



# Tecnostamp

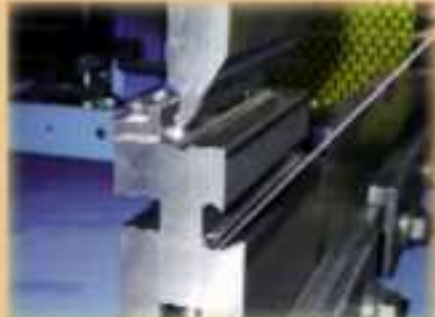
<http://www.tecnostamp.it>

world wide producer

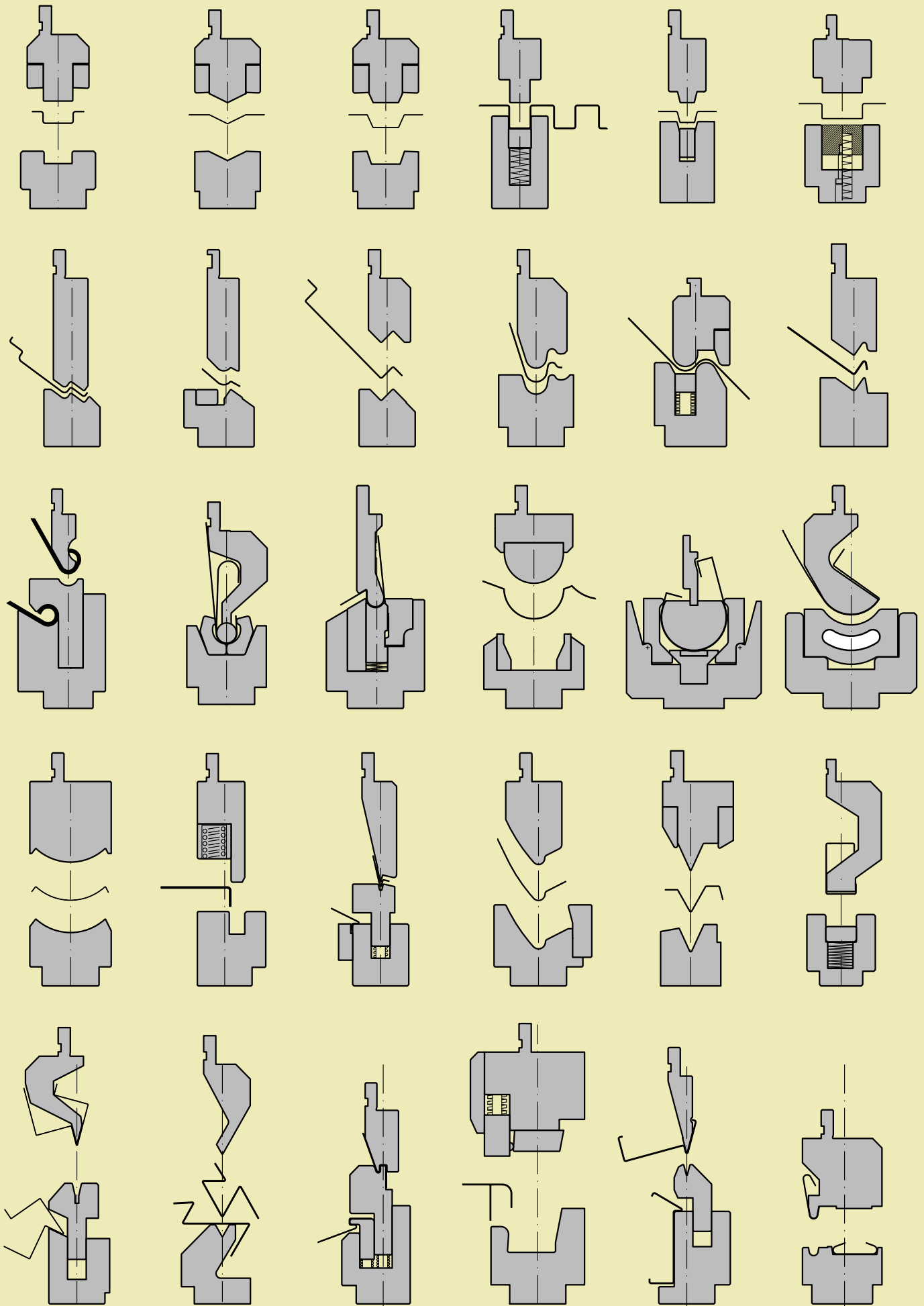
**2° EDIZIONE**  
**2<sup>nd</sup> EDITION**

**Bending Tooling**  
**Utensili di Piegatura**

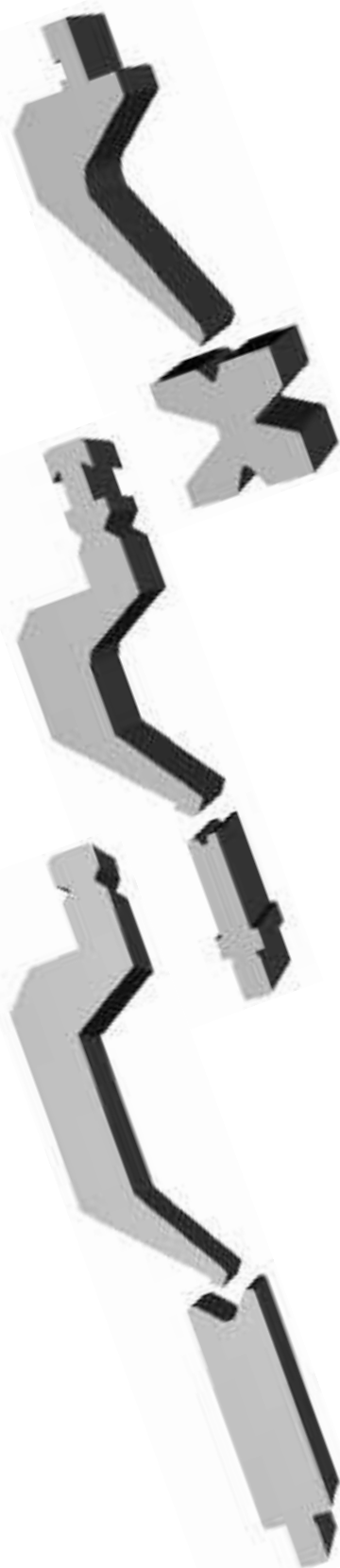
09



SPECIAL TOOLING



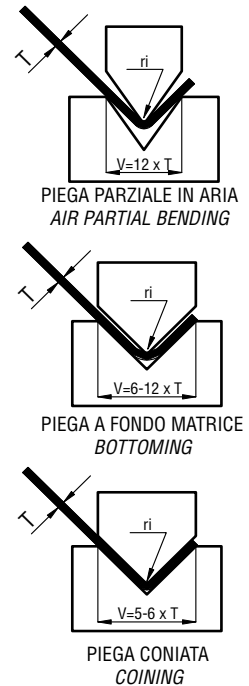
Pagine: da / a  
Pages: from / to



<b>5</b>	TABELLA DI PIEGATURA BENDING SCHEME
<b>6 / 13</b>	ADATTATORI, INTERMEDIARI, STAFFE, CANALINE E ADATTATORI INFERIORI ADAPTORS, INTERMEDIATES, CLAMPS, LOWER HOLDERS AND LOWER ADAPTORS
<b>14 / 27</b>	PUNZONI AMADA/PROMECAM - PUNZONE ROTANTE AMADA/PROMECAM PUNCHES - ROTARY PUNCH
<b>28 / 41</b>	MATRICI AMADA/PROMECAM AMADA/PROMECAM DIES
<b>42 / 43</b>	PIEGA-SCHIACCIA AMADA/PROMECAM AMADA/PROMECAM FLATTENING-HEMMING TOOLS
<b>44 / 45</b>	MATRICI A RULLI ROLLERS DIES
<b>46 / 54</b>	PUNZONI BEYELER BEYELER PUNCHES
<b>55</b>	PIEGA-SCHIACCIA BEYELER BEYELER FLATTENING-HEMMING TOOLS
<b>56 / 58</b>	MATRICI BEYELER BEYELER DIES
<b>59 / 65</b>	PUNZONI WILA/TRUMPF WILA/TRUMPF PUNCHES
<b>64</b>	PIEGA-SCHIACCIA WILA/TRUMPF WILA/TRUMPF FLATTENING-HEMMING TOOLS
<b>67 / 73</b>	MATRICI WILA/TRUMPF WILA/TRUMPF DIES
<b>74</b>	PUNZONI LVD LVD PUNCHES
<b>75</b>	MATRICI LVD LVD DIES
<b>76 / 87</b>	ATTREZZATURE (ZETA, CONTENITORI PER INSERTI A Z, INSERTI RAGGIATI, SUPPORTI PER INSERTI RAGGIATI, GOMMA, NYLON, FILM ANTIGRAFFIO, TENDITORE, ARMADI, SQUADRE DI RIFERIMENTO, SUPPORTI ANTERIORI, ARRESTI MICROMETRICI E FISSI) EQUIPMENTS (JOGGLE TOOLS AND HOLDERS, RADIUS TOOLS, HOLDERS FOR RADIUS TOOLS, POLIURETHANE, NYLON INSERTS, PROTECTIVE TAPE/FILM AND HOLDER, TOOLING CUPBOARDS, SQUARING ARMS, FRONT-SUPPORT ARMS AND STOPS)
<b>83 / 88</b>	BLOCCAGGI PNEUMATICI SUPERIORI ED INFERIORI PER CAMBIO RAPIDO UTENSILI UPPER AND LOWER PNEUMATIC CLAMPING FOR FAST CHANGE TOOLS
<b>89</b>	RIALZI MODULARI PNEUMATICI PNEUMATIC MODULAR HOLDER

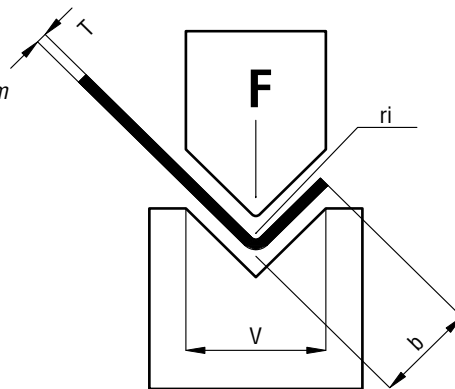
## COMPARAZIONE FRA TECNICHE DI PIEGATURA COMPARISON BETWEEN BENDING TECHNIQUES

TIPO DI PIEGATURA KIND OF BENDING	AMPIEZZA-V V-width	ri	DISPERSIONE DELL'ANGOLO DI PIEGATURA BENDING ANGLE DISPERSION	PRECISIONE DI PIEGA BENDING PRECISION	CARATTERISTICHE FEATURE
PIEGA PARZIALE IN ARIA PARTIAL AIR BENDING	12T-15T	2T-2.5T	CIRCA/ABOUT +/- 45'	BUONA, MA CON RAGGIO INTERNO GRANDE FORMS SURFACE WITH LARGE CURVATURE RADIUS	FORZA NECESSARIA BASSA, MA RISENTE DI UN IMPORTANTE RITORNO ELASTICO WEAK FORCE FOR THIS KIND OF BEND, BUT HIGH SPRINGBACK
PIEGA A FONDO MATRICE BOTTOMING	6T-12T	1T-2T	CIRCA/ABOUT +/- 30'	BUONA GOOD	SI PUO' OTTENERE UNA BUONA PRECISIONE USANDO UNA FORZA RELATIVAMENTE BASSA GOOD PRECISION IS OBTAINABLE USING A RELATIVELY WEAK FORCE
PIEGA CONIATA COINING	5T	0.5T-0.8T	CIRCA/ABOUT +/- 15'	BUONA GOOD	SI PUO' OTTENERE UN'OTTIMA PRECISIONE, MA LA FORZA NECESSARIA E' 5-8 VOLTE SUPERIORE A QUELLA RICHIESTA NELLA PIEGA A FONDO MATRICE VERY GOOD PRECISION IS OBTAINABLE, BUT THE TONNAGE REQUIRED IS 5-8 TIMES THAT REQUIRED IN BOTTOMING



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

- T** Spessore lamiera in mm  
Thickness of the sheet in mm
- F** Forza in Ton /metro  
Force in Ton /meter
- ri** Raggio interno  
Inside radius
- b** Bordo minimo possibile  
Shortest edge to be bent
- V** Larghezza del V  
V-opening



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

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

- Alluminio/Aluminium R=20-25 kg/mm<sup>2</sup>
- Acciaio dolce/Mild steel R=40-45 kg/mm<sup>2</sup>
- Inox/Stainless steel R=65-70 kg/mm<sup>2</sup>

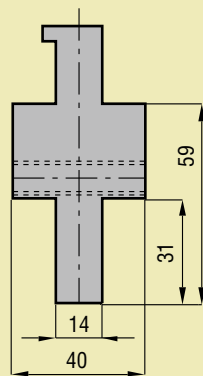
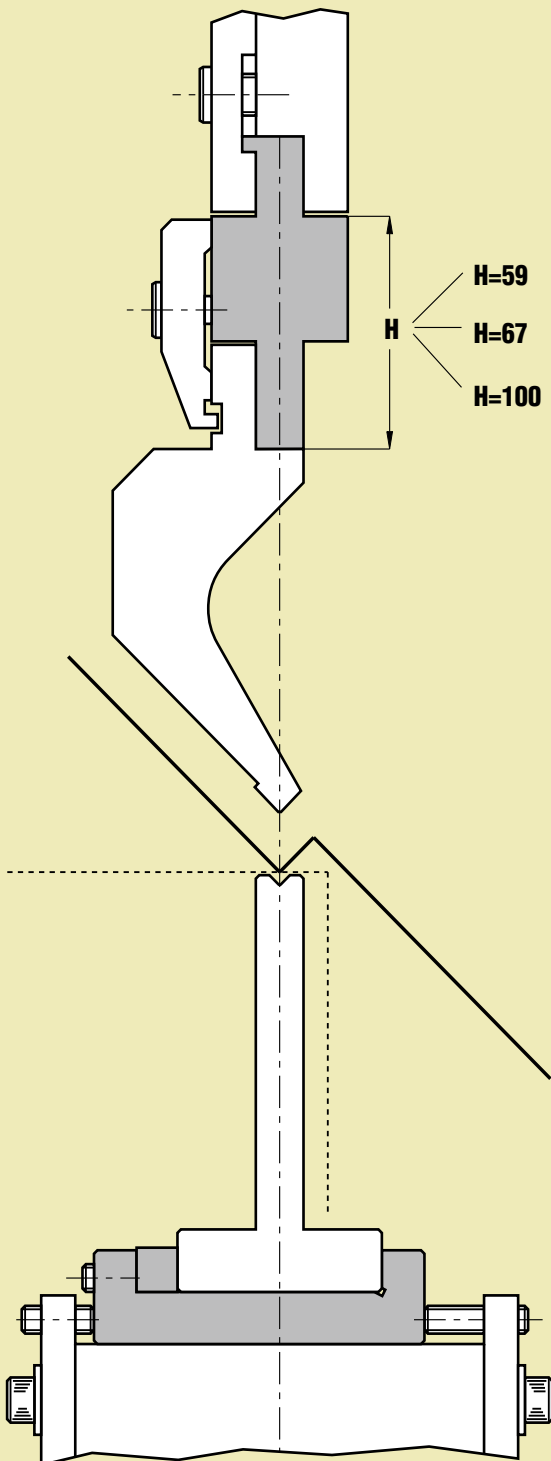
TABELLA DI PIEGATURA IN ARIA FORZA NECESSARIA PER PIEGA A 90 IN ARIA DI LAMIERA CON R=45 Kg/mm <sup>2</sup> CHART BY BENDING IN THE AIR NEEDED FORCE FOR 90 AIR BENDING, SHEET RESISTANCE R=45 Kg/mm <sup>2</sup>																			
T	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V b ri	
	4	5.5	7	8.5	11	14	17.5	22	28	35	45	55	71	89	113	140	175		
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			
20													270	215	170	135	108		

**F**

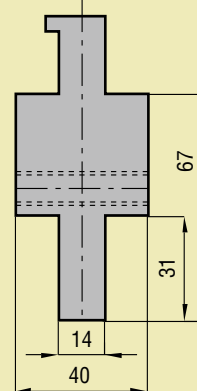
SOLUZIONE OTTIMALE PER L'USO  
DEGLI UTENSILI STANDARD  
DELLA LINEA  
**TEGNOStamp**  
SU TUTTI I TIPI DI PRESSE PIEGATRICI

BEST SOLUTION FOR THE USE OF  
**TEGNOStamp**  
RANGE STANDARD TOOLS  
ON ALL KIND OF  
BENDING MACHINES

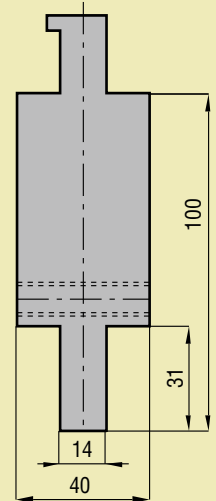
INTERMEDIARI FISSI PER TUTTI I TIPI DI PRESSE PIEGATRICI CON STAFFAGGIO A SCELTA  
FIXED INTERMEDIATES FOR ALL KIND OF PRESS-BRAKES EQUIPPED WITH CLAMPING SYSTEM AT YOUR CHOICE



**800.000**  
L=150



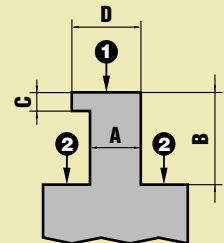
**810.000**  
L=150



**820.000**  
L=150

INDICARE QUOTE D'ATTACCO  
E PUNTO DI SPINTA  
SHOW DIMENSION OF TANG  
AND THRUST POINT

	①	②
A =		
B =		
C =		
D =		



STAFFE NON COMPRESI (vedi pag. 11)  
CLAMPS NOT INCLUDED (see page 11)

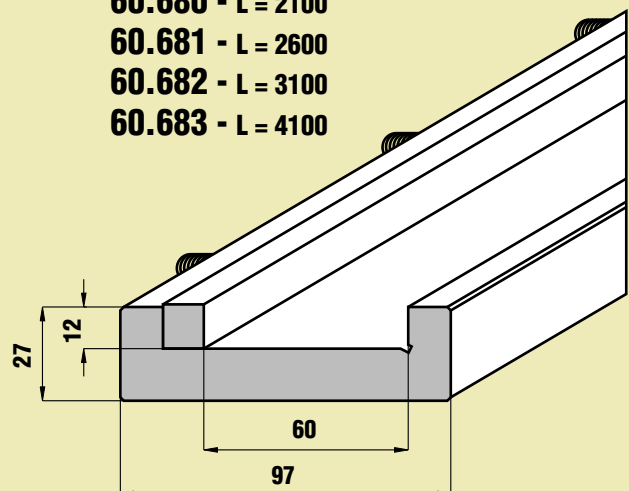
## CANALETTA HOLDER

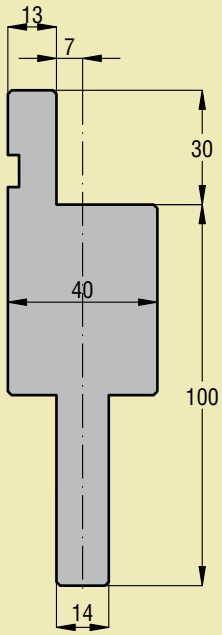
60.680 - L = 2100

60.681 - L = 2600

60.682 - L = 3100

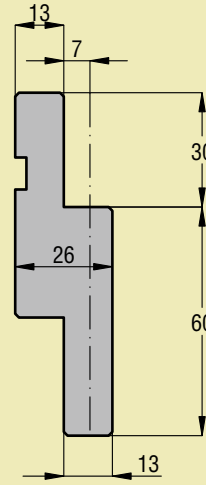
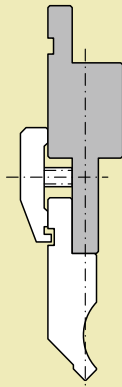
60.683 - L = 4100





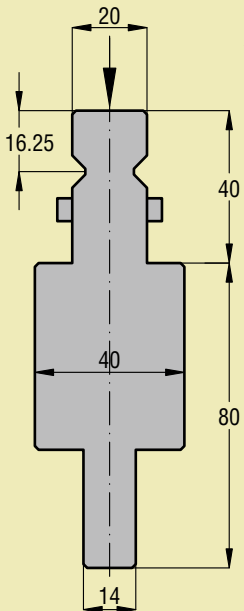
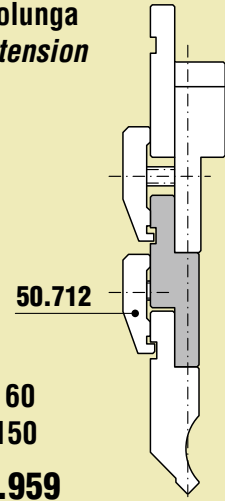
**Intermediario NON CENTINABILE**  
**NOT CENTERING Intermediate**

**H100**  
**L150**  
**50.671**



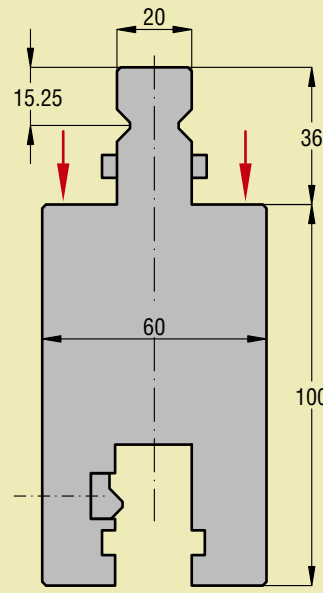
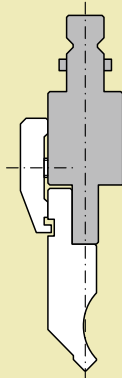
**Prolunga**  
**Extension**

**H 60**  
**L150**  
**50.959**



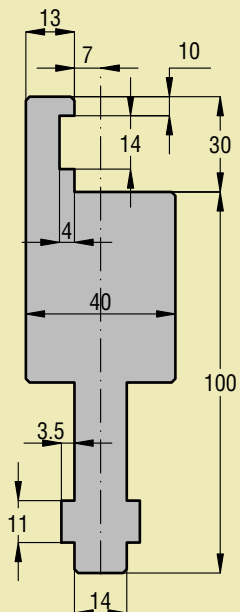
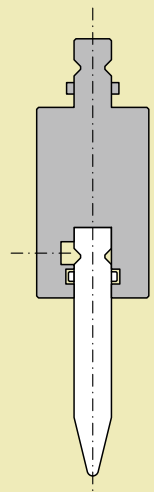
**Adattatore WILA-TRUMPF**  
**WILA-TRUMPF Adaptor**

**H 80**  
**L150**  
**50.970**



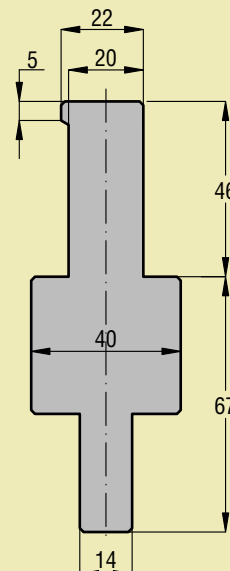
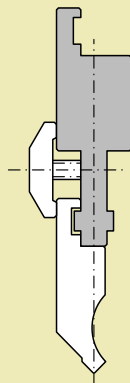
**Prolunga WILA-TRUMPF**  
**WILA-TRUMPF Extension**

**50.410 H100 L150**  
**50.415 H100 L50**



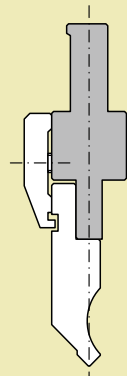
**Prolunga BEYELER**  
**BEYELER Extension**

**H100**  
**L150**  
**50.985**

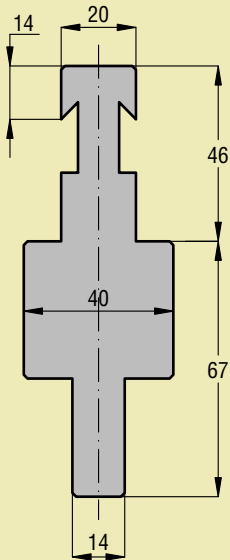


**Adattatore BEYELER-S**  
**BEYELER-S Adaptor**

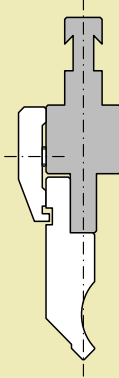
**H 67**  
**L150**  
**50.981**



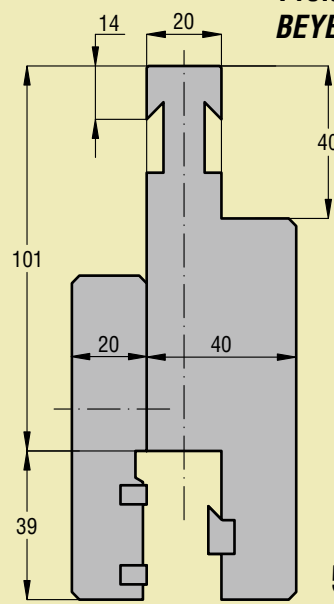
**Adattatore BEYELER-R**  
*BEYELER-R Adaptor*



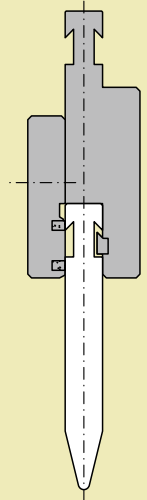
**H 67**  
**L 150**  
**50.980**



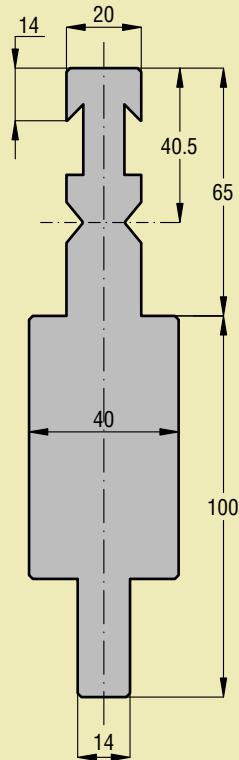
**Prolunga BEYELER-R**  
*BEYELER-R Extension*



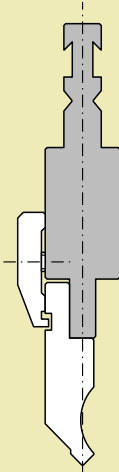
**H 101**  
**L 150**  
**50.982**



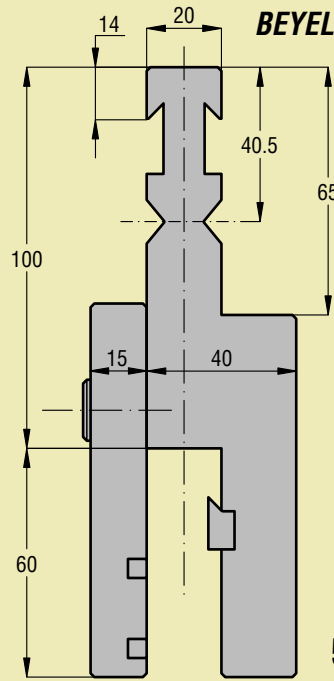
**Adattatore BEYELER RF-A**  
*BEYELER RF-A Adaptor*



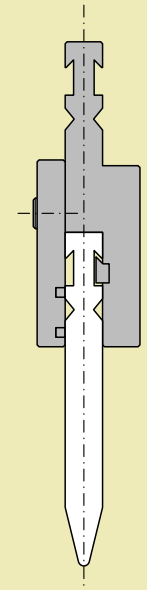
**H 100**  
**L 150**  
**50.983**



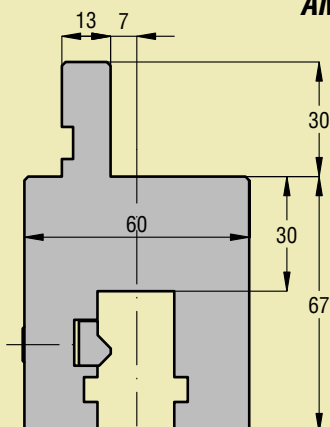
**Prolunga BEYELER RF-A**  
*BEYELER RF-A Extension*



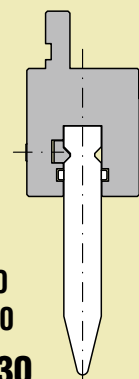
**H 100**  
**L 150**  
**50.400**



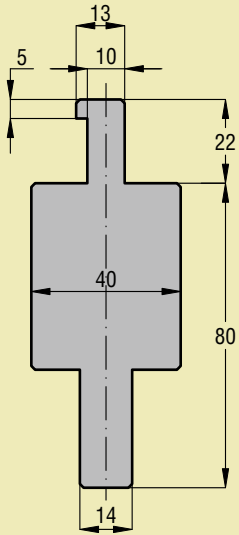
**Adattatore AMADA/WILA**  
*AMADA/WILA Adaptor*



**H 30**  
**L 150**  
**50.430**

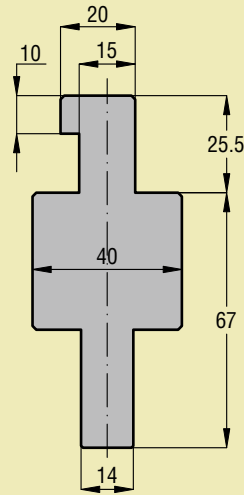
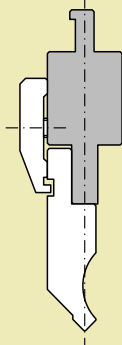






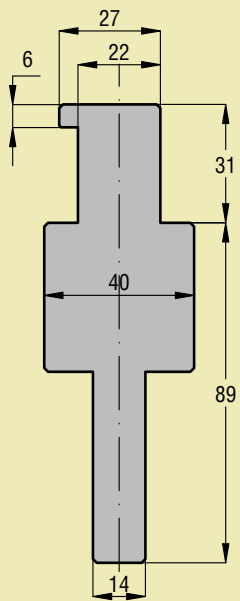
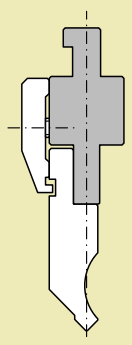
**Adattatore LVD**  
*LVD Adaptor*

**H 80**  
**L 150**  
**50.990**



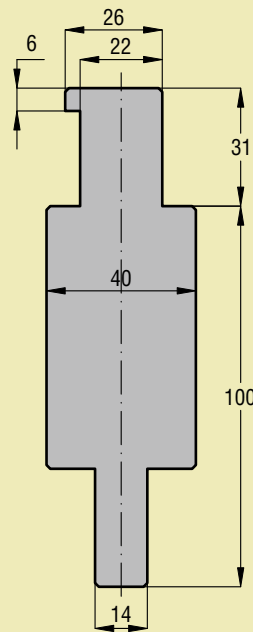
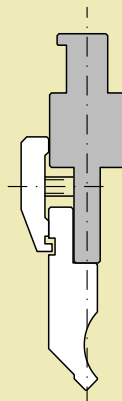
**Adattatore DURMAZLAR**  
*DURMAZLAR Adaptor*

**H 67**  
**L 150**  
**50.992**



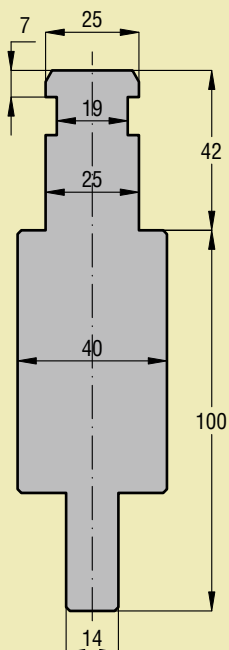
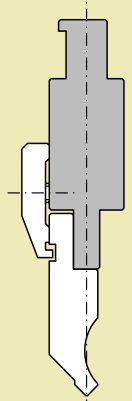
**Adattatore BAYKAL**  
*BAYKAL Adaptor*

**H 89**  
**L 150**  
**50.996**



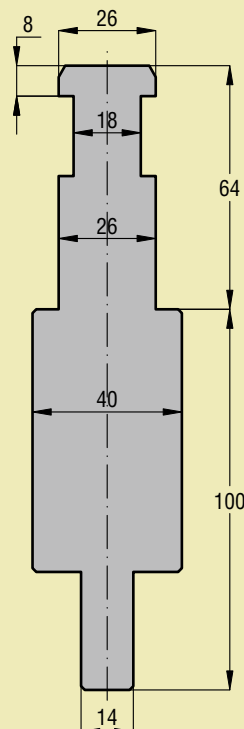
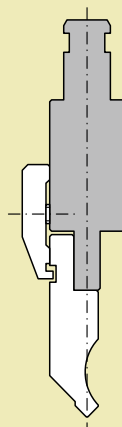
**Adattatore DARLEY**  
*DARLEY Adaptor*

**H 100**  
**L 150**  
**50.994**



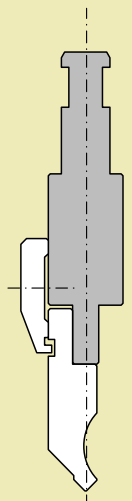
**Adattatore WEINBRENNER**  
*WEINBRENNER Adaptor*

**H 100**  
**L 150**  
**50.993**



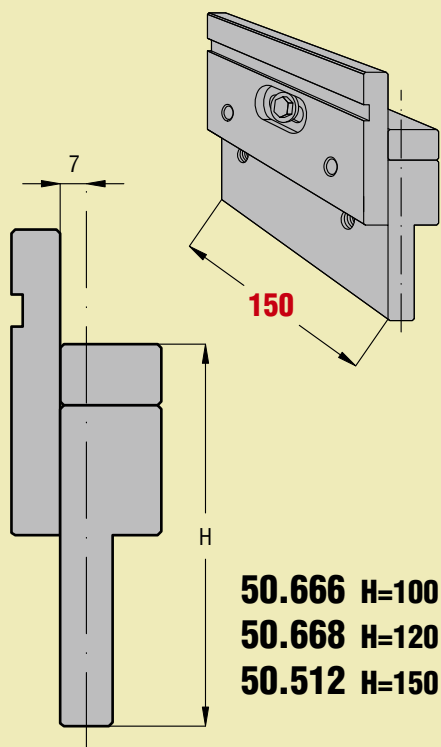
**Adattatore EHT**  
*EHT Adaptor*

**H 100**  
**L 150**  
**50.991**

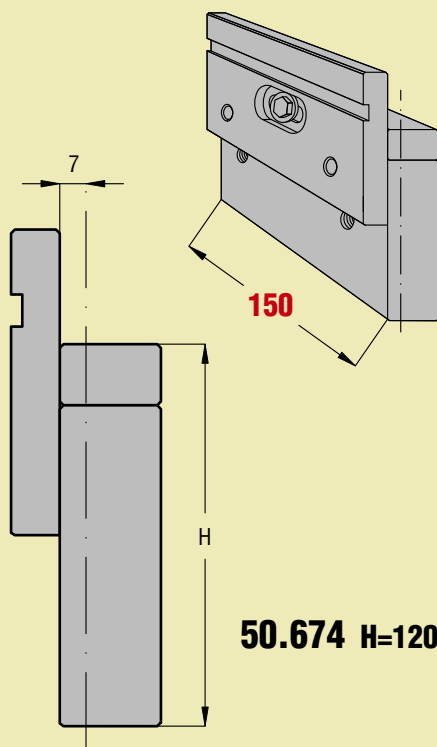


## INTERMEDIARI REGISTRABILI - ADJUSTABLE INTERMEDIATES

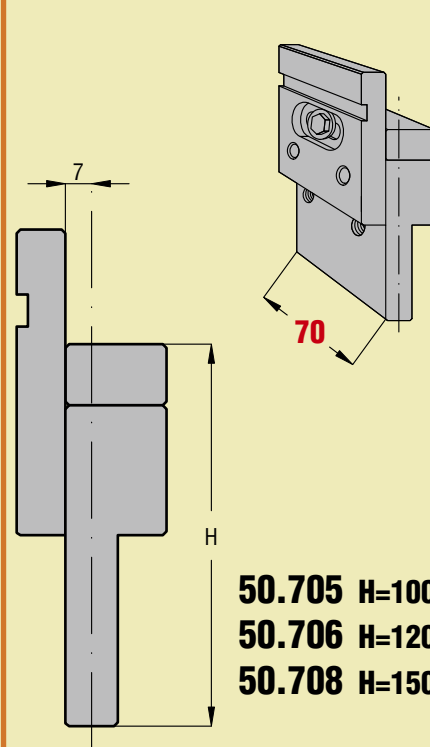
STAFFE NON COMPRESI - CLAMPS NOT INCLUDED



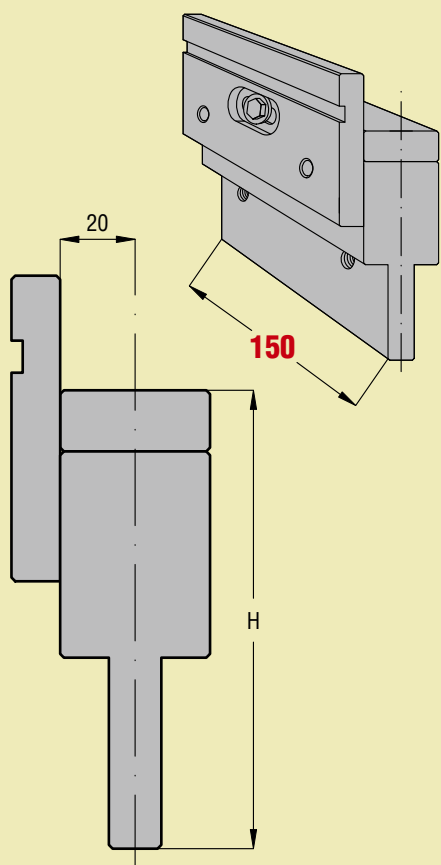
**50.666 H=100**  
**50.668 H=120**  
**50.512 H=150**



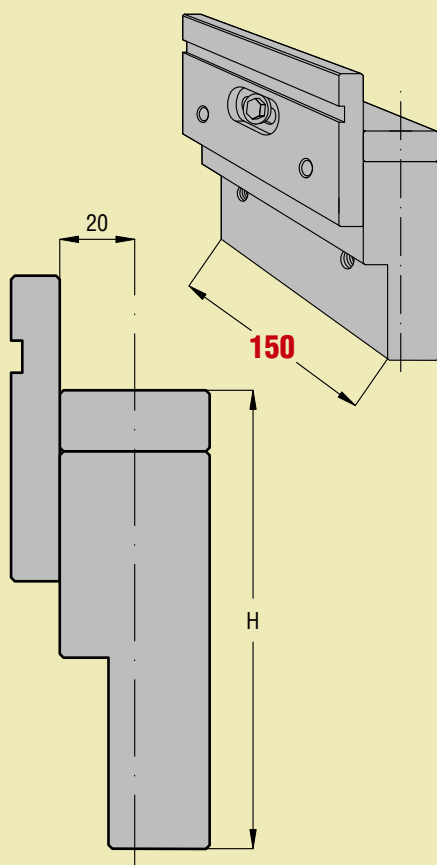
**50.674 H=120**



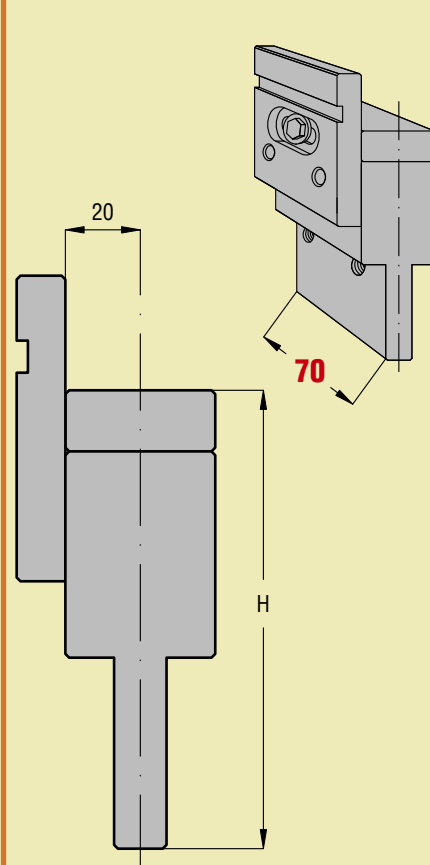
**50.705 H=100**  
**50.706 H=120**  
**50.708 H=150**



**50.667 H=120**  
**50.669 H=150**

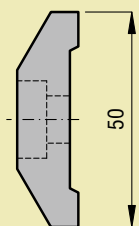


**50.673 H=120**

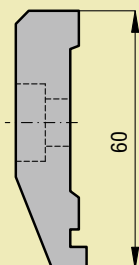
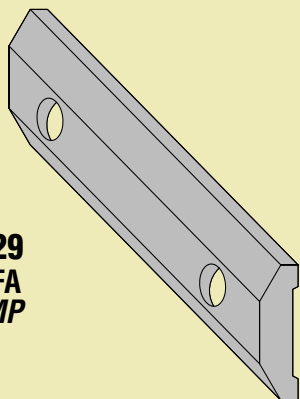


**50.707 H=120**  
**50.710 H=150**

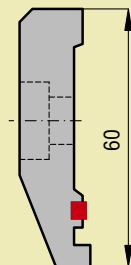
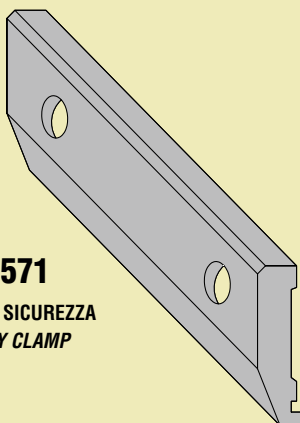
## STAFFE PER INTERMEDIARI REGISTRABILI E FISSI L=150 mm CLAMPS ABOUT CENTERING AND NOT CENTERING ADAPTORS L=150 mm



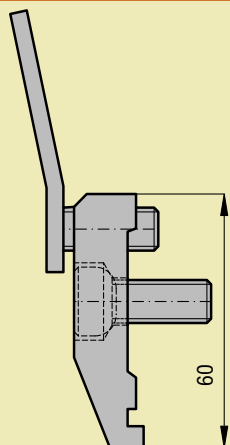
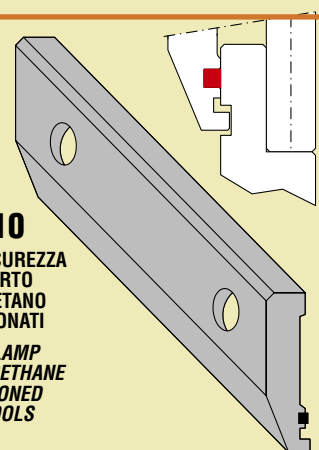
**50.529**  
STAFFA  
CLAMP



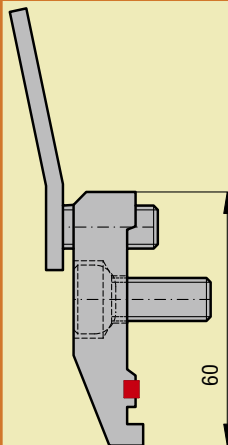
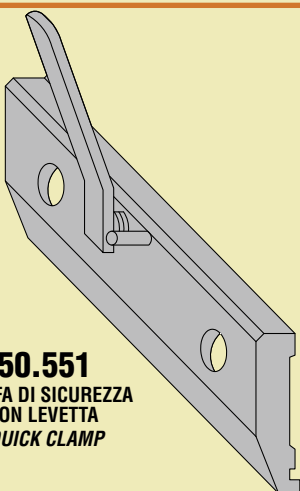
**50.571**  
STAFFA DI SICUREZZA  
SAFETY CLAMP



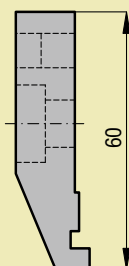
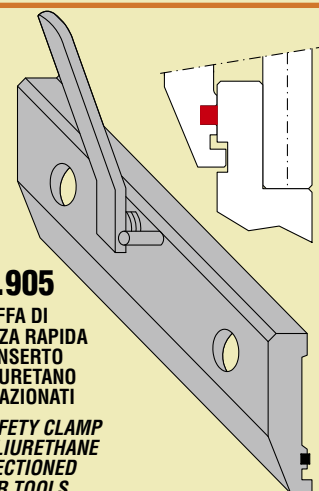
**50.910**  
STAFFA DI SICUREZZA  
CON INSERTO  
IN POLIURETANO  
PER FRAZIONATI  
SAFETY CLAMP  
WITH POLIURETHANE  
FOR SECTIONED  
UPPER TOOLS



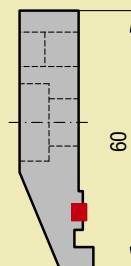
**50.551**  
STAFFA DI SICUREZZA  
CON LEVETTA  
QUICK CLAMP



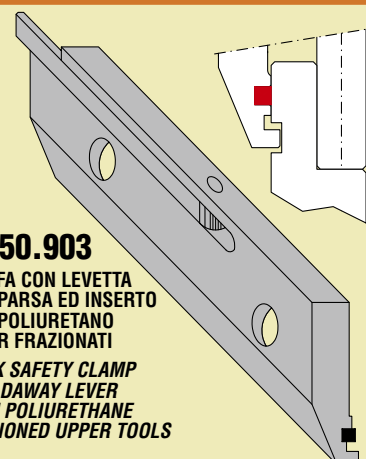
**50.905**  
STAFFA DI  
SICUREZZA RAPIDA  
CON INSERTO  
IN POLIURETANO  
PER FRAZIONATI  
QUICK SAFETY CLAMP  
WITH POLIURETHANE  
FOR SECTIONED  
UPPER TOOLS

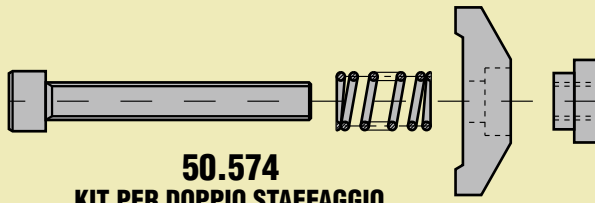


**50.900**  
STAFFA DI SICUREZZA  
CON LEVETTA A SCOMPARSA  
QUICK CLAMP  
WITH FOLDAWAY LEVER

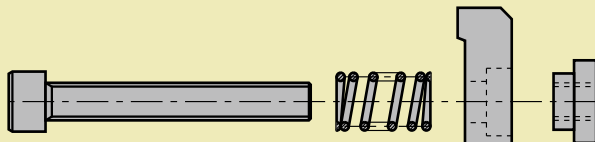
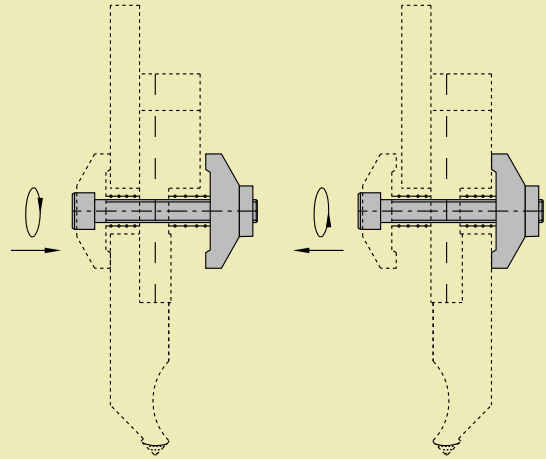


**50.903**  
STAFFA CON LEVETTA  
A SCOMPARSA ED INSERTO  
IN POLIURETANO  
PER FRAZIONATI  
QUICK SAFETY CLAMP  
FOLDAWAY LEVER  
WITH POLIURETHANE  
FOR SECTIONED UPPER TOOLS

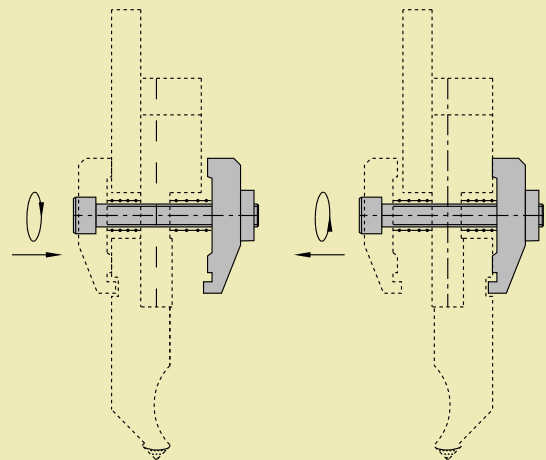




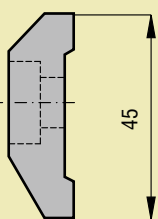
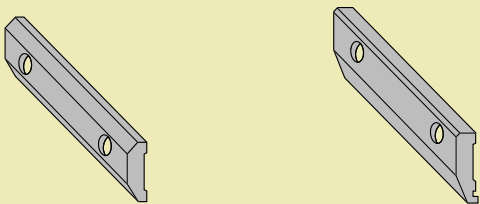
**50.574**  
KIT PER DOPPIO STAFFAGGIO  
EQUIPMENT FOR DOUBLE CLAMPING



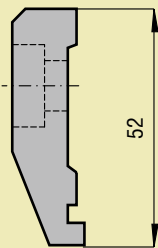
**50.577**  
KIT PER DOPPIO STAFFAGGIO  
EQUIPMENT FOR DOUBLE CLAMPING



**STAFFE PER INTERMEDIARI FISSI**  
**CLAMPS FOR ADAPTORS**  
H = 59 mm - L = 150 mm

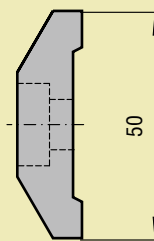
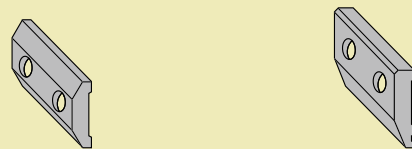


**50.310**  
STAFFA  
CLAMP

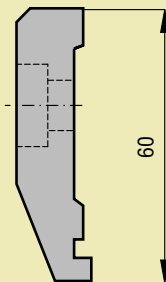


**50.712**  
STAFFA DI SICUREZZA  
SAFETY CLAMP

**STAFFE PER INTERMEDIARI REGISTRABILI**  
**CLAMPS FOR CENTERING ADAPTORS**  
L = 70 mm



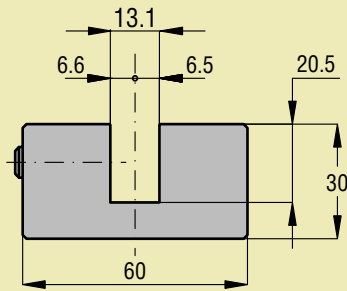
**50.697**  
STAFFA  
CLAMP



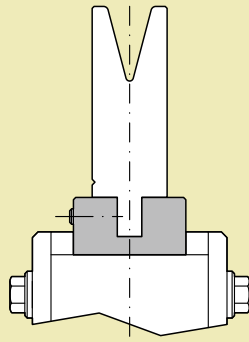
**50.693**  
STAFFA DI SICUREZZA  
SAFETY CLAMP

**Adattatore inferiore AMADA-BEYELER/TRUMPF**  
*AMADA-BEYELER/TRUMPF Lower adaptor*

**L = 1000**

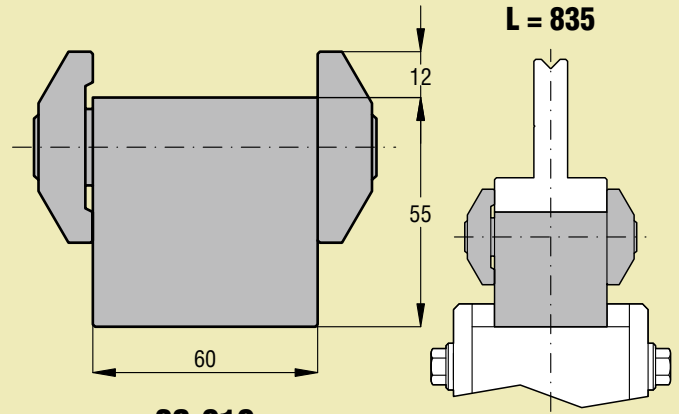


**60.910**

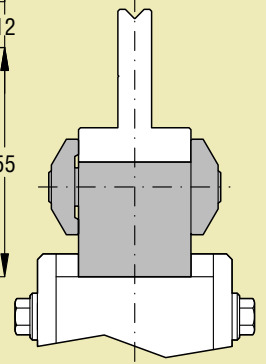


**Controtavola AMADA**  
*AMADA Lower extension*

**L = 835**

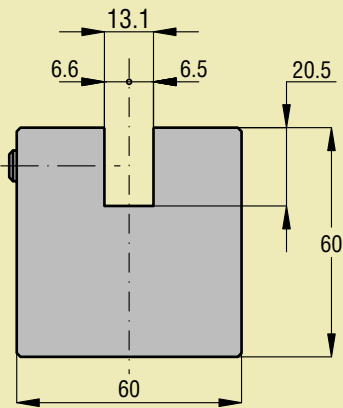


**60.919**

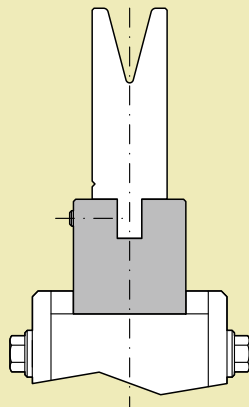


**Adattatore inferiore AMADA-BEYELER/TRUMPF**  
*AMADA-BEYELER/TRUMPF Lower Adaptor*

**L = 1000**

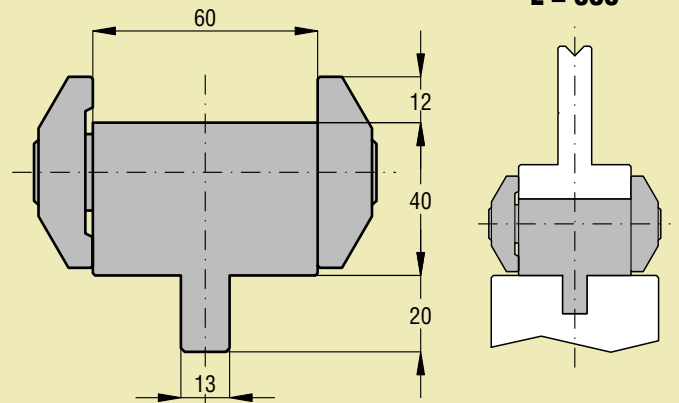


**60.920**

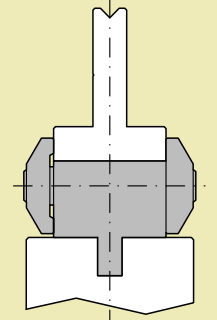


**Adattatore inferiore BEYELER/TRUMPF-AMADA**  
*BEYELER/TRUMPF-AMADA Lower Adaptor*

**L = 835**

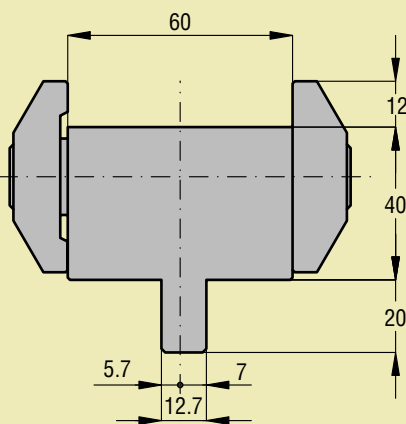


**60.925**

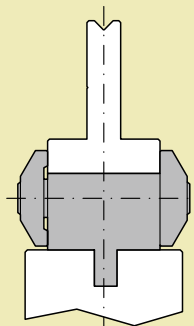


**Adattatore inferiore LVD-AMADA**  
*LVD-AMADA Lower Adaptor*

**L = 835**

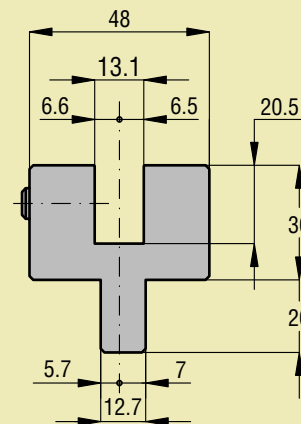


**60.930**

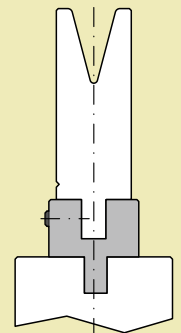


**Adattatore inferiore LVD-BEYELER/TRUMPF**  
*LVD-BEYELER/TRUMPF Lower Adaptor*

**L = 1000**



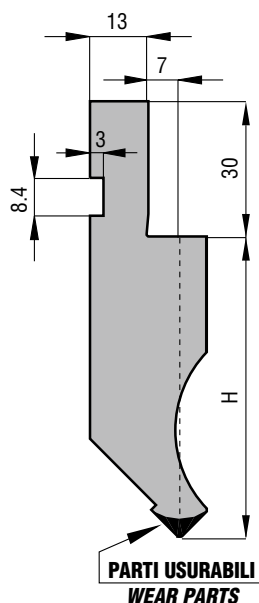
**60.935**





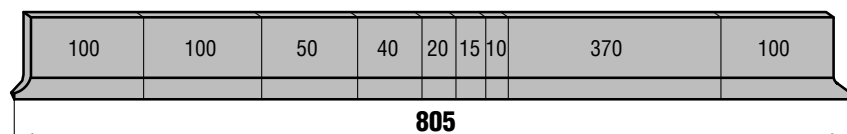
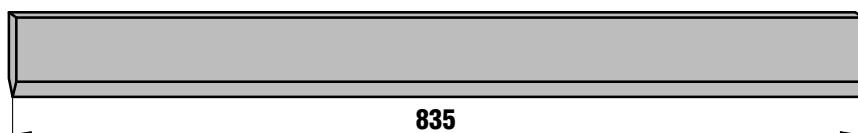
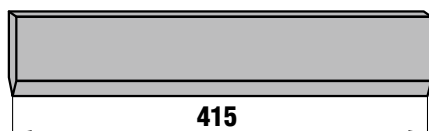
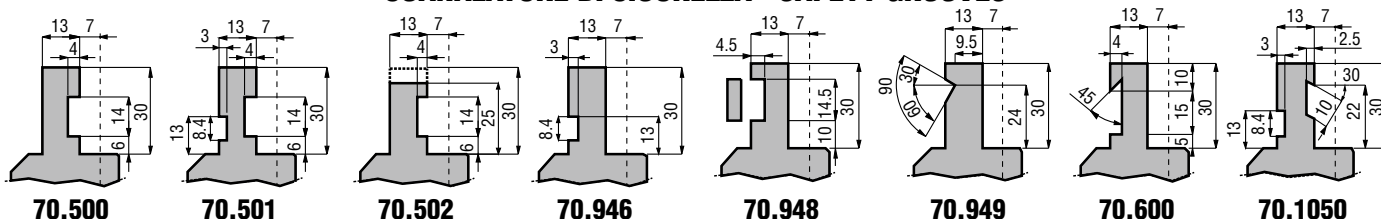
# PUNZONI AMADA/PROMECAM - AMADA/PROMECAM PUNCHES

