



## **Gimec srl**

via della misericordia 37

Italy 20854 Vedano al Lambro MB

t +39.039.492897

f +39.039.492535

info@gimec.it

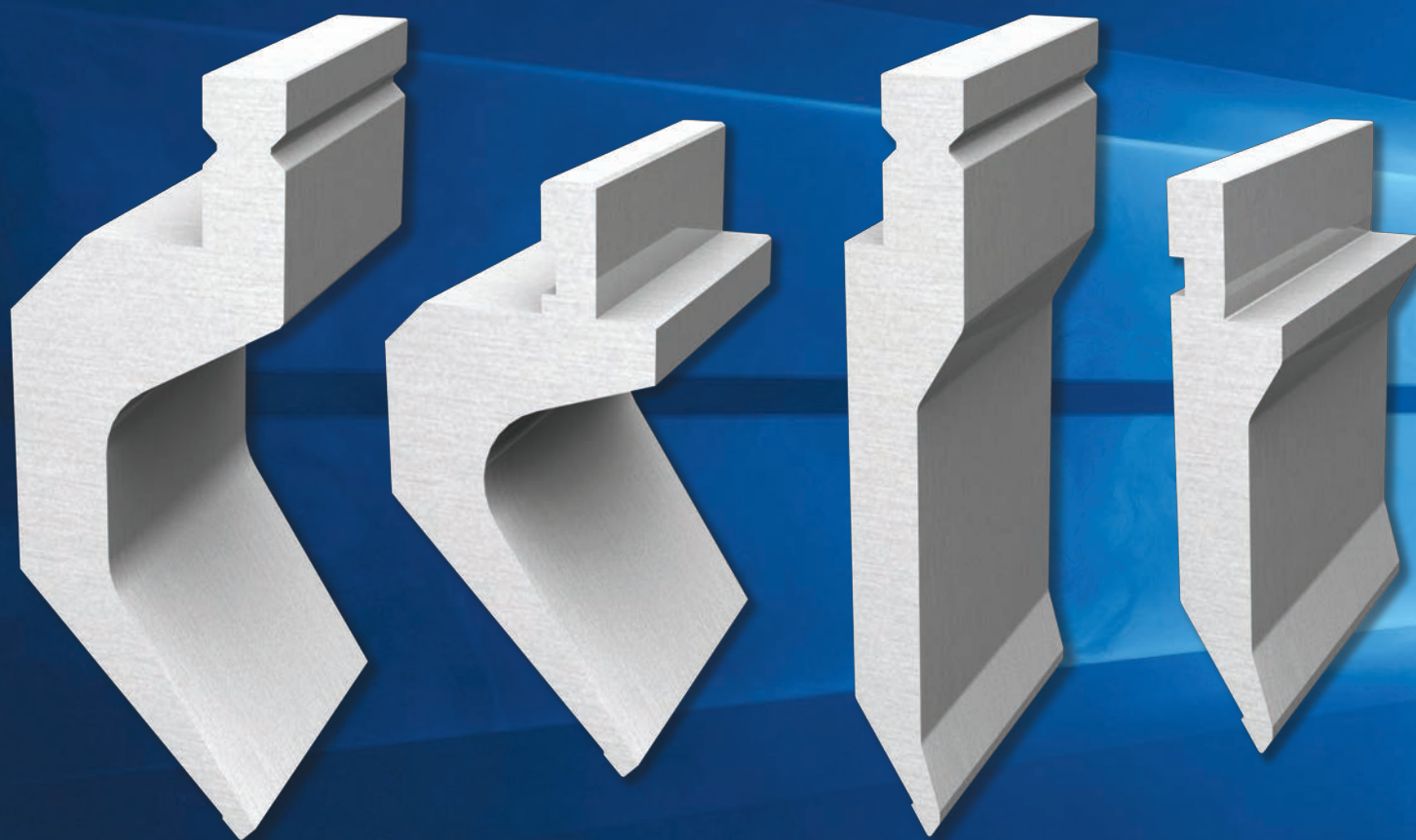
www.gimec.it

**Jun 2016**



[www.gimec.it](http://www.gimec.it)

# 2016



utensili per presse piegatrici  
attrezzature per la lavorazione della lamiera



since 1986

press brake tools  
fixtures for sheet metal working

**GIMEC**<sup>®</sup>  
PRESS BRAKE TOOLS FACTORY

Dal 1986 Gimec è tra le aziende più qualificate nella costruzione di utensili ed attrezzature per la lavorazione della lamiera.

In particolare siamo specializzati nella fornitura di utensili per presse piegatrici e lame per cesoie.

L'analisi metodica di tutti i materiali impiegati, il controllo accurato del prodotto durante le varie fasi produttive e la continua ricerca innovativa, contribuiscono ad accrescere l'alto livello tecnologico raggiunto dalla Gimec in tale settore.

Siamo un'azienda compatta ed agile, che opera quotidianamente con passione ed entusiasmo, caratteristiche che da sempre ci contraddistinguono sul mercato.

In un'economia sempre più competitiva, cerchiamo di fornire il miglior servizio, con prodotti di alta qualità, progettando e proponendo soluzioni efficaci e funzionali.

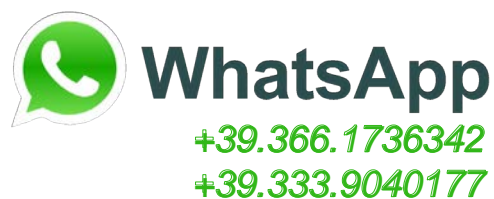
Since 1986 Gimec is among the leading companies in the manufacturing of tools and equipment for sheet metal working.

In particular, we are specialized in providing tools for press brake and shear blades.

The methodical analysis of all materials used, the careful monitor of the product during the various stages of production and continued innovative research, help us to increase the high technological level reached in this area.

We are a compact and agile company, which daily works with passion and enthusiasm, characteristics that have always distinguished us in the market.

In a more and more competitive economy, we try to provide the best service with high quality products, designing and proposing effective and useful solutions.



## **UTENSILI SUPERIORI - UPPER TOOLS**

tipo Europa type ..... pag.01

**US**

tipo Colgar type ..... pag.16

**USC**

tipo Trumpf Wila type ..... pag.17

**UST**

tipo Beyeler Bystronic type ..... pag.21

**USB**

tipo LVD type ..... pag.23

**USL**

## **UTENSILI INFERIORI - LOWER TOOLS**

tipo Europa type ..... pag.09

**60**

tipo ROLLA-V <sup>®</sup> type ..... pag.25

**RV**

tipo Trumpf Wila type ..... pag.27

**13 UST**

tipo Beyeler Bystronic type ..... pag.28

**13 USB**

tipo LVD type ..... pag.29

**12,7**

## **UTENSILI - TOOLS**

tipo Haco type ..... pag.30

**USH**

tipo Newton type ..... pag.31

**USN**

## **STAMPI**

stampi presse piegatrici - press brake tools.....pag.33

## **PORTA UT**

porta utensili - tools holder ..... pag.39

## **TABLUS**

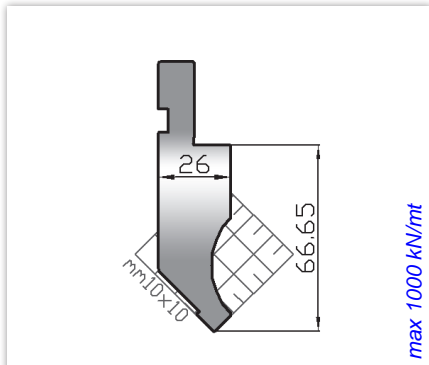
sistema di centinatura - crowning system ..... pag.41

