



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

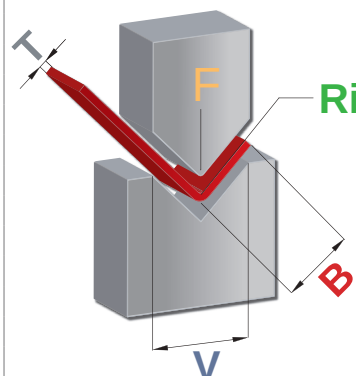


TABELLA DI PIEGATURA / BENDING CHART

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.

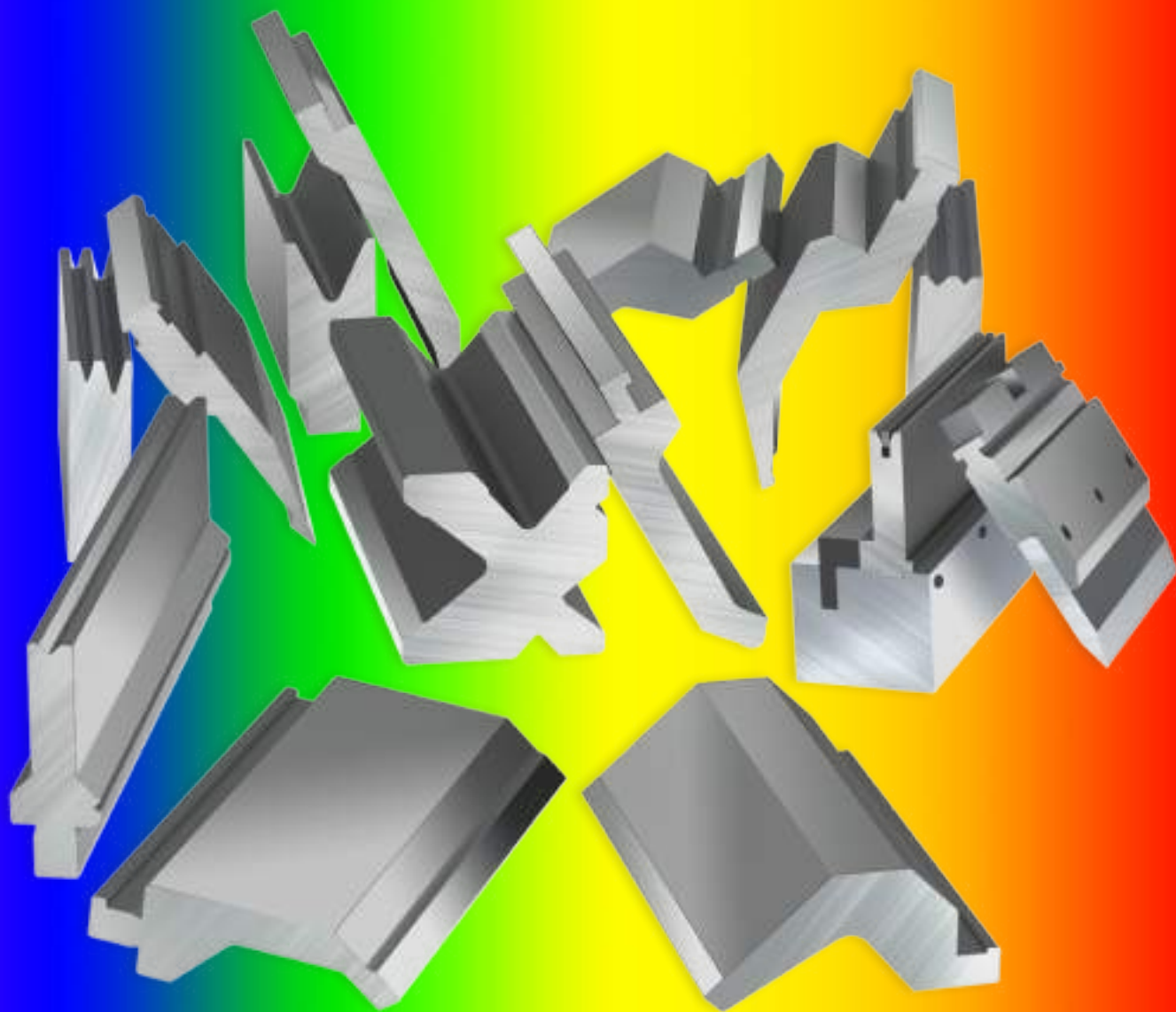
TRATTAMENTI ANTIUSURA
ANTIWEAR TREATMENT

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.