I PUNZONI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 mm - 835 mm E FRAZIONATI (805)  
 THE PUNCHES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 mm - 835 mm AND SECTIONED (805)



<b>ACCIAIO C45 (UNI 7845-78) TEMPRATO AD INDUZIONE 52/55 HRC          SULLE PARTI USURABILI          STEEL C45 (UNI 7845-78) INDUCTION TEMPERED 52/55 HRC          ON WEAR PARTS</b>	
<b>ACCIAIO C45 (UNI 7845-78) BONIFICATO R=80-85 kg/mm<sup>2</sup>          TEMPRATO AD INDUZIONE 52/55 HRC SULLE PARTI USURABILI          STEEL C45 (UNI 7845-78) HARDENED R=80-85 kg/mm<sup>2</sup>          INDUCTION TEMPERED 52/55 HRC ON WEAR PARTS</b>	
<b>ACCIAIO 42CrMo4 (UNI EN 10083-93) BONIFICATO R=95-105 kg/mm<sup>2</sup>          TEMPRATO AD INDUZIONE 52/55 HRC SULLE PARTI USURABILI          STEEL 42CrMo4 (UNI EN 10083-93) HARDENED R=95-105 kg/mm<sup>2</sup>          INDUCTION TEMPERED 52/55 HRC ON WEAR PARTS</b>	

## SCANALATURE DI SICUREZZA - SAFETY GROOVES

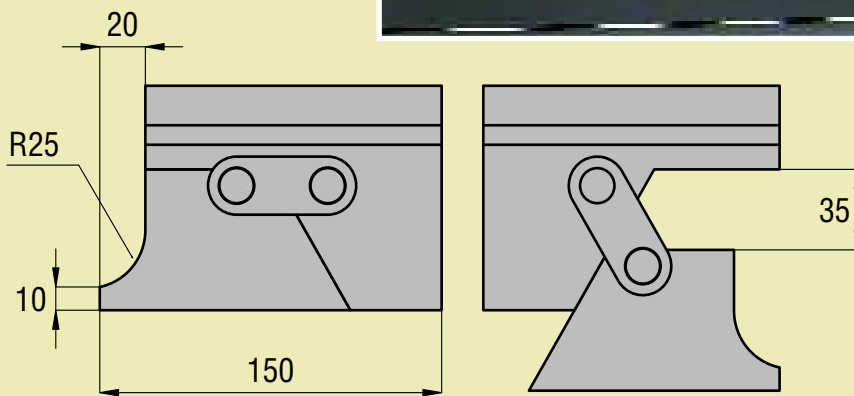
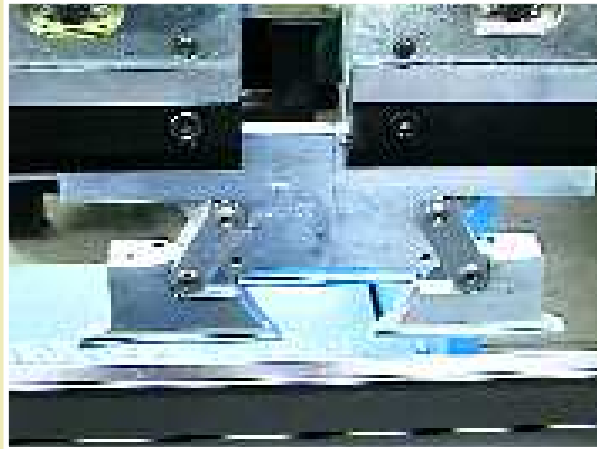


**FRAZIONATURA STANDARD  
 STANDARD SECTIONING**

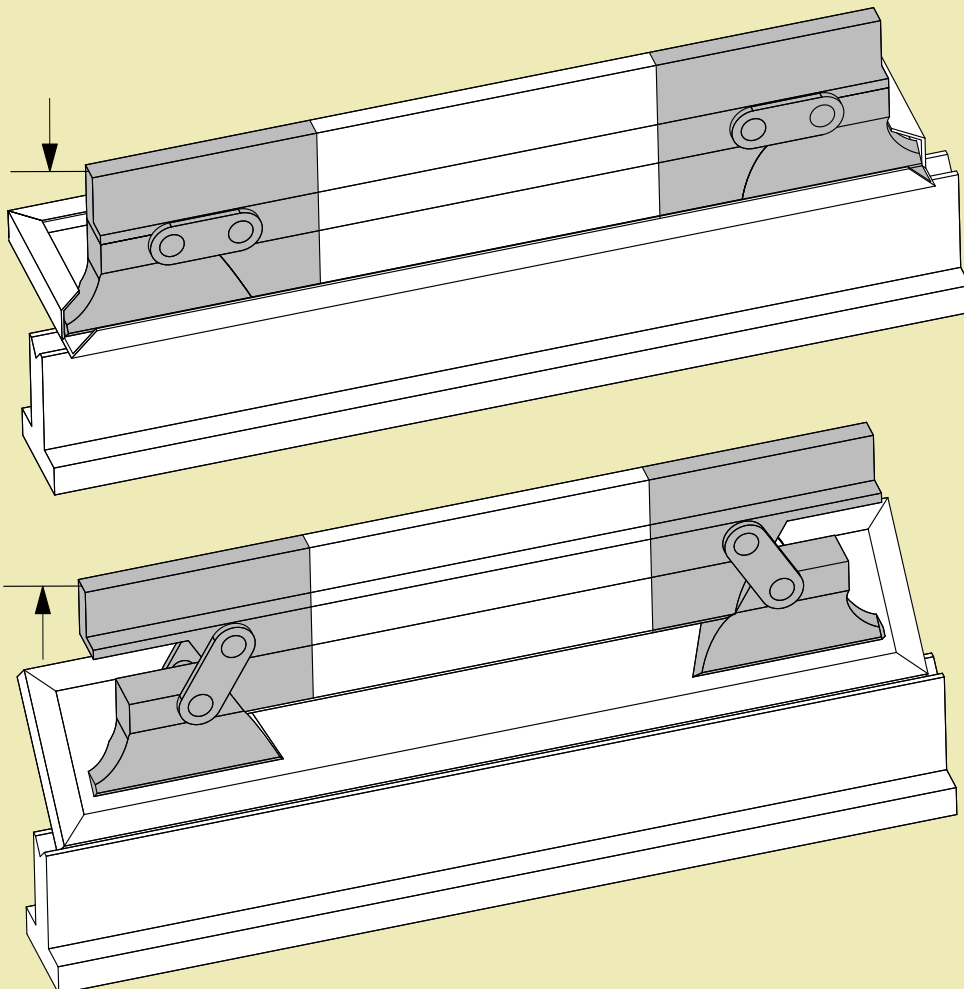
## SCHEMA SCARPETTE FRAZIONATO STANDARD - HORNS SCHEME STANDARD SECTIONING

	10.142	10.262	10.520	11.200	
	10.143	10.263	11.100	11.201	
	10.152	10.264	11.101	11.228	
	10.153	10.500	11.105	11.230	
	10.154	10.501	11.106	11.233	
	10.155	10.502	11.107	11.240	
	10.156	10.503	11.108	11.241	
	10.157	10.504	11.145	11.256	
	10.173	10.505	11.146	11.257	
	10.174	10.506	11.147	11.259	
	10.175	10.510	11.148	11.260	
	10.176	10.516	11.149		
	10.261	10.517	11.151		
	10.136	11.528			
	10.150	11.530			
	10.511	11.540			
10.512	11.550				
10.514	11.554				
10.515	11.560				
11.102	11.600				
11.103	11.710				
11.104	11.720				
11.134	11.750				
11.158	11.780				
11.258	11.810				
11.514					

**SCARPETTE MOBILI DA ABBINARE AI MODELLI ELENCATI**  
**MOVING HORNS FOR COUPLING WITH LISTED MODELS**

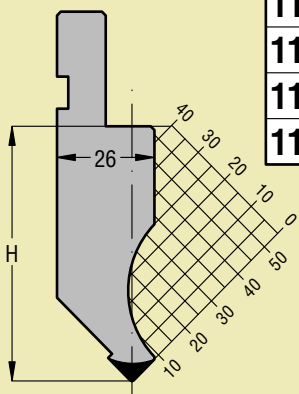


<b>CODICE SCARPETTE MOBILE</b> <b>CODE MOVING HORNS</b>	<b>CODICE PUNZONE</b> <b>CODE PUNCH</b>
<b>40.110</b>	<b>10.152</b>
<b>40.111</b>	<b>10.153</b>
<b>40.112</b>	<b>11.100</b>
<b>40.113</b>	<b>11.145</b>



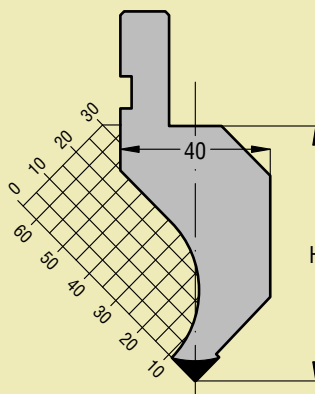
90° 88° 85°

Cod.	$\alpha$	R	H	Max T/mt
10.152	90	0.25	66.60	100
11.100	90	0.80	66.60	100
10.153	88	0.25	66.50	100
11.145	88	0.80	66.50	100
11.101	88	3.00	65.45	100
11.200	85	0.80	66.50	100
11.201	85	3.00	65.45	100



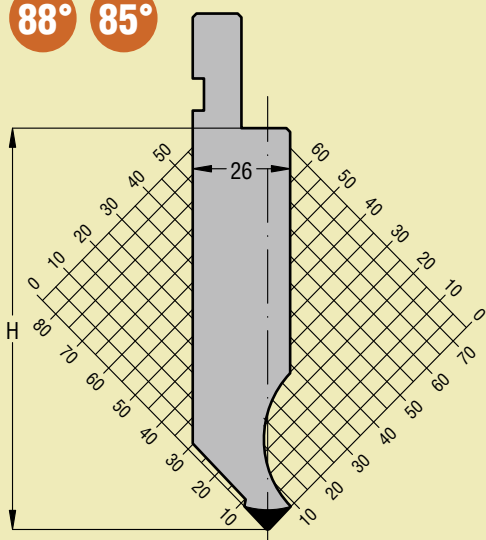
90° 88°

Cod.	$\alpha$	R	H	Max T/mt
11.241	90	0.80	66.50	80
11.240	88	0.80	66.50	80



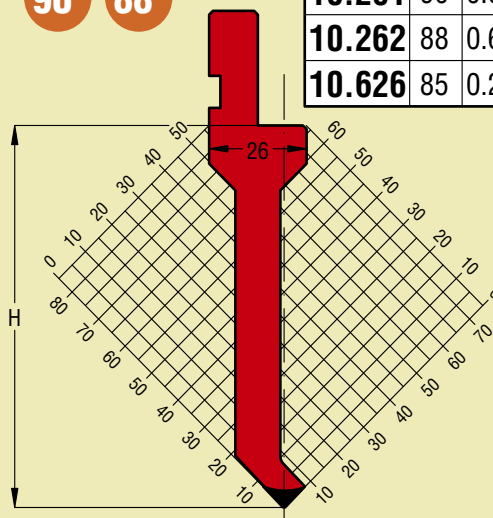
88° 85°

Cod.	$\alpha$	R	H	Max T/mt
11.228	88	0.80	105.00	100
11.230	85	0.80	105.00	100



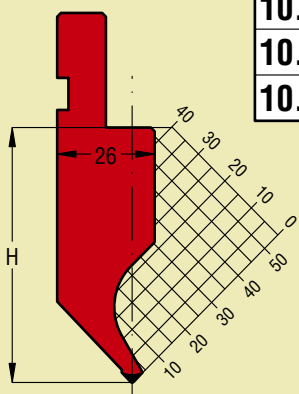
90° 88°

Cod.	$\alpha$	R	H	Max T/mt
10.263	90	0.25	100.00	50
10.264	88	0.25	100.00	50
10.261	90	0.60	100.00	50
10.262	88	0.60	100.00	50
10.626	85	0.25	100.00	70



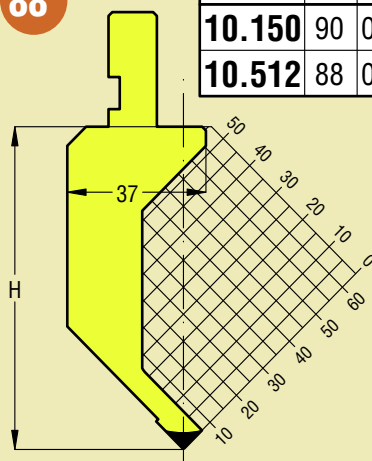
90° 88°

Cod.	$\alpha$	R	H	Max T/mt
10.173	90	0.25	66.70	35
10.174	88	0.25	66.70	35
10.175	90	0.60	66.75	35
10.176	88	0.60	66.74	35



90° 88°

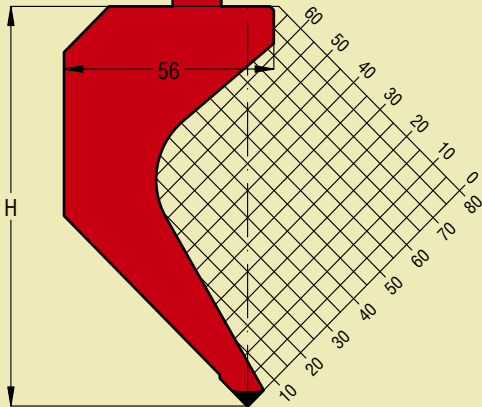
Cod.	$\alpha$	R	H	Max T/mt
10.150	90	0.60	84.13	20
10.512	88	0.60	84.13	20





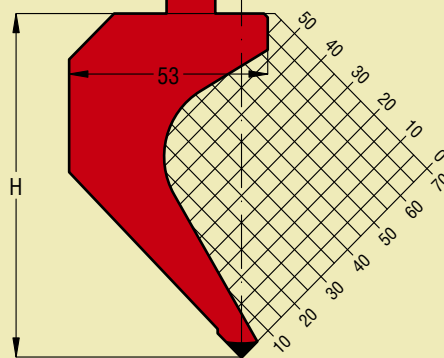
90° 88°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.503</b>	90	0.20	104.70	50
<b>10.504</b>	88	0.80	104.50	50



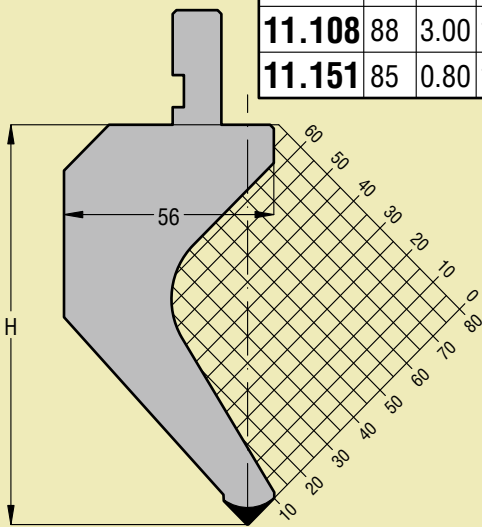
90° 88°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.501</b>	90	0.20	90.00	50
<b>10.502</b>	88	0.80	89.70	50
<b>10.672</b>	85	0.25	90.00	50



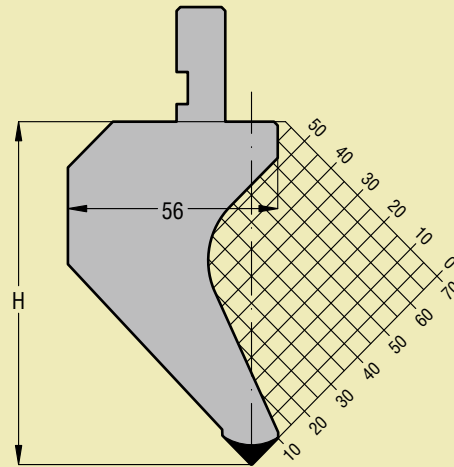
90° 88° 85°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.156</b>	90	0.25	104.50	50
<b>11.107</b>	90	0.80	104.50	50
<b>10.157</b>	88	0.25	104.50	50
<b>11.147</b>	88	0.80	104.50	50
<b>11.108</b>	88	3.00	103.50	50
<b>11.151</b>	85	0.80	104.50	50



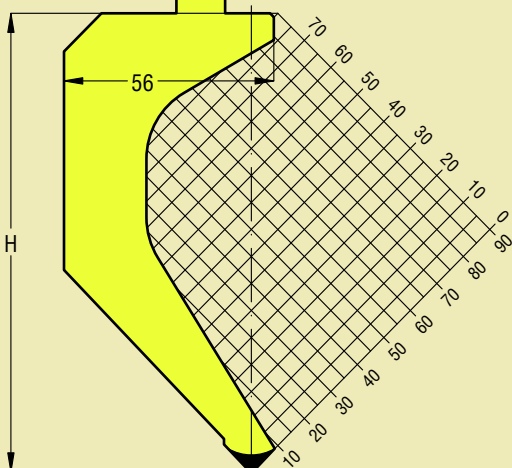
90° 88°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.154</b>	90	0.25	89.60	60
<b>11.105</b>	90	0.80	89.60	60
<b>10.155</b>	88	0.25	89.60	60
<b>11.146</b>	88	0.80	89.58	60
<b>11.106</b>	88	3.00	88.50	60



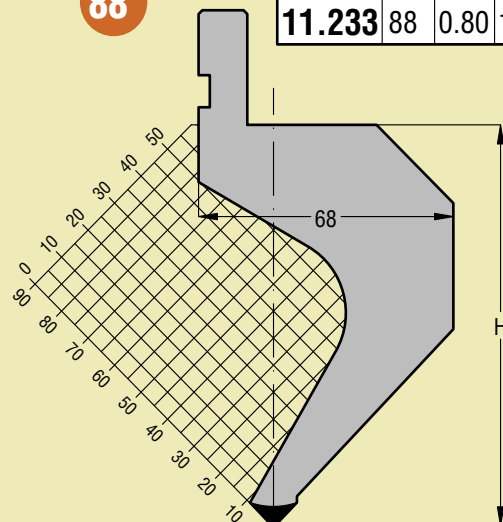
88°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.505</b>	88	0.80	120.00	50

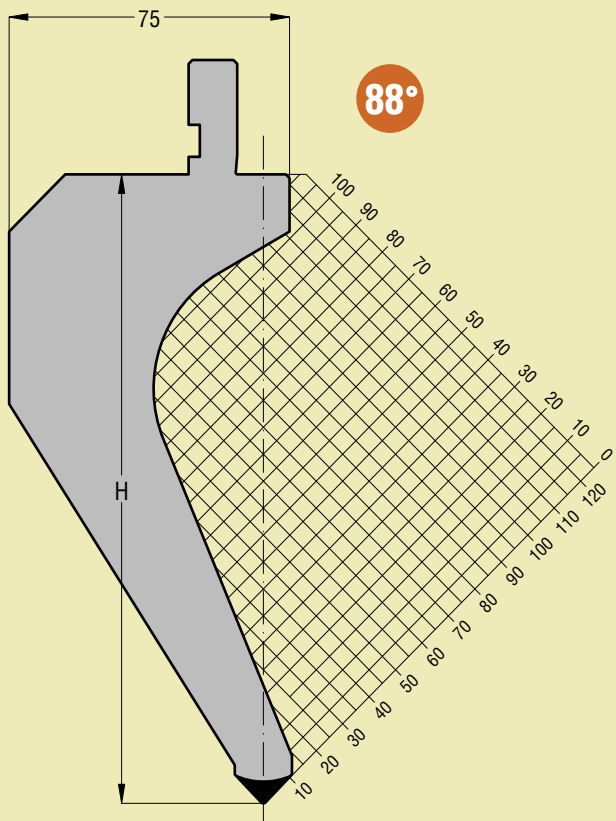


88°

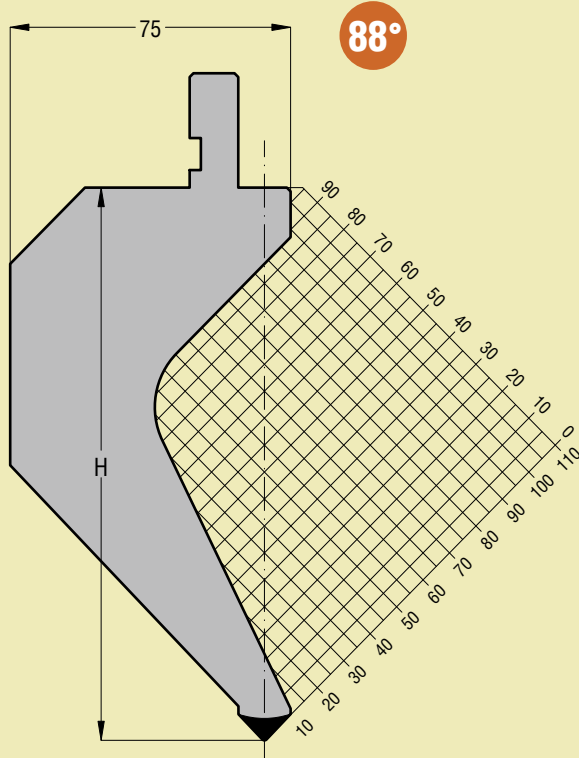
Cod.	$\alpha$	R	H	Max T/mt
<b>11.233</b>	88	0.80	105.00	45



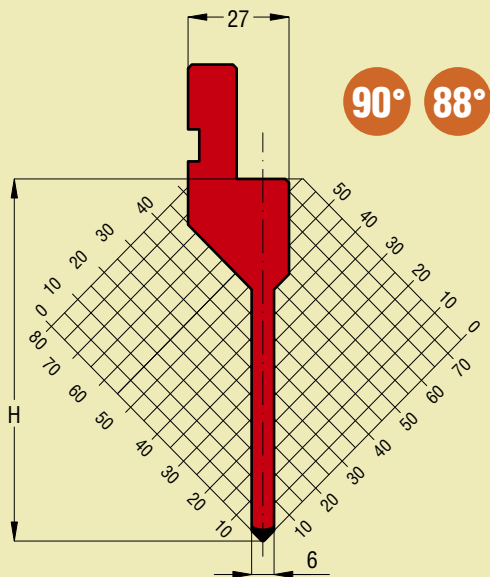
Cod.	$\alpha$	R	H	Max T/mt
<b>11.149</b>	88°	0.80	165.00	60



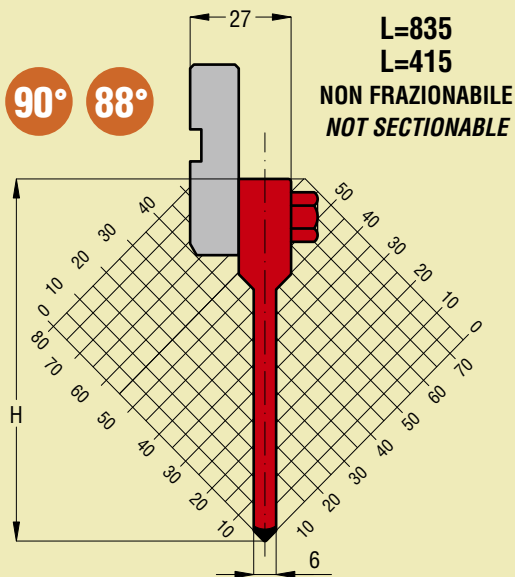
Cod.	$\alpha$	R	H	Max T/mt
<b>11.148</b>	88°	0.80	145.00	70

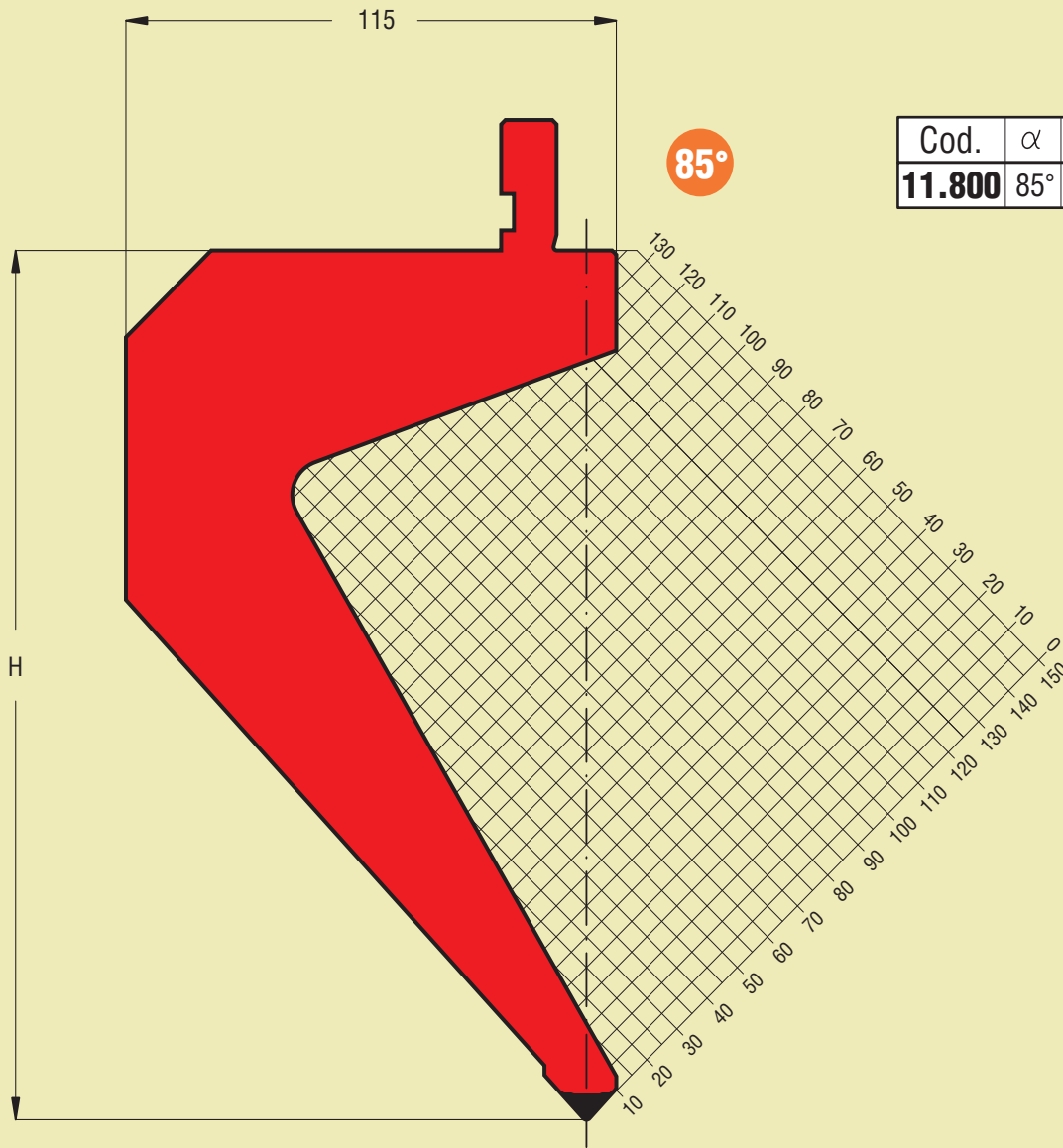


Cod.	$\alpha$	R	H	Max T/mt
<b>11.256</b>	90°	0.25	95.00	50
<b>11.257</b>	88°	0.25	95.00	50
<b>11.259</b>	90°	0.60	95.00	50
<b>11.260</b>	88°	0.60	95.00	50

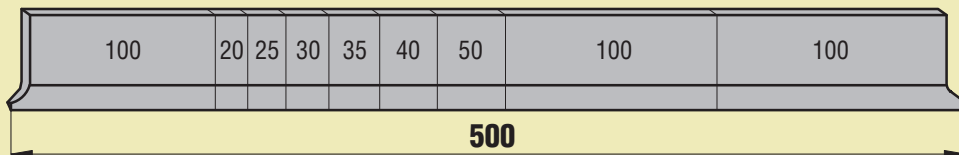
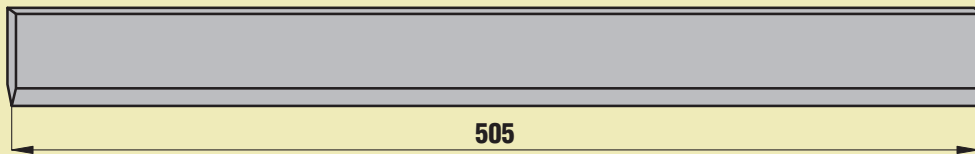


Cod.	$\alpha$	R	H	Max T/mt
<b>10.256</b>	90°	0.25	95.00	50
<b>10.257</b>	88°	0.25	95.00	50
<b>10.259</b>	90°	0.60	95.00	50
<b>10.260</b>	88°	0.60	95.00	50



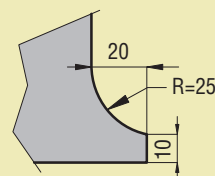


Cod.	$\alpha$	R	H	Max T/mt
11.800	85°	1.00	200.00	70



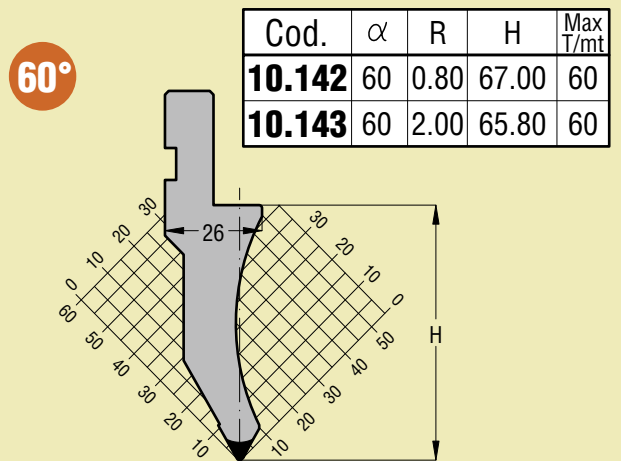
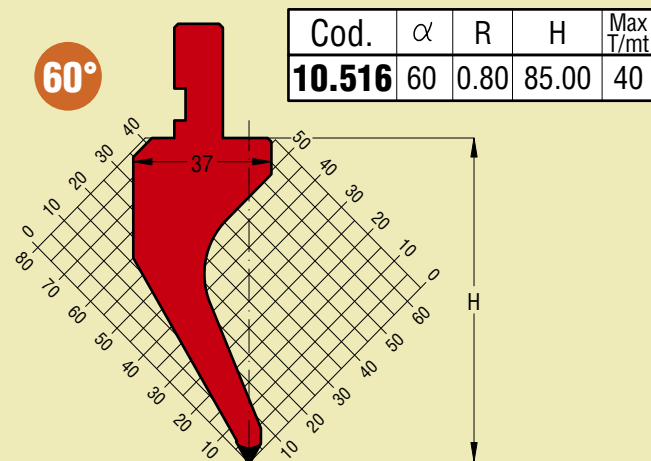
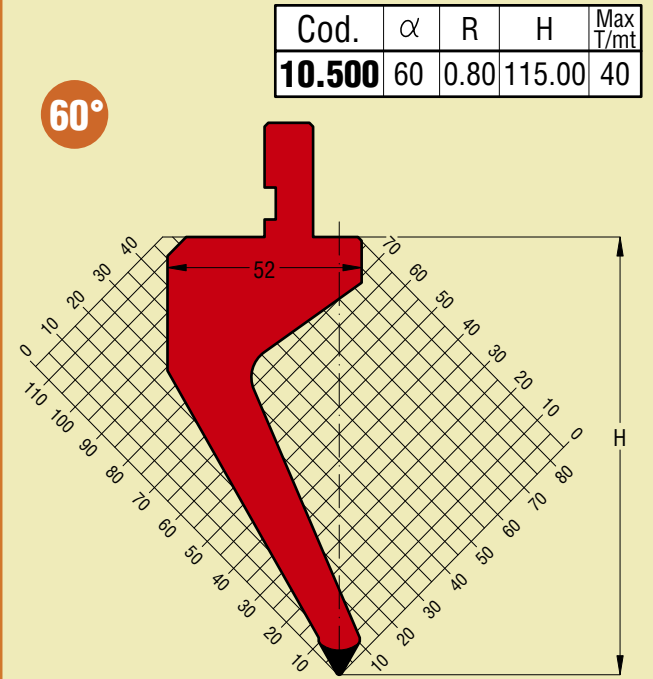
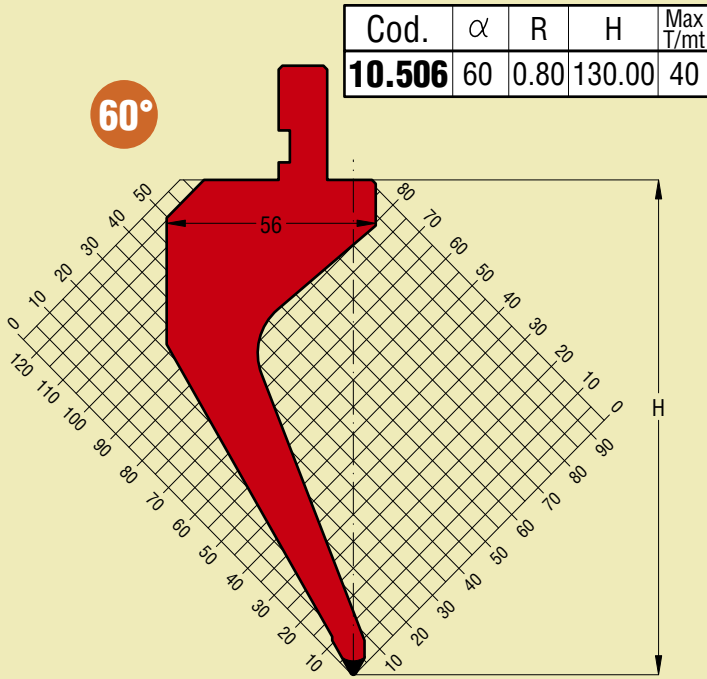
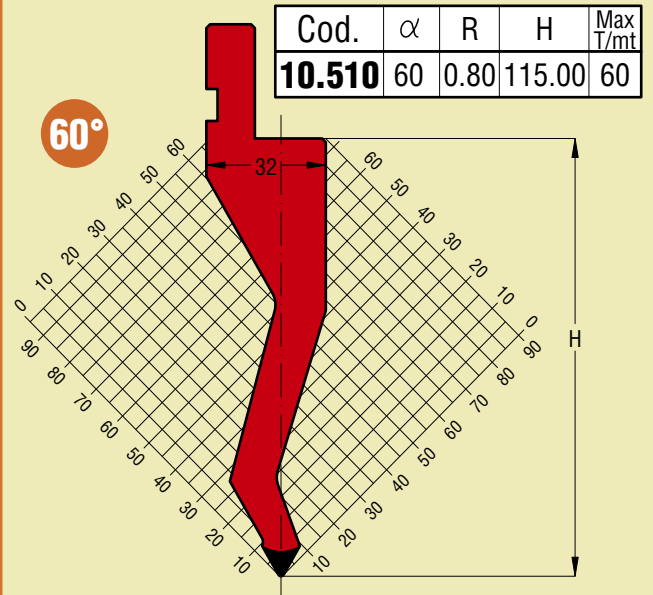
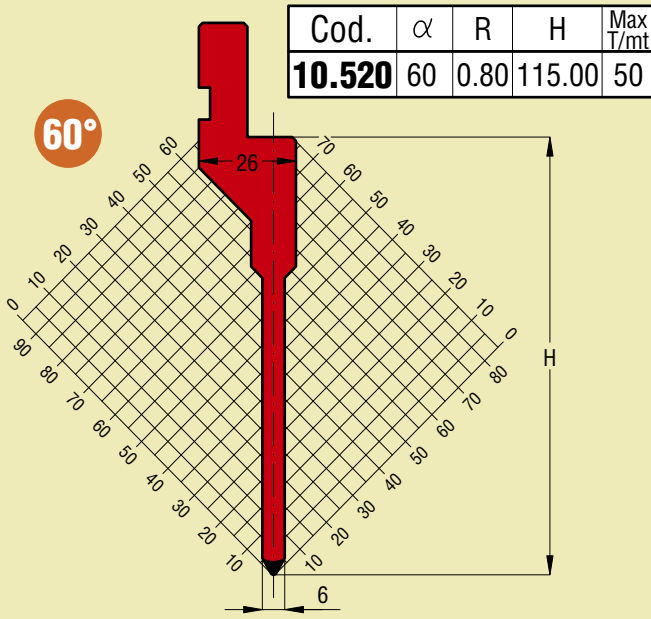
**FRAZIONATURA STANDARD  
STANDARD SECTIONING**

**SCHEMA SCARPETTE FRAZIONATO STANDARD  
HORNS SCHEME STANDARD SECTIONING**



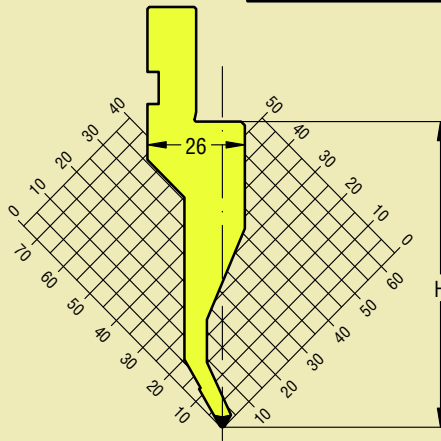


# PUNZONI AMADA/PROMECAM - AMADA/PROMECAM PUNCHES



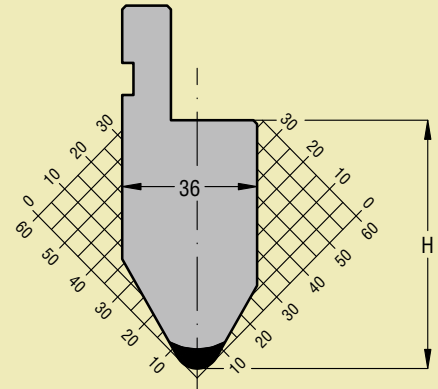
60°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.517</b>	60	0.80	80.00	25



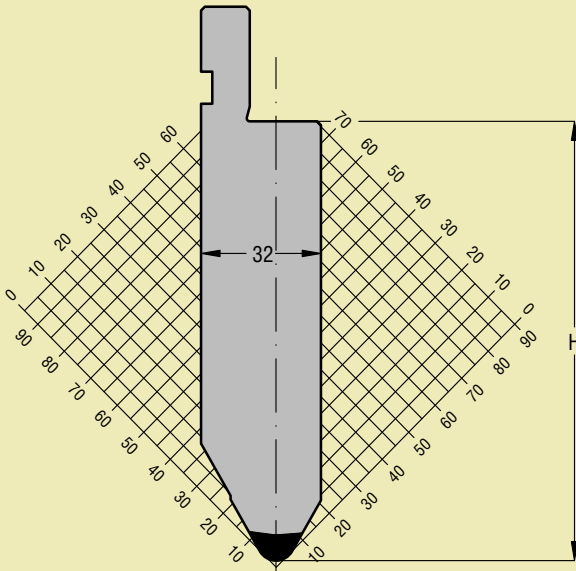
60°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.136</b>	60	6.00	65.00	100



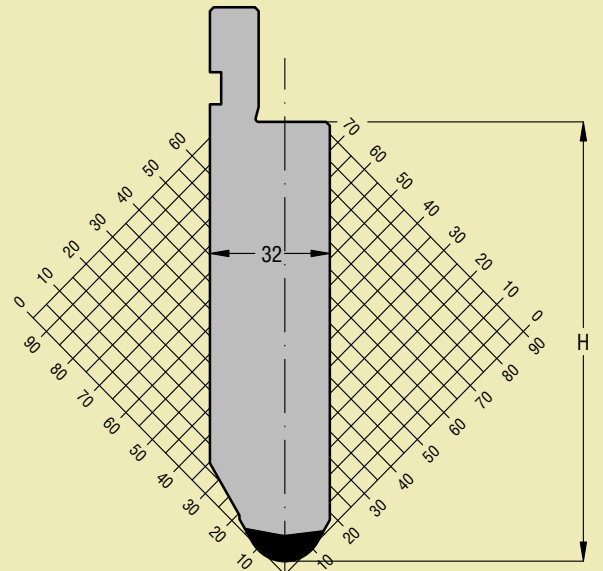
60°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.710</b>	60	5.00	115.00	100



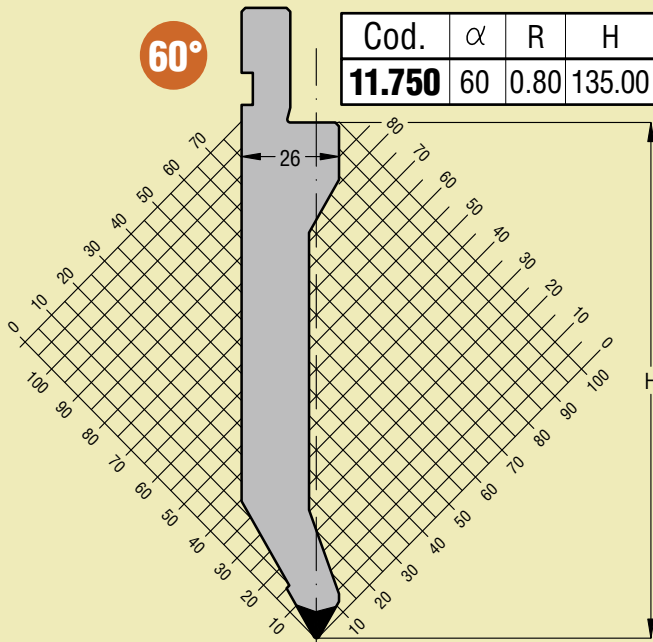
60°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.720</b>	60	10.00	115.00	100



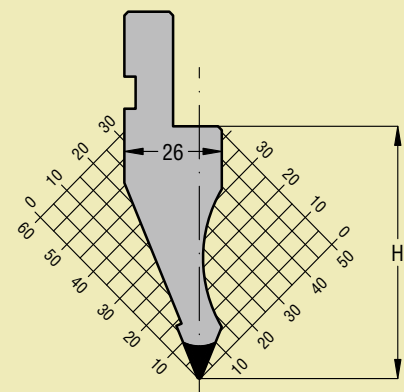
60°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.750</b>	60	0.80	135.00	70



45°

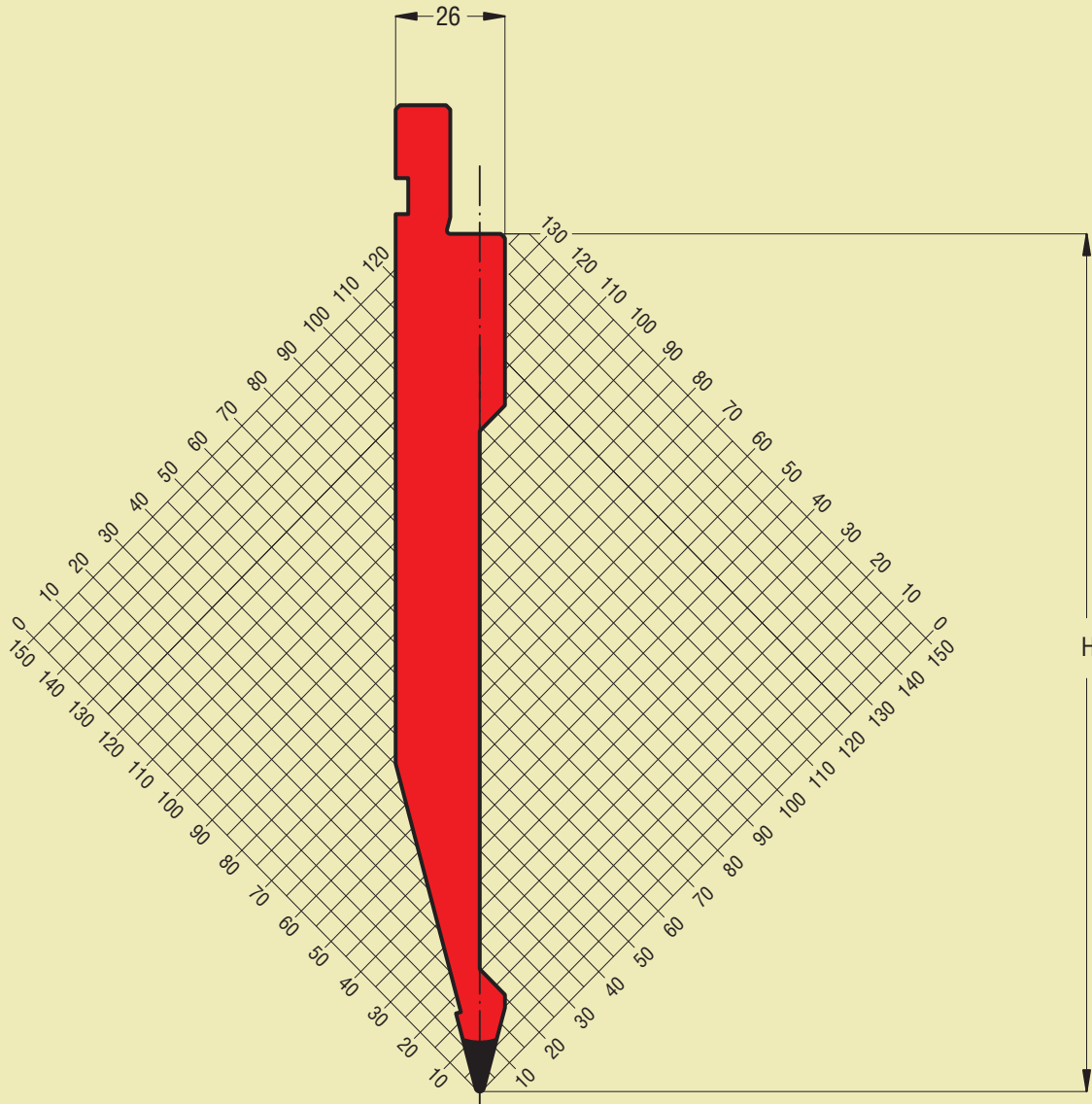
Cod.	$\alpha$	R	H	Max T/mt
<b>11.134</b>	45	0.60	66.30	80
<b>11.102</b>	45	1.00	65.20	80





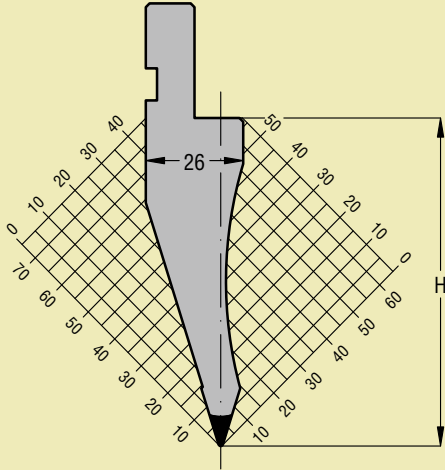
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.810</b>	30°	1.00	200.00	50



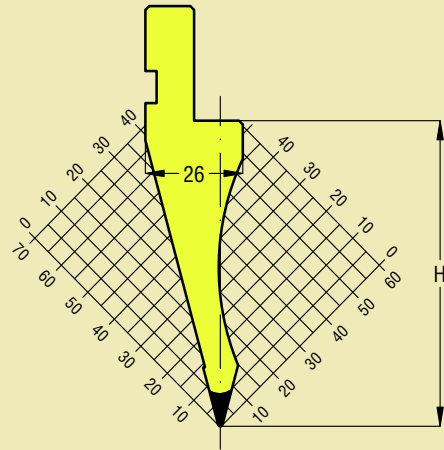
35°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.103</b>	35	0.60	86.00	70
<b>11.104</b>	35	1.50	86.00	70
<b>11.600</b>	35	0.80	90.00	70



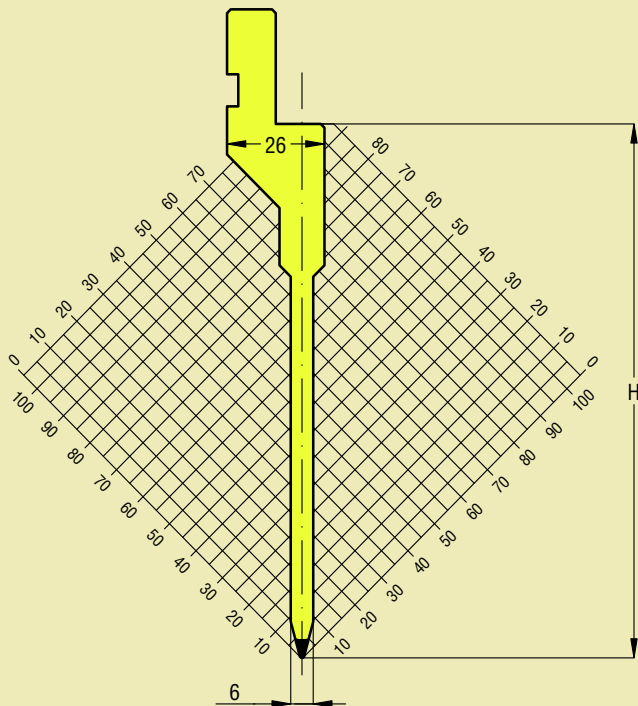
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.514</b>	30	0.60	80.00	50



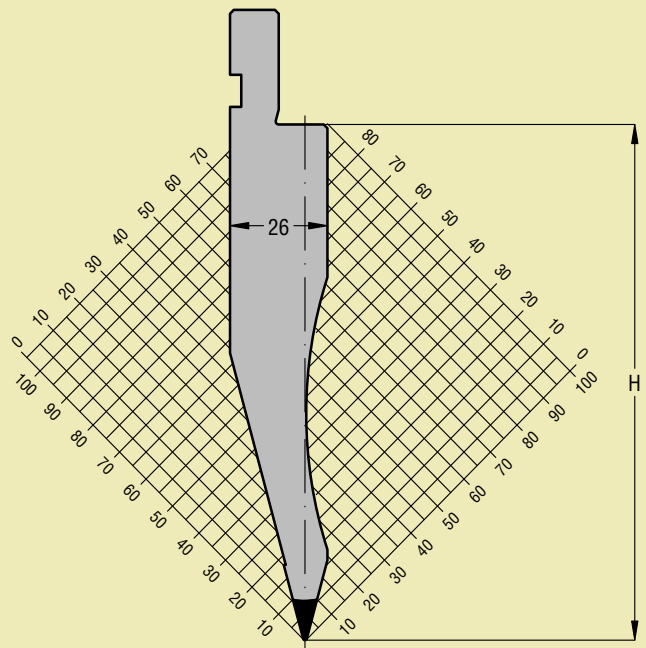
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.515</b>	30	0.60	140.00	50



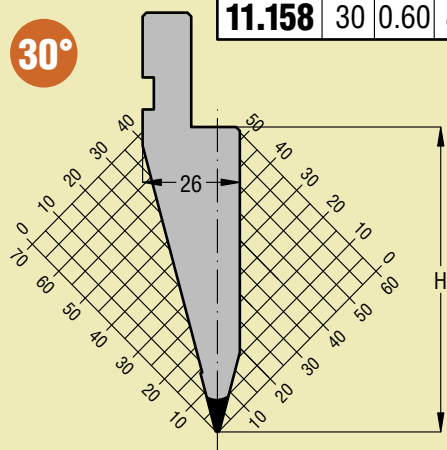
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.780</b>	30	0.50	135.00	80



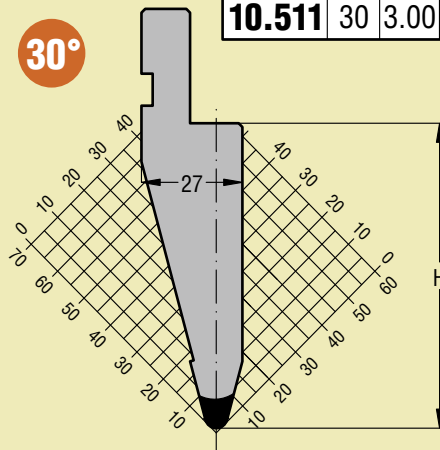
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.158</b>	30	0.60	80.00	100



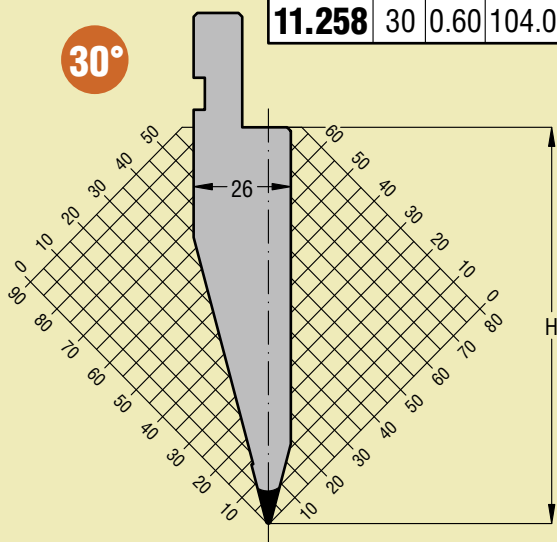
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>10.511</b>	30	3.00	80.00	100



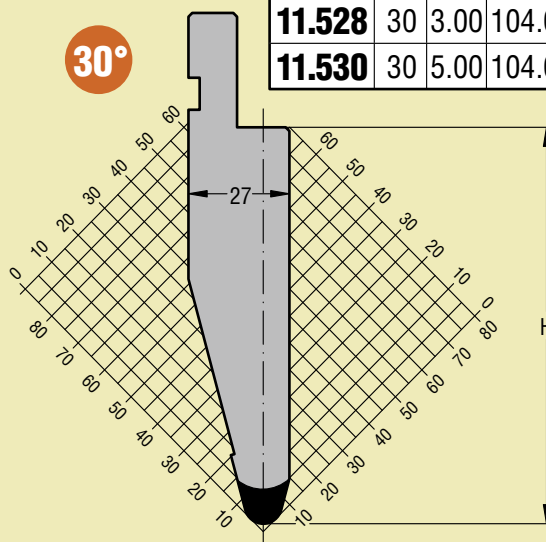
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.258</b>	30	0.60	104.00	100



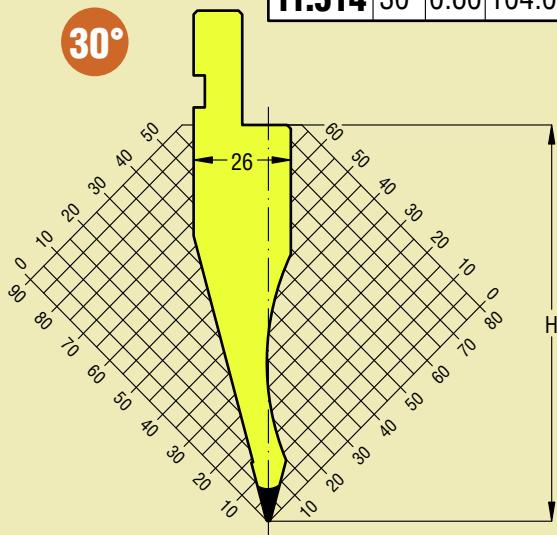
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.528</b>	30	3.00	104.00	100
<b>11.530</b>	30	5.00	104.00	100