## **LAME**

lame per cesoia - shear blades ..... pag.43

## **ATTREZZATURE**

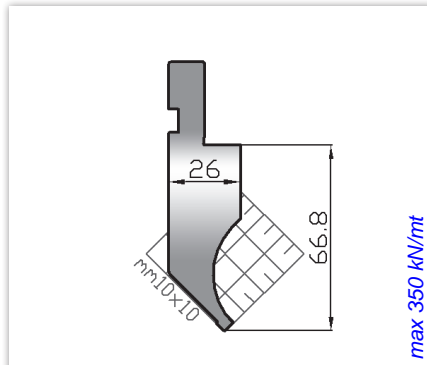
attrezzature - fixtures ..... pag.44



max 1000 kN/mt

### US 110/90° R0,8

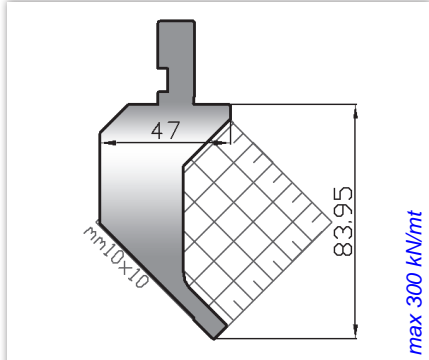
altezza-height 66,65 mm  
 angolo-degree 90° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 350 kN/mt

### US 126/90° R0,6

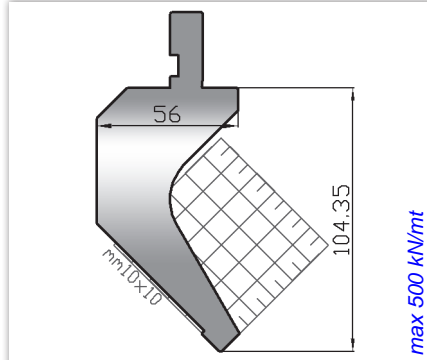
altezza-height 66,80 mm  
 angolo-degree 90° raggio-radius 0,6 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 300 kN/mt

### US 117/90° R0,6

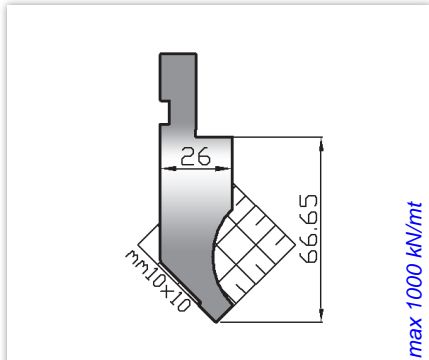
altezza-height 83,95 mm  
 angolo-degree 90° raggio-radius 0,6 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 500 kN/mt

### US 115/90° R0,8

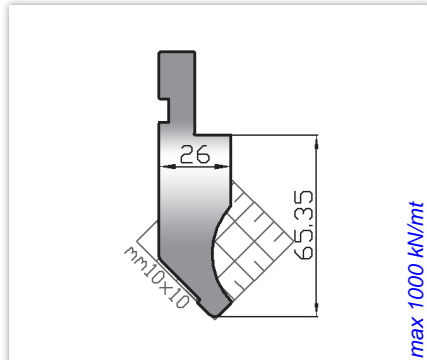
altezza-height 104,35 mm  
 angolo-degree 90° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 1000 kN/mt

### US 110/88° R0,8

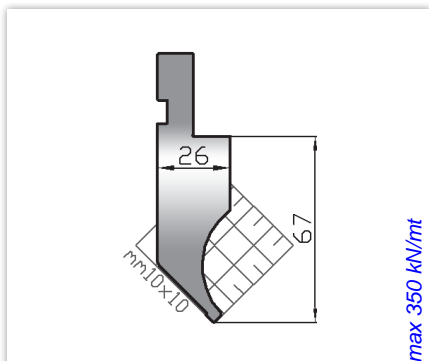
altezza-height 66,65 mm  
 angolo-degree 88° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 1000 kN/mt

### US 110/88° R3,0

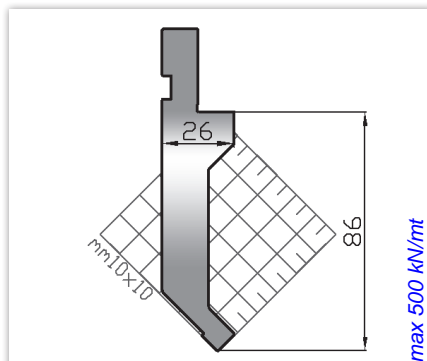
altezza-height 65,35 mm  
 angolo-degree 88° raggio-radius 3,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 350 kN/mt

### US 126/88° R0,6

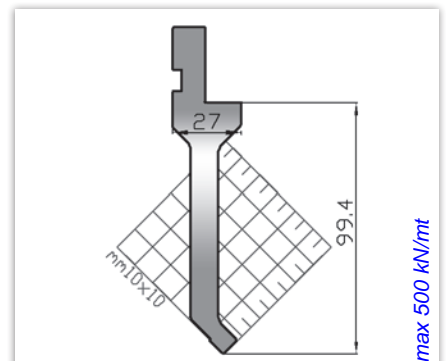
altezza-height 67,00 mm  
 angolo-degree 88° raggio-radius 0,6 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 500 kN/mt

### US 125/88° R0,8

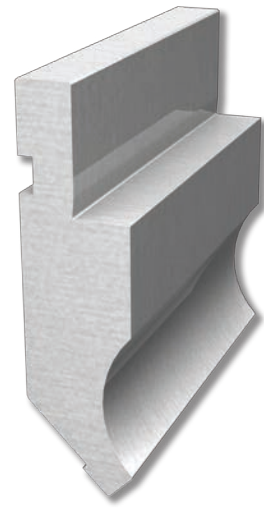
altezza-height 86,00 mm  
 angolo-degree 88° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



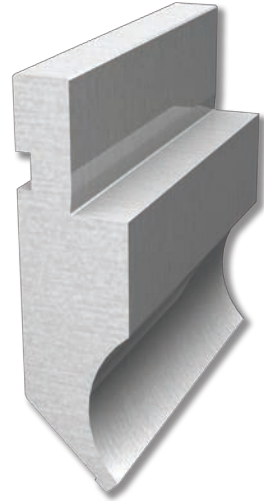
max 500 kN/mt

### US 143/88° R0,6

altezza-height 99,40 mm  
 angolo-degree 88° raggio-radius 0,6 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



