



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

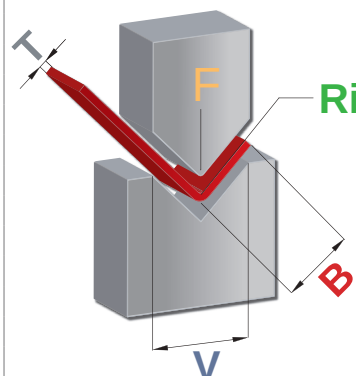


TABELLA DI PIEGATURA / BENDING CHART

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.

BYSTRONIC - BEYELER STYLE

PUNZONI
PUNCHES



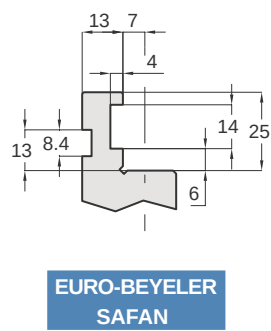
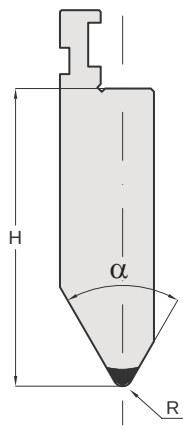
ORANGE LINE

BYSTRONIC - BEYELER STYLE



PUNZONI / PUNCHES **EURO - BYSTRONIC - BEYELER STYLE**

I PUNZONI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 100 / 200 / 300 mm - 500 mm E FRAZIONATI (550 mm)
THE PUNCHES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 100 / 200 / 300 mm - 500 mm AND SECTIONED (550 mm)



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

100mm

200mm

300mm

500mm

550mm

100 L 25 25 30 35 40 45 50 100 100 R

R25 20 10

550mm 550mm

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
14.040	86°	1.00	95.00	75	■

100 mm
200 mm
300 mm
500 mm
550 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
14.020	80°	1.00	95.00	75	■

100 mm
200 mm
300 mm
500 mm
550 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
14.010	60°	3.00	95.00	100	■

100 mm
200 mm
300 mm
500 mm
550 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
14.030	28°	1.00	95.00	70	■

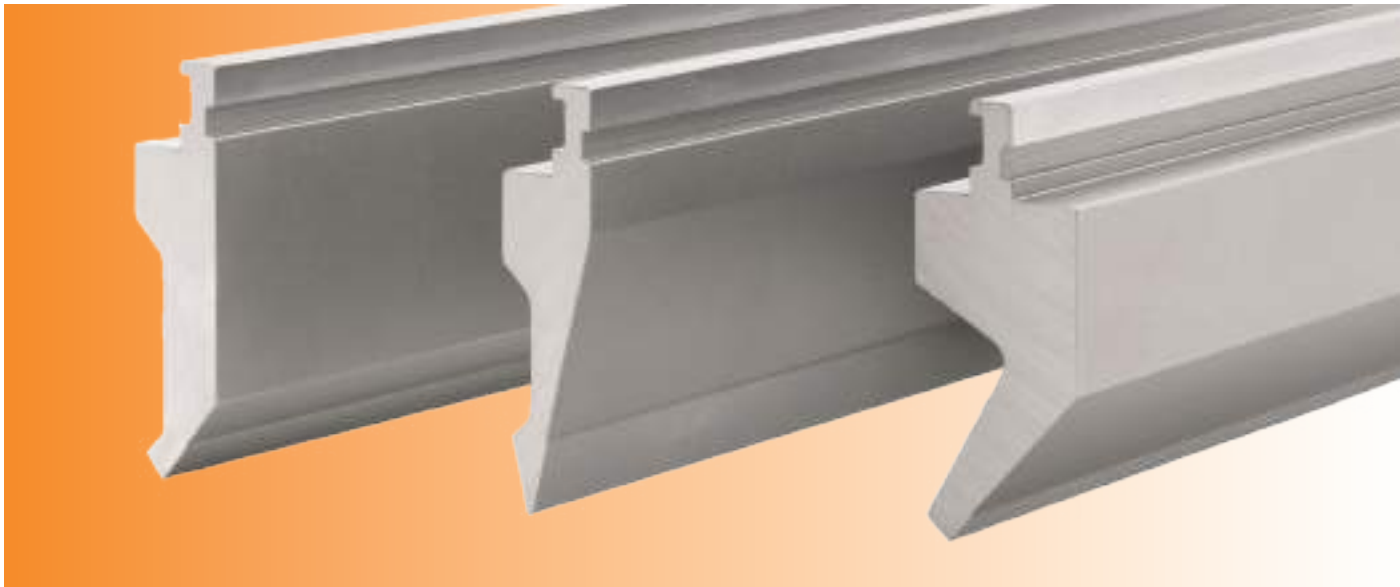
100 mm
200 mm
300 mm
500 mm
550 mm
SECTIONED

CODE	α	R	H	T/Mt	Mt
14.060	80°	1.00	175.00	80	■

100 mm
200 mm
300 mm
500 mm
550 mm
SECTIONED

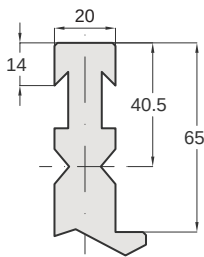
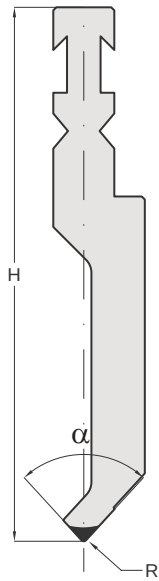
CODE	α	R	H	T/Mt	Mt
14.050	28°	1.00	175.00	100	■

100 mm
200 mm
300 mm
500 mm
550 mm
SECTIONED



PUNZONI / PUNCHES *BYSTRONIC - BEYELER RF-A 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)