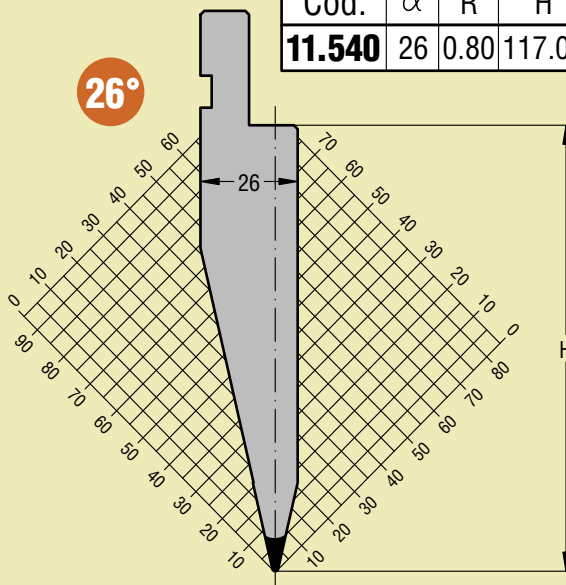
30°

Cod.	$\alpha$	R	H	Max T/mt
<b>11.514</b>	30	0.60	104.00	50

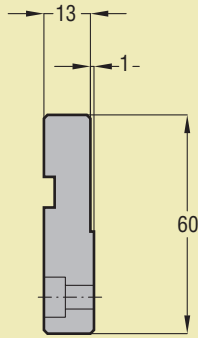


26°

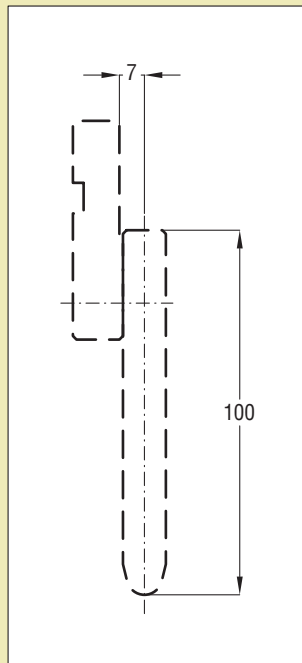
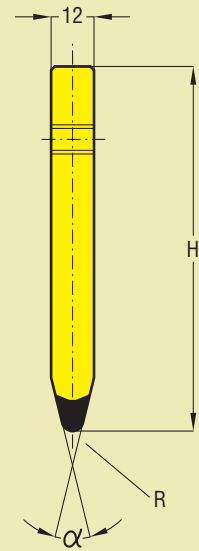
Cod.	$\alpha$	R	H	Max T/mt
<b>11.540</b>	26	0.80	117.00	100







**Cod.**  
**10.400**



Cod.	$\alpha$	R	H	Max T/mt
<b>15.761</b>	28	0.50	100	100
<b>15.763</b>	28	1.00	100	100
<b>15.765</b>	28	2.00	100	100
<b>15.766</b>	28	3.00	100	100
<b>15.767</b>	28	4.00	100	100
<b>15.768</b>	28	5.00	100	100
<b>15.769</b>	28	6.00	100	100

**28°**

Cod.	$\alpha$	R	H	Max T/mt
<b>15.774</b>	84	1.00	100	100

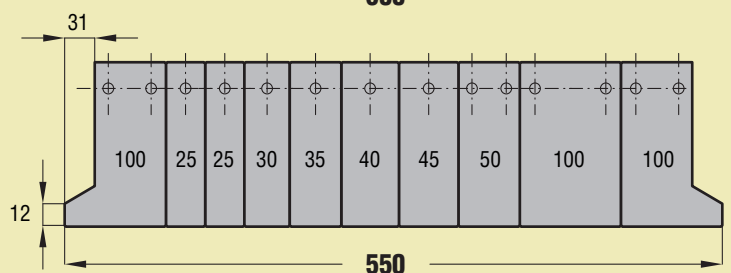
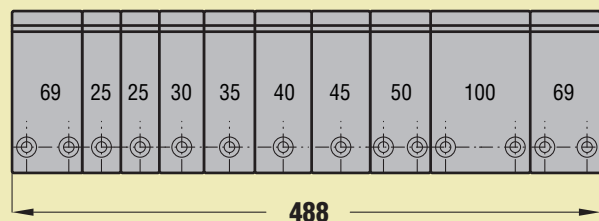
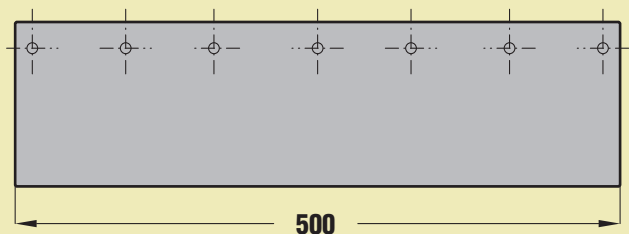
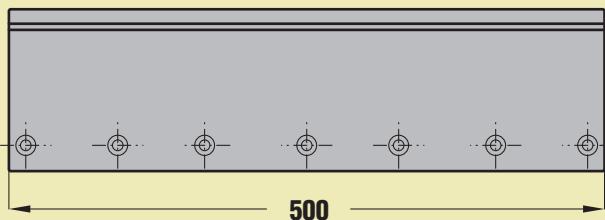
**84°**

Cod.	$\alpha$	R	H	Max T/mt
<b>15.776</b>	86	1.00	100	100

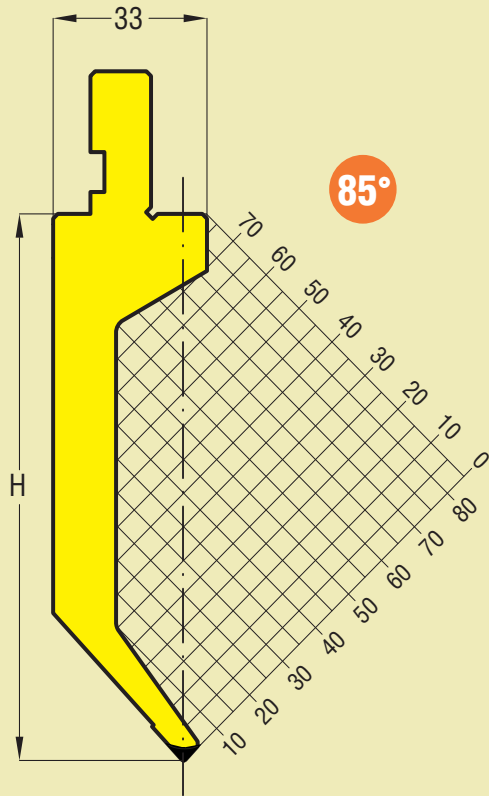
**86°**

Cod.	$\alpha$	R	H	Max T/mt
<b>15.782</b>	90	0.50	100	100
<b>15.784</b>	90	1.00	100	100
<b>15.787</b>	90	1.50	100	100
<b>15.788</b>	90	2.00	100	100

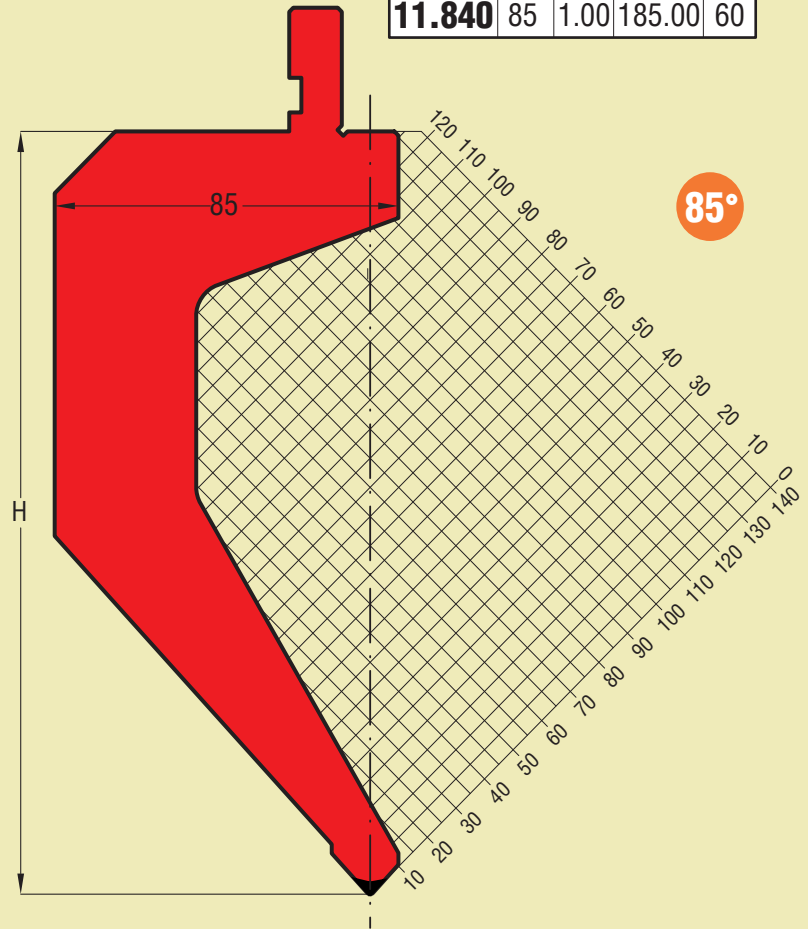
**90°**



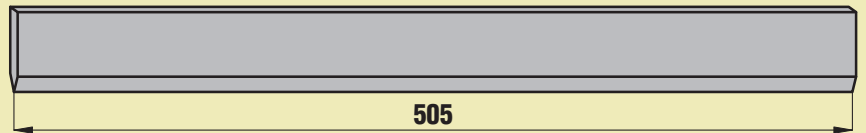
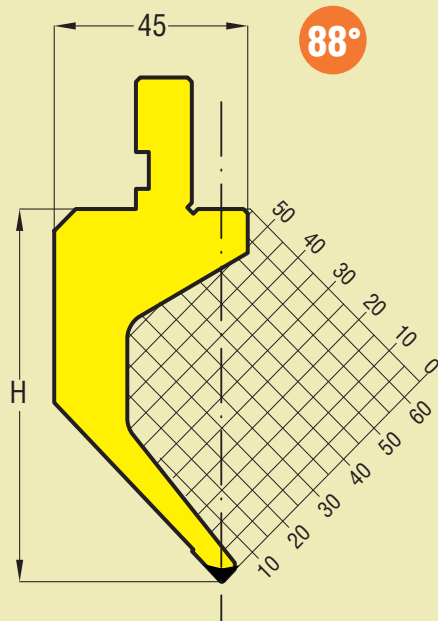
Cod.	$\alpha$	R	H	Max T/mt
<b>11.820</b>	85	0.60	115.00	20



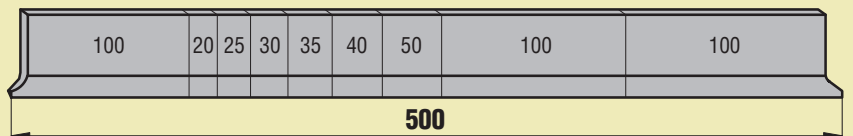
Cod.	$\alpha$	R	H	Max T/mt
<b>11.840</b>	85	1.00	185.00	60



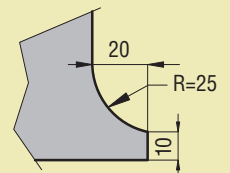
Cod.	$\alpha$	R	H	Max T/mt
<b>11.830</b>	88	0.60	85.00	15



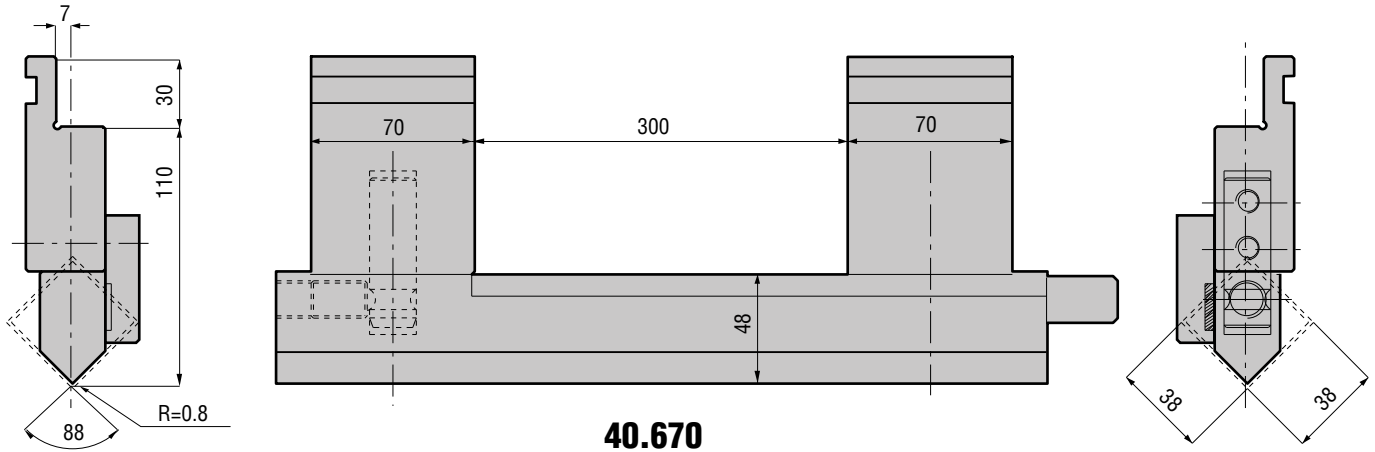
**FRAZIONATURA STANDARD  
STANDARD SECTIONING**



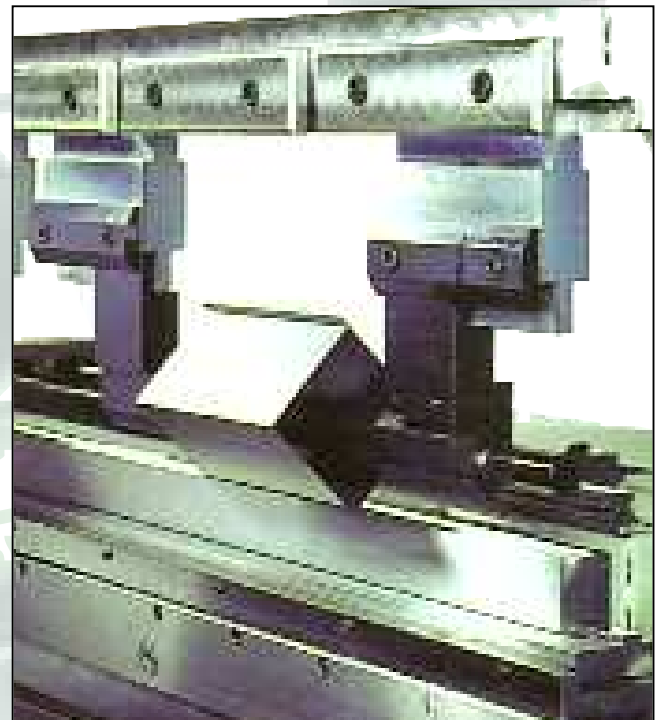
**SCHEMA SCARPETTE FRAZIONATO STANDARD  
HORNS SCHEME STANDARD SECTIONING**



15 T/m

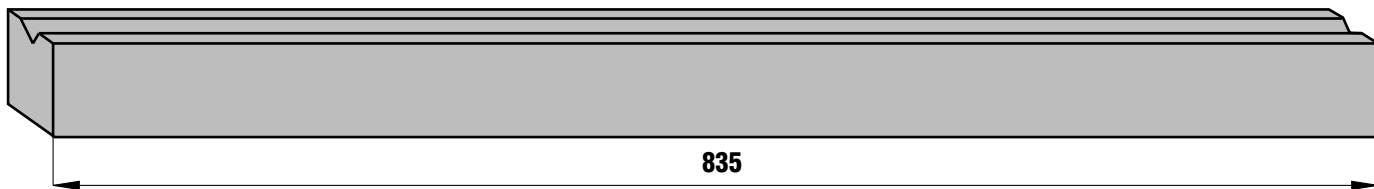
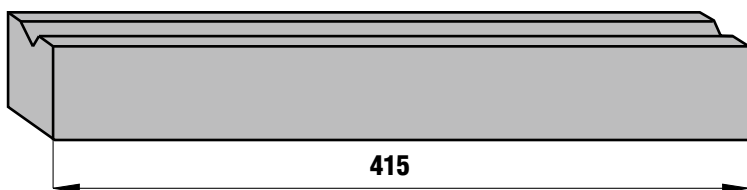
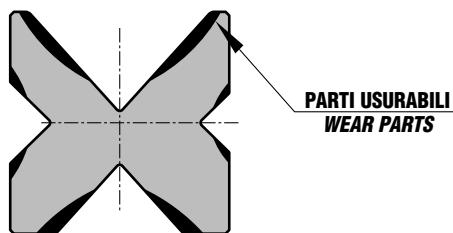
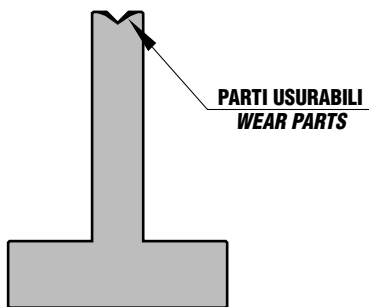
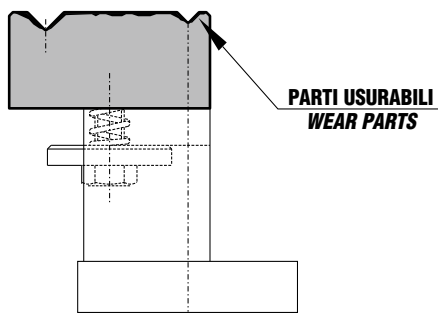
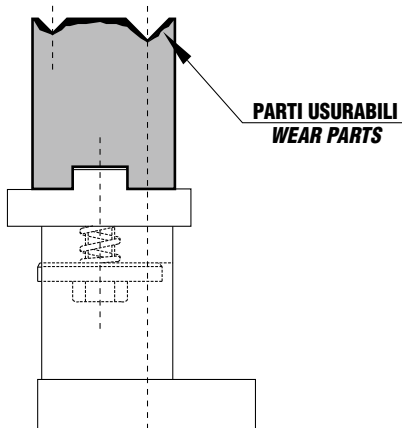


## ROTAX

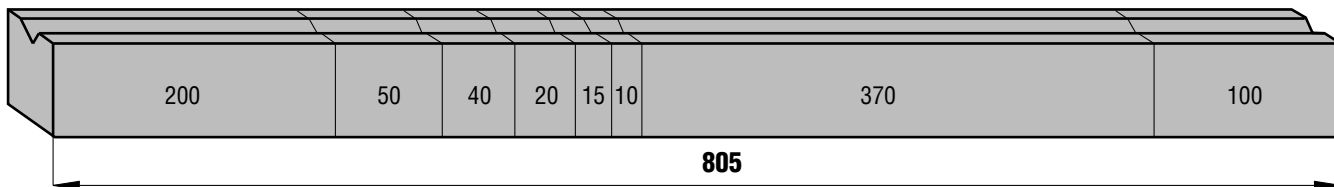


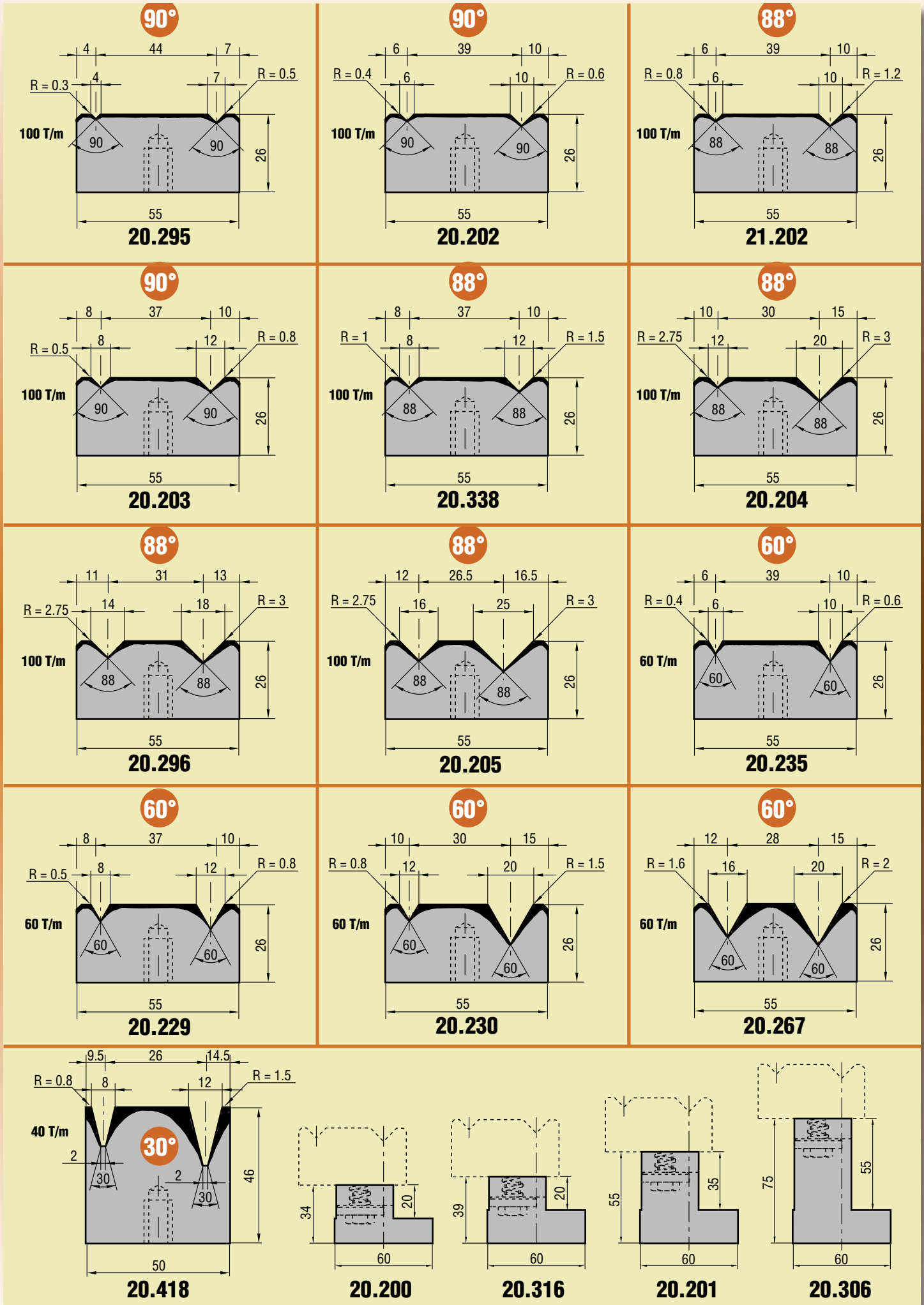
LE MATRICI STANDARD SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 415 mm - 835 mm E FRAZIONATE (805)  
 THE DIES ARE AVAILABLE IN THE FOLLOWING STANDARD LENGTHS: 415 mm - 835 mm AND SECTIONED (805)

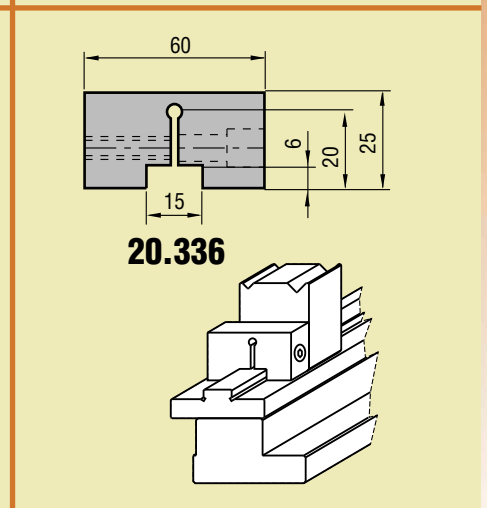
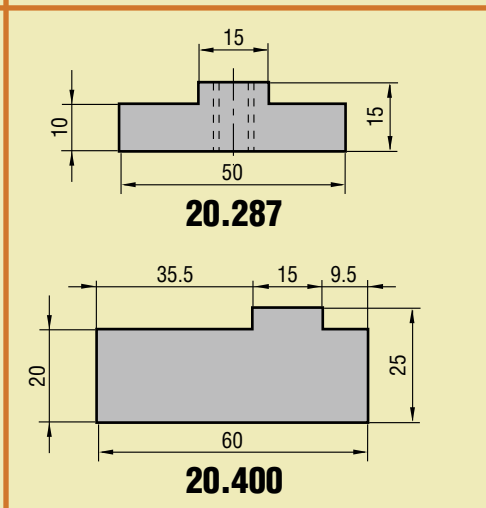
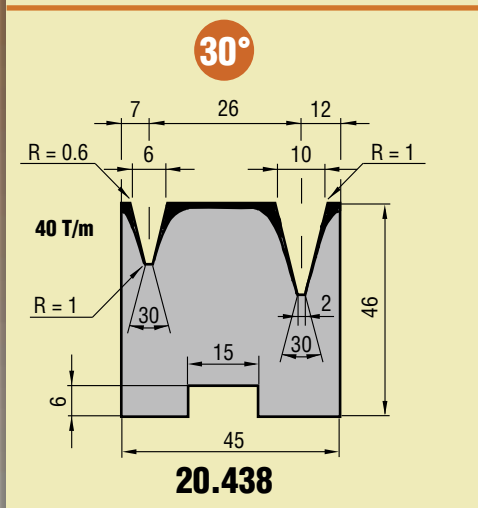
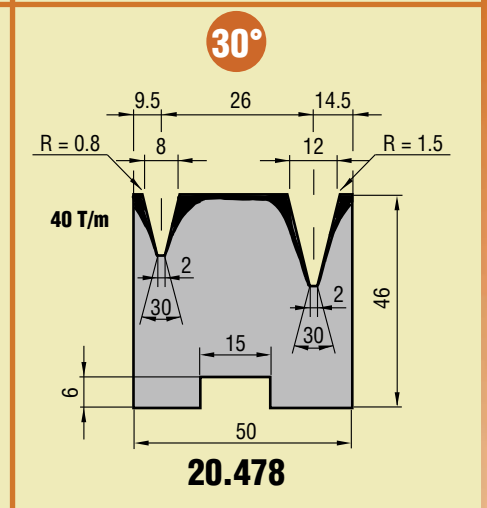
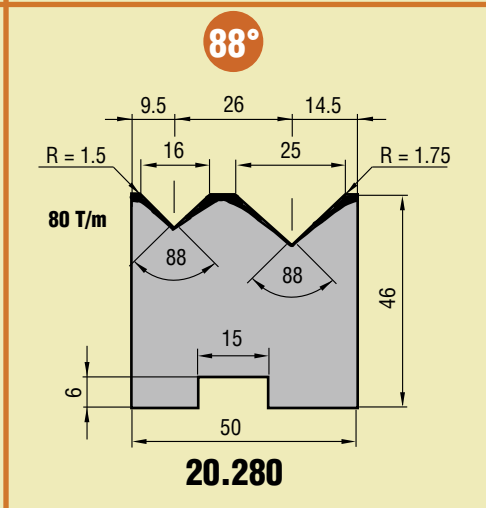
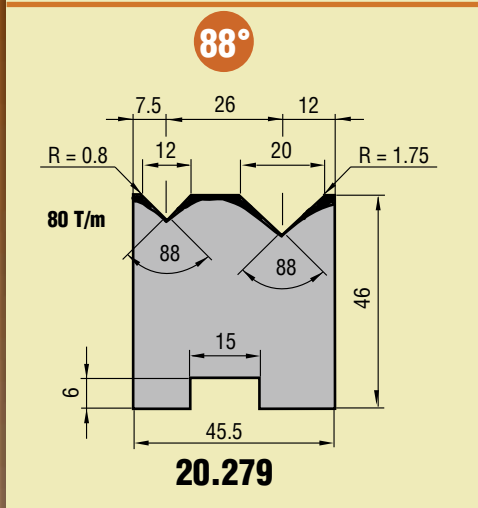
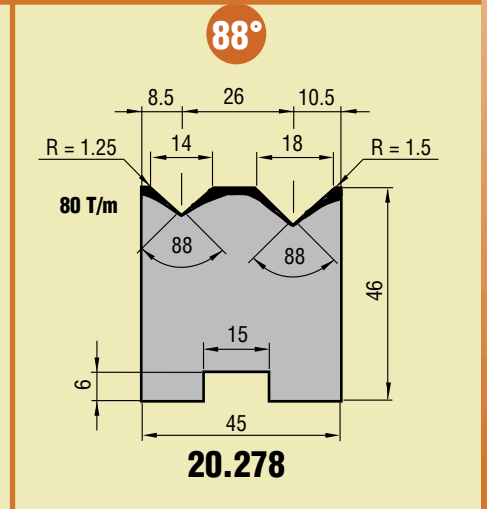
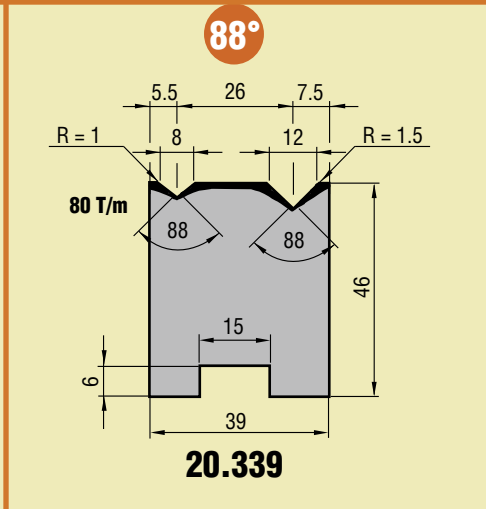
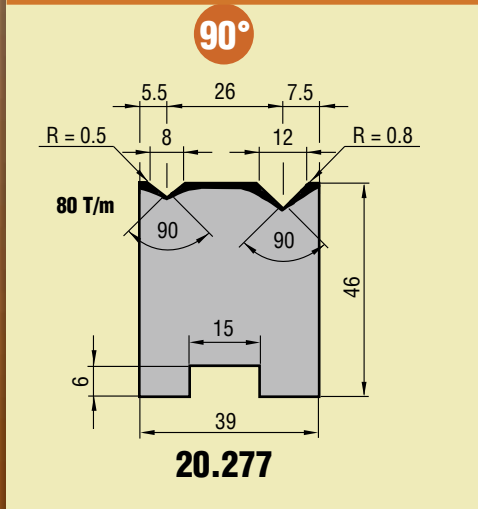
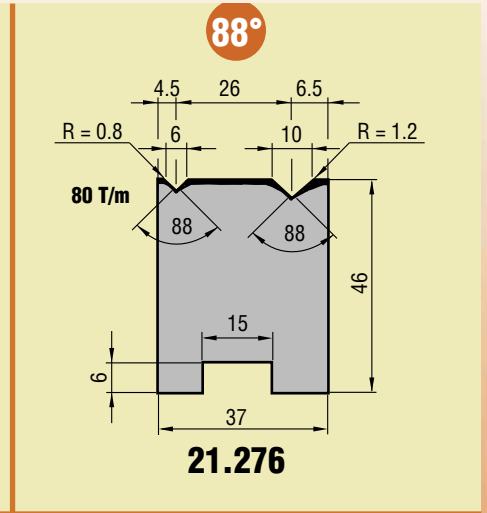
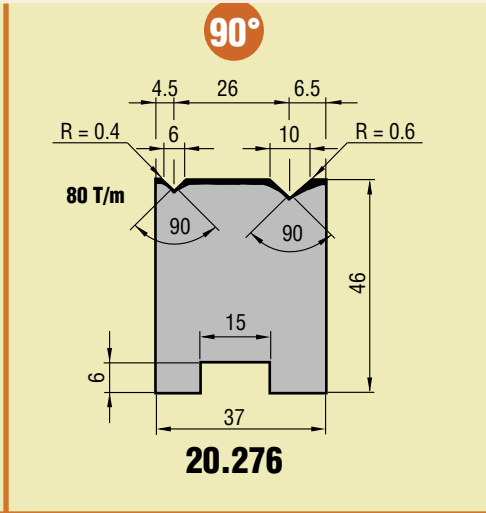
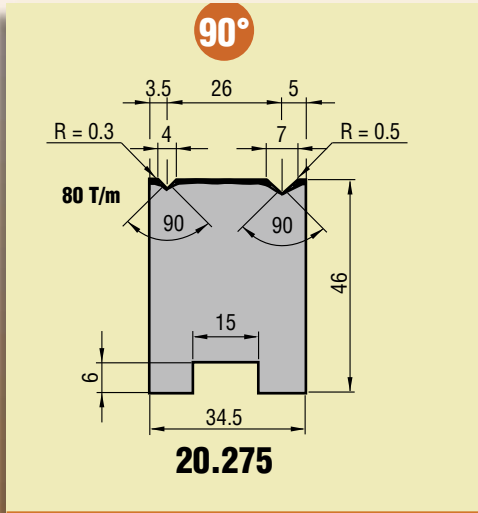
**ACCIAIO C45 (UNI 7845-78) TEMPRATO AD INDUZIONE 52/55 HRC  
 SULLE PARTI USURABILI  
 STEEL C45 (UNI 7845-78) INDUCTION TEMPERED 52/55 HRC  
 ON WEAR PARTS**