**AJIAL - AMERICAN - COLGAR
COLLY - HÄMMERLE - EHT
NEWTON - WEINBRENNER STYLE**

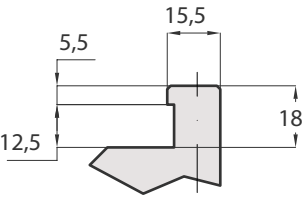


RAINBOW LINE

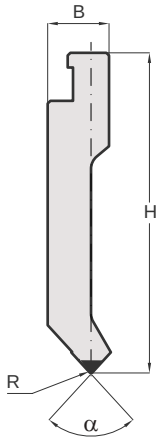
**UTENSILI MULTIMARCA
MULTI BRAND TOOLS**



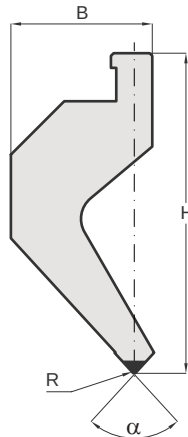
I PUNZONI SONO PRODOTTI A RICHIESTA NELLE LUNGHEZZE DI: 1020 mm E FRAZIONATI (990 mm)
THE PUNCHES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 1020 mm AND SECTIONED (990 mm)



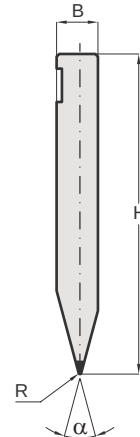
CODE
AJIAL-P1



CODE
AJIAL-P2



CODE
AJIAL-P3



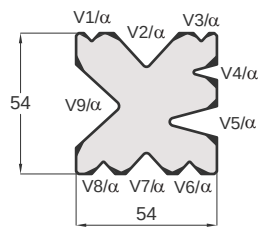
CODE
H = ...
B = ...
R = ...
 α = ...

1020 mm | 990 mm SECTIONED

SPECIFICARE DIMENSIONI / SPECIFY DIMENSIONS

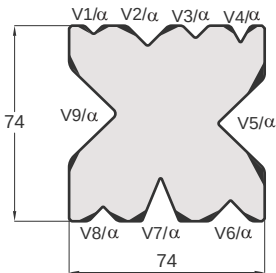
MATRICI / DIES AJIAL STYLE

CODE
AJIAL-M1



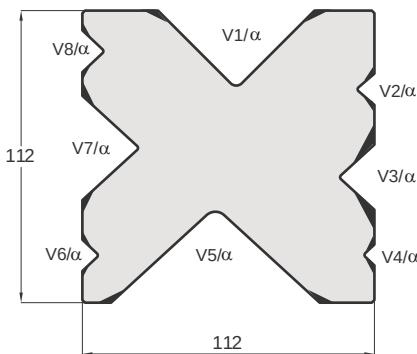
V1 / α
V2 / α
V3 / α
V4 / α
V5 / α
V6 / α
V7 / α
V8 / α
V9 / α

CODE
AJIAL-M2



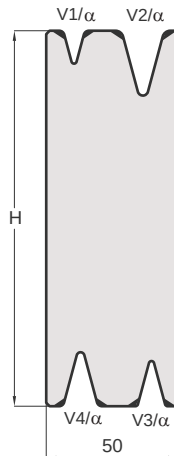
V1 / α
V2 / α
V3 / α
V4 / α
V5 / α
V6 / α
V7 / α
V8 / α
V9 / α

CODE
AJIAL-M3



V1 / α
V2 / α
V3 / α
V4 / α
V5 / α
V6 / α
V7 / α
V8 / α

CODE
AJIAL-M4



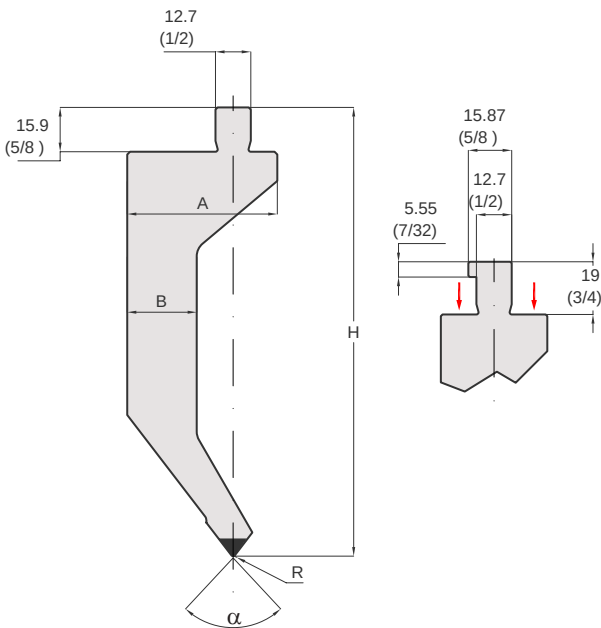
V1 / α
V2 / α
V3 / α
V4 / α
H

1020 mm | 990 mm SECTIONED

SPECIFICARE DIMENSIONI / SPECIFY DIMENSIONS

PUNZONI / PUNCHES - MATRICI / DIES AMERICAN STYLE

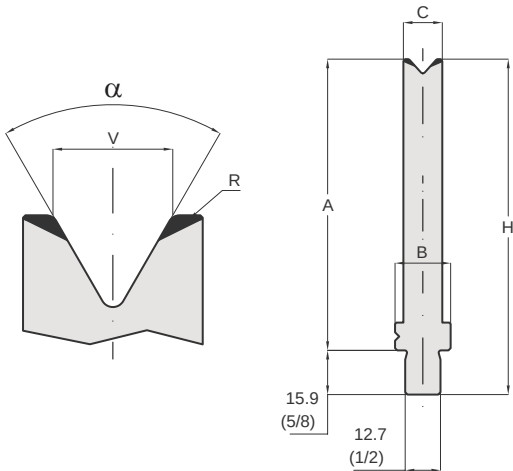
PUNZONI A RICHIESTA NELLE LUNGHEZZE DI: 18" (457.2 mm)
PUNCHES ON REQUEST IN THE FOLLOWING LENGTHS: 18" (457.2 mm)