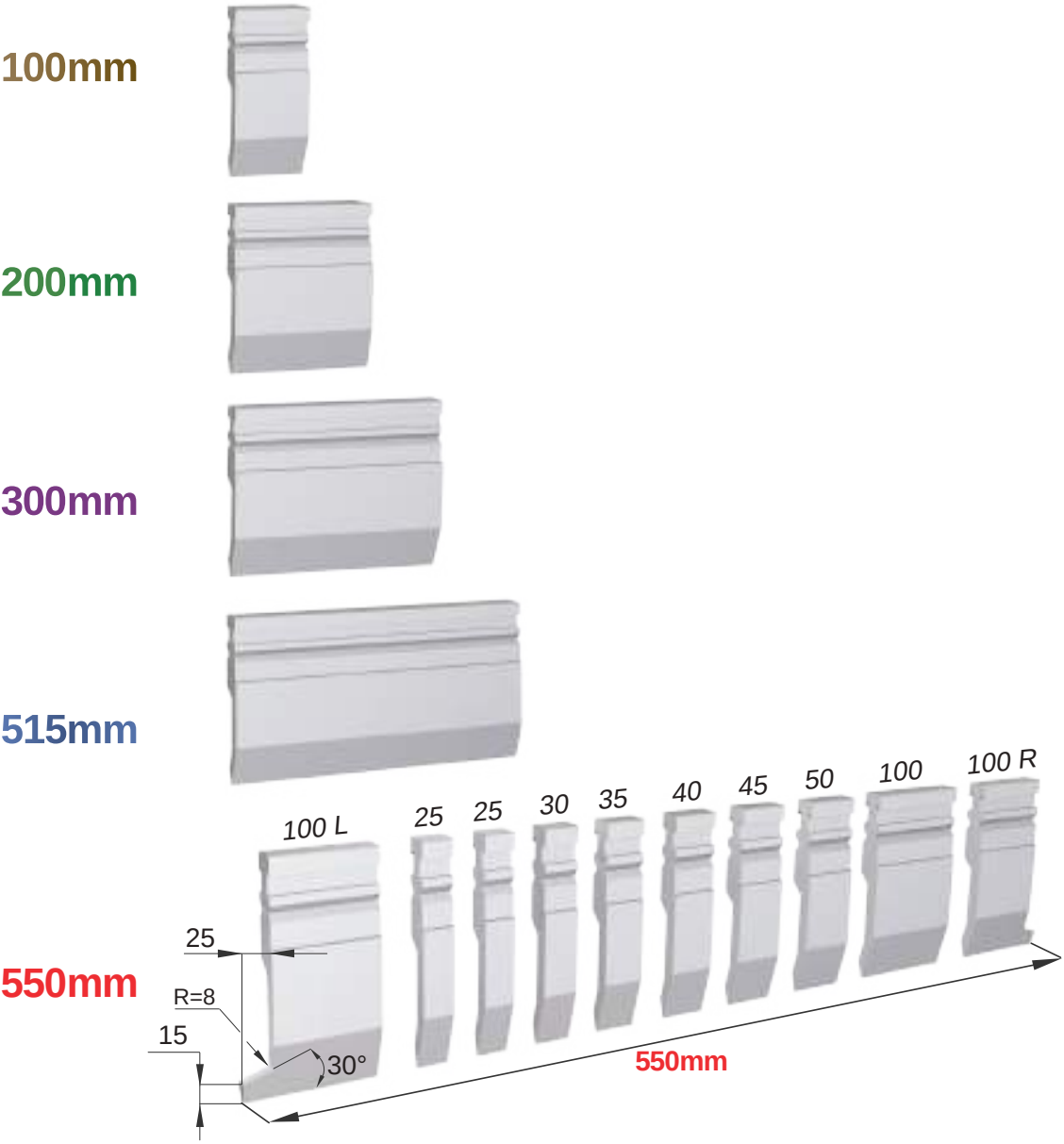


BEYELER RF-A

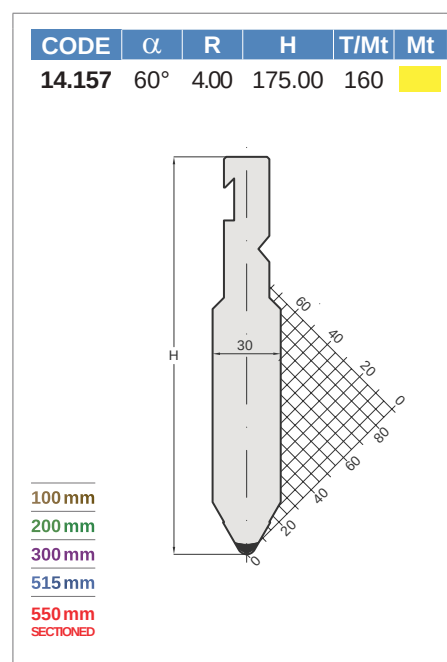
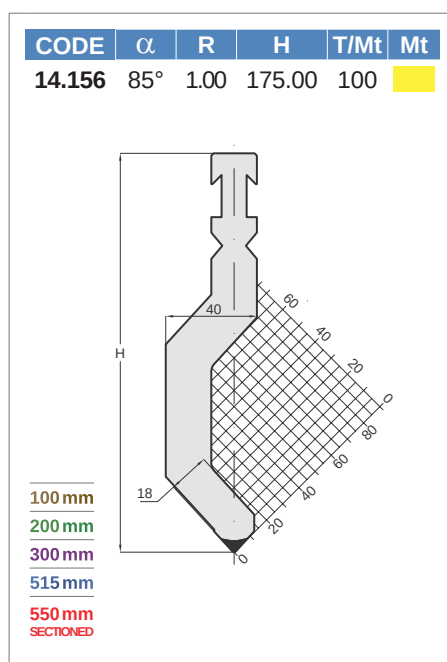
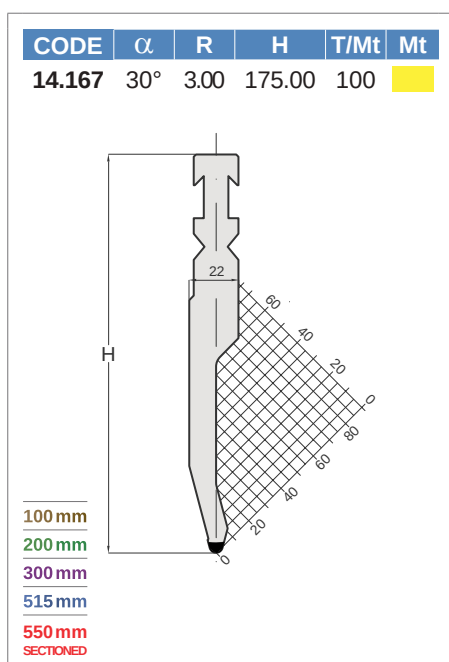
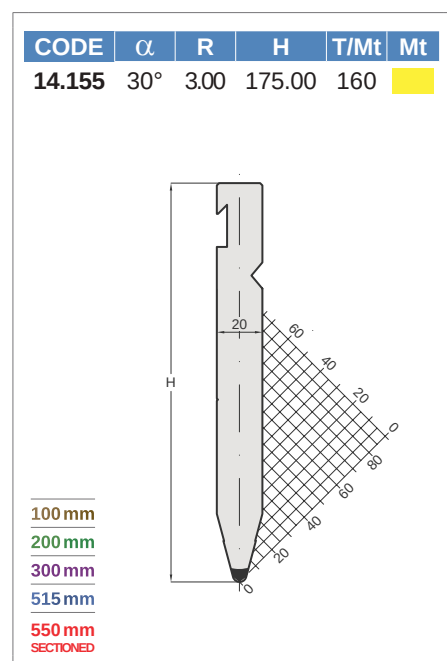
