

2018



PRESS BRAKE TOOLING | NARZĘDZIA DO PRAS KRAWĘDZIOWYCH

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Dear customers,

we present to you catalogue of press brake tools and shear knives produced by PPMiU Plasmet.

The content of this catalogue are standard tools available from stock. Produced from high quality steel, they are all ground and induction hardened and we guarantee full exchangeability of unused tools.

All tools in the catalogue can also be made from 1.2312 steel 30 HRC in the body and induction hardened to 55-60 HRC. It is particularly advisable for tools working on hard, plasma or laser cut sheets.

As well as those in the catalogue, we are able to deliver special tools for all types of press brakes also tools designed by you.

We can help in choosing the right tools for the job, and make tools according to the final product with the assist of computer design.

Apart from production of new tools we can offer alteration and regrinding of used tools.

Since 2013 we can offer tools which are laser hardened, and also renovation of tools can be connected with laser hardening.

Szanowni klienci,

przedstawiamy katalog narzędzi do pras krawędziowych i noży do nożyc gilotynowych produkowanych przez P.P.M.i U. Plasmet.

Zawarta w nim oferta to narzędzia standardowe, dostępne z magazynu. Są to narzędzia produkowane ze stali narzędziowej najwyższej jakości, szlifowane i hartowane indukcyjnie. Gwarantujemy pełną zamienność narzędzi.

Wszystkie narzędzia prezentowane w katalogu mogą być również wykonane ze stali 1.2312, ulepszonej do 30 HRC i zahartowanej indukcyjnie na krawędziach pracujących do 55-60 HRC. Jest to szczególnie korzystne dla narzędzi pracujących na blachach twardej, z krawędziami ciętymi laserem.

Poza narzędziami standardowymi oferujemy narzędzia do różnych typów pras krawędziowych, katalogowe lub specjalne wykonane ze stali wysokostopowych.

Jesteśmy w stanie, przy pomocy programu komputerowego, pomóc w doborze narzędzi do profilu końcowego. Oprócz wykonywania narzędzi, proponujemy także przeróbki i regenerację narzędzi używanych.

Od 2013 roku oferujemy również narzędzia hartowane laserowo, oraz renowacje narzędzi używanych w połączeniu z ponownym hartowaniem laserem.

GENERAL INFORMATION | INFORMACJE OGÓLNE

standard tools TYPE "A" | narzędzia standardowe TYPU „A”

Material

C45, C50, 41Cr4 or 42CrMo4

Working edge hardened

55 ±2 HRC

Standard lengths

835 and 415 mm

Segment length

as shown on drawing

Material

C45, C50, 40H lub 40HM

Część robocza hartowana

55 ±2 HRC

Długość standardowa

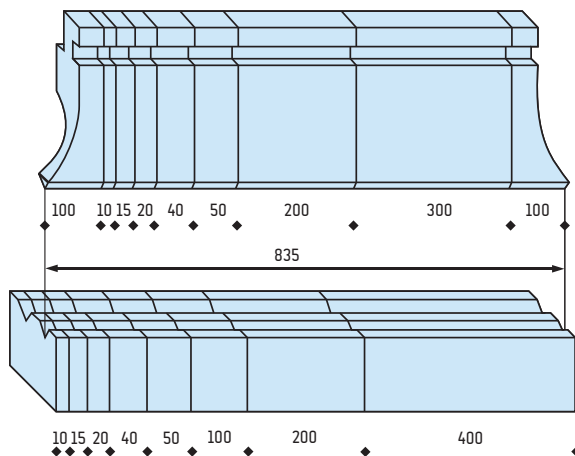
835 i 415 mm

Narzędzia segmentowe

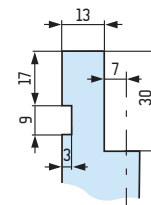
jak na rysunku

Sectionalized tool TYPE "A".

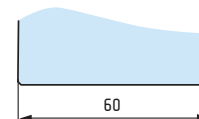
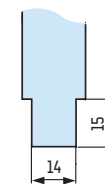
Schemat narzędzia segmentowego TYPU „A”.



Punch mounting edge.
Uchwyt stempla.



Die mounting edge.
Uchwyt matrycy.



standard tools TYPE "T" | narzędzia standardowe TYPU „T”

Material

C45, 42CrMo4 or 1.2312

Thermal enhancement to*

30 ±2 HRC (950 - 1100 MPa)

Working edge hardened

55 ±2 HRC (1500 - 1600 MPa)

Length

TYPE "T" 835, 500, 550 mm segmented

* applies to 1.2312

Material

C45, 40HM lub 1.2312

Ulepszenie cieplne*

30 ±2 HRC (950 - 1100 MPa)

Część robocza hartowana

55 ±2 HRC (1500 - 1600 MPa)

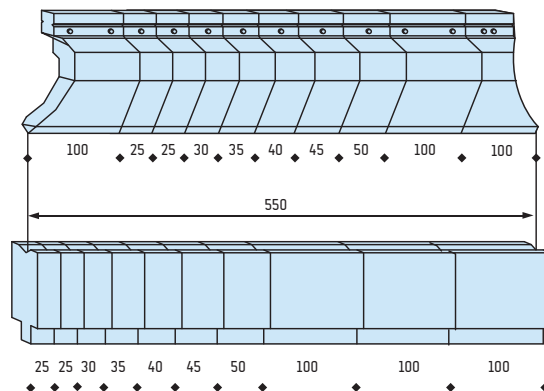
Długość

TYP "T" 835, 500, 550 mm segmentowa

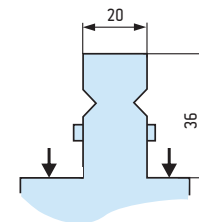
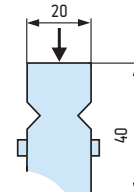
* dotyczy 1.2312

Sectionalized tool TYPE "T".

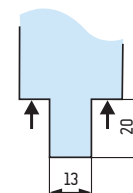
Schemat narzędzia segmentowego TYPU „T”.



Punch mounting edge.
Uchwyt stempla.



Die mounting edge.
Uchwyt matrycy.



GENERAL INFORMATION | INFORMACJE OGÓLNE

standard tools TYPE "W" | narzędzia standardowe TYPU „W”

Material

C45, 42CrMo4 or 1.2312

Thermal enhancement to*

30 ±2 HRC (950 - 1100 MPa)

Working edge hardened

55 ±2 HRC (1500 - 1600 MPa)

Length

TYPE "W" 515, 550 mm segmented

* applies to 1.2312

Material

C45, 40HM lub 1.2312

Ulepszenie cieplne*

30 ±2 HRC (950 - 1100 MPa)

Część robocza hartowana

55 ±2 HRC (1500 - 1600 MPa)

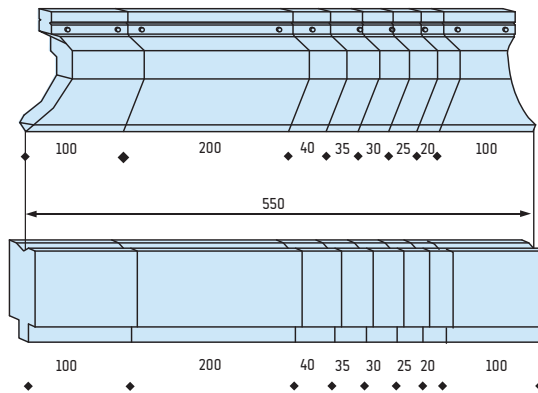
Długość

TYP "W" 515, 550 mm segmentowa

* dotyczy 1.2312

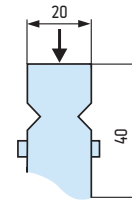
Sectionalized tool TYPE "W".

Schemat narzędzia segmentowego TYPU „W”.



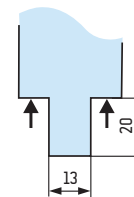
Punch mounting edge.

Uchwyt stempla.



Die mounting edge.

Uchwyt matrycy.



standard tools TYPE "L" | narzędzia standardowe TYPU „L”

Material

C45, 42CrMo4 or 1.2312

Thermal enhancement to*

30 ±2 HRC (950 - 1100 MPa)

Working edge hardened

55 ±2 HRC (1500 - 1600 MPa)

Length

508 and 550 mm segmented

* applies to 1.2312

Material

C45, 40HM lub 1.2312

Ulepszenie cieplne*

30 ±2 HRC (950 - 1100 MPa)

Część robocza hartowana

55 ±2 HRC (1500 - 1600 MPa)

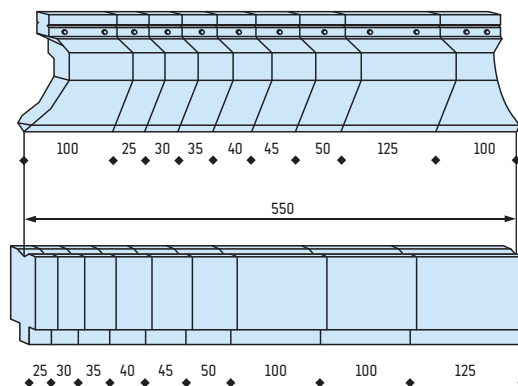
Długość

508 i 550 mm segmentowa

* dotyczy 1.2312

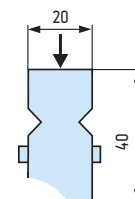
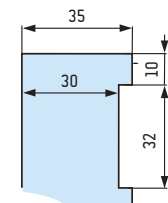
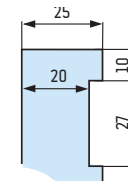
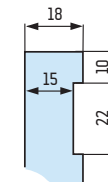
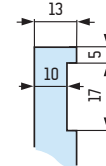
Sectionalized tool TYPE "L".

Schemat narzędzia segmentowego TYPU „L”.



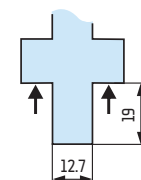
Punches type "L" have five different clampings.

Stemple typu „L” występują z pięcioma typami mocowań.



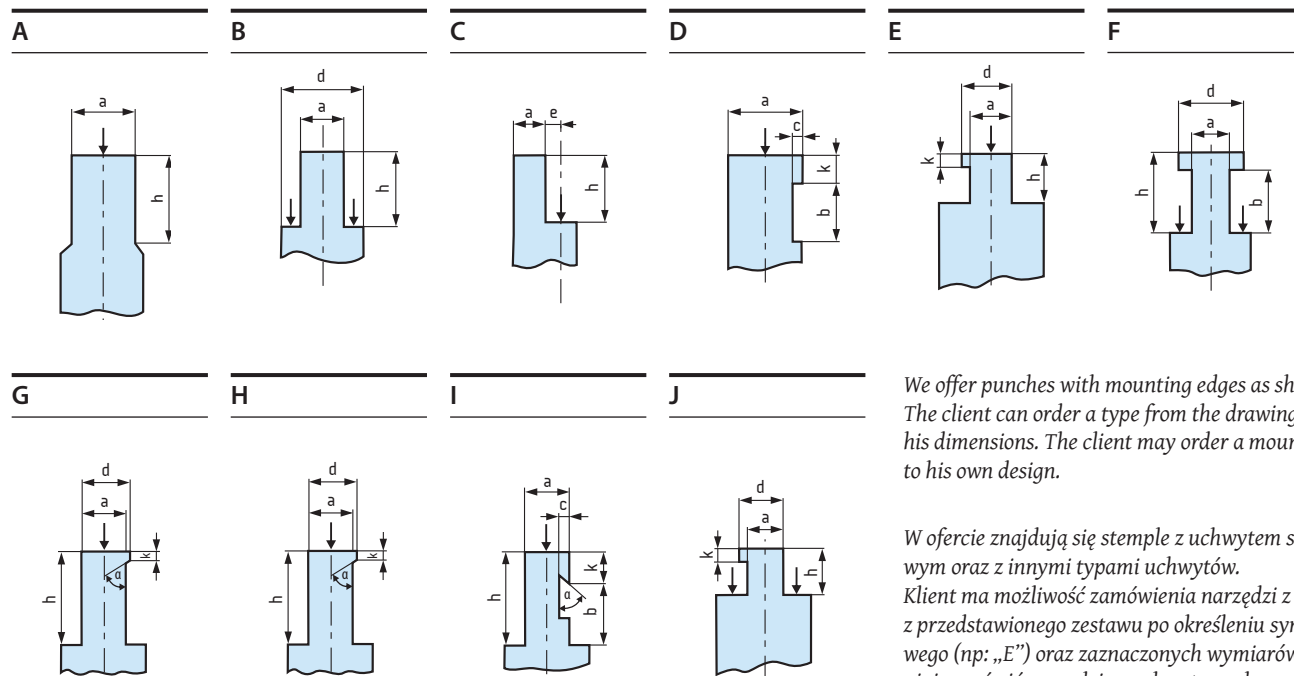
Die mounting edge.

Uchwyt matrycy.



GENERAL INFORMATION | INFORMACJE OGÓLNE

punch mounting edge | rodzaje uchwytów stempli



We offer punches with mounting edges as shown. The client can order a type from the drawing specifying his dimensions. The client may order a mounting edge to his own design.

W ofercie znajdują się stemple z uchwytem standardowym oraz z innymi typami uchwytów. Klient ma możliwość zamówienia narzędzi z uchwytem z przedstawionego zestawu po określeniu symbolu literowego (np: „E”) oraz zaznaczonych wymiarów. Można również zamówić narzędzie z uchwytem własnego projektu.

tool ordering code | sposób zamawiania

Punches i.e 2010/88/R0.8/835

2010/88/R0.8/835 - Catalogue number

2010/88/R0.8/835 - Angle $\alpha = 30^\circ, 35^\circ, 60^\circ, 75^\circ, 80^\circ, 88^\circ, 90^\circ$

2010/88/R0.8/835 - Working edge type - thus "F" or "R" and size

2010/88/R0.8/835 - Length of tool - thus 835 mm, 415 mm, 835 mm sectionalized

Dies i.e 6112/35/835

6112/35/835 - Catalogue number

6112/35/835 - Angle $\alpha = 30^\circ, 35^\circ, 60^\circ, 85^\circ, 88^\circ, 90^\circ$

6112/35/835 - Length of tool - thus 835 mm, 415 mm, 835 mm sectionalized

Stemple np. 2010/88/R0.8/835

2010/88/R0.8/835 - Numer katalogowy stempla

2010/88/R0.8/835 - Kąt $\alpha = 30^\circ, 35^\circ, 60^\circ, 75^\circ, 80^\circ, 88^\circ, 90^\circ$

2010/88/R0.8/835 - Część robocza stempla („F” lub „R” oraz wielkość)

2010/88/R0.8/835 - Długość elementu 835 mm, 415 mm, 835 mm segmentowy

Matryce np. 6112/35/835

6112/35/835 - Numer katalogowy matrycy

6112/35/835 - Kąt $\alpha = 30^\circ, 35^\circ, 60^\circ, 85^\circ, 88^\circ, 90^\circ$

6112/35/835 - Rodzaj elementu 835 mm, 415 mm, 835 mm segmentowy

special tools | narzędzia specjalne

Material

C45, 40HM lub 1.2312

Ulepszenie cieplne*

30 ± 2HRC (950 - 1100 MPa)

Część robocza hartowana

55 ± 2HRC (1500 - 1600 MPa)

Długość

do 4100 mm

* dotyczy 1.2312

Material

C45, 42CrMo4 or 1.2312

Thermal enhancement to*

30 ± 2HRC (950 - 1100 MPa)

Working edge hardened

55 ± 2HRC (1500 - 1600 MPa)

Length

up to 4100 mm

* applies to 1.2312

additional information | oznaczenia symboli



in stock / dostępne z magazynu



fast delivery possible / możliwość szybkiej dostawy

42CrMo4

42CrMo4 steel as standard / narzędzie wykonane ze stali 42CrMo4

Narzędzia wykonywane w szczególności z wymienionych gatunków stali lub z innej stali o podobnej wytrzymałości.

Prezentowany katalog nie stanowi oferty handlowej w rozumieniu Kodeksu Cywilnego, a ma jedynie charakter informacyjny.

TYPE "A" PUNCHES | STEMPEL TYPU „A“



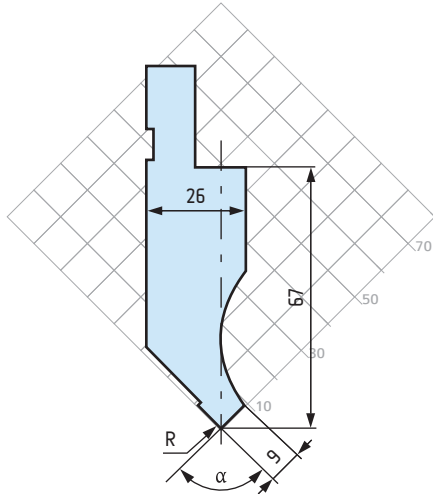
S 2010 100 t/m

$\alpha = 75^\circ, R = 0.8 \text{ mm}$

$\alpha = 85^\circ, R = 0.8 \text{ mm}$

$\alpha = 88^\circ, R = 0.2 \text{ mm}, 0.8 \text{ mm}, 1.5 \text{ mm}, 3 \text{ mm}$

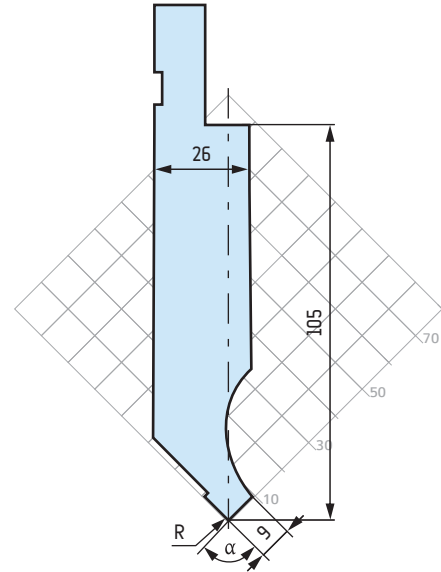
$\alpha = 90^\circ, R = 0.2 \text{ mm}, 0.8 \text{ mm}$



S 2010/105 100 t/m

$\alpha = 75^\circ, 85^\circ, 88^\circ$

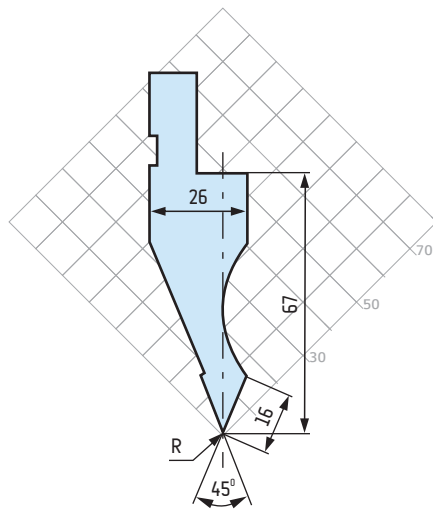
$R = 0.8 \text{ mm}$



S 2011 80 t/m

$\alpha = 45^\circ$

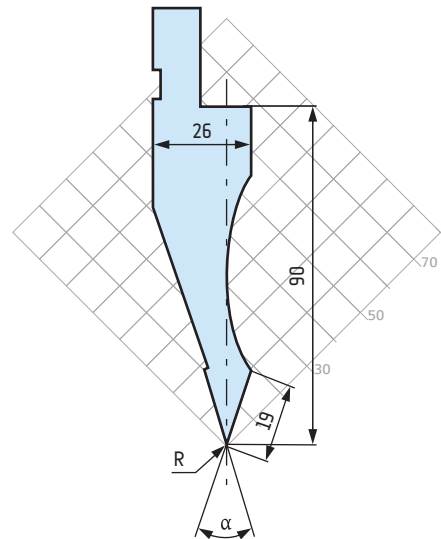
$R = 0.4 \text{ mm}, 0.8 \text{ mm}, 1.5 \text{ mm}$