457.2 mm | 18" inches

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

MATRICI A RICHIESTA NELLE LUNGHEZZE DI: 18" (457.2 mm)
DIES ON REQUEST IN THE FOLLOWING LENGTHS: 18" (457.2 mm)

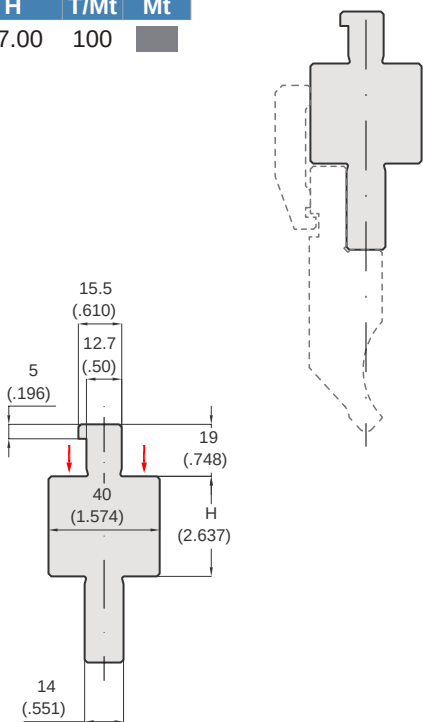


457.2 mm | 18" inches

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

ADATTATORI / ADAPTERS AMERICAN STYLE

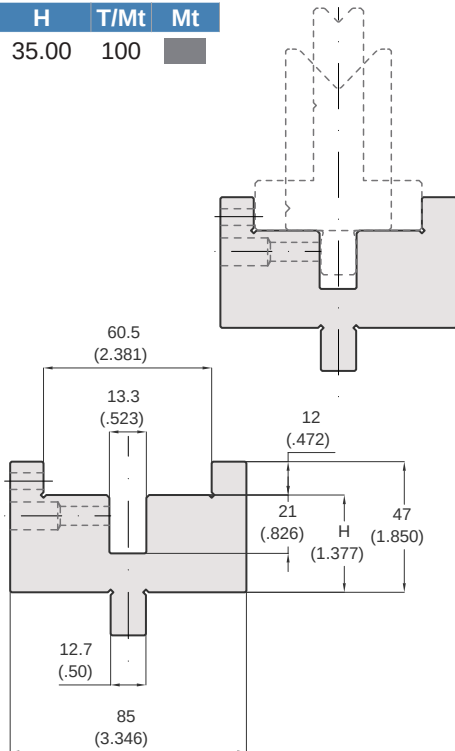
CODE	L	H	T/Mt	Mt
50.950	150	67.00	100	



457.2 mm | 18" inches

USA - EU ADAPTER

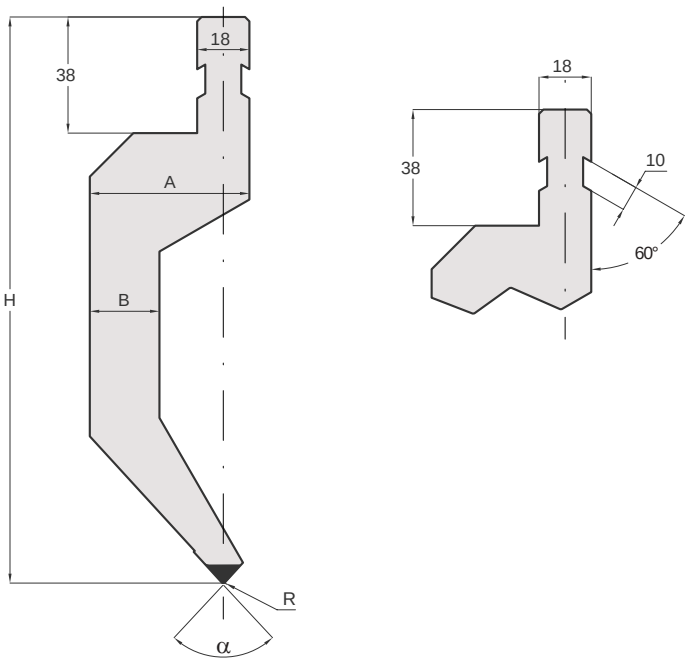
CODE	L	H	T/Mt	Mt
60.980	835	35.00	100	



457.2 mm | 18" inches

USA - EU - WILA LOWER ADAPTER

I PUNZONI SONO PRODOTTI A RICHIESTA NELLE LUNGHEZZE DI: 525 mm E FRAZIONATI (495 mm, 500 mm)
THE PUNCHES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 525 mm AND SECTIONED (495 mm, 500 mm)