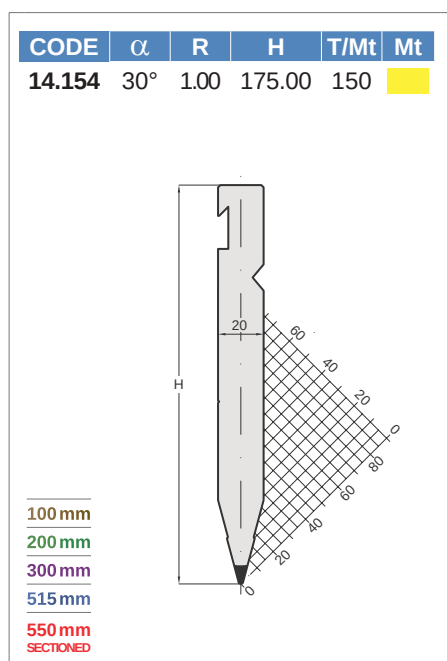
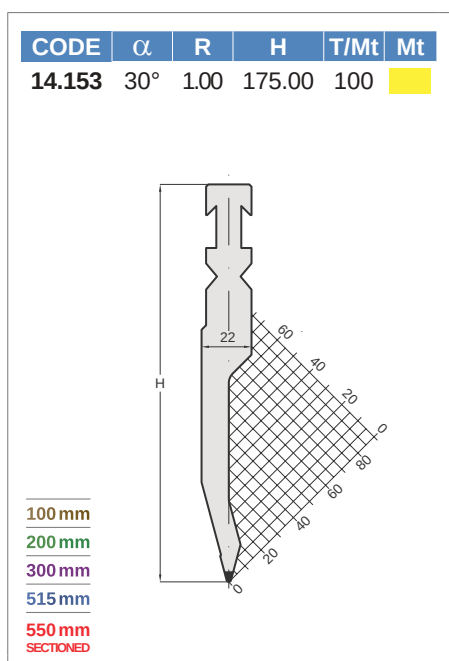
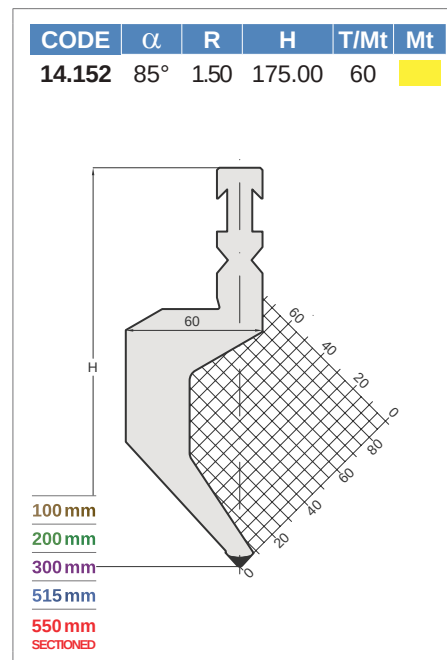
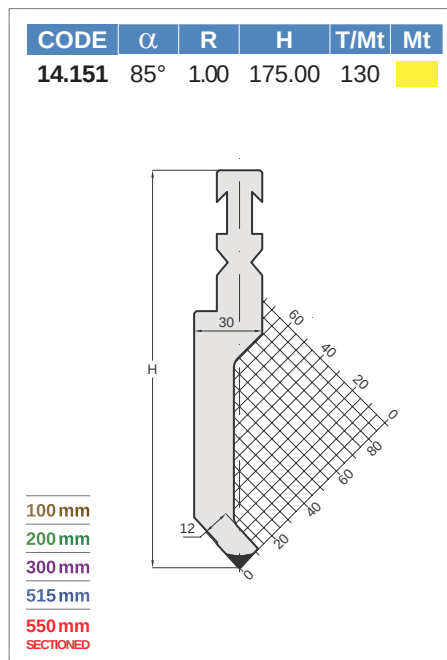
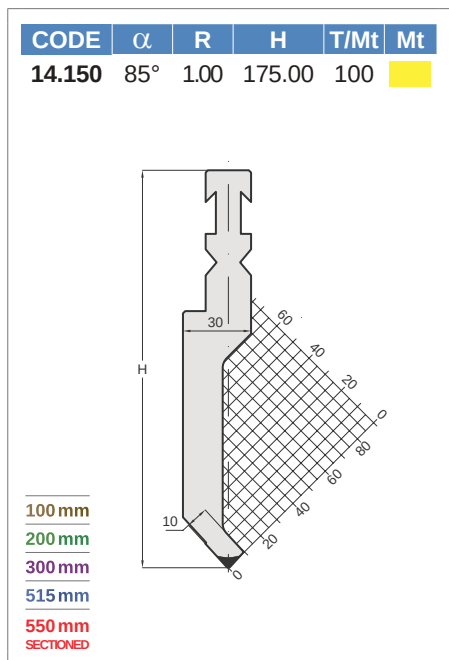