90°



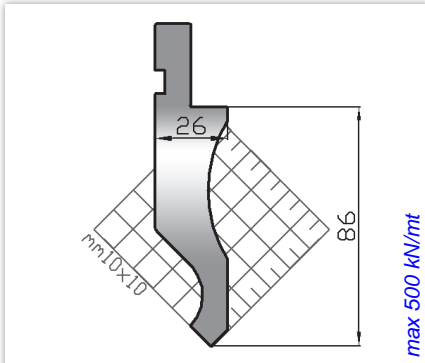
88°

88°

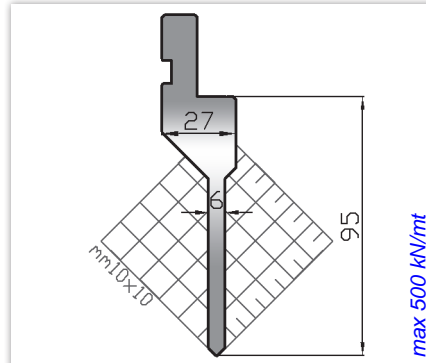
tipo Europa type

02

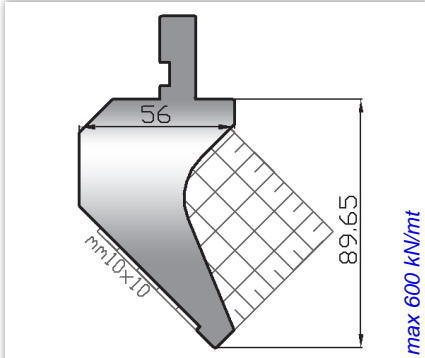
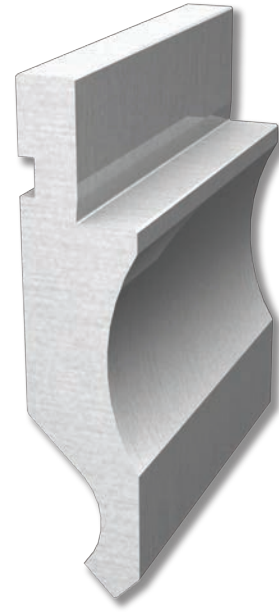
serie US  
utensili superiori - upper tools



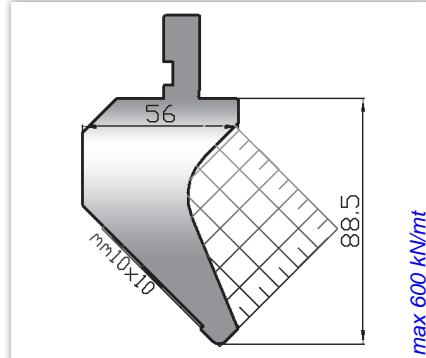
**US 120/88° R0,8**  
 altezza-height 86,00mm  
 angolo-degree 88° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



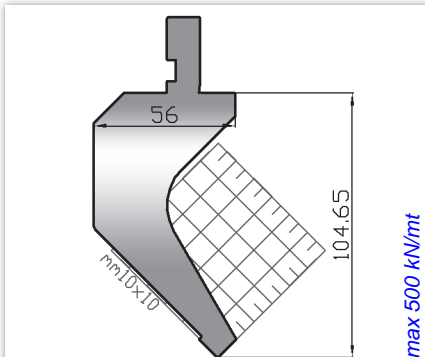
**US 147/88° R0,25**  
 altezza-height 95,00 mm  
 angolo-degree 88° raggio-radius 0,25 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



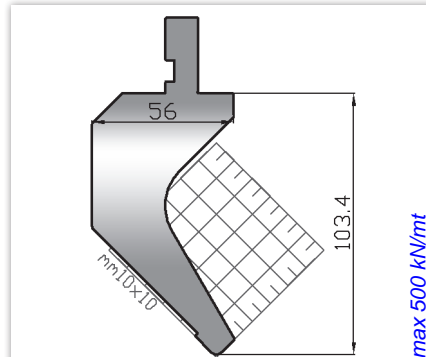
**US 114/88° R0,8**  
 altezza-height 89,65 mm  
 angolo-degree 88° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



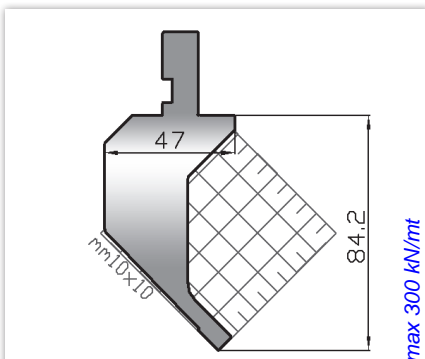
**US 114/88° R3,0**  
 altezza-height 88,50 mm  
 angolo-degree 88° raggio-radius 3,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



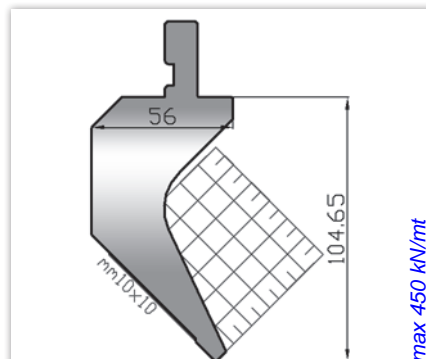
**US 115/88° R0,8**  
 altezza-height 104,65 mm  
 angolo-degree 88° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



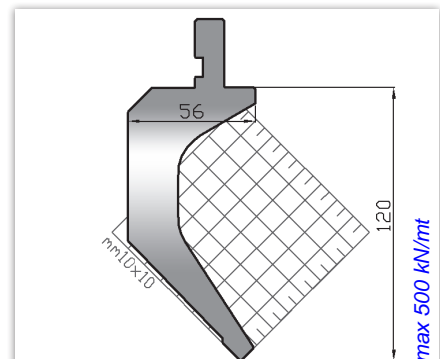
**US 115/88° R3,0**  
 altezza-height 103,40 mm  
 angolo-degree 88° raggio-radius 3,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



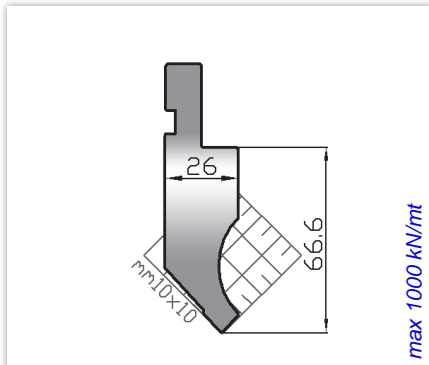
**US 117/88° R0,6**  
 altezza-height 84,20 mm  
 angolo-degree 88° raggio-radius 0,6 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



**US 144/88° R0,8**  
 altezza-height 104,65 mm  
 angolo-degree 88° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

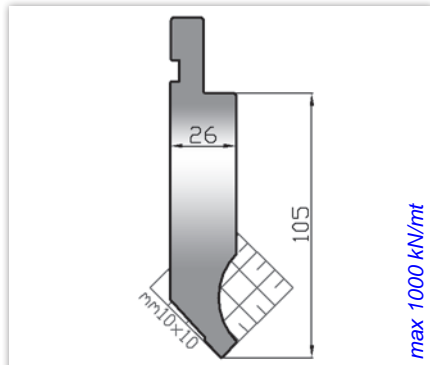


**US 152/88° R0,8**  
 altezza-height 120,00 mm  
 angolo-degree 88° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



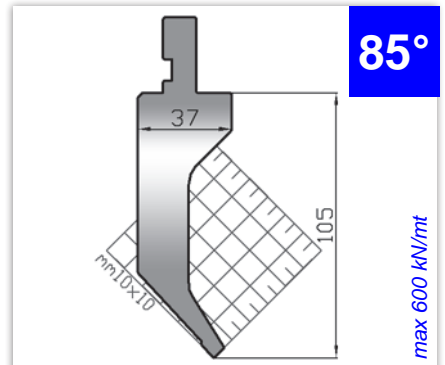
**US 110/85° R0,8**  
 altezza-height 66,60 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