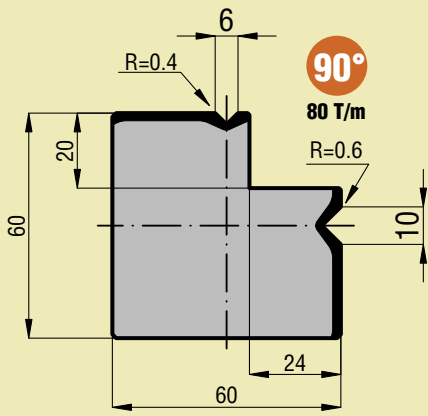


**FRAZIONATURA STANDARD  
 STANDARD SECTIONING**

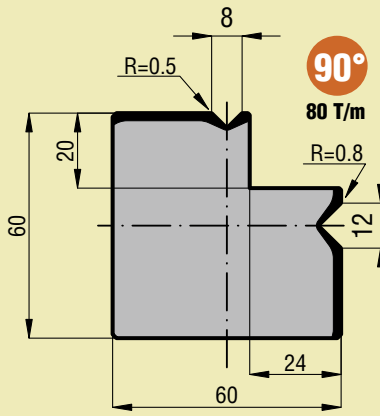




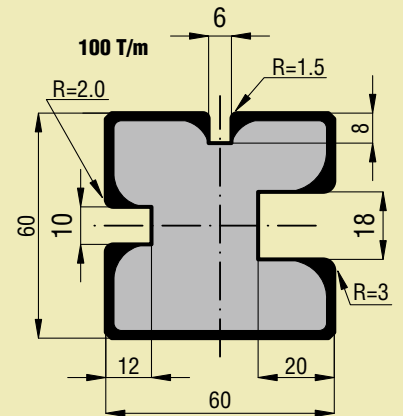




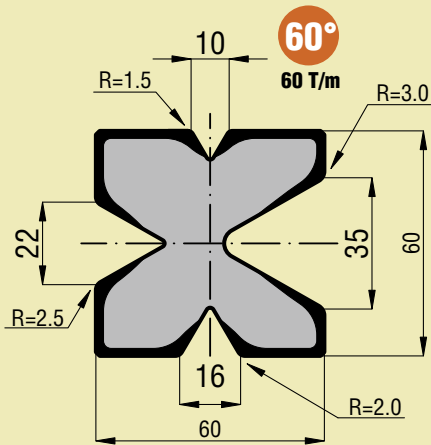
**20.208**



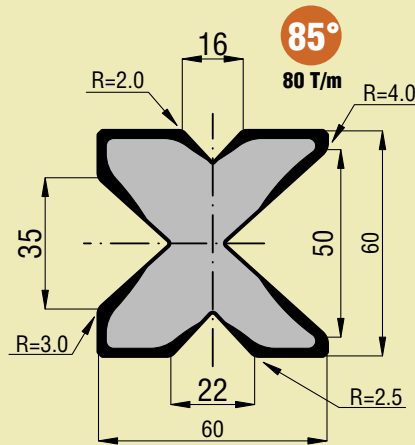
**20.237**



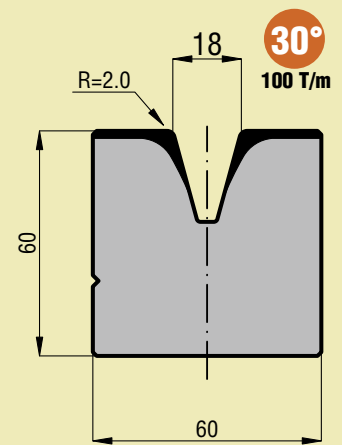
**21.209**



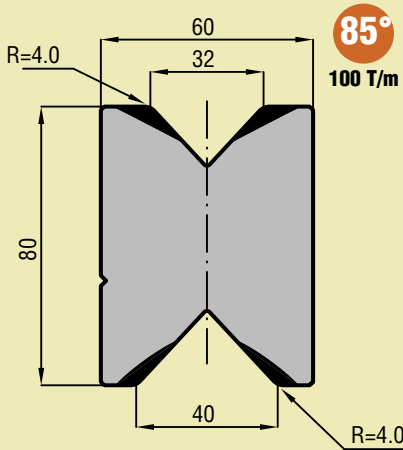
**20.350**



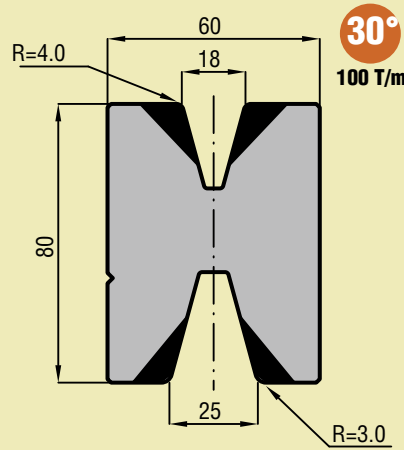
**21.207**



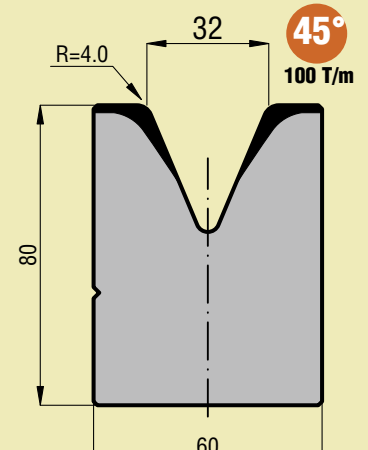
**20.494**



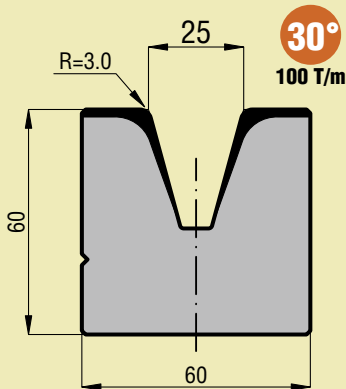
**20.820**



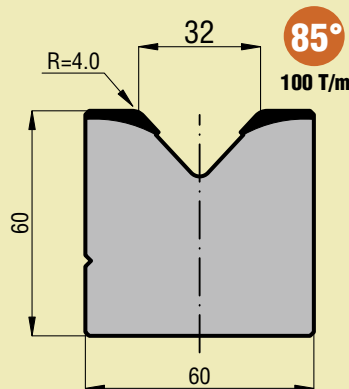
**20.830**



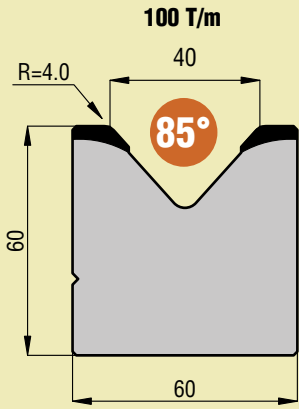
**20.484**



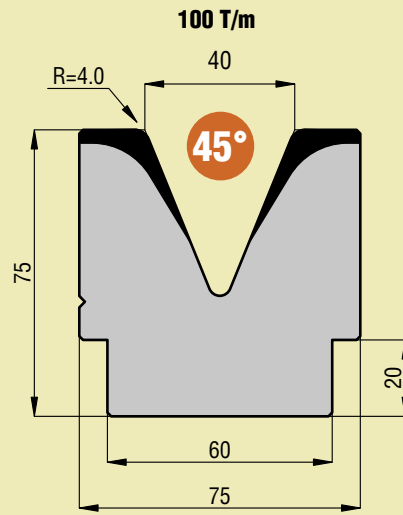
**20.325**



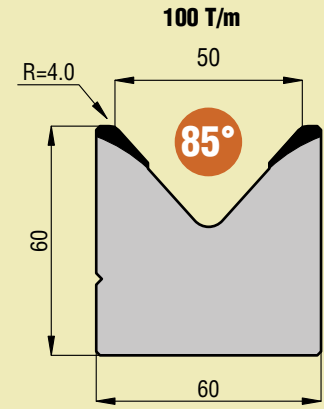
**20.210**



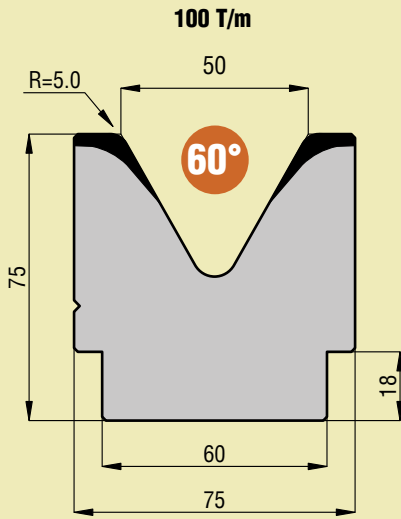
**20.211**



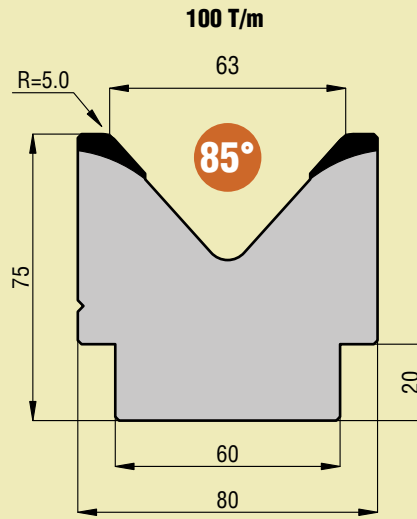
**20.440**



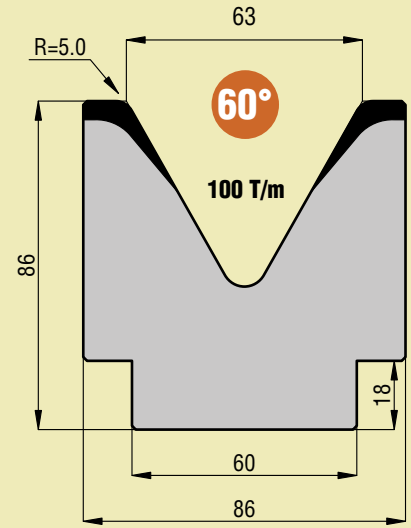
**20.212**



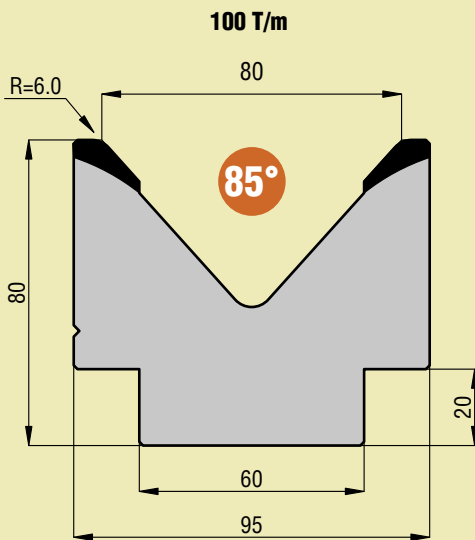
**20.650**



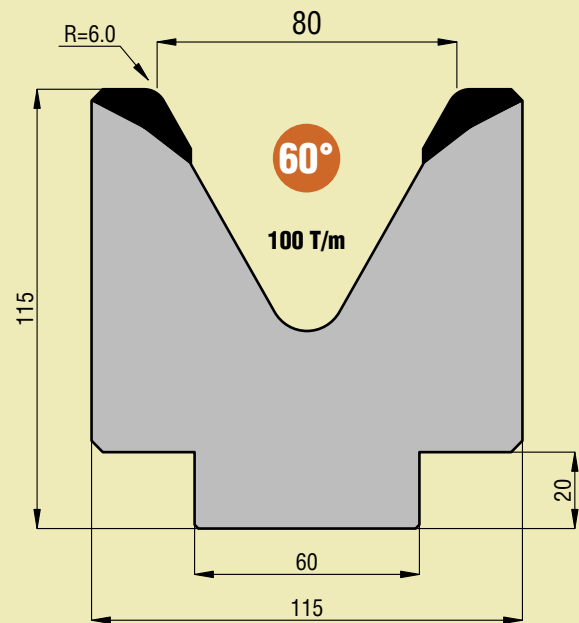
**20.213**



**20.370**

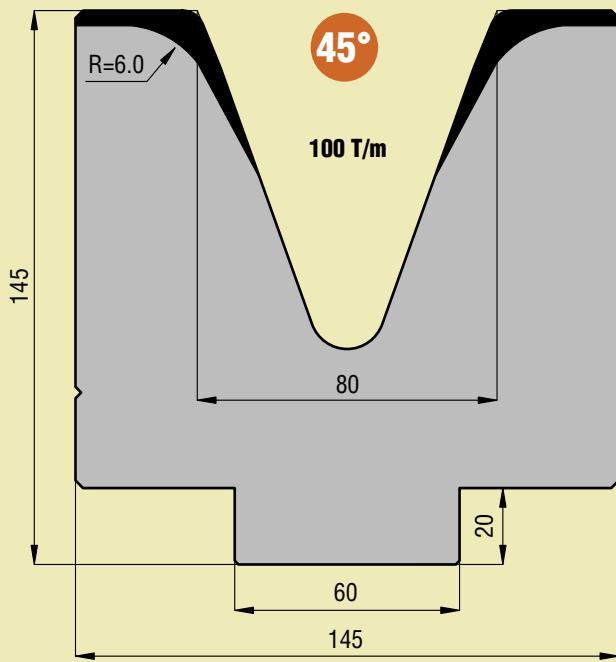


**20.214**

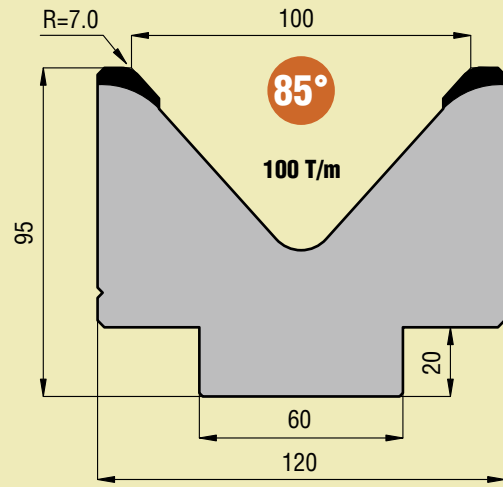


**20.680**

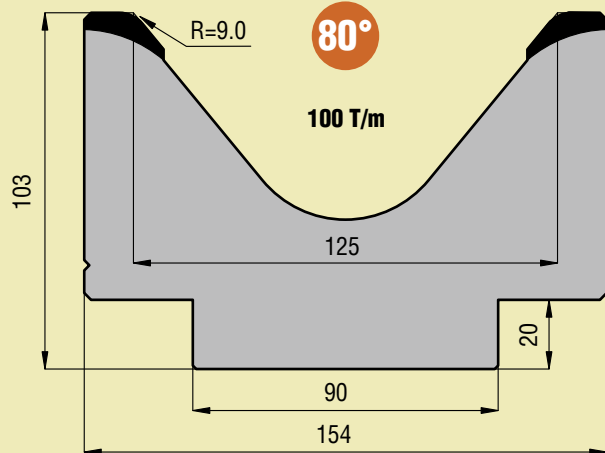




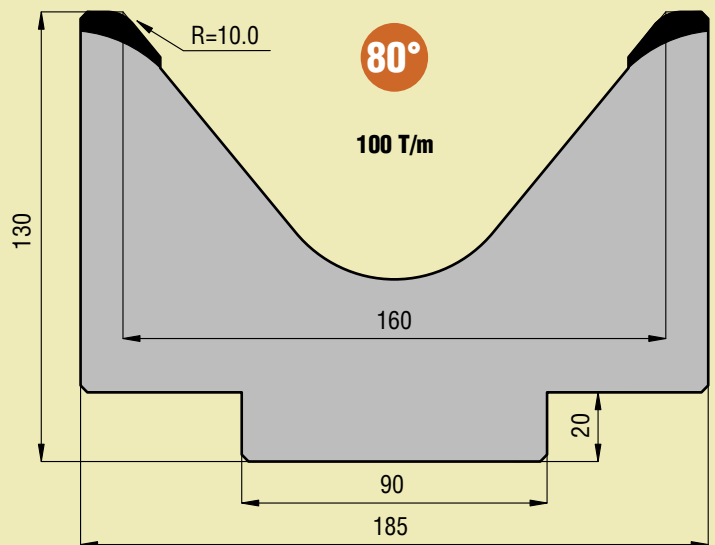
20.380



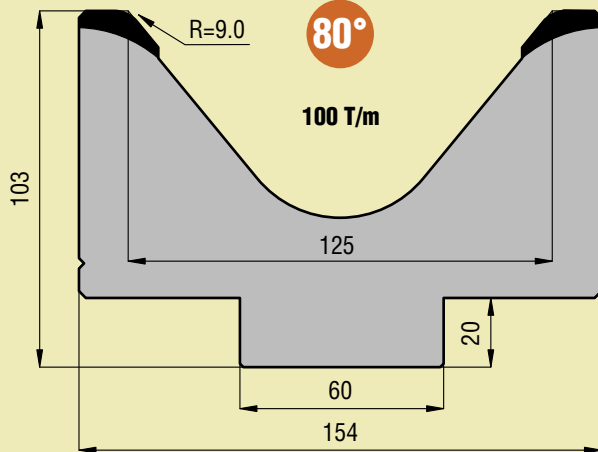
20.215



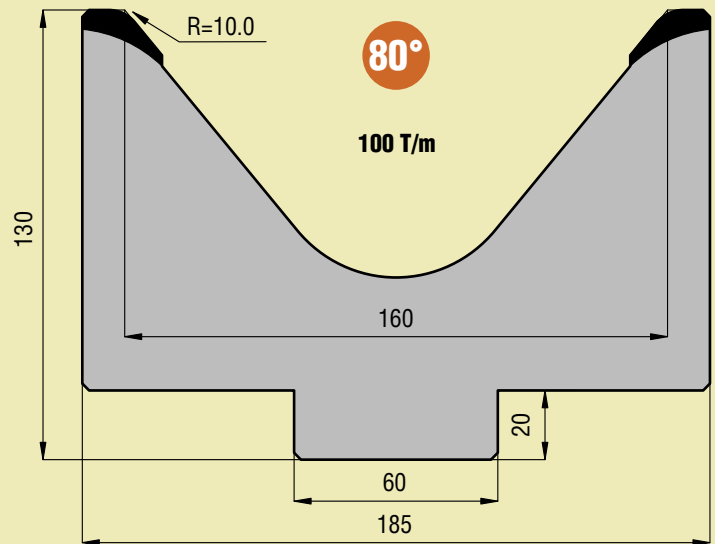
20.216



20.217

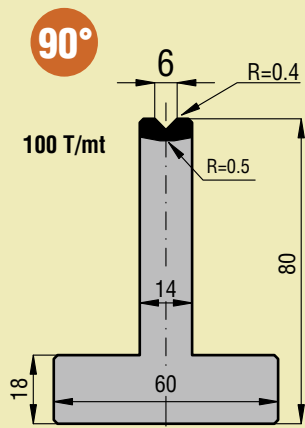


21.125

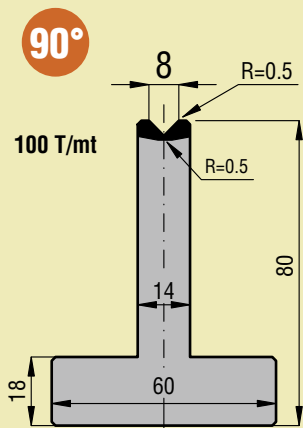


21.160

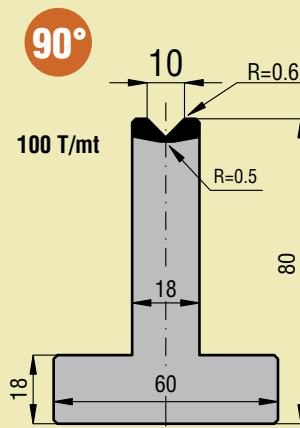
## H = 80



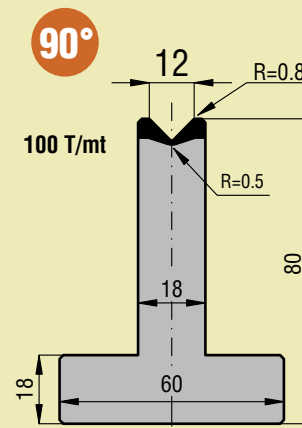
**20.243**



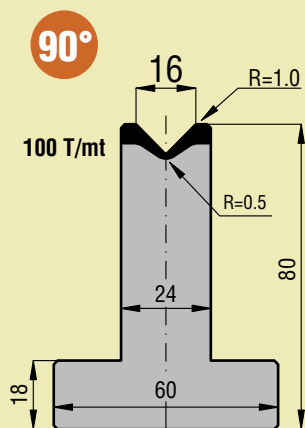
**20.258**



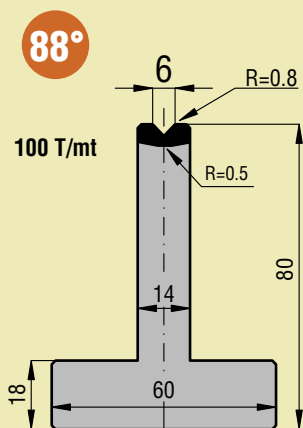
**20.244**



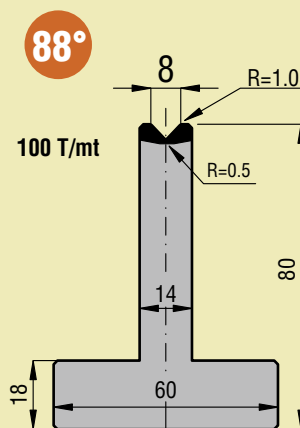
**20.245**



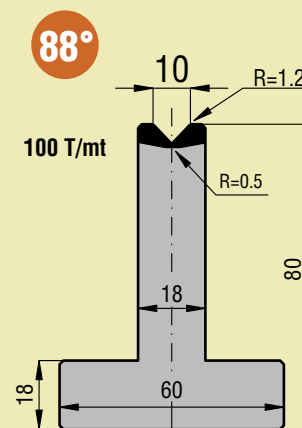
**20.246**



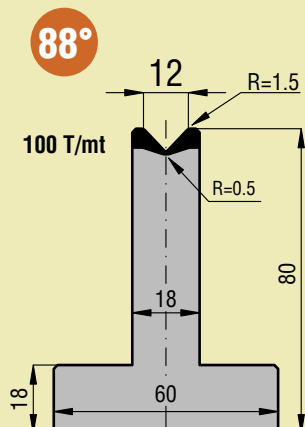
**20.806**



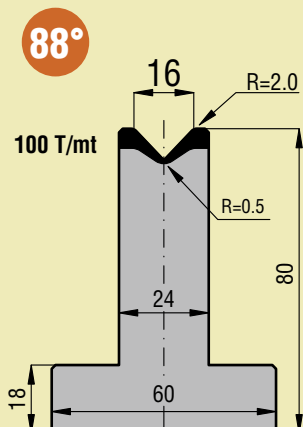
**20.808**



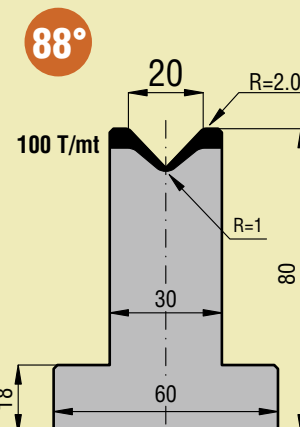
**20.810**



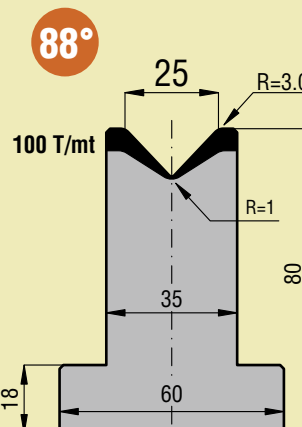
**20.371**



**20.327**

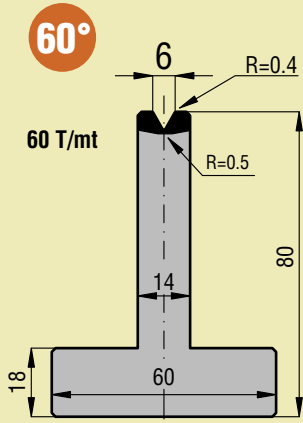


**20.310**

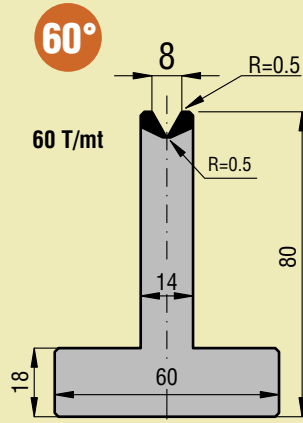


**20.309**

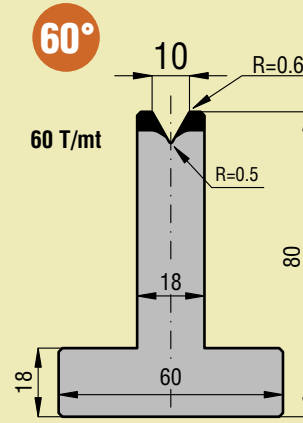
H = 80



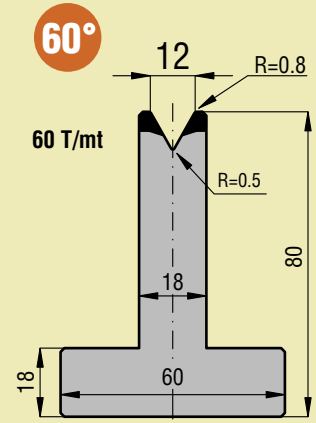
20.297



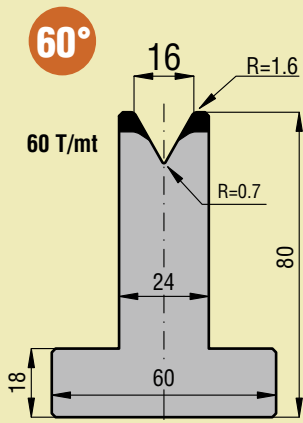
20.298



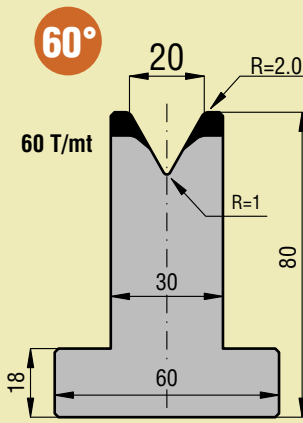
20.299



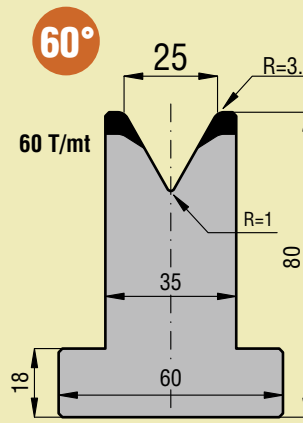
20.300



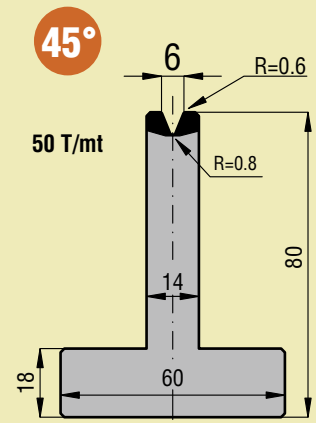
20.301



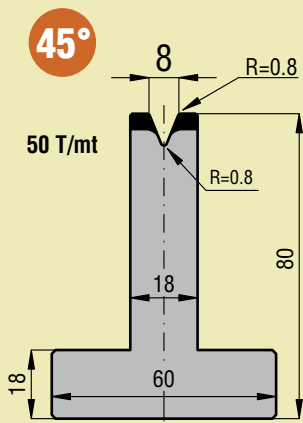
20.308



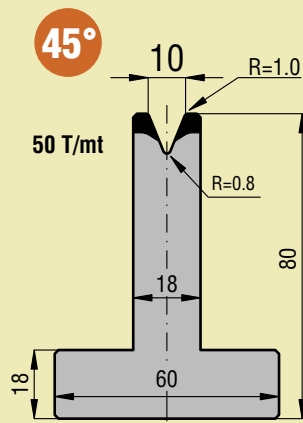
20.311



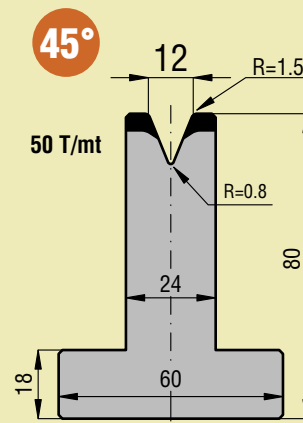
20.328



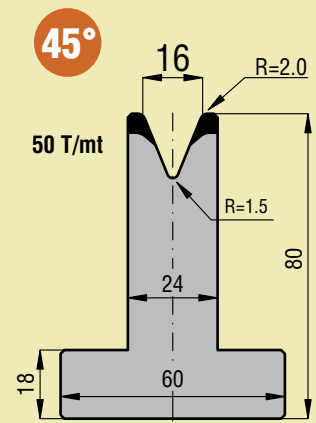
20.329



20.330

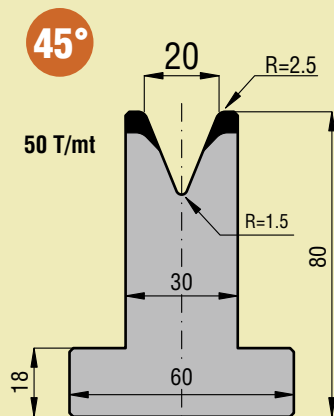


20.331

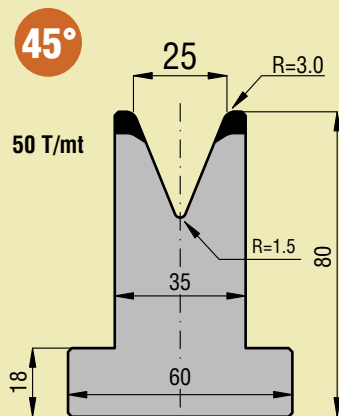


20.332

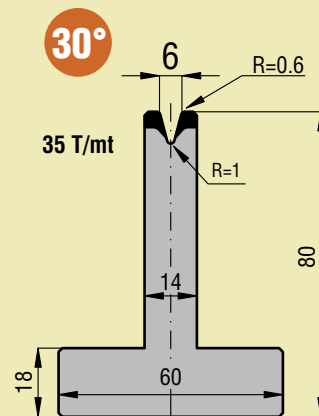
**H = 80**



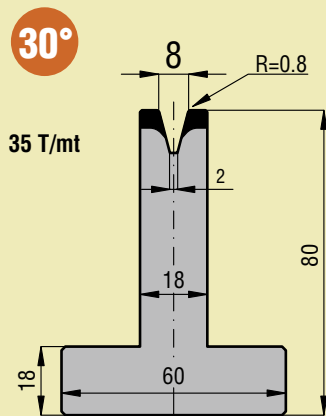
**20.333**



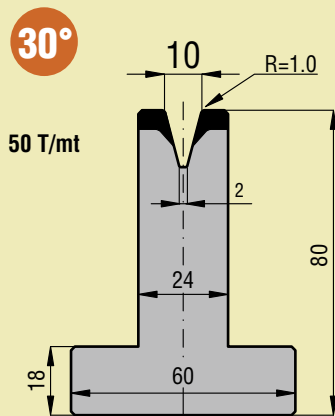
**20.334**



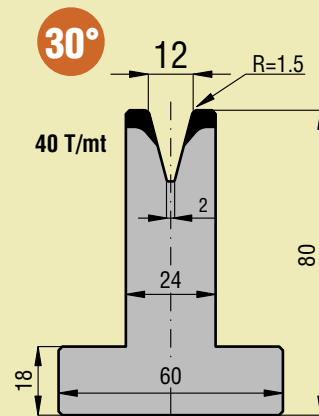
**20.317**



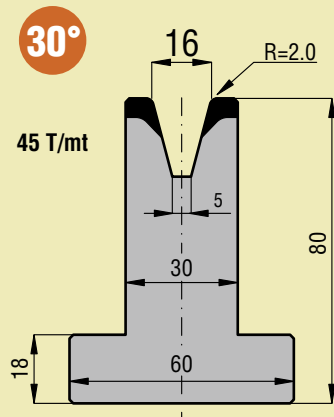
**20.318**



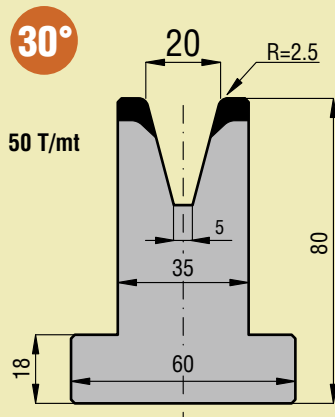
**20.319**



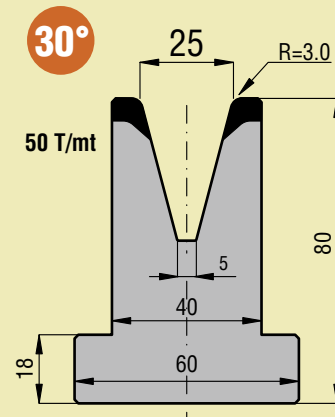
**20.320**



**20.321**

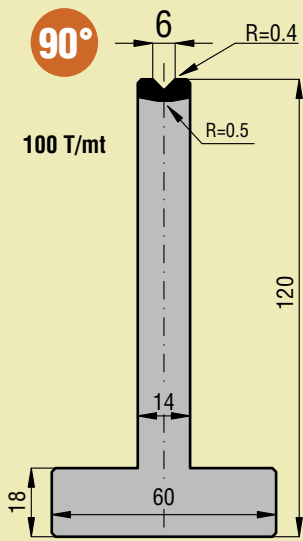


**20.322**

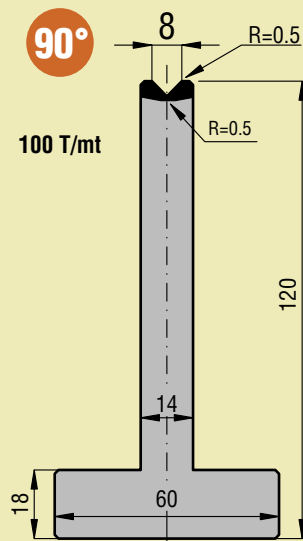


**20.323**

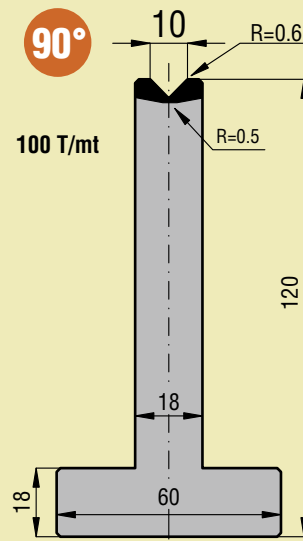
H = 120



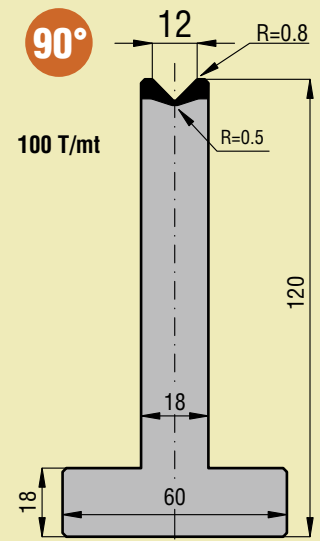
20.361



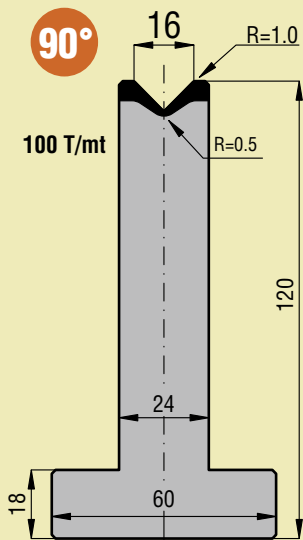
20.362



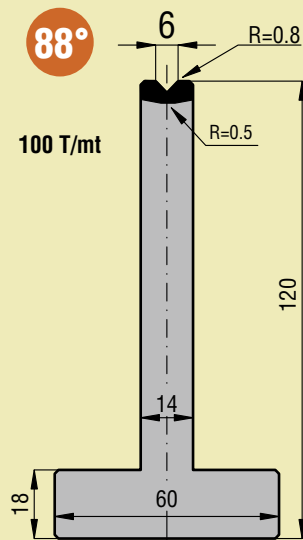
20.363



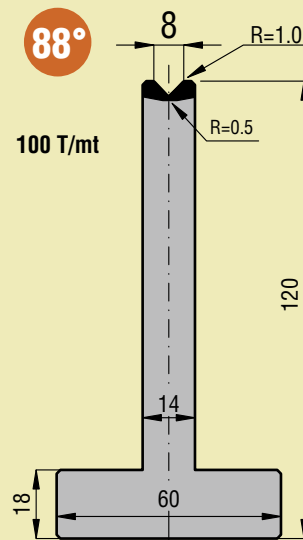
20.364



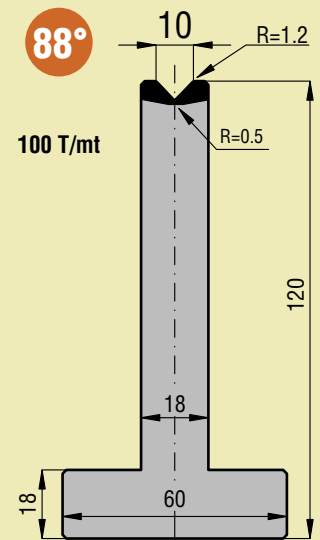
20.381



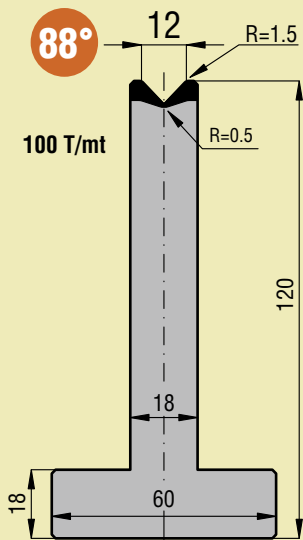
21.806



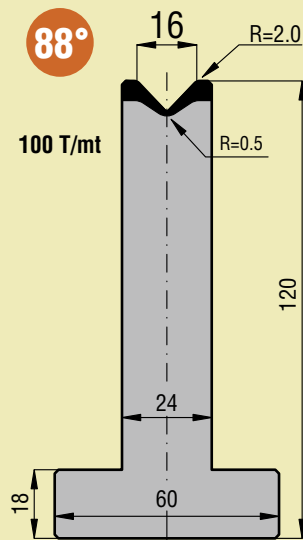
21.808



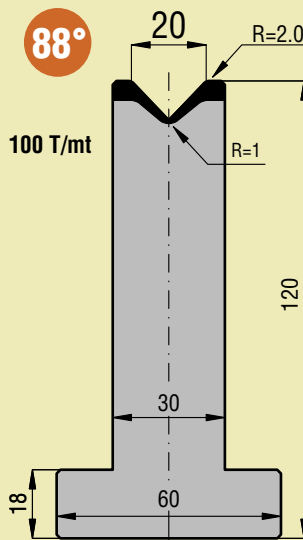
21.810



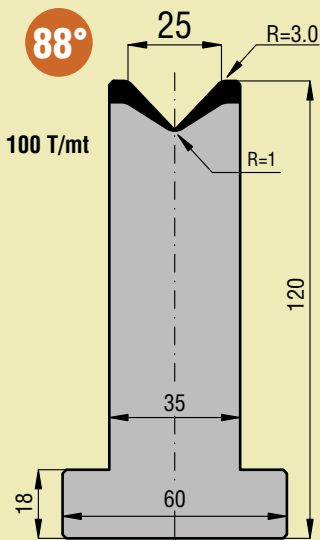
20.382



20.383

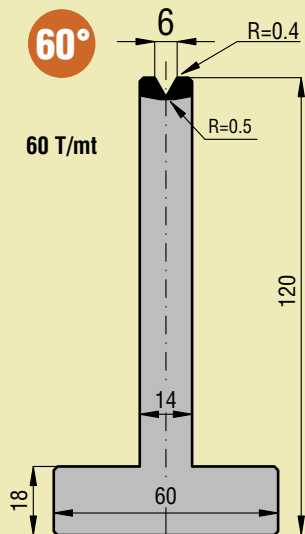


20.384

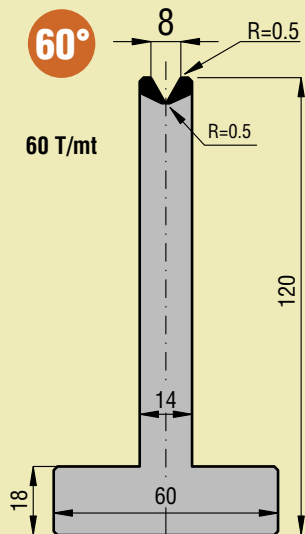


20.385

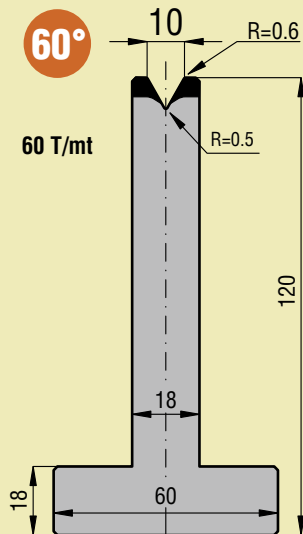
H = 120



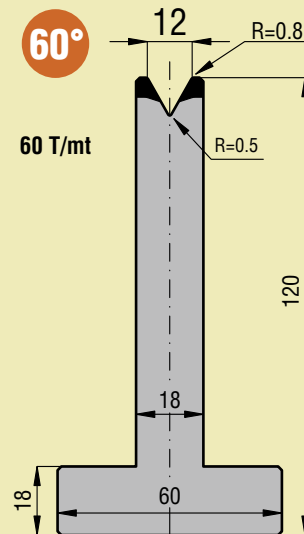
**20.386**



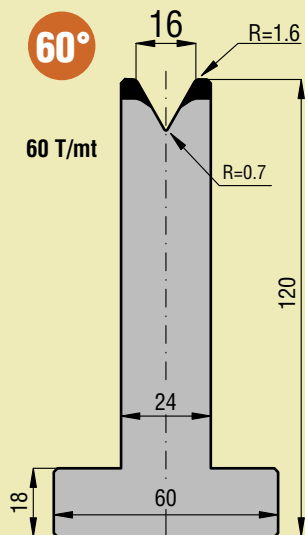
**20.387**



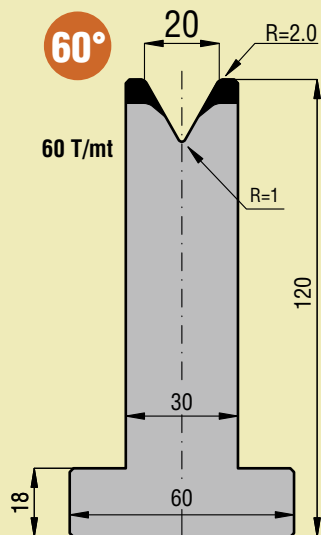
**20.388**



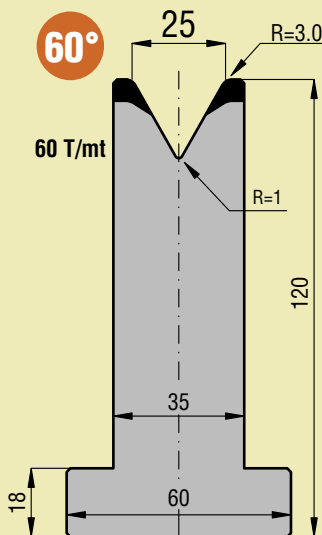
**20.389**



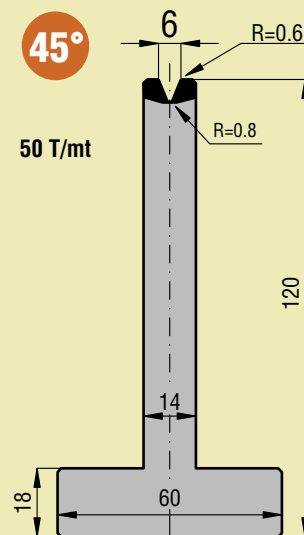
**20.390**



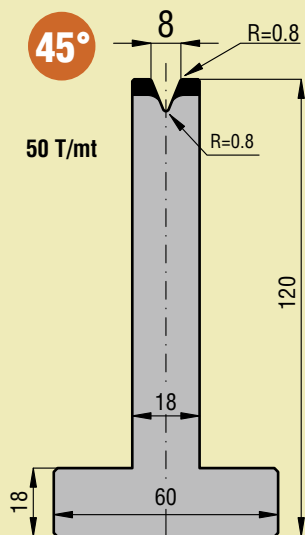
**20.391**



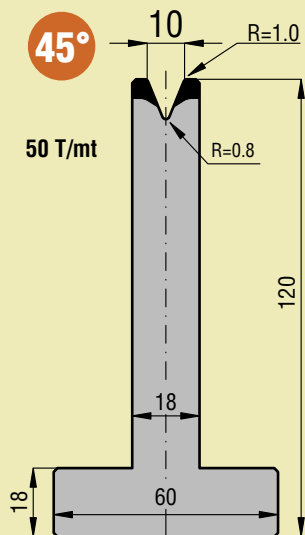
**20.392**



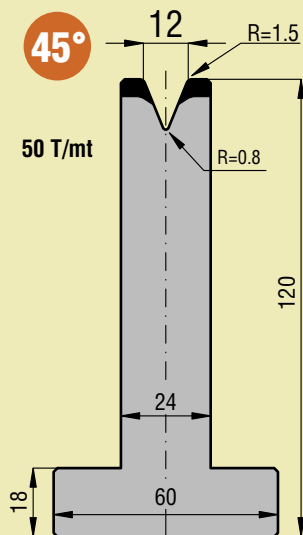
**20.393**



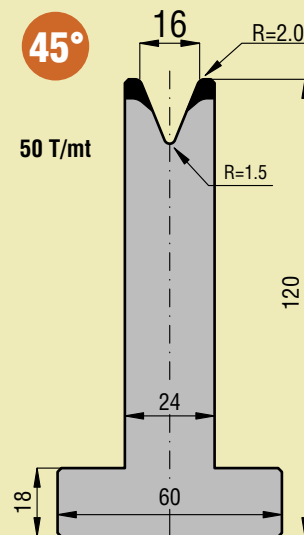
**20.394**



**20.395**

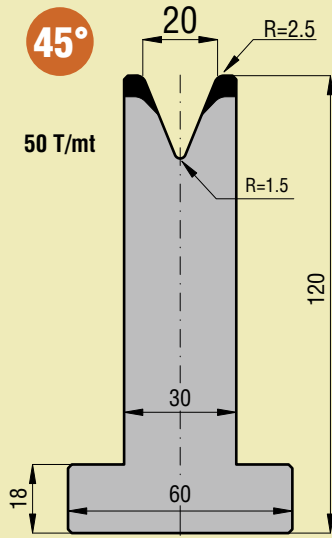


**20.396**

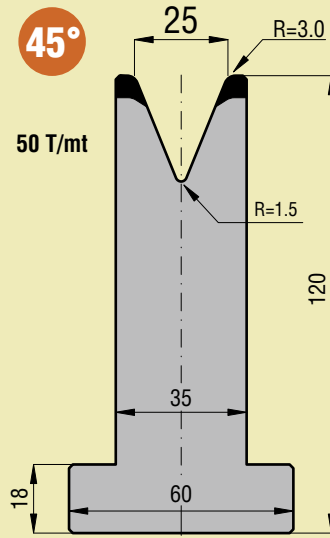


**20.397**

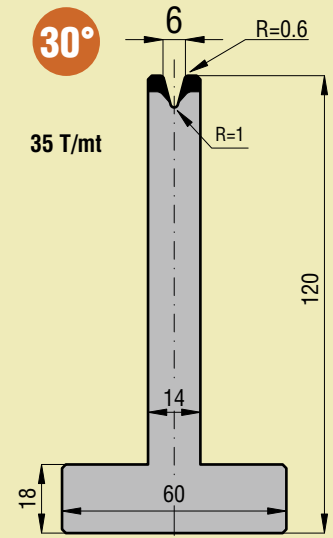
**H = 120**



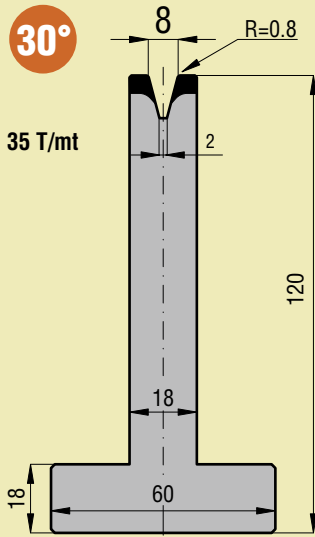
**20.398**



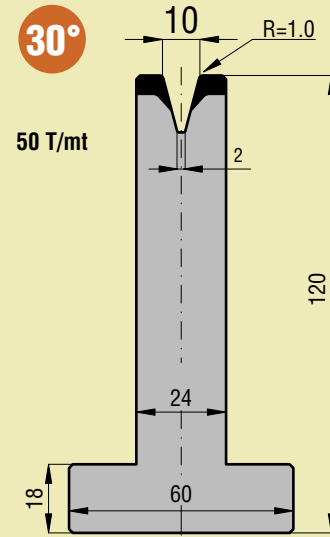
**20.399**



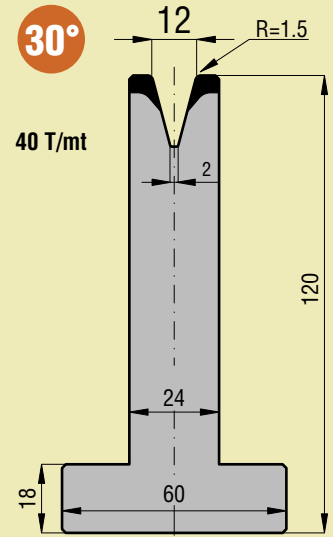
**20.351**



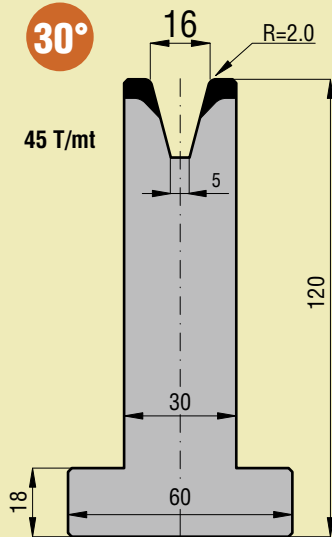
**20.352**



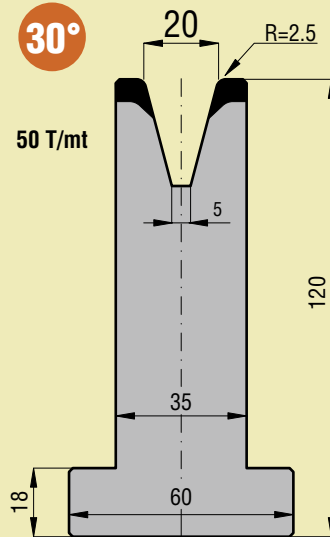
**20.353**



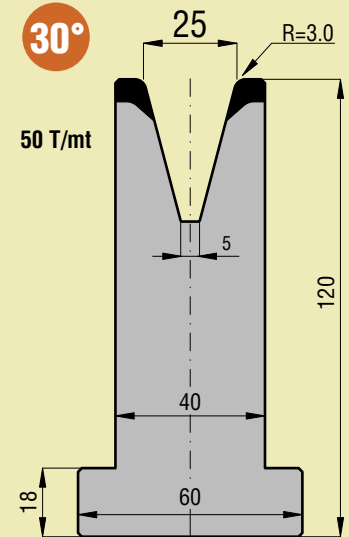
**20.354**



**20.401**



**20.402**

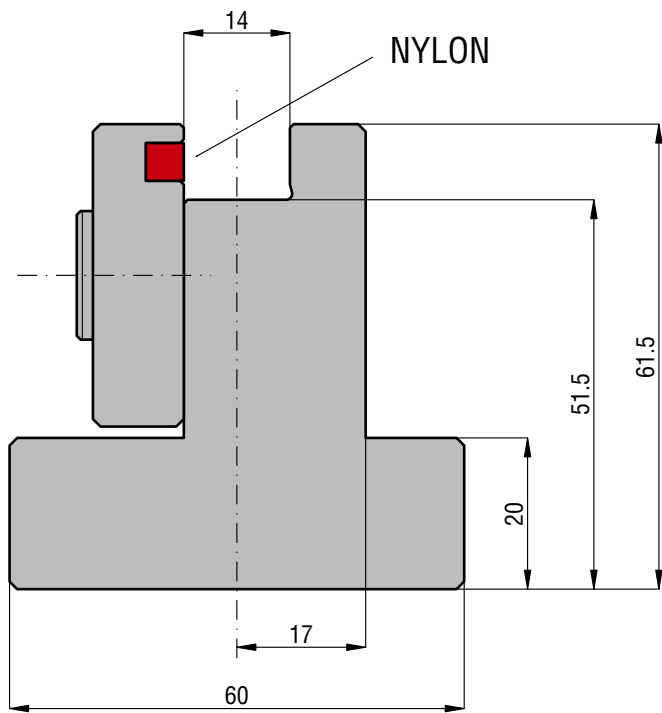


**20.403**

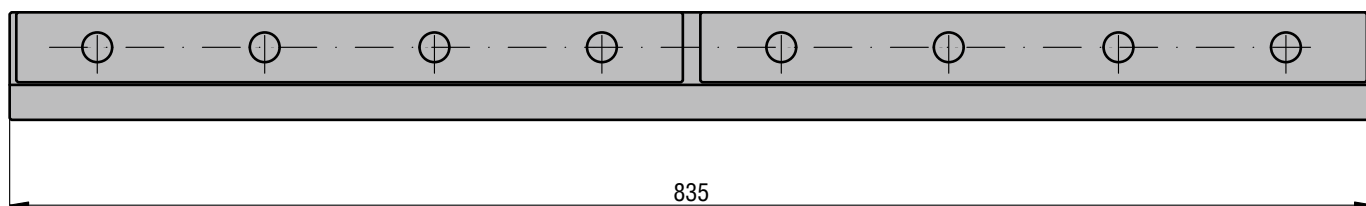
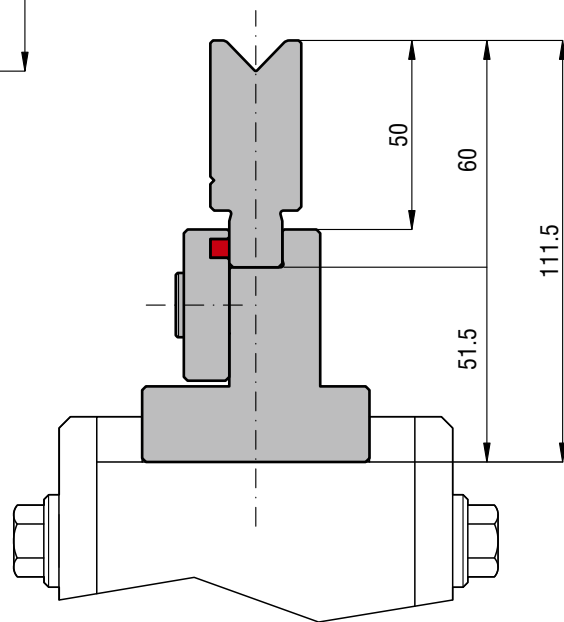


# SUPPORTO PER INSERTI MATRICI - *HOLDER FOR INSERTED DIES*

**L=835**  
**L=415**

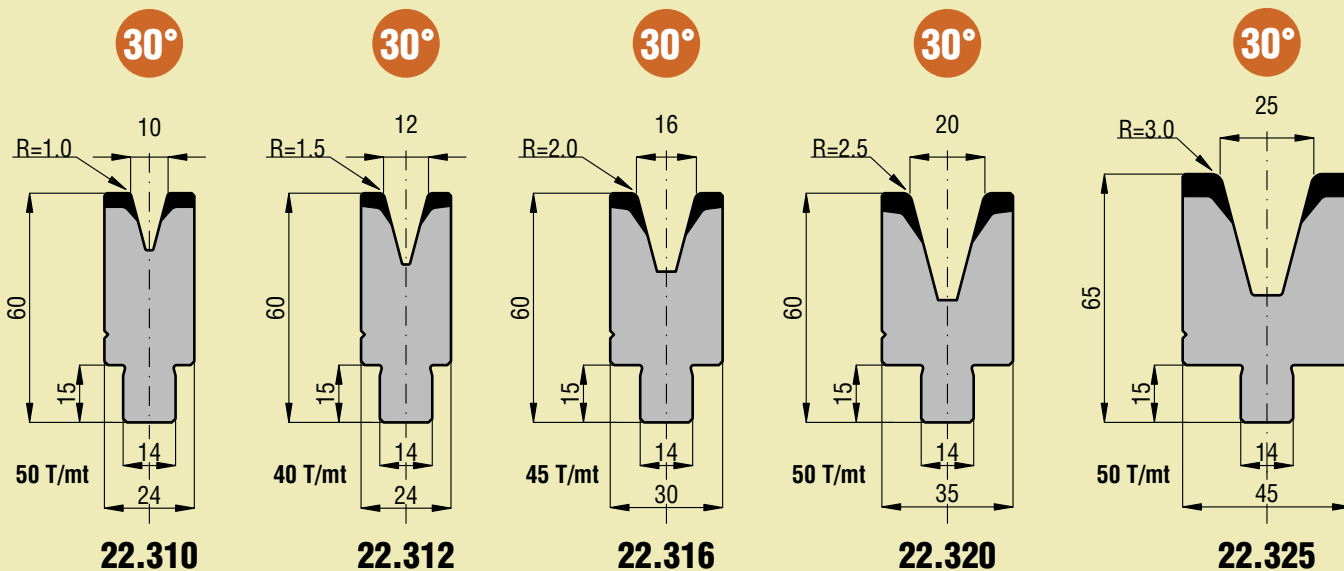
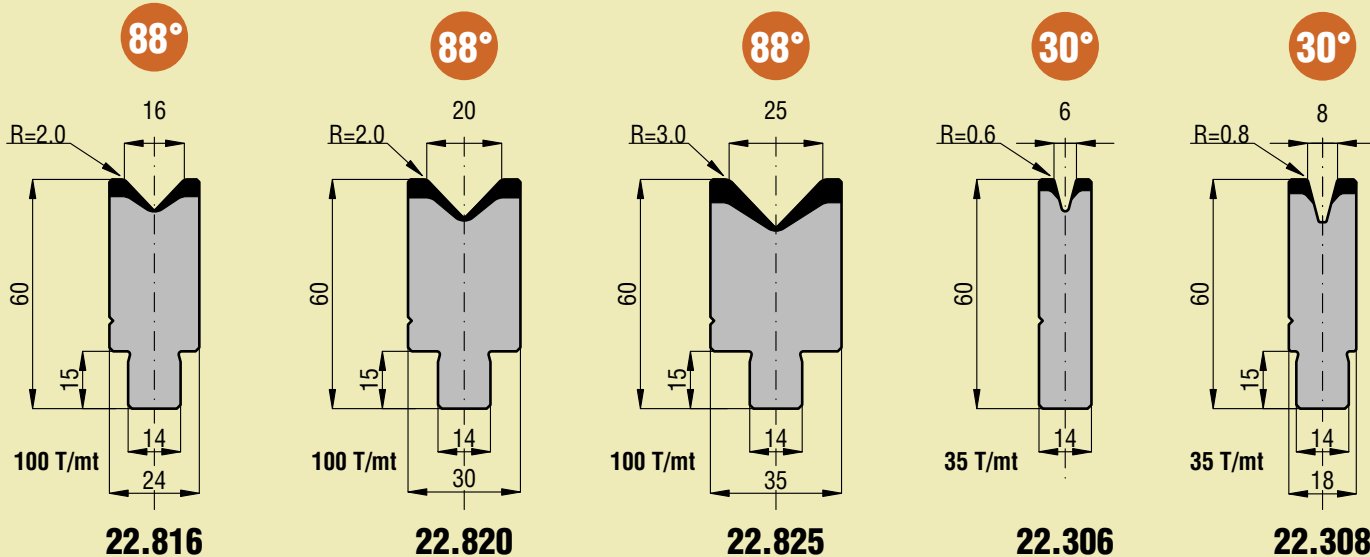
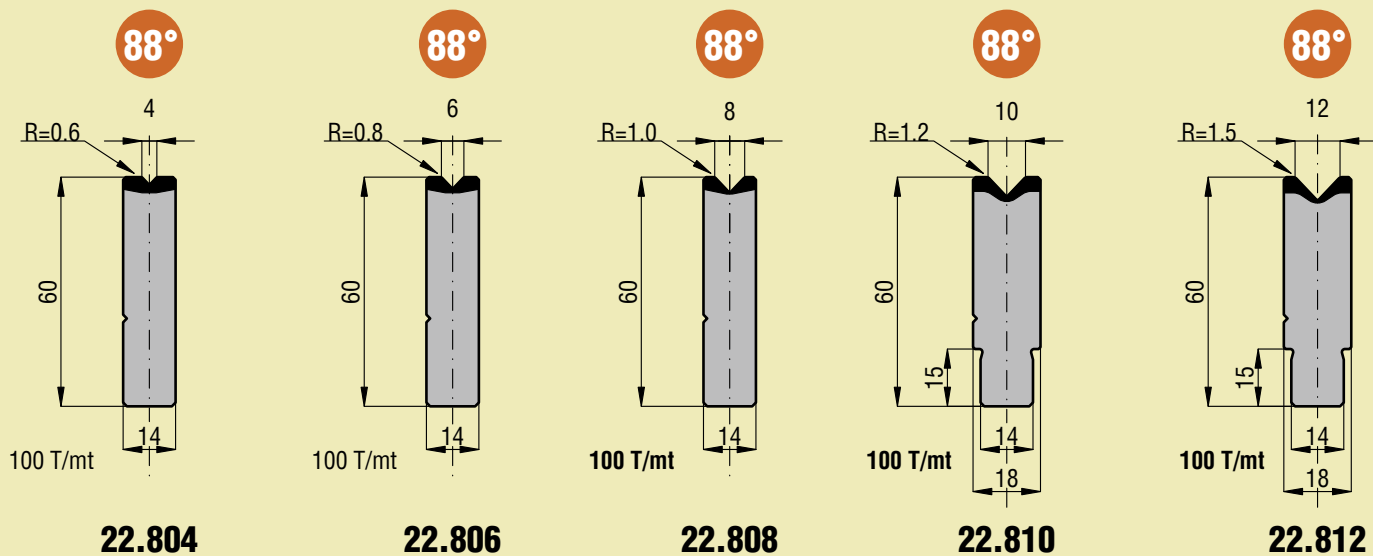


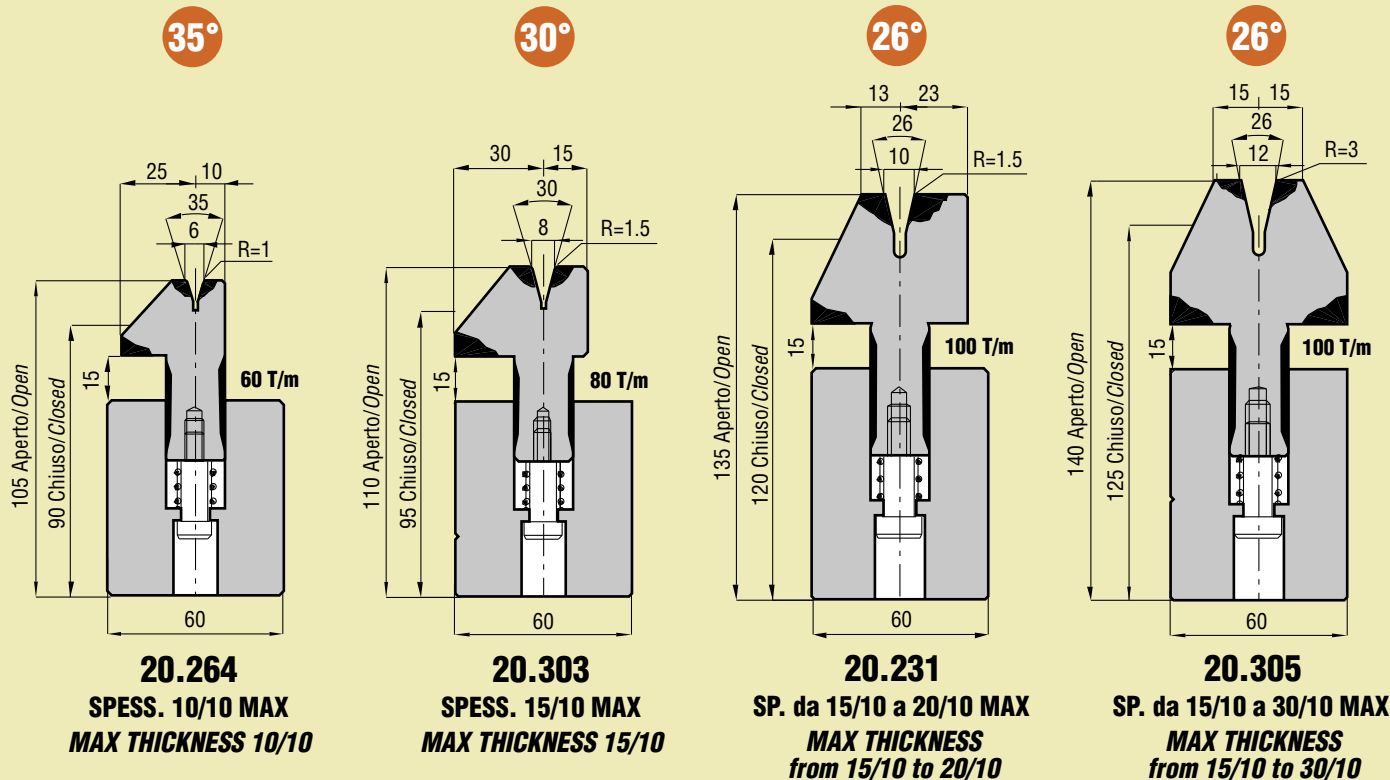
**22.010**





L=835 - L=415 - L=805 S.





## MATRICI MOBILI AD AZIONAMENTO PNEUMATICO

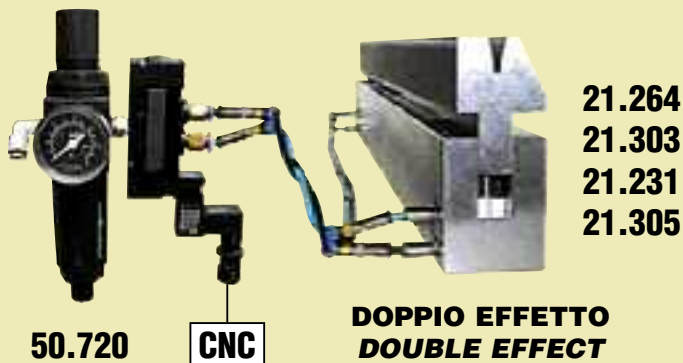
Su richiesta, le matrici mobili elencate (20.264 - 20.303 - 20.231 - 20.305) possono essere fornite di cilindri anziché di molle ricavandone rilevanti vantaggi:

- A) minor usura degli utensili;
- B) maggior precisione di piega;
- C) recupero di 15 mm di luce, e quindi di corsa, con conseguente riduzione dei tempi di lavorazione.

## MOVING DIES PNEUMATICALLY OPERATED

On request, Tecnostamp can supply the listed moving dies (20.264 - 20.303 - 20.231 - 20.305) equipped with cylinder instead of springs getting the following benefits:

- A) less wear of the tools;
- B) more precise bending;
- C) gain 15 mm light and stroke with a consequent reduction of machining time.



## TABELLA DI PIEGATURA BENDING SCHEME

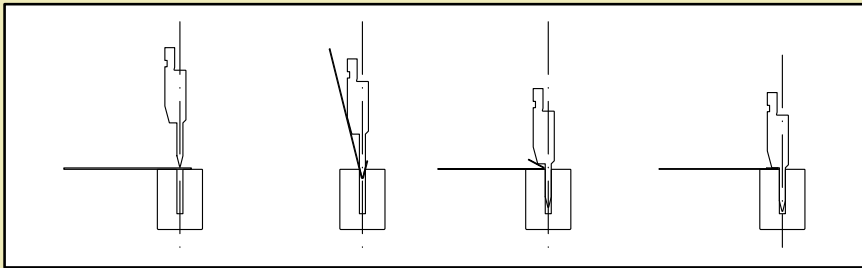
MATERIALE - MATERIAL - ACC. R ~ 40 Kg/mm<sup>2</sup>

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

MATERIALE - MATERIAL - ACC. R ~ 70 Kg/mm<sup>2</sup>

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

# PIEGASCHIACCIA AMADA/PROMECAM AMADA/PROMECAM FLATTENING-HEMMING TOOLS

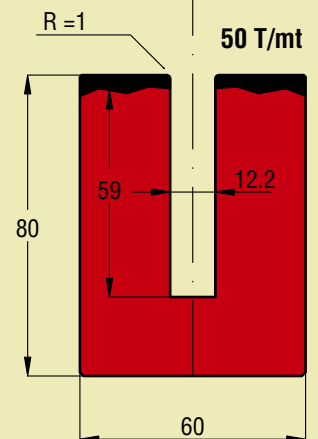
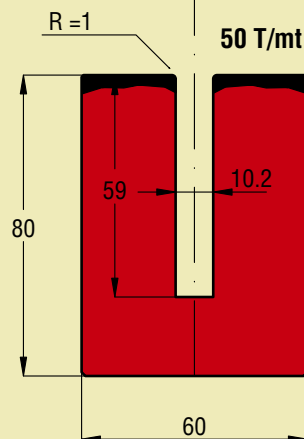
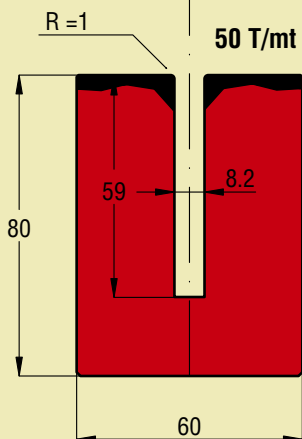
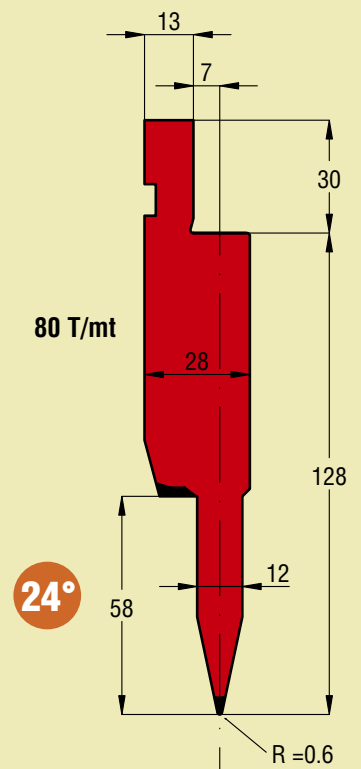
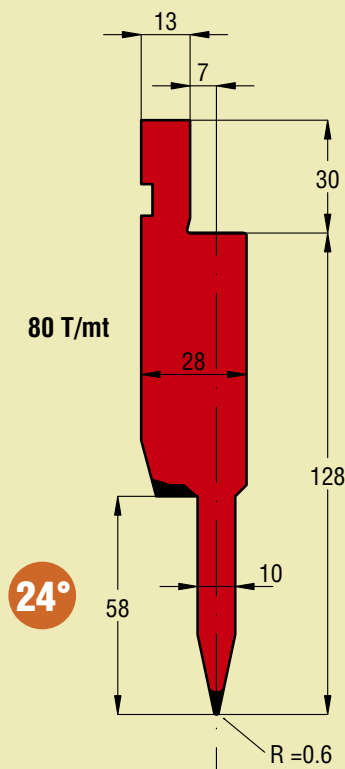
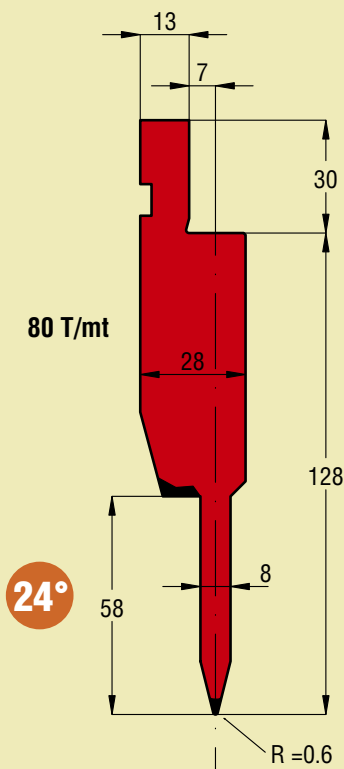


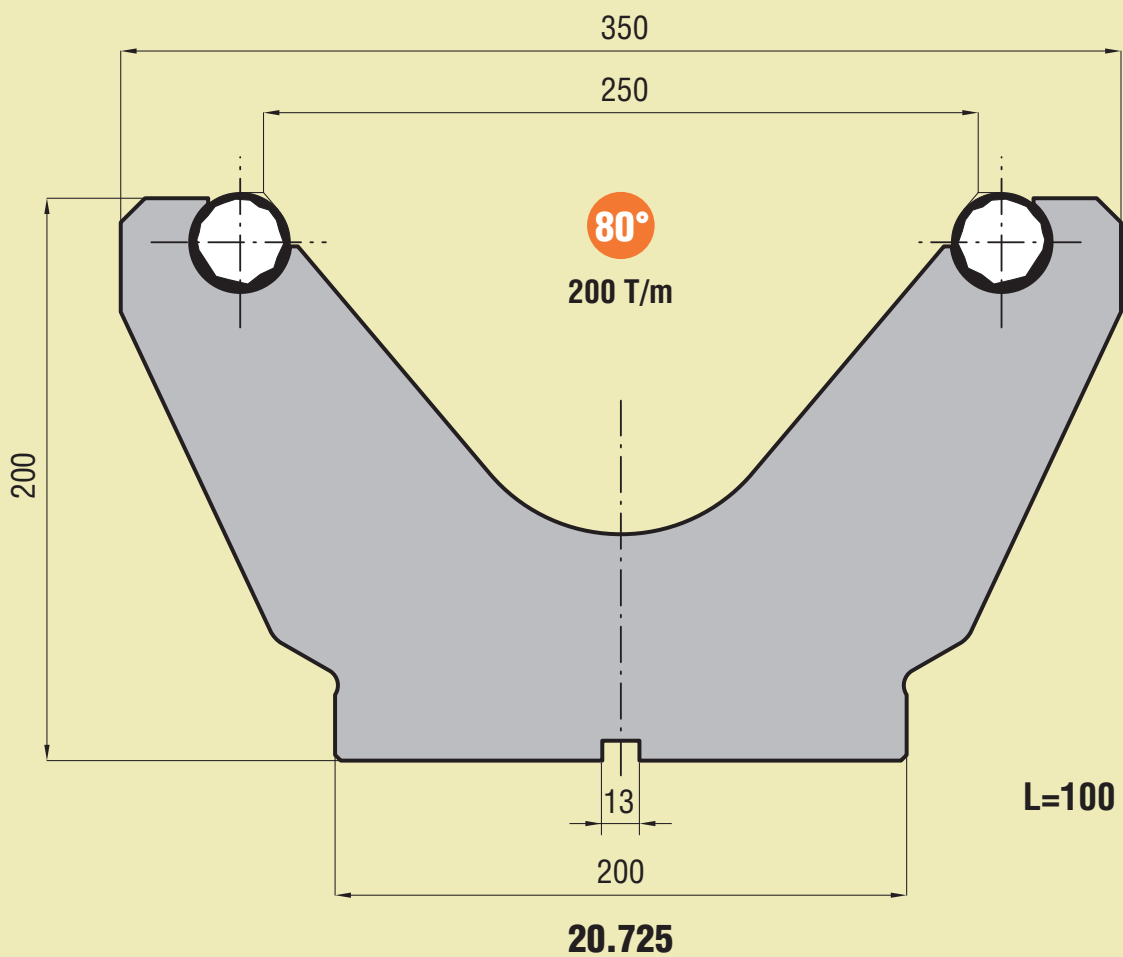
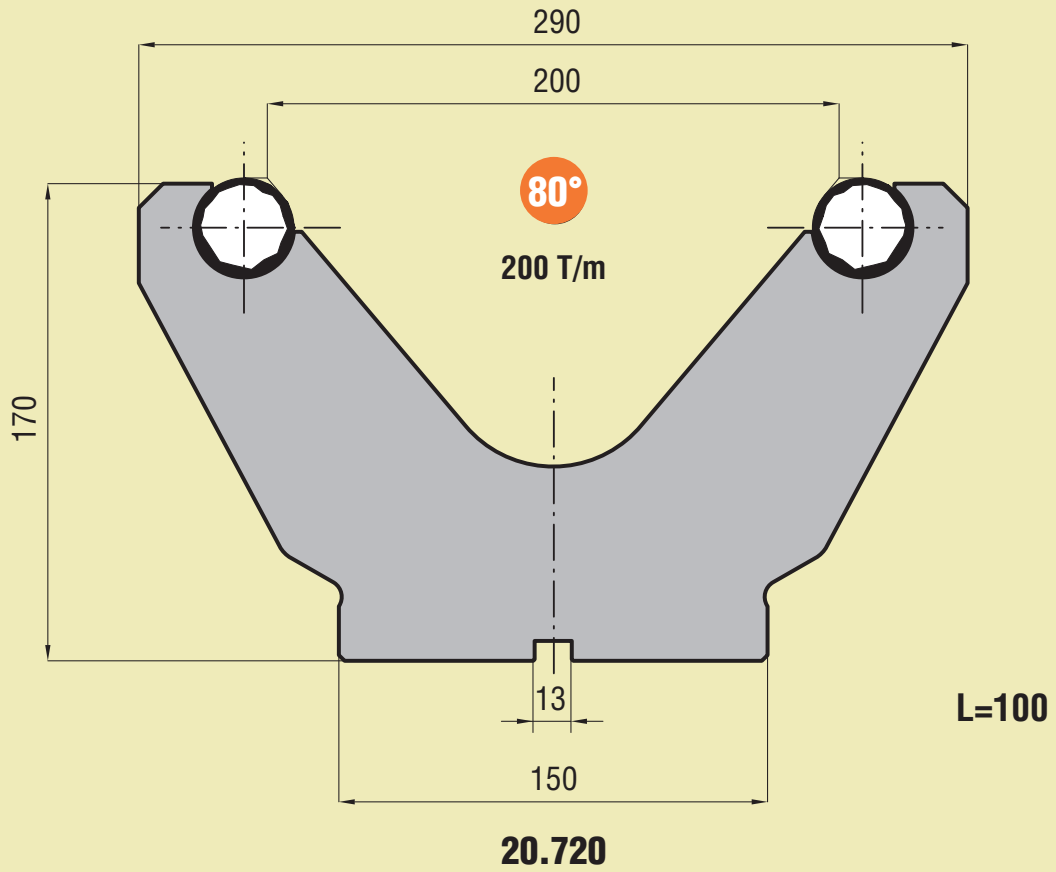
**L=835**  
**L=415**  
**L=805 S.**