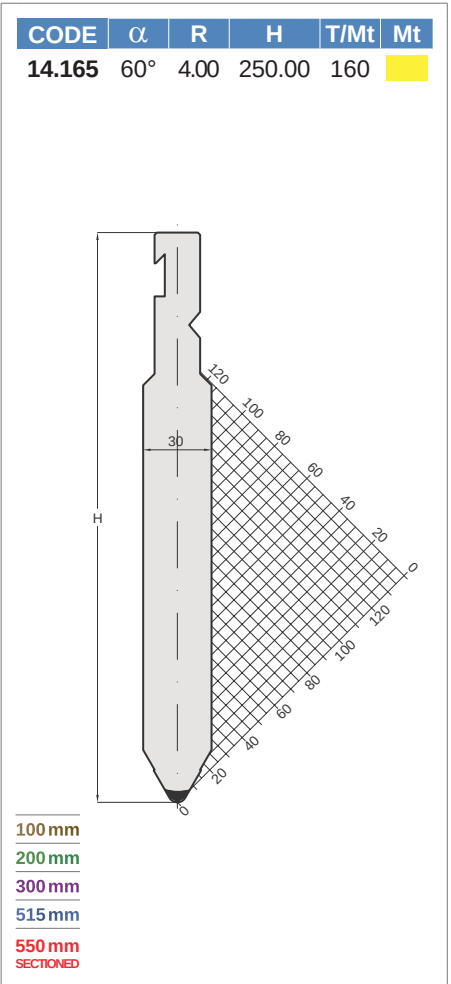
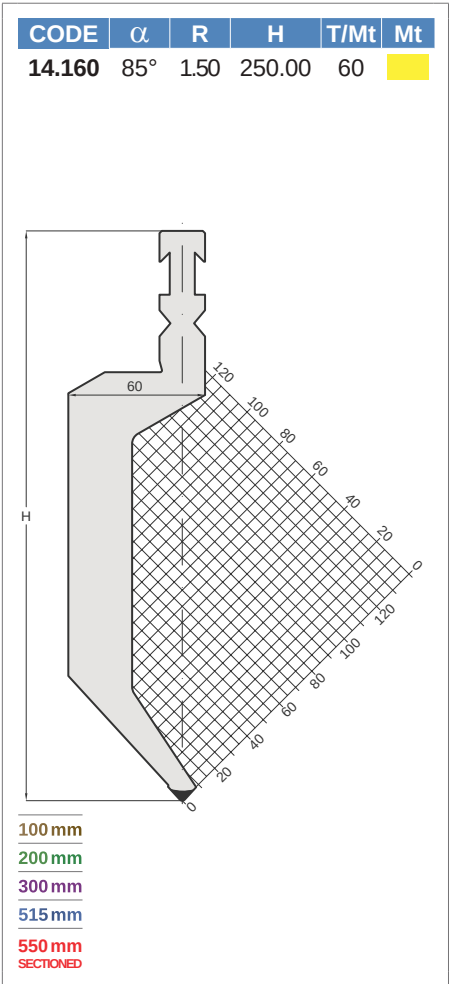
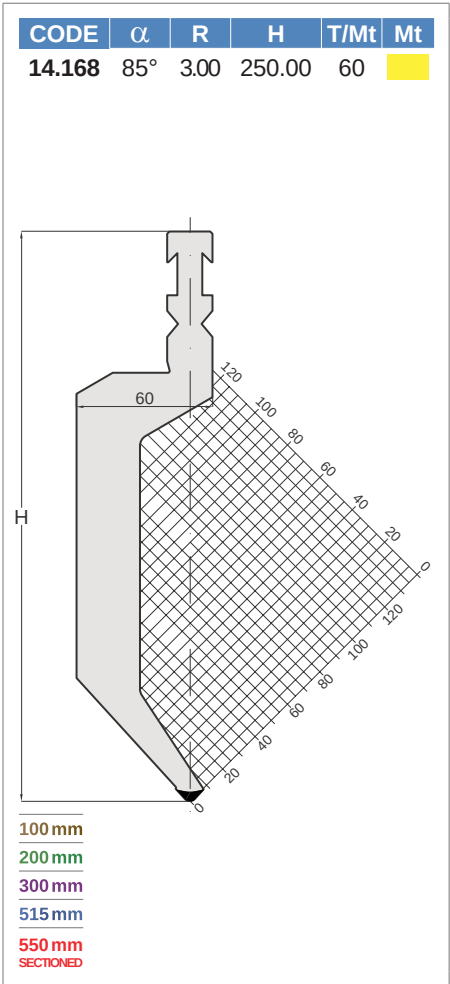
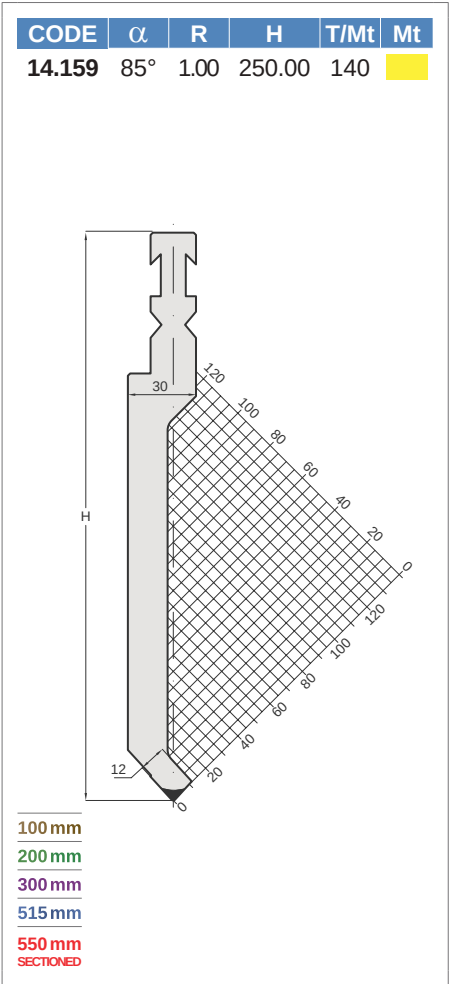
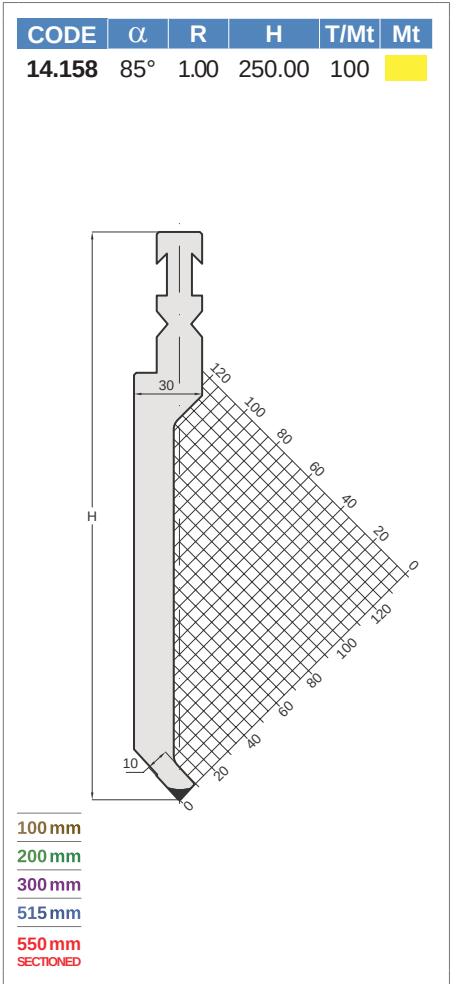
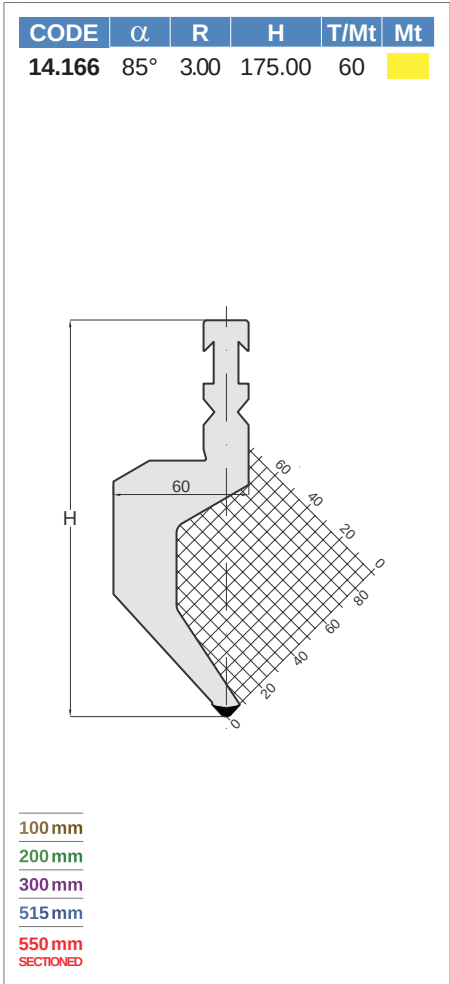
TEMPRA AD INDUZIONE 52-55 HRC
INDUCTION HARDENED 52-55 HRC