S 2012 70 t/m

$\alpha = 30^\circ, 35^\circ$

$R = 1 \text{ mm}$



TYPE "A" PUNCHES | STEMPLU TYPU „A“

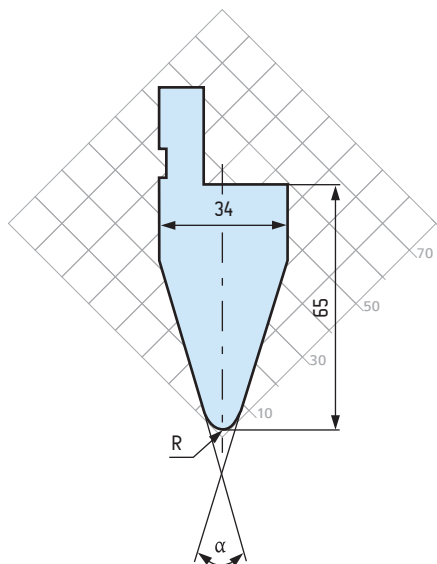


S 2013 100 t/m

$\alpha = 35^\circ$, $R = 5 \text{ mm}$

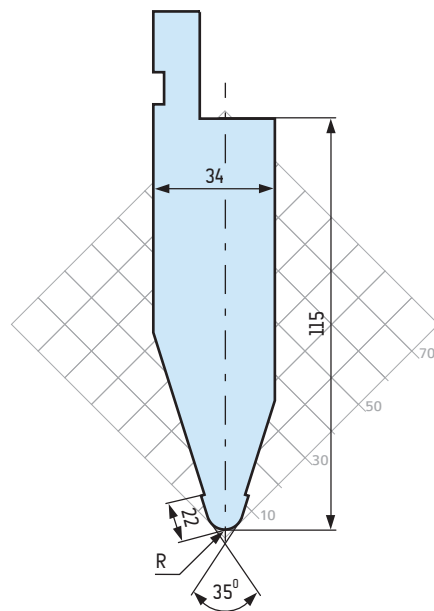
$\alpha = 60^\circ$, $R = 6 \text{ mm}$

$\alpha = 80^\circ$, $R = 6 \text{ mm}$



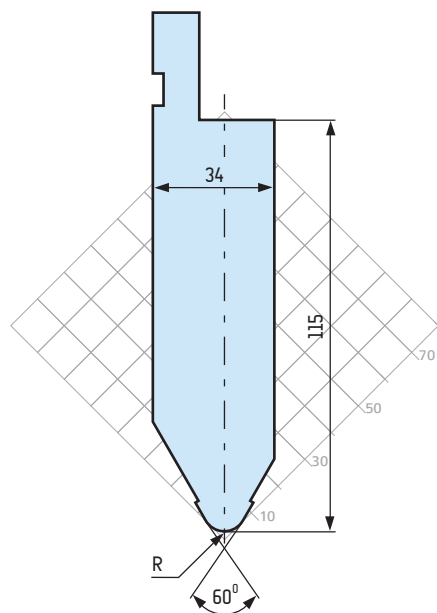
S 2013/115 100 t/m

$\alpha = 35^\circ$, $R = 5 \text{ mm}$



S 2013/115 100 t/m

$\alpha = 60^\circ$, $R = 6 \text{ mm}$



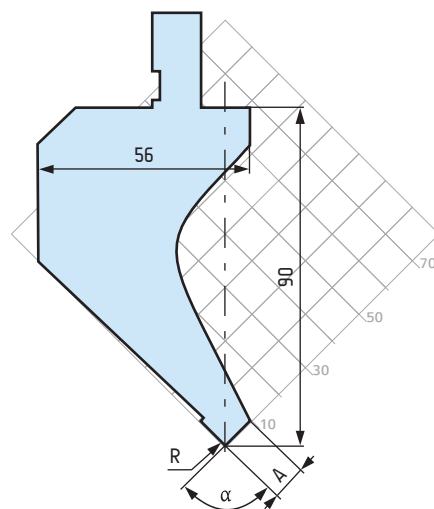
S 2014 60 t/m*

$\alpha = 75^\circ$, $A = 9 \text{ mm}$, $R = 0.8 \text{ mm}$, *20 t/m

$\alpha = 88^\circ$, $A = 6 \text{ mm}$, $R = 0.2 \text{ mm}$, 0.8 mm *50 t/m

$\alpha = 88^\circ$, $A = 9 \text{ mm}$, $R = 0.2 \text{ mm}$, 0.8 mm

$\alpha = 90^\circ$, $A = 9 \text{ mm}$, $R = 0.8 \text{ mm}$



TYPE "A" PUNCHES | STEMPEL TYPU „A“

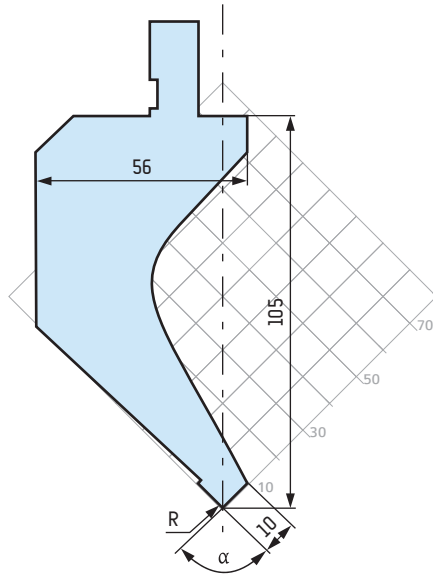


S 2015 50 t/m

$\alpha = 85^\circ$, $R = 0.8 \text{ mm}$

$\alpha = 88^\circ$, $R = 0.2 \text{ mm}, 0.8 \text{ mm}$

$\alpha = 90^\circ$, $R = 0.8 \text{ mm}$

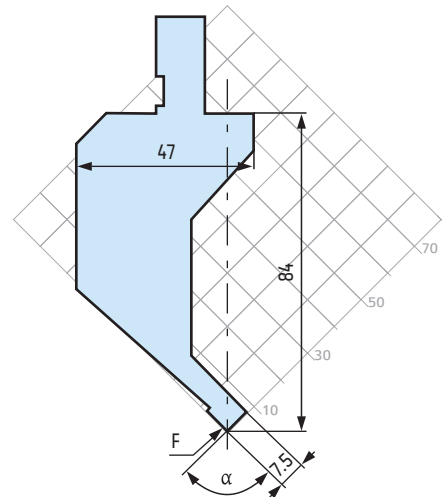


42CrMo4

S 2016 15 t/m

$\alpha = 88^\circ, 90^\circ$

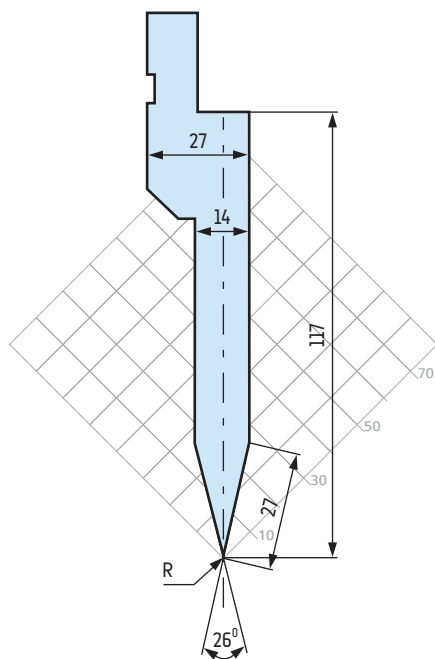
$F = 0.6 \text{ mm}$



S 2017/26 100 t/m

$\alpha = 26^\circ$

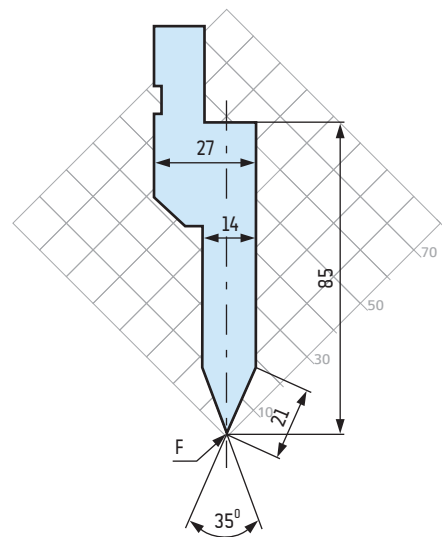
$R = 0.8 \text{ mm}$



S 2017/35 100 t/m

$\alpha = 35^\circ$

$F = 0.8 \text{ mm}$



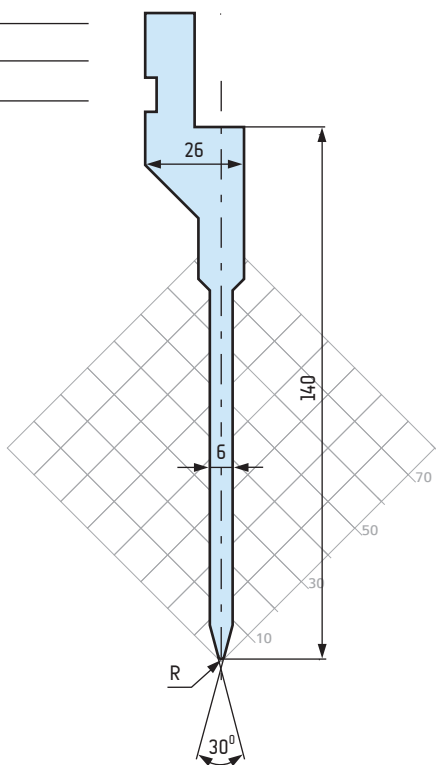
TYPE "A" PUNCHES | STEMPLU TYPU „A“

24h 42CrMo4

S 2017/30 40 t/m

$\alpha = 30^\circ$

$R = 0.8 \text{ mm}$

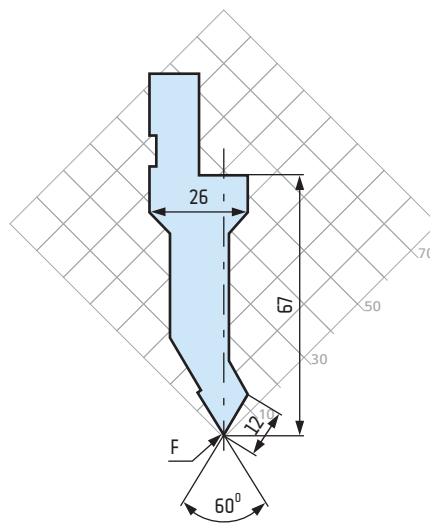


24h

S 2018 60 t/m

$\alpha = 60^\circ$

$F = 0.8 \text{ mm}$

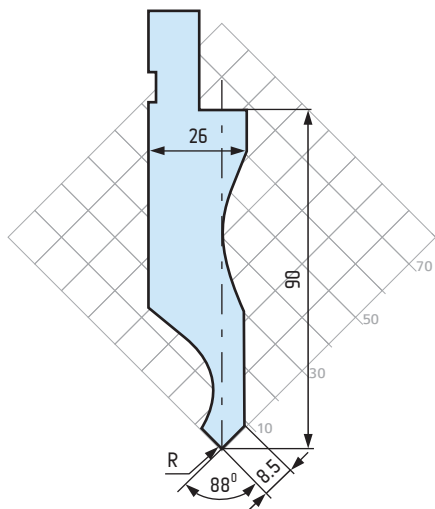


24h

S 2019 70 t/m

$\alpha = 88^\circ$

$R = 0.8 \text{ mm}$



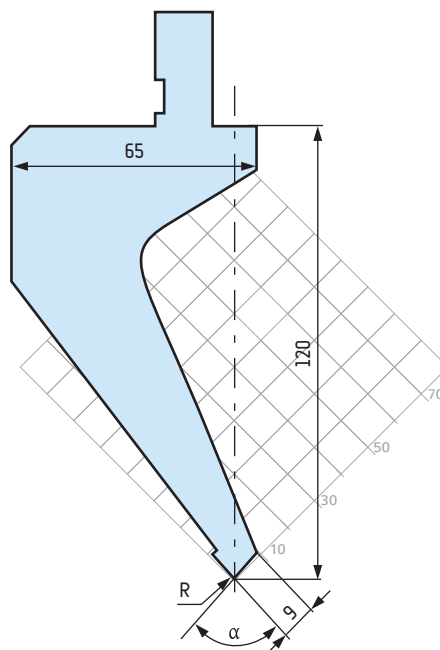
24h

S 2020 50 t/m

$\alpha = 75^\circ, R = 0.8 \text{ mm}$

$\alpha = 85^\circ, R = 0.8 \text{ mm}$

$\alpha = 88^\circ, R = 0.2 \text{ mm}, R = 0.8 \text{ mm}$



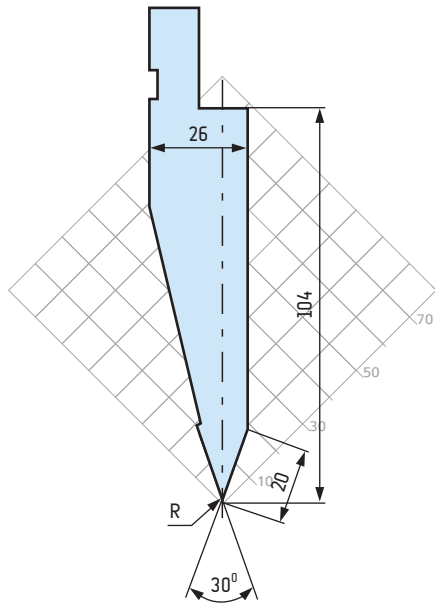
TYPE "A" PUNCHES | STEMPLE TYPU „A“



S 2021 100 t/m

$\alpha = 30^\circ$

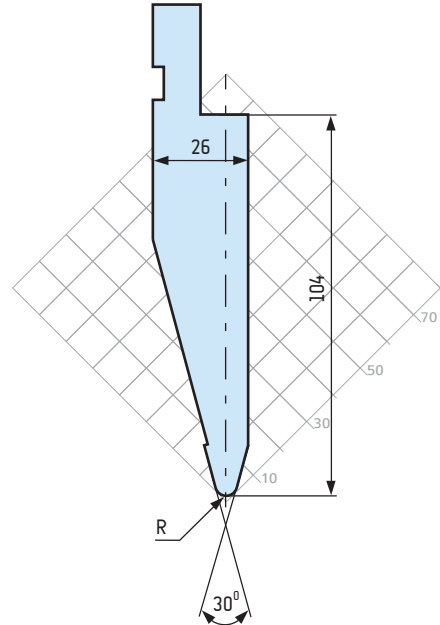
$R = 0.8 \text{ mm}$



S 2021/R3 100 t/m

$\alpha = 30^\circ$

$R = 3 \text{ mm}$

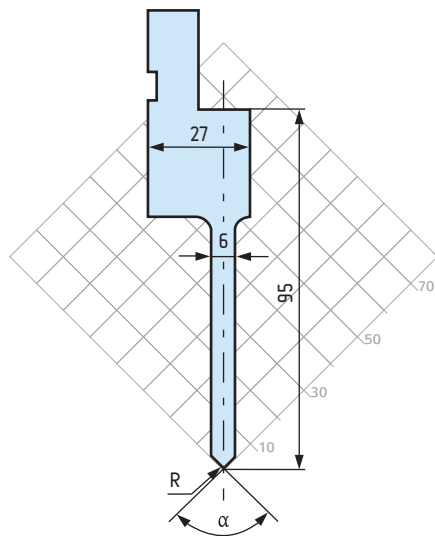


S 2022 50 t/m

$\alpha = 75^\circ$, $R = 0.8 \text{ mm}$

$\alpha = 88^\circ$, $R = 0.2 \text{ mm}$

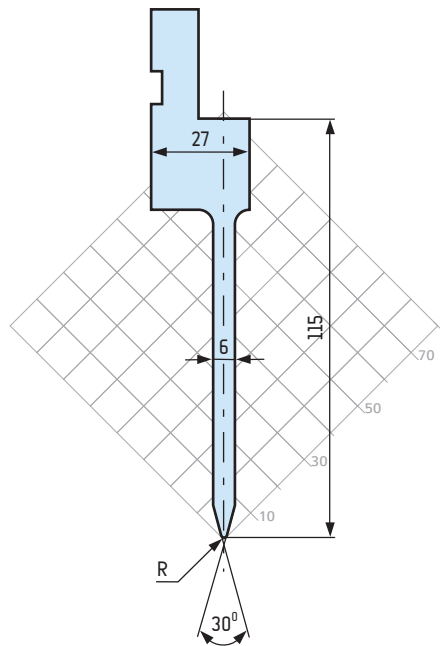
$\alpha = 90^\circ$, $R = 0.2 \text{ mm}$



S 2022/115 45 t/m

$\alpha = 30^\circ$

$R = 0.8 \text{ mm}$



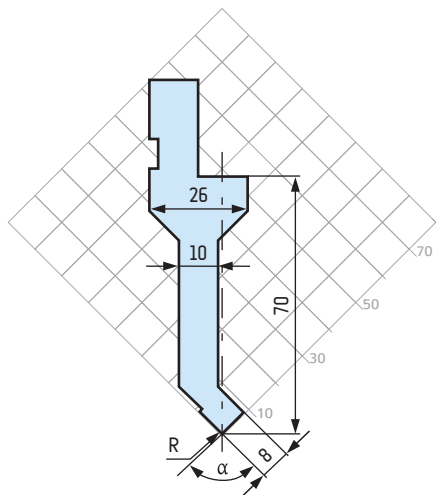
TYPE "A" PUNCHES | STEMPLE TYPU „A”



S 2023 30 t/m

$\alpha = 88^\circ, 85^\circ, 90^\circ$

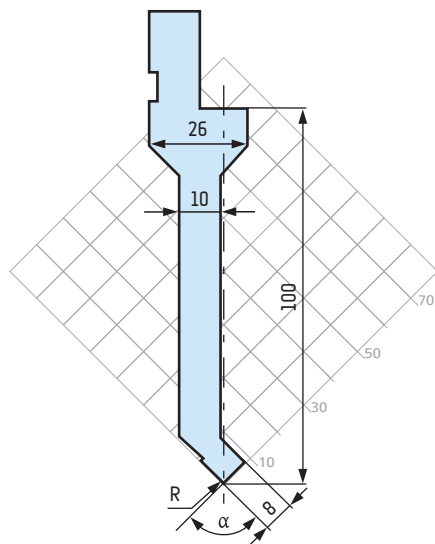
$R = 0.2 \text{ mm}$



S 2024 30 t/m

$\alpha = 88^\circ, 85^\circ, 90^\circ$

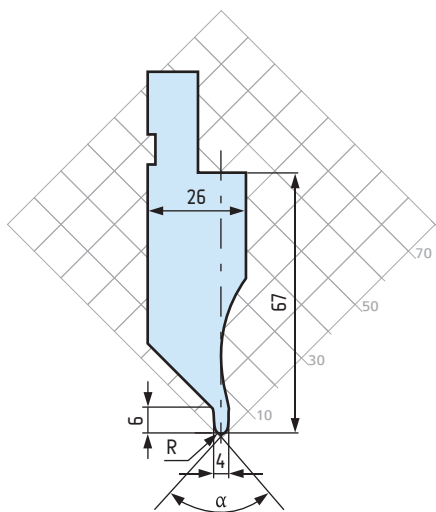
$R = 0.2 \text{ mm}$



S 2025 40 t/m

$\alpha = 88^\circ, 90^\circ$

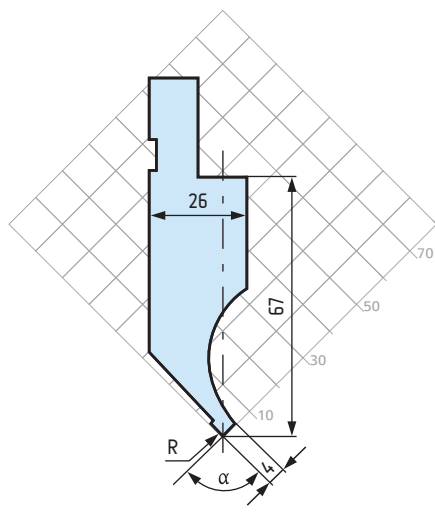
$R = 0.2 \text{ mm}$



S 2026 20 t/m

$\alpha = 88^\circ, 90^\circ$

$R = 0.2 \text{ mm}$



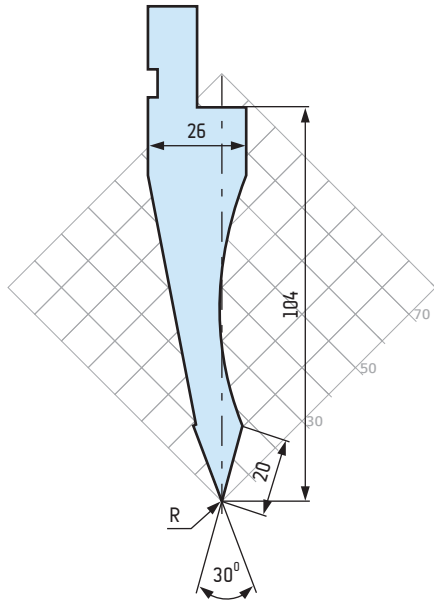
TYPE "A" PUNCHES | STEMPLE TYPU „A”



S 2027 70 t/m

$\alpha = 30^\circ$

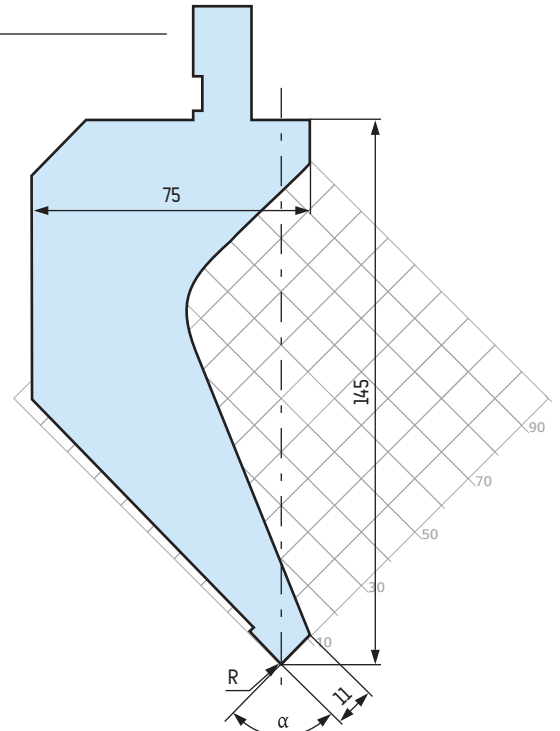
$R = 0.8 \text{ mm}$



S 2028 80 t/m

$\alpha = 85^\circ, 88^\circ$

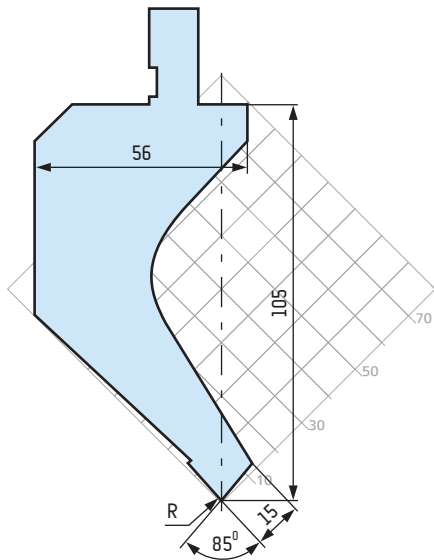
$R = 0.8 \text{ mm}$



S 2029 60 t/m

$\alpha = 85^\circ$

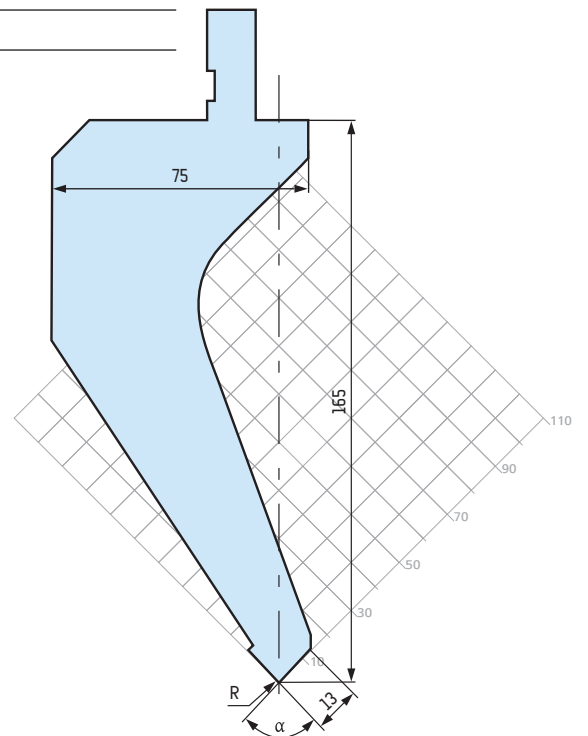
$R = 5 \text{ mm}, 6.5 \text{ mm}$



S 2030 60 t/m

$\alpha = 85^\circ, 88^\circ$

$R = 0.8 \text{ mm}$



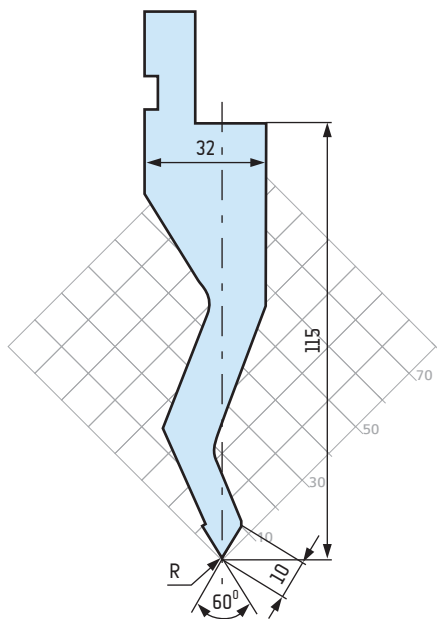
TYPE "A" PUNCHES | STEMPLU TYPU „A“



S 2031 55 t/m

$\alpha = 60^\circ$

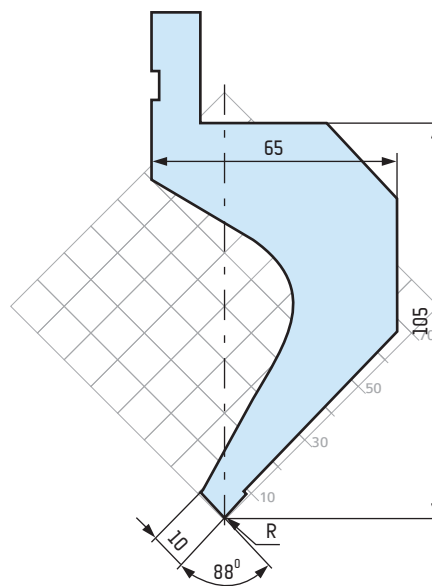
$R = 0.8 \text{ mm}$



S 2032 45 t/m

$\alpha = 88^\circ$

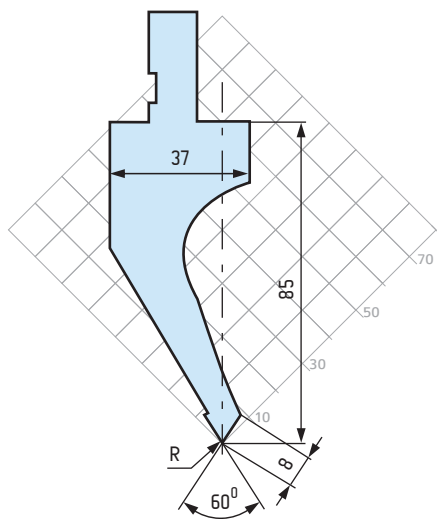
$R = 0.8 \text{ mm}$



S 2034 35 t/m

$\alpha = 60^\circ$

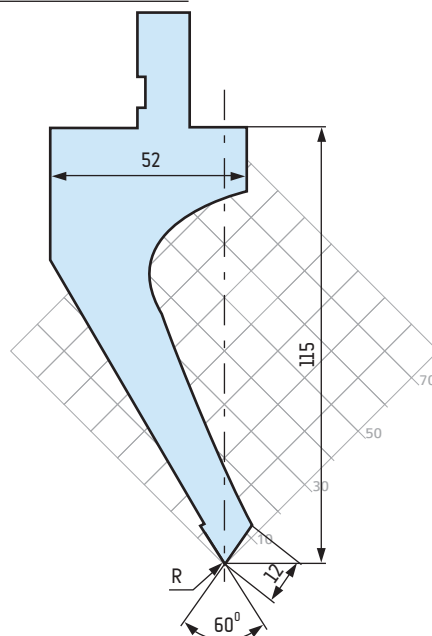
$R = 0.8 \text{ mm}$



S 2035 35 t/m

$\alpha = 60^\circ$

$R = 0.8 \text{ mm}$



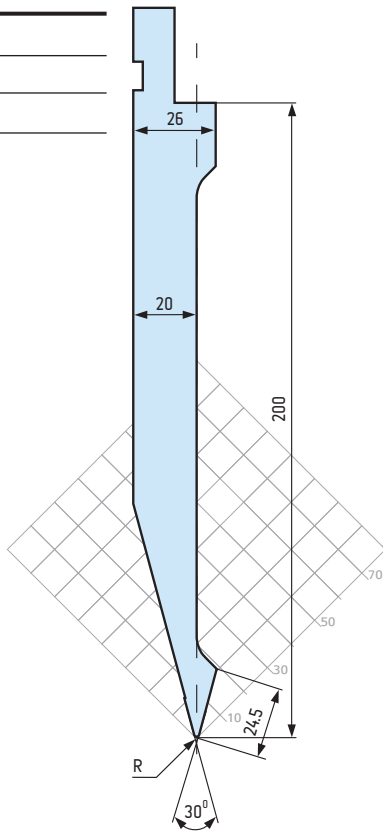
TYPE "A" PUNCHES | STEMPEL TYPU „A“

42CrMo4

S 2036 50 t/m

$\alpha = 30^\circ$

$R = 0.8 \text{ mm}$

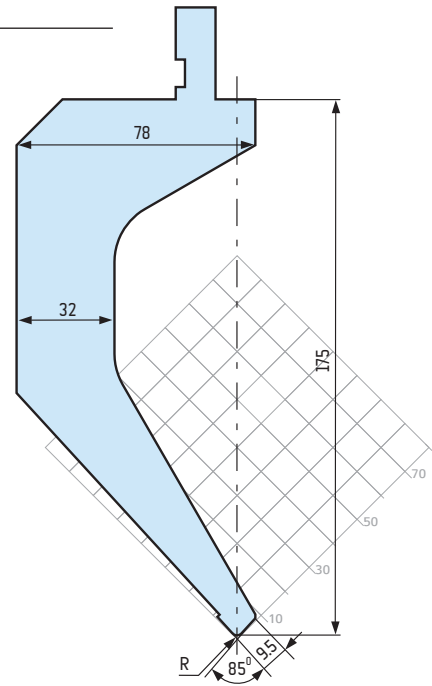


42CrMo4

S 2037 70 t/m

$\alpha = 85^\circ$

$R = 0.8 \text{ mm}$

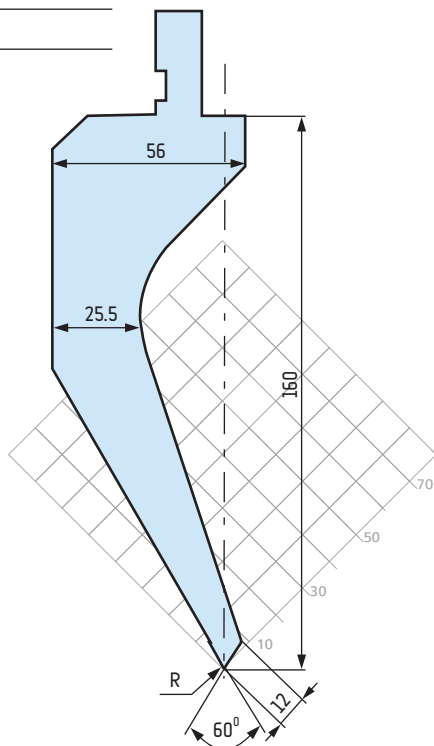


42CrMo4

S 2038 70 t/m

$\alpha = 60^\circ$

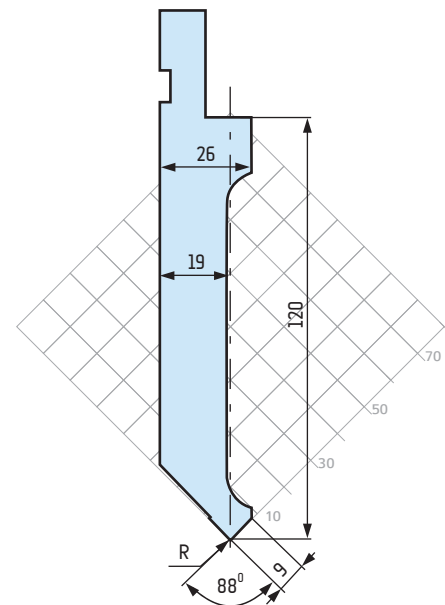
$R = 0.8 \text{ mm}$



S 2039 100 t/m

$\alpha = 88^\circ$

$R = 0.5 \text{ mm}$



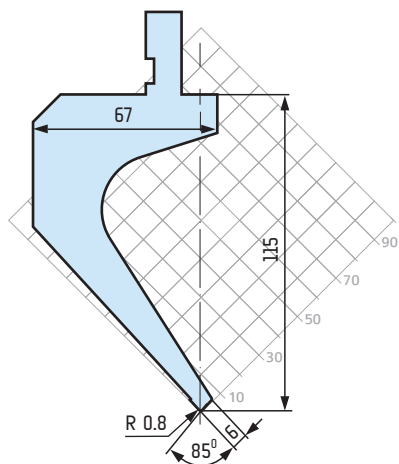
TYPE "A" PUNCHES | STEMPLE TYPU „A”

42CrMo4

S 2040 30 t/m

$\alpha = 85^\circ$

R = 0.8 mm

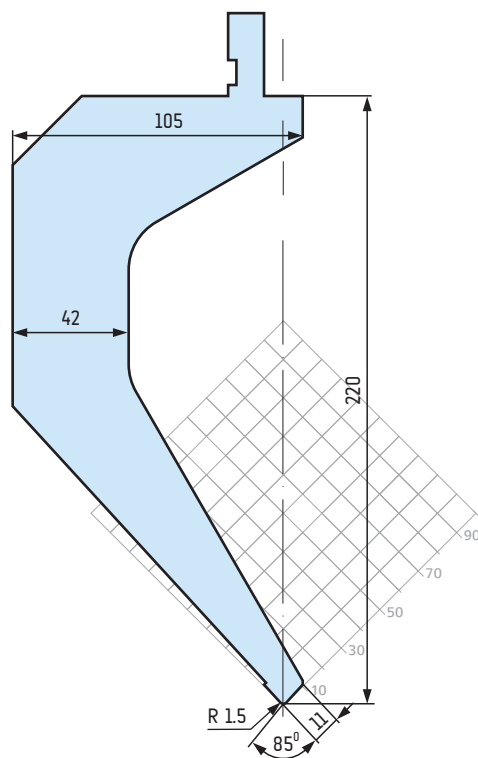


42CrMo4

S 2041 80 t/m

$\alpha = 85^\circ$

R = 1.5 mm



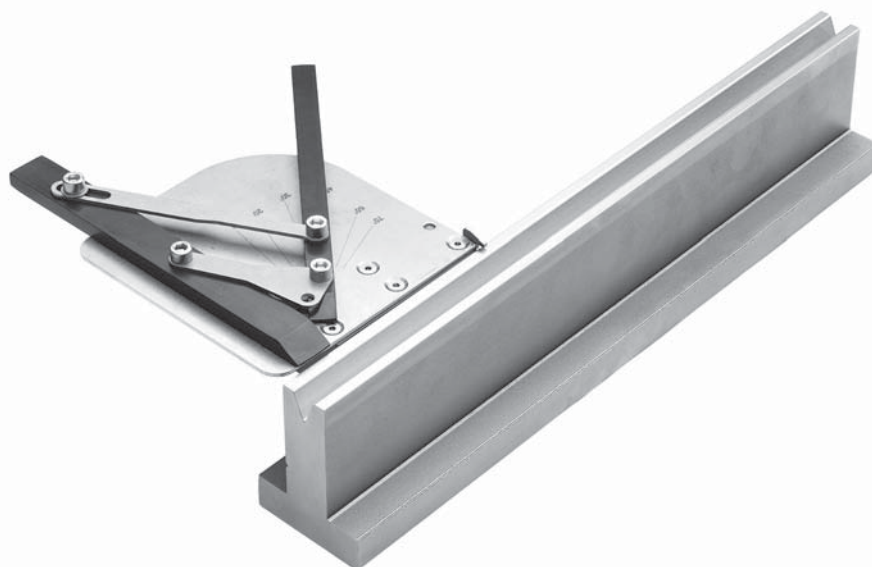
MAGNETIC SQUARING ARM | MAGNETYCZNY USTAWIAK KĄTA GIĘCIA

The magnetic squaring arm with is available in the left and right versions.

Magnetyczny ustawiak kąta gięcia występuje w wersji lewej i prawej.

Ustawiak lewy.
Left squaring arm.

Ustawiak prawy.
Right squaring arm.