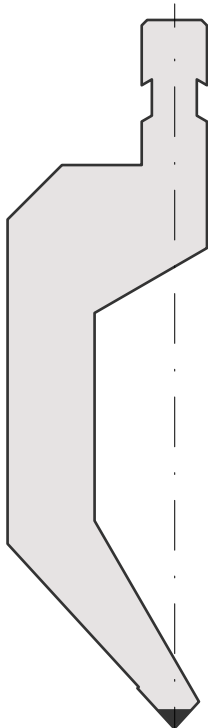


525 mm | 495 mm, 500 mm SECTIONED

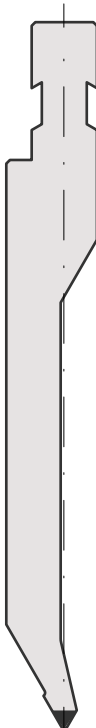
LEGENDA	α = ANGOLO	R = RAGGIO	H = ALTEZZA
LEGEND	α = ANGLE	R = RADIUS	H = HEIGHT

MODELLI SU RICHIESTA / MODELS ON REQUEST

CODE
COLG-P1



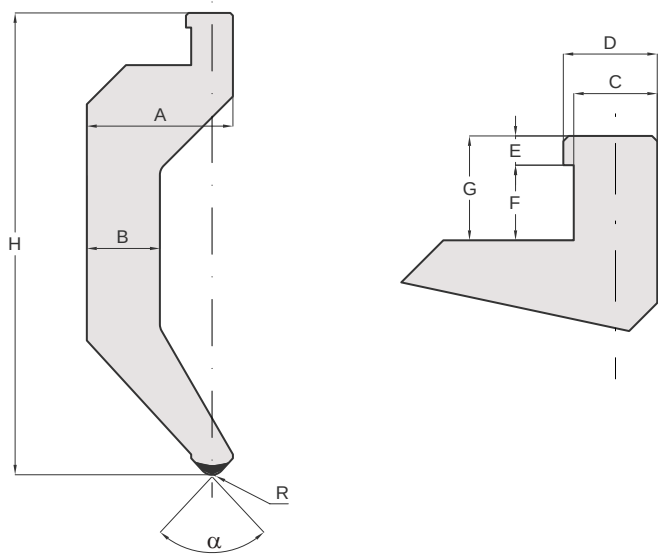
CODE
COLG-P2



CODE
COLG-P3



I PUNZONI SONO PRODOTTI A RICHIESTA NELLE LUNGHEZZE DI: 1020 mm E FRAZIONATI (1250 mm)
THE PUNCHES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 1020 mm AND SECTIONED (1250 mm)

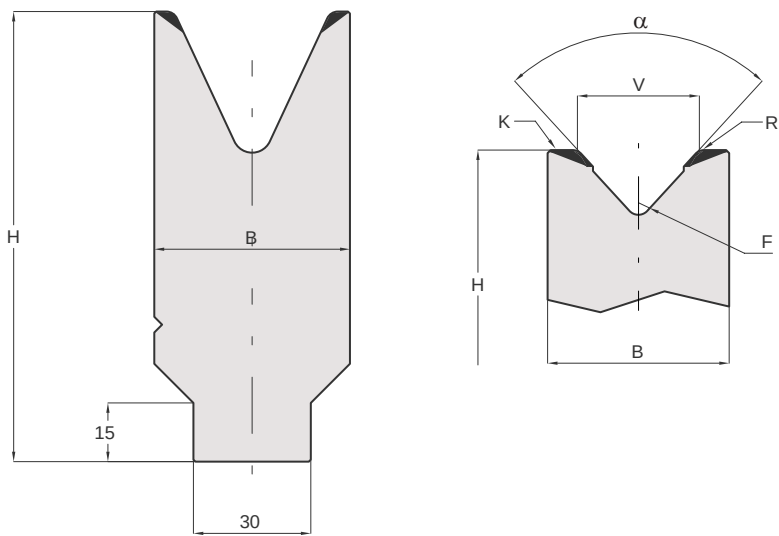


1020 mm | 1250 mm SECTIONED

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

MATRICI / DIES COLLY STYLE

LE MATRICI SONO PRODOTTE SU RICHIESTA NELLE LUNGHEZZE DI: 1020 mm E FRAZIONATI (990 mm)
THE DIES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 1020 mm AND SECTIONED (990 mm)