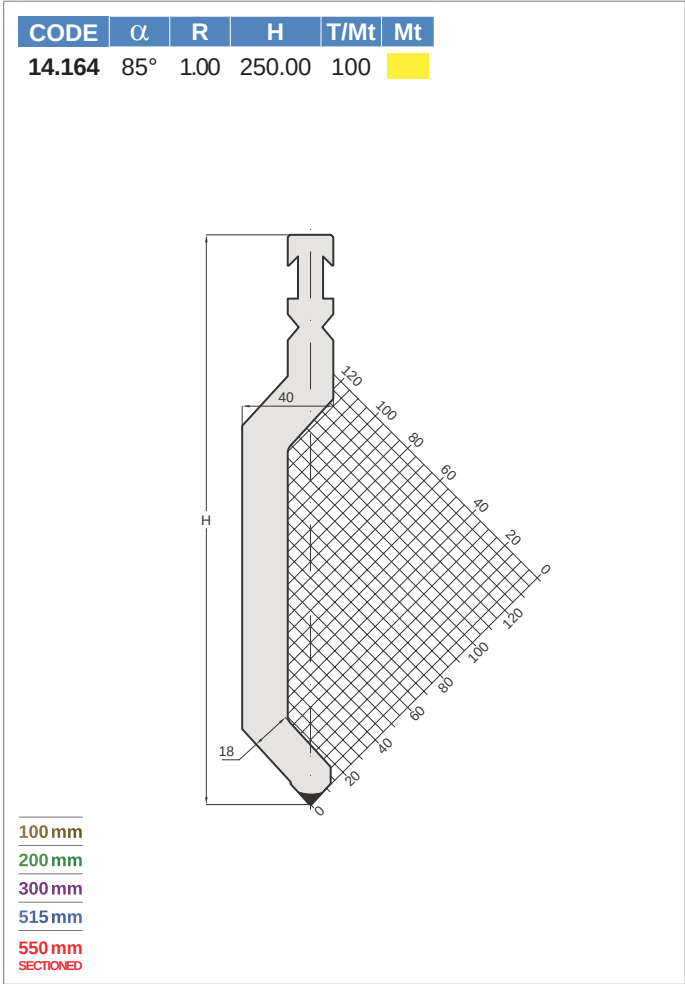
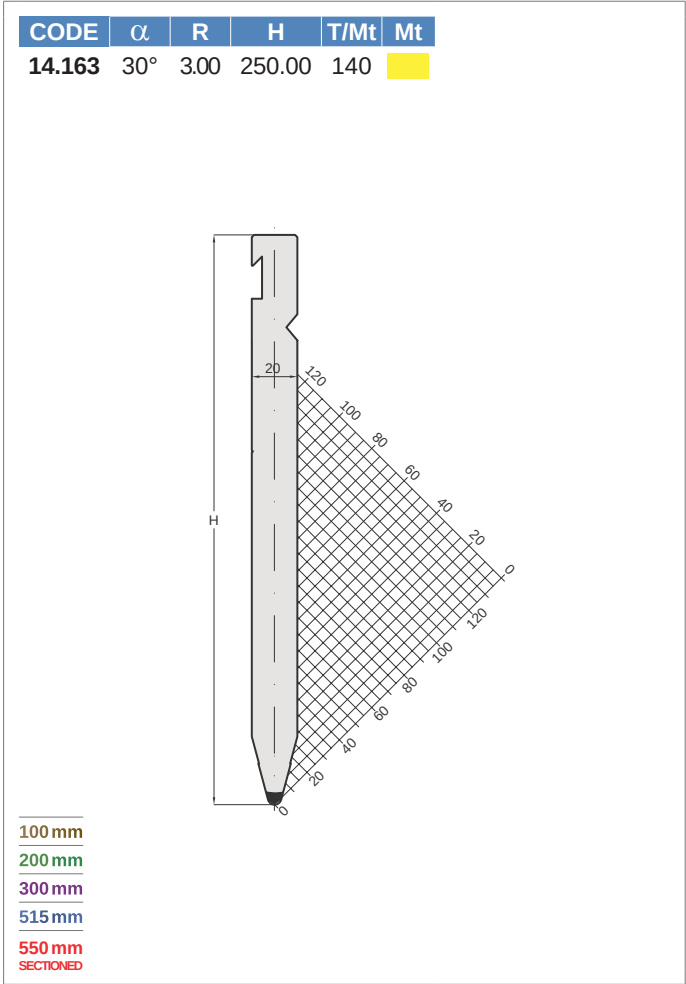
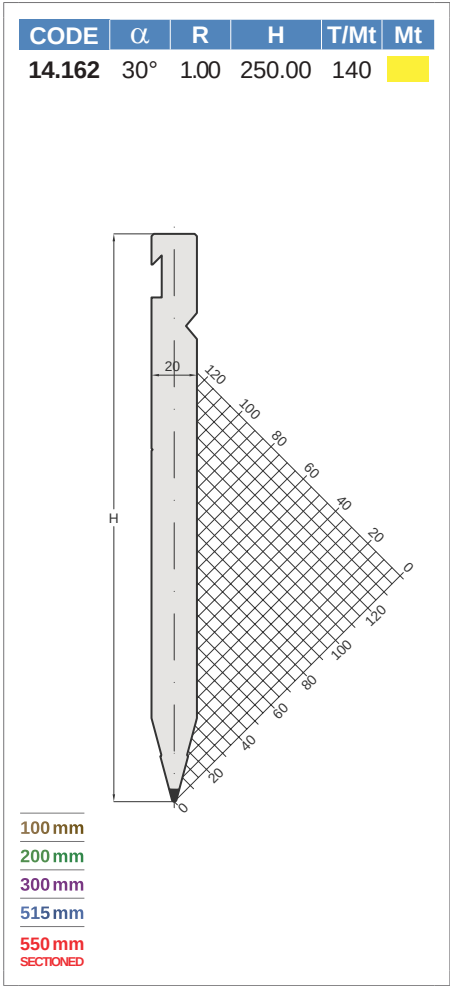
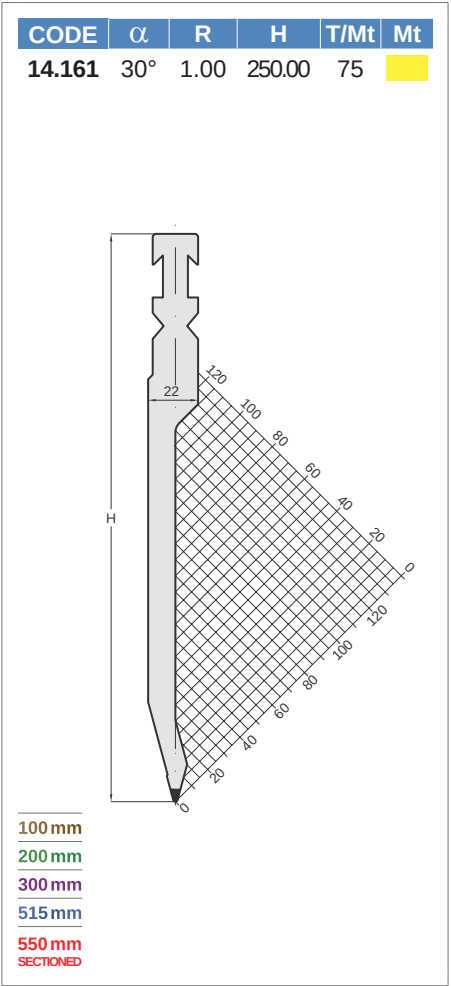
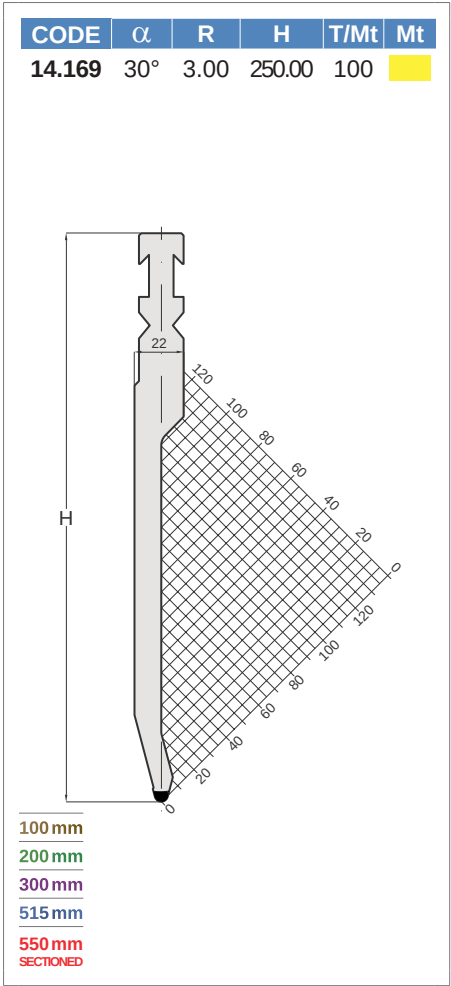
LEGENDA	α = ANGOLO	R = RAGGIO	H = ALTEZZA
LEGEND	α = ANGLE	R = RADIUS	H = HEIGHT