**US 110/85° R0,8 h105**  
 altezza-height 105,00 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

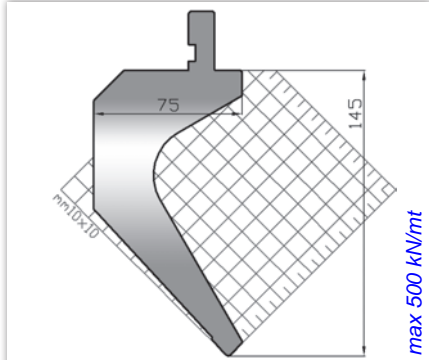
max 1000 kN/mt



**US 142/85° R0,8**  
 altezza-height 105,00 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

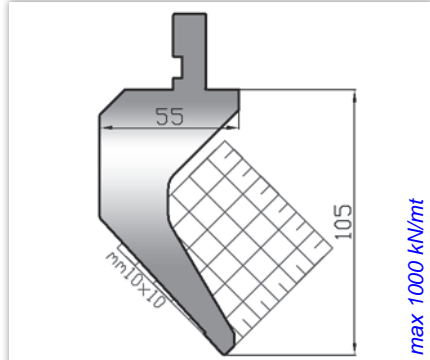
max 600 kN/mt

85°



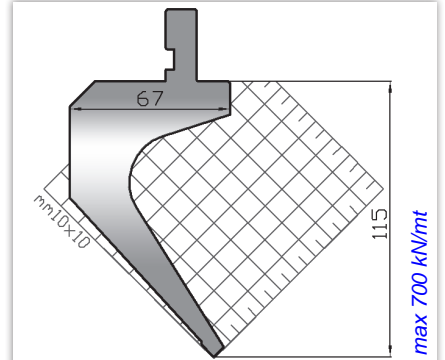
**US 127/85° R0,8**  
 altezza-height 145,00 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 500 kN/mt



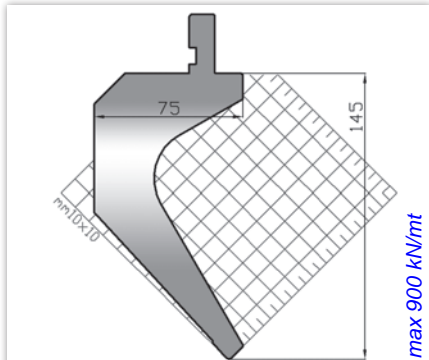
**US 129/85° R0,8**  
 altezza-height 105,00 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



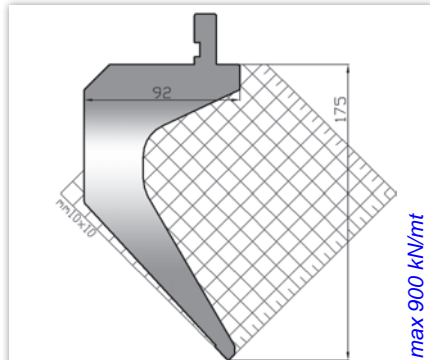
**US 141/85° R0,8**  
 altezza-height 115,00 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 700 kN/mt



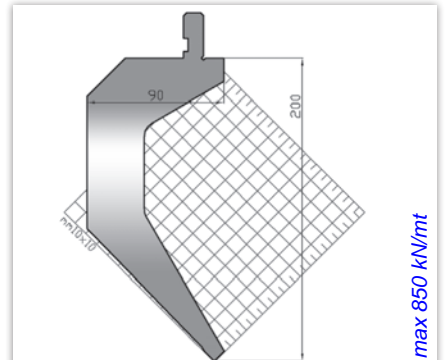
**US 145/85° R2,0**  
 altezza-height 145,00 mm  
 angolo-degree 85° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 900 kN/mt



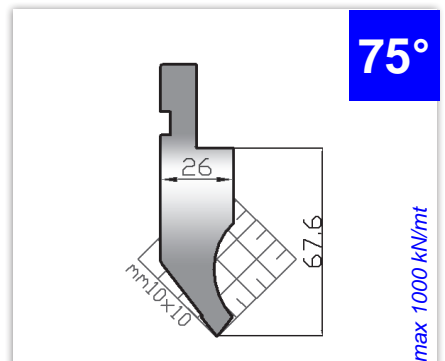
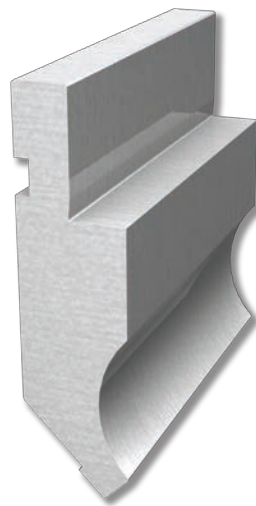
**US 146/85° R1,25**  
 altezza-height 175,00 mm  
 angolo-degree 85° raggio-radius 1,25 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 900 kN/mt



**US 153/85° R0,8**  
 altezza-height 200,00 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 415 mm - fraz

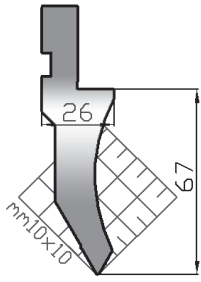
max 850 kN/mt



**US 110/75° R0,8**  
 altezza-height 67,60 mm  
 angolo-degree 75° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt

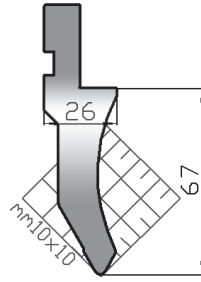
75°



max 800 kN/mt

**US 124/60° R0,8**

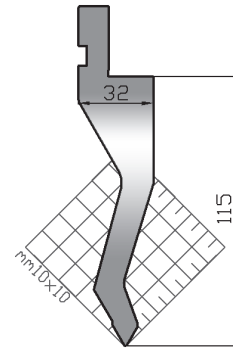
altezza-height 67,00mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 800 kN/mt

**US 124/60° R2,0**

altezza-height 67,00 mm  
 angolo-degree 60° raggio-radius 2,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

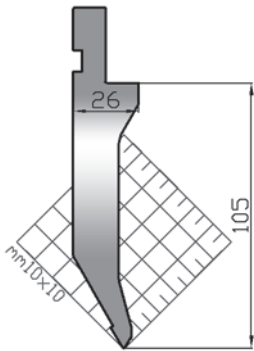


60°

max 700 kN/mt

**US 134/60° R0,8**

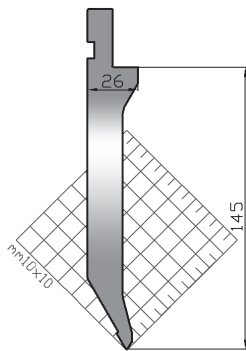
altezza-height 115,00 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 800 kN/mt

**US 128/60° R0,8**

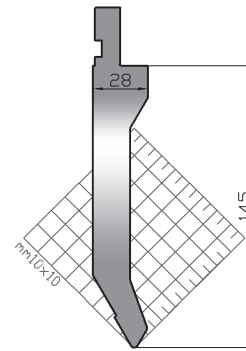
altezza-height 105,00 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 800 kN/mt

