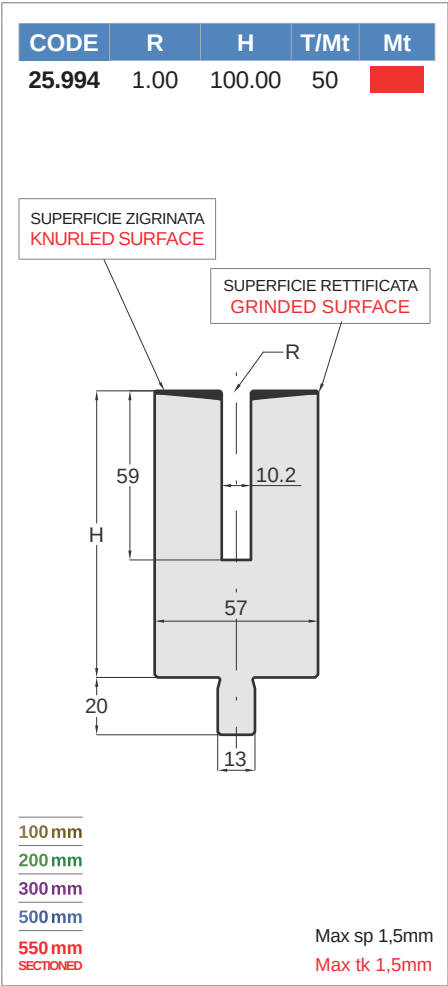
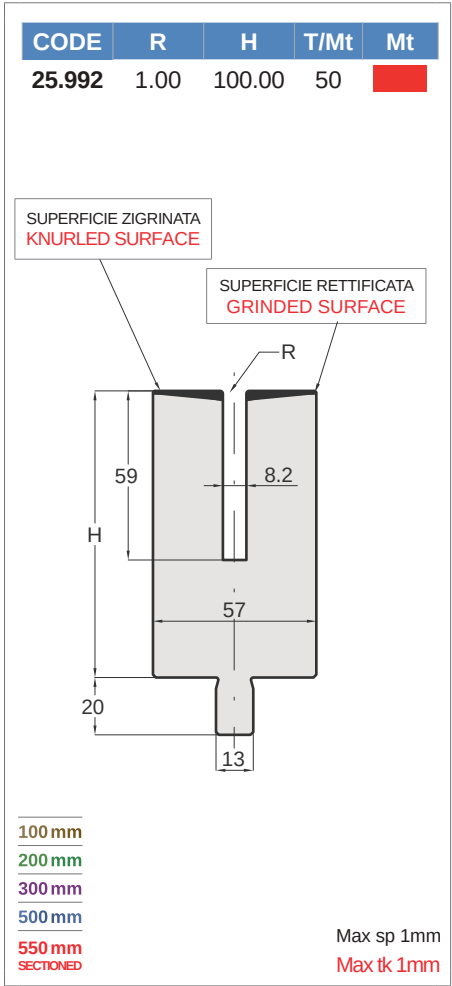
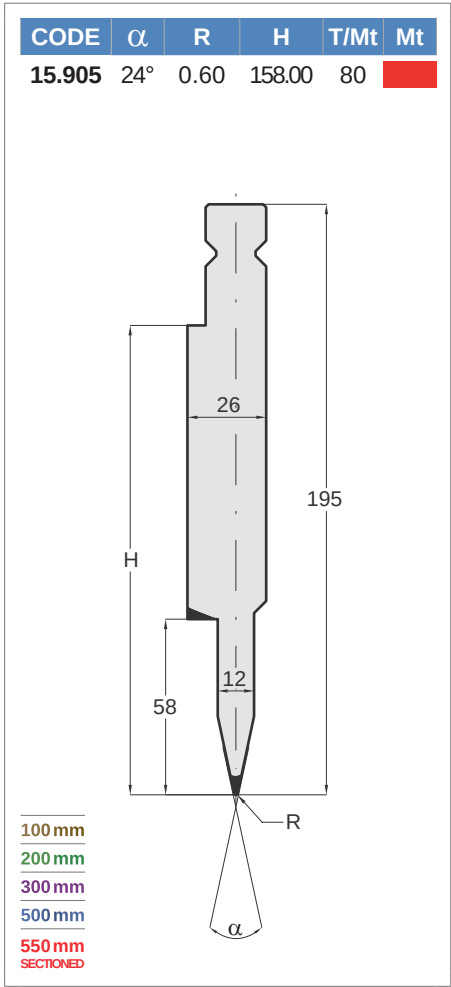
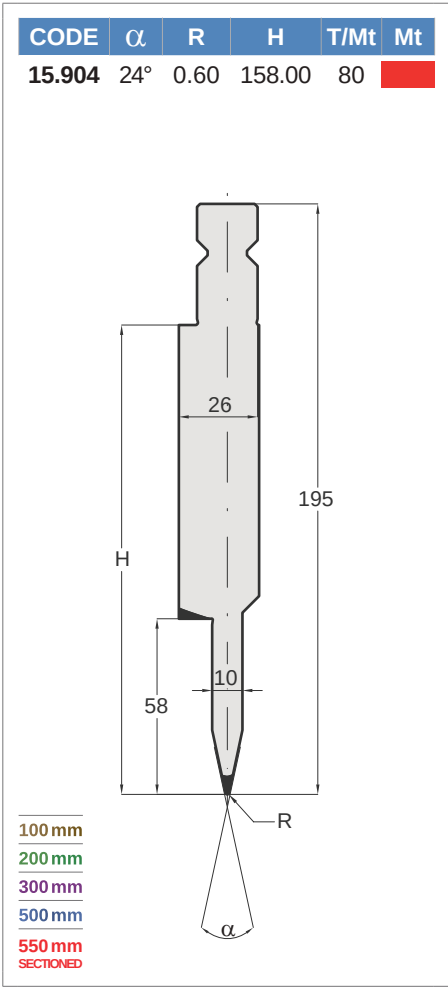
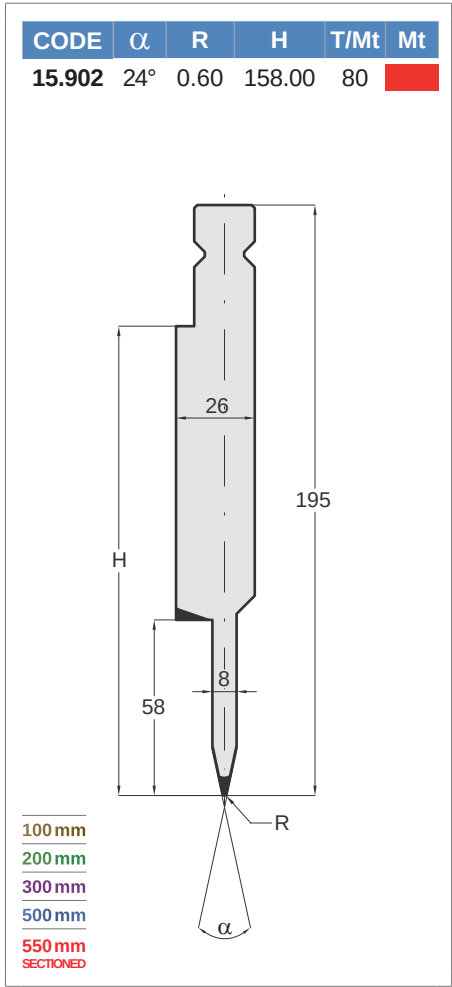
100 mm | 200 mm | 300 mm | 500 mm | 550 mm SECTIONED

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





SCHIACCIATORE / HEMMING TOOL WILA STYLE

CODE	H	T/Mt	Mt
19.041	120.00	120	

FRAZIONATO SENZA SCARPETTE
SECTIONED WITHOUT HORNS

100 mm
200 mm
300 mm
515 mm
550 mm
SECTIONED

CODE	H	T/Mt	Mt
29.384	100.00	100	

100 mm
200 mm
300 mm
515 mm
550 mm
SECTIONED