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THE MAX LOAD OF THE HORN EXTENSIONS IS 50% OF THE MAX LOAD OF THE PUNCH.



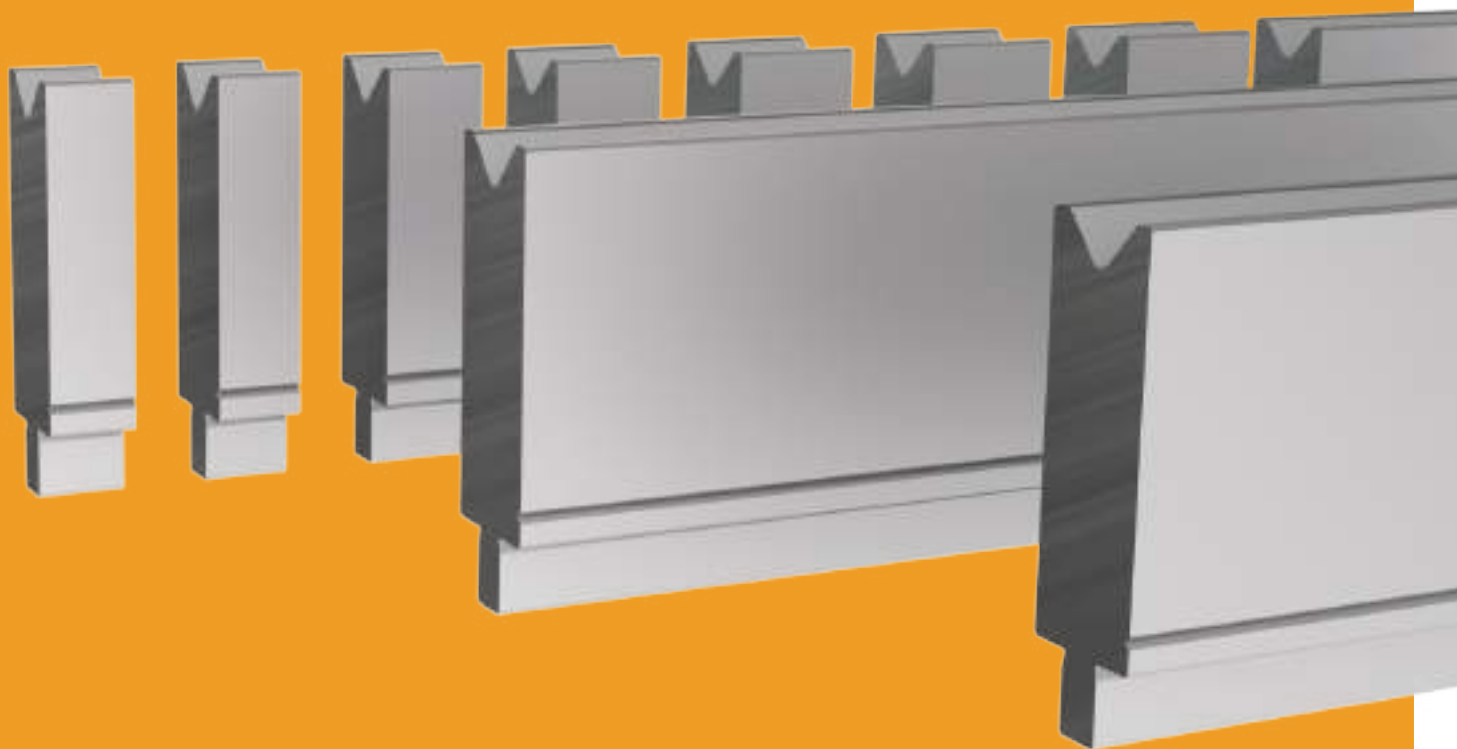






BYSTRONIC - BEYELER STYLE

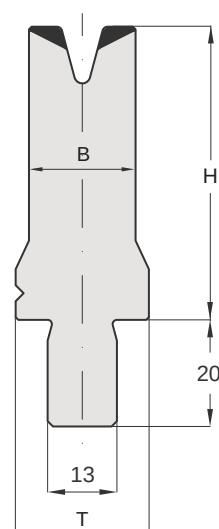
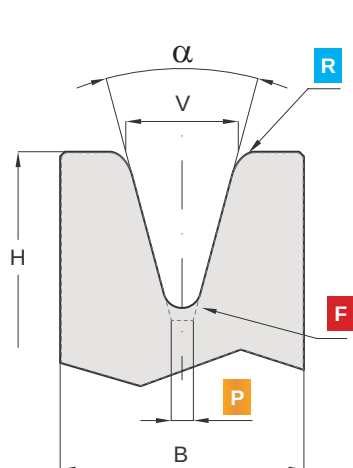
MATRICI
DIES