**US 135/60° R0,8**

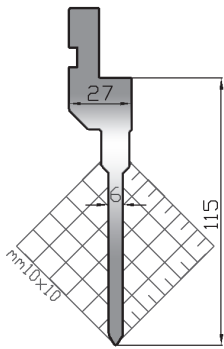
altezza-height 145,00 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 1000 kN/mt

**US 136/60° R2,0**

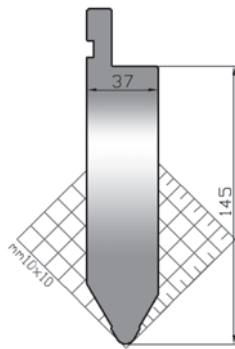
altezza-height 145,00 mm  
 angolo-degree 60° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 500 kN/mt

**US 151/60° R0,8**

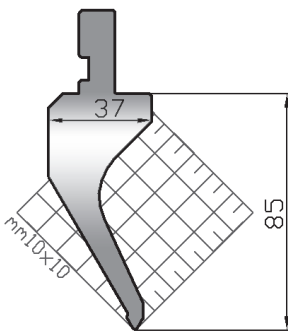
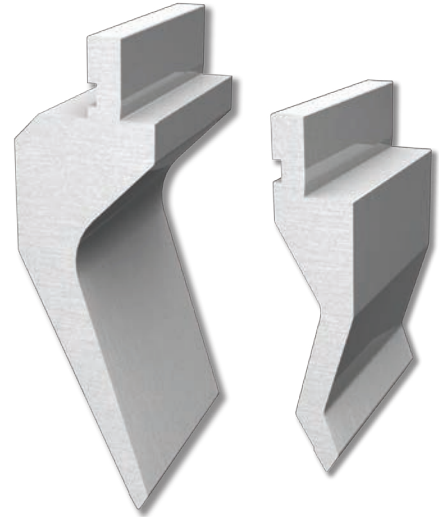
altezza-height 115,00 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 1600 kN/mt

**US 155/60° R5,0**

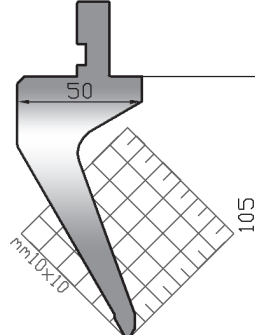
altezza-height 145,00 mm  
 angolo-degree 60° raggio-radius 5,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 400 kN/mt

**US 148/60° R0,8**

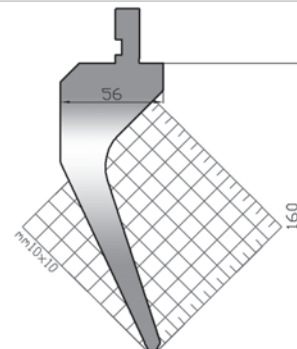
altezza-height 85,00 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



max 700 kN/mt

**US 132/60° R0,8**

altezza-height 105,00 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

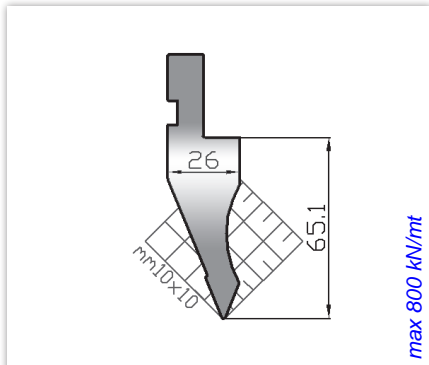


max 400 kN/mt

**US 150/60° R0,8**

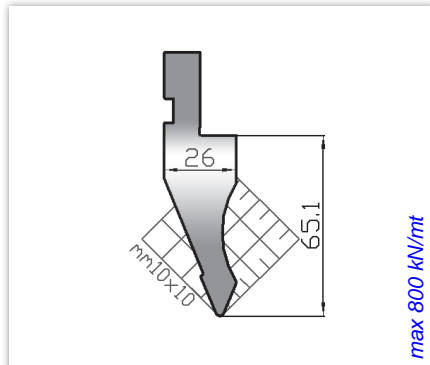
altezza-height 160,00 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz





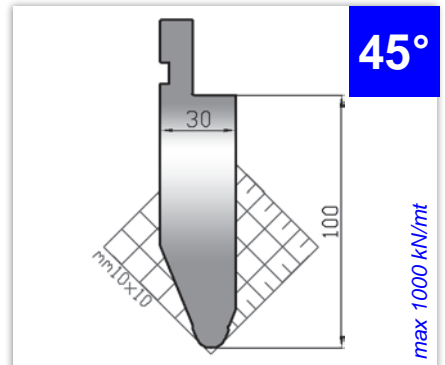
**US 111/45° R0,8**  
 altezza-height 65,10 mm  
 angolo-degree 45° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt



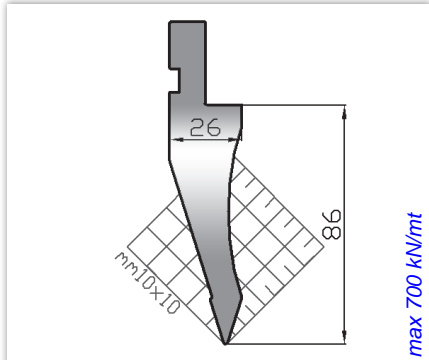
**US 111/45° R1,5**  
 altezza-height 65,10 mm  
 angolo-degree 45° raggio-radius 1,5 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt



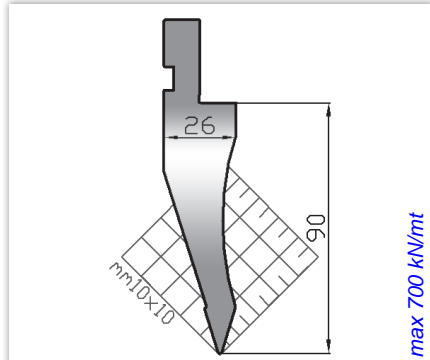
**US 149/45° R6,0**  
 altezza-height 100,00 mm  
 angolo-degree 45° raggio-radius 6,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



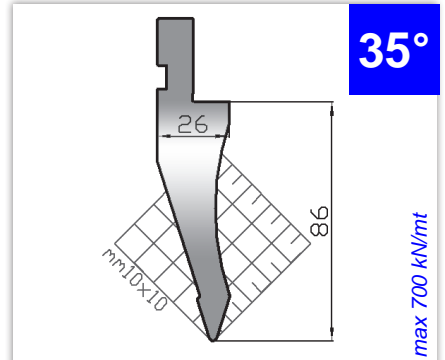
**US 112/35° R0,8 h86**  
 altezza-height 86,00 mm  
 angolo-degree 35° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 700 kN/mt



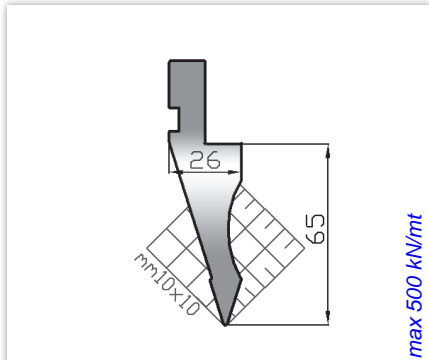
**US 112/35° R0,8 h90**  
 altezza-height 90,00 mm  
 angolo-degree 35° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 700 kN/mt