TYPE "A" PUNCHES | STEMPLE TYPU „A”

flattening tools | zestaw do zagniatania

24h 42CrMo4

S 2033 70 t/m

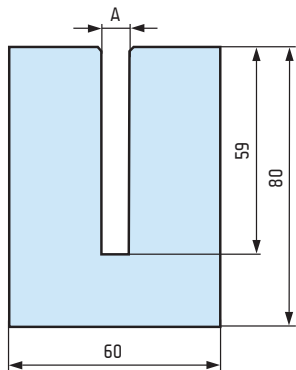
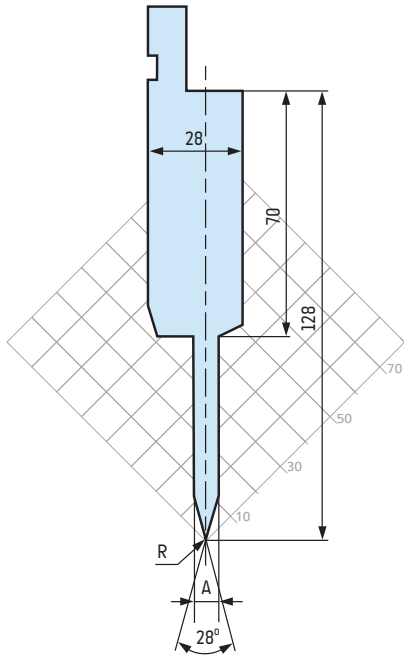
$\alpha = 28^\circ$

$R = 0.6 \text{ mm}, A = 8 \text{ mm}, 10 \text{ mm}, 12 \text{ mm}$

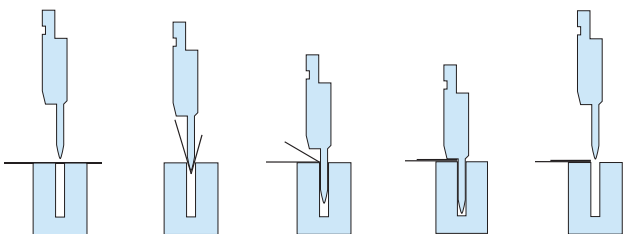
24h 42CrMo4

M 3000 70 t/m

$A = 8 \text{ mm}, 10 \text{ mm}, 12 \text{ mm}$

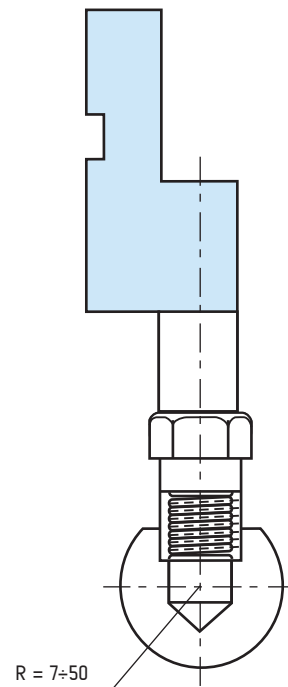
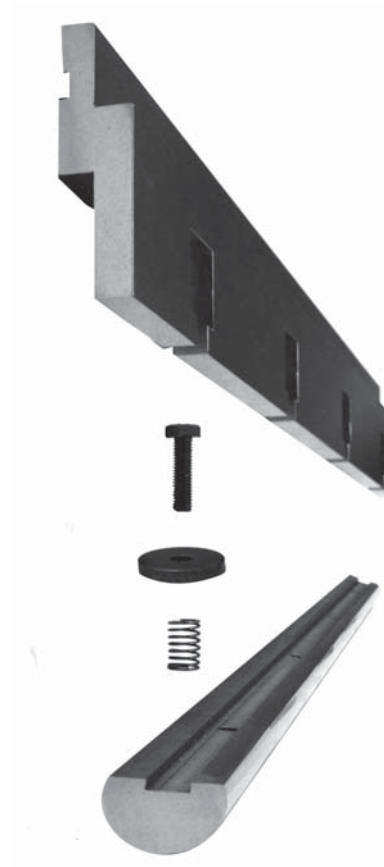


example of use S 2033 and M 3000 |
przykład zastosowania S 2033 i M 3000



RADIUS PUNCHES | STEMPLE PROMIENIOWE

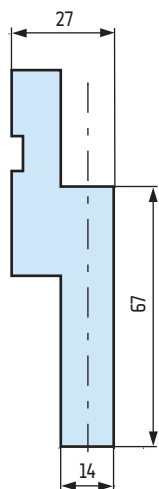
assembly | sposób mocowania



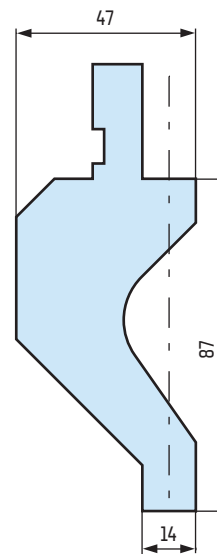
RADIUS PUNCHES | STEMPEL PROMIENIOWE



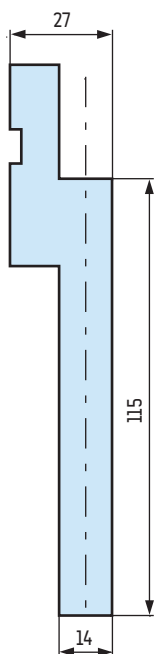
PUNCH R | **STEMPEL R** 80 t/m



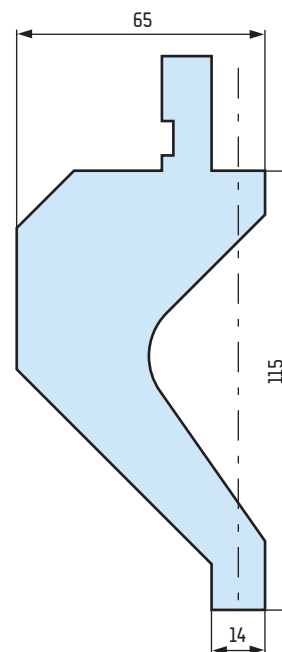
PUNCH R 2 | **STEMPEL R 2** 50 t/m



PUNCH R/115 | **STEMPEL R/115** 80 t/m



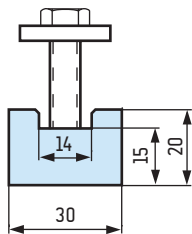
PUNCH R 2 /115 | **STEMPEL R 2/115** 50 t/m



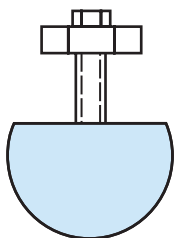
RADIUS PUNCHES | STEMPLE PROMIENIOWE



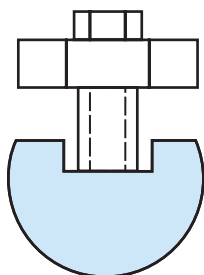
FLATTENING INSERT | WKŁADKA PŁASKA



WKŁADKA R 7 - R 12

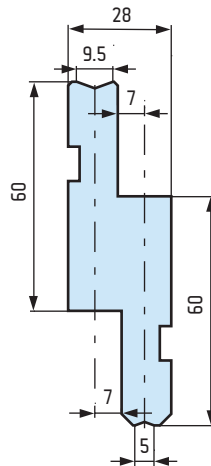


WKŁADKA R 12.5 - R 50



STEMPEL R - R 80 t/m

Double radius punch.
Stempel podwójny promieniowy.

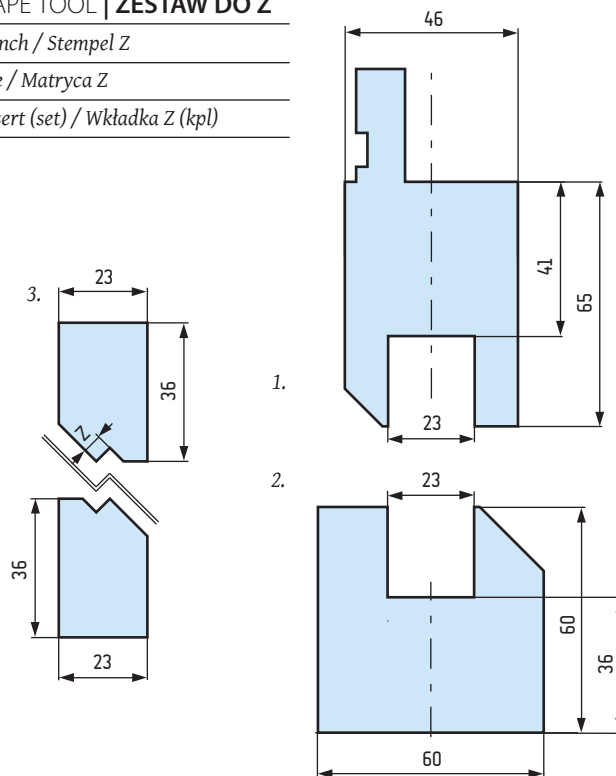


WKŁADKA R 3 - R 6.5



Z SHAPE TOOL | ZESTAW DO Z

1. Z Punch / Stempel Z
2. Z Die / Matryca Z
3. Z Insert (set) / Wkładka Z (kpl)



MECHANICAL ADAPTORS FOR PUNCHES | ŁĄCZNIKI MECHANICZNE STEPLI

joiners | **adaptersy** *Note: The clamp is not included in the kit.*
Uwaga: Klamra nie wchodzi w skład zestawu.



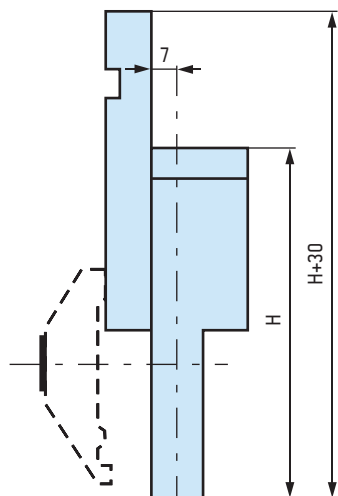
TYPE "A" | **TYP „A”**

H = 100 mm, L = 150 mm

H = 120 mm, L = 150 mm

H = 140 mm, L = 150 mm

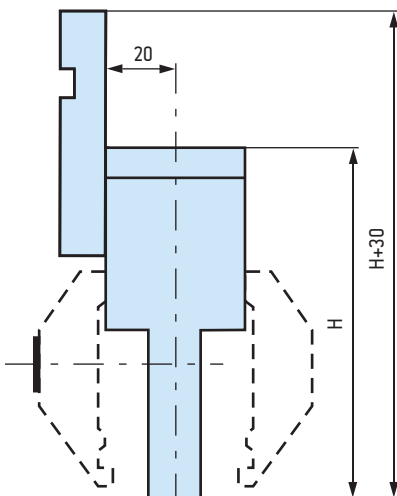
H = 150 mm, L = 150 mm



TYPE "B" | **TYP „B”**

H = 120 mm, L = 150 mm

H = 170 mm, L = 150 mm

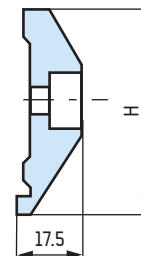


clamping washers | **podkładki mocujące (klamry)**



TYPE "S" | **TYP „S”**

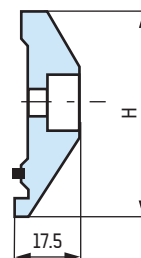
H = 58 mm, L = 150 mm



TYPE "P" | **TYP „P”**

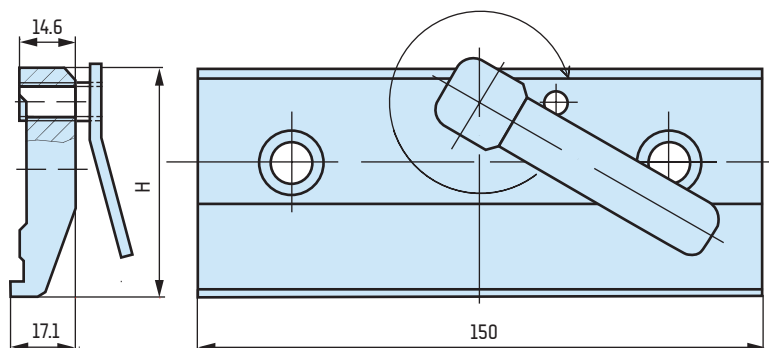
with plastic insert / z wkładką plastikową

H = 58 mm, L = 150 mm



TYPE "QR" | **TYP „QR”**

H = 58 mm, L = 150 mm



type "T" adaptor | adapter typu „T”



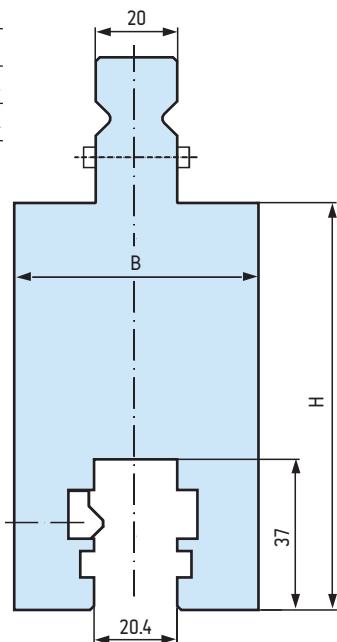
TYPE "T/T" | TYP „T/T”

H = 60 mm, L = 100 mm, B = 55 mm

H = 80 mm, L = 100 mm, B = 55 mm

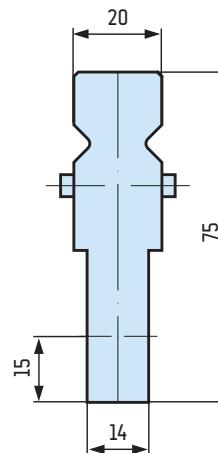
H = 100 mm, L = 100 mm, B = 55 mm

H = 150 mm, L = 100 mm, B = 60 mm



TYPE "T/A" 75 | TYP „T/A” 75

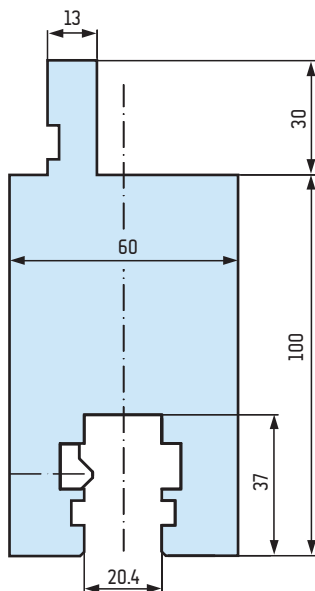
H = 75 mm, L = 835 mm



system changing adaptors |
adaptery międzysystemowe

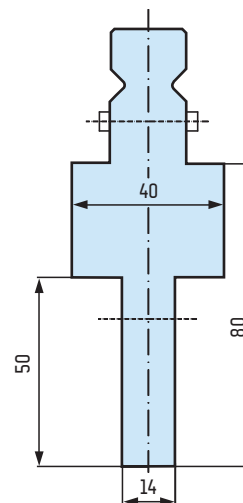
TYPE "A/T" | TYP „A/T”

H = 100 mm, L = 100 mm



TYPE "T/A" 80 | TYP „T/A” 80

H = 80 mm, L = 150 mm

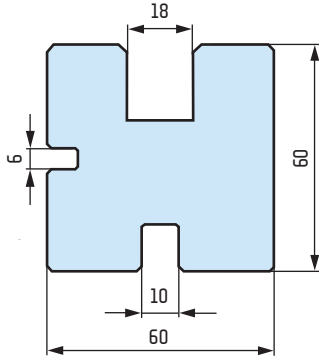


TYPE "A" DIES | MATRYCE TYPU „A”

multiple vee dies | matryce wielorowkowe



MR 100 t/m



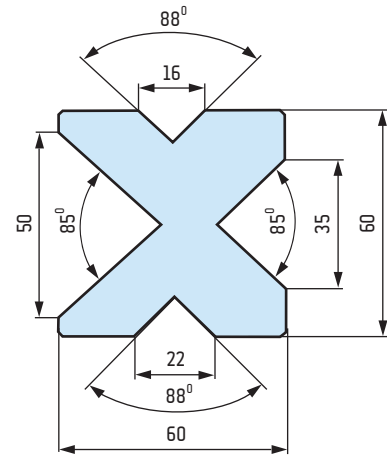
42CrMo4

M 4 80 t/m

$\alpha = 85^\circ, 88^\circ$

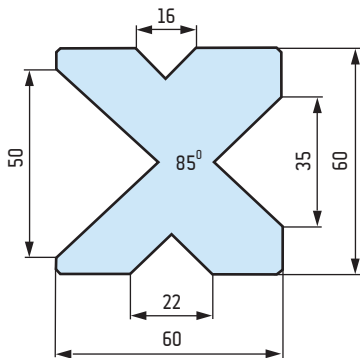
M 4 80 t/m

$\alpha = 85^\circ, 88^\circ$



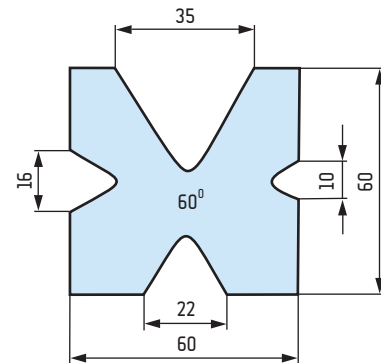
M 4/85° 80 t/m

$\alpha = 85^\circ$



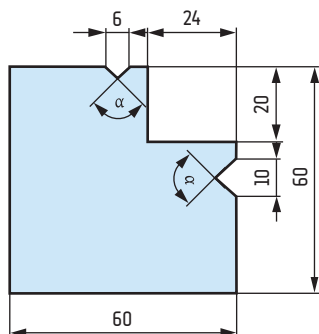
M 4/60° 60 t/m

$\alpha = 60^\circ$



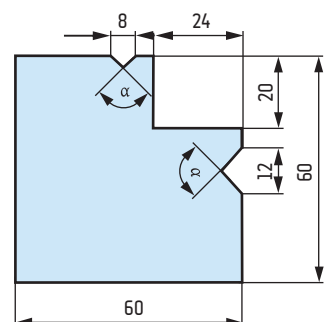
M 2/6 - 10 100 t/m

$\alpha = 90^\circ$



M 2/8 - 12 80 t/m

$\alpha = 90^\circ$



TYPE "A" DIES | MATRYCE TYPU „A”

Dies fixed using die supports A 20 or A -> p. 61

Matryce montowane przy pomocy podpór A 20 lub prowadnicy A -> str 61

with groove | rowkowe



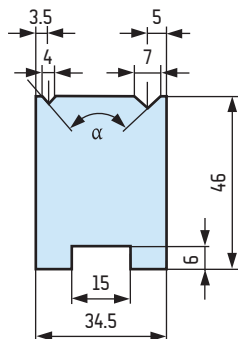
M 6019 80 t/m

$\alpha = 90^\circ$



M 6119 80 t/m

$\alpha = 88^\circ$



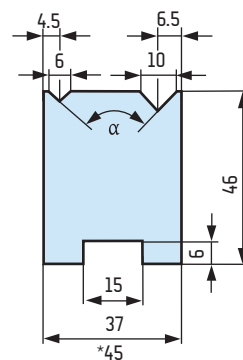
M 6020 80 t/m

$\alpha = 90^\circ$



M 6120 80 t/m

$\alpha = 88^\circ$



M 6220 35 t/m*

$\alpha = 30^\circ$



M 6021 80 t/m

$\alpha = 90^\circ$



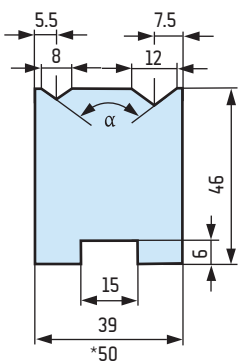
M 6121 80 t/m

$\alpha = 88^\circ$



M 6221 40 t/m*

$\alpha = 30^\circ$



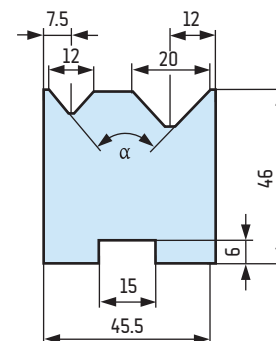
M 6022 80 t/m

$\alpha = 90^\circ$



M 6122 80 t/m

$\alpha = 88^\circ$



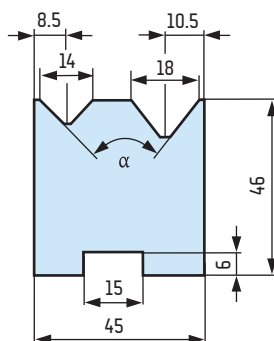
M 6023 80 t/m

$\alpha = 90^\circ$



M 6123 80 t/m

$\alpha = 88^\circ$



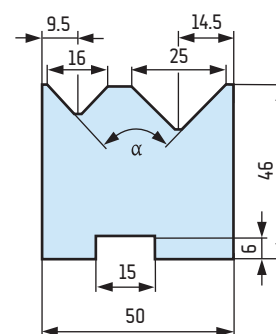
M 6024 80 t/m

$\alpha = 90^\circ$



M 6124 80 t/m

$\alpha = 88^\circ$



TYPE "A" DIES | MATRYCE TYPU „A“

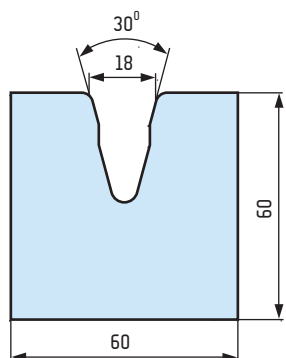
1V dies | matryce 1V



M 3330/18 100 t/m

$\alpha = 30^\circ$

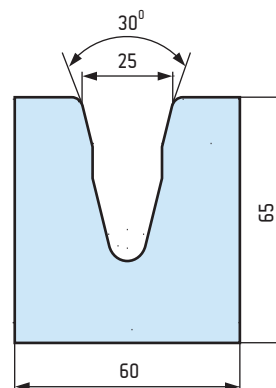
$V = 18 \text{ mm}$



M 3330/25 100 t/m

$\alpha = 30^\circ$

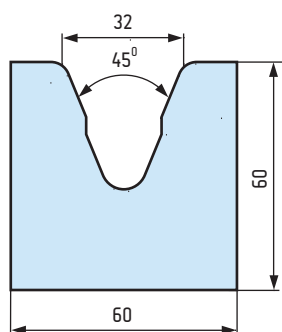
$V = 25 \text{ mm}$



M 3345/32 100 t/m

$\alpha = 45^\circ$

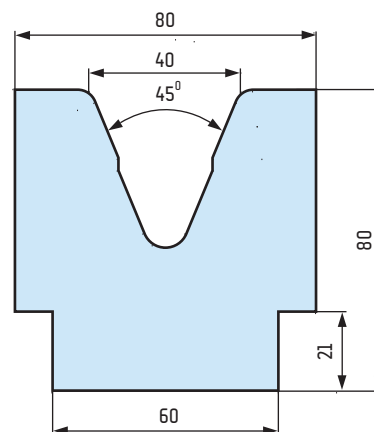
$V = 32 \text{ mm}$



M 3345/40 100 t/m

$\alpha = 45^\circ$

$V = 40 \text{ mm}$



TYPE "A" DIES | MATRYCE TYPU „A“

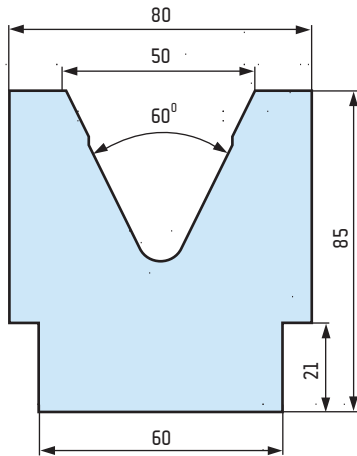
1V dies | matryce 1V



M 3360/50 100 t/m

$\alpha = 60^\circ$

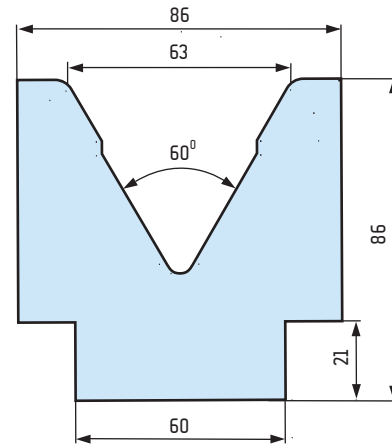
$V = 50 \text{ mm}$



M 3360/63 100 t/m

$\alpha = 60^\circ$

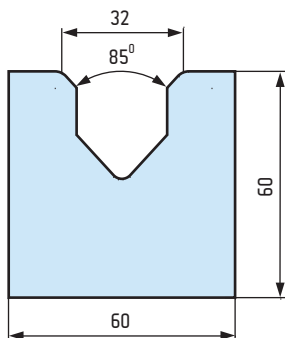
$V = 63 \text{ mm}$



M 3385/32 100 t/m

$\alpha = 85^\circ$

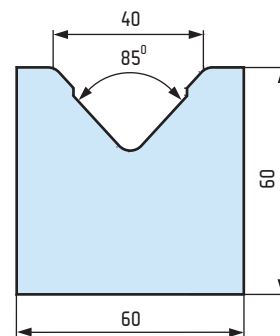
$V = 32 \text{ mm}$



M 3385/40 100 t/m

$\alpha = 85^\circ$

$V = 40 \text{ mm}$



TYPE "A" DIES | MATRYCE TYPU „A“

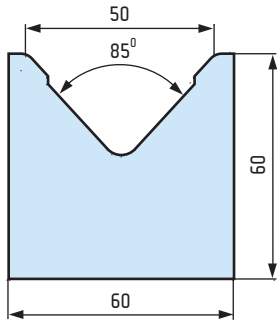
1V dies | matryce 1V



M 3385/50 100 t/m

$\alpha = 85^\circ$

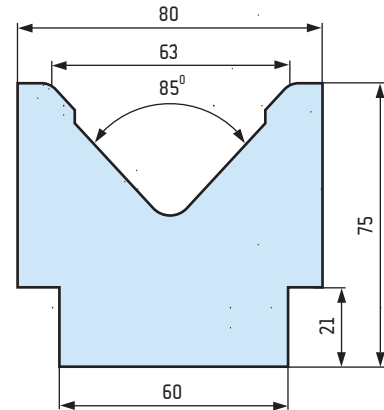
$V = 50 \text{ mm}$



M 3385/63 100 t/m

$\alpha = 85^\circ$

$V = 63 \text{ mm}$



M 3385/80 100 t/m

$\alpha = 85^\circ$

$V = 80 \text{ mm}$

$H = 80 \text{ mm}$

na zamówienie $H = 95 \text{ mm}$



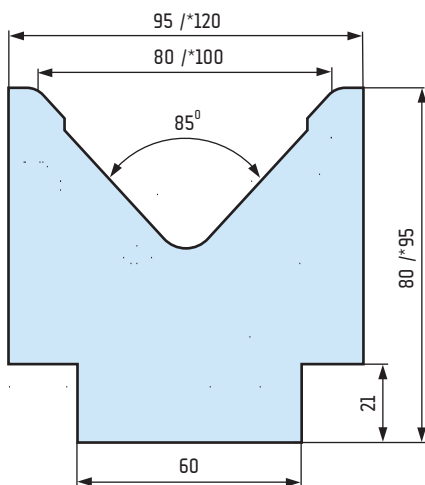
M 3385/100 * 100 t/m

$\alpha = 85^\circ$ *

$V = 100 \text{ mm}$ *

$H = 95 \text{ mm}$ *

na zamówienie $H = 110 \text{ mm}$



M 3380/125 100 t/m

$\alpha = 80^\circ$

$V = 125 \text{ mm}$

$H = 123 \text{ mm}$

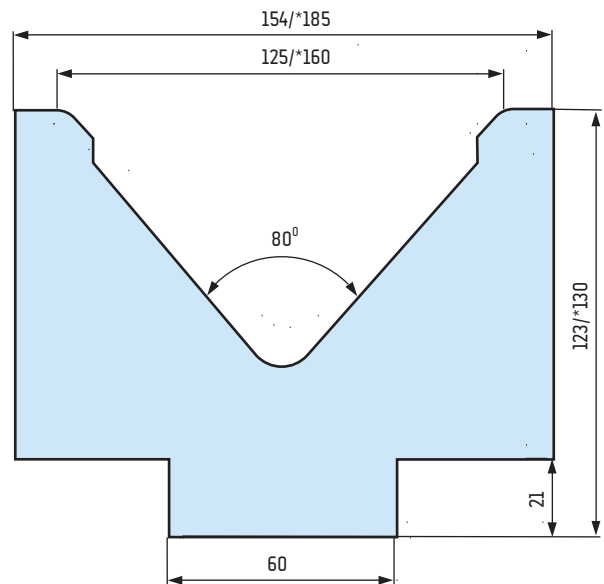


M 3380/160 100 t/m*

$\alpha = 80^\circ$ *

$V = 160 \text{ mm}$ *

$H = 130 \text{ mm}$ *



TYPE "A" DIES | MATRYCE TYPU „A“

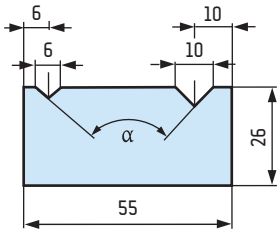
Dies fixed using die supports A 34, A 39, A 55 or A 75 -> p. 61
 Matryce montowane przy pomocy podpór A 34, A 39, A 55 lub A 75 -> str 61