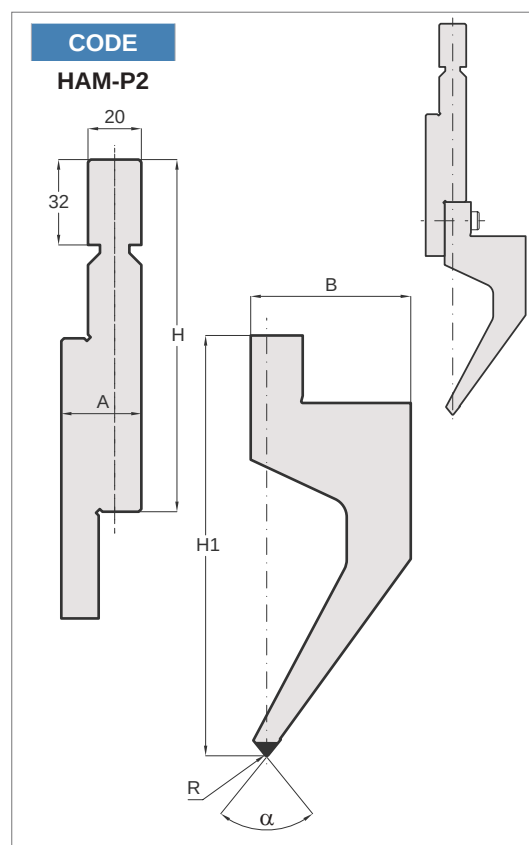
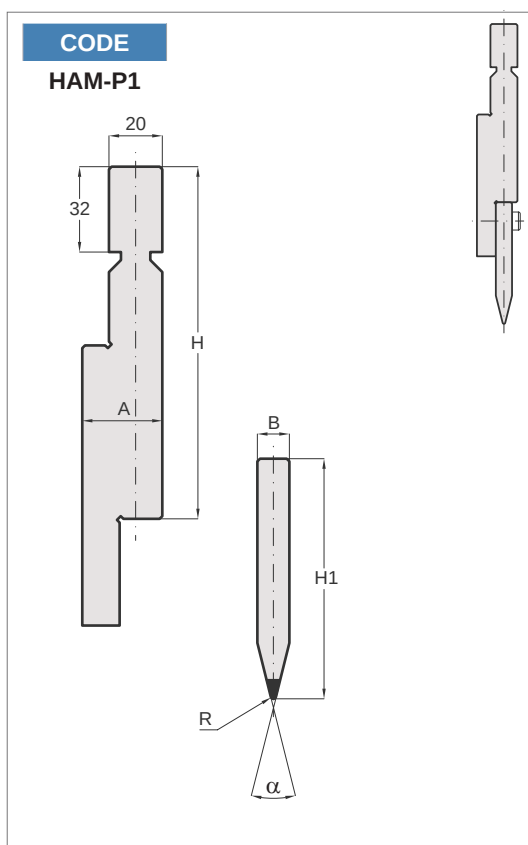


1020 mm | 1250 mm SECTIONED

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

PRODOTTI A RICHIESTA
PRODUCTS ON REQUEST

CODE
H = ...
H1 = ...
A = ...
B = ...
R = ...
 α = ...

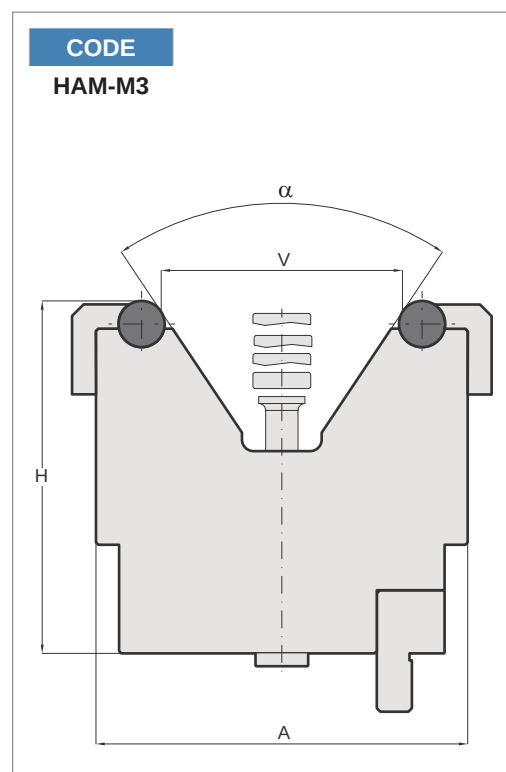
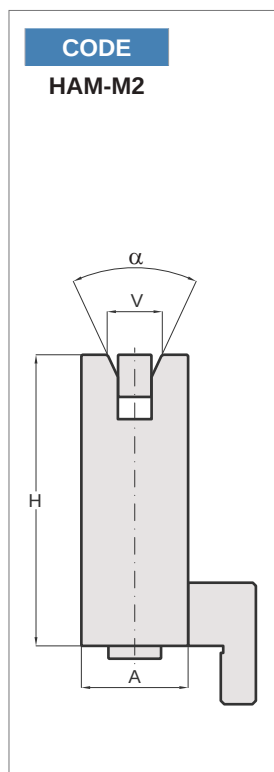
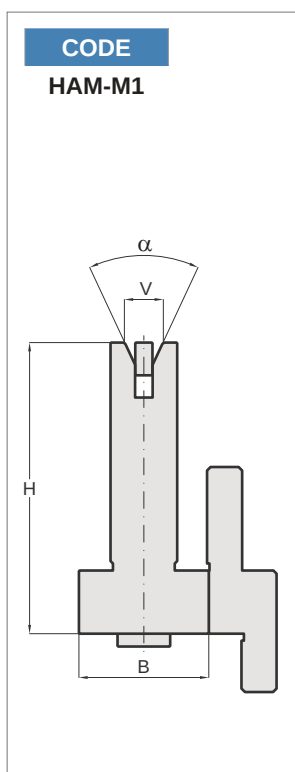


SPECIFICARE DIMENSIONI / SPECIFY DIMENSIONS

MATRICI / DIES **HÄMMERLE** STYLE

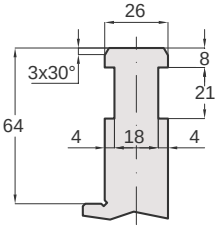
LE MATRICI SONO PRODOTTE SU RICHIESTA
THE DIES ARE PRODUCED ON REQUEST

CODE
H = ...
A = ...
B = ...
R = ...
 α = ...