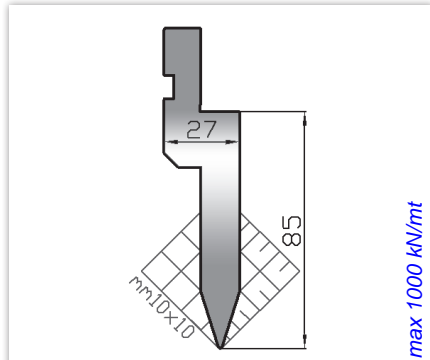
**US 112/35° R1,5 h86**  
 altezza-height 86,00 mm  
 angolo-degree 35° raggio-radius 1,5 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 700 kN/mt



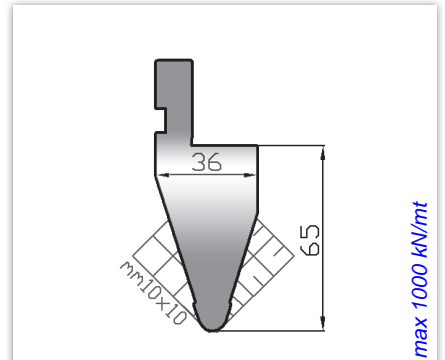
**US 111/35° R0,8**  
 altezza-height 65,00 mm  
 angolo-degree 35° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 500 kN/mt



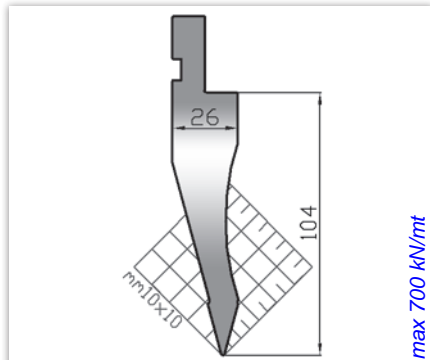
**US 121/35° R0,8**  
 altezza-height 85,00 mm  
 angolo-degree 35° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



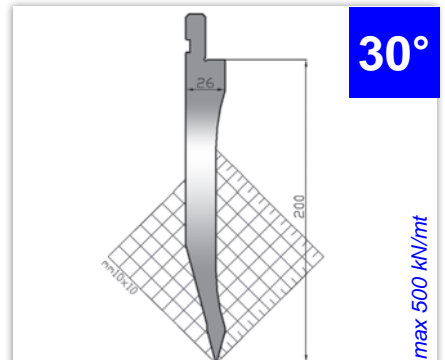
**US 113/35° R5,0**  
 altezza-height 65,00 mm  
 angolo-degree 35° raggio-radius 5,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



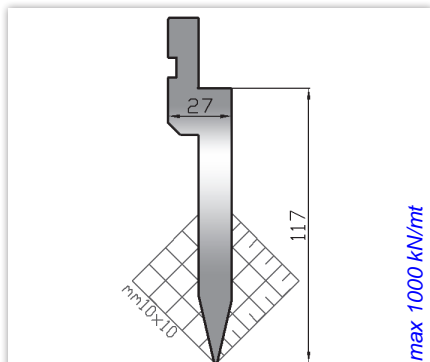
**US 133/30° R0,8**  
 altezza-height 104,00 mm  
 angolo-degree 30° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 700 kN/mt

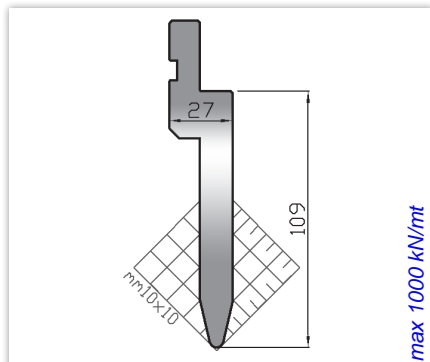


**US 154/30° R0,5**  
 altezza-height 200,00 mm  
 angolo-degree 30° raggio-radius 0,5 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

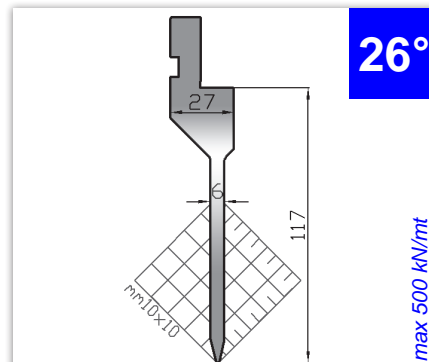
max 500 kN/mt



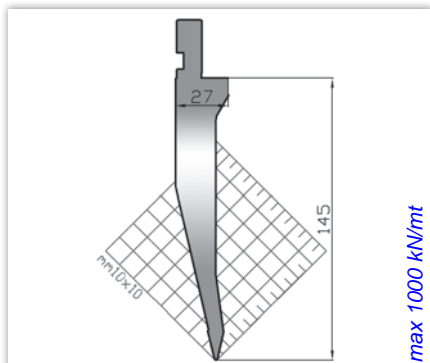
**US 122/26° R0,8**  
 altezza-height 117,00 mm  
 angolo-degree 26° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



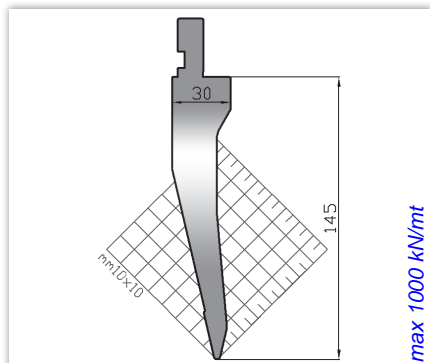
**US 122/26° R3,0**  
 altezza-height 109,00 mm  
 angolo-degree 26° raggio-radius 3,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



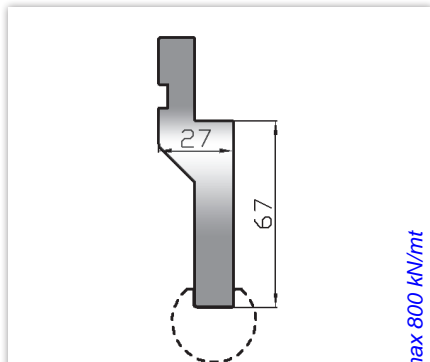
**US 137/26° R0,8**  
 altezza-height 117,00 mm  
 angolo-degree 26° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



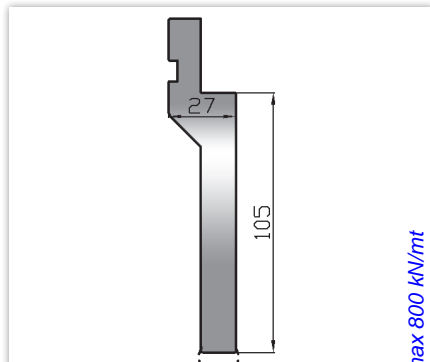
**US 139/26° R0,8**  
 altezza-height 145,00 mm  
 angolo-degree 26° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