ORANGE LINE

BYSTRONIC - BEYELER 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



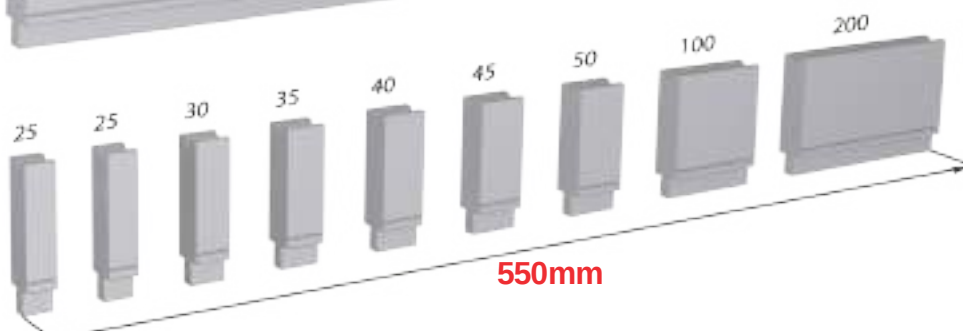
300mm



515mm



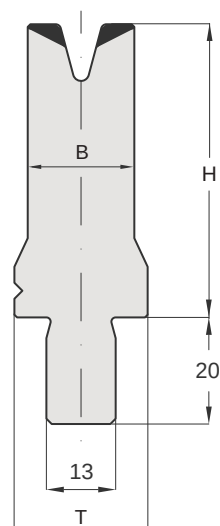
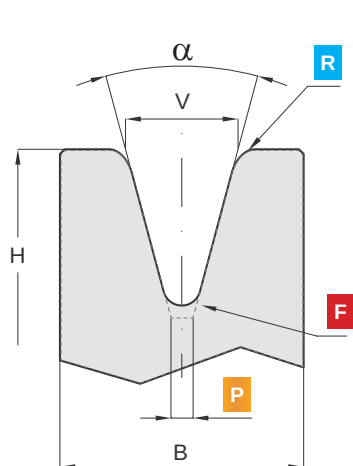
550mm



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

CODE	α	V	R	H	B	T	F	T/mt	Mt
24.403	85°	6	0,75	55	20	25	R0,5	80	
24.404	85°	6	0,75	55	12	25	R0,5	80	
24.405	85°	8	0,75	55	20	25	R0,5	85	
24.406	85°	8	0,75	55	14	25	R0,5	80	
24.407	85°	10	1,00	55	20	25	R0,5	80	
24.408	85°	10	1,00	55	16	25	R0,5	70	
24.409	85°	12	1,50	55	25	25	R0,5	90	
24.410	85°	12	1,50	55	18	25	R0,5	70	
24.411	85°	16	2,00	55	30	30	R0,5	120	
24.412	85°	16	2,00	55	24	30	R0,5	100	
24.413	85°	20	2,50	55	30	30	R1,0	140	
24.414	85°	24	3,00	55	40	40	R1,0	170	
24.415	85°	32	4,00	55	48	48	R2,0	250	
24.080	80°	80	10,00	65	100	100	P15,0	140	
24.180	80°	100	12,00	85	125	125	P15,0	175	
24.040	60°	40	5,00	55	55	55	R5,0	110	
24.050	60°	50	5,00	55	70	70	P15,0	100	
24.060	60°	60	7,00	65	80	80	P15,0	100	
24.453	30°	6	0,75	55	20	25	P1,0	28	
24.454	30°	6	0,75	55	12	25	P1,0	11	
24.455	30°	8	1,00	55	20	25	P2,0	30	
24.456	30°	8	1,00	55	14	25	P2,0	11	
24.457	30°	10	1,00	55	20	25	P2,0	20	
24.458	30°	10	1,00	55	16	25	P2,0	10	
24.459	30°	12	1,50	55	25	25	P2,0	25	
24.460	30°	12	1,50	55	18	25	P2,0	10	
24.017	30°	16	2,00	55	30	30	P5,0	30	
24.462	30°	16	2,00	55	24	30	P5,0	15	
24.320	30°	20	2,50	55	30	30	P5,0	18	
24.018	30°	24	3,00	55	40	40	P8,0	33	
24.465	30°	32	4,00	55	48	48	P14,0	34	





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

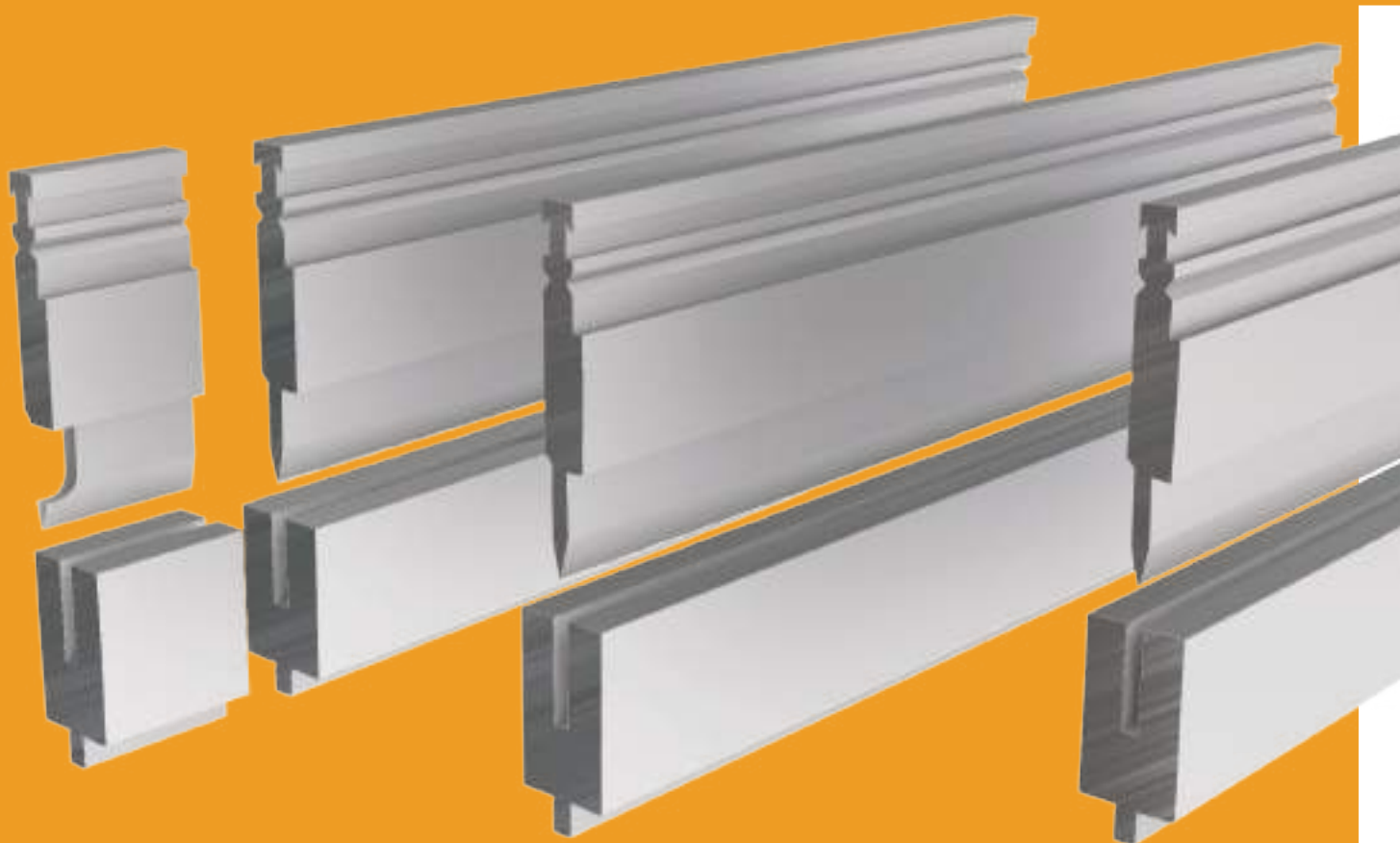
LE MATRICI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 100 / 200 / 300 mm - 515 mm E FRAZIONATI (550 mm)
 THE DIES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 100 / 200 / 300 mm - 515 mm AND SECTIONED (550 mm)