SPECIFICARE DIMENSIONI / SPECIFY DIMENSIONS

I PUNZONI SONO PRODOTTI A RICHIESTA NELLE LUNGHEZZE DI: 2100 mm, 2600 mm, 3100 mm, 3600 mm E 4100 mm (FRAZIONATI)
THE PUNCHES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 2100 mm, 2600 mm, 3100 mm, 3600 mm AND 4100 mm (SECTIONED)



CODE

H =

B =

R =

$\alpha =$

CODE	Diagram
EHT-P1	
EHT-P2	
EHT-P3	
EHT-P4	
EHT-P5	

2100 mm | 2600 mm | 3100 mm | 3600 mm | 4100 mm SECTIONED

SPECIFICARE DIMENSIONI / SPECIFY DIMENSIONS

MATRICI / DIES EHT STYLE

LE MATRICI SONO PRODOTTE SU RICHIESTA NELLE LUNGHEZZE DI: 2100 mm, 2600 mm, 3100 mm, 3600 mm E 4100 mm (FRAZIONATI)
THE DIES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 2100 mm, 2600 mm, 3100 mm, 3600 mm AND 4100 mm (SECTIONED)

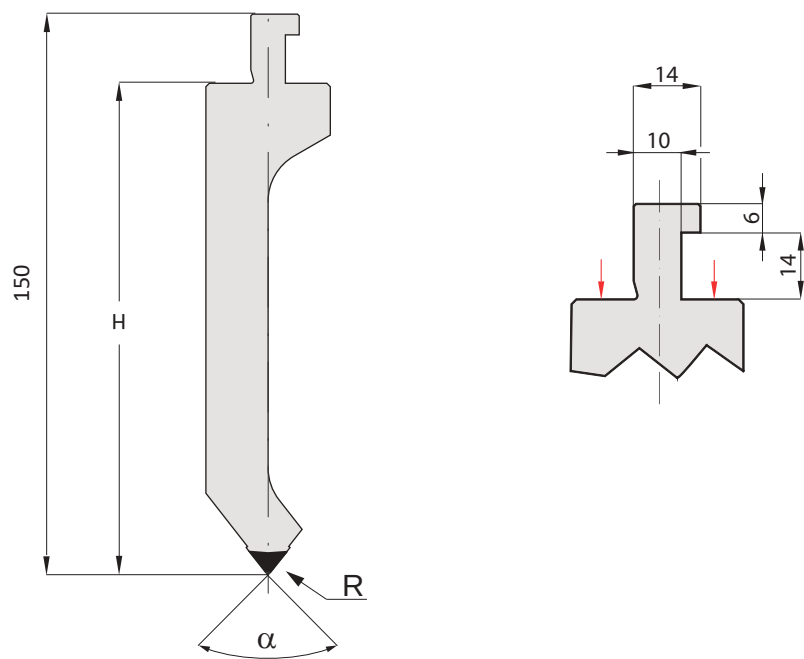
CODE	Diagram	CODE	Diagram	CODE	Diagram	CODE	Diagram	CODE	Diagram			
EHT-M1		EHT-M2		EHT-M3		EHT-M4		EHT-M5				
V1 / α		V1 / α		V1 / α		V1 / α		V1 / α				
V2 / α		V2 / α		V2 / α								
V3 / α		V3 / α										
V4 / α		V4 / α										
V5 / α												
V6 / α												
U		U										
P		P										
H		H		H		H		H				