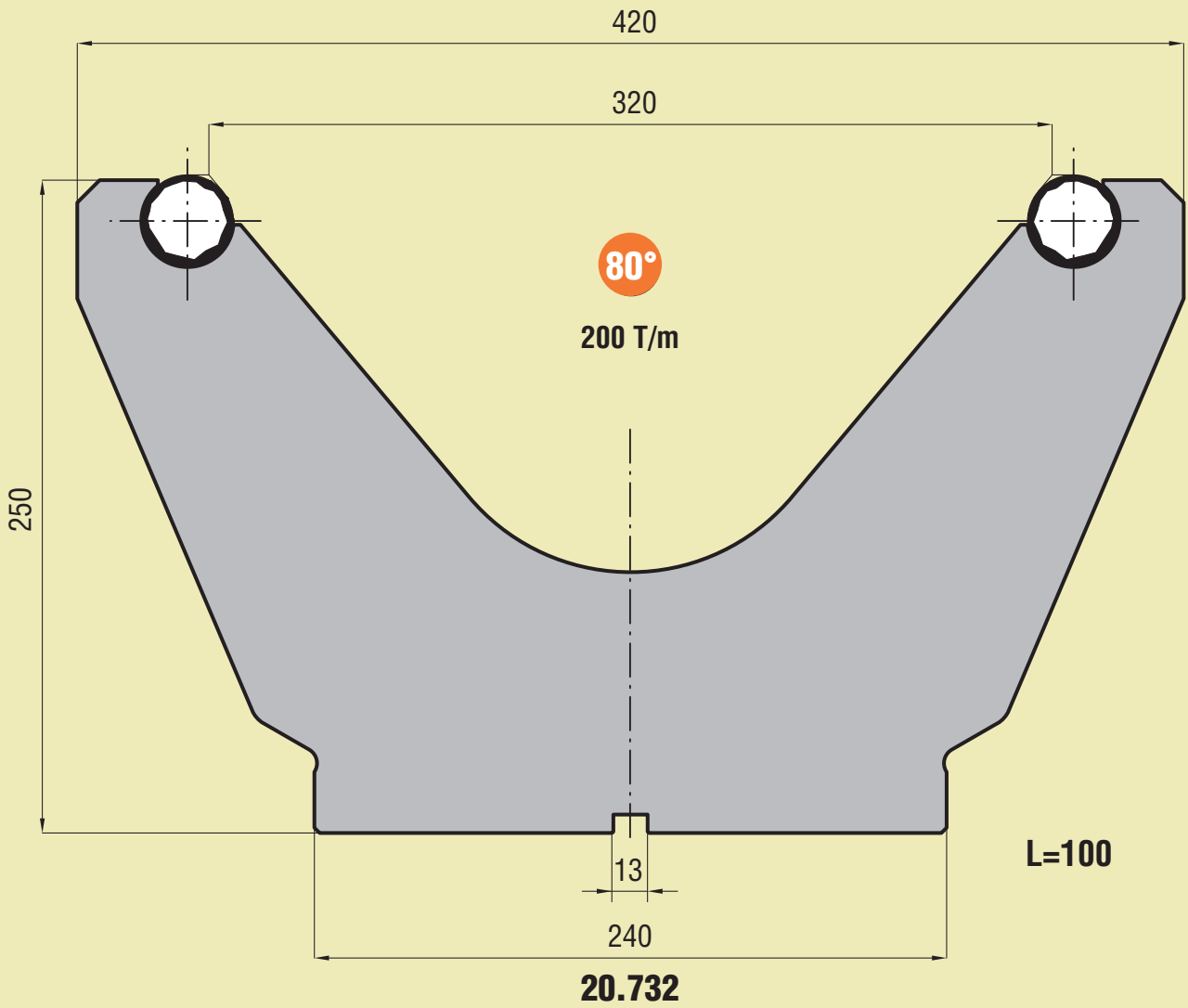
**11.550**

**11.554**

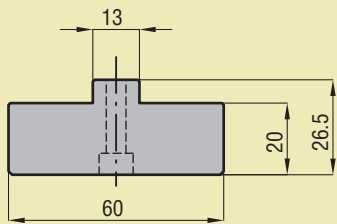
**11.560**





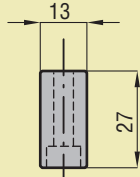


**AMADA SYSTEM**



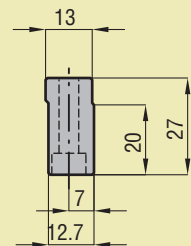
20.701 L=100

**BEYELER/TRUMPF SYSTEM**



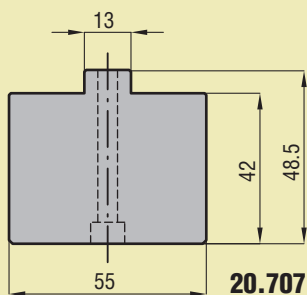
20.703 L=100

**LVD SYSTEM**



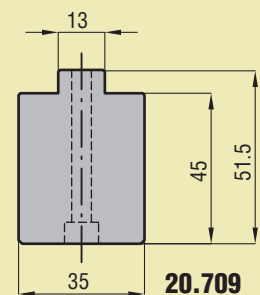
20.705 L=100

**EHT SYSTEM**



L=100 20.707

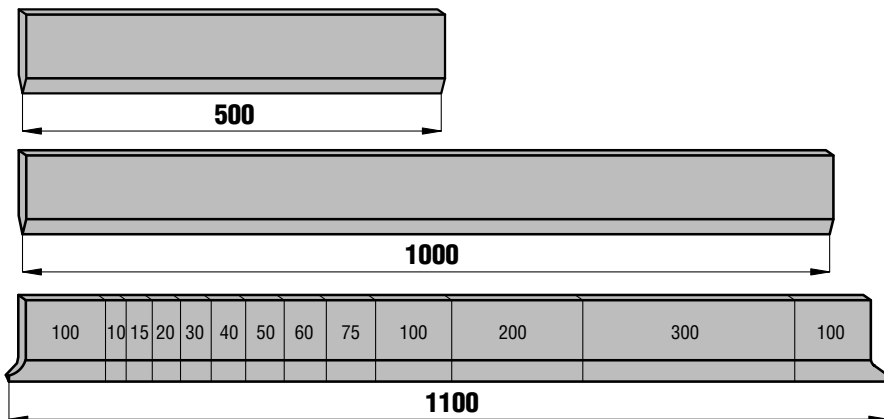
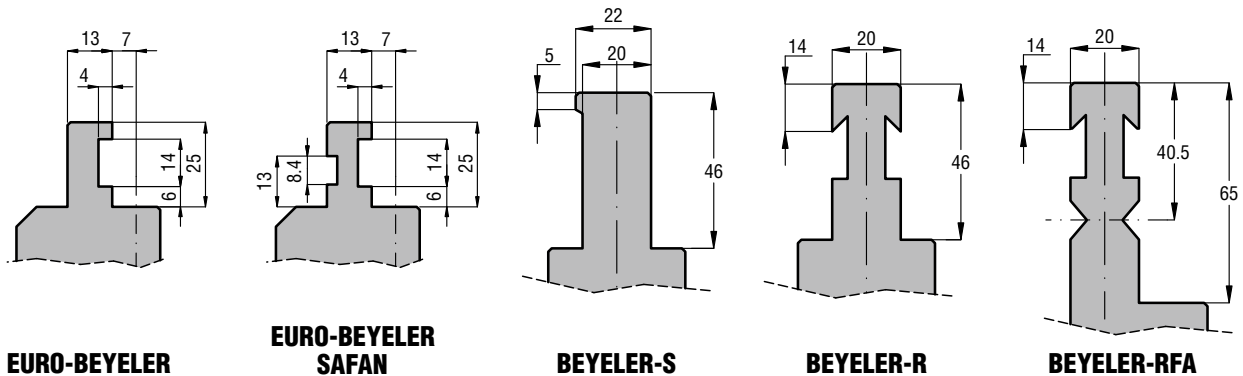
**WEINBRENNER SYSTEM**



L=100 20.709

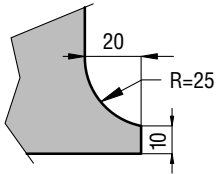
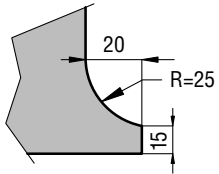
I PUNZONI SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 500 mm - 1000 mm E FRAZIONATI (1100)  
 THE PUNCHES ARE AVAILABLE IN THE FOLLOWING LENGTHS: 500 mm - 1000 mm AND SECTIONED (1100)

<b>ACCIAIO C45 (UNI 7845-78) TEMPRATO AD INDUZIONE 52/55 HRC          SULLE PARTI USURABILI          STEEL C45 (UNI 7845-78) INDUCTION TEMPERED 52/55 HRC          ON WEAR PARTS</b>	
<b>ACCIAIO C45 (UNI 7845-78) BONIFICATO R=80-85 kg/mm<sup>2</sup>          TEMPRATO AD INDUZIONE 52/55 HRC SULLE PARTI USURABILI          STEEL C45 (UNI 7845-78) HARDENED R=80-85 kg/mm<sup>2</sup>          INDUCTION TEMPERED 52/55 HRC ON WEAR PARTS</b>	
<b>ACCIAIO 42CrMo4 (UNI EN 10083-93) BONIFICATO R=95-105 kg/mm<sup>2</sup>          TEMPRATO AD INDUZIONE 52/55 HRC SULLE PARTI USURABILI          STEEL 42CrMo4 (UNI EN 10083-93) HARDENED R=95-105 kg/mm<sup>2</sup>          INDUCTION TEMPERED 52/55 HRC ON WEAR PARTS</b>	

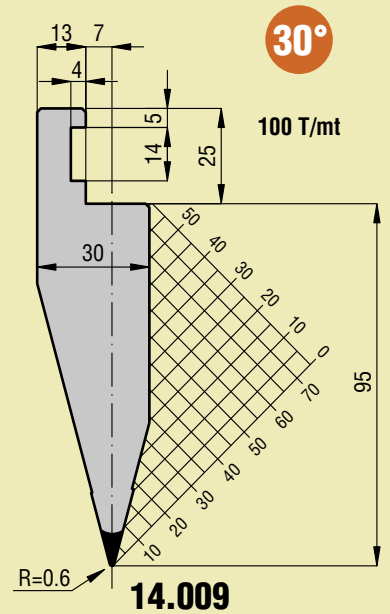
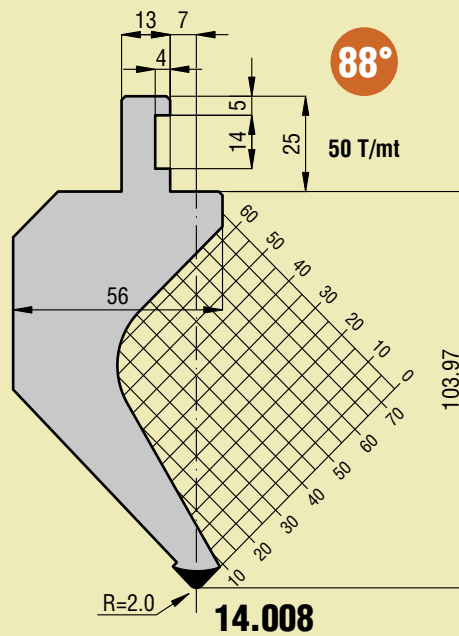
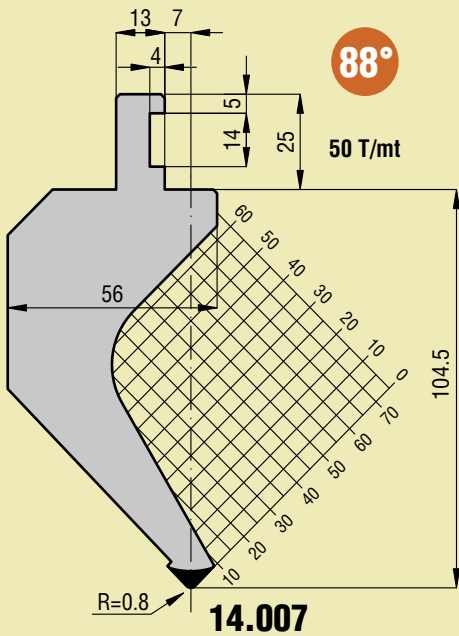
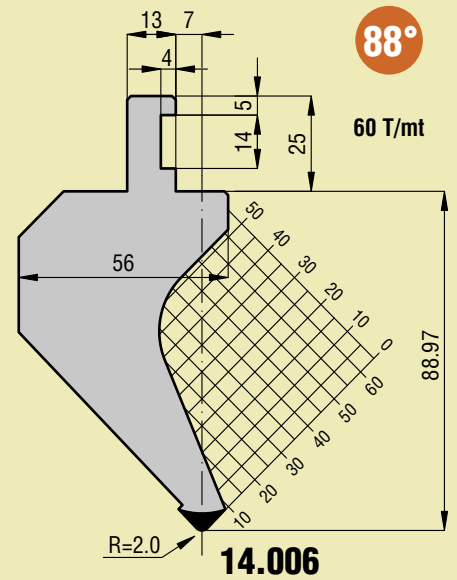
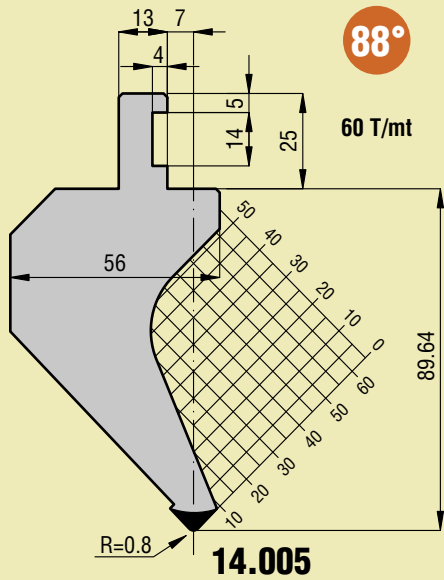
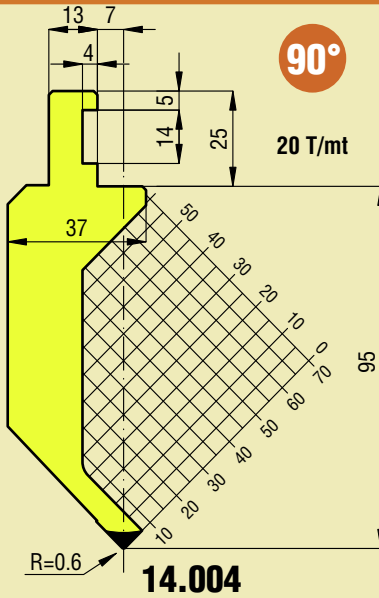
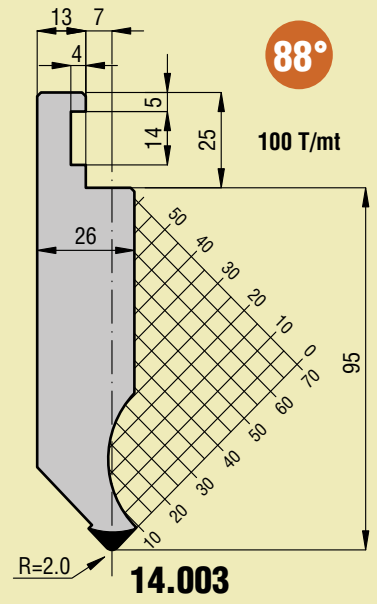
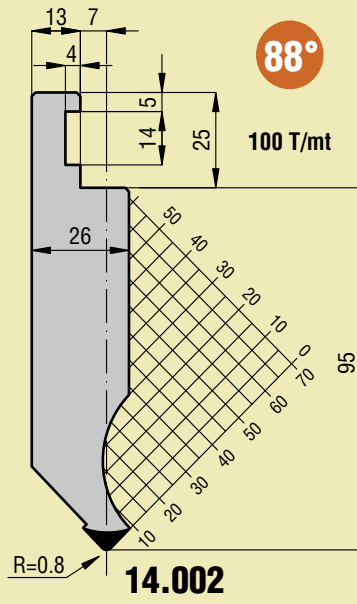
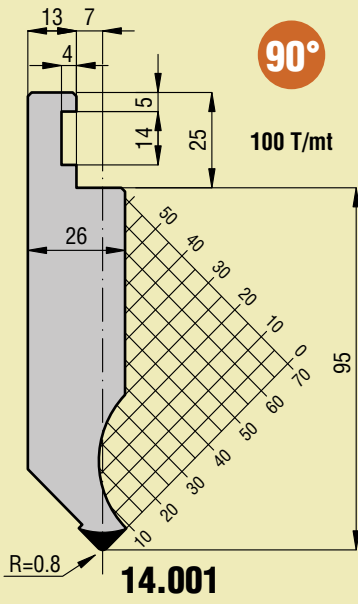


**FRAZIONATURA STANDARD  
 STANDARD SECTIONING**

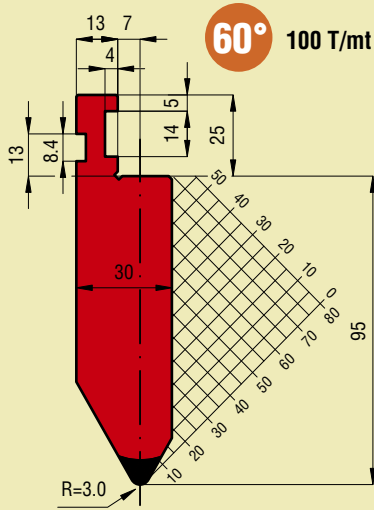
**SCHEMA SCARPETTE FRAZIONATO STANDARD - HORNS SCHEME STANDARD SECTIONING**

	14.001	14.010	
	14.002	14.020	
	14.003	14.030	
	14.005	14.040	
	14.006		
	14.008		
	14.007		
	14.004	14.205	
14.009	14.206	14.310	14.363
14.101	14.207	14.313	14.380
14.105	14.208	14.330	14.383
14.106	14.209	14.333	14.908
14.200	14.210	14.350	14.910
14.201	14.300	14.353	14.912

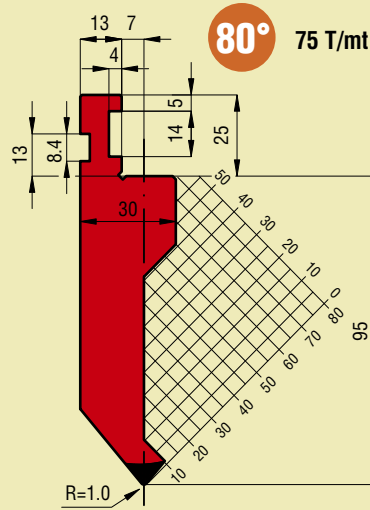
EURO-BEYELER



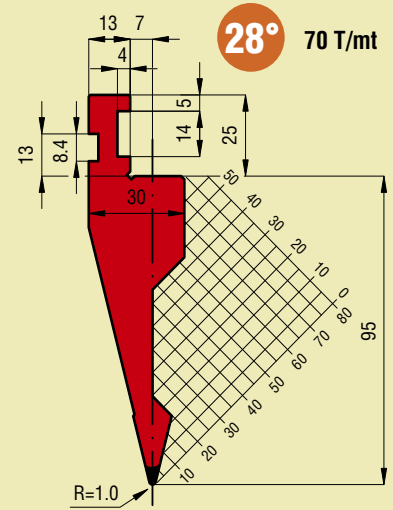
## EURO-BEYELER - SAFAN



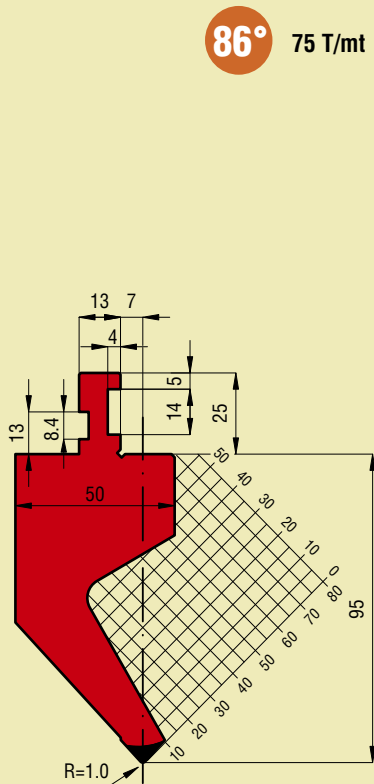
**14.010**



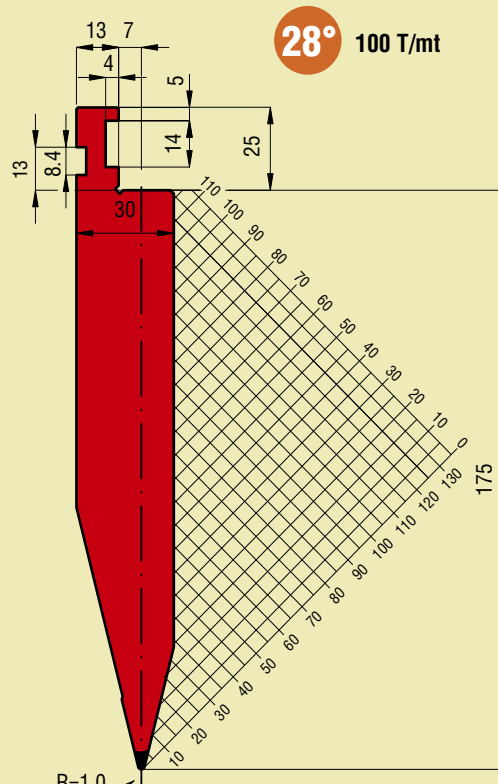
**14.020**



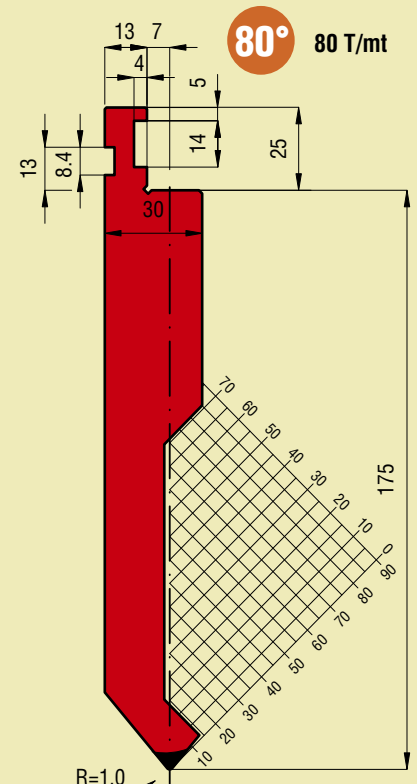
**14.030**



**14.040**

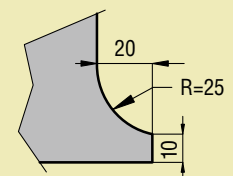
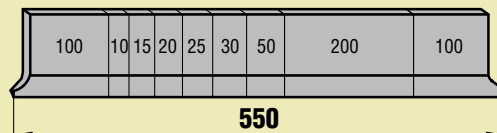
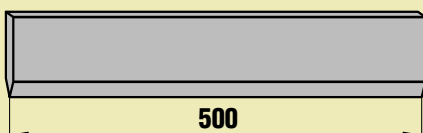


**14.050**



**14.060**

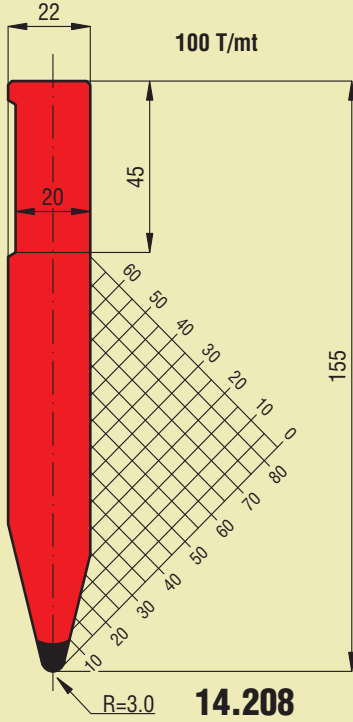
### FRAZIONATURA STANDARD E SCHEMA SCARPETTE STANDARD SECTIONING AND HORNS SCHEME





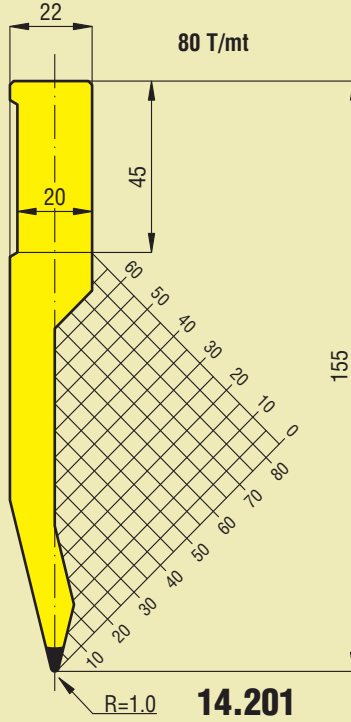
**BEYELER - S**

**28°**



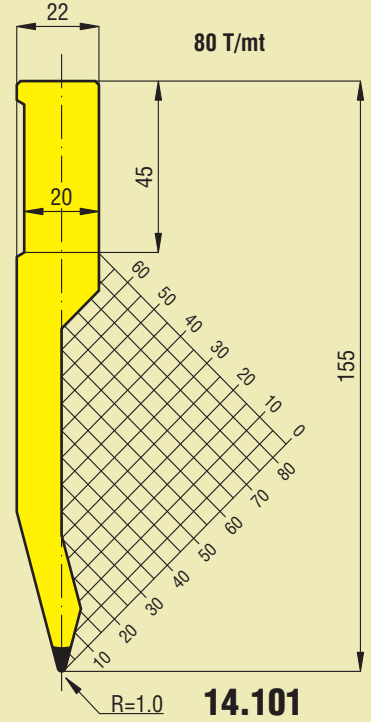
**14.208**

**28°**



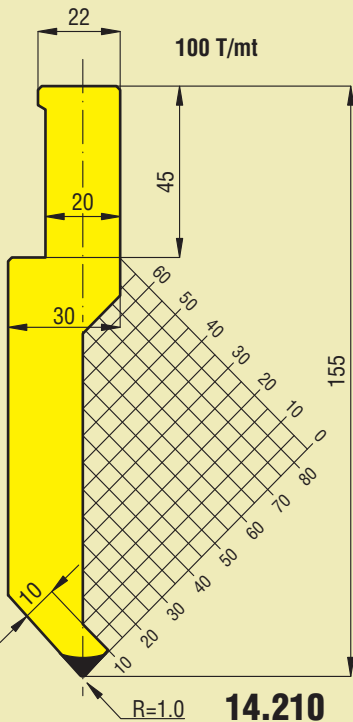
**14.201**

**30°**



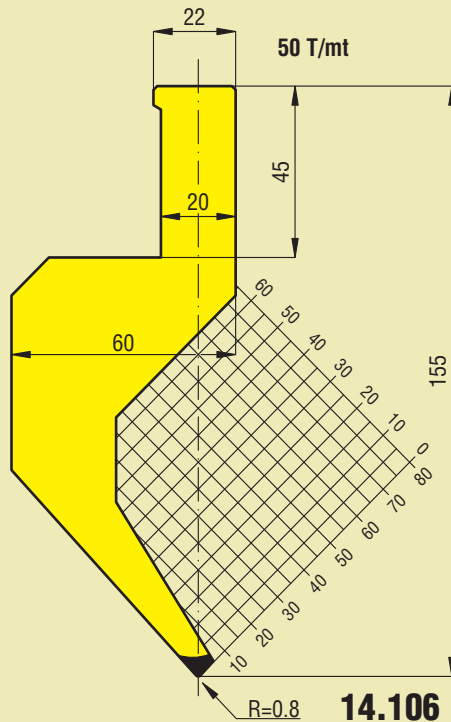
**14.101**

**85°**



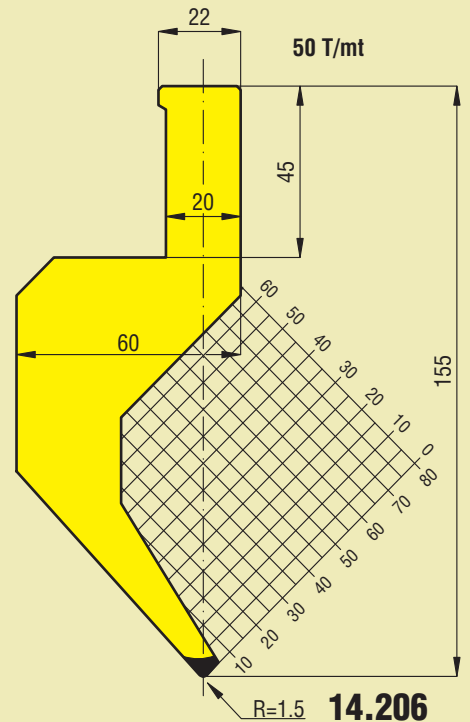
**14.210**

**85°**



**14.106**

**85°**

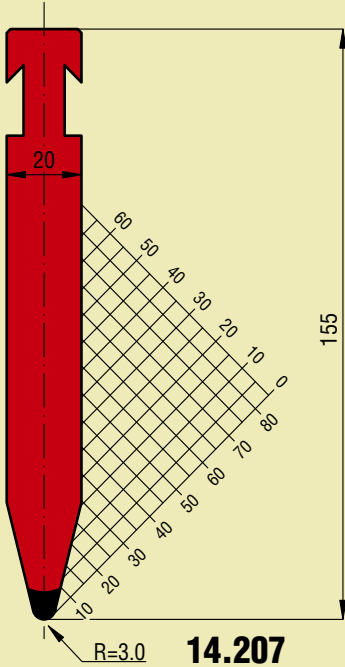


**14.206**

## BEYELER - R

28°

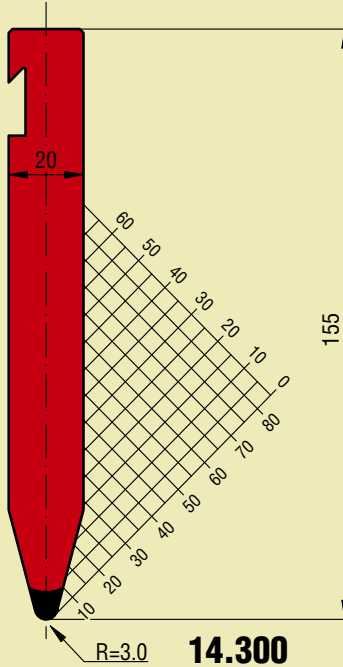
100 T/mt



R=3.0 **14.207**

30°

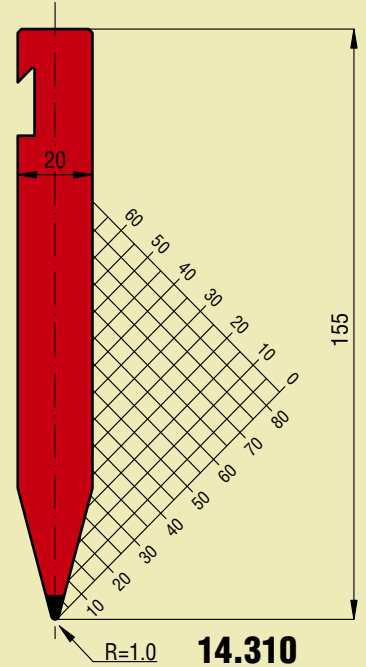
100 T/mt



R=3.0 **14.300**

30°

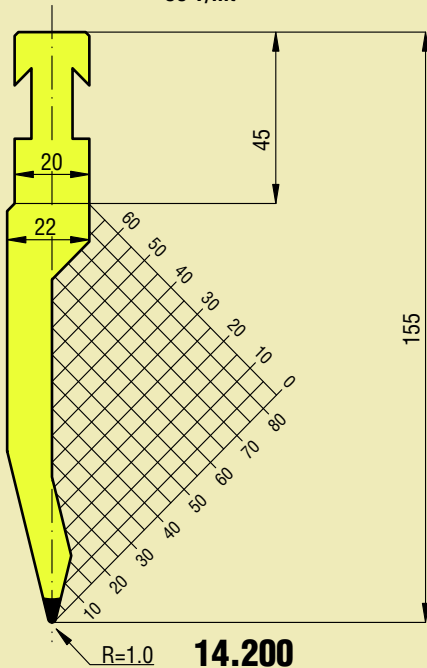
100 T/mt



R=1.0 **14.310**

28°

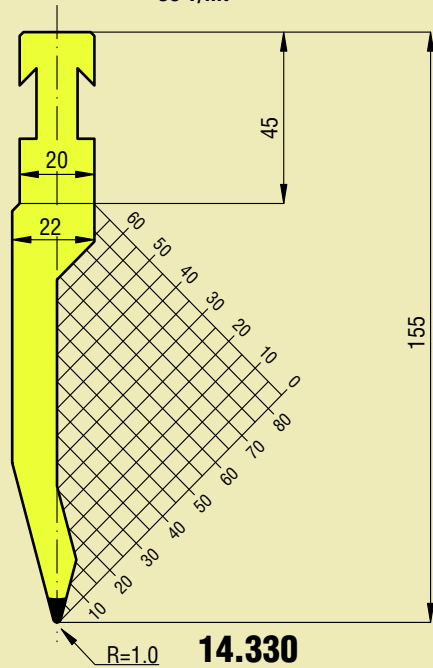
80 T/mt



R=1.0 **14.200**

30°

80 T/mt

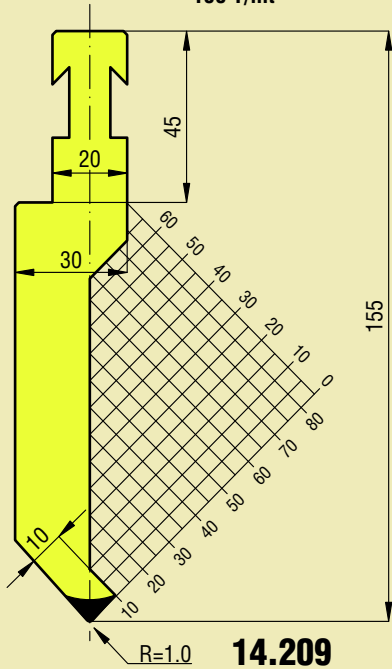


R=1.0 **14.330**

BEYELER - R

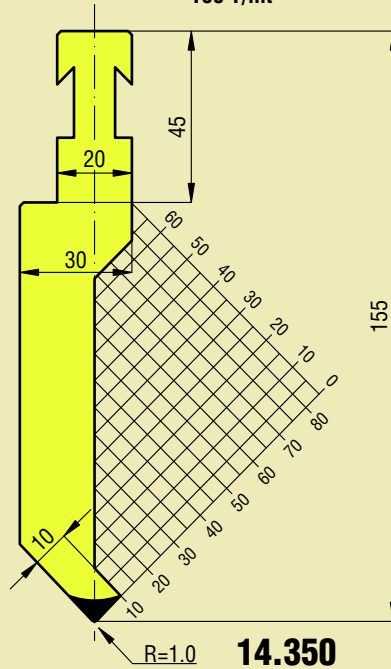
85°

100 T/mt



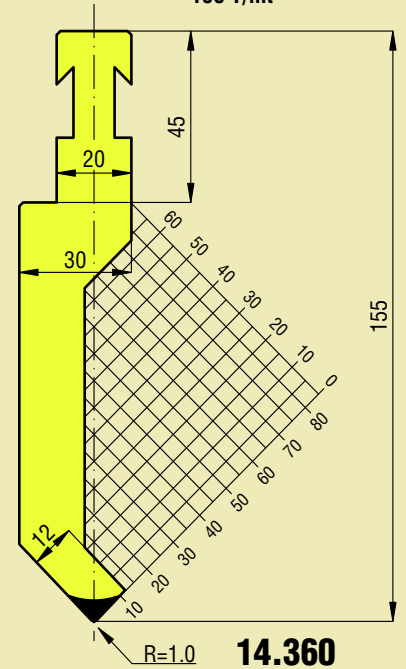
88°

100 T/mt



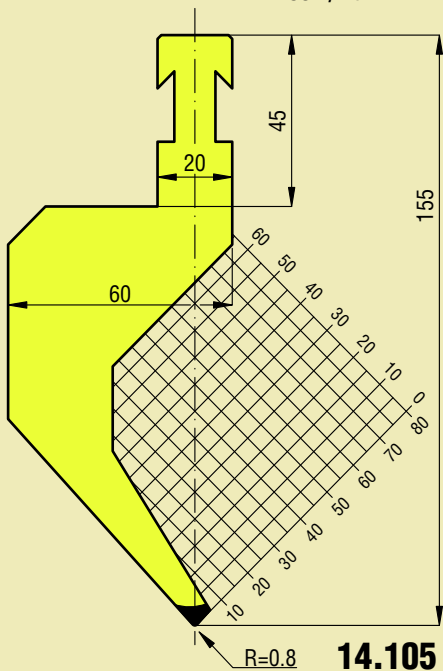
88°

100 T/mt



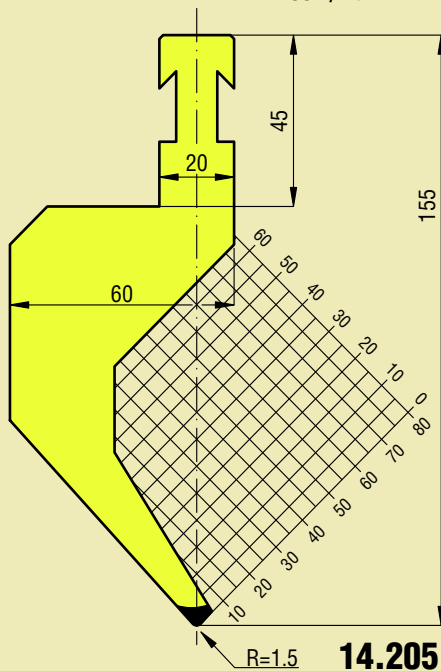
85°

50 T/mt



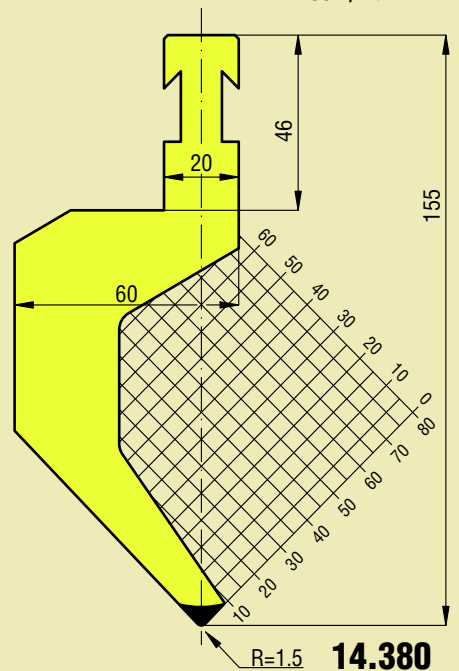
85°

50 T/mt



88°

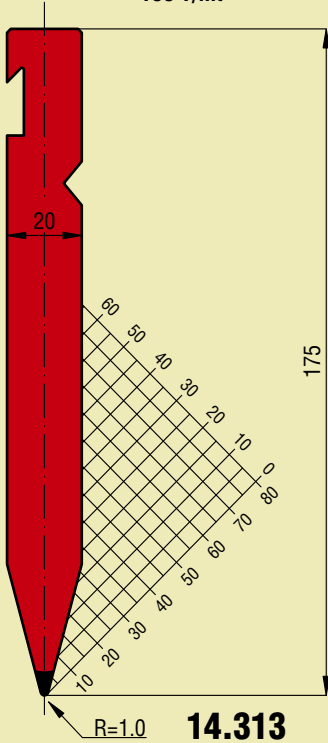
50 T/mt



## BEYELER - RFA

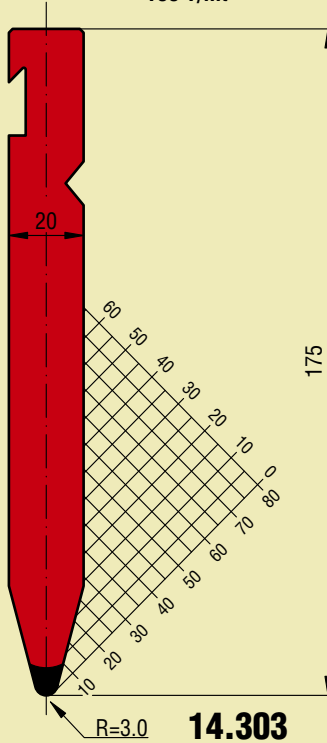
30°

100 T/mt



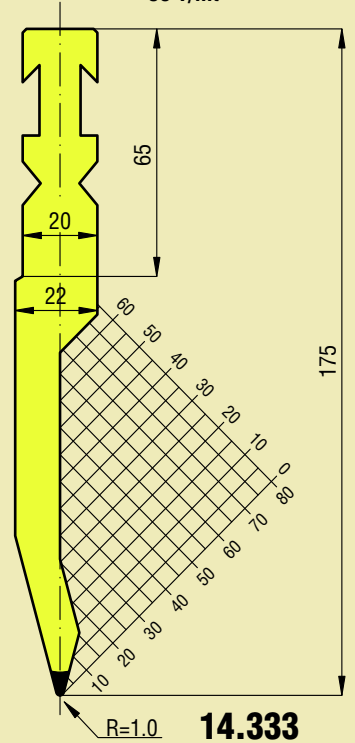
30°

100 T/mt



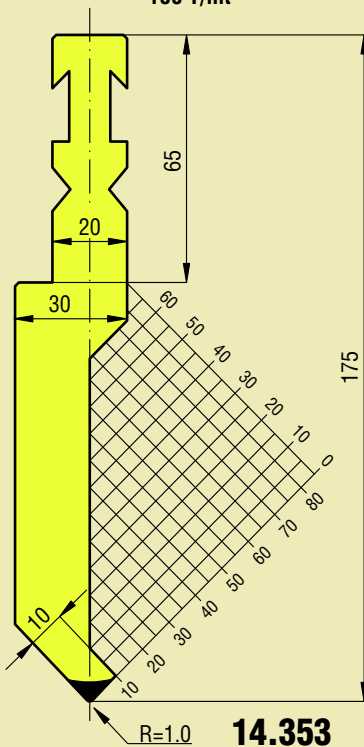
30°

80 T/mt



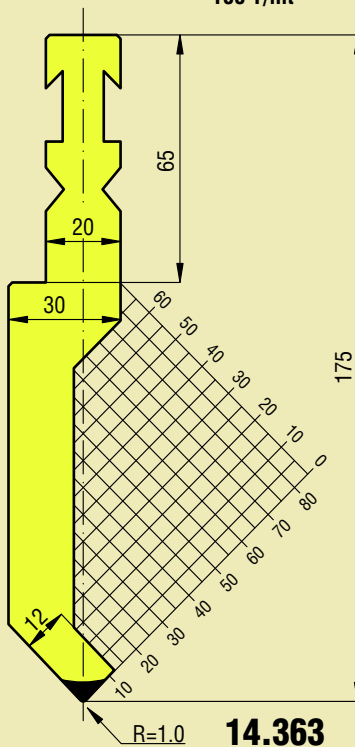
88°

100 T/mt



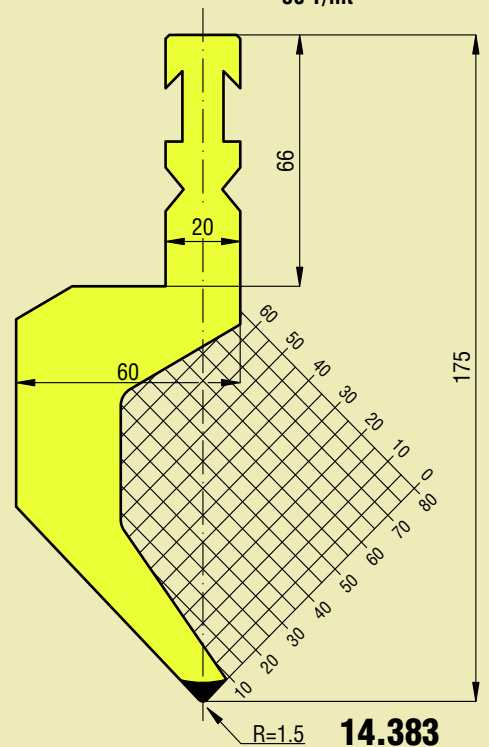
88°

100 T/mt

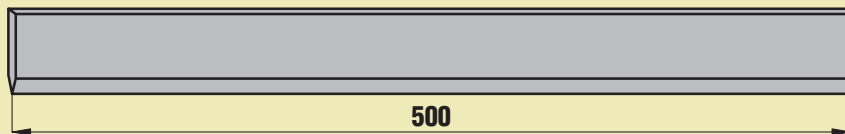
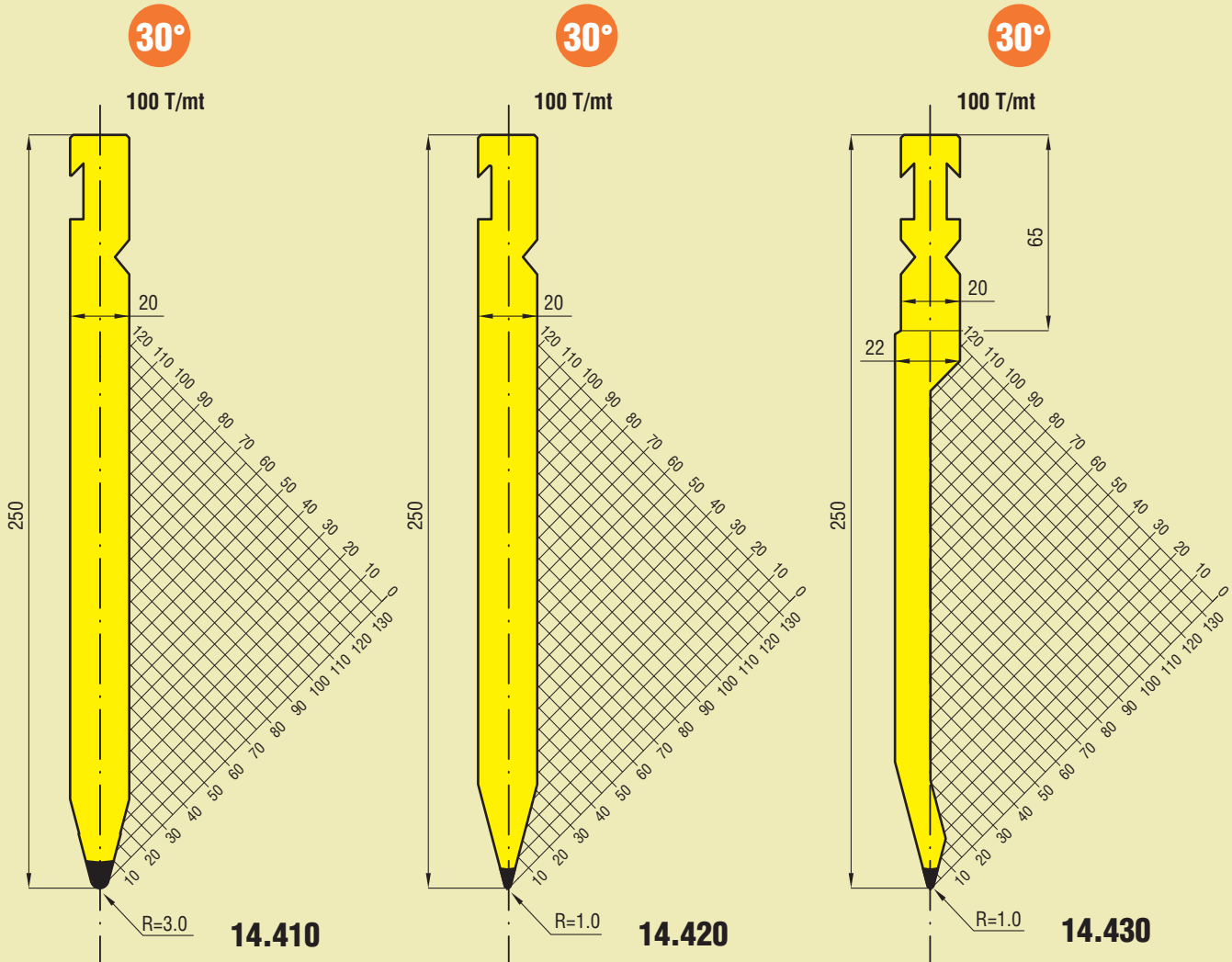


88°

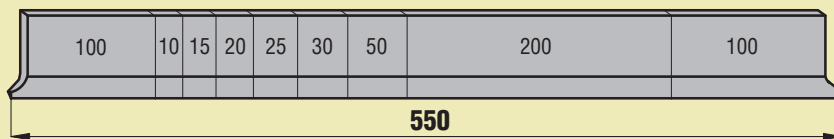
50 T/mt



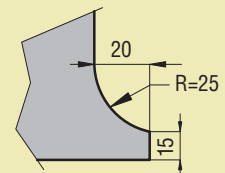
**BEYELER - RFA**



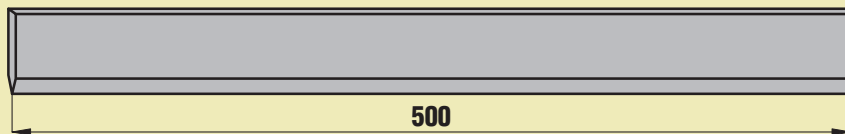
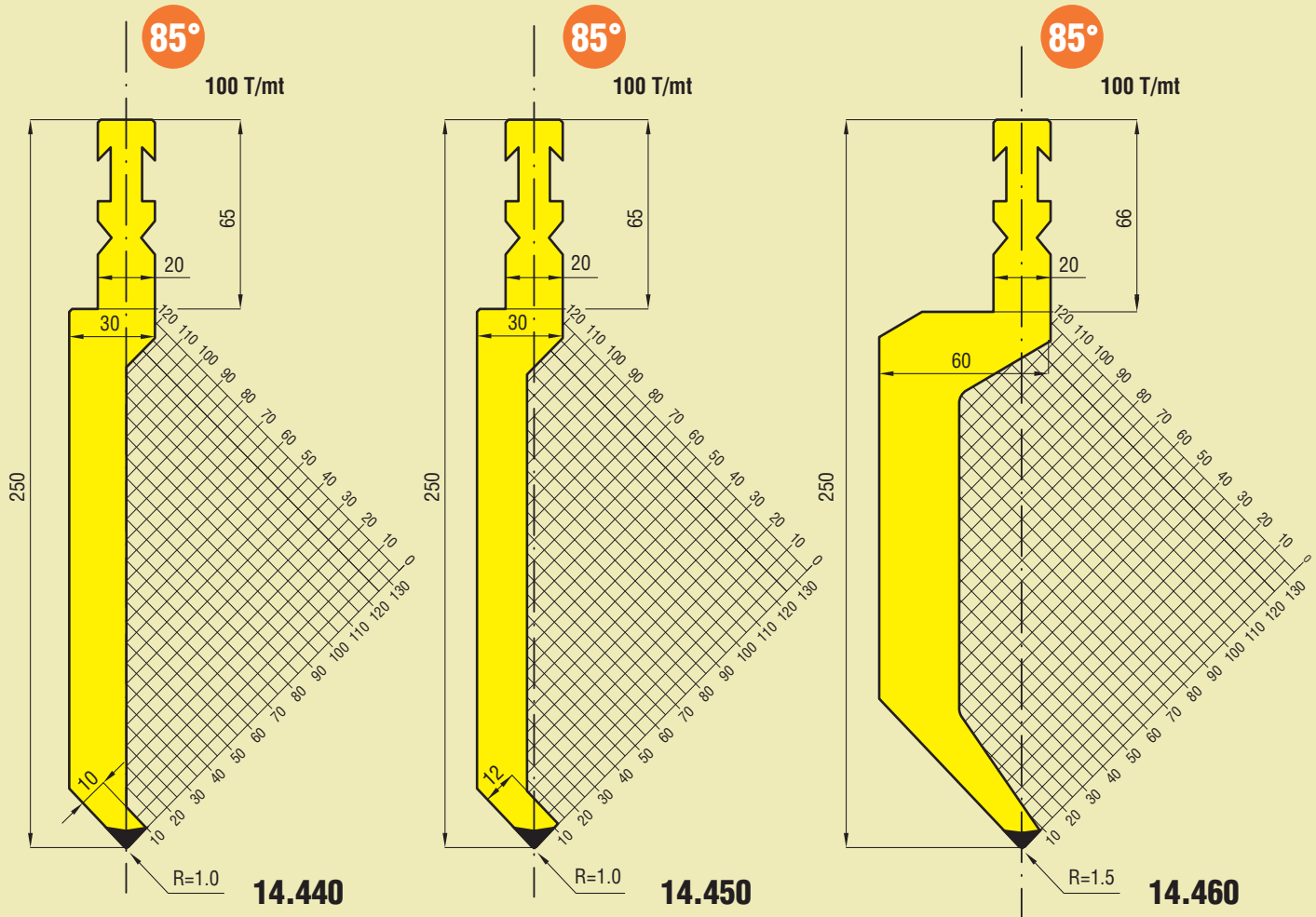
**FRAZIONATURA STANDARD  
STANDARD SECTIONING**



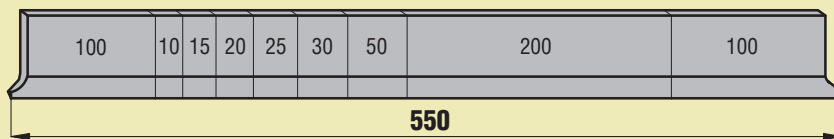
**SCHEMA SCARPETTE FRAZIONATO STANDARD  
HORNS SCHEME STANDARD SECTIONING**



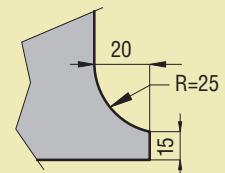
## BEYELER - RFA



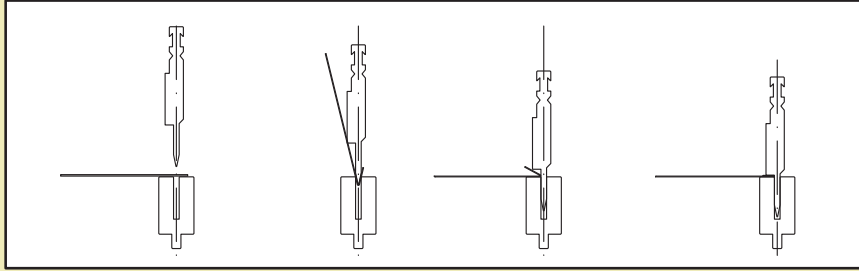
**FRAZIONATURA STANDARD  
STANDARD SECTIONING**



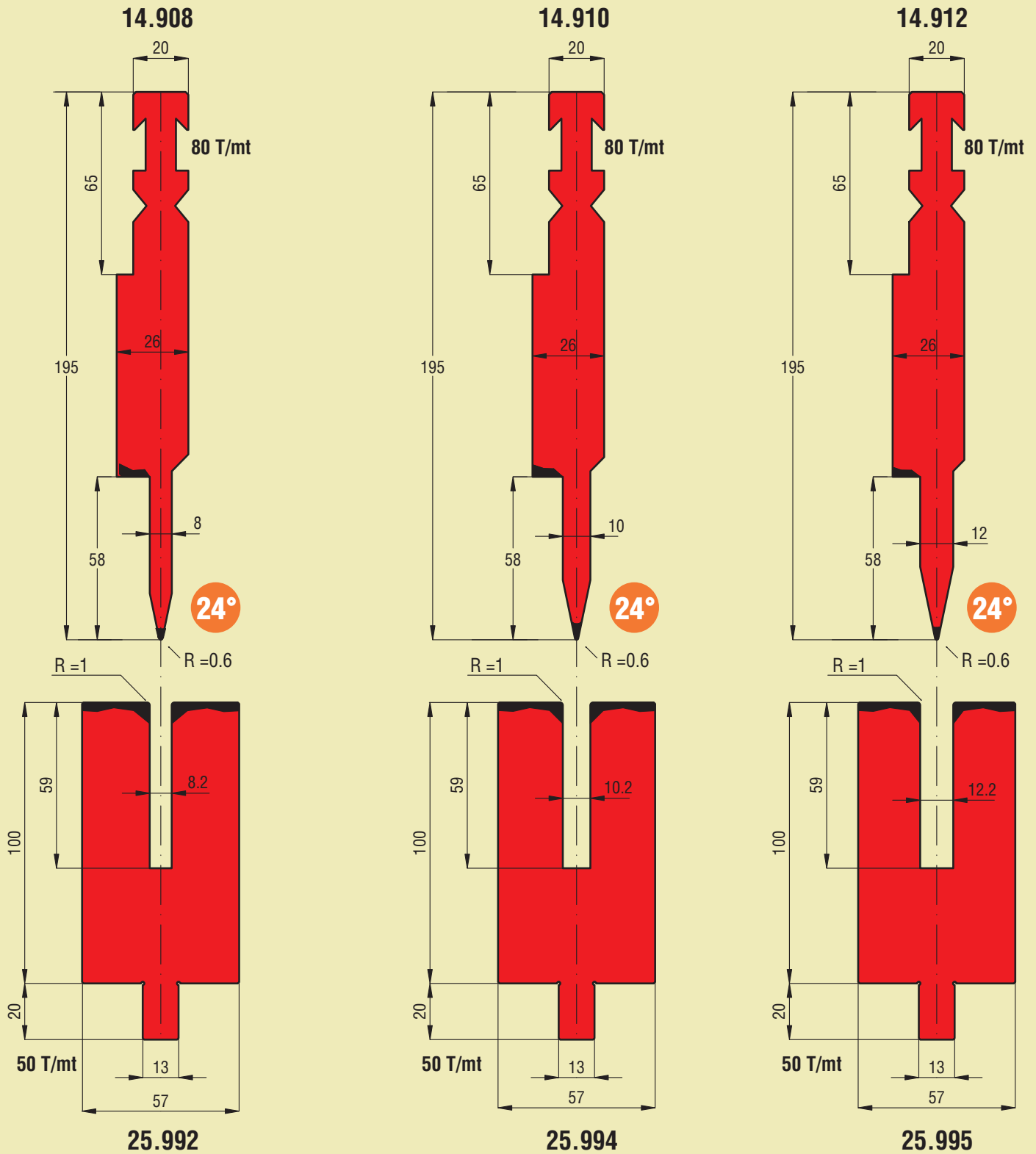
**SCHEMA SCARPETTE FRAZIONATO STANDARD  
HORNS SCHEME STANDARD SECTIONING**



# PIEGASCHIACCIA BEYELER BEYELER FLATTENING-HEMMING TOOLS

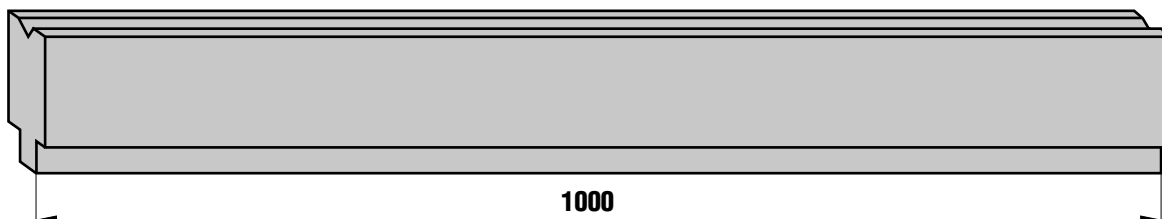
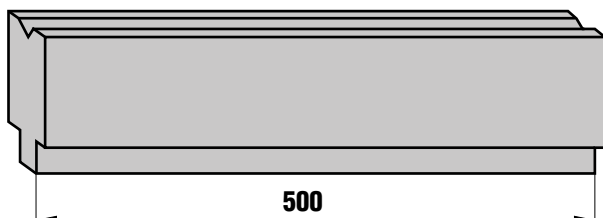
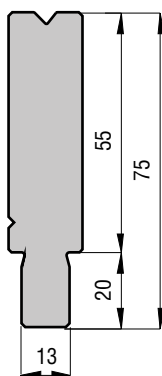