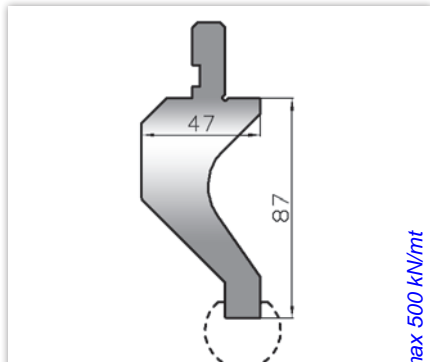
**US 140/26° R1,5**  
 altezza-height 145,00 mm  
 angolo-degree 26° raggio-radius 1,5 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



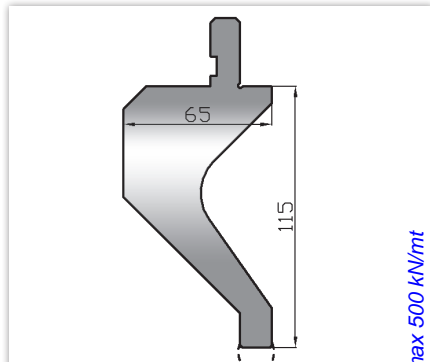
**US 119 h 67**  
 altezza-height 67,00 mm  
 raggio-radius min 8 mm - max 50 mm  
 C45 rettificato-grinding  
 lunghezze-lengths 830 mm - 412 mm



**US 119 h 105**  
 altezza-height 105,00 mm  
 raggio-radius min 8 mm - max 50 mm  
 C45 rettificato-grinding  
 lunghezze-lengths 830 mm - 412 mm

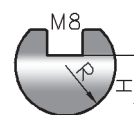


**US 119C h 87**  
 altezza-height 87,00 mm  
 raggio-radius min 8 mm - max 50 mm  
 C45 rettificato-grinding  
 lunghezze-lengths 830 mm - 412 mm



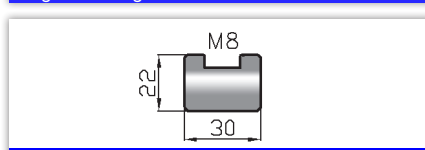
**US 119C h 115**  
 altezza-height 115,00 mm  
 raggio-radius min 8 mm - max 50 mm  
 C45 rettificato-grinding  
 lunghezze-lengths 830 mm - 412 mm

4 fori/holes mm. 104-209...-104 = mm 835  
 2 fori/holes mm. 103-209...-103 = mm 415



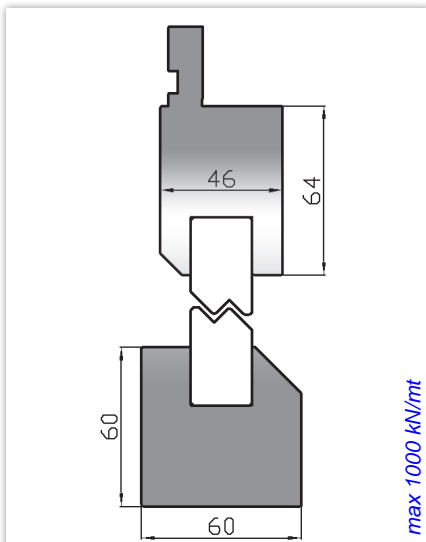
	raggio-radius	altezza-height
<b>US 305/R 8</b>	8	10 mm
<b>US 305/R 9</b>	9	10 mm
<b>US 305/R 10</b>	10	12 mm
<b>US 305/R 12,5</b>	12,5	17 mm
<b>US 305/R 15</b>	15	20 mm
<b>US 305/R 17,5</b>	17,5	22 mm
<b>US 305/R 20</b>	20	24 mm
<b>US 305/R 22,5</b>	22,5	25 mm
<b>US 305/R 25</b>	25	29 mm
<b>US 305/R 27,5</b>	27,5	34 mm
<b>US 305/R 30</b>	30	34 mm
<b>US 305/R 35</b>	35	45 mm
<b>US 305/R 40</b>	40	44 mm
<b>US 305/R 45</b>	45	50 mm
<b>US 305/R 50</b>	50	54 mm

C45 rettificato-grinding  
 (N) 39NiCrMo3 NITRURATO rettificato-grinding  
 lunghezze-lengths 835 mm - 415 mm



**US 310**  
 C45 rettificato-grinding  
**US 310 T**  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm



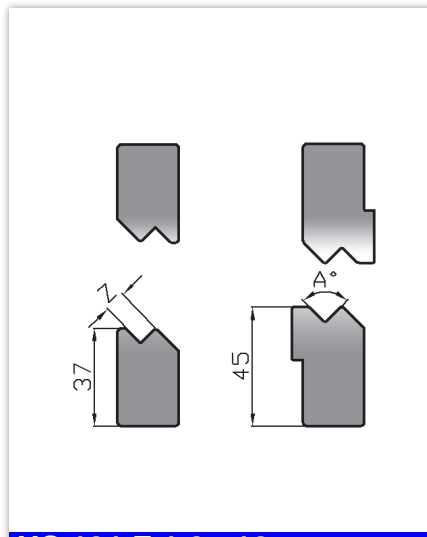


**US 130**

C45 rettificato-grinding

lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt



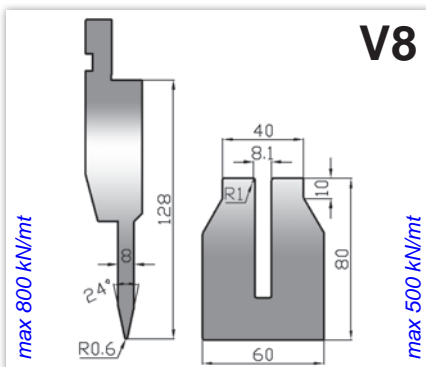
**US 131 Z 1.0 - 12 mm**

C45 rettificato-grinding

temprato ind.-induction hardened HRC 52/58

lunghezze-lengths 835 mm - 415 mm

ZIPA°	Z mm	A°	MAX spessore thickness	altezza height mm
US 131/ 1	1,0	160°	0,5 mm	37
US 131/1,5	1,5	160°	0,6 mm	37
US 131/ 2	2,0	150°	0,8 mm	37
US 131/2,5	2,5	140°	1,0 mm	37
US 131/ 3	3,0	90°	1,0 mm	37
US 131/3,5	3,5	90°	1,2 mm	37
US 131/ 4	4,0	90°	1,2 mm	37
US 131/4,5	4,5	90°	1,5 mm	37
US 131/ 5	5,0	90°	1,5 mm	37
US 131/5,5	5,5	90°	1,5 mm	37
US 131/ 6	6,0	90°	1,5 mm	37
US 131/6,5	6,5	90°	1,5 mm	37
US 131/ 7	7,0	90°	2,0 mm	37
US 131/7,5	7,5	90°	2,0 mm	37
US 131/ 8	8,0	90°	2,5 mm	37
US 131/ 9	9,0	90°	2,5 mm	45
US 131/10	10,0	90°	3,0 mm	45
US 131/11	11,0	90°	3,0 mm	45
US 131/12	12,0	90°	3,0 mm	45