2100 mm | 2600 mm | 3100 mm | 3600 mm | 4100 mm SECTIONED

SPECIFICARE DIMENSIONI / SPECIFY DIMENSIONS

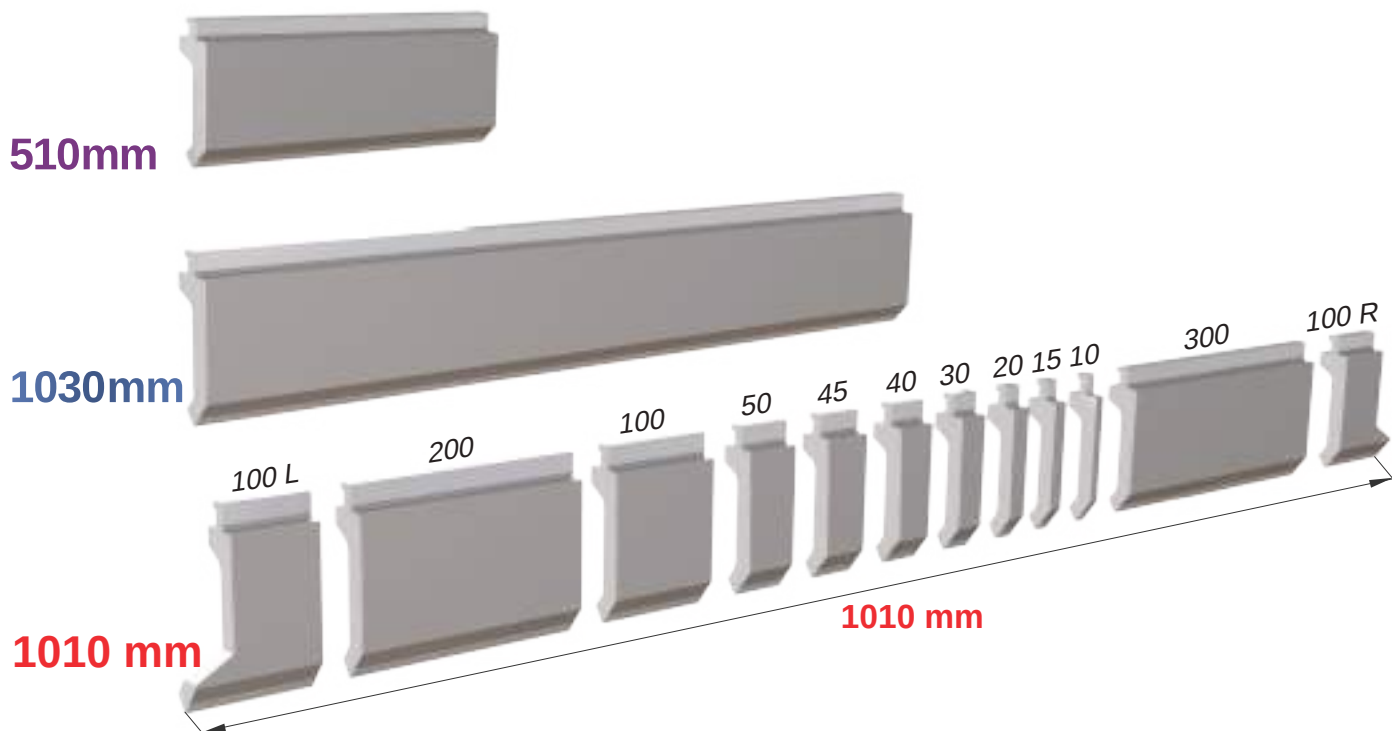
PUNZONI / PUNCHES **NEWTON STYLE**

I PUNZONI SONO PRODOTTI A RICHIESTA NELLE LUNGHEZZE DI: 510 mm, 1030 mm E FRAZIONATI (1010 mm)
THE PUNCHES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 510 mm, 1030 mm AND SECTIONED (1010 mm)



510 mm | 1030 mm | 1010 mm SECTIONED

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



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	L	H	T/Mt	Mt
50.930	150	100.00	100	

ADATTATORE
ADAPTER
NEWTON/AMADA

CODE	L	H	T/Mt	Mt
50.935	150	100.00	100	

ADATTATORE
ADAPTER
AMADA/NEWTON

CODE	α	R	H	T/Mt	Mt
18.100	76°	1.00	130.00	100	

510 mm
1030 mm
1010 mm
SECTIONED



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

415 mm | 835 mm | 805 mm SECTIONED

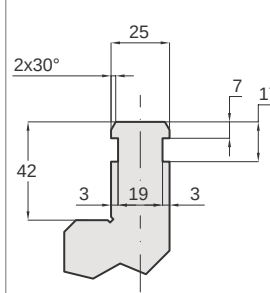
LE MATRICI SONO PRODOTTE SU RICHIESTA NELLE LUNGHEZZE DI: 415 mm, 835 mm E 805 mm (FRAZIONATI)
THE DIES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 415 mm, 835 mm AND 805 mm (SECTIONED)

CODE	α	H	T/Mt	Mt
28.100	80°	90	80	

510 mm | 1030mm | 1010 mm SECTIONED

LE MATRICI SONO PRODOTTE SU RICHIESTA NELLE LUNGHEZZE DI: 510 mm, 1030 mm E 1010 mm (FRAZIONATI)
THE DIES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 510 mm, 1030 mm AND 1010 mm (SECTIONED)

I PUNZONI SONO PRODOTTI A RICHIESTA NELLE LUNGHEZZE DI: 2050 mm, 2550 mm, 3050 mm, 3550 mm E 4050 mm (FRAZIONATI)
THE PUNCHES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 2050 mm, 2550 mm, 3050 mm, 3550 mm AND 4050 mm (SECTIONED)