bolt fastened | mocowane śrubami



M 6112 100 t/m

$\alpha = 90^\circ$



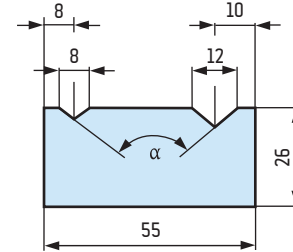
M 6212 60 t/m

$\alpha = 60^\circ$



M 6113 100 t/m

$\alpha = 90^\circ$



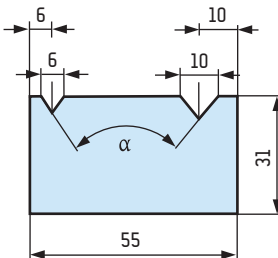
M 6213 80 t/m

$\alpha = 60^\circ$



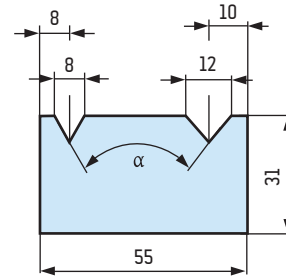
M 6312 30 t/m

$\alpha = 35^\circ$



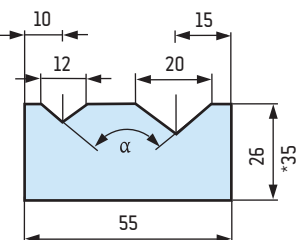
M 6313 30 t/m

$\alpha = 35^\circ$



M 6114 100 t/m

$\alpha = 88^\circ$



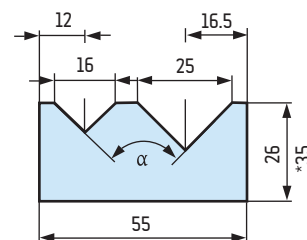
M 6214 80 t/m *

$\alpha = 60^\circ$



M 6115 100 t/m

$\alpha = 88^\circ$



M 6215 80 t/m *

$\alpha = 60^\circ$

TYPE "A" DIES | MATRYCE TYPU „A“

dies with base H = 80 mm | matryce z podstawą H = 80 mm



M 6130 30 t/m

A = 8 mm, B = 16 mm

R₁ = 1 mm, R₂ = 1 mm



M 6230 35 t/m

A = 10 mm, B = 20 mm

R₁ = 1 mm, R₂ = 1 mm



M 6330 35 t/m

A = 12 mm, B = 22 mm

R₁ = 1 mm, R₂ = 1 mm



M 6430 45 t/m

A = 16 mm, B = 30 mm

R₁ = 2 mm, R₂ = 2 mm



M 6530 30 t/m

A = 6 mm, B = 14 mm

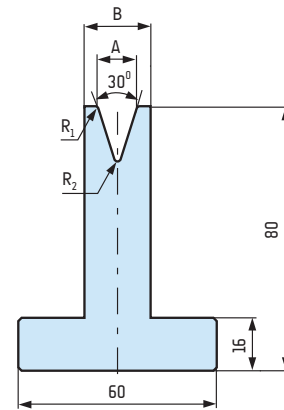
R₁ = 0.8 mm, R₂ = 0.8 mm



M 6630 50 t/m

A = 20 mm, B = 35 mm

R₁ = 4 mm, R₂ = 4 mm



M 6135 35 t/m

A = 8 mm, B = 14 mm

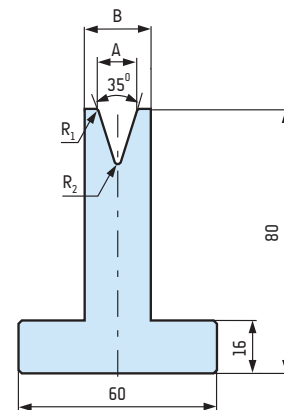
R₁ = 1.5 mm, R₂ = 0.8 mm



M 6235 40 t/m

A = 12 mm, B = 18 mm

R₁ = 2 mm, R₂ = 1 mm



M 6145 50 t/m

A = 10 mm, B = 16 mm

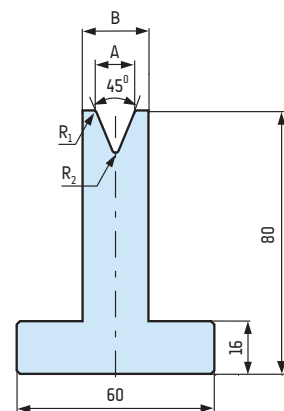
R₁ = 2 mm, R₂ = 1 mm



M 6245 50 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm



TYPE "A" DIES | MATRYCE TYPU „A“

dies with base H = 80 mm | matryce z podstawą H = 80 mm



M 6160 60 t/m

A = 8 mm, B = 14 mm

R₁ = 1.5 mm, R₂ = 0.8 mm



M 6260 60 t/m

A = 10 mm, B = 16 mm

R₁ = 2 mm, R₂ = 1 mm



M 6360 60 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 6460 60 t/m

A = 16 mm, B = 24 mm

R₁ = 1.5 mm, R₂ = 1.5 mm



M 6560 60 t/m

A = 20 mm, B = 30 mm

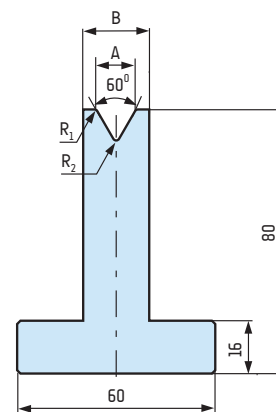
R₁ = 2 mm, R₂ = 2 mm



M 6660 60 t/m

A = 25 mm, B = 40 mm

R₁ = 3 mm, R₂ = 3 mm



M 6085 100 t/m

A = 8 mm, B = 14 mm

R₁ = 1 mm, R₂ = 0.5 mm



M 6185 100 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 6285 100 t/m

A = 16 mm, B = 24 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 6385 100 t/m

A = 20 mm, B = 30 mm

R₁ = 3 mm, R₂ = 1.5 mm



M 6485 100 t/m

A = 25 mm, B = 40 mm

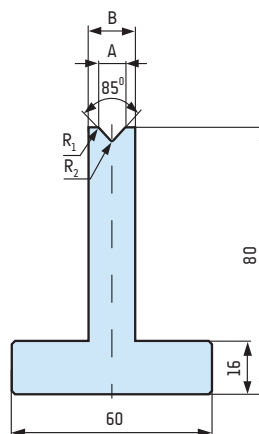
R₁ = 3 mm, R₂ = 3 mm



M 6585 100 t/m

A = 10 mm, B = 18 mm

R₁ = 1 mm, R₂ = 1 mm



M 6685 100 t/m

A = 14 mm, B = 18 mm

R₁ = 2.6 mm, R₂ = 0.4 mm



M 6785 100 t/m

A = 6 mm, B = 14 mm

R₁ = 0.5 mm, R₂ = 0.5 mm



M 6088 100 t/m

A = 8 mm, B = 14 mm

R₁ = 1 mm, R₂ = 0.5 mm



M 6188 100 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 6288 100 t/m

A = 16 mm, B = 24 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 6388 100 t/m

A = 20 mm, B = 30 mm

R₁ = 3 mm, R₂ = 1.5 mm



M 6488 100 t/m

A = 25 mm, B = 40 mm

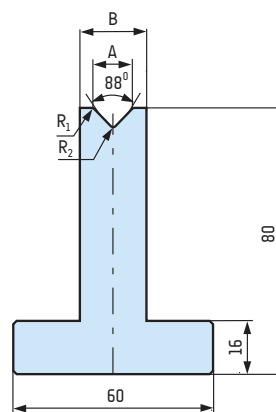
R₁ = 3 mm, R₂ = 3 mm



M 6588 100 t/m

A = 10 mm, B = 18 mm

R₁ = 1 mm, R₂ = 1 mm



M 6688 100 t/m

A = 14 mm, B = 18 mm

R₁ = 2.6 mm, R₂ = 0.4 mm



M 6788 100 t/m

A = 6 mm, B = 14 mm

R₁ = 0.5 mm, R₂ = 0.5 mm

TYPE "A" DIES | MATRYCE TYPU „A“

dies with base H = 80 mm | matryce z podstawą H = 80 mm



M 6190 100 t/m

A = 6 mm, B = 12 mm

R₁ = 1.5 mm, R₂ = 0.5 mm



M 6290 100 t/m

A = 8 mm, B = 14 mm

R₁ = 1.5 mm, R₂ = 0.8 mm



M 6390 100 t/m

A = 10 mm, B = 16 mm

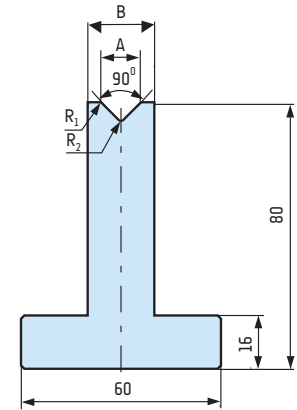
R₁ = 2 mm, R₂ = 1 mm



M 6490 100 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1.5 mm



dies with base H = 120 mm | matryce z podstawą H = 120 mm



M 9130 30 t/m

A = 8 mm, B = 18 mm

R₁ = 1 mm, R₂ = 1 mm



M 9230 35 t/m

A = 10 mm, B = 24 mm

R₁ = 1 mm, R₂ = 1 mm



M 9330 35 t/m

A = 12 mm, B = 24 mm

R₁ = 1 mm, R₂ = 1 mm



M 9430 45 t/m

A = 16 mm, B = 30 mm

R₁ = 2 mm, R₂ = 2 mm



M 9530 30 t/m

A = 6 mm, B = 14 mm

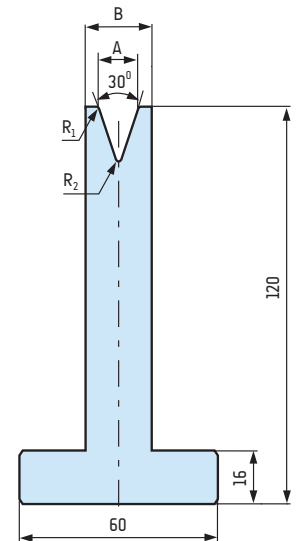
R₁ = 0.8 mm, R₂ = 0.8 mm



M 9630 50 t/m

A = 20 mm, B = 35 mm

R₁ = 4 mm, R₂ = 4 mm



M 9135 35 t/m

A = 8 mm, B = 18 mm

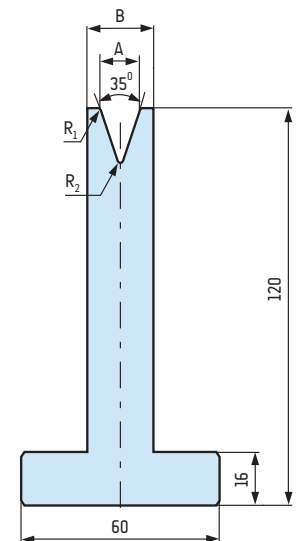
R₁ = 1.5 mm, R₂ = 0.8 mm



M 9235 40 t/m

A = 12 mm, B = 18 mm

R₁ = 2 mm, R₂ = 1 mm



TYPE "A" DIES | MATRYCE TYPU „A“

dies with base H = 120 mm | matryce z podstawą H = 120 mm



M 9145 50 t/m

A = 10 mm, B = 18 mm

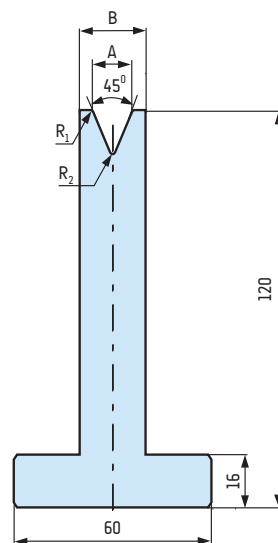
R₁ = 2 mm, R₂ = 1 mm



M 9245 50 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 9160 60 t/m

A = 8 mm, B = 14 mm

R₁ = 1.5 mm, R₂ = 0.8 mm



M 9260 60 t/m

A = 10 mm, B = 18 mm

R₁ = 2 mm, R₂ = 1 mm



M 9360 60 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 9460 60 t/m

A = 16 mm, B = 24 mm

R₁ = 1.5 mm, R₂ = 1.5 mm



M 9560 60 t/m

A = 20 mm, B = 30 mm

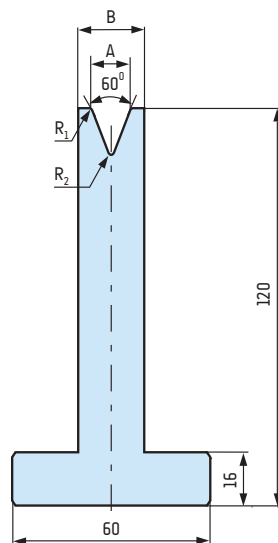
R₁ = 2 mm, R₂ = 2 mm



M 9660 60 t/m

A = 25 mm, B = 40 mm

R₁ = 3 mm, R₂ = 3 mm



M 9085 100 t/m

A = 8 mm, B = 14 mm

R₁ = 1 mm, R₂ = 0.5 mm

M 9185 100 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm

M 9285 100 t/m

A = 16 mm, B = 24 mm

R₁ = 2.5 mm, R₂ = 1 mm

M 9385 100 t/m

A = 20 mm, B = 30 mm

R₁ = 3 mm, R₂ = 1.5 mm

M 9485 100 t/m

A = 25 mm, B = 40 mm

R₁ = 3 mm, R₂ = 3 mm

M 9585 100 t/m

A = 10 mm, B = 18 mm

R₁ = 1 mm, R₂ = 1 mm

M 9685 100 t/m

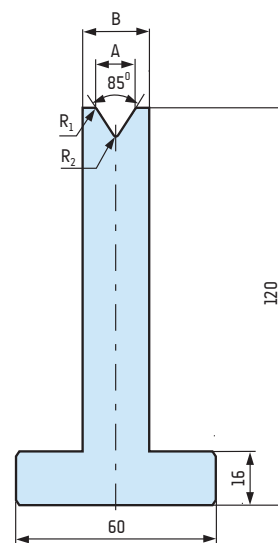
A = 14 mm, B = 18 mm

R₁ = 2.6 mm, R₂ = 0.4 mm

M 9785 100 t/m

A = 6 mm, B = 14 mm

R₁ = 0.5 mm, R₂ = 0.5 mm



TYPE "A" DIES | MATRYCE TYPU „A”

dies with base H = 120 mm | matryce z podstawą H = 120 mm



M 9088 100 t/m

A = 8 mm, B = 14 mm

R₁ = 1 mm, R₂ = 0.5 mm



M 9188 100 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 9288 100 t/m

A = 16 mm, B = 24 mm

R₁ = 2.5 mm, R₂ = 1 mm



M 9388 100 t/m

A = 20 mm, B = 30 mm

R₁ = 3 mm, R₂ = 1.5 mm



M 9488 100 t/m

A = 25 mm, B = 40 mm

R₁ = 3 mm, R₂ = 3 mm



M 9588 100 t/m

A = 10 mm, B = 18 mm

R₁ = 1 mm, R₂ = 1 mm



M 9688 100 t/m

A = 14 mm, B = 18 mm

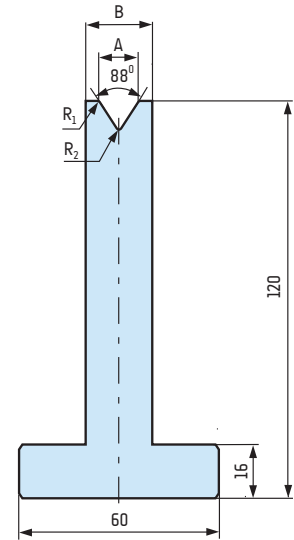
R₁ = 2.6 mm, R₂ = 0.4 mm



M 9788 100 t/m

A = 6 mm, B = 14 mm

R₁ = 0.5 mm, R₂ = 0.5 mm



M 9190 100 t/m

A = 6 mm, B = 14 mm

R₁ = 1.5 mm, R₂ = 0.5 mm

M 9290 100 t/m

A = 8 mm, B = 14 mm

R₁ = 1.5 mm, R₂ = 0.8 mm

M 9390 100 t/m

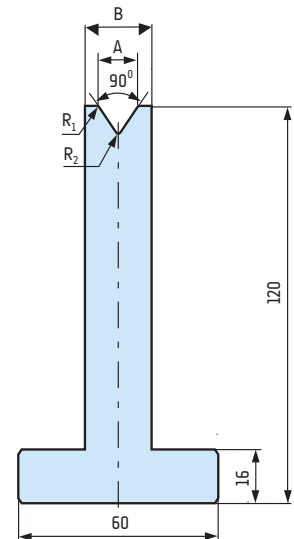
A = 10 mm, B = 18 mm

R₁ = 2 mm, R₂ = 1 mm

M 9490 100 t/m

A = 12 mm, B = 18 mm

R₁ = 3 mm, R₂ = 0.8 mm



TYPE "A" DIES | MATRYCE TYPU „A“

Dies fixed using die supports A 31 or A 61 -> p. 62
 Matryce montowane przy pomocy podpór A 31 lub A 61 -> str 62

insert dies | matryce wkładkowe

 42CrMo4

M 8130 35 t/m

$\alpha = 30^\circ$

A = 6 mm, B = 16 mm

 42CrMo4

M 8230 35 t/m

$\alpha = 30^\circ$

A = 8 mm, B = 19 mm

 42CrMo4

M 8330 50 t/m

$\alpha = 30^\circ$

A = 10 mm, B = 24 mm

 42CrMo4

M 8430 40 t/m

$\alpha = 30^\circ$

A = 12 mm, B = 25 mm

 42CrMo4

M 8160 60 t/m

$\alpha = 60^\circ$

A = 6 mm, B = 14 mm

 42CrMo4

M 8260 60 t/m

$\alpha = 60^\circ$

A = 8 mm, B = 15 mm

 42CrMo4

M 8360 60 t/m

$\alpha = 60^\circ$

A = 10 mm, B = 18 mm

 42CrMo4

M 8460 60 t/m

$\alpha = 60^\circ$

A = 12 mm, B = 18 mm

 42CrMo4

M 8560 60 t/m

$\alpha = 60^\circ$

A = 16 mm, B = 24 mm

 42CrMo4

M 8660 60 t/m

$\alpha = 60^\circ$

A = 20 mm, B = 30 mm

 42CrMo4

M 8760 60 t/m

$\alpha = 60^\circ$

A = 25 mm, B = 33 mm

 42CrMo4

M 8188 100 t/m

$\alpha = 88^\circ$

A = 6 mm, B = 14 mm

 42CrMo4

M 8288 100 t/m

$\alpha = 88^\circ$

A = 8 mm, B = 14 mm

 42CrMo4

M 8388 100 t/m

$\alpha = 88^\circ$

A = 10 mm, B = 15 mm

 42CrMo4

M 8488 100 t/m

$\alpha = 88^\circ$

A = 12 mm, B = 17 mm

 42CrMo4

M 8588 100 t/m

$\alpha = 88^\circ$

A = 14 mm, B = 18 mm

 42CrMo4

M 8688 100 t/m

$\alpha = 88^\circ$

A = 16 mm, B = 21 mm

 42CrMo4

M 8788 100 t/m

$\alpha = 88^\circ$

A = 18 mm, B = 23 mm

 42CrMo4

M 8888 100 t/m

$\alpha = 88^\circ$

A = 20 mm, B = 25 mm

 42CrMo4

M 8988 100 t/m

$\alpha = 88^\circ$

A = 25 mm, B = 30 mm

 42CrMo4

M 8190 100 t/m

$\alpha = 90^\circ$

A = 6 mm, B = 14 mm

 42CrMo4

M 8290 100 t/m

$\alpha = 90^\circ$

A = 8 mm, B = 14 mm

 42CrMo4

M 8390 100 t/m

$\alpha = 90^\circ$

A = 10 mm, B = 15 mm

 42CrMo4

M 8490 100 t/m

$\alpha = 90^\circ$

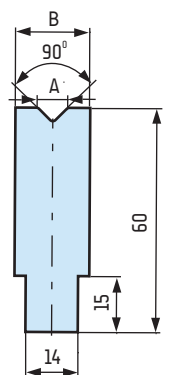
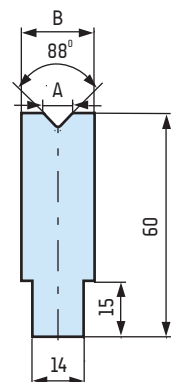
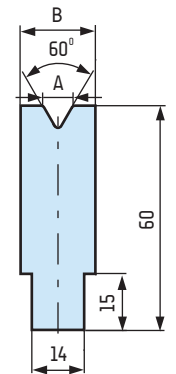
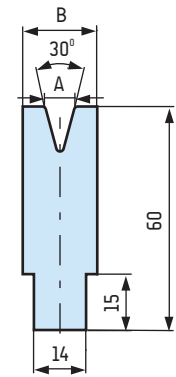
A = 12 mm, B = 17 mm

 42CrMo4

M 8590 100 t/m

$\alpha = 90^\circ$

A = 14 mm, B = 18 mm



TYPE "A" DIES | MATRYCE TYPU „A”

Bending and folding die, upper part moves on springs.
 Matryce dwufunkcyjne do gięcia i zagniatania.
 Górna część porusza się na sprężynach.

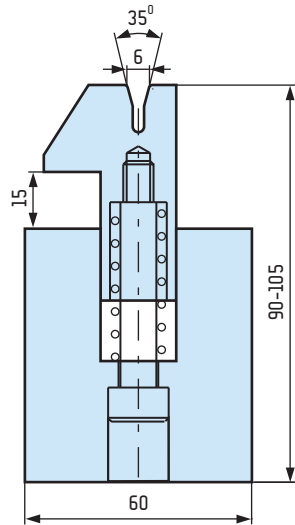
flattening dies | matryce do zagniatania



M 3033/6 60 t/m

$\alpha = 35^\circ$

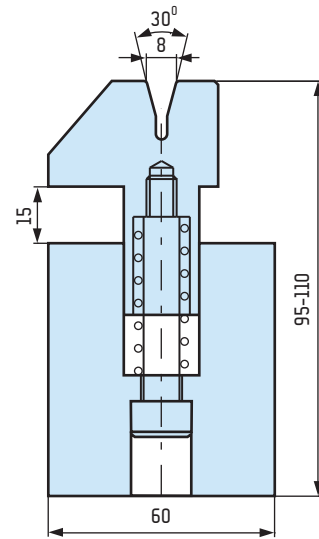
$V = 6 \text{ mm}$



M 3033/8 80 t/m

$\alpha = 30^\circ$

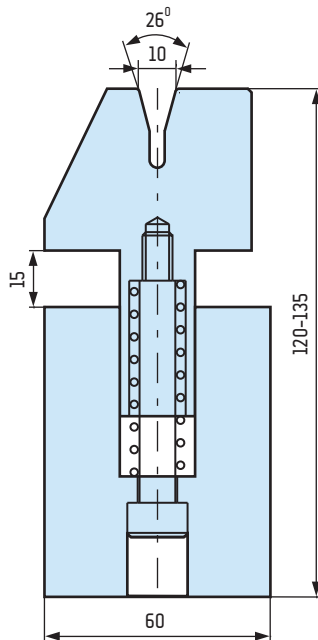
$V = 8 \text{ mm}$



M 3033/10 100 t/m

$\alpha = 26^\circ$

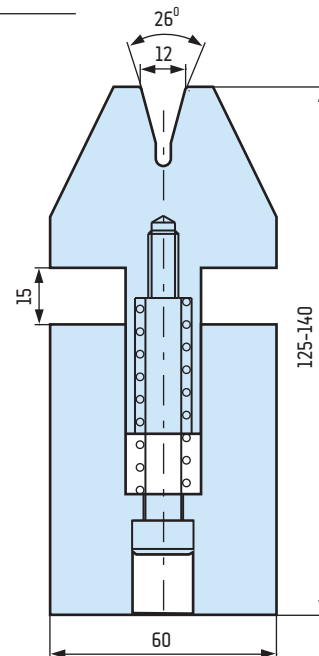
$V = 10 \text{ mm}$



M 3033/12 100 t/m

$\alpha = 26^\circ$

$V = 12 \text{ mm}$



TYPE "A" DIES | MATRYCE TYPU „A“

dies with plastic inserts | matryce z wkładkami plastikowymi



INSERT W 24 | WKŁADKA W 24 20 t/m

$B = 14 \text{ mm}$, $H = 15 \text{ mm}$, $A = 24 \text{ mm}$

$\alpha = 35^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm}$

$\alpha = 45^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm}$

$\alpha = 60^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm}$

$\alpha = 88^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm}$



INSERT W 35 | WKŁADKA W 35 20 t/m

$B = 20 \text{ mm}$, $H = 19 \text{ mm}$, $A = 35 \text{ mm}$

$\alpha = 35^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm}$

$\alpha = 45^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm}$

$\alpha = 60^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm} / 20 \text{ mm}$

$\alpha = 88^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm} / 20 \text{ mm} / 25 \text{ mm}$



INSERT W 35 | WKŁADKA W 38 20 t/m

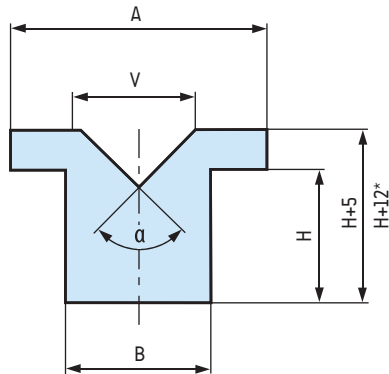
$B = 30 \text{ mm}$, $H = 19 \text{ mm}$, $A = 38 \text{ mm}$

$\alpha = 30^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm}$

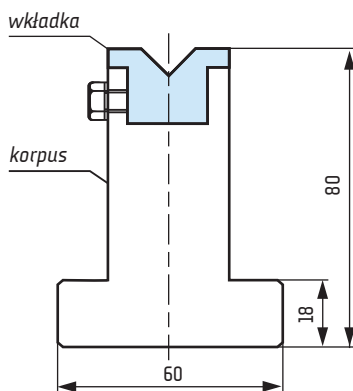
$\alpha = 60^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm} / 20 \text{ mm}$

$\alpha = 88^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm} / 20 \text{ mm} / 25 \text{ mm}$

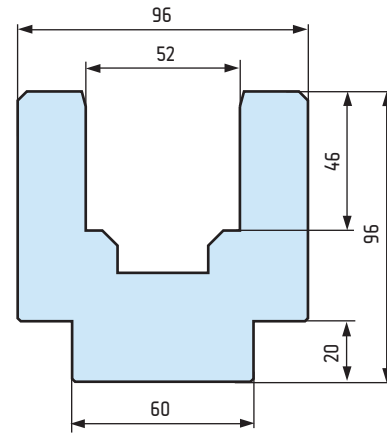
* for W 38 / dla W 38



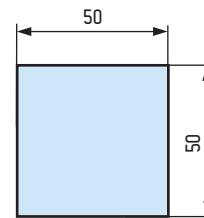
BODY | KORPUS W 24 / W 35 / W 38



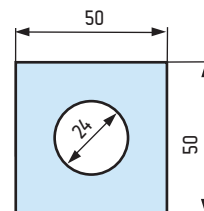
BODY W 50 | KORPUS W 50



INSERT 50 FULL | WKŁADKA 50 PEŁNA



INSERT 50 WITH HOLE | WKŁADKA 50 Z OTWOREM



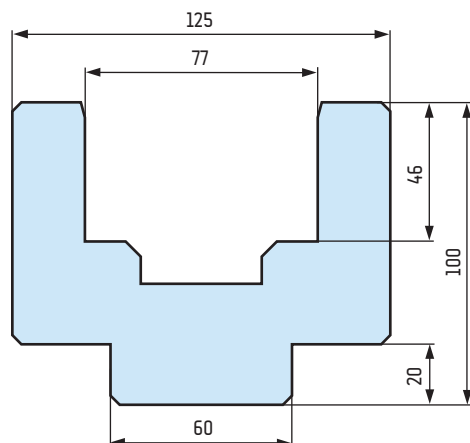
Polyamid inserts allow to minimize bending marks on coated or stainless steel.

Wkładki poliamidowe pozwalają zminimalizować ślady przy gięciu cienkich blach pokrywanych lub nierdzewnych.

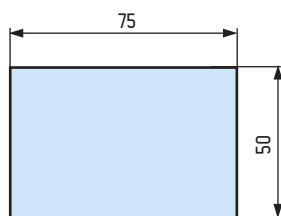
TYPE "A" DIES | MATRYCE TYPU „A“



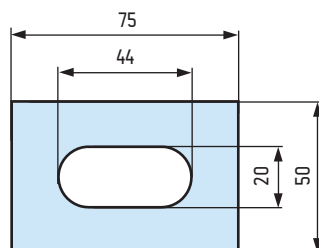
BODY W 75 | KORPUS W 75



INSERT 75 FULL | WKŁADKA 75 PEŁNA



INSERT 75 WITH HOLE | WKŁADKA 75 Z OTWOREM

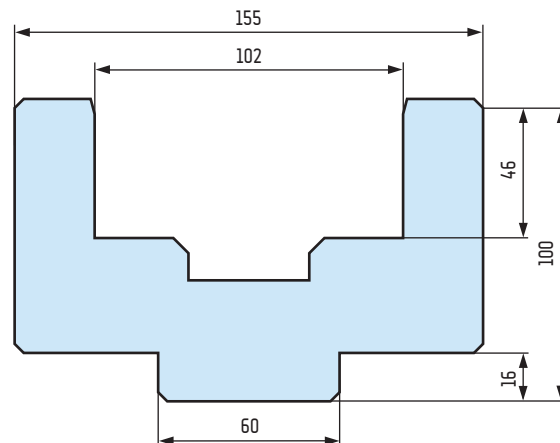


Rubber inserts allow mark free bending. Especially good with type "R" punches.