**L=500**  
**L=550 S.**

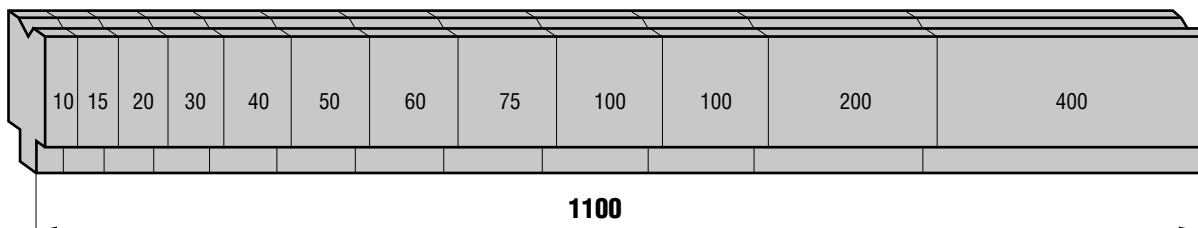


LE MATRICI SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 500 mm - 1000 mm E FRAZIONATE (1100)  
 THE DIES ARE AVAILABLE IN THE FOLLOWING LENGTHS: 500 mm - 1000 mm AND SECTIONED (1100)

**ACCIAIO C45 (UNI 7845-78) TEMPRATO AD INDUZIONE 52/55 HRC  
 SULLE PARTI USURABILI  
 STEEL C45 (UNI 7845-78) INDUCTION TEMPERED 52/55 HRC  
 ON WEAR PARTS**

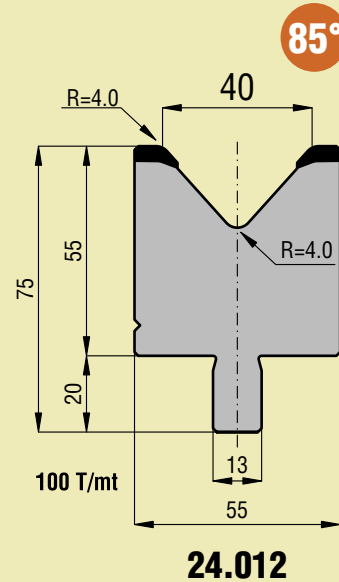
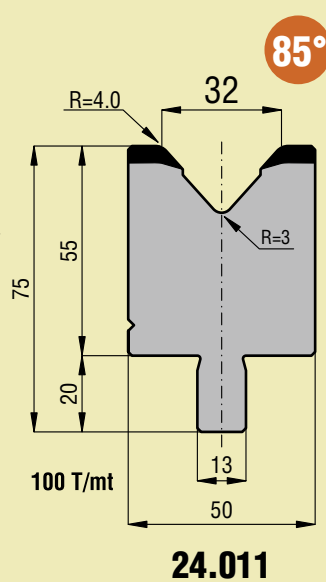
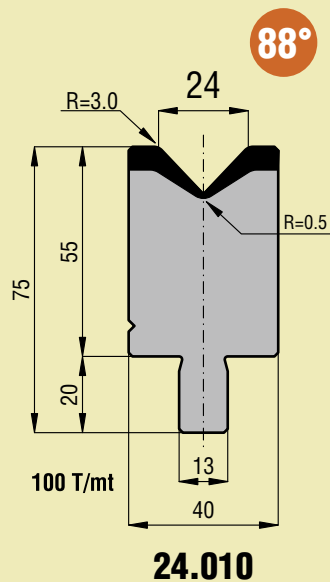
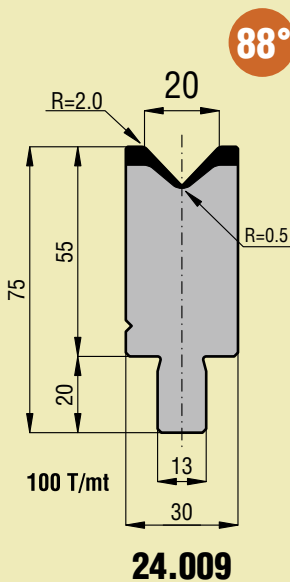
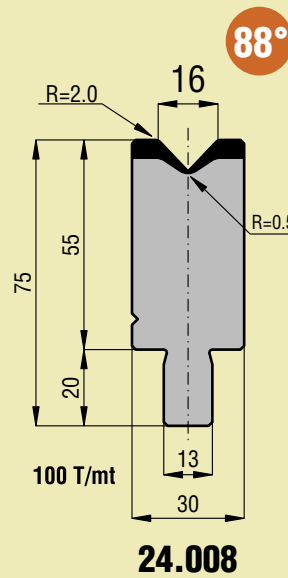
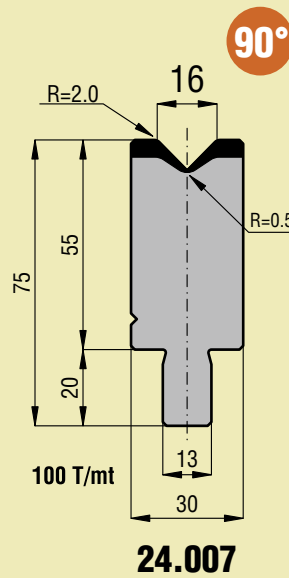
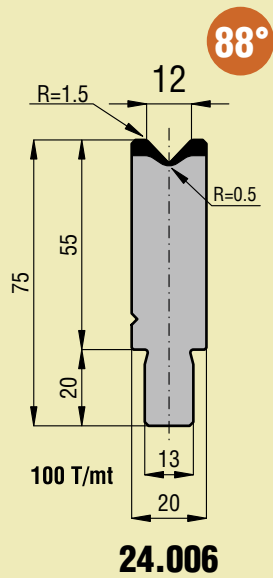
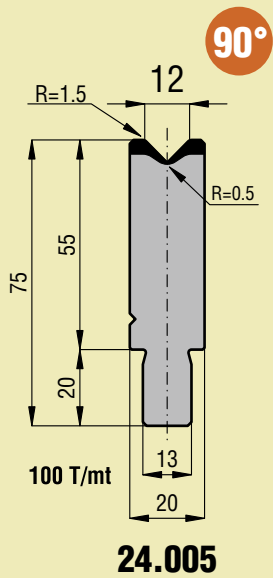
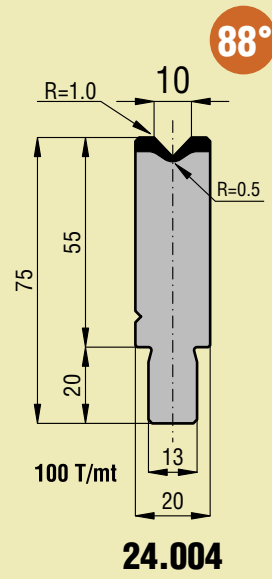
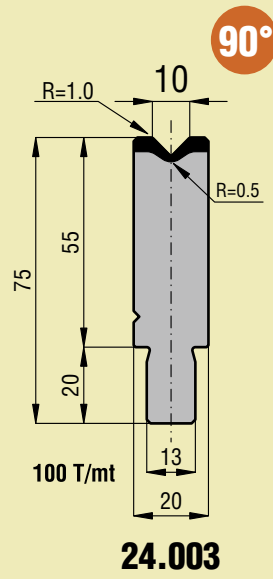
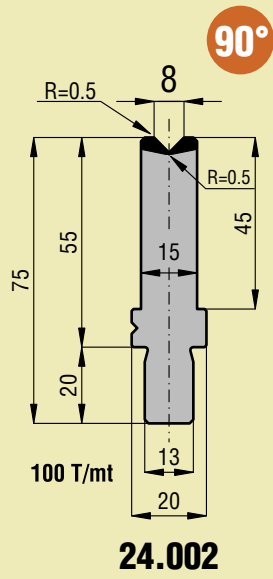
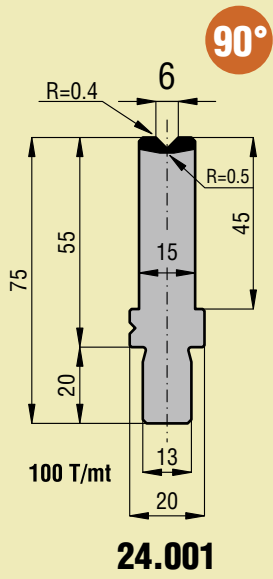


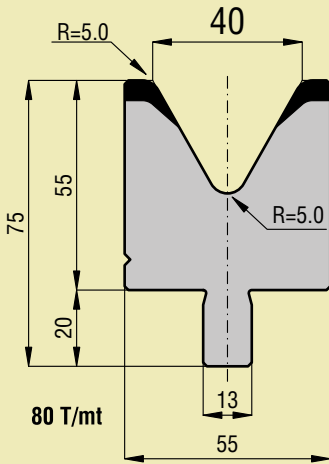
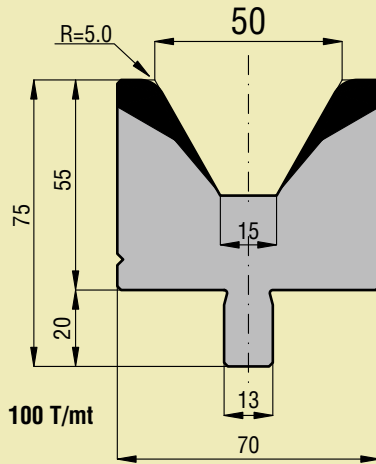
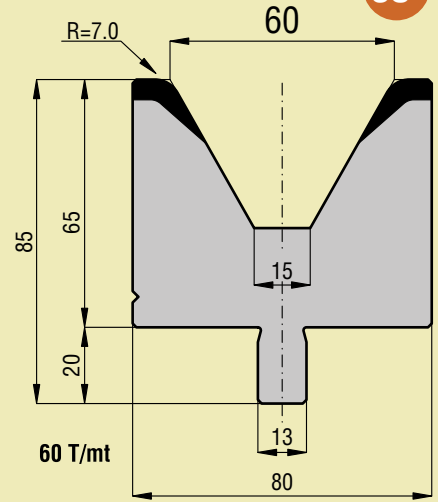
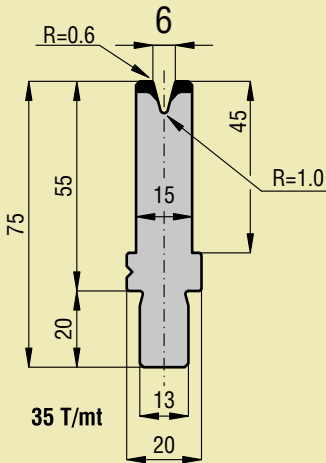
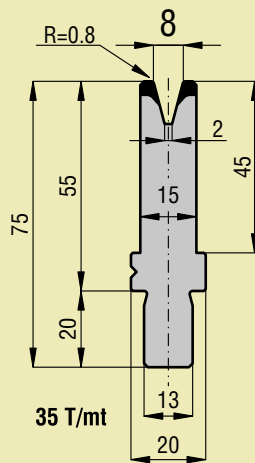
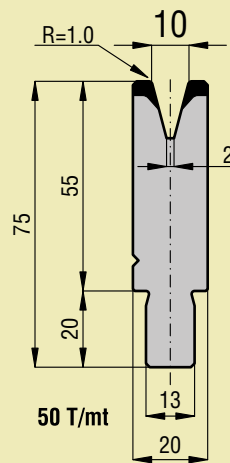
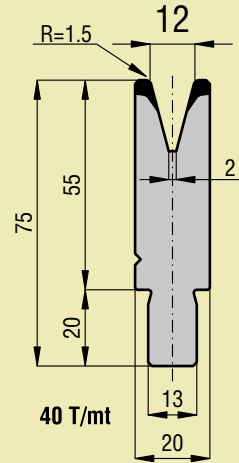
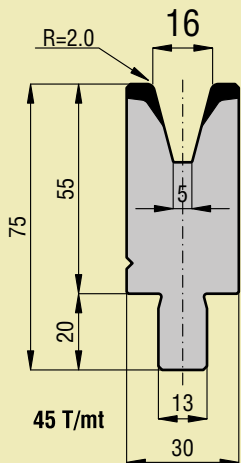
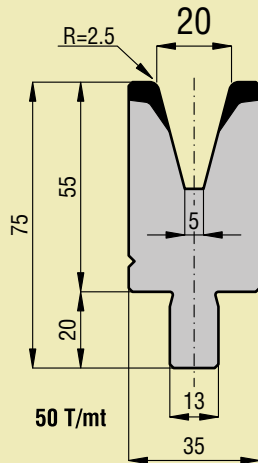
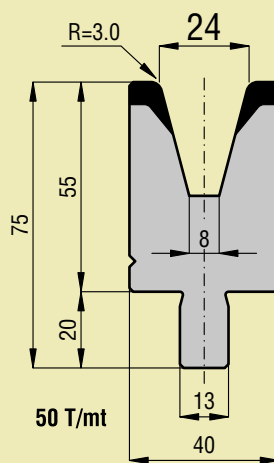
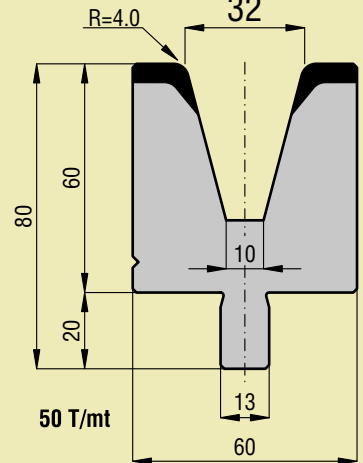
**FRAZIONATURA STANDARD  
 STANDARD SECTIONING**



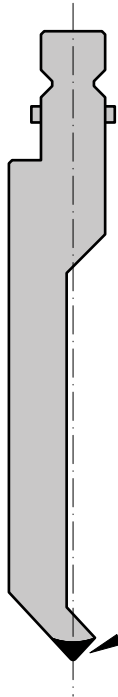


**BEYELER / SAFAN**



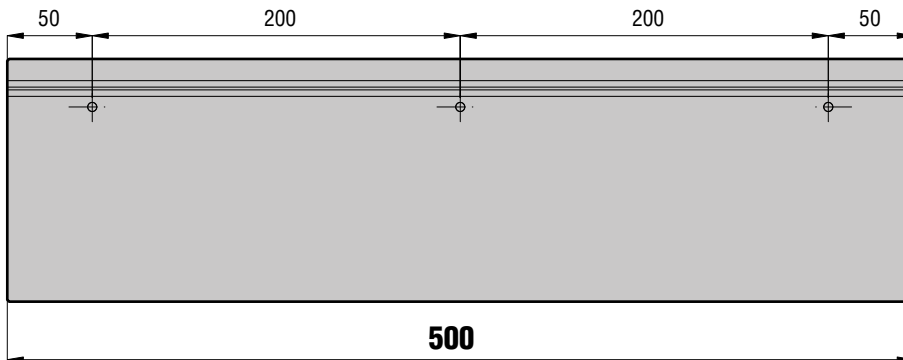
**BEYELER / SAFAN**
**60°**

**24.040**
**60°**

**24.050**
**60°**

**24.060**
**30°**

**24.013**
**30°**

**24.014**
**30°**

**24.015**
**30°**

**24.016**
**30°**

**24.017**
**30°**

**24.019**
**30°**

**24.018**
**30°**

**24.035**

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

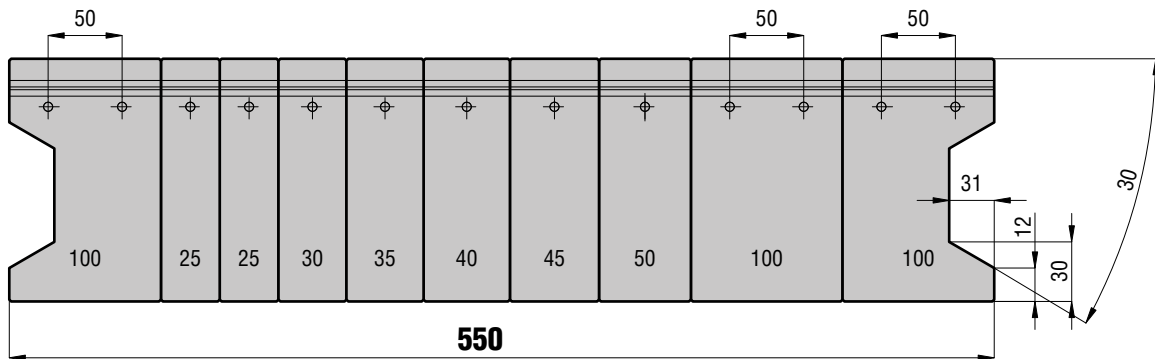


<p><b>ACCIAIO C45 (UNI 7845-78) BONIFICATO R=80-85 kg/mm<sup>q</sup></b>  <b>TEMPRATO AD INDUZIONE 52/55 HRC SULLE PARTI USURABILI</b>  <b>STEEL C45 (UNI 7845-78) HARDENED R=80-85 kg/mm<sup>q</sup></b>  <b>INDUCTION TEMPERED 52/55 HRC ON WEAR PARTS</b></p>	
<p><b>ACCIAIO 42CrMo4 (UNI EN 10083-93) BONIFICATO R=95-105 kg/mm<sup>q</sup></b>  <b>TEMPRATO AD INDUZIONE 52/55 HRC SULLE PARTI USURABILI</b>  <b>STEEL 42CrMo4 (UNI EN 10083-93) HARDENED R=95-105 kg/mm<sup>q</sup></b>  <b>INDUCTION TEMPERED 52/55 HRC ON WEAR PARTS</b></p>	

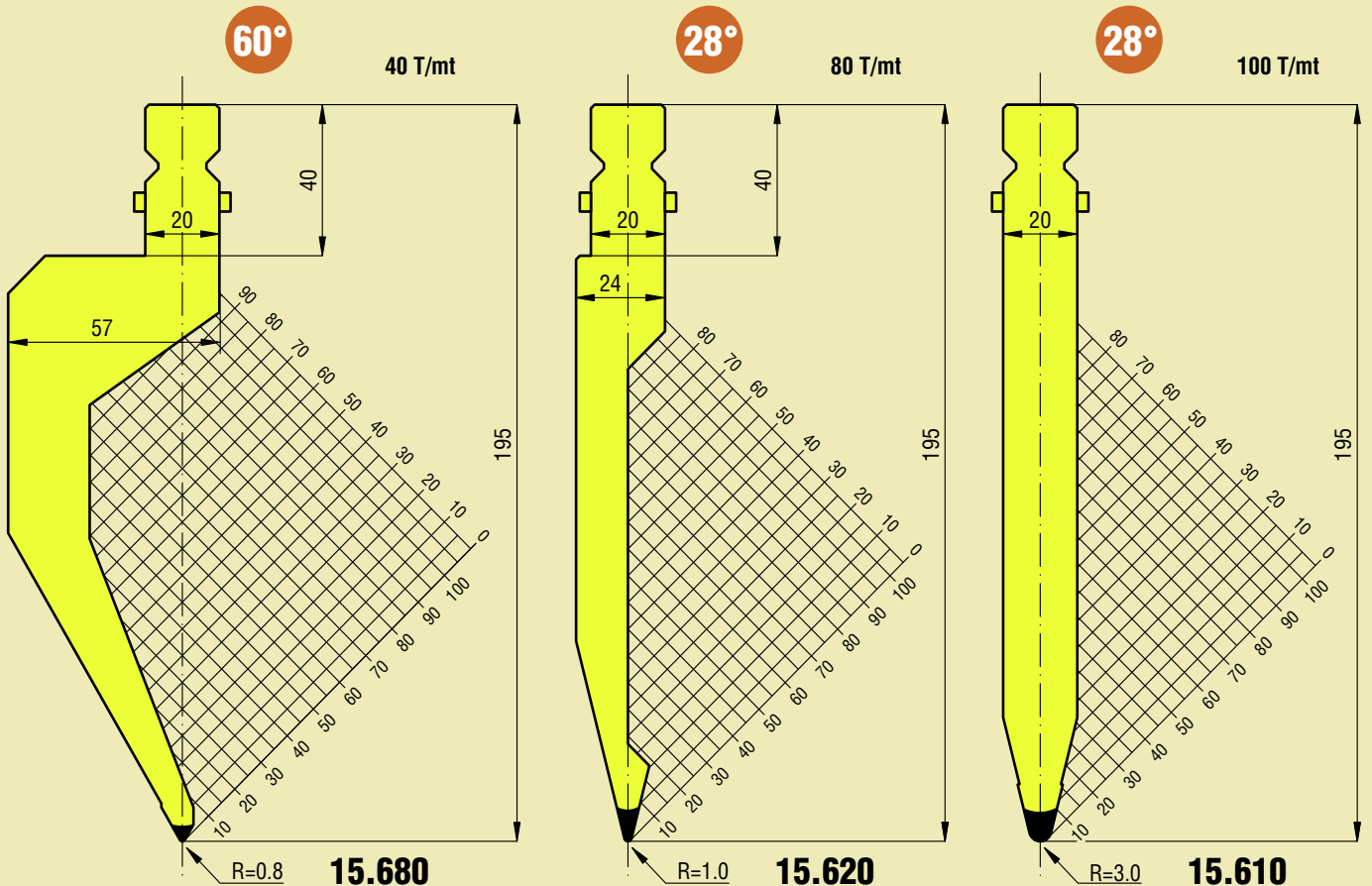
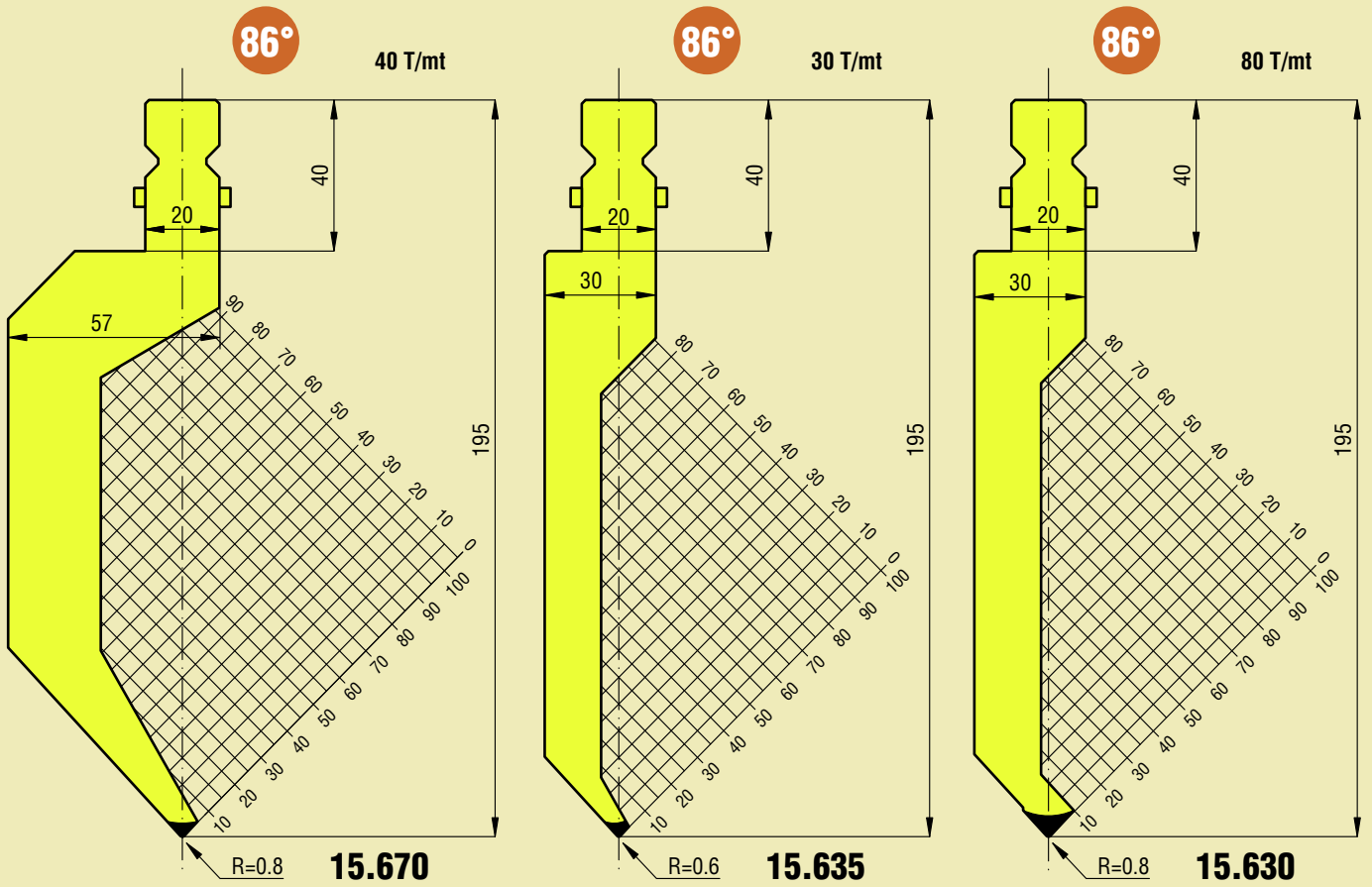
PARTI USURABILI  
 WEAR PARTS



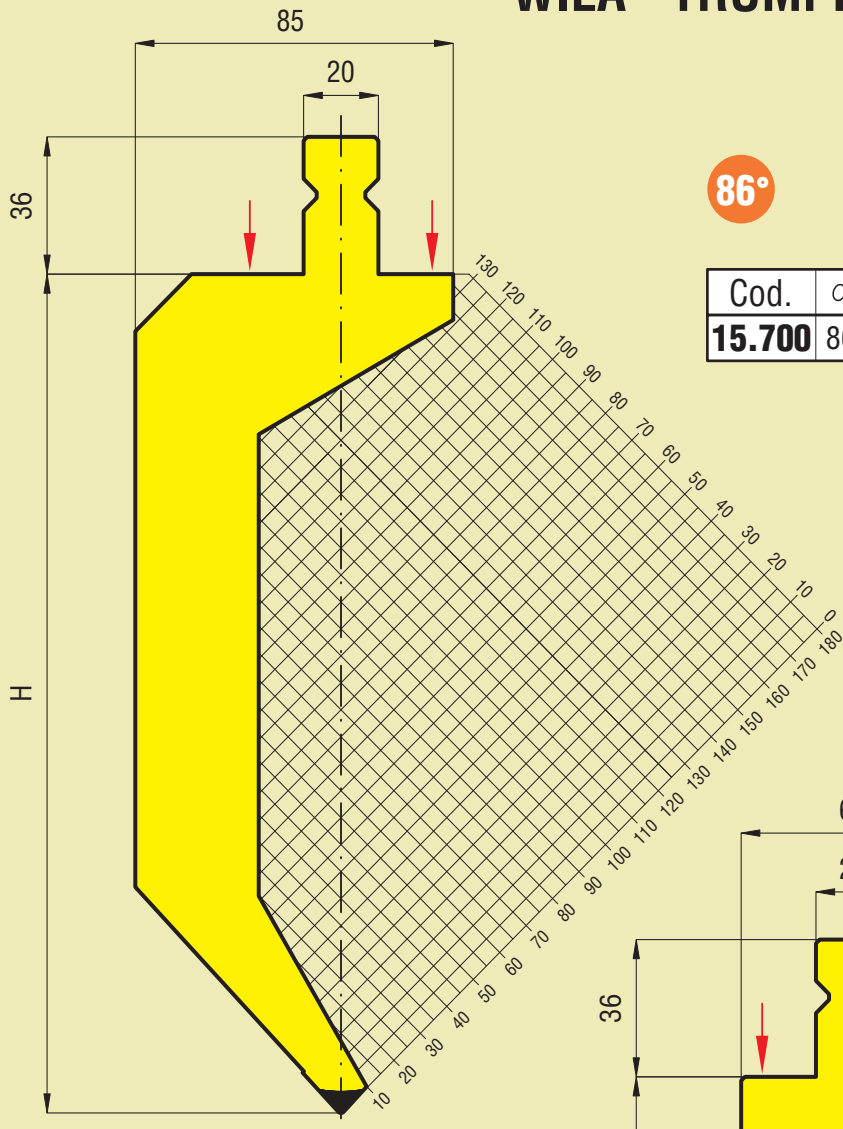
## FRAZIONATURA STANDARD STANDARD SECTIONING



## WILA - TRUMPF



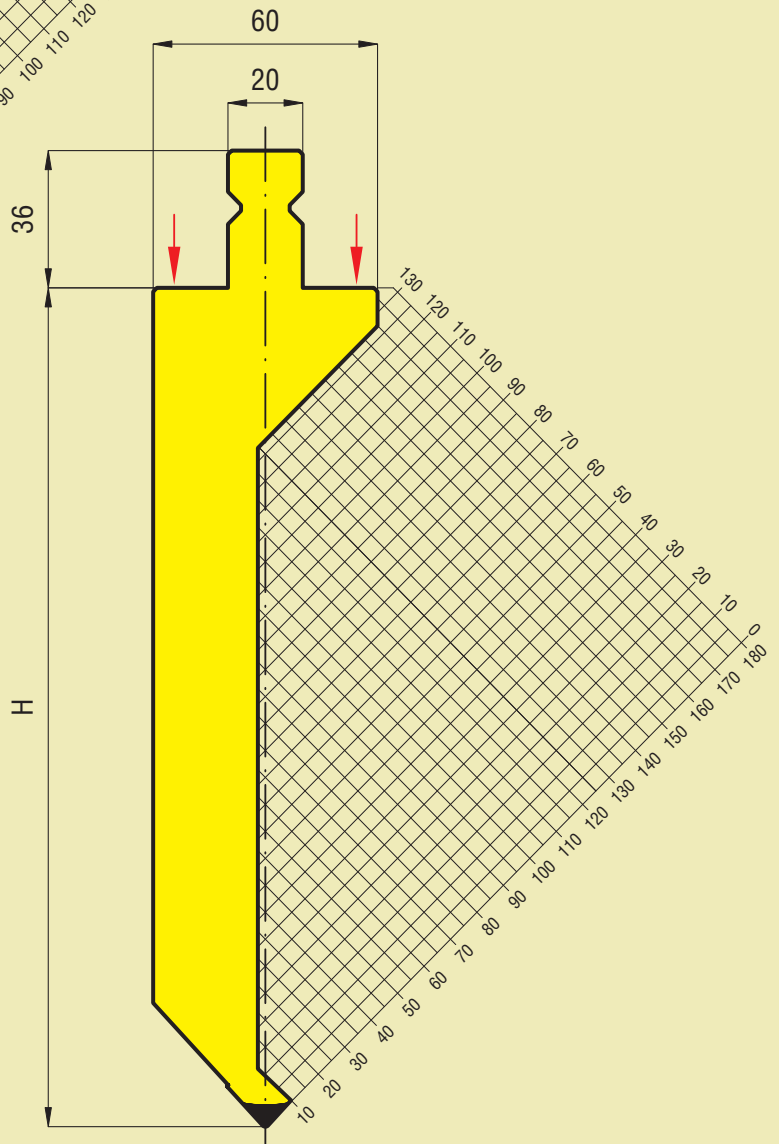
WILA - TRUMPF



86°

Cod.	$\alpha$	R	H	Max T/mt
<b>15.700</b>	86°	1.00	220.00	80

H

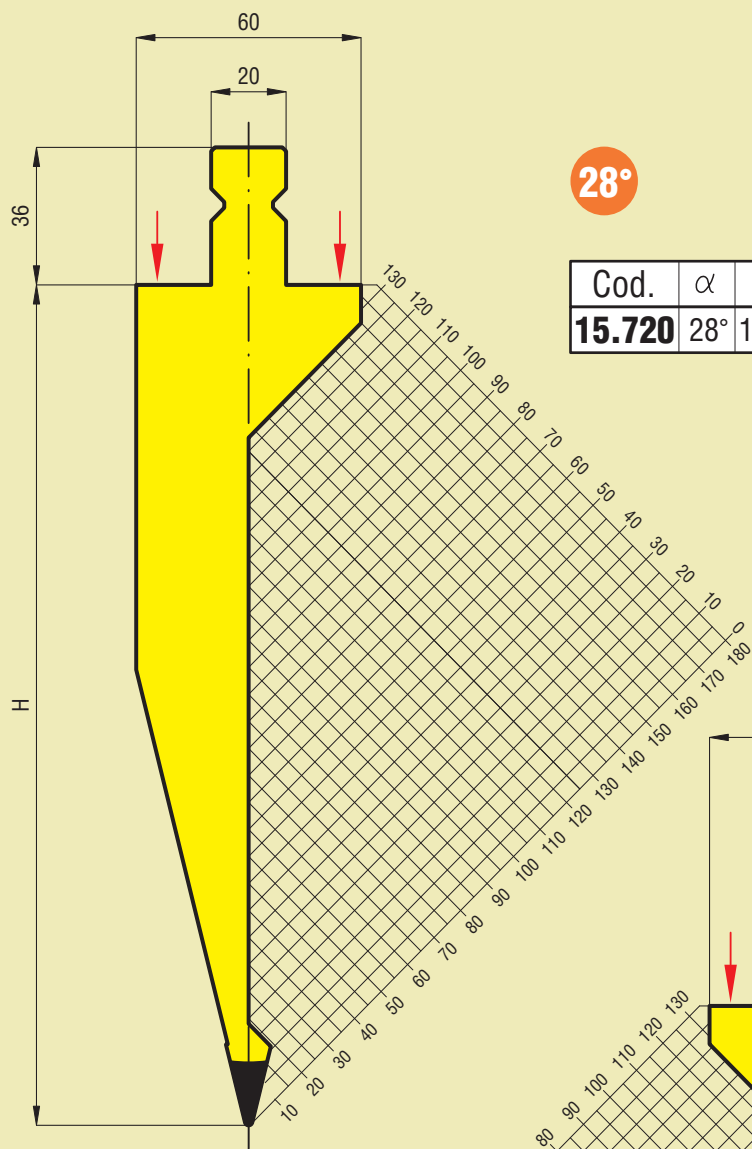


86°

Cod.	$\alpha$	R	H	Max T/mt
<b>15.710</b>	86°	1.00	220.00	80

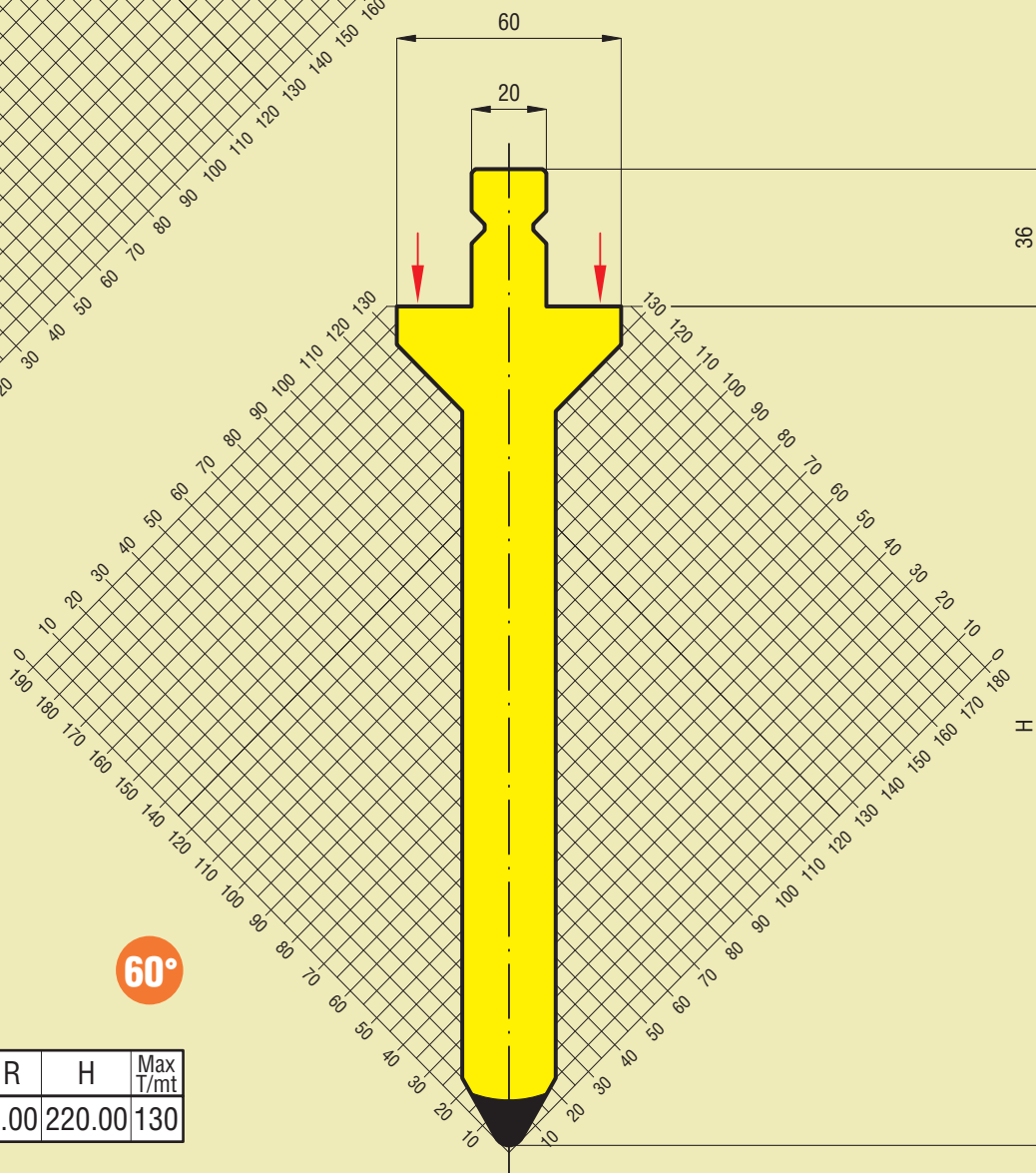
H

## WILA - TRUMPF



**28°**

Cod.	$\alpha$	R	H	Max T/mt
<b>15.720</b>	28°	1.00	220.00	80



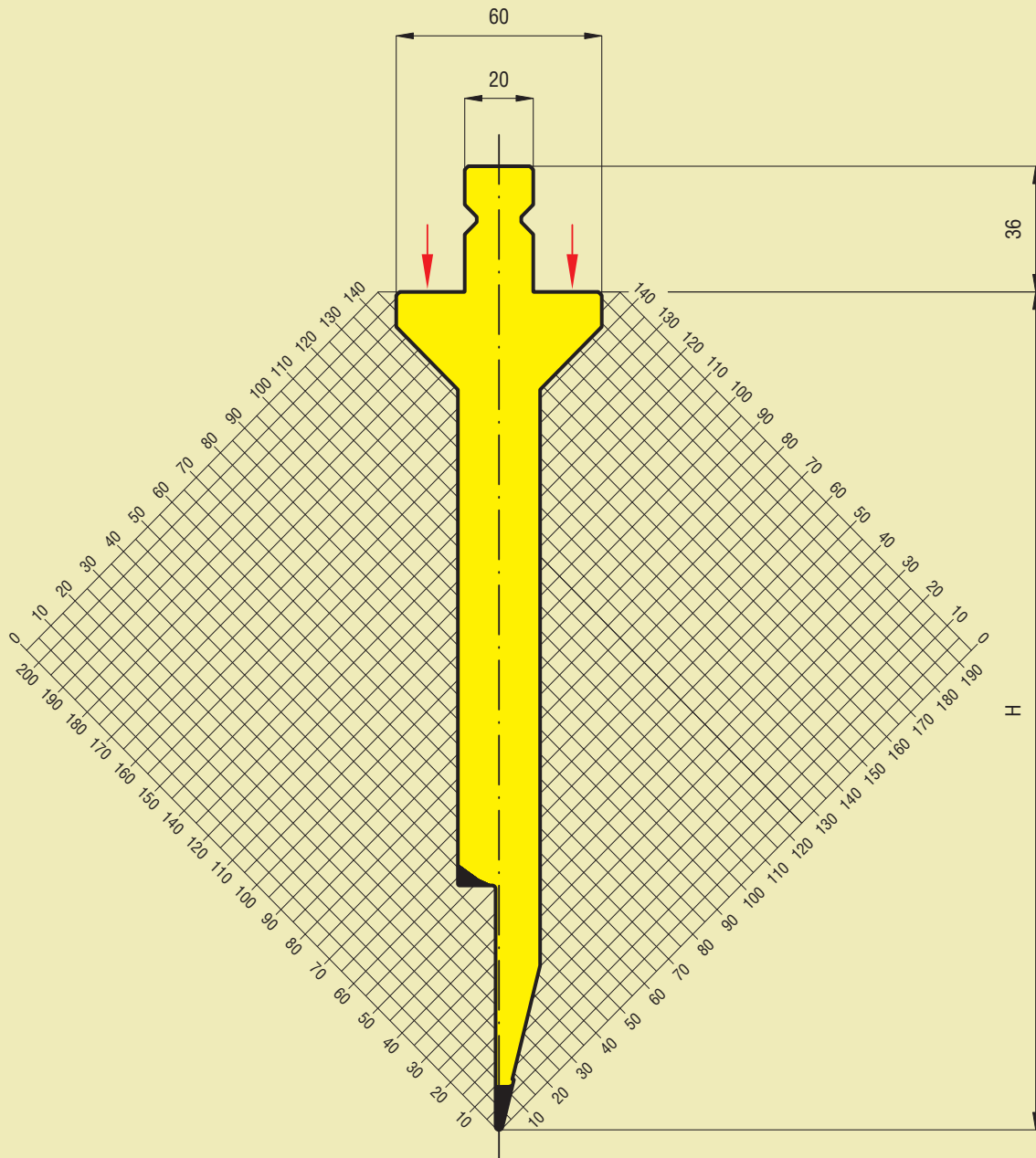
**60°**

Cod.	$\alpha$	R	H	Max T/mt
<b>15.730</b>	60°	4.00	220.00	130

# WILA - TRUMPF

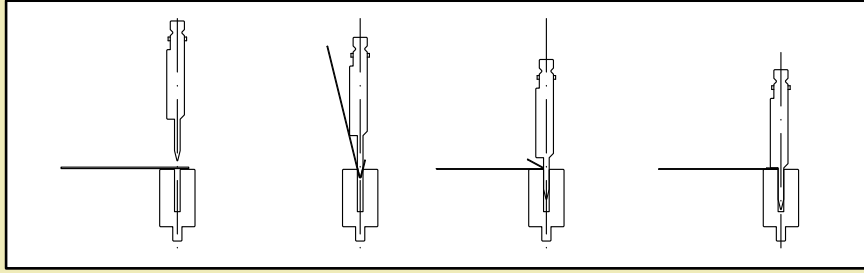
28°

Cod.	$\alpha$	R	H	Max T/mt
<b>15.750</b>	28°	1.00	240.00	40





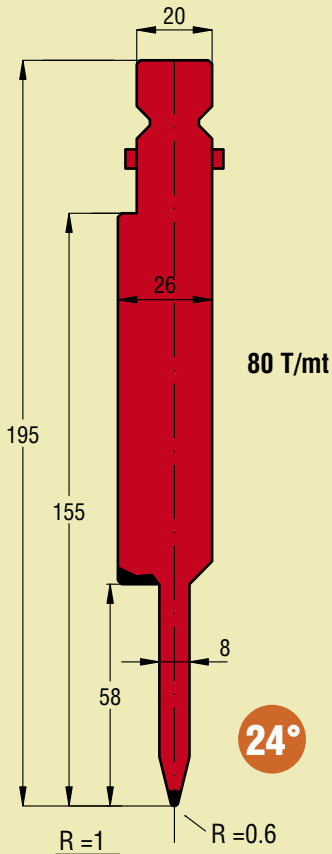
# PIEGASCHIACCIA WILA/TRUMPF WILA/TRUMPF FLATTENING-HEMMING TOOLS



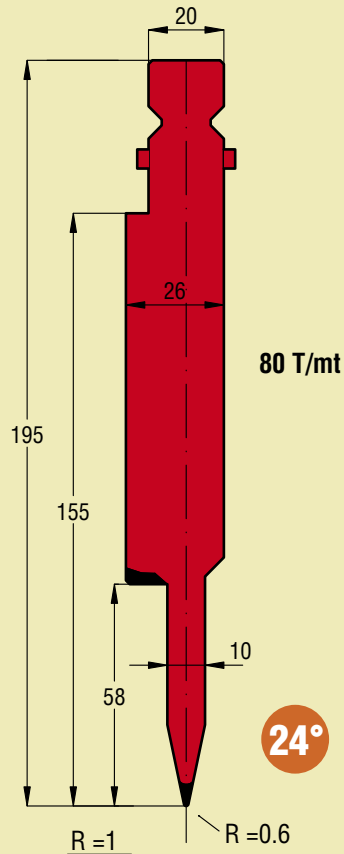
**L=500**

**L=550 S.**

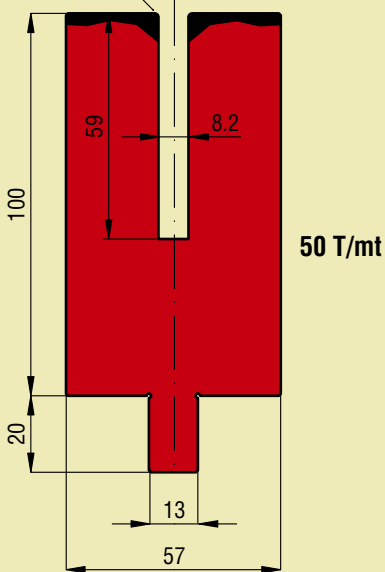
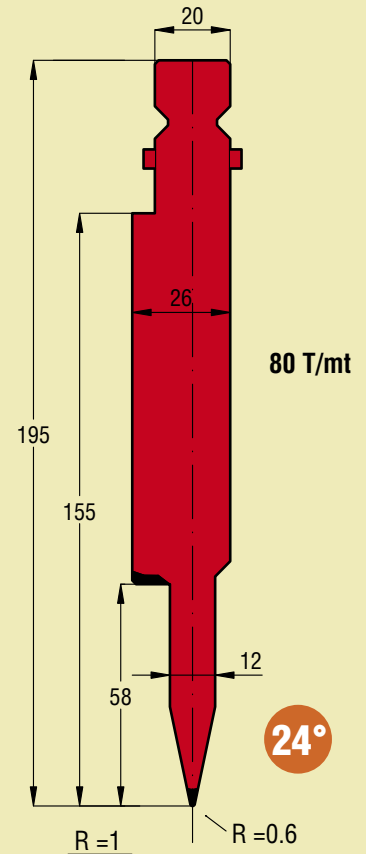
**15.902**



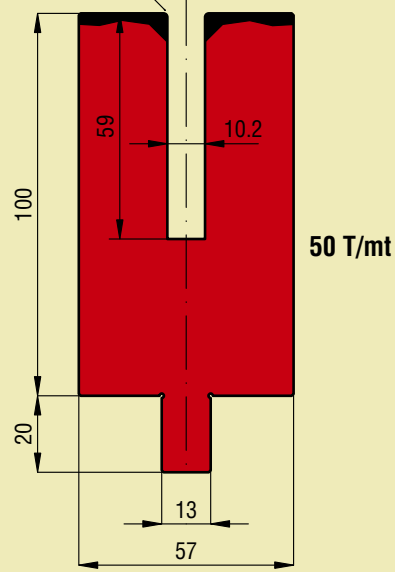
**15.904**



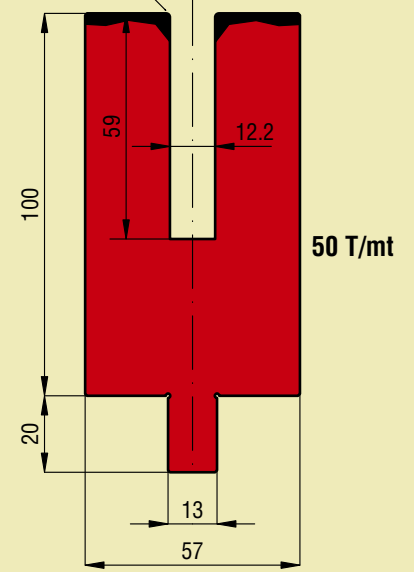
**15.905**



**25.992**

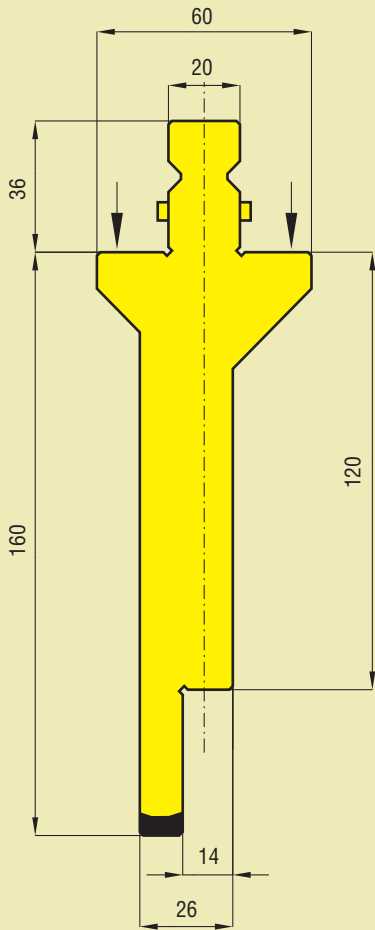


**25.994**

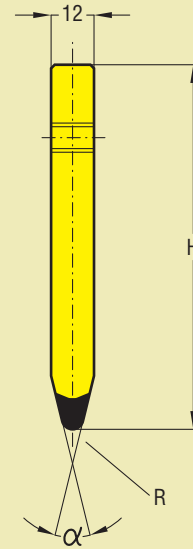
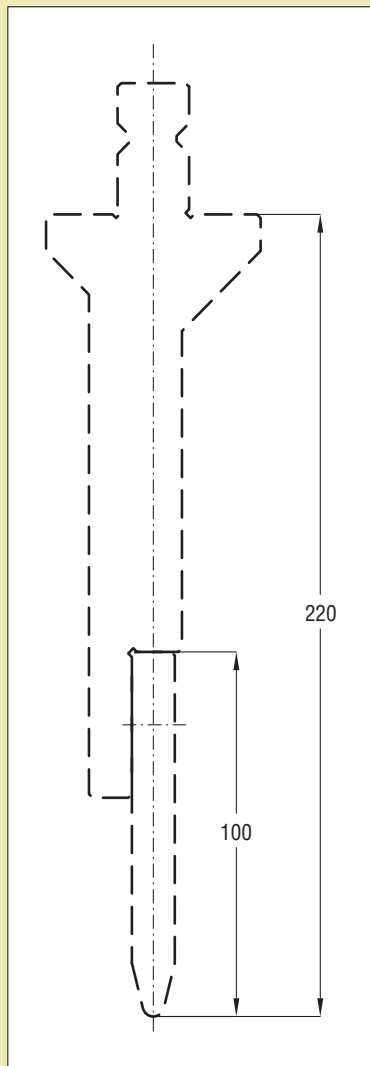


**25.995**





Cod.	H	Max T/mt
15.760	120	100



Cod.	$\alpha$	R	H	Max T/mt
15.761	28	0.50	100	100
15.763	28	1.00	100	100
15.765	28	2.00	100	100
15.766	28	3.00	100	100
15.767	28	4.00	100	100
15.768	28	5.00	100	100
15.769	28	6.00	100	100

28°

Cod.	$\alpha$	R	H	Max T/mt
15.774	84	1.00	100	100

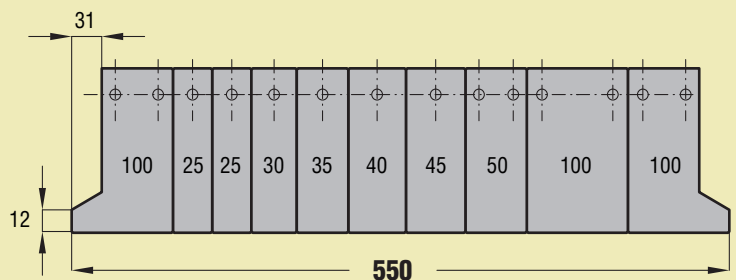
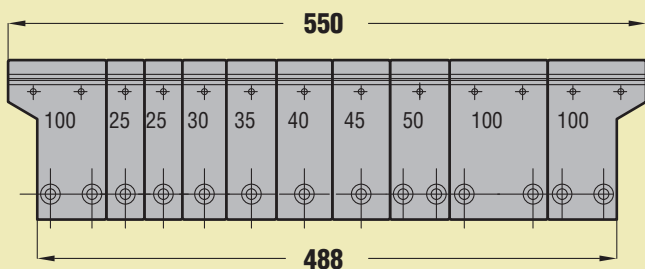
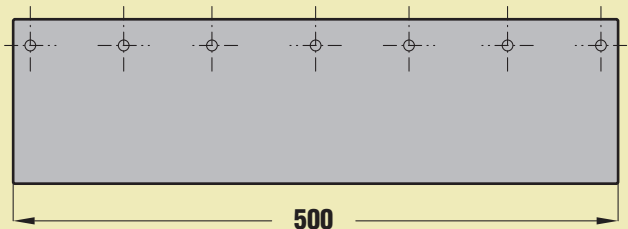
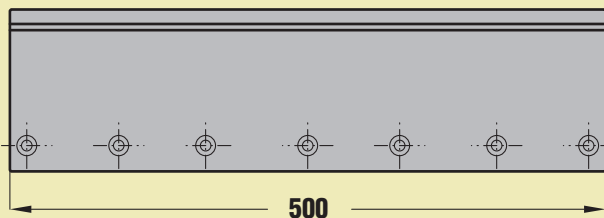
84°

Cod.	$\alpha$	R	H	Max T/mt
15.776	86	1.00	100	100

86°

Cod.	$\alpha$	R	H	Max T/mt
15.782	90	0.50	100	100
15.784	90	1.00	100	100
15.787	90	1.50	100	100
15.788	90	2.00	100	100

90°





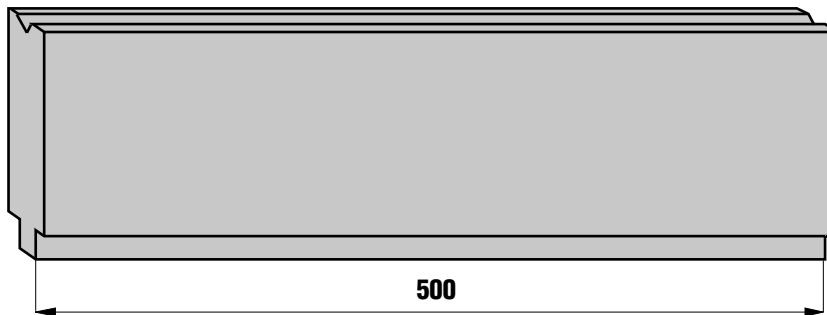
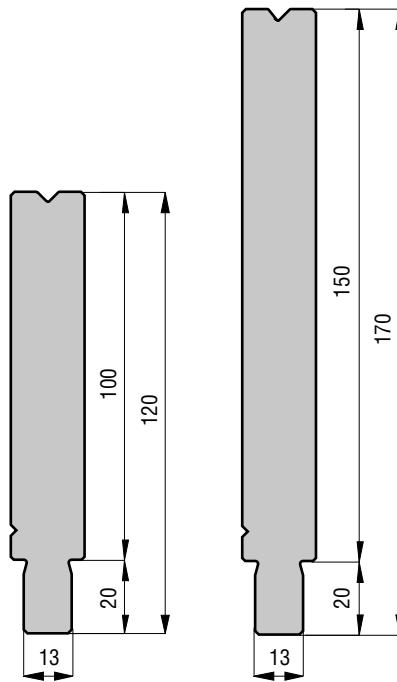
310