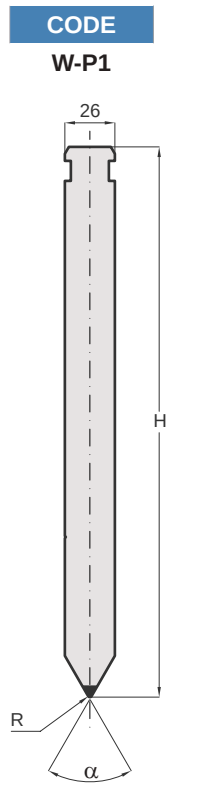
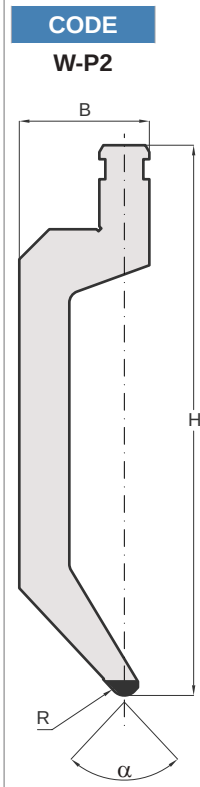
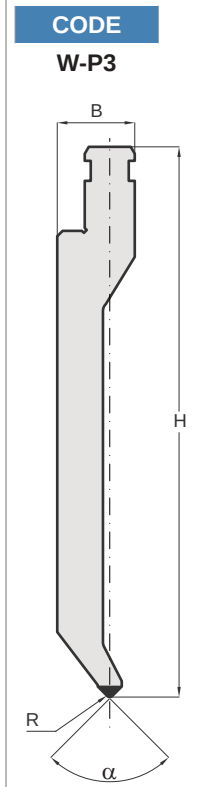
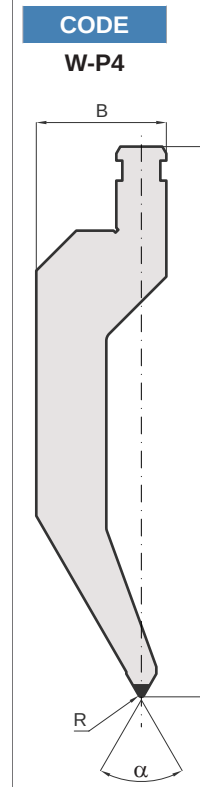
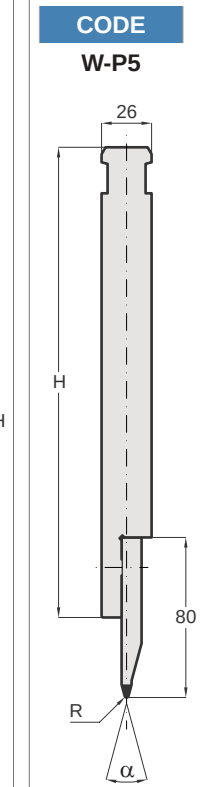
CODE

H = ...

B = ...

R = ...

α = ...

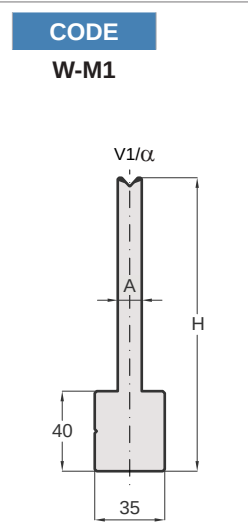
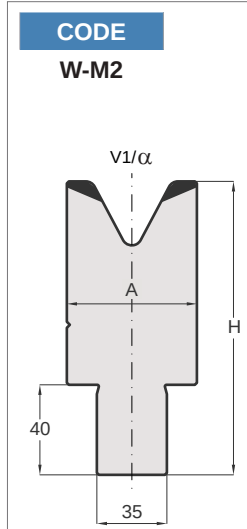
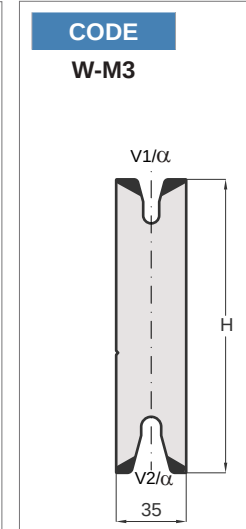
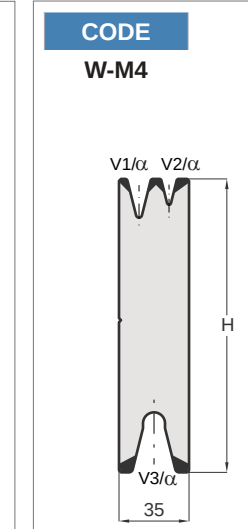
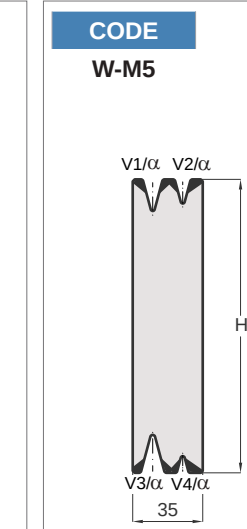
CODE W-P1	CODE W-P2	CODE W-P3	CODE W-P4	CODE W-P5
				

2050 mm | 2550 mm | 3050 mm | 3550 mm | 4050 mm SECTIONED

SPECIFICARE DIMENSIONI / SPECIFY DIMENSIONS

MATRICI / DIES WEINBRENNER STYLE

LE MATRICI SONO PRODOTTE SU RICHIESTA NELLE LUNGHEZZE DI: 2050 mm, 2550 mm, 3050 mm, 3550 mm E 4050 mm (FRAZIONATI)
THE DIES ARE PRODUCED ON REQUEST IN THE FOLLOWING LENGTHS: 2050 mm, 2550 mm, 3050 mm, 3550 mm AND 4050 mm (SECTIONED)

CODE W-M1	CODE W-M2	CODE W-M3	CODE W-M4	CODE W-M5
				
V1 / α H A	V1 / α H A	V1 / α V2 / α H	V1 / α V2 / α V3 / α H	V1 / α V2 / α V3 / α V4 / α H

2050 mm | 2550 mm | 3050 mm | 3550 mm | 4050 mm SECTIONED

SPECIFICARE DIMENSIONI / SPECIFY DIMENSIONS