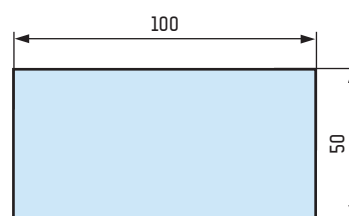
Wkładki gumowe pozwalają na gięcie bez uszkodzeń blachy. Szczególnie polecane ze stemplami „R”.



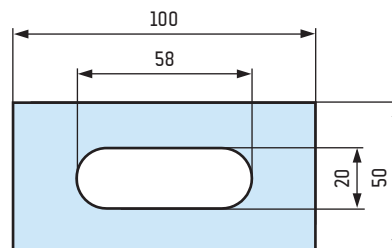
BODY W 100 | KORPUS W 100



INSERT 100 FULL | WKŁADKA 100 PEŁNA

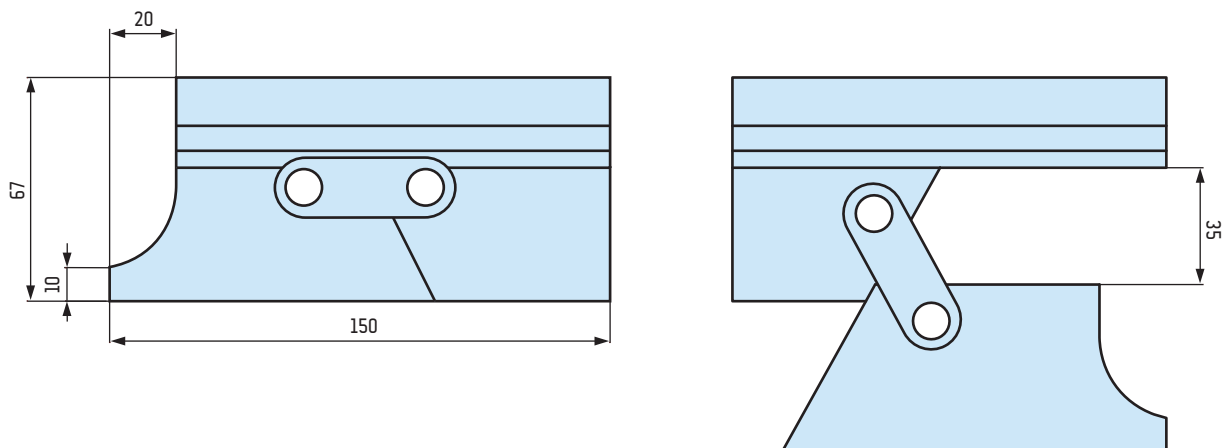


INSERT 100 WITH HOLE | WKŁADKA 100 Z OTWOREM

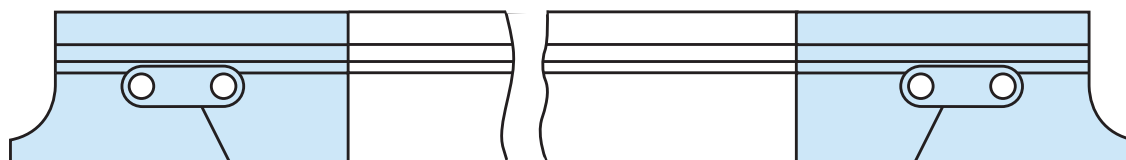


BOX – CLOSING PUNCH | STEMPEL DO ZAMYKANIA PUDEŁEK

Punch with dimensions as S2010/88/R0.8 used for closing boxes.
Stempel o geometrii jak S2010/88/R0.8 służący do zamykania pudełek.



Assembly with S2010.
Złożenie z S2010.



PROTECTIVE TAPE | TAŚMA OCHRONNA



Tape size

thickness = 0.4 mm, width = 100 mm

thickness = 0.5 mm, width = 100 mm, 105 mm

thickness = 0.8 mm, width = 95 mm, 100 mm

Wymiary taśmy

grubość = 0.4 mm, szerokość = 100mm

grubość = 0.5 mm, szerokość = 100mm, 105 mm

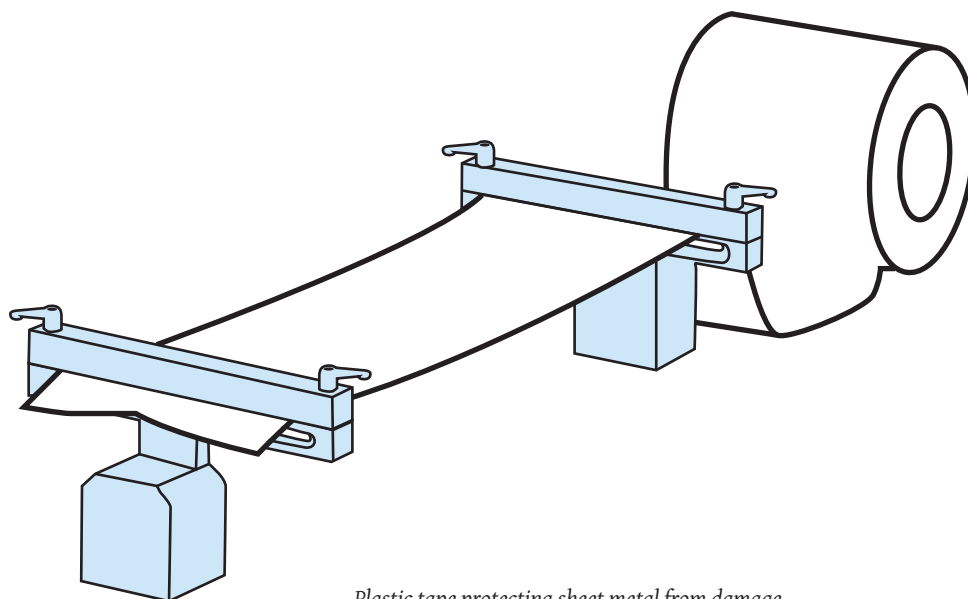
grubość = 0.8 mm, szerokość = 95 mm, 100 mm

Holder for protective tape

suitable for dies size 13 mm to 60 mm

Uchwyt do folii ochronnej

mocowanie do matryc od 13 do 60 mm



Plastic tape protecting sheet metal from damage.
Plastikowa taśma zabezpieczająca gięty materiał przed zarysowaniem.

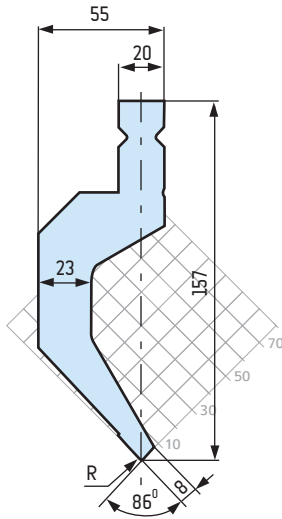
TYPE "T" PUNCHES | STEMPLE TYPU „T”

24h 42CrMo4

S 2200 80 t/m

$\alpha = 86^\circ$

R = 1 mm

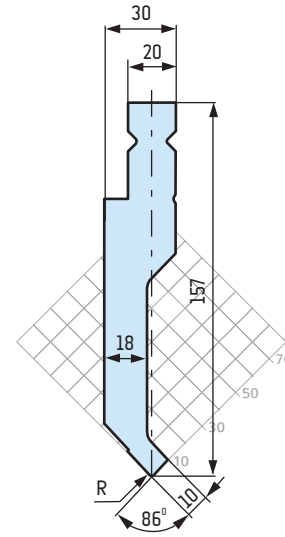


24h 42CrMo4

S 2201 80 t/m

$\alpha = 86^\circ$

R = 1 mm

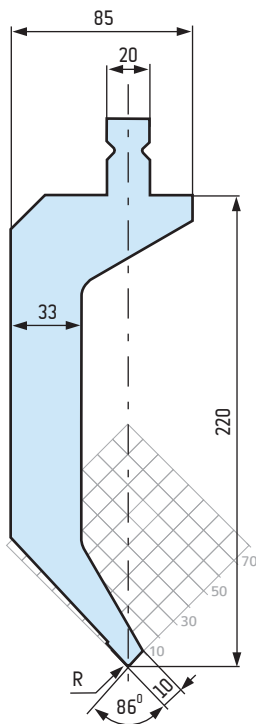


24h 42CrMo4

S 2200 W 80 t/m

$\alpha = 86^\circ$

R = 1 mm

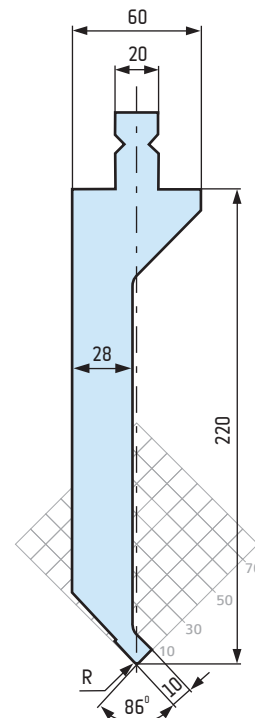


24h 42CrMo4

S 2201 W 80 t/m

$\alpha = 86^\circ$

R = 1 mm



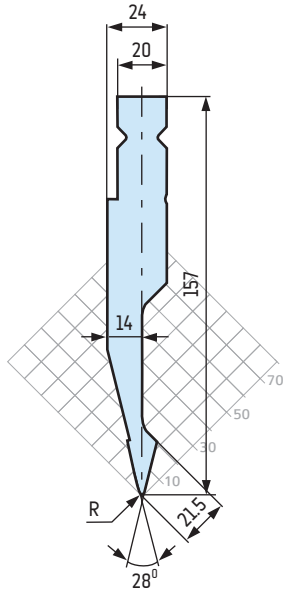
TYPE "T" PUNCHES | STEMPE TYPU „T“

24h 42CrMo4

S 2202 60 t/m

$\alpha = 28^\circ$

$R = 1 \text{ mm}$

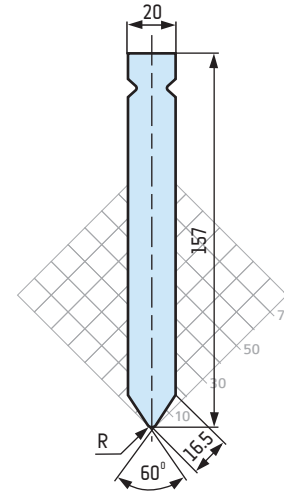


24h 42CrMo4

S 2203 130 t/m

$\alpha = 60^\circ$

$R = 4 \text{ mm}$

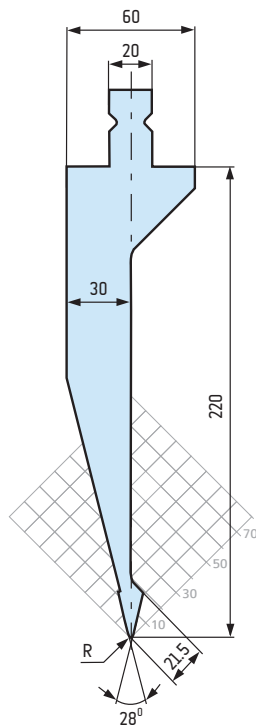


24h 42CrMo4

S 2202 W 60 t/m

$\alpha = 28^\circ$

$R = 1 \text{ mm}$

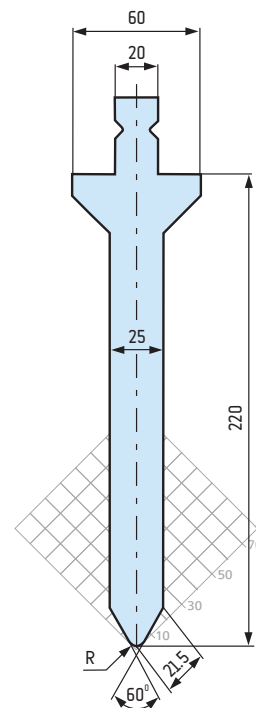


24h 42CrMo4

S 2203 W 130 t/m

$\alpha = 60^\circ$

$R = 4 \text{ mm}$



TYPE "T" PUNCHES | STEMPEL TYPU „T“

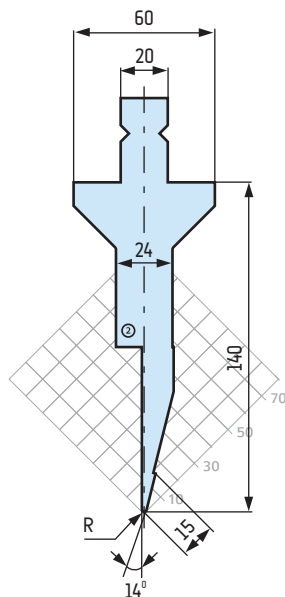
24h 42CrMo4

S 2204 40 t/m

⊙ 130 t/m

$\alpha = 14^\circ$

$R = 1 \text{ mm}$



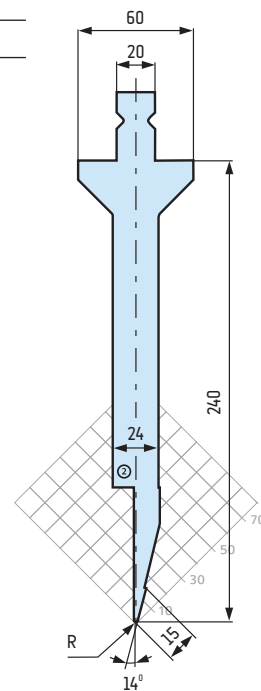
24h 42CrMo4

S 2204 W 40 t/m

⊙ 130 t/m

$\alpha = 14^\circ$

$R = 1 \text{ mm}$

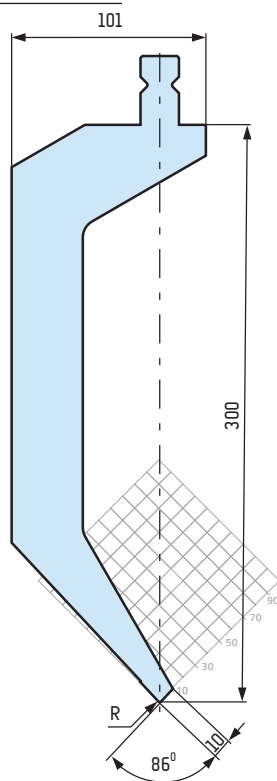


42CrMo4

S 2300 W 80 t/m

$\alpha = 86^\circ$

$R = 1 \text{ mm}$

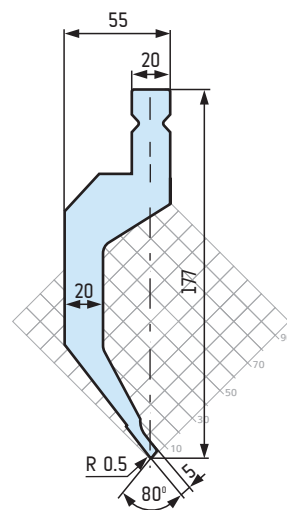


42CrMo4

S 2280 20 t/m

$\alpha = 80^\circ$

$R = 0.5 \text{ mm}$

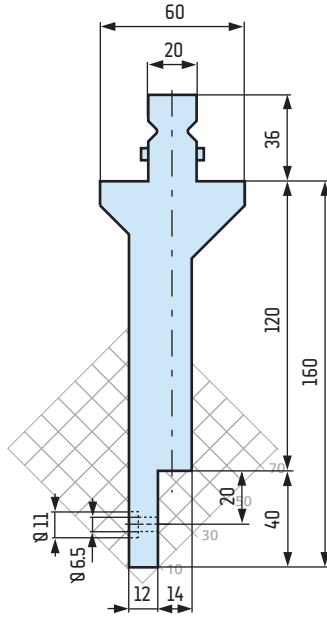


TYPE "T" PUNCHES | STEMPLE TYPU „T”

insert punch | stempel z wkładką

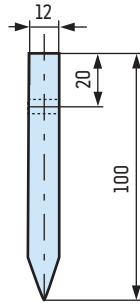
24h 42CrMo4

S 2206 100 t/m



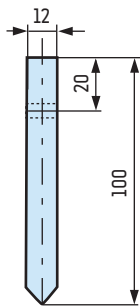
WKŁADKA R 0.3 – R 6

$\alpha = 28^\circ$



WKŁADKA R 0.2 – R 1.5

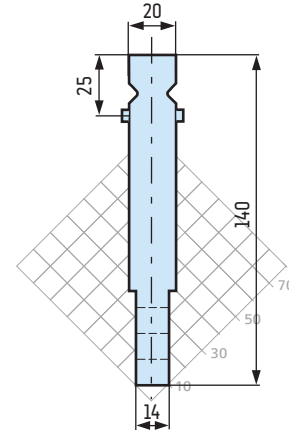
$\alpha = 84^\circ, 86^\circ, 90^\circ$



radius punch | stempel promieniowy

24h 42CrMo4

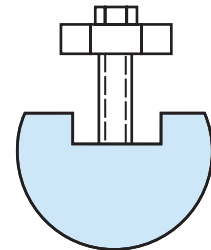
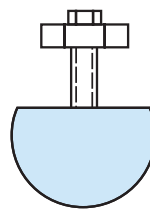
S 2207 80 t/m



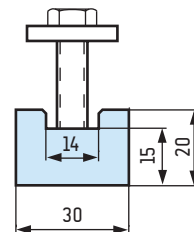
WKŁADKA R 7 – R 12



WKŁADKA R 12.5 – R 50

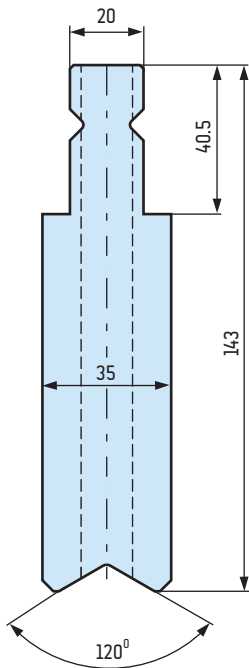


FLATTENING INSERT | WKŁADKA PŁASKA



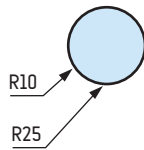
24h 42CrMo4

S 2208 R 10 – R 25 100 t/m



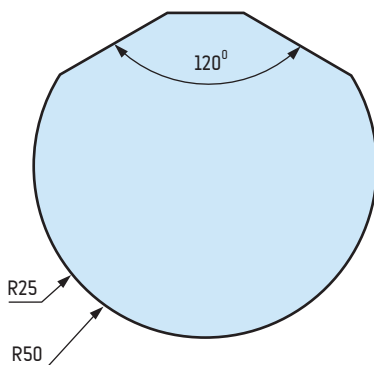
R 10 – R 25

* for punch / dla stempli S 2208 W



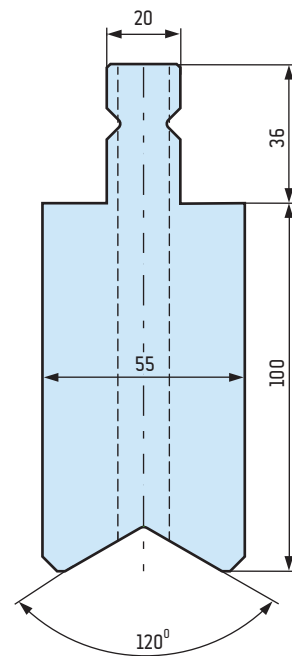
R 25 – R 50

* for punch / dla stempli S 2208 W



24h 42CrMo4

S 2208 W R 25 – R 50 100 t/m



flattening tools | zestaw do zagniatania

42CrMo4

S 2205 70 t/m

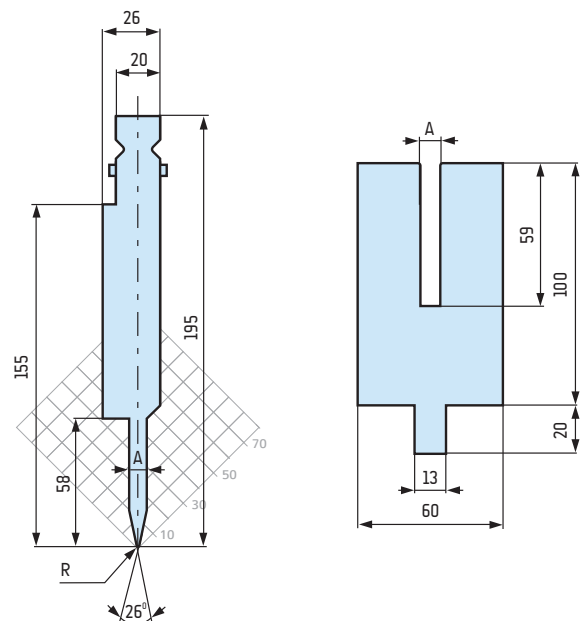
A = 8 mm, 10 mm, 12 mm

R = 0.6 mm

42CrMo4

M 2000 70 t/m

A = 8 mm, 10 mm, 12 mm



TYPE "T" DIES 100 MM | MATRYCE TYPU „T” 100 MM

24h 42CrMo4

M 7106 100 t/m
A = 6 mm, B = 20 mm

24h 42CrMo4

M 7108 100 t/m
A = 8 mm, B = 20 mm

24h 42CrMo4

M 7110 100 t/m
A = 10 mm, B = 20 mm

24h 42CrMo4

M 7112 100 t/m
A = 12 mm, B = 25 mm

24h 42CrMo4

M 7116 100 t/m
A = 16 mm, B = 30 mm

24h 42CrMo4

M 7120 100 t/m
A = 20 mm, B = 30 mm

24h 42CrMo4

M 7124 100 t/m
A = 24 mm, B = 35 mm

24h 42CrMo4

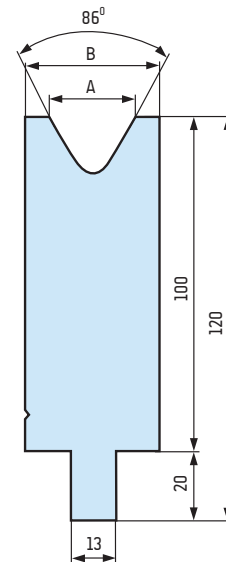
M 7130 100 t/m
A = 30 mm, B = 45 mm

24h 42CrMo4

M 7140 100 t/m
A = 40 mm, B = 55 mm

24h 42CrMo4

M 7150 100 t/m
A = 50 mm, B = 75 mm



24h 42CrMo4

M 7224 100 t/m
A = 24 mm, B = 35 mm

24h 42CrMo4

M 7230 100 t/m
A = 30 mm, B = 45 mm

24h 42CrMo4

M 7240 100 t/m
A = 40 mm, B = 55 mm

24h 42CrMo4

M 7250 100 t/m
A = 50 mm, B = 65 mm

24h 42CrMo4

M 7260 100 t/m
A = 60 mm, B = 75 mm

24h 42CrMo4

M 7280 100 t/m
A = 80 mm, B = 100 mm

24h 42CrMo4

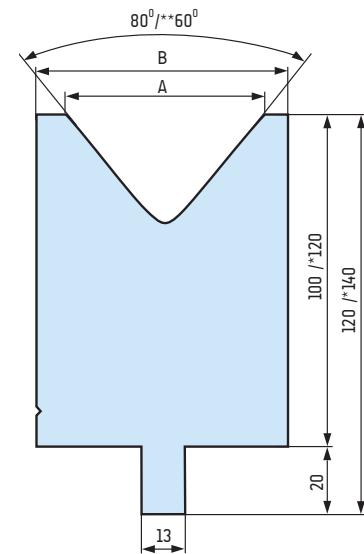
M 7290 100 t/m
A = 90 mm, B = 110 mm
H = 120 mm

24h 42CrMo4

M 72100 100 t/m*
A = 100 mm, B = 120 mm
H = 120 mm

24h 42CrMo4

M 72120 100 t/m**
A = 120 mm, B = 145 mm
H = 120 mm
 $\alpha = 60^\circ$



24h 42CrMo4

M 7306 50 t/m
A = 6 mm, B = 20 mm

24h 42CrMo4

M 7308 40 t/m
A = 8 mm, B = 20 mm

24h 42CrMo4

M 7310 40 t/m
A = 10 mm, B = 20 mm

24h 42CrMo4

M 7312 40 t/m
A = 12 mm, B = 25 mm

24h 42CrMo4

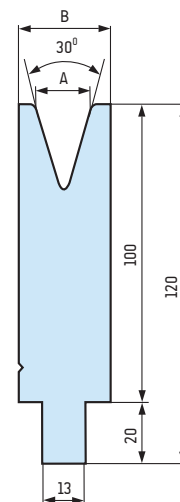
M 7316 45 t/m
A = 16 mm, B = 30 mm

24h 42CrMo4

M 7320 50 t/m
A = 20 mm, B = 35 mm

24h 42CrMo4

M 7324 50 t/m
A = 24 mm, B = 40 mm



TYPE "T" DIES 55 MM | MATRYCE TYPU „T” 55 MM

42CrMo4

M 7406 100 t/m

$\alpha = 90^\circ$

A = 6 mm, B = 15 mm

42CrMo4

M 7408 100 t/m

$\alpha = 90^\circ$

A = 8 mm, B = 15 mm

42CrMo4

M 7410 100 t/m

$\alpha = 88^\circ$

A = 10 mm, B = 20 mm

42CrMo4

M 7412 100 t/m

$\alpha = 88^\circ$

A = 12 mm, B = 20 mm

42CrMo4

M 7416 100 t/m

$\alpha = 88^\circ$

A = 16 mm, B = 30 mm

42CrMo4

M 7420 100 t/m

$\alpha = 88^\circ$

A = 20 mm, B = 30 mm

42CrMo4

M 7424 100 t/m

$\alpha = 88^\circ$

A = 24 mm, B = 40 mm

42CrMo4

M 7432 100 t/m

$\alpha = 85^\circ$

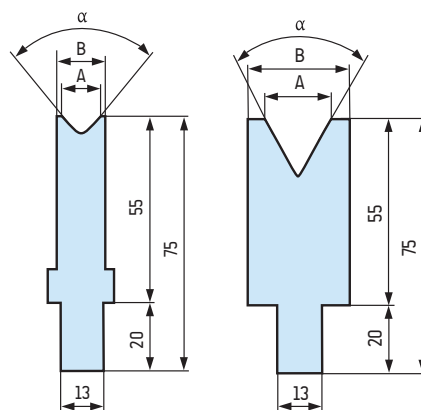
A = 32 mm, B = 50 mm

42CrMo4

M 7440 100 t/m

$\alpha = 85^\circ$

A = 40 mm, B = 55 mm



42CrMo4

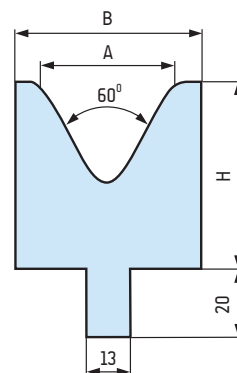
M 7540 80 t/m

A = 40 mm, B = 55 mm, H = 55 mm

42CrMo4

M 7560 60 t/m

A = 60 mm, B = 80 mm, H = 65 mm



42CrMo4

M 7606 35 t/m

A = 6 mm, B = 15 mm

42CrMo4

M 7608 35 t/m

A = 8 mm, B = 15 mm

42CrMo4

M 7610 40 t/m

A = 10 mm, B = 20 mm

42CrMo4

M 7612 40 t/m

A = 12 mm, B = 20 mm

42CrMo4

M 7616 45 t/m

A = 16 mm, B = 30 mm, H = 55 mm

42CrMo4

M 7620 50 t/m

A = 20 mm, B = 35 mm, H = 55 mm

42CrMo4

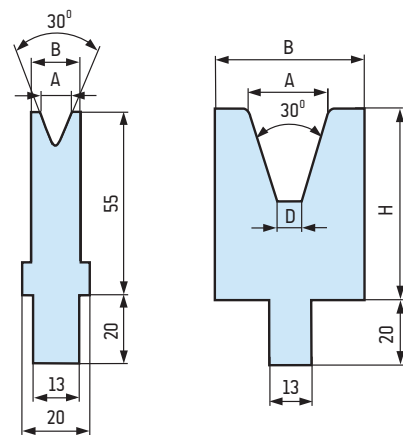
M 7624 50 t/m

A = 24 mm, B = 40 mm, H = 55 mm

42CrMo4

M 7632 50 t/m

A = 32 mm, B = 60 mm, H = 60 mm



TYPE "T" DIES | MATRYCE TYPU „T”

dies with plastic inserts |
matryce z wkładkami poliamidowymi



INSERT W 35-T | WKŁADKA W 35-T 20 t/m

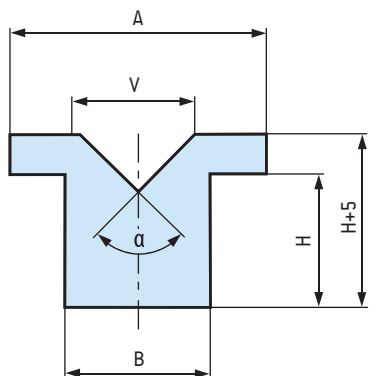
$B = 20 \text{ mm}$, $H = 19 \text{ mm}$, $A = 35 \text{ mm}$