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

CODE	α	V	R	H	B	T	F	T/mt	Mt
24.503	85°	6	0,75	100	20	25	R0,5	80	
24.504	85°	6	0,75	100	12	25	R0,5	80	
24.505	85°	8	0,75	100	20	25	R0,5	85	
24.506	85°	8	0,75	100	14	25	R0,5	80	
24.507	85°	10	1,00	100	20	25	R0,5	80	
24.508	85°	10	1,00	100	16	25	R0,5	70	
24.509	85°	12	1,50	100	25	25	R0,5	90	
24.510	85°	12	1,50	100	18	25	R0,5	70	
24.511	85°	16	2,00	100	30	30	R0,5	120	
24.512	85°	16	2,00	100	24	30	R0,5	100	
24.513	85°	20	2,50	100	30	30	R1,0	140	
24.514	85°	24	3,00	100	40	40	R1,0	170	
24.515	85°	32	4,00	100	48	48	R2,0	250	
24.580	80°	80	10,00	100	100	100	P15,0	140	
24.600	80°	120	15,00	105	160	160	P20,0	220	
24.540	60°	40	5,00	100	55	55	R5,0	110	
24.550	60°	50	5,00	100	70	70	P15,0	100	
24.570	60°	60	7,00	100	80	80	P15,0	100	
24.553	30°	6	0,75	100	20	25	P1,0	28	
24.554	30°	6	0,75	100	12	25	P1,0	11	
24.555	30°	8	1,00	100	20	25	P2,0	30	
24.556	30°	8	1,00	100	14	25	P2,0	11	
24.557	30°	10	1,00	100	20	25	P2,0	20	
24.558	30°	10	1,00	100	16	25	P2,0	10	
24.559	30°	12	1,50	100	25	25	P2,0	25	
24.560	30°	12	1,50	100	18	25	P2,0	10	
24.561	30°	16	2,00	100	30	30	P5,0	30	
24.562	30°	16	2,00	100	24	25	P5,0	15	
24.563	30°	20	2,50	100	30	30	P5,0	18	
24.564	30°	24	3,00	100	40	40	P8,0	33	
24.565	30°	32	4,00	100	48	48	P14,0	34	

BYSTRONIC - BEYELER STYLE

PIEGASCHIACCIA
HEMMING TOOLS

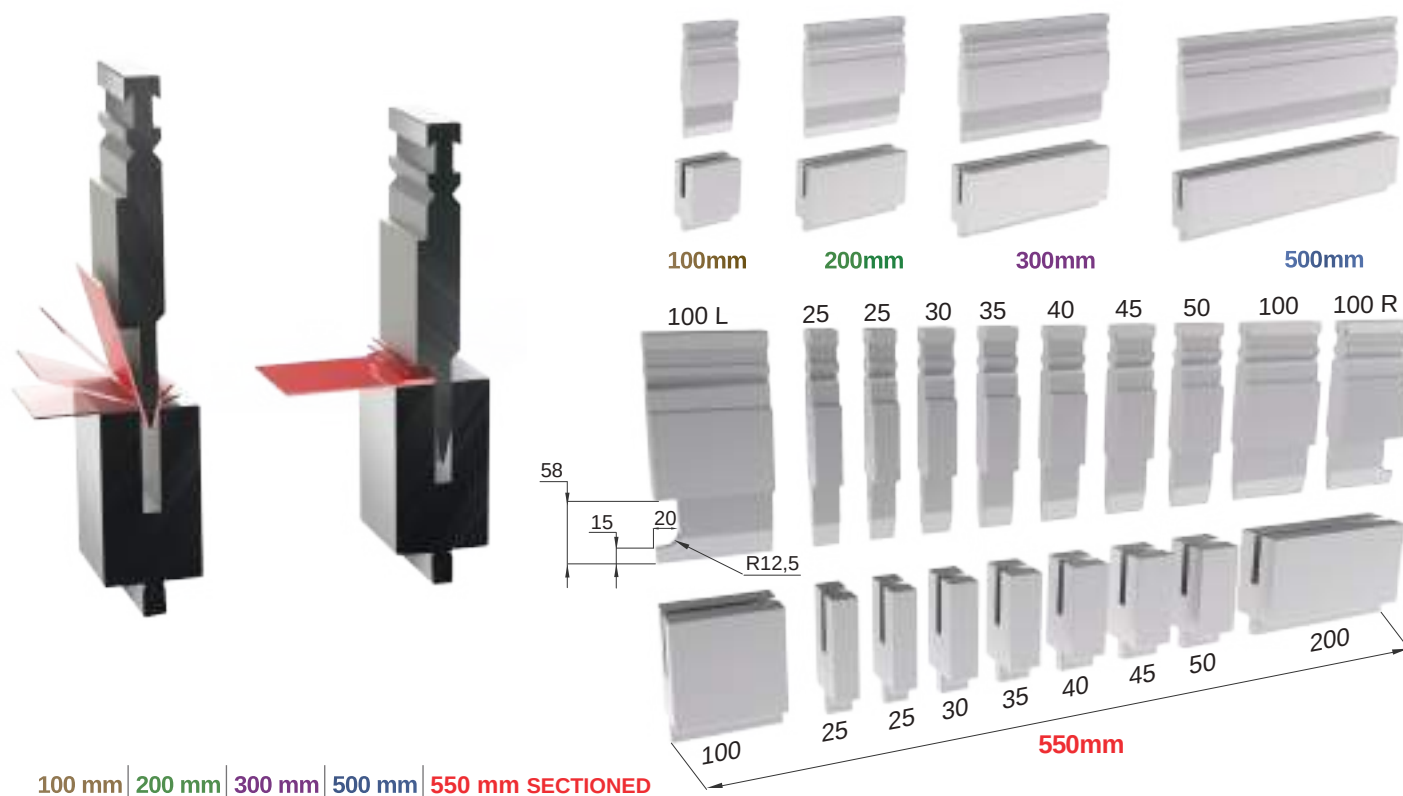


ORANGE LINE

BYSTRONIC - BEYELER STYLE



PIEGASCHIACCIA / HEMMING TOOLS **BYSTRONIC - BEYELER STYLE**



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