10.311

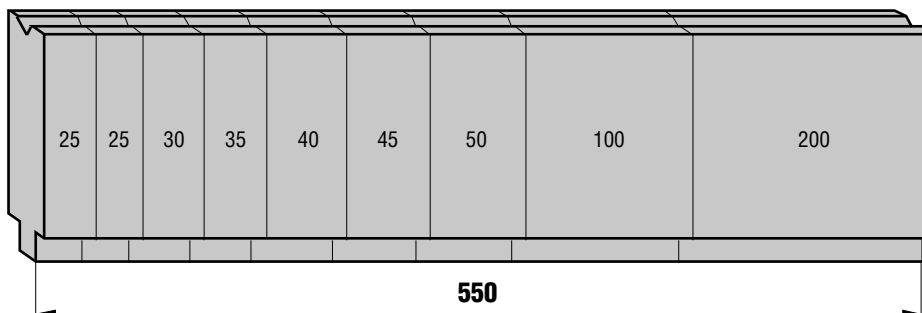
3

LE MATRICI SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 500 mm E FRAZIONATE (550)  
 THE DIES ARE AVAILABLE IN THE FOLLOWING LENGTHS: 500 mm AND SECTIONED (550)

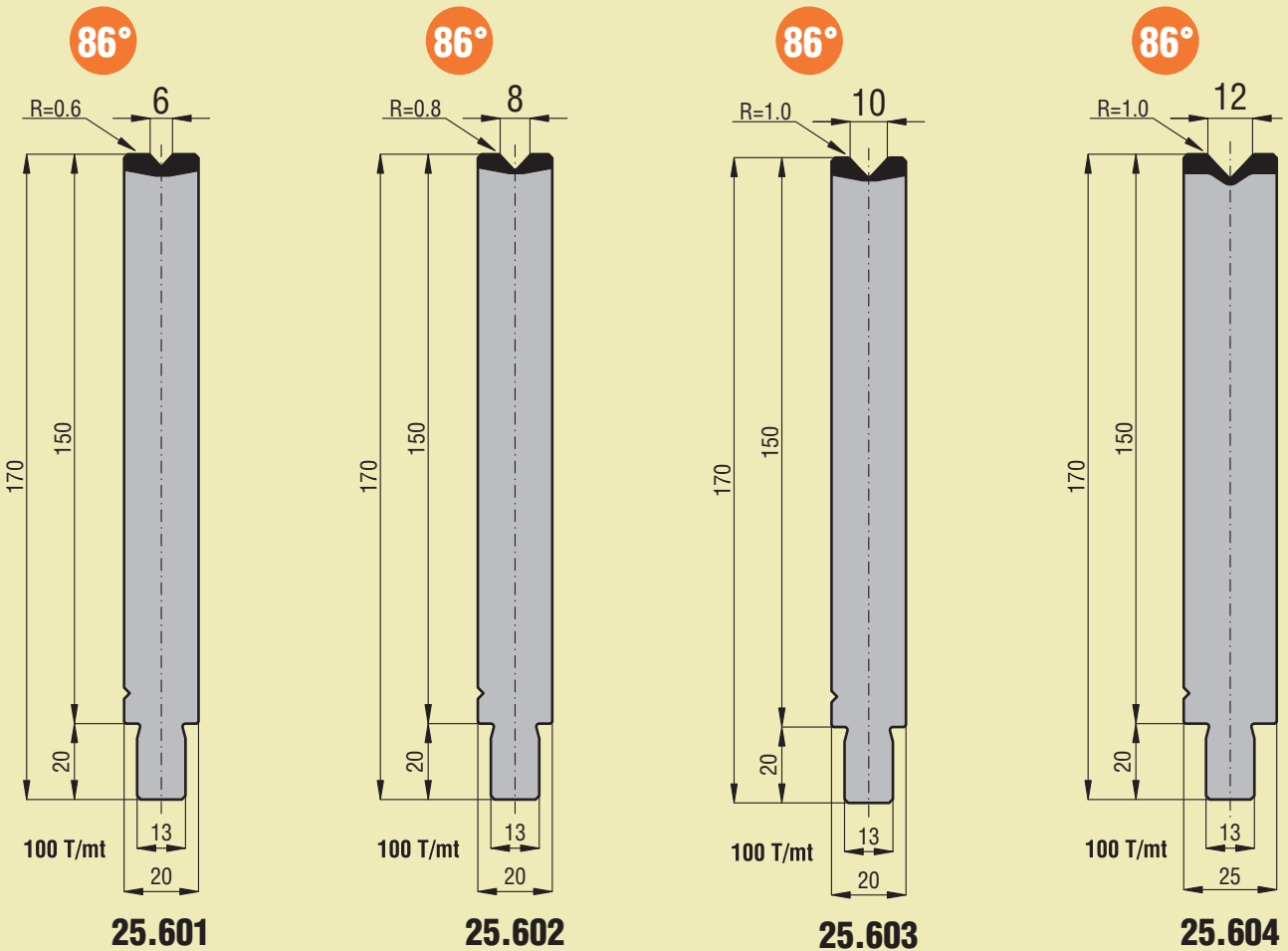
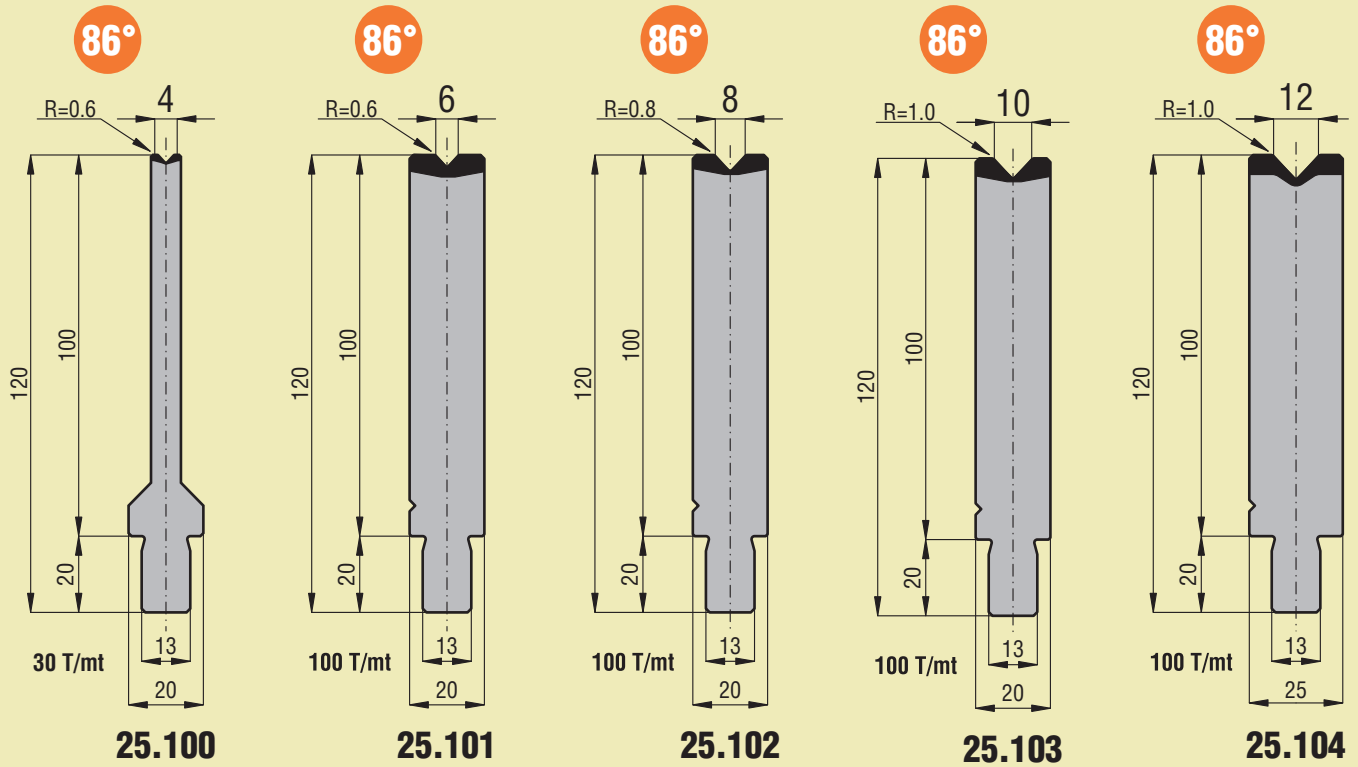
**ACCIAIO C45 (UNI 7845-78) TEMPRATO AD INDUZIONE 52/55 HRC  
 SULLE PARTI USURABILI  
 STEEL C45 (UNI 7845-78) INDUCTION TEMPERED 52/55 HRC  
 ON WEAR PARTS**



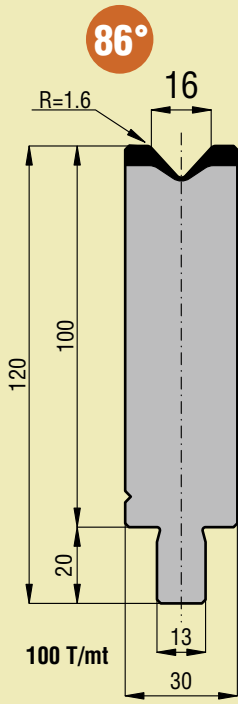
**FRAZIONATURA STANDARD  
 STANDARD SECTIONING**



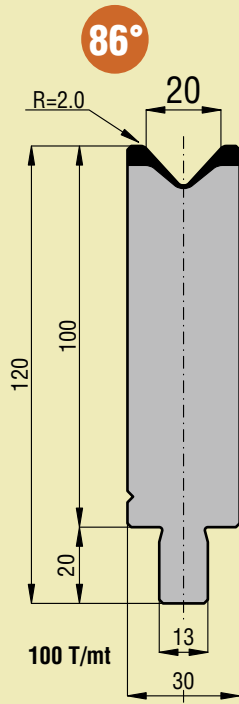
**WILA / TRUMPF**



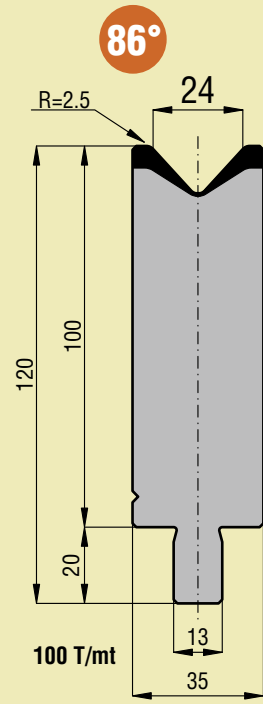
WILA / TRUMPF



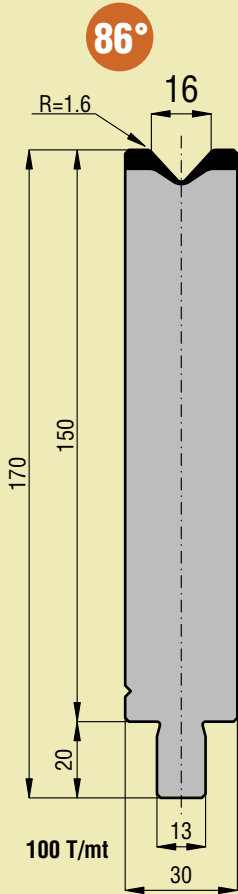
25.105



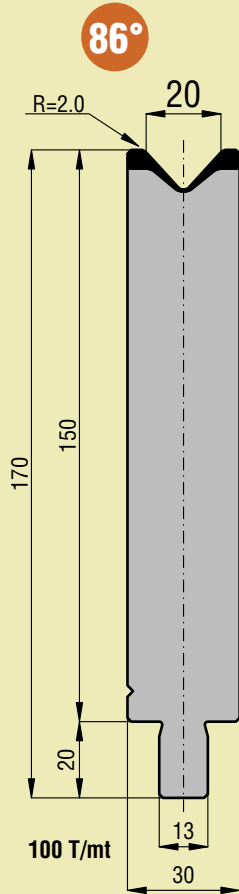
25.106



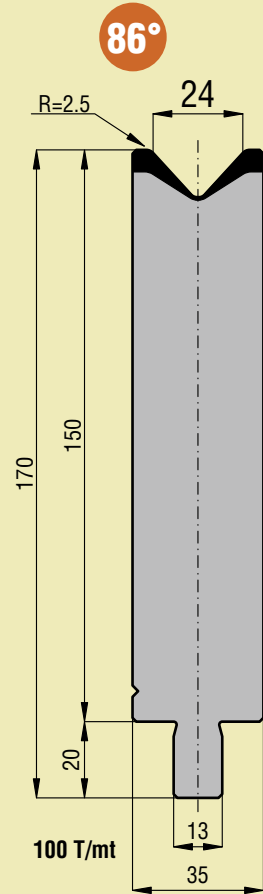
25.107



25.605

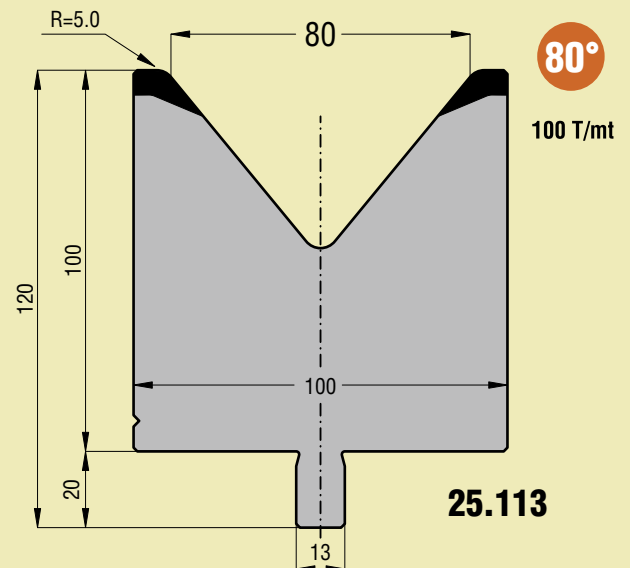
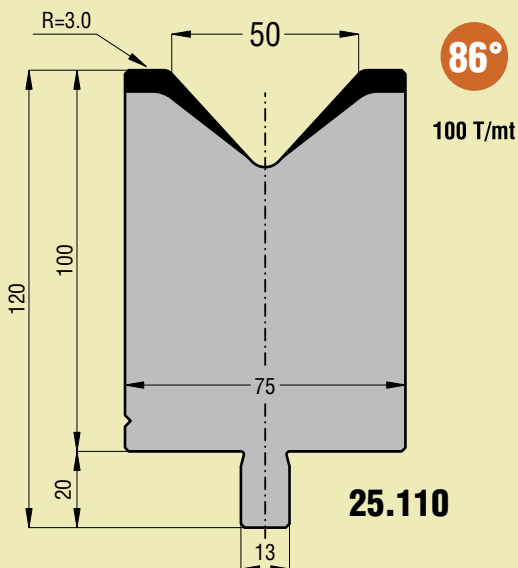
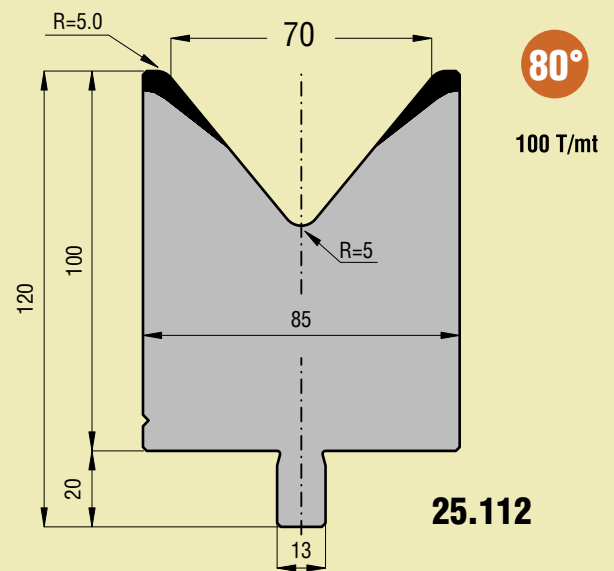
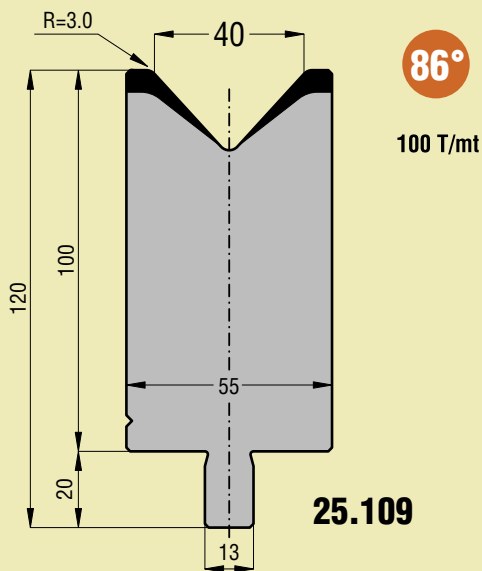
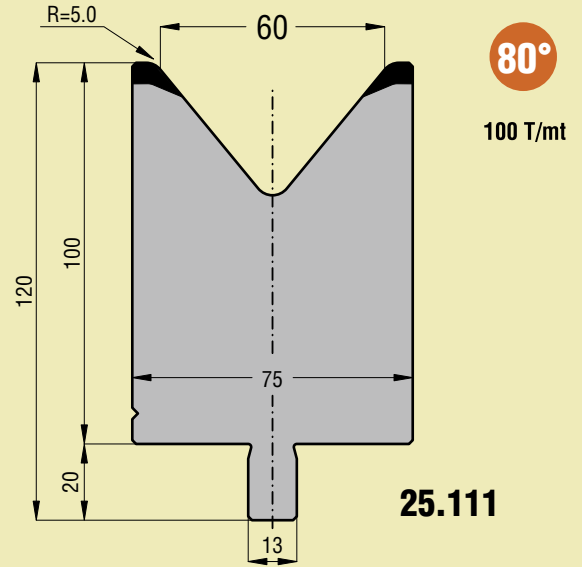
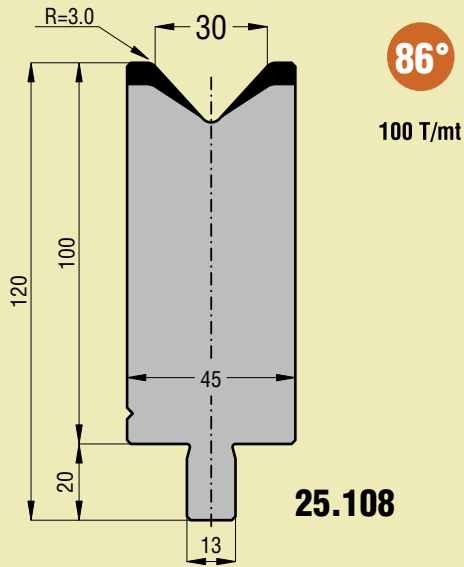


25.606

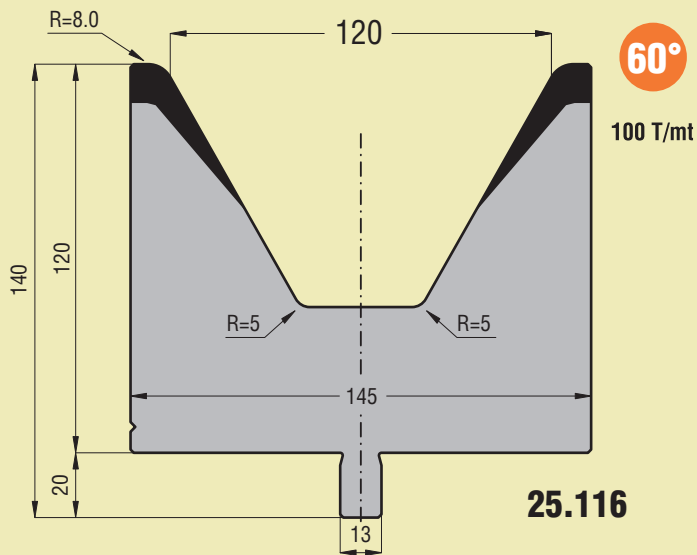
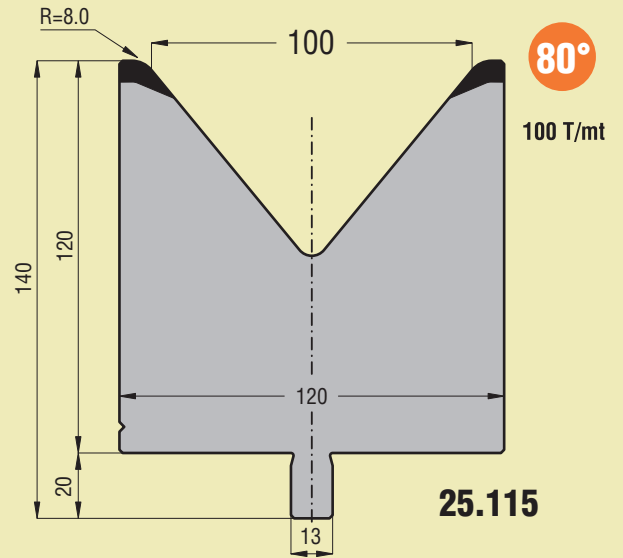
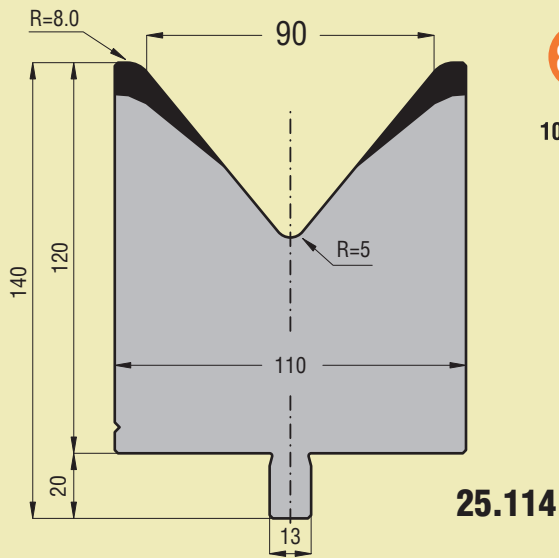


25.607

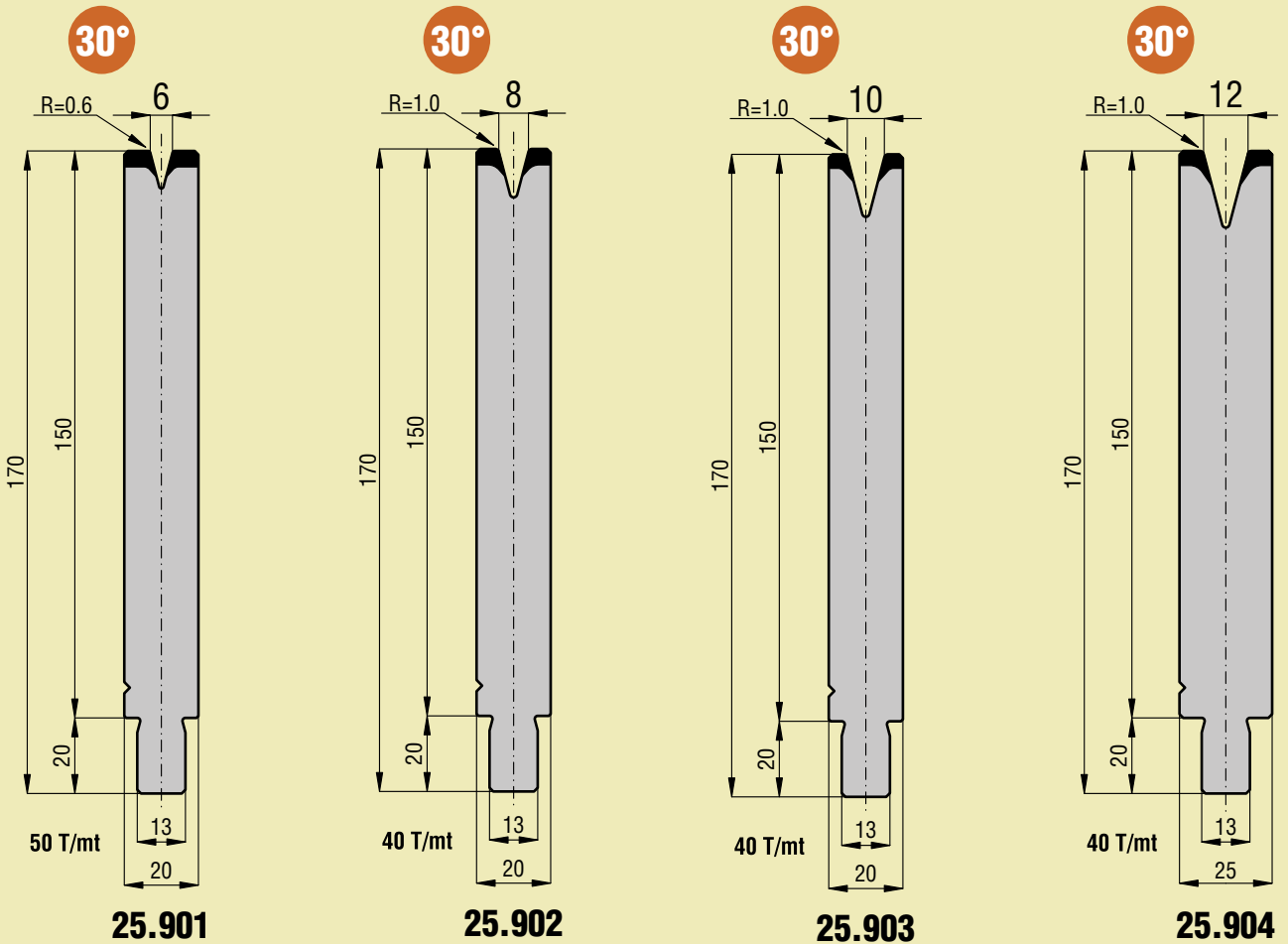
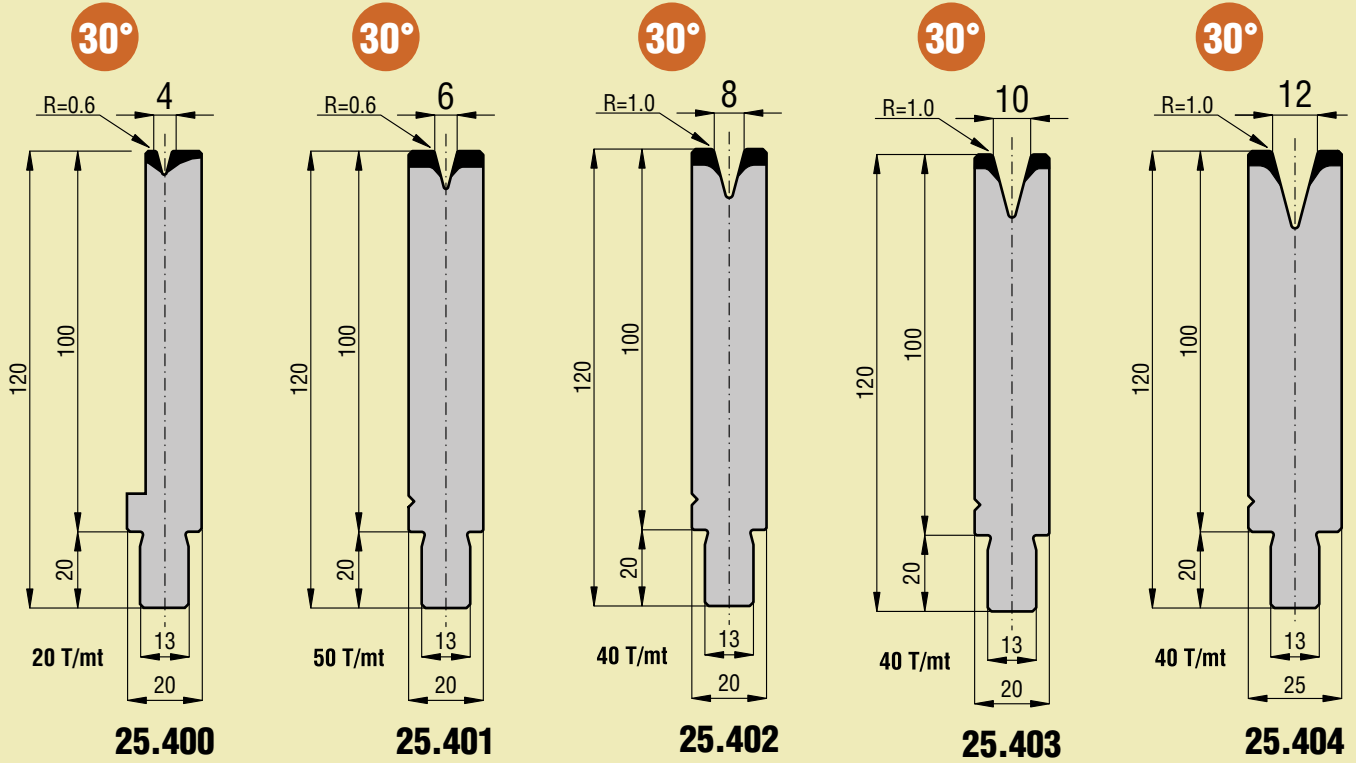
**WILA / TRUMPF**



**WILA / TRUMPF**

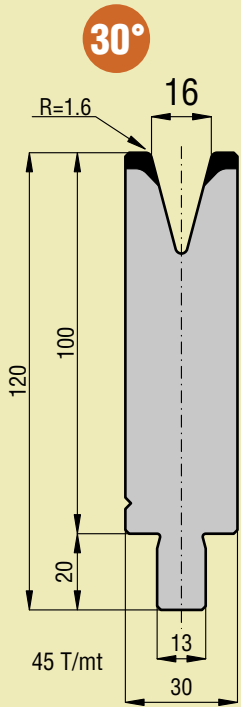


**WILA / TRUMPF**

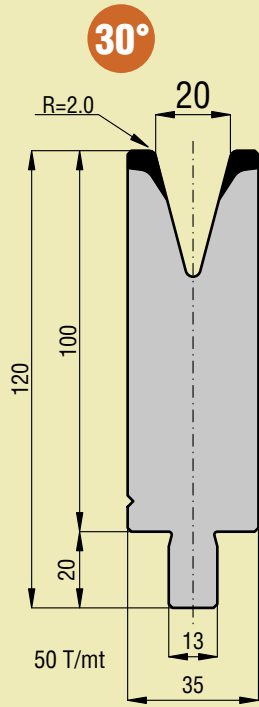




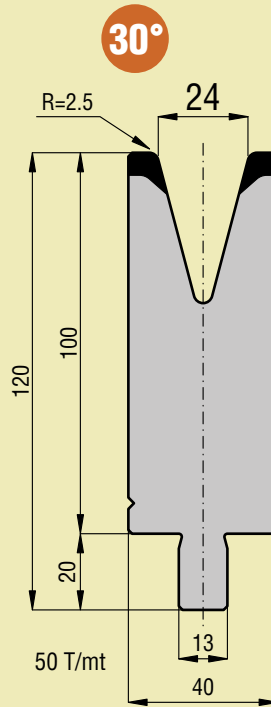
WILA / TRUMPF



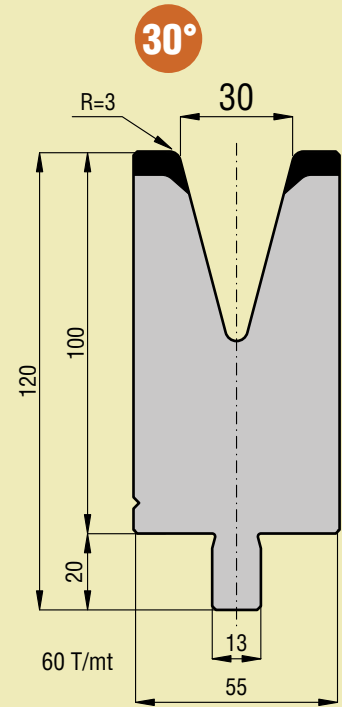
25.405



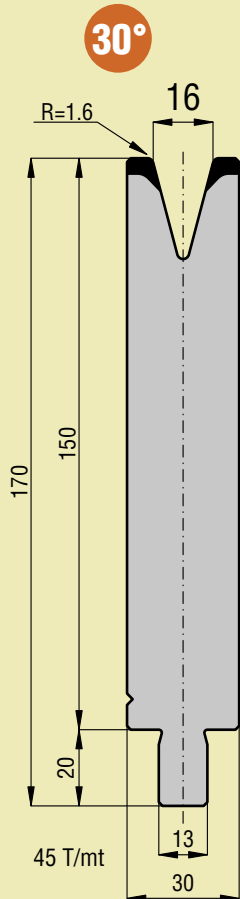
25.406



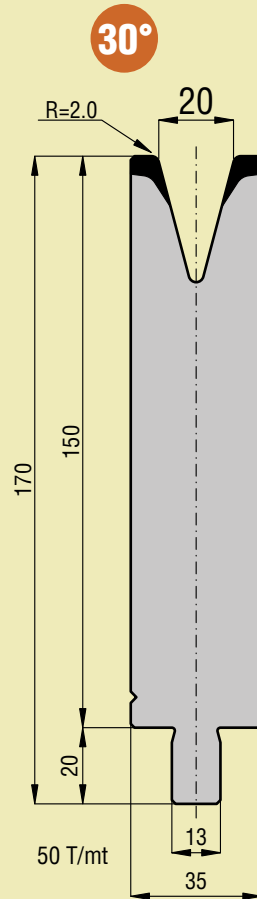
25.407



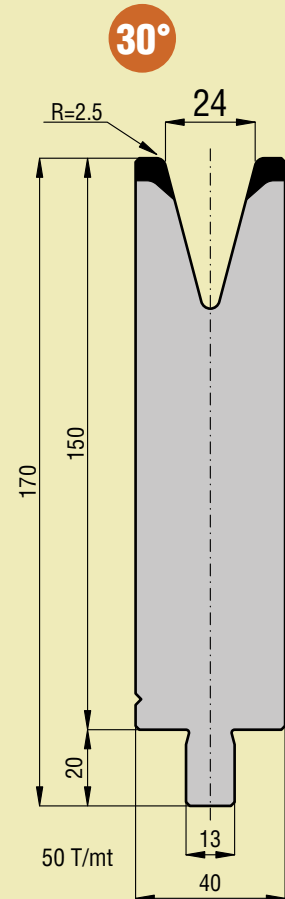
25.408



25.905




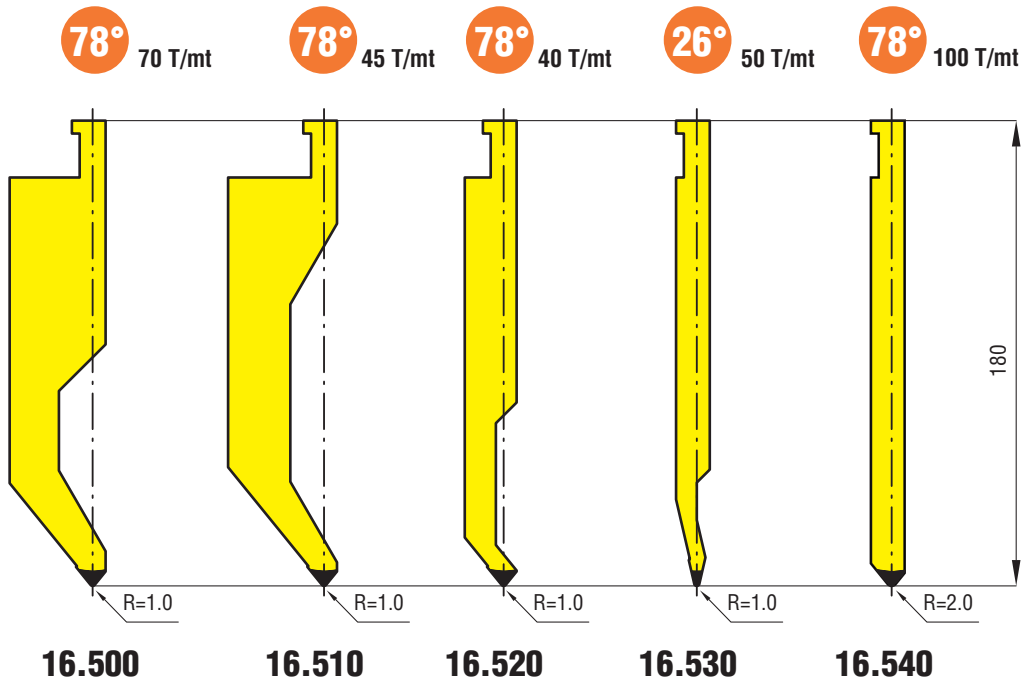
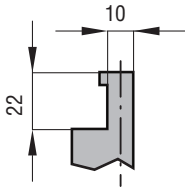
25.906



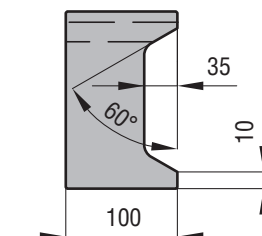
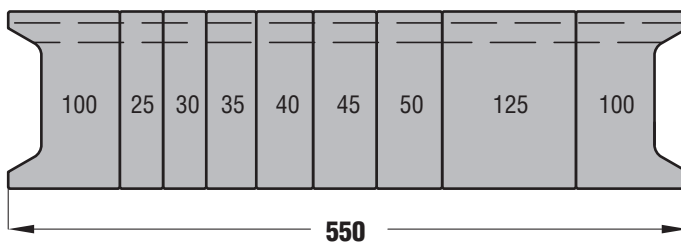
25.907

I PUNZONI SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 508 mm E FRAZIONATI (550)  
 THE PUNCHES ARE AVAILABLE IN THE FOLLOWING LENGTHS: 508 mm AND SECTIONED (550)

**ACCIAIO 42CrMo4 (UNI EN 10083-93) BONIFICATO R=95-105 kg/mm<sup>2</sup>**  
**TEMPRATO AD INDUZIONE 52/55 HRC SULLE PARTI USURABILI**  
**STEEL 42CrMo4 (UNI EN 10083-93) HARDENED R=95-105 kg/mm<sup>2</sup>**  
**INDUCTION TEMPERED 52/55 HRC ON WEAR PARTS**

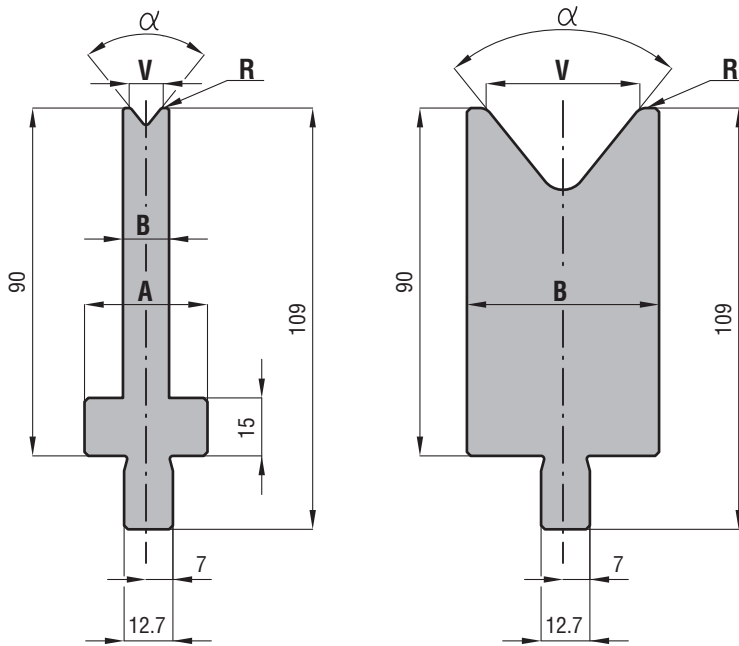



**FRAZIONATURA STANDARD**  
**STANDARD SECTIONING**

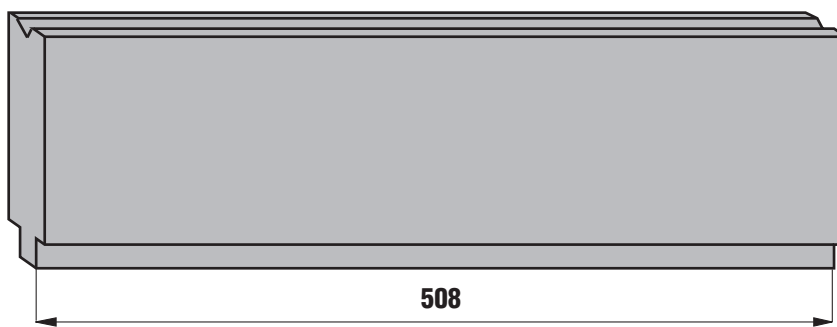


LE MATRICI SONO DISPONIBILI A MAGAZZINO NELLE LUNGHEZZE DI: 508 mm E FRAZIONATE (550)  
 THE DIES ARE AVAILABLE IN THE FOLLOWING LENGTHS: 508 mm AND SECTIONED (550)

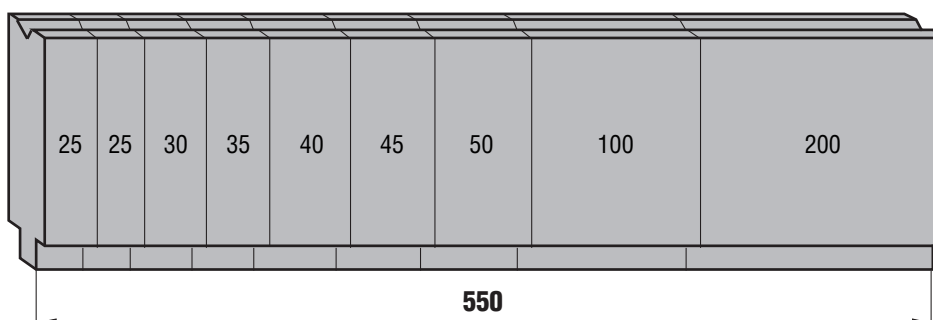
**ACCIAIO C45 (UNI 7845-78) TEMPRATO AD INDUZIONE 52/55 HRC  
 SULLE PARTI USURABILI  
 STEEL C45 (UNI 7845-78) INDUCTION TEMPERED 52/55 HRC  
 ON WEAR PARTS**



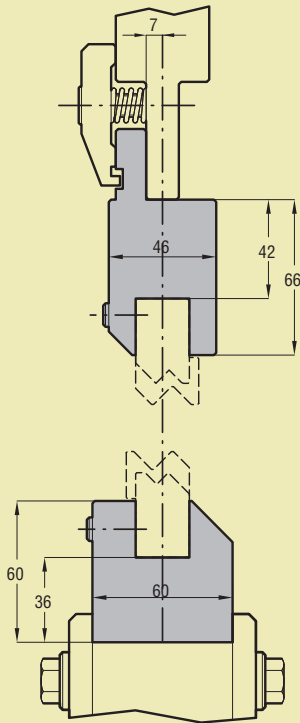
Cod.	V	$\alpha$	B	A	R	Max T/mt
26.306	6	30°	16	32	0.8	40
26.308	8	30°	18	32	1.0	35
26.310	10	30°	25	32	1.2	40
26.312	12	30°	25	32	1.5	40
26.316	16	30°	32	/	2.0	50
26.320	20	30°	40	/	2.5	60
26.324	24	30°	45	/	3.0	60
26.706	6	78°	12	32	0.8	40
26.708	8	78°	12	32	1.0	40
26.710	10	78°	14	32	1.2	50
26.712	12	78°	18	32	1.5	60
26.716	16	78°	25	32	2.0	80
26.720	20	78°	32	/	2.5	80
26.724	24	78°	32	/	3.0	100
26.730	30	78°	40	/	3.0	100
26.740	40	78°	50	/	3.5	100
26.750	50	78°	70	/	4.0	100
26.760	60	78°	70	/	5.0	100
26.780	80	78°	95	/	6.0	100
26.794	100	78°	120	/	8.0	100
26.797	120	78°	140	/	10.0	100



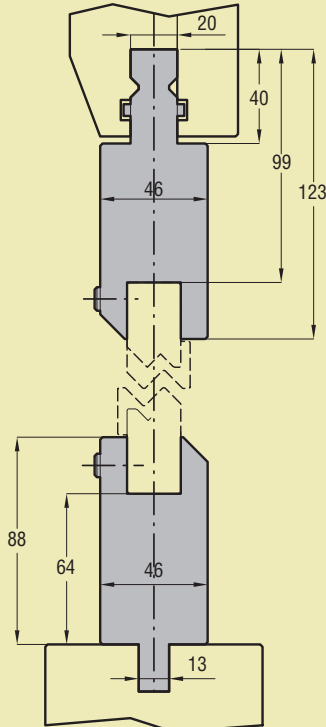
**FRAZIONATURA STANDARD  
 STANDARD SECTIONING**



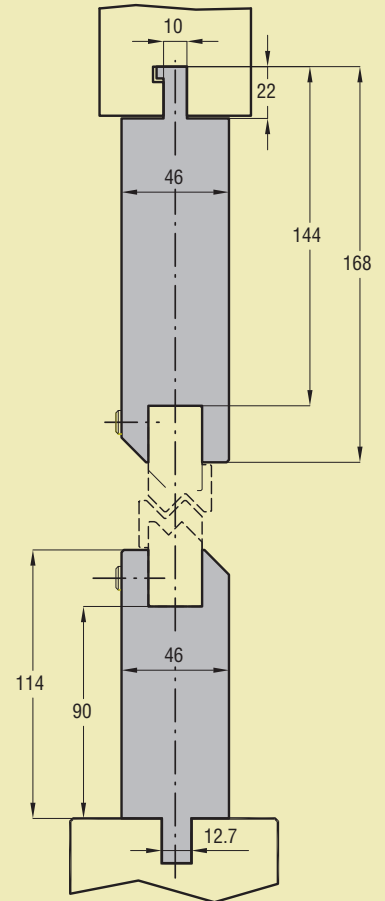
L = 835 - L = 415  
100 T/mt



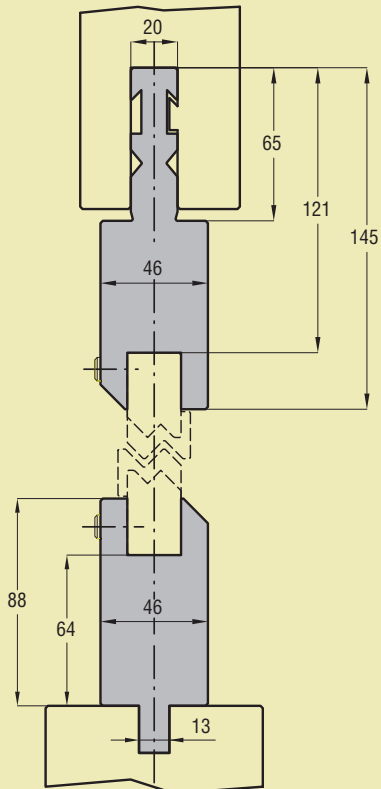
**40.419**  
**AMADA/PROMECAM**



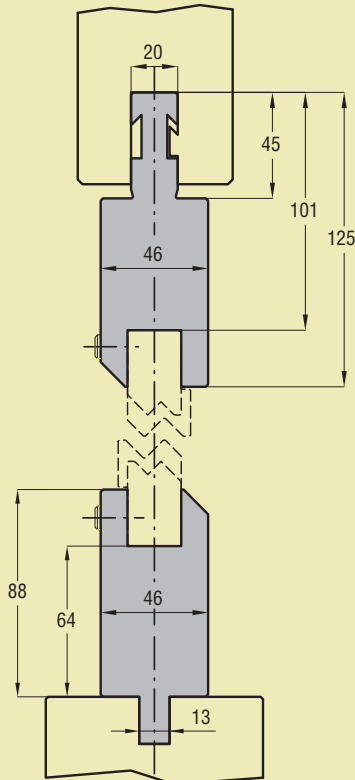
**15.050**  
**WILA/TRUMPF**



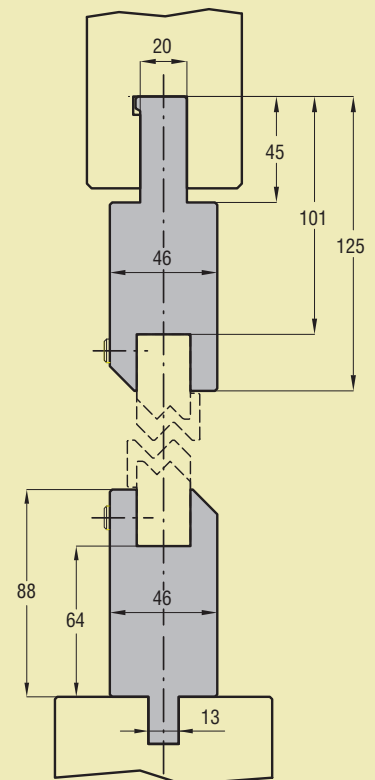
**16.050**  
**LVD**



**14.080**  
**BEYELER-RFA**



**14.085**  
**BEYELER-R**

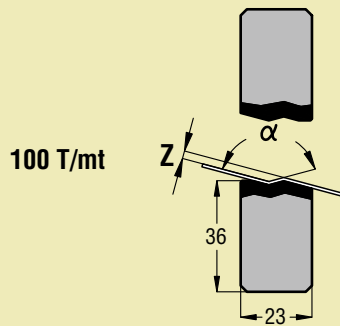


**14.090**  
**BEYELER-S**

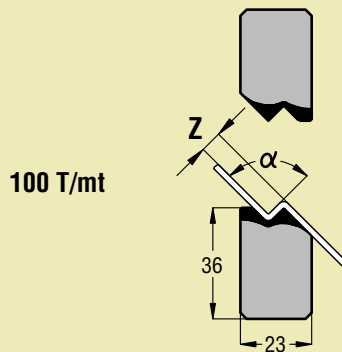
# CONTENITORI ED INSERTI A Z JOGGLE (Z) TOOL HOLDERS AND INSERTS



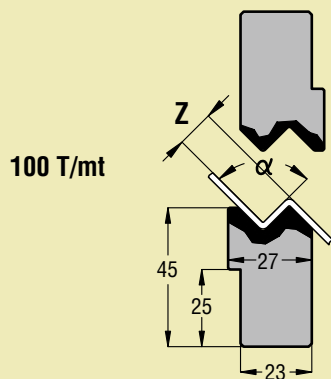
L = 835 - L = 415



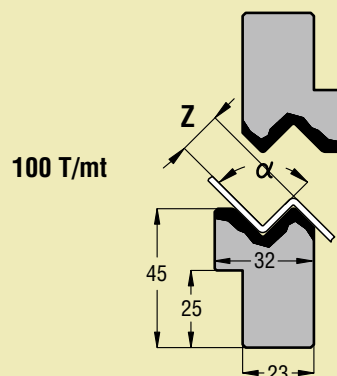
Cod.	Z	$\alpha$
40.510	1.0	160
40.515	1.5	
40.520	2.0	150
40.525	2.5	140



40.511	1.0	90
40.516	1.5	
40.521	2.0	
40.526	2.5	
40.530	3.0	
40.535	3.5	
40.540	4.0	
40.545	4.5	
40.550	5.0	
40.555	5.5	
40.560	6.0	
40.565	6.5	
40.570	7.0	
40.575	7.5	
40.580	8.0	

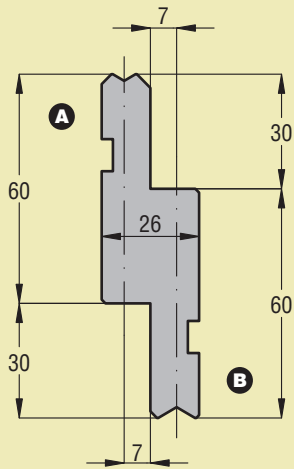


40.590	9.0	90
40.610	10.0	
40.611	11.0	
40.612	12.0	



40.613	13.0	90
40.614	14.0	
40.615	15.0	

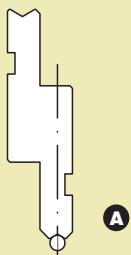
## SUPPORTO PER INSERTI TONDI HOLDER FOR RADIUS INSERTS



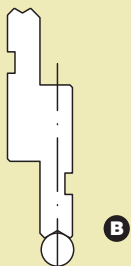
**10.180**

## INSERTI APPLICABILI INSERTS

- 10.181
- 10.182
- 10.183
- 10.184
- 10.185
- 10.186
- 10.187
- 10.188

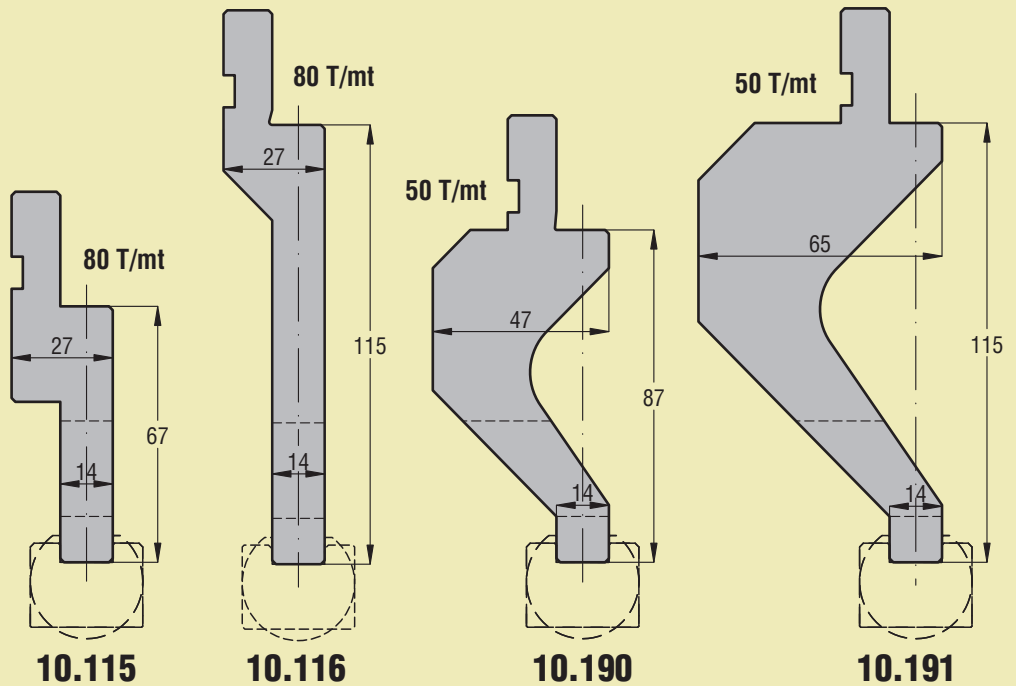


R 3.0 Min  
R 4.5 Max



R 5.0 Min  
R 6.5 Max

## SUPPORTI PER INSERTI RAGGIATI E PIANI HOLDERS FOR RADIUS AND PLAIN INSERTS

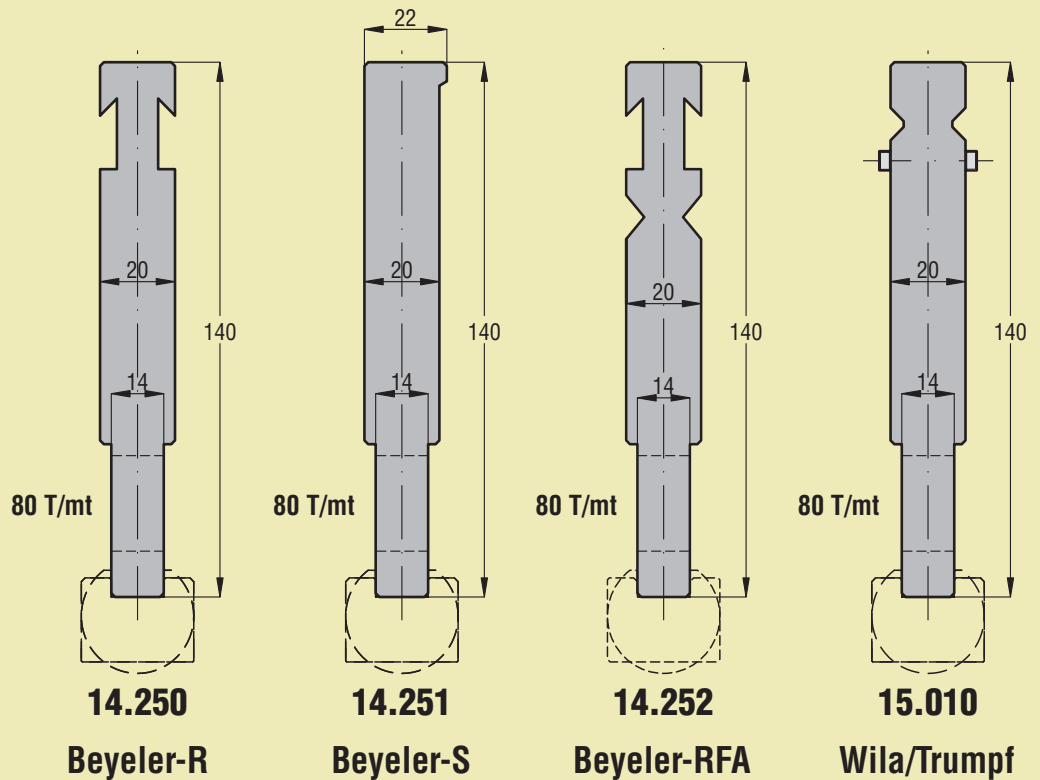


**10.115**

**10.116**

**10.190**

**10.191**



**14.250**

**14.251**

**14.252**

**15.010**

**Beyeler-R**

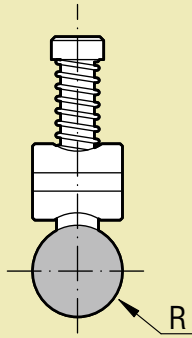
**Beyeler-S**

**Beyeler-RFA**

**Wila/Trumpf**



# INSERTI RAGGIATI - RADIUS INSERTS

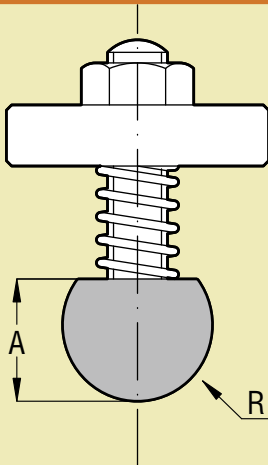


Cod.	R
10.181	3.0
10.182	3.5
10.183	4.0
10.184	4.5
10.185	5.0
10.186	5.5
10.187	6.0
10.188	6.5

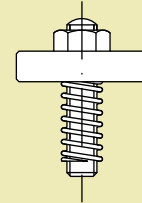


**Pezzo di ricambio  
Spare part**

**40.003**

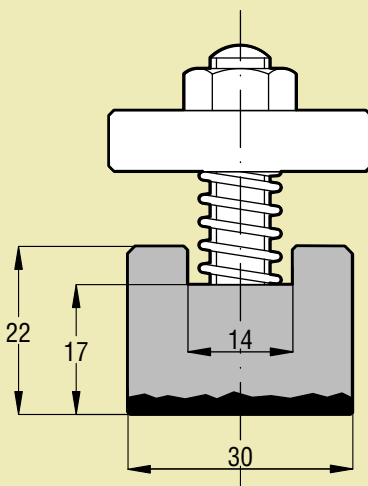
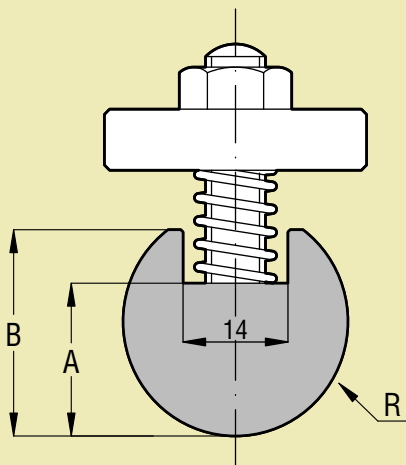


Cod.	R	A	B
10.300	7.0	11.5	
10.301	7.5	11.5	
10.302	8.0	13.0	
10.303	9.0	16.0	
10.304	10.0	16.0	
10.305	11.0	16.0	
10.306	11.5	19.0	
10.307	12.0	20.0	
10.308	12.5	16.0	21.0
10.309	13.0	17.0	23.0
10.310	14.0	19.0	25.0
10.311	15.0	20.0	27.0
10.312	16.0	21.0	28.0
10.313	17.0	21.5	31.5
10.314	17.5	22.0	32.0
10.315	19.0	25.0	32.0
10.316	20.0	24.0	34.0
10.317	22.5	25.0	33.0
10.318	25.0	29.0	39.0
10.319	27.5	34.0	44.0
10.320	30.0	34.0	44.0
10.321	35.0	45.0	55.0
10.322	40.0	45.0	55.0
10.323	45.0	50.0	60.0
10.324	50.0	54.0	64.0



**Pezzo di ricambio  
Spare part**

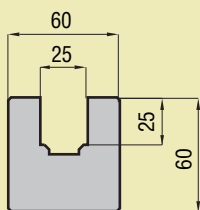
**40.002**



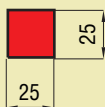
**10.325**



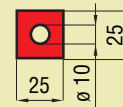
## CONTENITORI E LISTELLI DI POLIURETANO 92 Shore HOLDERS AND POLYURETHANE INSERTS 92 Shore



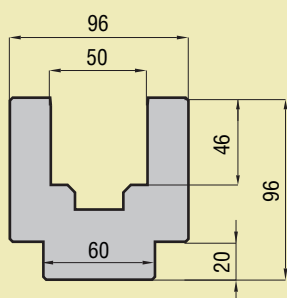
**20.271**



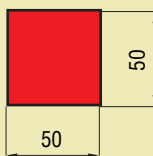
**20.292**



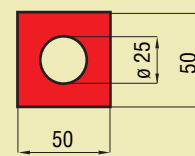
**21.292**



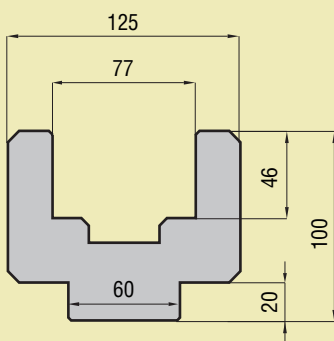
**20.272**



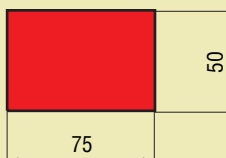
**20.291**



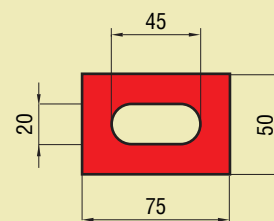
**21.291**



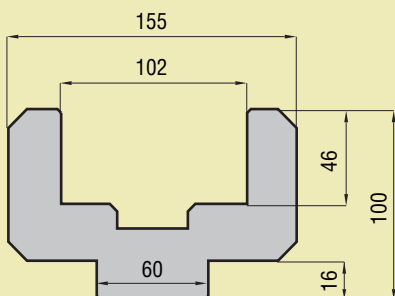
**20.273**



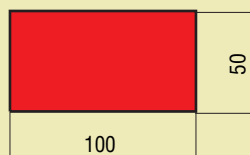
**20.290**



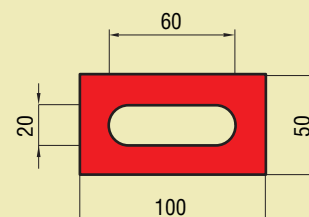
**21.290**



**20.274**



**20.289**



**21.289**

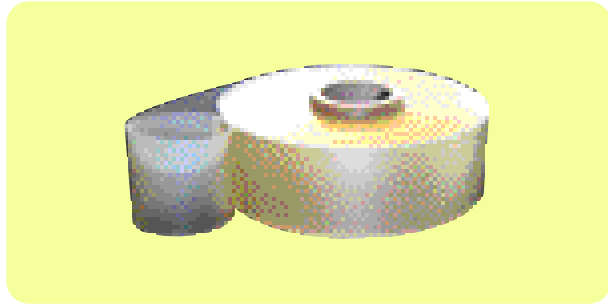


**PELLICOLA DI POLIURETANO  
ANTIGRAFFIO**

Spess. 0,8 mm - Largh. 95 mm - Lungh. 33 mt.