$\alpha = 35^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm}$

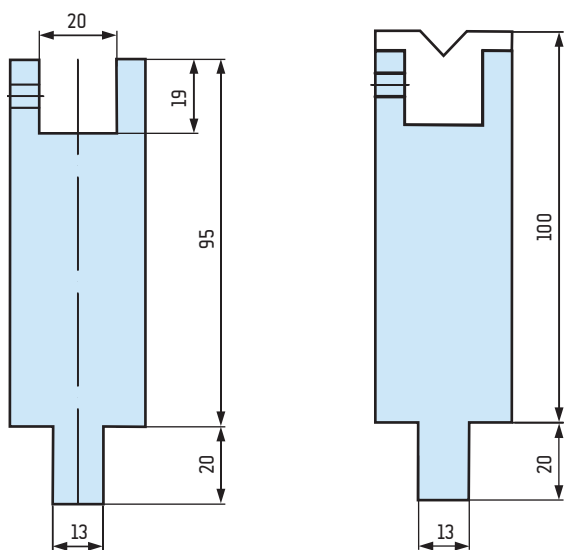
$\alpha = 45^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm}$

$\alpha = 60^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm} / 20 \text{ mm}$

$\alpha = 88^\circ$, $V = 6 \text{ mm} / 8 \text{ mm} / 10 \text{ mm} / 12 \text{ mm} / 16 \text{ mm} / 20 \text{ mm} / 25 \text{ mm}$



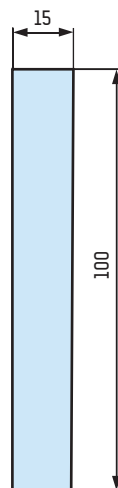
BODY | KORPUS W 35-T



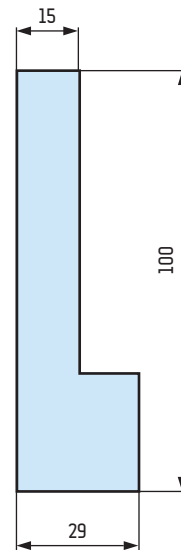
flattening inserts |
wkładki do zapłaszczania



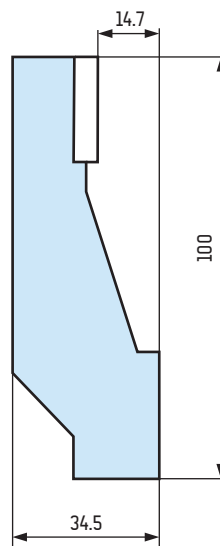
INSERT T 1 | WKŁADKA T 1



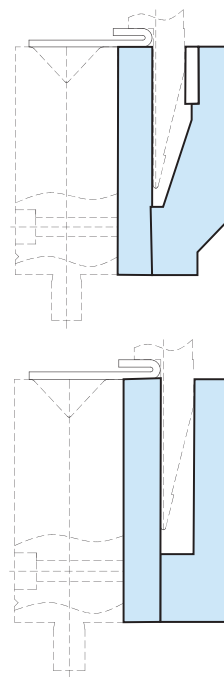
INSERT T 2 | WKŁADKA T 2



INSERT T 3 | WKŁADKA T 3



ASSAMBLE | PRZYKŁAD MONTAŻU



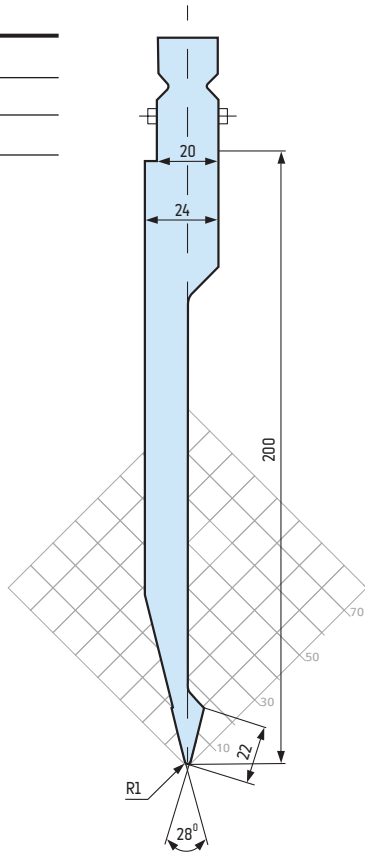
TYPE "W" PUNCHES | STEMPE TYPU „W“

24h 42CrMo4

S 2231 60 t/m

$\alpha = 28^\circ$

R = 1 mm

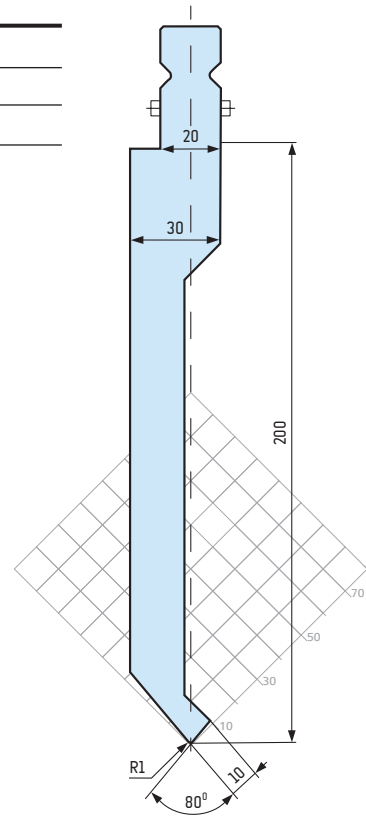


24h 42CrMo4

S 2232 70 t/m

$\alpha = 80^\circ$

R = 1 mm

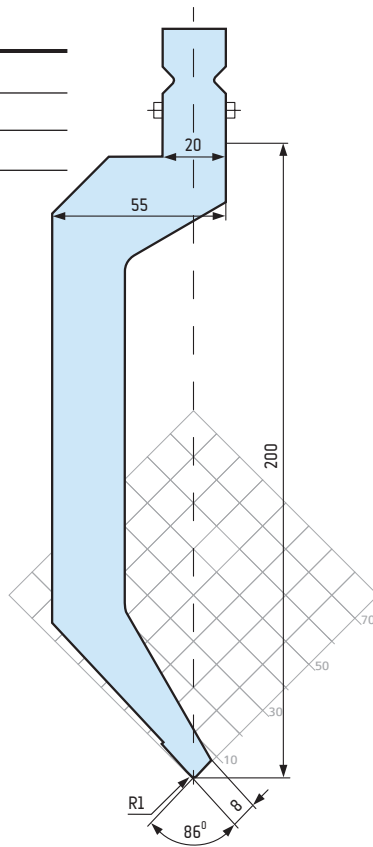


24h 42CrMo4

S 2233 50 t/m

$\alpha = 86^\circ$

R = 1 mm

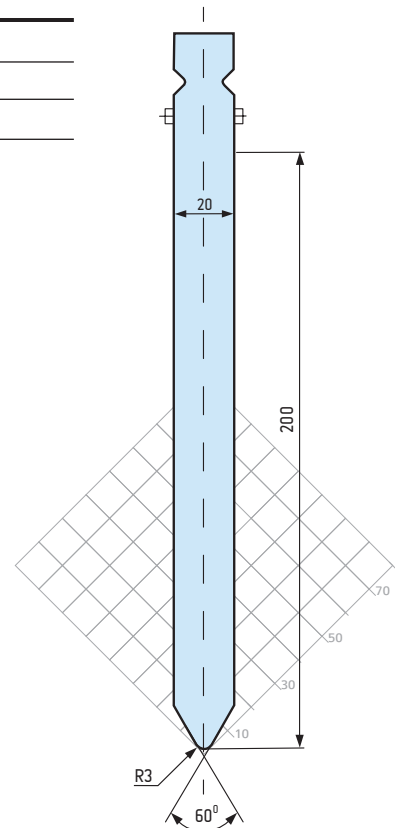


24h 42CrMo4

S 2234 160 t/m

$\alpha = 60^\circ$

R = 3 mm



TYPE "W" DIES 55 MM | MATRYCE TYPU „W” 55 MM

42CrMo4

M 7706 100 t/m

$\alpha = 86^\circ$

A = 6 mm, B = 16 mm

42CrMo4

M 7708 100 t/m

$\alpha = 86^\circ$

A = 8 mm, B = 16 mm

42CrMo4

M 7710 100 t/m

$\alpha = 86^\circ$

A = 10 mm, B = 20 mm

42CrMo4

M 7712 100 t/m

$\alpha = 86^\circ$

A = 12 mm, B = 20 mm

42CrMo4

M 7716 100 t/m

$\alpha = 86^\circ$

A = 16 mm, B = 25 mm

42CrMo4

M 7720 100 t/m

$\alpha = 86^\circ$

A = 20 mm, B = 30 mm

42CrMo4

M 7824 100 t/m

$\alpha = 80^\circ$

A = 24 mm, B = 35 mm

42CrMo4

M 7830 100 t/m

$\alpha = 80^\circ$

A = 30 mm, B = 40 mm

42CrMo4

M 7840 100 t/m

$\alpha = 80^\circ$

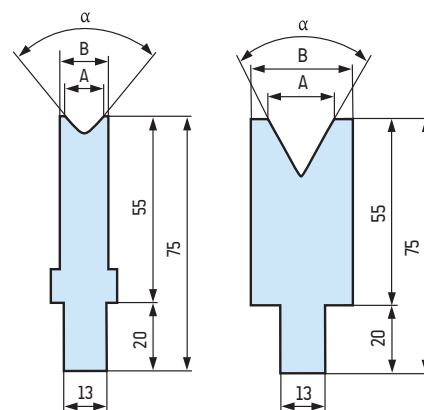
A = 40 mm, B = 50 mm

42CrMo4

M 7850 100 t/m

$\alpha = 80^\circ$

A = 50 mm, B = 75 mm



TYPE "T" DIES 55 MM | MATRYCE TYPU „T” 55 MM

42CrMo4

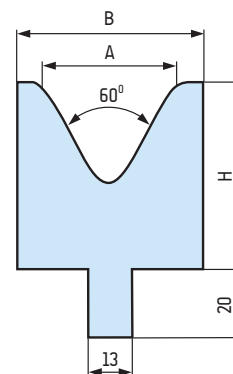
M 7540 80 t/m

A = 40 mm, B = 55 mm, H = 55 mm

42CrMo4

M 7560 60 t/m

A = 60 mm, B = 80 mm, H = 65 mm



42CrMo4

M 7606 35 t/m

A = 6 mm, B = 15 mm

42CrMo4

M 7608 35 t/m

A = 8 mm, B = 15 mm

42CrMo4

M 7610 40 t/m

A = 10 mm, B = 20 mm

42CrMo4

M 7612 40 t/m

A = 12 mm, B = 20 mm

42CrMo4

M 7616 45 t/m

A = 16 mm, B = 30 mm, H = 55 mm

42CrMo4

M 7620 50 t/m

A = 20 mm, B = 35 mm, H = 55 mm

42CrMo4

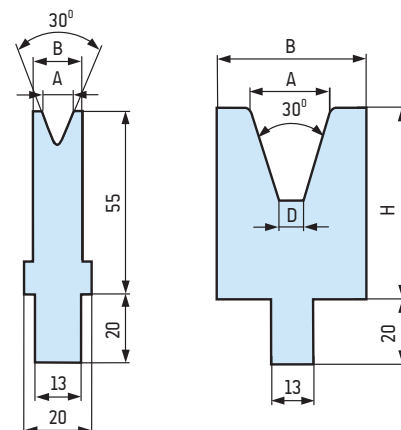
M 7624 50 t/m

A = 24 mm, B = 40 mm, H = 55 mm

42CrMo4

M 7632 50 t/m

A = 32 mm, B = 60 mm, H = 60 mm



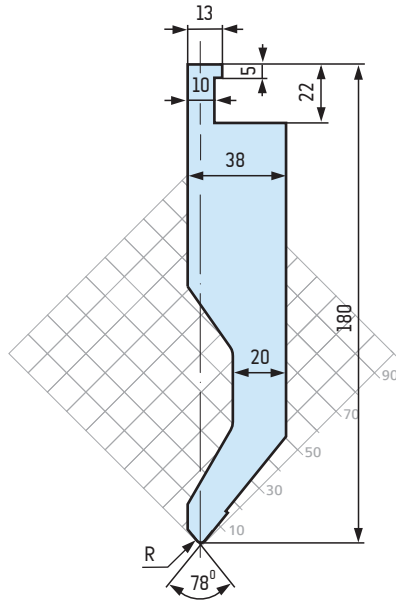
TYPE "L" PUNCHES | STEMPEL TYPU „L“

42CrMo4

S 2510 C 70 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$

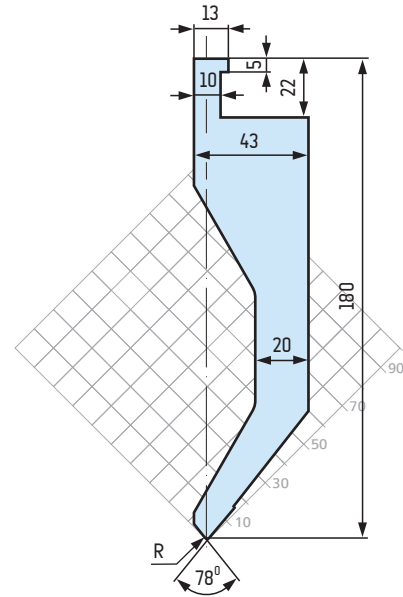


24h 42CrMo4

S 2510 D 40 t/m

$\alpha = 78^\circ$

$R = 1 \text{ mm}$

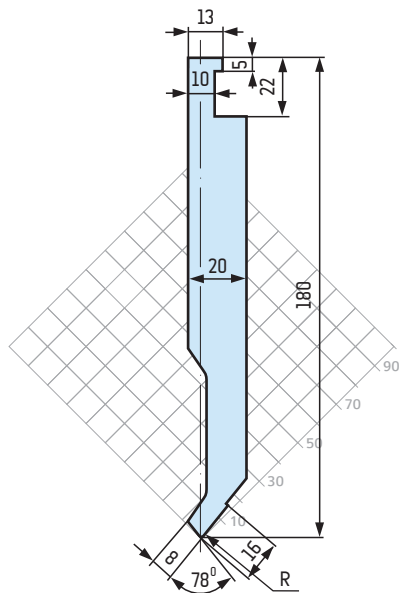


24h 42CrMo4

S 2510 E 40 t/m

$\alpha = 78^\circ$

$R = 1 \text{ mm}$

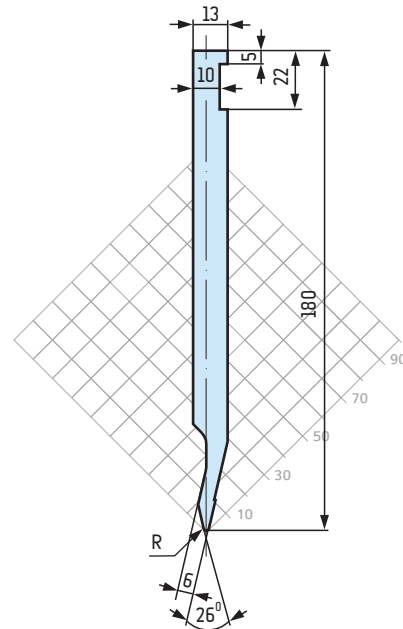


24h 42CrMo4

S 2510 F 40 t/m

$\alpha = 26^\circ$

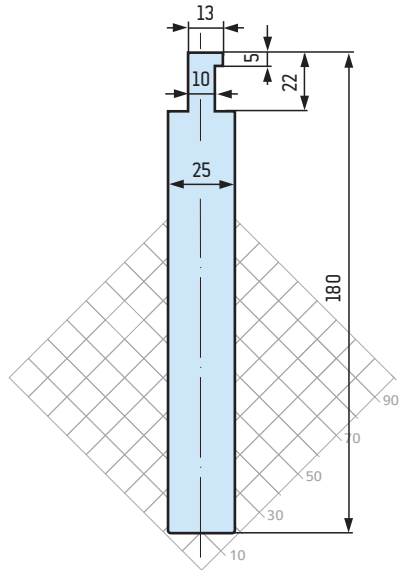
$R = 1 \text{ mm}$



TYPE "L" PUNCHES | STEMPLU TYPU „L“

42CrMo4

S 2510 H 150 t/m

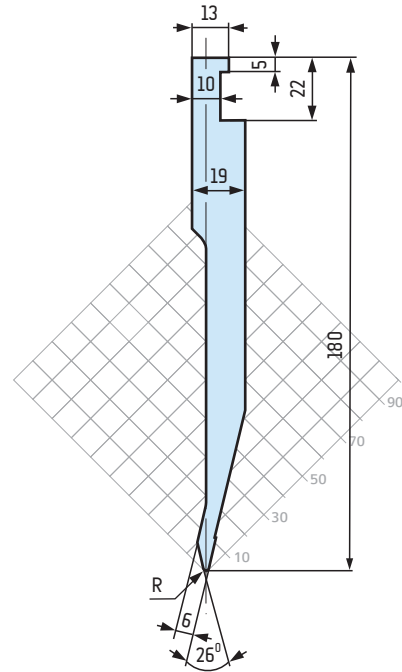


42CrMo4

S 2510 J 40 t/m

$\alpha = 26^\circ$

$R = 1 \text{ mm}$



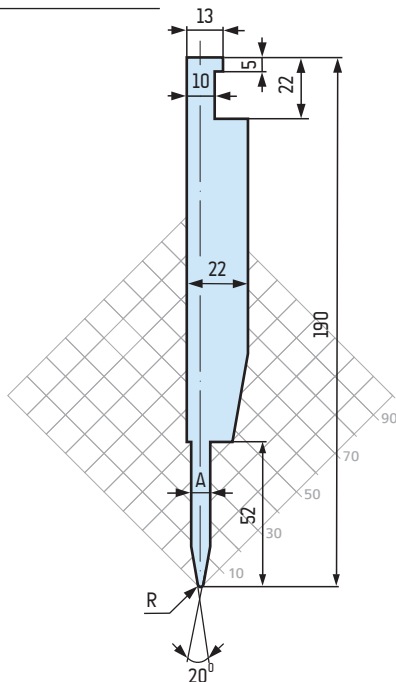
42CrMo4

S 2510 P 40 t/m

$\alpha = 20^\circ$

$R = 1 \text{ mm}$

$A = 8 \text{ mm}, 10 \text{ mm}, 12 \text{ mm}$

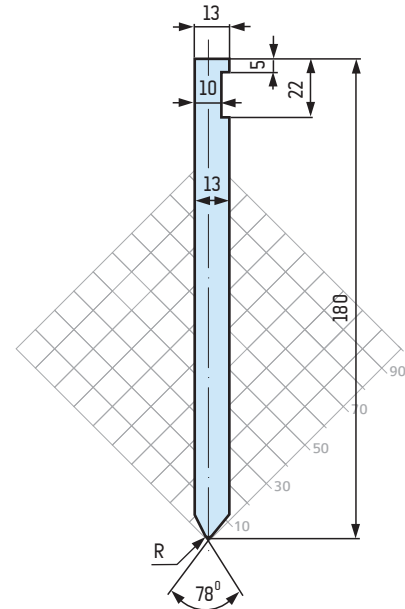


42CrMo4

S 2510 R 80 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$



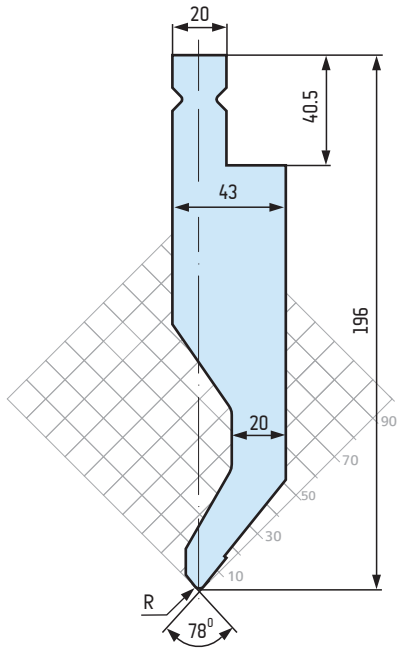
TYPE "L" PUNCHES | STEMPLU TYPU „L“

42CrMo4

S 2610 C 70 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$

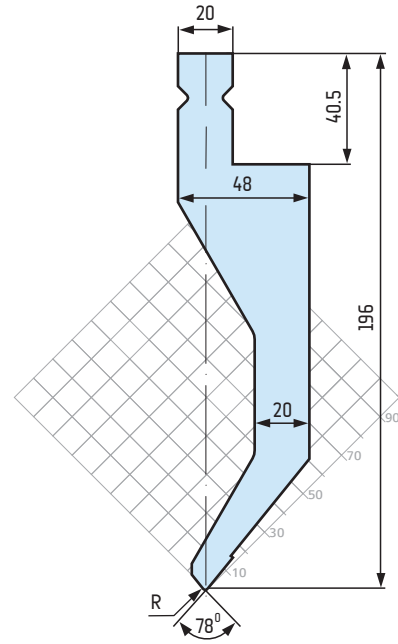


24h 42CrMo4

S 2610 D 50 t/m

$\alpha = 78^\circ$

$R = 1 \text{ mm}$

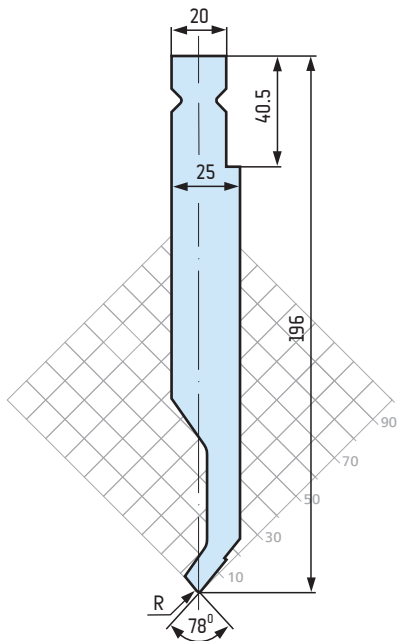


24h 42CrMo4

S 2610 E 40 t/m

$\alpha = 78^\circ$

$R = 1 \text{ mm}$

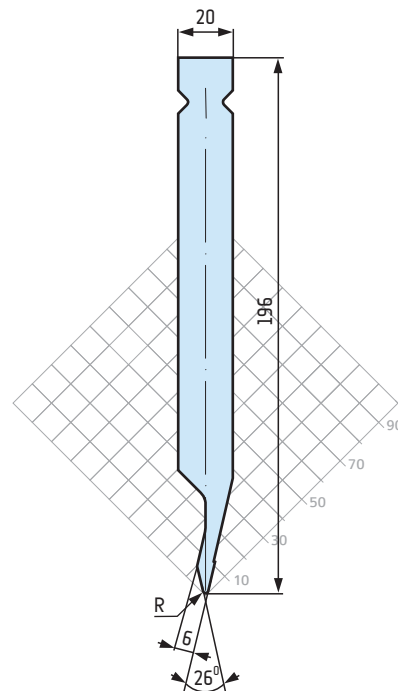


24h 42CrMo4

S 2610 F 40 t/m

$\alpha = 26^\circ$

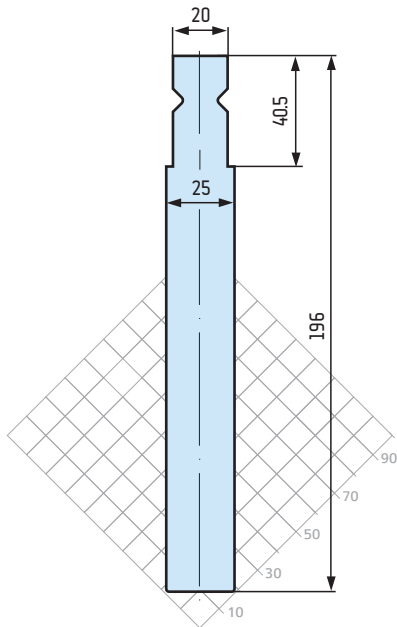
$R = 1 \text{ mm}$



TYPE "L" PUNCHES | STEMPEL TYPU „L“

42CrMo4

S 2610 H 160 t/m

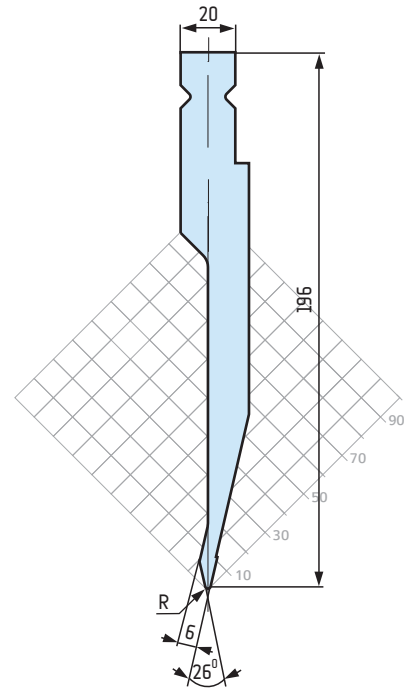


42CrMo4

S 2610 J 40 t/m

$\alpha = 26^\circ$

$R = 1 \text{ mm}$



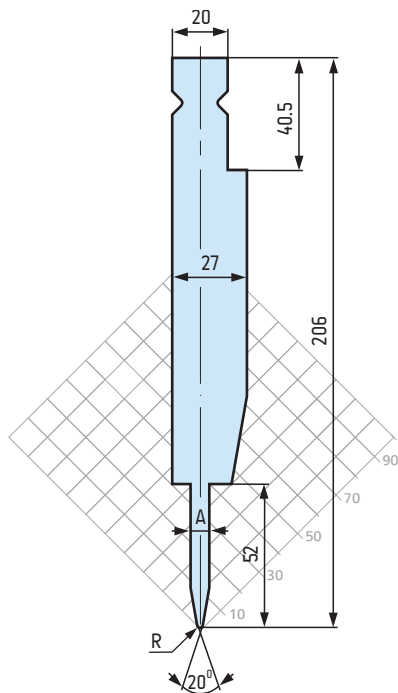
42CrMo4

S 2610 P 40 t/m

$\alpha = 20^\circ$

$R = 1 \text{ mm}$

$A = 8 \text{ mm}, 10 \text{ mm}, 12 \text{ mm}$

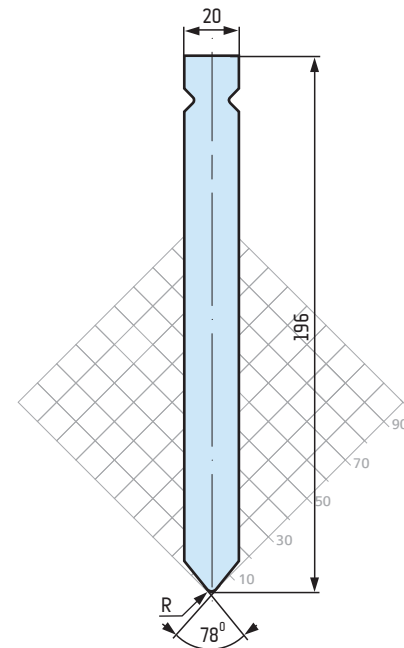


42CrMo4

S 2610 R 80 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$



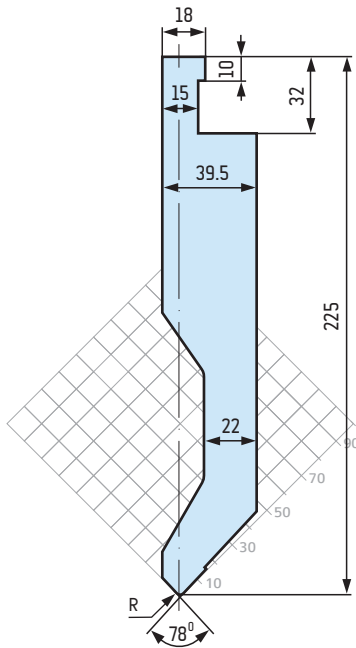
TYPE "L" PUNCHES | STEMPEL TYPU „L“

42CrMo4

S 2515 C 80 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$

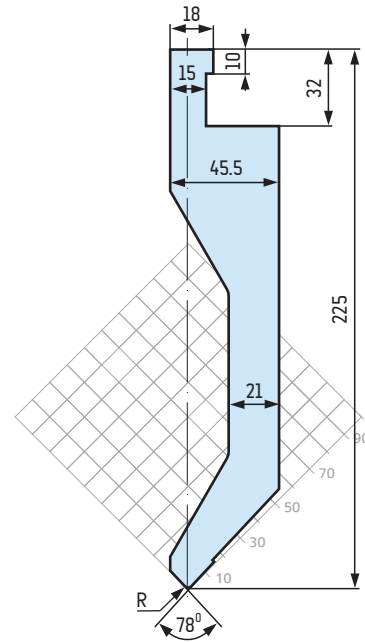


42CrMo4

S 2515 D 75 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$

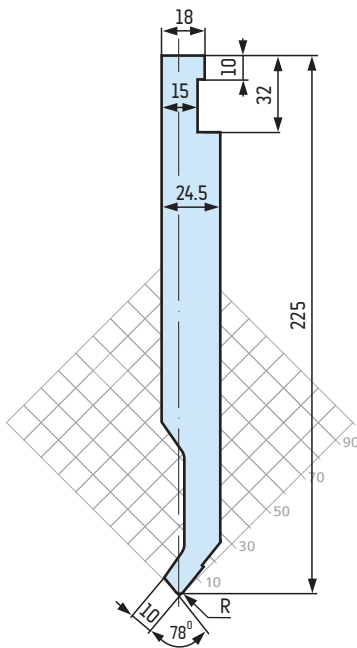


42CrMo4

S 2515 E 50 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$

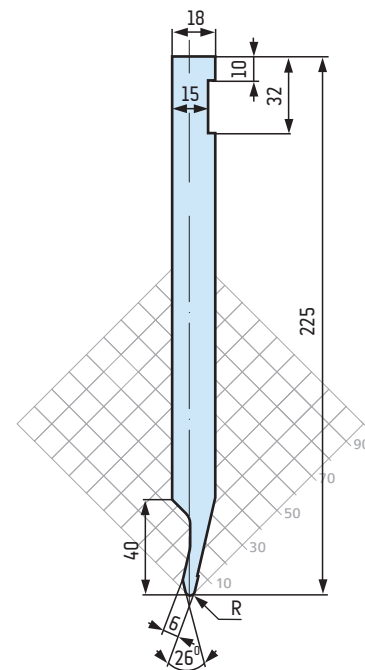


42CrMo4

S 2515 F 50 t/m

$\alpha = 26^\circ$

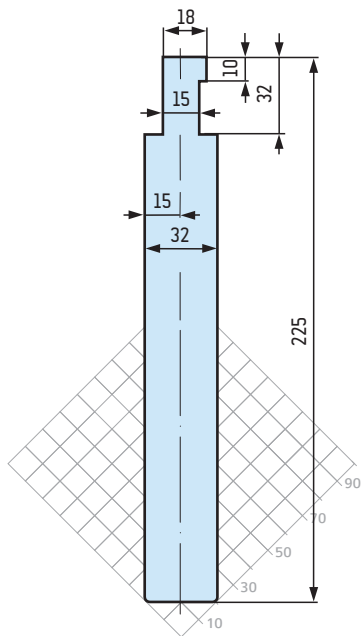
$R = 2 \text{ mm}$



TYPE "L" PUNCHES | STEMPEL TYPU „L“

42CrMo4

S 2515 H 150 t/m

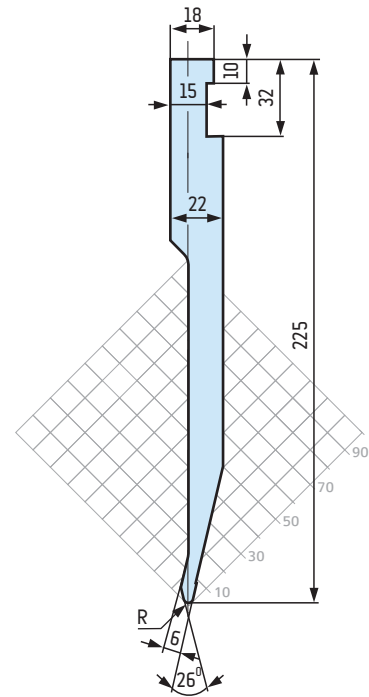


42CrMo4

S 2515 J 50 t/m

$\alpha = 26^\circ$

$R = 2 \text{ mm}$



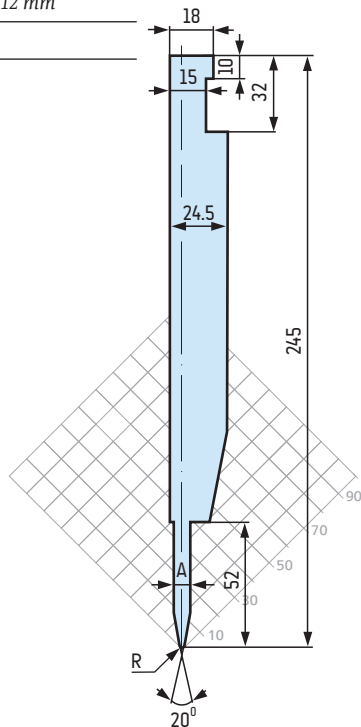
42CrMo4

S 2515 P 40 t/m

$\alpha = 20^\circ$

$A = 8 \text{ mm}, 10 \text{ mm}, 12 \text{ mm}$

$R = 1 \text{ mm}$

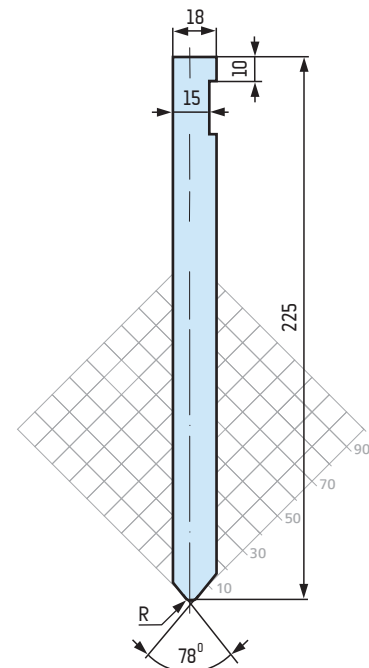


42CrMo4

S 2515 R 120 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$



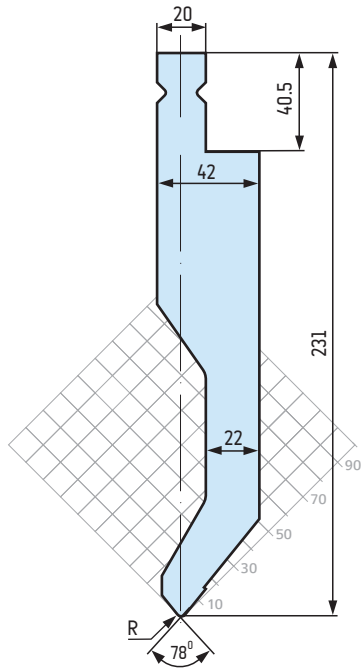
TYPE "L" PUNCHES | STEMPEL TYPU „L“

42CrMo4

S 2615 C 80 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$

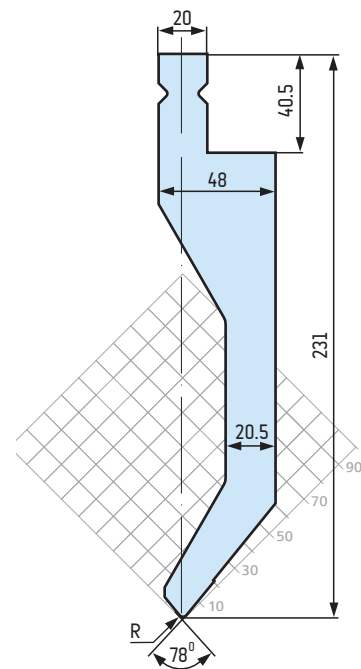


42CrMo4

S 2615 D 75 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$

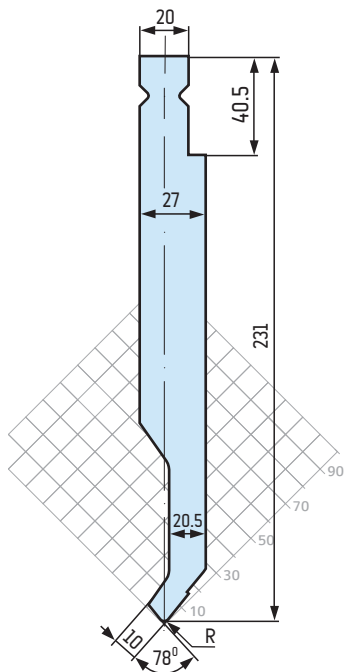


42CrMo4

S 2615 E 50 t/m

$\alpha = 78^\circ$

$R = 2 \text{ mm}$

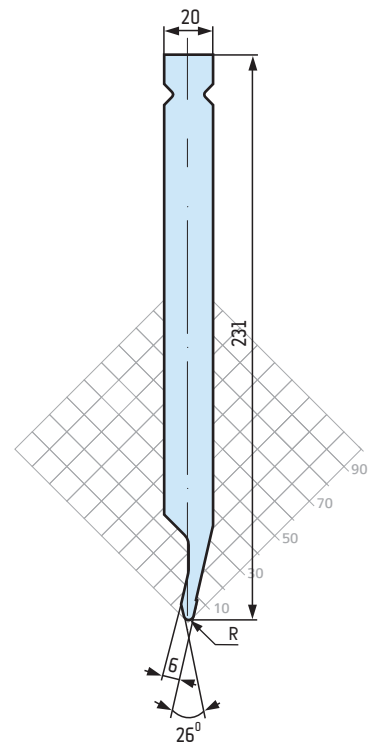


42CrMo4

S 2615 F 50 t/m

$\alpha = 26^\circ$

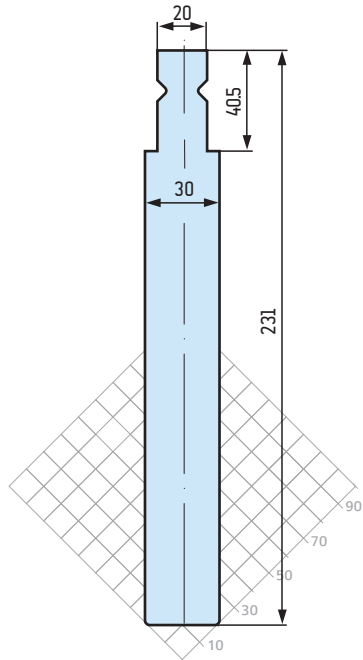
$R = 2 \text{ mm}$



TYPE "L" PUNCHES | STEMPLA TYPU „L”

42CrMo4

S 2615 H 150 t/m

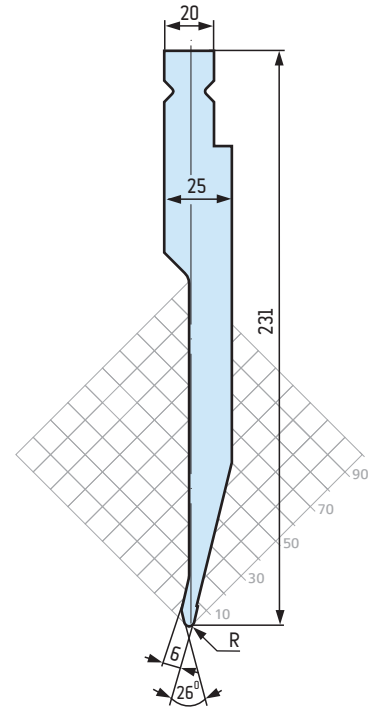


42CrMo4

S 2615 J 50 t/m

$\alpha = 26^\circ$

$R = 2 \text{ mm}$



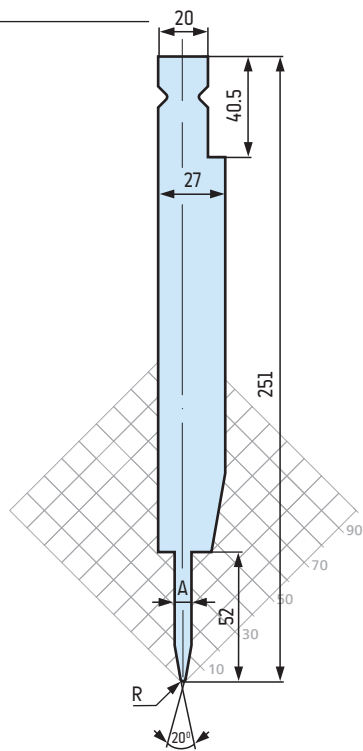
42CrMo4

S 2615 P 40 t/m

$\alpha = 20^\circ$

$A = 8 \text{ mm}, 10 \text{ mm}, 12 \text{ mm}$

$R = 1 \text{ mm}$

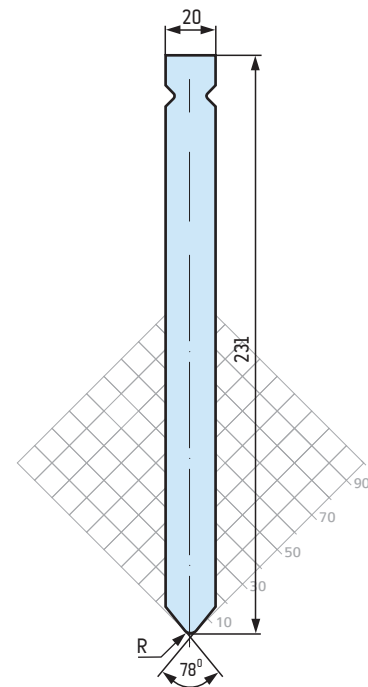


42CrMo4

S 2615 R 120 t/m

$\alpha = 78^\circ$

$R = 3 \text{ mm}$



TYPE "L" DIES 90 MM | MATRYCE TYPU „L” 90 MM

24h 42CrMo4

M 5106 20 t/m

A = 6 mm, B = 16 mm, C = 32 mm

24h 42CrMo4

M 5110 30 t/m

A = 10 mm, B = 25 mm, C = 32 mm

24h 42CrMo4

M 5116 35 t/m

A = 16 mm, B = 32 mm, C = 32 mm

24h 42CrMo4

M 5124 55 t/m

A = 24 mm, B = 45 mm, C = 45 mm

24h 42CrMo4

M 5140 60 t/m

A = 40 mm, B = 75 mm, C = 75 mm

24h 42CrMo4

M 5108 20 t/m

A = 8 mm, B = 18 mm, C = 32 mm

24h 42CrMo4

M 5112 35 t/m

A = 12 mm, B = 25 mm, C = 32 mm

24h 42CrMo4

M 5120 35 t/m

A = 20 mm, B = 40 mm, C = 40 mm

24h 42CrMo4

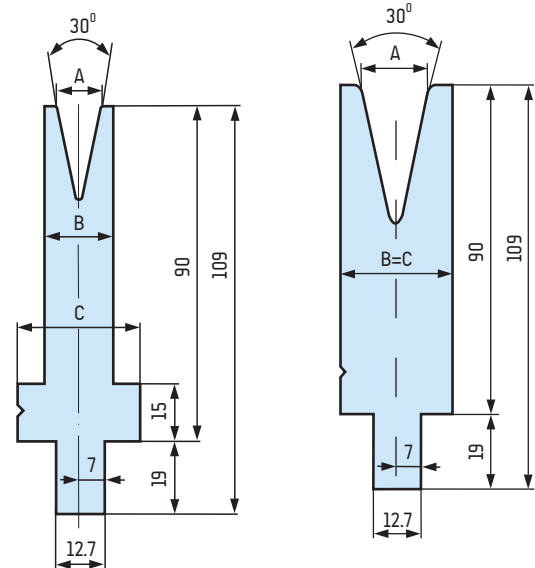
M 5130 60 t/m

A = 30 mm, B = 70 mm, C = 70 mm

24h 42CrMo4

M 5150 80 t/m

A = 50 mm, B = 95 mm, C = 95 mm



42CrMo4

M 5206 40 t/m

A = 6 mm, B = 12 mm, C = 32 mm

42CrMo4

M 5210 50 t/m

A = 10 mm, B = 14 mm, C = 32 mm

42CrMo4

M 5216 80 t/m

A = 16 mm, B = 25 mm, C = 32 mm

42CrMo4

M 5224 100 t/m

A = 24 mm, B = 32 mm, C = 32 mm

42CrMo4

M 5240 130 t/m

A = 40 mm, B = 50 mm, C = 50 mm

42CrMo4

M 5260 150 t/m

A = 60 mm, B = 70 mm, C = 70 mm

42CrMo4

M 5208 40 t/m

A = 8 mm, B = 12 mm, C = 32 mm

42CrMo4

M 5212 60 t/m

A = 12 mm, B = 18 mm, C = 32 mm

42CrMo4

M 5220 100 t/m

A = 20 mm, B = 32 mm, C = 32 mm

42CrMo4

M 5230 110 t/m

A = 30 mm, B = 40 mm, C = 40 mm

42CrMo4

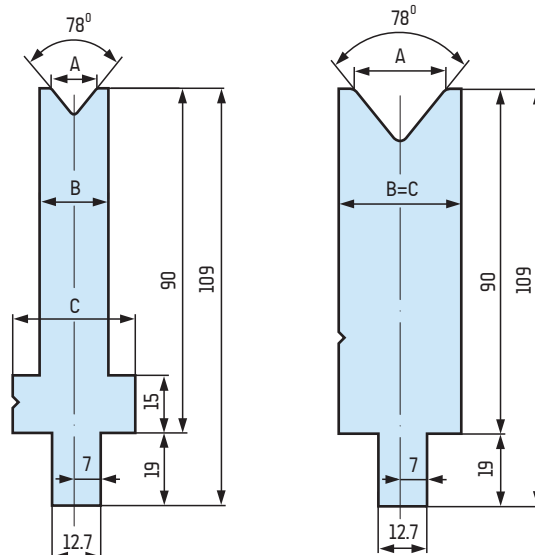
M 5250 150 t/m

A = 50 mm, B = 70 mm, C = 70 mm

42CrMo4

M 5280 150 t/m

A = 80 mm, B = 95 mm, C = 95 mm



TYPE "L" DIES 130 MM | MATRYCE TYPU „L” 130 MM

24h 42CrMo4

M 5306 20 t/m

A = 6 mm, B = 16 mm, C = 32 mm

24h 42CrMo4

M 5308 20 t/m

A = 8 mm, B = 18 mm, C = 32 mm

24h 42CrMo4

M 5310 30 t/m

A = 10 mm, B = 25 mm, C = 32 mm

24h 42CrMo4

M 5312 35 t/m

A = 12 mm, B = 25 mm, C = 32 mm

24h 42CrMo4

M 5316 35 t/m

A = 16 mm, B = 32 mm, C = 32 mm

24h 42CrMo4

M 5320 35 t/m

A = 20 mm, B = 40 mm, C = 40 mm

24h 42CrMo4

M 5324 55 t/m

A = 24 mm, B = 45 mm, C = 45 mm

24h 42CrMo4

M 5330 60 t/m

A = 30 mm, B = 70 mm, C = 70 mm

24h 42CrMo4

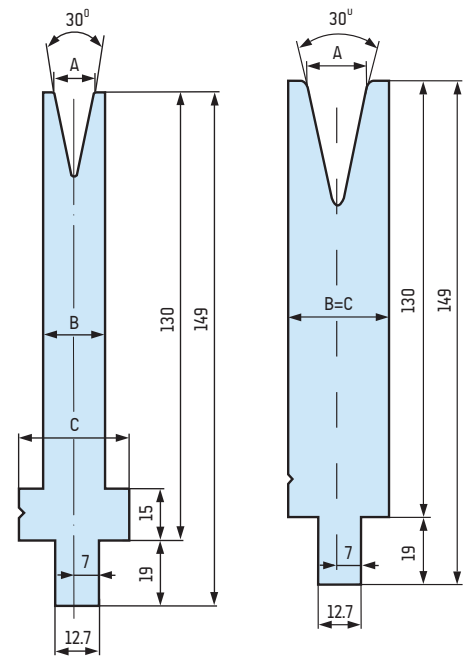
M 5340 60 t/m

A = 40 mm, B = 75 mm, C = 75 mm

24h 42CrMo4

M 5350 70 t/m

A = 50 mm, B = 95 mm, C = 95 mm



42CrMo4

M 5406 40 t/m

A = 6 mm, B = 12 mm, C = 32 mm

42CrMo4

M 5408 40 t/m

A = 8 mm, B = 12 mm, C = 32 mm

42CrMo4

M 5410 50 t/m

A = 10 mm, B = 14 mm, C = 32 mm

42CrMo4

M 5412 60 t/m

A = 12 mm, B = 18 mm, C = 32 mm

42CrMo4

M 5416 80 t/m

A = 16 mm, B = 25 mm, C = 32 mm

42CrMo4

M 5420 100 t/m

A = 20 mm, B = 32 mm, C = 32 mm

42CrMo4

M 5424 100 t/m

A = 24 mm, B = 32 mm, C = 32 mm

42CrMo4

M 5430 110 t/m

A = 30 mm, B = 40 mm, C = 40 mm

42CrMo4

M 5440 130 t/m

A = 40 mm, B = 50 mm, C = 50 mm

42CrMo4

M 5450 150 t/m

A = 50 mm, B = 70 mm, C = 70 mm

42CrMo4

M 5460 150 t/m

A = 60 mm, B = 70 mm, C = 70 mm

42CrMo4

M 5480 150 t/m

A = 80 mm, B = 95 mm, C = 95 mm

42CrMo4

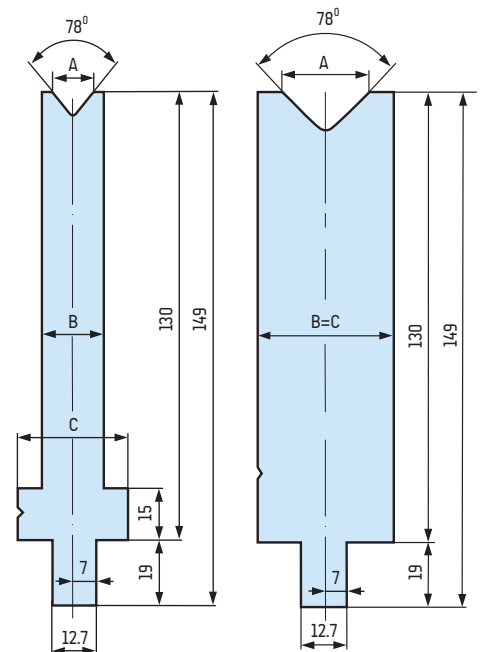
M 54100 150 t/m

A = 100 mm, B = 120 mm, C = 120 mm

42CrMo4

M 54120 150 t/m

A = 120 mm, B = 140 mm, C = 140 mm



TYPE "L" DIES | MATRYCE TYPU „L”

flattening dies | matryce do zagniatania

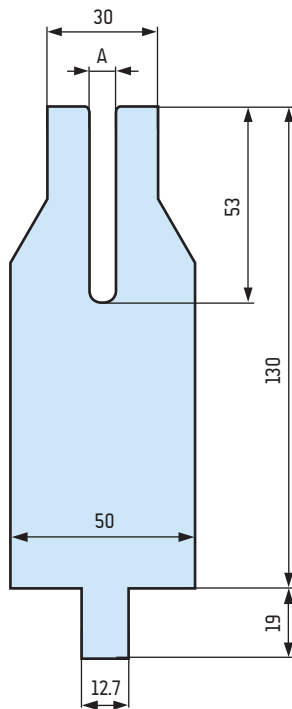
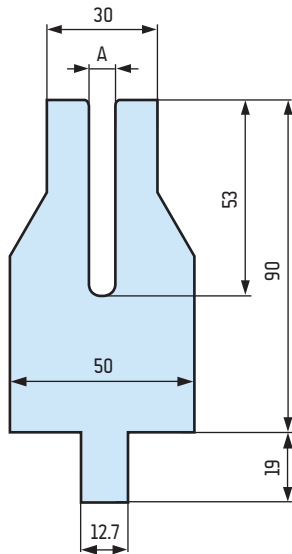
42CrMo4

M 5000 50 t/m

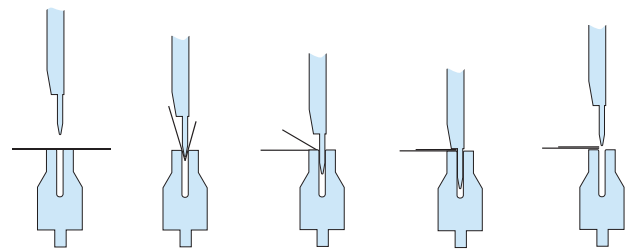
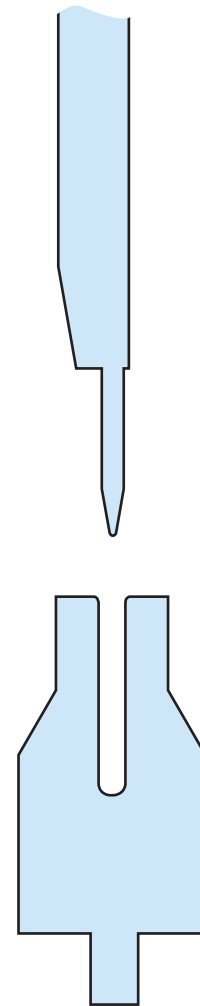
A = 8 mm, 10 mm, 12 mm

R = 1 mm

H = 90 mm, 130 mm



example of use | przykład zastosowania



Dies M5000 are used together with punches S2510 P, S2610 P, S2515 P or S2615 P.

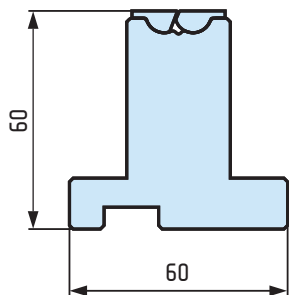
Do matryc M5000 stosujemy stemple S2510 P, S2610 P, S2515 P lub S2615 P.

ROLLA-V DIES | MATRYCE ROLLA-V

dies with movable inserts |
matryce z ruchomymi wkładkami

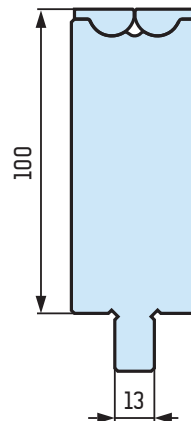
RVP 60-1

L = 100 mm, 440 mm, 500 mm



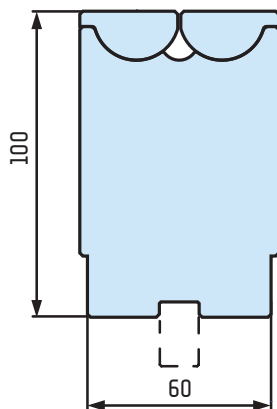
RVT 100-2

L = 100 mm, 450 mm, 500 mm



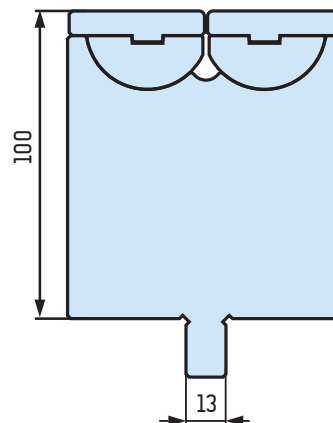
RVM 2.5

L = 100 mm, 470 mm, 500 mm



RVT 100-3

L = 100 mm, 455 mm, 500 mm



Dies support reduce bending marks for stainless and coated steel. Thanks to continuous support they allow use on short bending arms, and next to holes.

Matryce zmniejszające ślady po gięciu dla blachy nierdzewnej i powlekanej. Dzięki stałemu podparciu umożliwiają gięcie blach o krótkich ramionach i w sąsiedztwie otworów.

Different sizes of dies available. Dies can be offered with: 60 mm - type A, 13 mm - type T and W and 12.7 mm - type L holding type. Length of a single section - up to 500 mm.

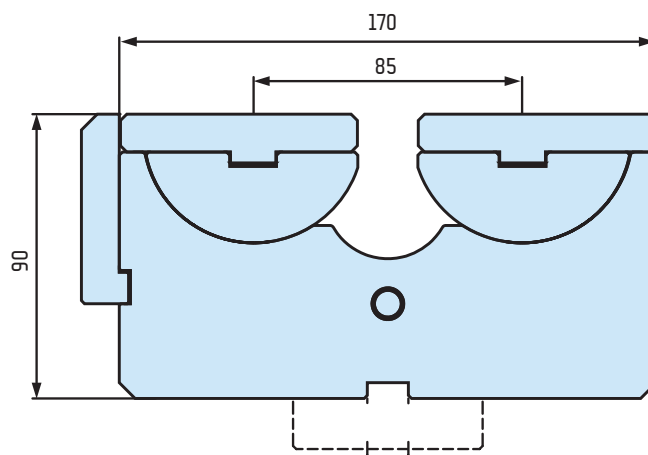
Możliwość wykonania różnej wielkości matryc. Dostępne uchwyty matryc: 60 mm - typ A, 13 mm - typy T i W oraz 12.7 mm - typ L. Długość pojedynczego segmentu do 500 mm.