**FILM OF POLYURETHANE  
ANTISCRATCH**

*Tick 0,8 mm - Width 95 mm - Lenght 33 mt.*



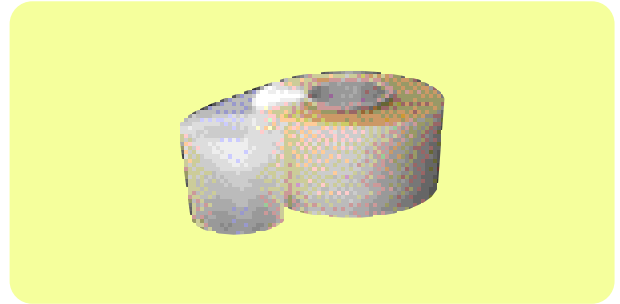
**40.810**

**PELLICOLA DI POLIURETANO  
ANTIGRAFFIO**

Spess. 0,5 mm - Largh. 95 mm - Lungh. 33 mt.

**FILM OF POLYURETHANE  
ANTISCRATCH**

*Tick 0,5 mm - Width 95 mm - Lenght 33 mt.*



**40.820**

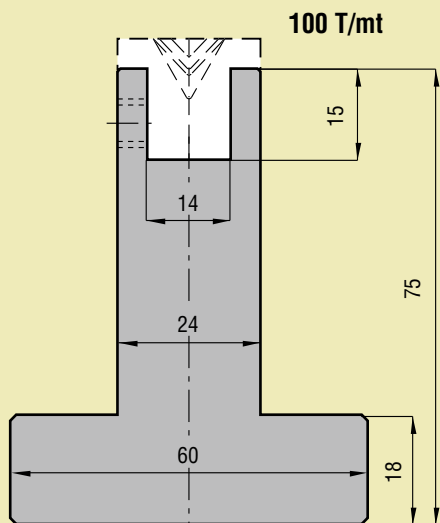
**COPPIA DI TENDIPELLICOLA (AVVOLGITORE E SVOLGITORE)  
REGISTRABILI VERTICALMENTE E TRASVERSALMENTE.**

***ADJUSTABLE COUPLE OF TIGHTENERS.  
VERTICALLY AND TRANSVERSALLY ADJUSTMENT.***



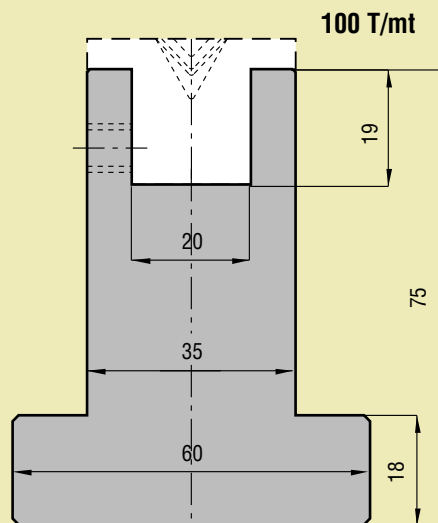
**40.800**

## CONTENITORI PER INSERTI IN NYLON INTERCambiABILI HOLDERS FOR INTERCHANGEABLE PLASTIC INSERTS



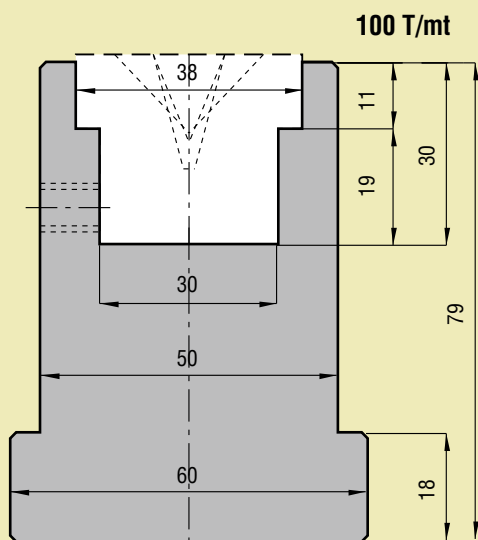
**22.001**

**PROMECAM - AMADA**



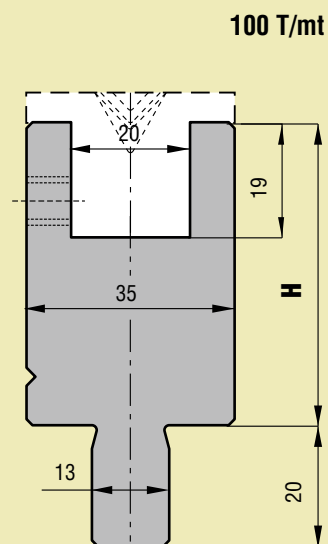
**22.002**

**PROMECAM - AMADA**



**22.003**

**PROMECAM - AMADA**

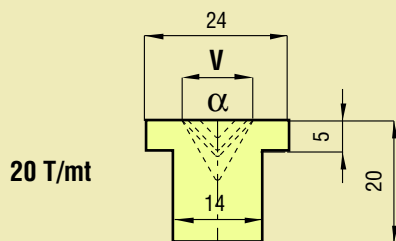


**22.004 H=50**

**22.005 H=95**

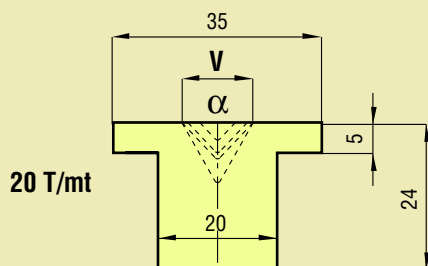
**BEYELER  
TRUMPF**

## INSERTI IN NYLON INTERCAMBIABILI INTERCHANGEABLE PLASTIC INSERTS



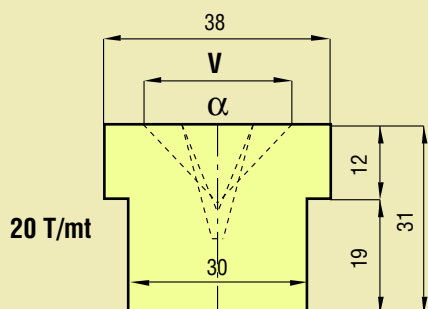
Cod.	V	$\alpha$
31.306	6	30
31.308	8	
31.406	6	45
31.408	8	
31.410	10	

Cod.	V	$\alpha$
31.606	6	60
31.608	8	
31.610	10	
31.806	6	88
31.808	8	
31.810	10	



Cod.	V	$\alpha$
32.306	6	30
32.308	8	
32.310	10	
32.406	6	45
32.408	8	
32.410	10	
32.412	12	

Cod.	V	$\alpha$
32.606	6	60
32.608	8	
32.610	10	
32.612	12	
32.806	6	88
32.808	8	
32.810	10	
32.812	12	
32.816	16	



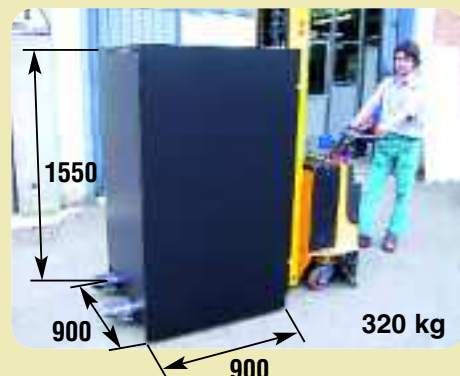
Cod.	V	$\alpha$
33.306	6	30
33.308	8	
33.310	10	
33.312	12	
33.406	6	45
33.408	8	
33.410	10	
33.412	12	
33.416	16	
33.420	20	

Cod.	V	$\alpha$
33.606	6	60
33.608	8	
33.610	10	
33.612	12	
33.616	16	
33.806	6	88
33.808	8	
33.810	10	
33.812	12	
33.816	16	
33.820	20	
33.825	25	

**ARMADIO PORTAUTENSILI  
TOOLING CUPBOARD**

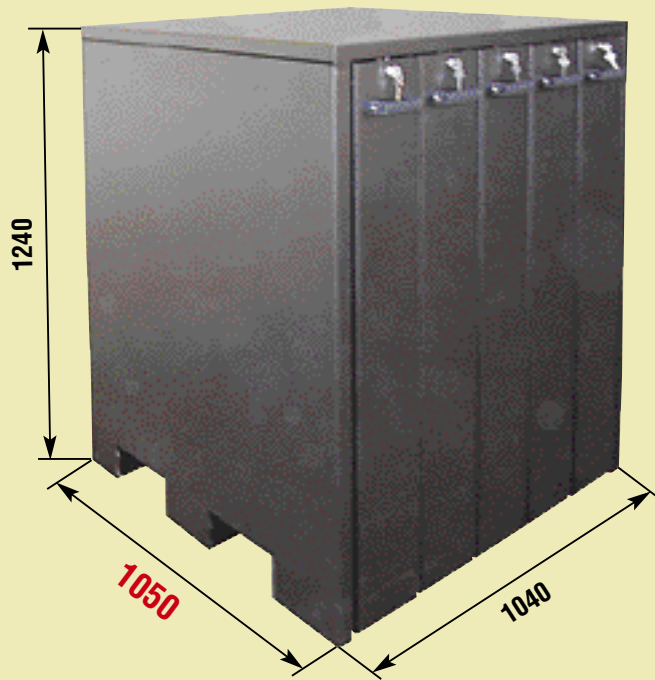


**40.650**



**ARMADIO PORTAUTENSILI A CASSETTI  
TOOLING CUPBOARD**

**L=835**



40.651

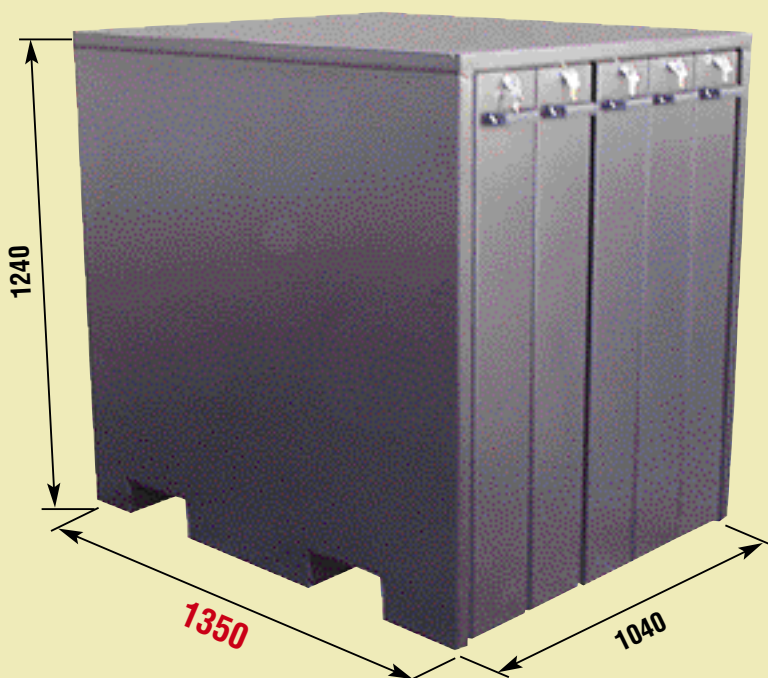


350 Kg



**ARMADIO PORTAUTENSILI A CASSETTI  
TOOLING CUPBOARD**

**L=1100**

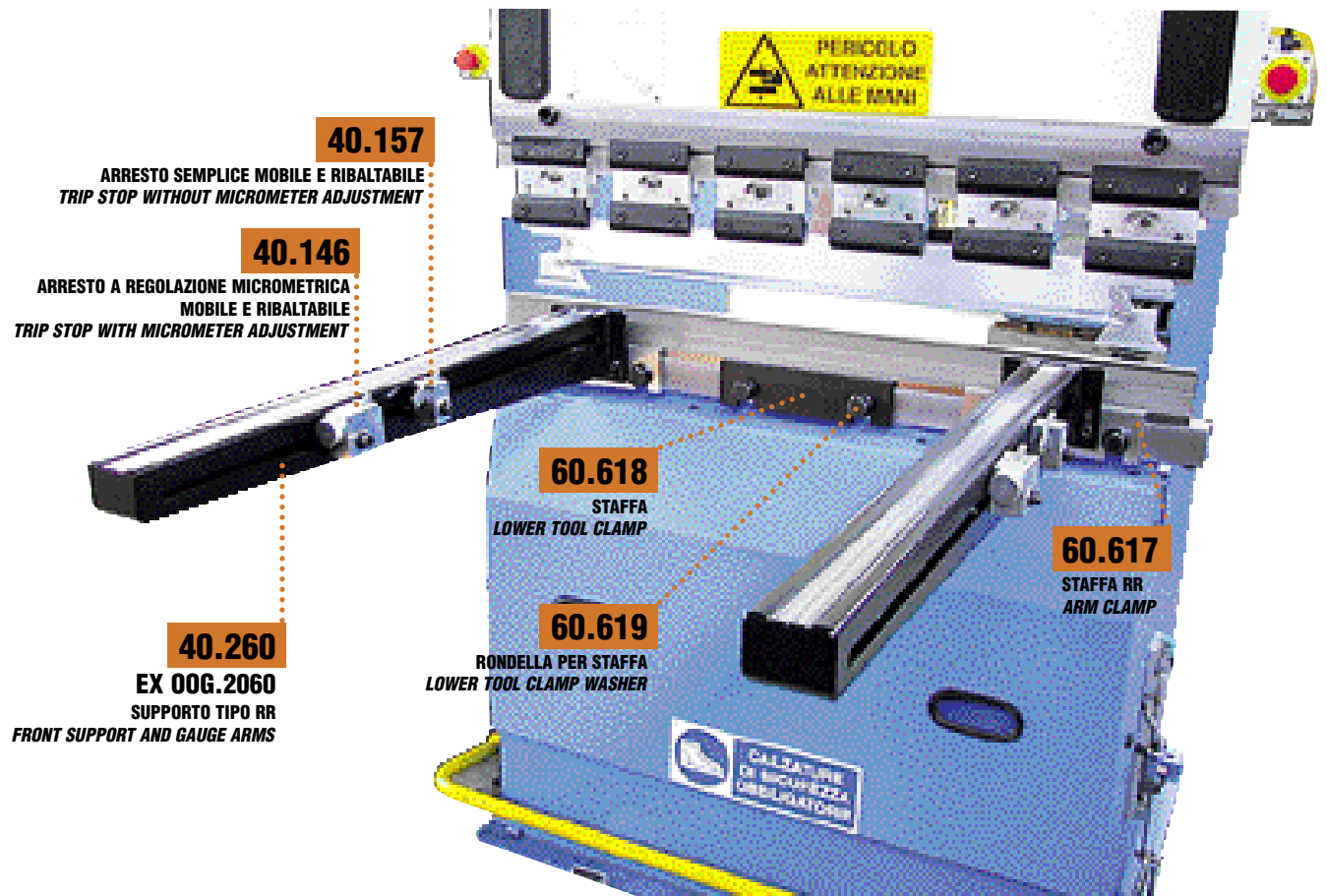


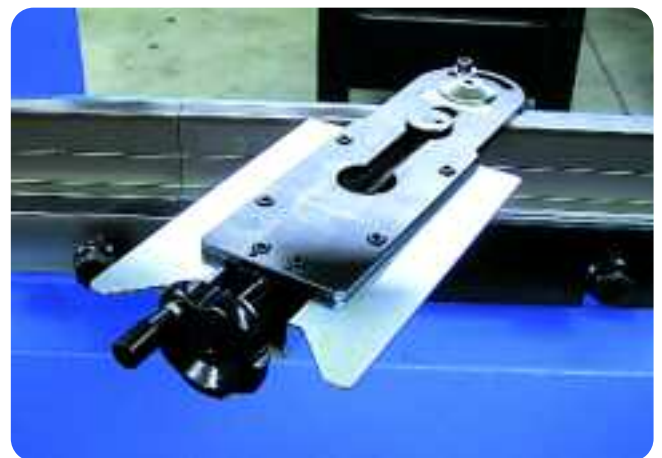
40.652



450 Kg



**RIFERIMENTI ANTERIORI E ARRESTI MICROMETRICI E FISSI  
FRONT REFERENCE**

**SQUADRE DI RIFERIMENTO  
REFERENCE SQUARES**

**40.660**

**40.700**  
**ORIENTABILE**  
**ADJUSTABLE**

## BLOCCAGGI AUTOMATICI PER CAMBIO UTENSILI PNEUMATIC CLAMPING FOR FAST CHANGE TOOLS



**IERI  
YESTERDAY**

**OGGI  
TODAY**



- Serie **"RAPID"** per utensili superiori con scanalatura di sicurezza standard **AMADA 8.4x3 (70.946)**
- Serie **"CLARK"** per utensili superiori con scanalatura di sicurezza doppia (**70.1050**)
- Tavole e staffe inferiori pneumatiche
- A richiesta bloccaggi pneumatici ed idraulici per tutti i tipi di presse piegatrici
- **"RAPID"** series for upper tools only with **AMADA** safety groove 8.4x3 (**70.946**)
- **"CLARK"** series for upper tools with double safety groove (**70.1050**)
- Pneumatic lower clamps and die holder tables
- On request we manufacture pneumatic and hydraulic clamping for all kinds of press-brakes



### CENTRALINA PNEUMATICA PER LINEE SUPERIORI ED INFERIORI DI BLOCCAGGI PNEUMATICI

**PNEUMATIC EQUIPMENT  
FOR UPPER AND LOWER PNEUMATIC LINES**

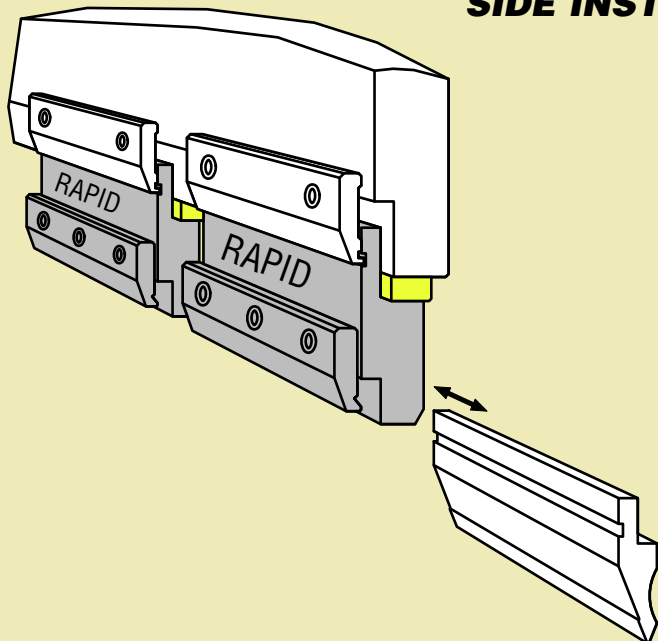
**50.650**

**CENTRALINA PNEUMATICA AD 1 COMANDO  
PNEUMATIC EQUIPMENT AT 1 CONTROL**

**50.651**

**CENTRALINA PNEUMATICA A 2 COMANDI  
PNEUMATIC EQUIPMENT AT 2 CONTROLS**

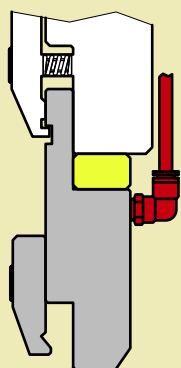
## MONTAGGIO LATERALE SIDE INSTALLATION



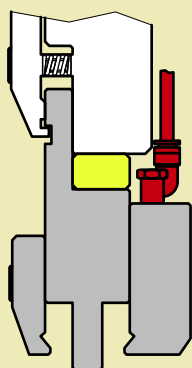
## RAPID

Intermediario pneumatico centinabile.  
 Bloccaggio pneumatico/sbloccaggio meccanico.  
 Montaggio e smontaggio LATERALE degli utensili.  
 L'utensile viene portato automaticamente in battuta  
 contro il corpo dell'intermediario.  
 Tubi di collegamento ad innesto rapido commerciali.

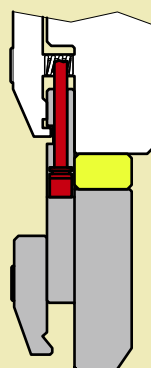
*Adjustable pneumatic adaptor.  
 Pneumatic clamping/Mechanical unclamping.  
 SIDE installation/disinstallation of tools.  
 The tools are automatically positioned and centered.  
 Fast coupling connections and its joining pipes  
 available on the market.*



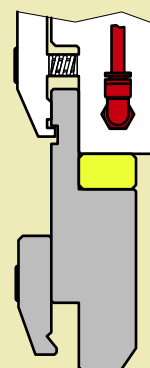
**RAPID**



**RAPID  
REVERS.**



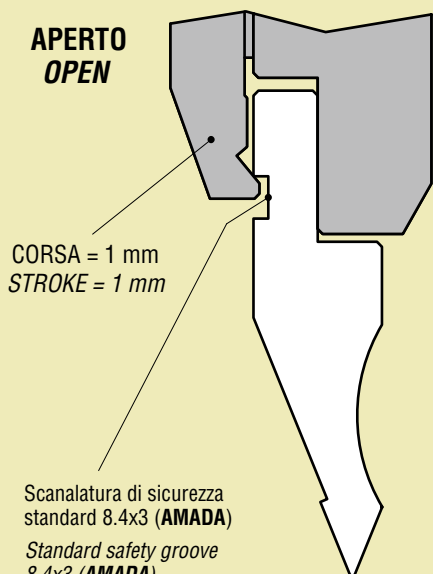
**RAPID  
"FP"**



**RAPID  
TOP-FIX**

BREVETTATO  
PATENTED

**APERTO  
OPEN**

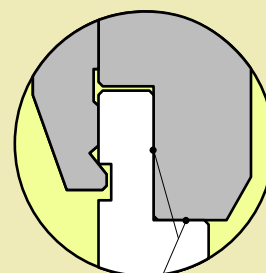


CORSA = 1 mm  
STROKE = 1 mm

Scanalatura di sicurezza  
standard 8.4x3 (AMADA)  
Standard safety groove  
8.4x3 (AMADA)

**CHIUSO  
CLOSED**

FORZA DI BLOCCAGGIO A 10 BAR = 700 kg  
CLAMPING POWER AT 10 BARS = 700 Kg



Punzone automaticamente  
posizionato e centrato.  
Tool automatically positioned  
and centered.

**CENTRALINA PNEUMATICA  
PNEUMATIC EQUIPMENT**

**50.650**  
A 1 COMANDO  
ONE CONTROL

**50.651**  
A 2 COMANDI  
TWO CONTROL



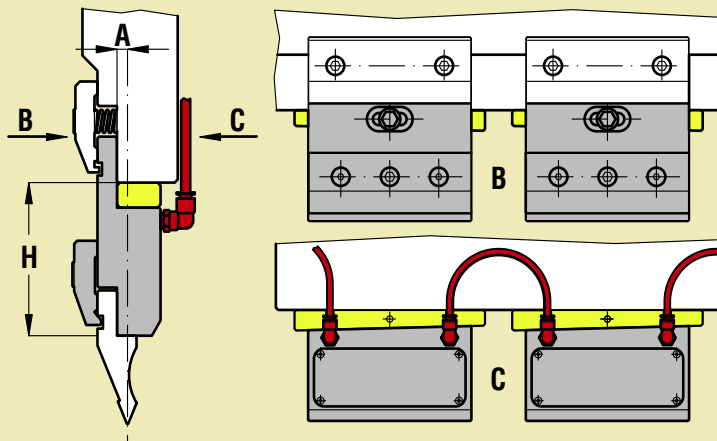
## RAPID

TUBI DI COLLEGAMENTO POSTERIORI  
*CONNECTION BACK PIPES*

50.800 H100 A7

50.805 H120 A7

50.810 H150 A7

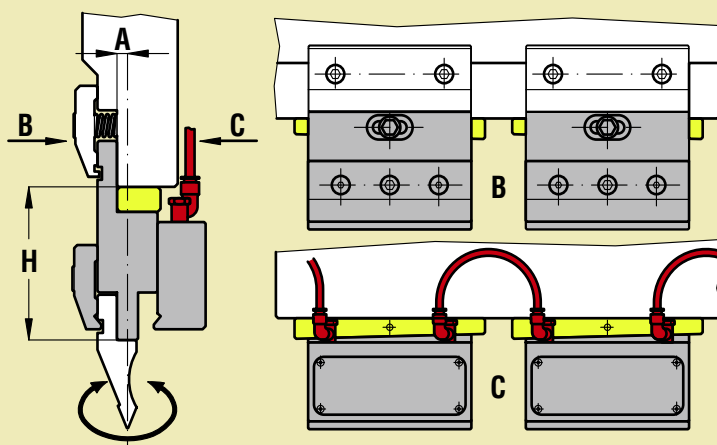


## RAPID REVERSIBILE

TUBI DI COLLEGAMENTO POSTERIORI  
REVERSIBILITA' DEGLI UTENSILI  
*CONNECTION BACK PIPES  
REVERSIBILITY OF UPPER TOOLS*

50.870 H100 A7

50.875 H150 A7



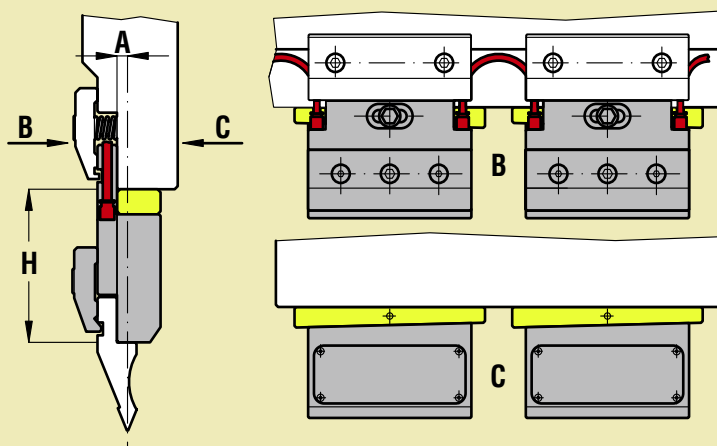
## RAPID "FP"

TUBI DI COLLEGAMENTO ANTERIORI  
*CONNECTION FRONT PIPES*

50.820 H100 A7

50.830 H120 A20

50.835 H150 A20

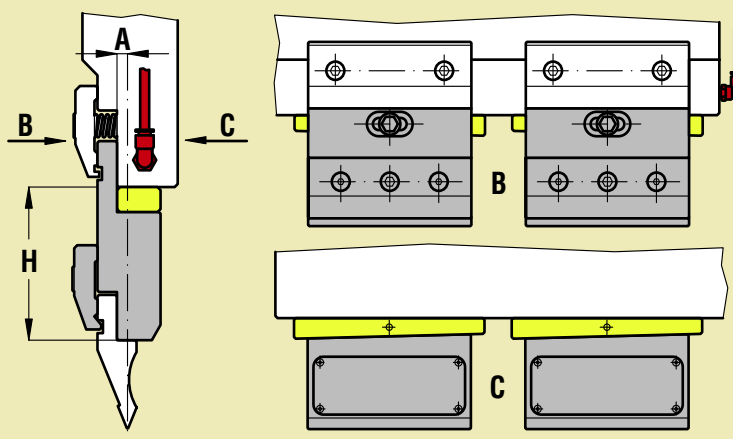


## RAPID TOP-FIX

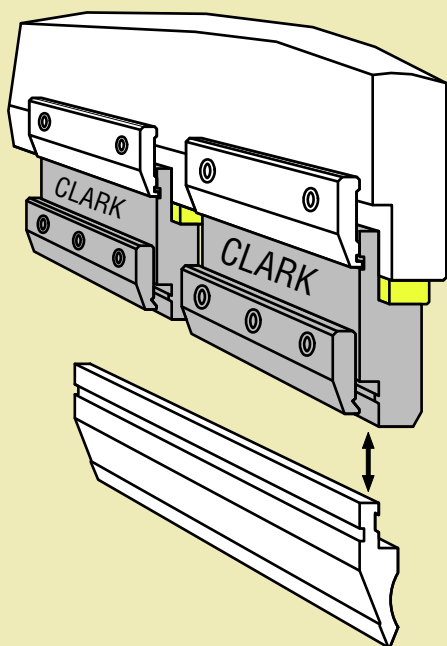
SENZA TUBI DI COLLEGAMENTO  
*WITHOUT CONNECTION PIPES*

50.840 H100 A7

50.845 H150 A7



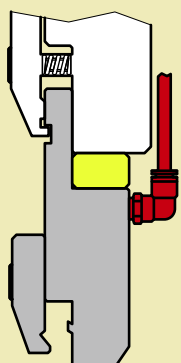
## MONTAGGIO FRONTALE VERTICALLY INSTALLATION



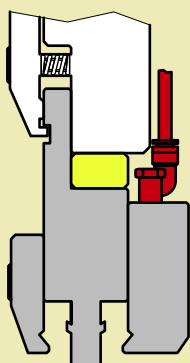
# CLARK

Intermediario pneumatico centinabile.  
 Bloccaggio pneumatico/sbloccaggio meccanico.  
 Montaggio e smontaggio FRONTALE degli utensili.  
 L'utensile viene portato automaticamente in battuta  
 contro il corpo dell'intermediario.  
 Tubi di collegamento ad innesto rapido commerciali.

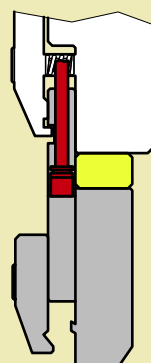
*Adjustable pneumatic adaptor.  
 Pneumatic clamping/Mechanical unclamping.  
 VERTICALLY installation/disinstallation of tools.  
 The tools are automatically positioned and centered.  
 Fast coupling connections and its joining pipes  
 available on the market.*



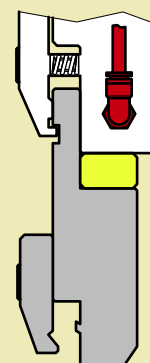
**CLARK**



**CLARK  
REVERS.**



**CLARK  
"FP"**



**CLARK  
TOP-FIX**

BREVETTATO  
PATENTED

**APERTO  
OPEN**

CORSA = 1 mm  
STROKE = 1 mm

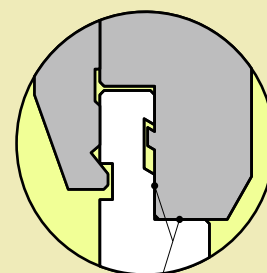
Scanalatura di sicurezza  
standard 8.4x3 (AMADA)  
Standard safety groove  
8.4x3 (AMADA)

Scanalatura supplementare  
cod. 70.1050 per montare  
il punzone frontalmente  
Additional groove cod. 70.1050

Dentello anticaduta  
di sicurezza  
Safety tooth

FORZA DI BLOCCAGGIO A 10 BAR = 700 kg  
CLAMPING POWER AT 10 BARS = 700 Kg

**CHIUSO  
CLOSED**



Punzone automaticamente  
posizionato e centrato.  
Tool automatically positioned  
and centered.

**CENTRALINA PNEUMATICA  
PNEUMATIC EQUIPMENT**

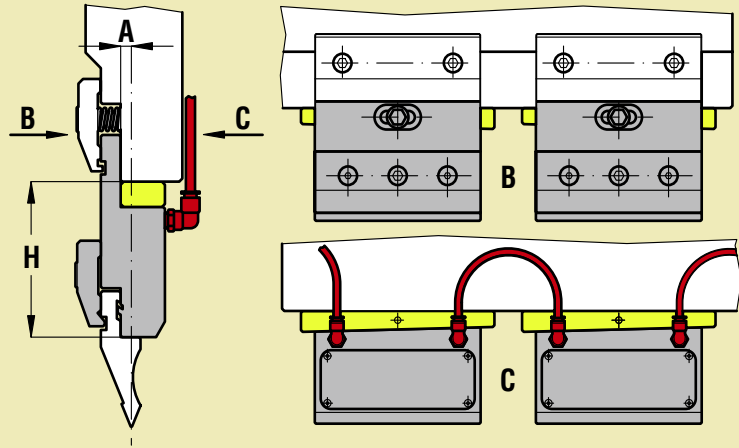
**50.650**  
A 1 COMANDO  
ONE CONTROL

**50.651**  
A 2 COMANDI  
TWO CONTROL

## CLARK

TUBI DI COLLEGAMENTO POSTERIORI  
*CONNECTION BACK PIPES*

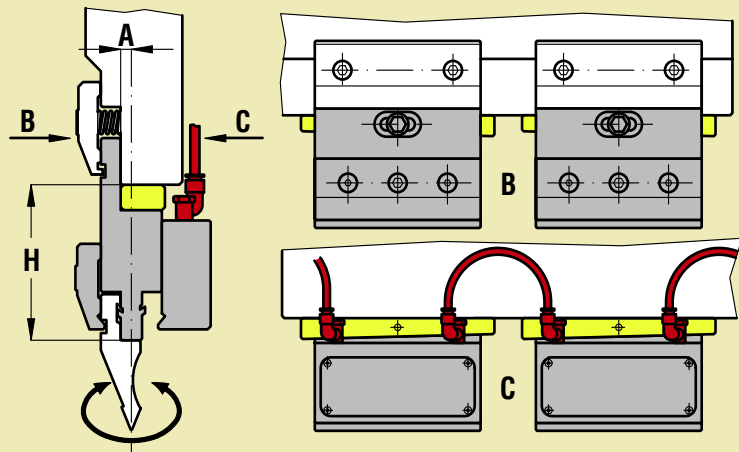
- 50.600 H100 A7
- 50.610 H120 A7
- 50.615 H150 A7
- 50.640 H120 A20
- 50.646 H150 A20



## CLARK REVERSIBILE

TUBI DI COLLEGAMENTO POSTERIORI  
REVERSIBILITA' DEGLI UTENSILI  
*CONNECTION BACK PIPES  
REVERSIBILITY OF UPPER TOOLS*

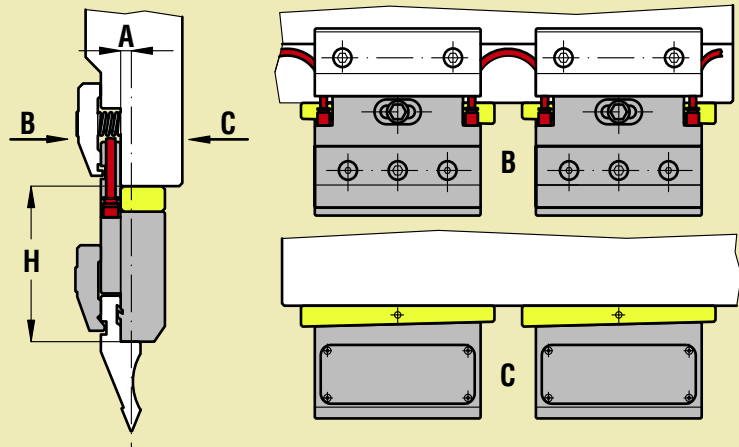
- 50.730 H100 A7
- 50.725 H150 A7
- 50.731 H120 A20



## CLARK "FP"

TUBI DI COLLEGAMENTO ANTERIORI  
*CONNECTION FRONT PIPES*

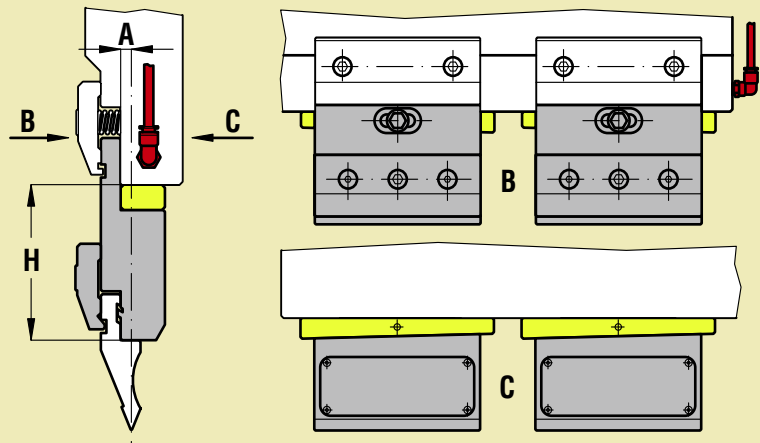
- 50.635 H100 A7
- 50.685 H150 A7
- 50.645 H120 A20
- 50.657 H150 A20



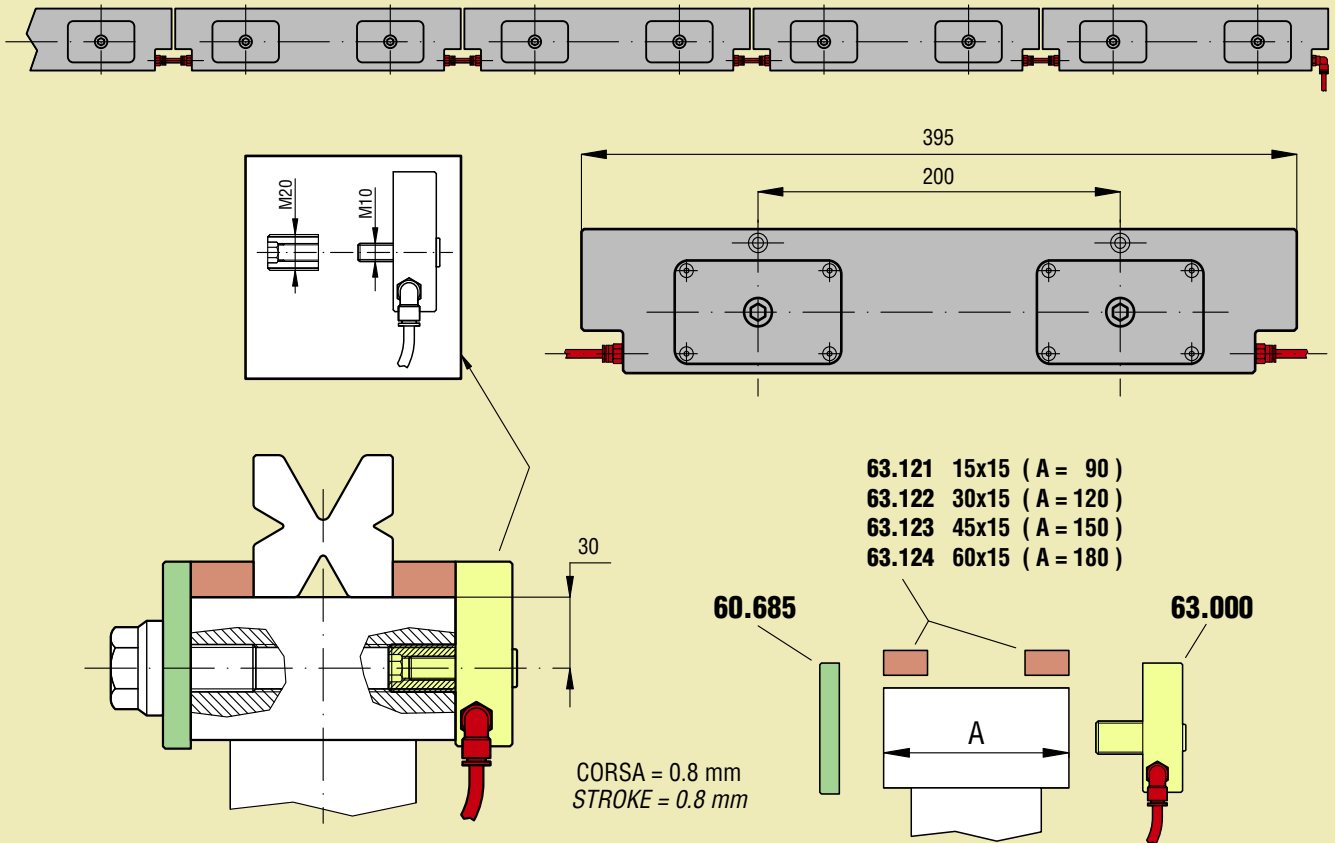
## CLARK TOP-FIX

SENZA TUBI DI COLLEGAMENTO  
*WITHOUT CONNECTION PIPES*

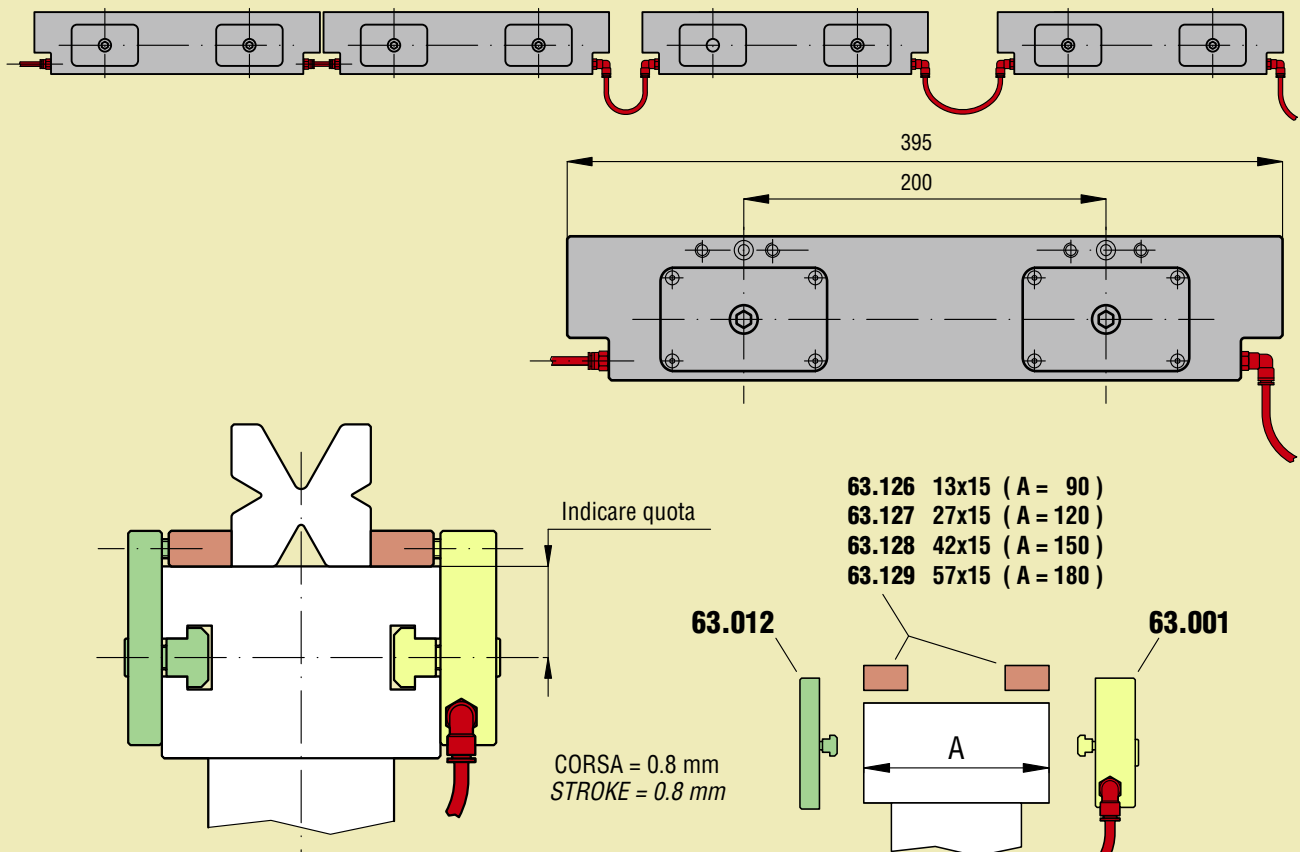
- 50.655 H100 A7
- 50.755 H150 A7



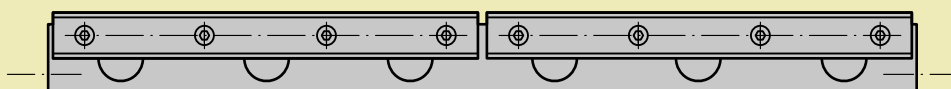
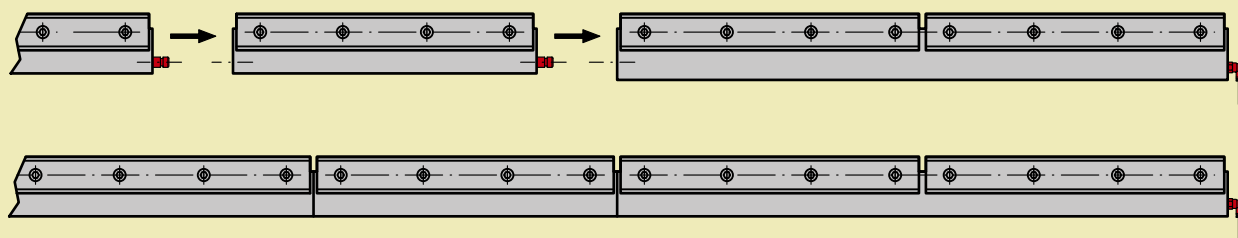
## STAFFA PNEUM. INDIPENDENTE x TAVOLE CON FORATURA PROMECAM PNEUMATIC FREE STANDING CLAMP FOR AMADA/PROMECAM PRESS-BRAKES LOWER TABLES



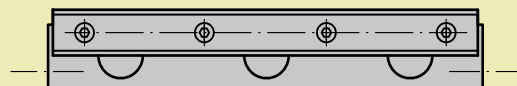
## STAFFA PNEUM. INDIPENDENTE x TAVOLE SCANALATE PNEUMATIC FREE STANDING CLAMP FOR GROOVED LOWER TABLES



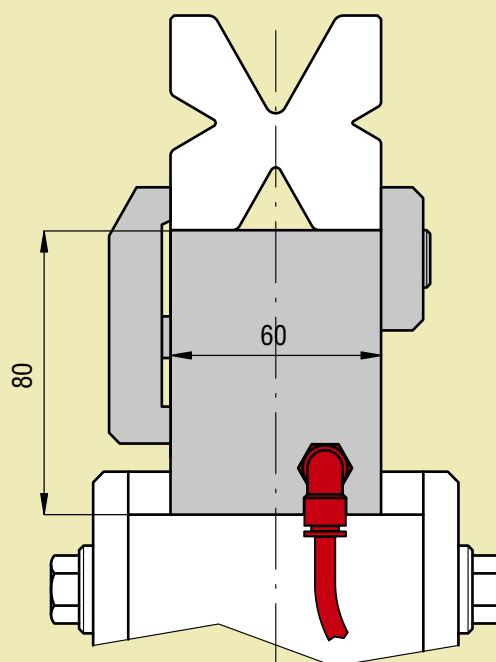
## RIALZO MODULARE PNEUMATICO PNEUMATIC MODULAR HOLDER



**L = 835**



**L = 415**

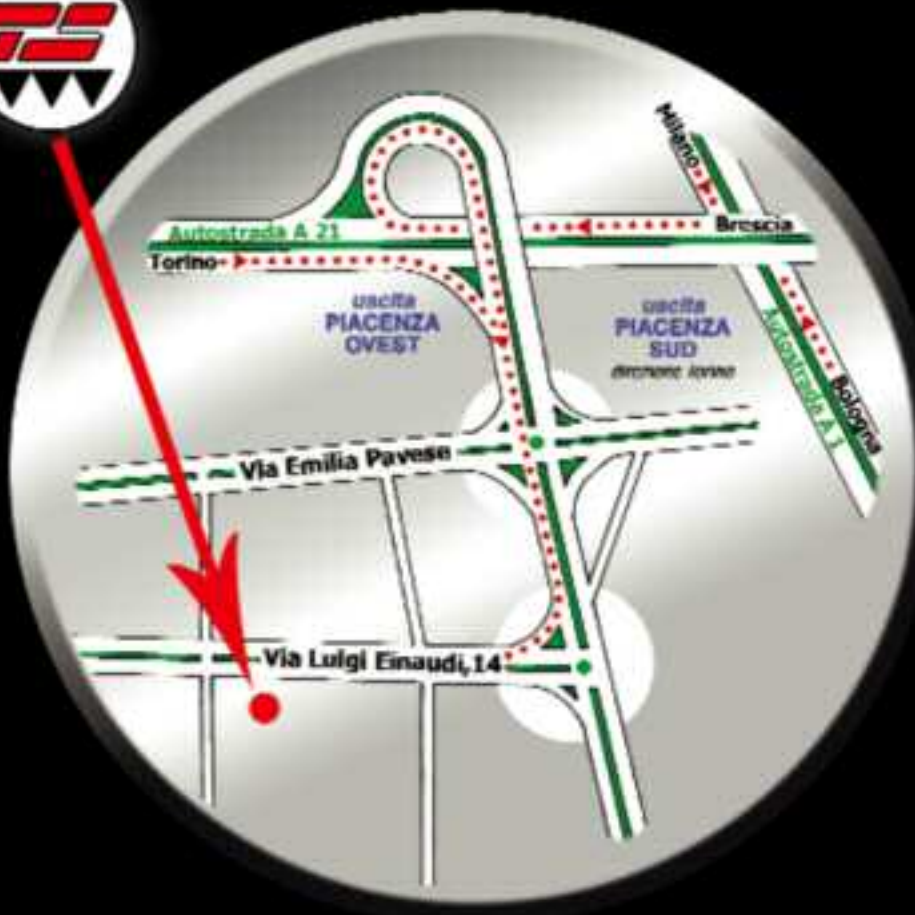


**60.691**

**Rialzo portamatrice modulare a bloccaggio  
pneumatico e sbloccaggio a molla.**

**Modular Holder. Pneumatic clamping.  
Spring unclamping.**

CORSA BLOCCAGGIO 0.8 mm  
CLAMPING MOTION/STROKE 0.8 mm



# ***Tecnostamp***



Via Luigi Einaudi, 14 - 29100 PIACENZA - ITALIA  
Tel. ++39 0523 499712 r.a. - Fax. ++39 0523 497020  
Web site: <http://www.tecnostamp.it>  
E-mail : [tecnostamp@tecnostamp.it](mailto:tecnostamp@tecnostamp.it)