ROLLA-V DIES | MATRYCE ROLLA-V

dies with movable inserts |
matryce z ruchomymi wkładkami

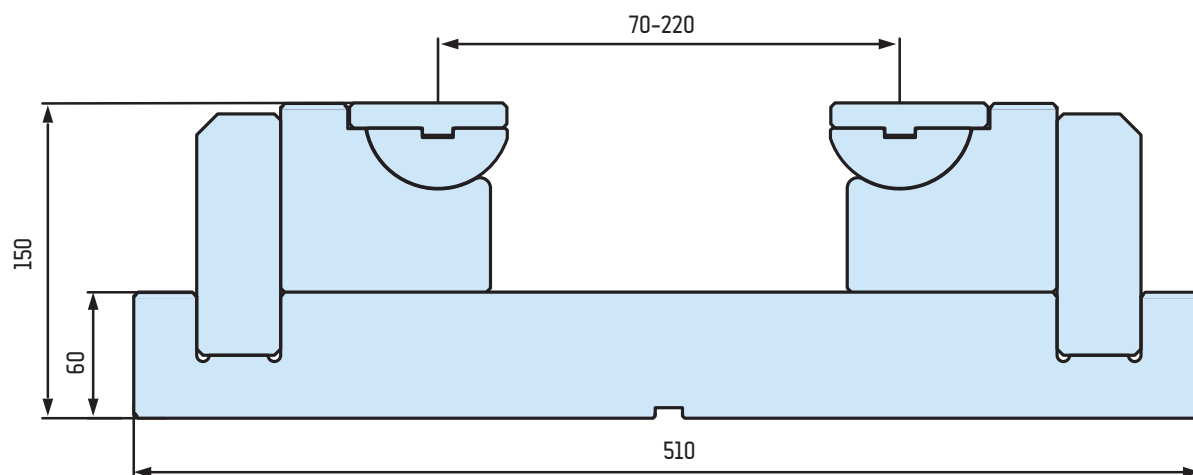
RVM 90-4

L = 250 mm, 500 mm



RVHD 4

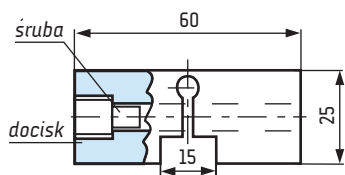
L = 200 mm, 500 mm



DIE HOLDERS | MOCOWANIA MATRYC

24h

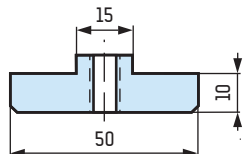
2 V



24h

A

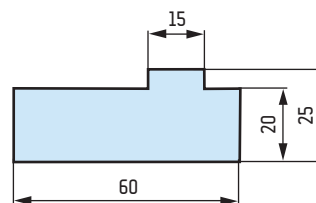
L = 415 mm, 835 mm



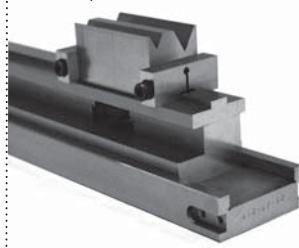
24h

A 20

L = 415 mm, 835 mm



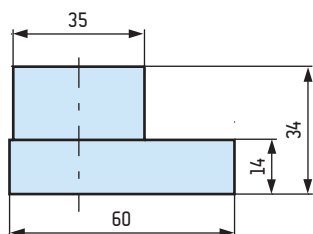
ASSEMBLY | PRZYKŁAD MONTAŻU



24h

A 34

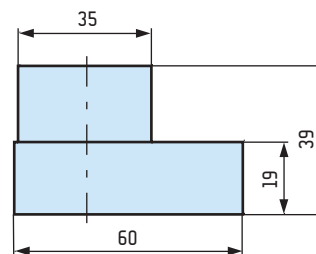
L = 412 mm, 830 mm



24h

A 39

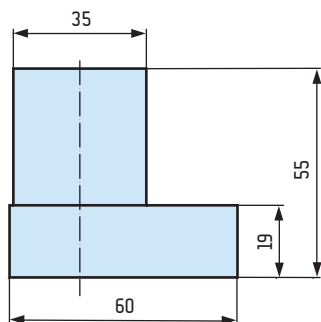
L = 412 mm, 830 mm



24h

A 55

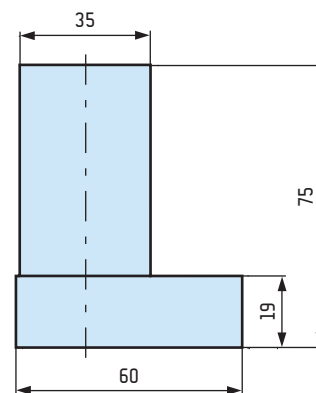
L = 412 mm, 830 mm



24h

A 75

L = 412 mm, 830 mm



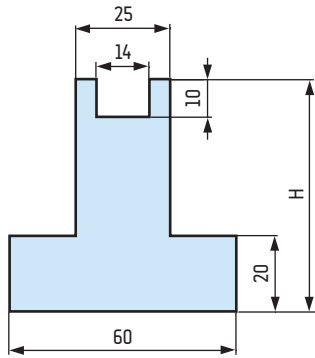
DIE HOLDERS | MOCOWANIA MATRYC

24h

A 31

$L = 415 \text{ mm}, 835 \text{ mm}$

$H = 31 \text{ mm}$



24h

A 61

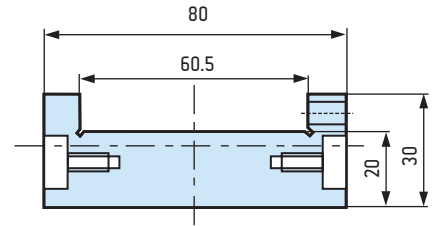
$L = 415 \text{ mm}, 835 \text{ mm}$

$H = 61.5 \text{ mm}$

24h

B 60

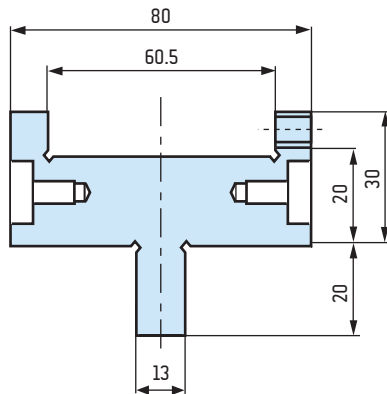
$L = 1050 \text{ mm}$



24h

B 60 / T-A

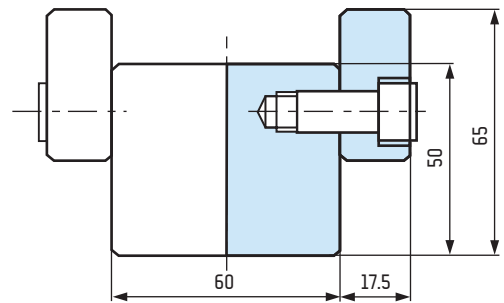
$L = 1050 \text{ mm}$



24h

C 60

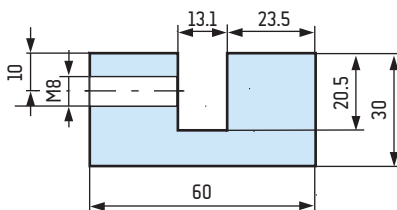
$L = 835 \text{ mm}$



24h

D 30

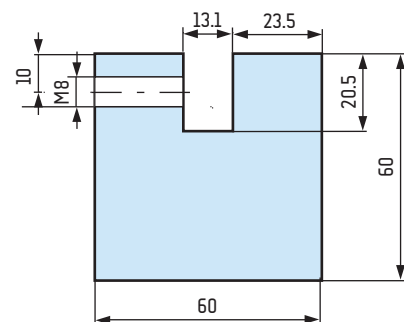
$L = 1000 \text{ mm}$

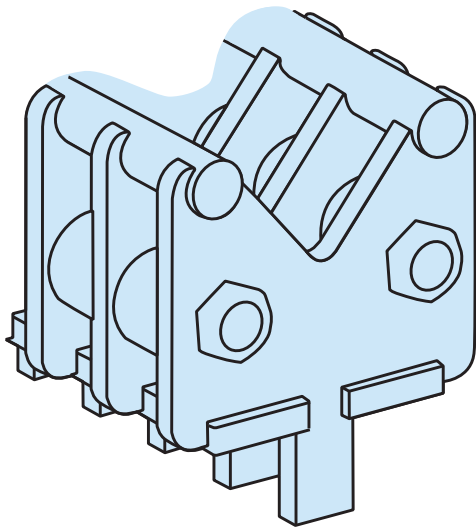


24h

D 60

$L = 1000 \text{ mm}$





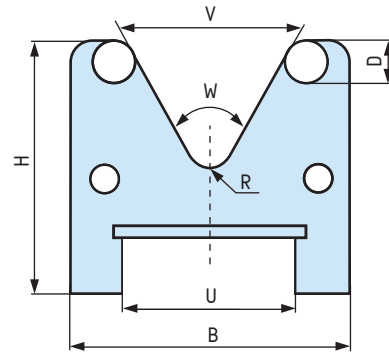
“Low Friction” dies meet the high demands of customers who need continual product improvement. By using new production techniques a new tooling product has been developed offering great value for money. It can be used for almost any application and will be a major advantage for use in the midrange and heavy sheet metal industry.

Matryce składane - o niskim tarczu. Wykonane ze stali stopowej, z wkładkami o twardości 60 HRC, stanowią tańszą alternatywę dla matryc pełnych. Dzięki wysokiej wytrzymałości mogą być używane do większości zastosowań przy blachach grubych i średniej grubości. Możliwa jest zmiana długości matryc, wymiana wkładek i wykonanie z każdym systemem mocowania.

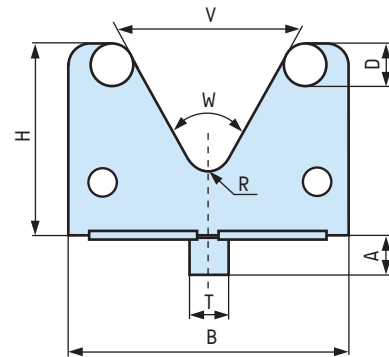
V	D	W ^o	B	H	R	t/m
16	6	28	30	55	2	50
20	6	28	34	55	2	50
24	8	28	40	55	3	30
32	10	28	53	55	5	50
32	10	85	53	55	5	30
40	10	85	62	55	5	60
48	10	85	70	55	5	70
mm	mm	°	mm	mm	mm	

V	D	W ^o	B	H	R	t/m
50	15	14	88	90	7	100
60	15	40	98	110	10	120
80	20	50	130	130	10	160
100	20	60	150	140	18	200
120	25	60	180	160	18	250
150	25	60	212	180	25	300
200	30	80	270	220	30	350
250	30	80	325	300	40	400
300	40	80	400	360	40	450
400	50	80	524	400	50	550
mm	mm	°	mm	mm	mm	

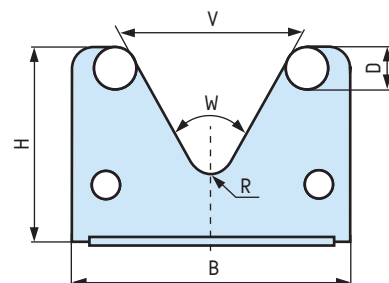
S



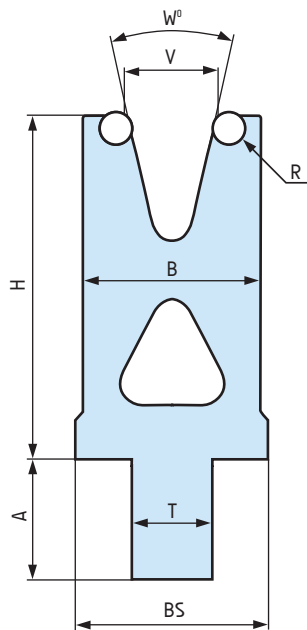
T



U



COMPOUND DIES | MATRYCE SKŁADANE

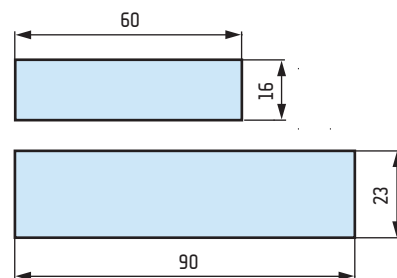
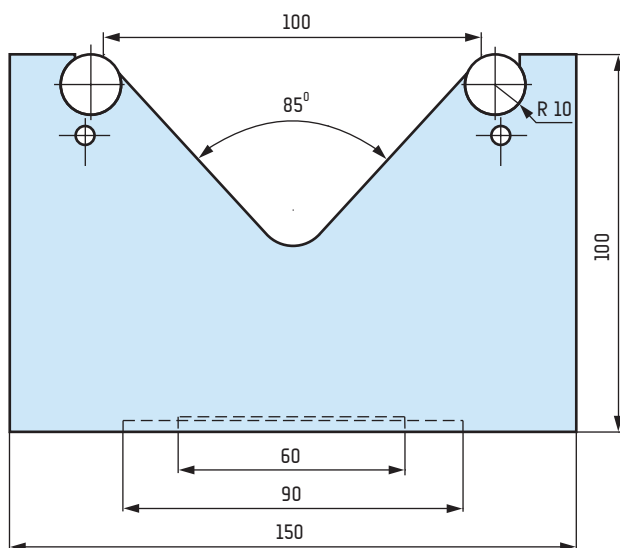


Compound dies are press brake dies for "airbending" only. The high precision, high quality, hardened and anodised, aluminium die body, contains the two hardened and ground die bars. The die bars are interchangeable in case of wear. The bars can be TiN coated for longer life, and less friction. Bronze or non metallic bars can be supplied for special applications.

Matryce kompozytowe, wykonane z wytrzymałych stopów utwardzonego aluminium. Matryce posiadają wysokiej jakości wymienne wkładki stalowe, hartowane i szlifowane. Możliwe jest zastosowanie wkładek pokrytych powłoką TIN dla zmniejszenia tarcia lub użycie wkładek plastikowych. Do specjalnych zastosowań możemy dostarczyć wkładki z brązu lub innych materiałów

V	R	W	B	BS	H	T/m	T	A
8	1.5	30	20	30	55	20	13	20
12	2	30	24	30	55	30	13	20
16	2.5	30	28	28	55	40	13	20
20	2.5	30	32	32	55	45	13	20
24	3	30	40	40	55	50	13	20
32	4	60	52	52	55	60	13	20

ROLL DIES | MATRYCE ROLKOWE



Round inserts hardened up to 60 HRC allow for bending steel up to 14 mm thick.

Matryce z rolkami o twardości do 60 HRC pozwalają na gięcie twardych blach o grubości do 14 mm.

Rectangular inserts 60 mm or 90 mm wide allow the die to be fixed on smaller machine beams.

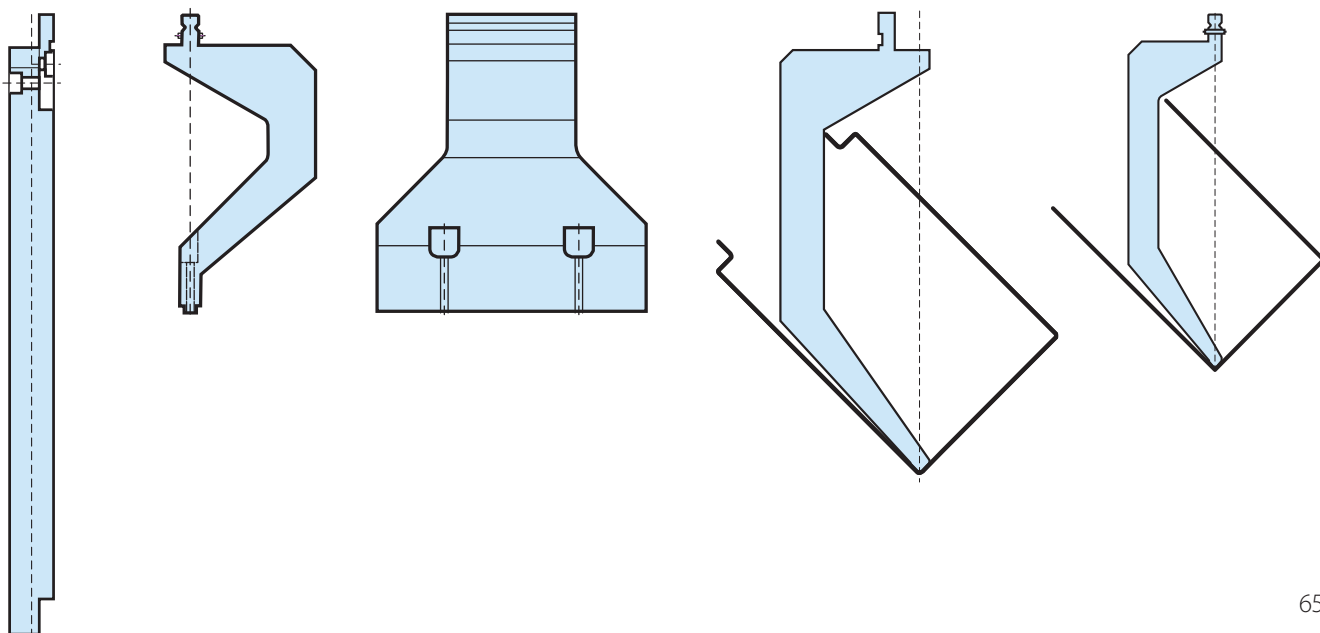
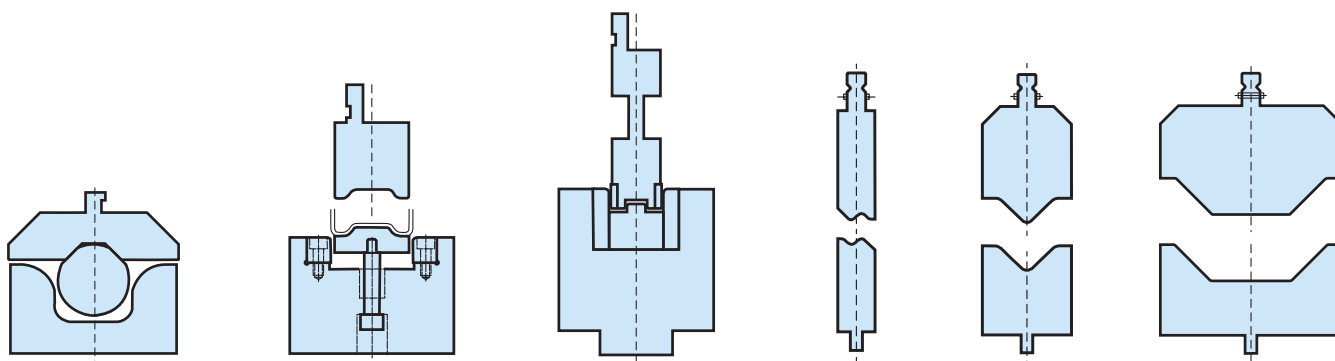
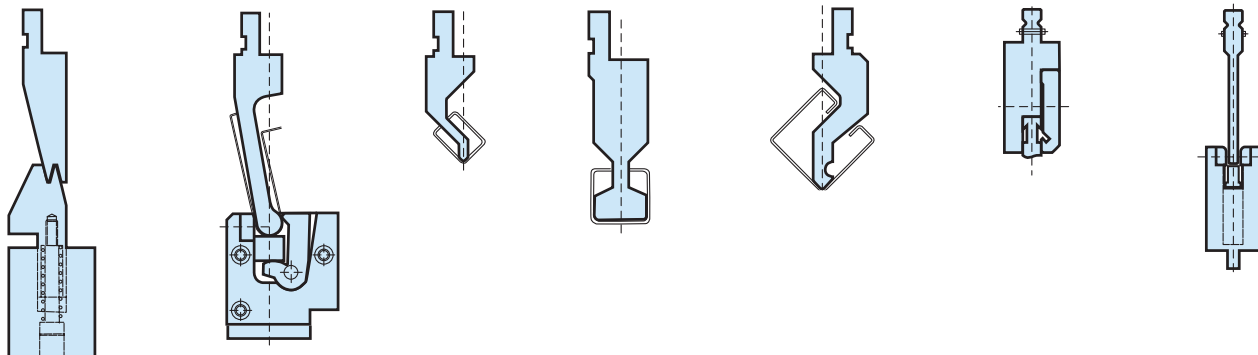
Wkładki o szerokości 60 mm lub 90 mm mogą służyć do zamocowania na węższym stole.

SPECIAL TOOLING | NARZĘDZIA SPECJALNE

special tooling examples | przykłady narzędzi specjalnych

We can offer many types of punches and dies for special applications, as well as non standard holders.

Możemy zaoferować wiele typów narzędzi do gięcia specjalistycznych profili, oraz niestandardowych mocowań narzędzi.

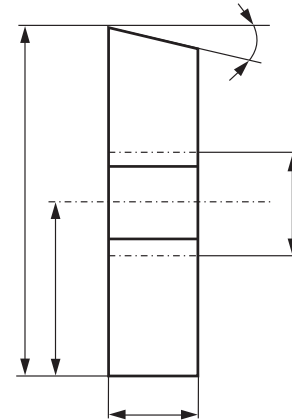
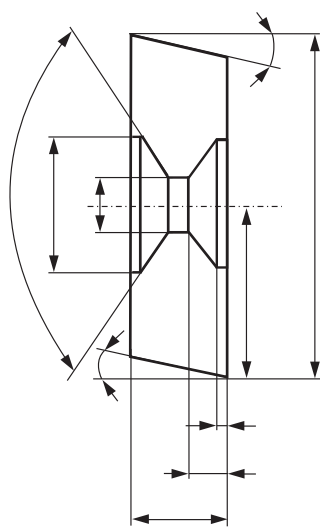
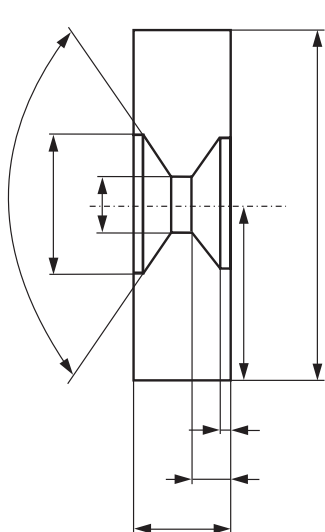
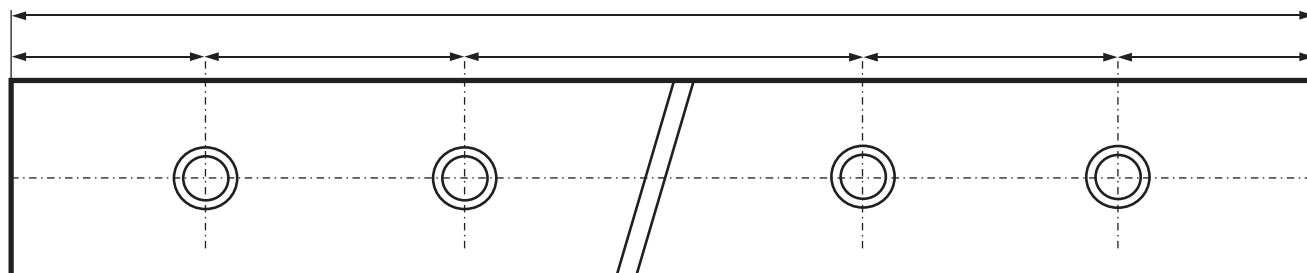


OTHER PRODUCTS | POZOSTAŁE PRODUKTY

shear blades | noże do gilotyn

Insert dimensions.

Przy zamówieniu uzupełnić wymiary.



We offer shear blades for most types of shears, typical or according to the clients own drawings .We grind the blades and harden them to 55 ± 2 HRC. We have in stock all types of Polish and Czech shear knives types NG 3-13, NTE, CNTA 6.3-25. We can also offer many other types of blades according to the client drawings and specification, of length up to 4100 mm. We can regrind and repair used blades of up to 4100 mm in length.

Produkujemy noże do nożyc gilotynowych, szlifowane i hartowane na wskroś do 55 ± 2 HRC. W stałej sprzedaży posiadamy noże do nożyc NG 3-13, NTE, CNTA 6.3-25. Możemy wykonać wiele innych typów noży według rysunków i specyfikacji klienta o długości noża do 4100 mm. Oferujemy również ostrzenie noży gilotynowych o długości do 4100 mm.

OTHER PRODUCTS | POZOSTAŁE PRODUKTY

teda adapters – main models | adaptery teda – podstawowe modele

Main benefits:

- standard type A tool
- no tool modification
- tool frontal insertion / removal
- easy assembly on any press brake (new or already in use)
- no modification of press necessary

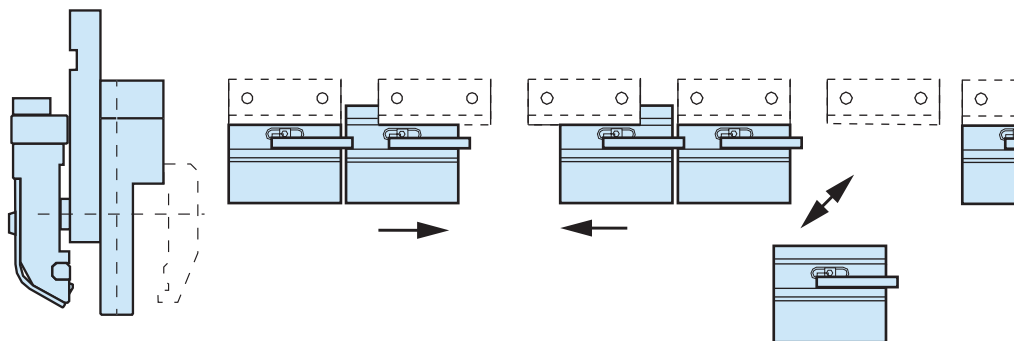
Główne korzyści:

- standardowe narzędzia typu A
- bez modyfikacji narzędzi
- narzędzia montowane / demontowane od frontu
- łatwy montaż na dowolnej prasie krawędziowej (nowej lub już używanej)
- nie ma konieczności modyfikacji prasy

SPEED GRIP 13000-M MANUAL | RĘCZNY

An ergonomic lever (one for each unit) locks / unlocks tools.

Ergonomiczna dźwignia (po jednej dla każdego adaptera) zamyka / odblokuje narzędzia.



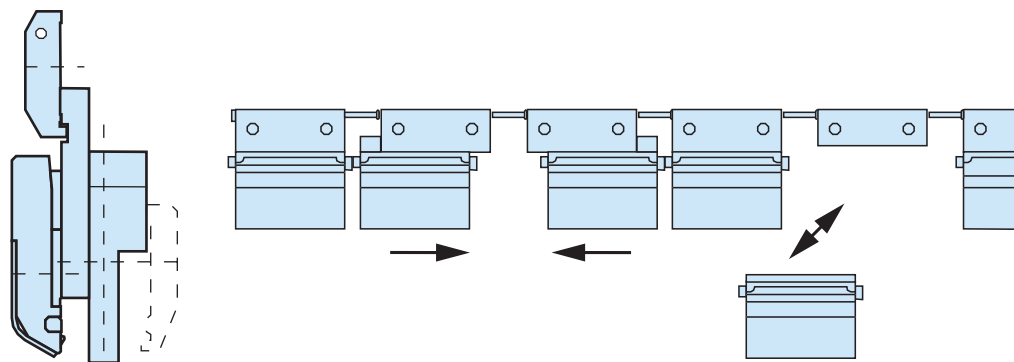
SPEED GRIP 13000-ST PNEUMATIC | PNEUMATYCZNE

One selector only for the whole line. Air transmission by Teda patented "STAR SYSTEM"

Tylko jeden przełącznik dla całej linii. Transmisja powietrza przez zabezpieczone rury stalowe teleskopowe (Patent TEDA).

Please note: depending on the press brake ram configuration (bending axis at 7 mm or at 20 mm different units height - 100 / 120 / 150 mm - wedge or not etc). Several different solutions are available for each SPEED GRIP model.

Uwaga: w zależności od konfiguracji belki prasy krawędziowej (oś gięcia na 7 mm lub 20 mm) różna wysokość adaptersów - 100 / 120 / 150 mm - z klinem lub bez itd). Szereg różnych rozwiązań dostępnych dla każdego modelu SPEED GRIP.



We also offer pneumatic die holders and special punch holders and adapters. Compared to traditional manual clampings with screws SPEED GRIP grants about 80% timesaving.

Oferujemy również pneumatyczne mocowanie matryc, oraz adaptory i uchwyty specjalne. W porównaniu do tradycyjnych ręcznych zamocowanych śrubami adatory speed grip dają około 80% oszczędności czasu.



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