**V8**

**US 138 L8 + M8**

altezza-height 128 - 80 mm

angolo-degree 24° raggio-radius 0,6-1,0 mm

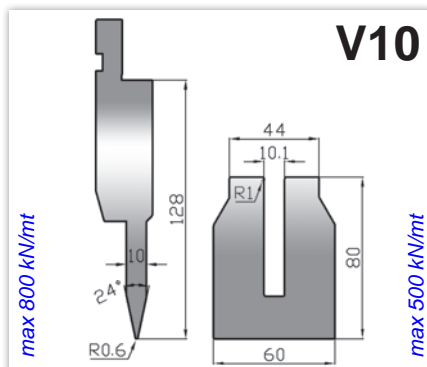
42CrMo4 rettificato-grinding

temprato ind.-induction hardened HRC 52/58

lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt

max 500 kN/mt



**V10**

**US 138 L10 + M10**

altezza-height 128 - 80 mm

angolo-degree 24° raggio-radius 0,6-1,0 mm

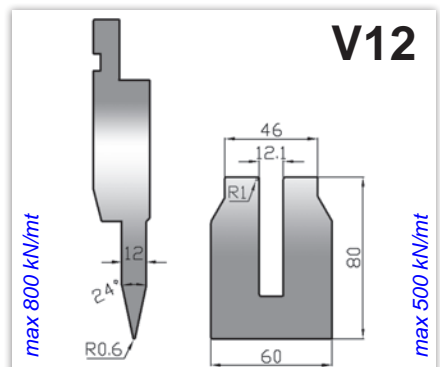
42CrMo4 rettificato-grinding

temprato ind.-induction hardened HRC 52/58

lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt

max 500 kN/mt



**V12**

**US 138 L12 + M12**

altezza-height 128 - 80 mm

angolo-degree 24° raggio-radius 0,6-1,0 mm

42CrMo4 rettificato-grinding

temprato ind.-induction hardened HRC 52/58

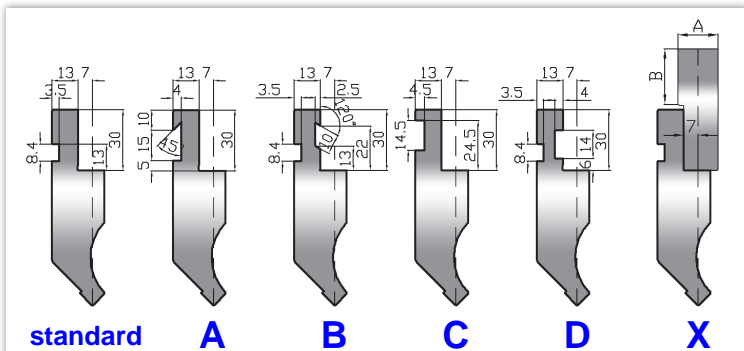
lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt

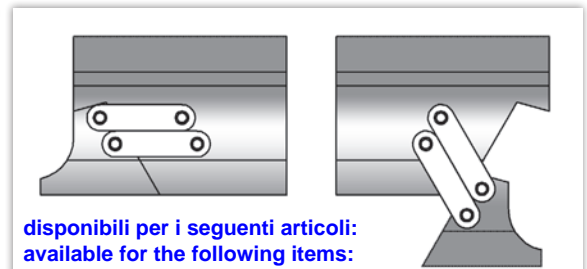
max 500 kN/mt

Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura. Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.

We suggest to use these tools on synchronized press brakes as it is necessary to change quickly press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on bend crushed.

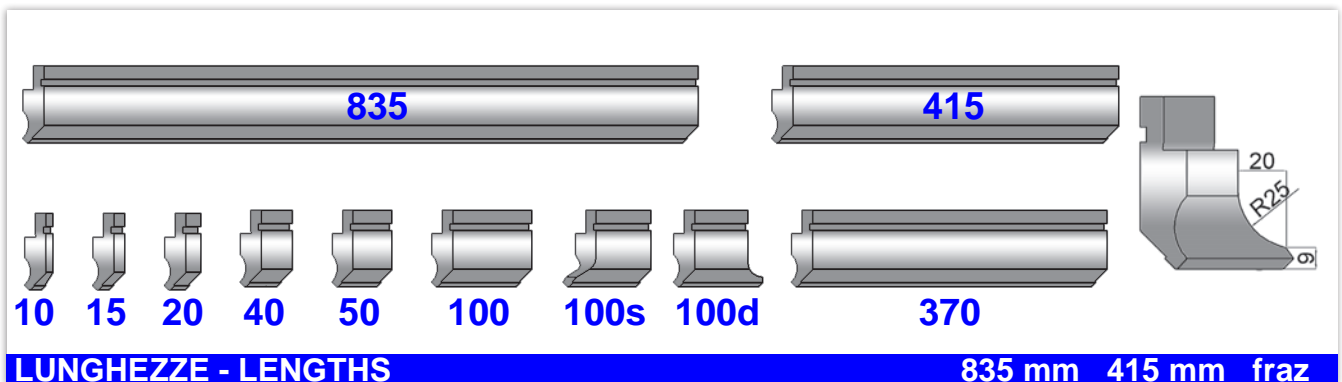


**ATTACCHI SPECIALI - SPECIAL CLAMPINGS**



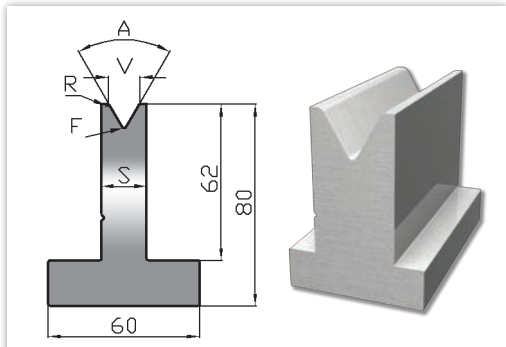
disponibili per i seguenti articoli:  
available for the following items:  
-US 110/88° R0,8 -US 125/88° R0,8  
-US 128/60° R0,8 -US 122/26° R0,8

**UTENSILI CON SCARPETTE MOBILI  
TOOLS WITH MOBILE HORNS**

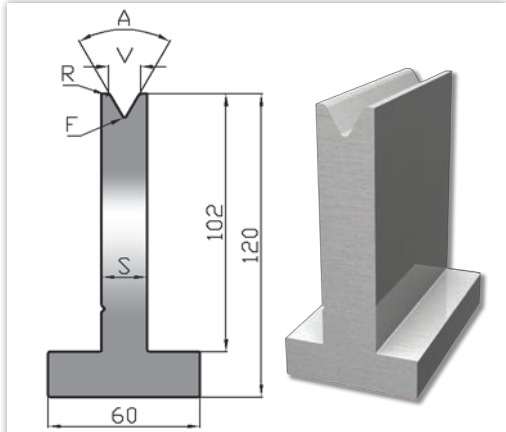


**LUNGHEZZE - LENGTHS**

835 mm 415 mm fraz



**US 220 h 80 mm**  
 dimensioni - dimensions 80 x 60 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



**US 420 h 120 mm**  
 dimensioni - dimensions 120 x 60 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

A°	V mm	R mm	S mm	F mm	max kN/mt
90°	6	0,40	14	r 0,5	1000
	8	0,50	14	r 0,5	1000
	10	0,60	18	r 0,5	1000
	12	0,80	18	r 0,5	1000
88°	6	0,40	14	r 0,5	1000
	8	0,50	14	r 0,5	1000
	10	0,80	18	r 0,5	1000
	12	2,75	18	r 0,5	1000
	16	2,75	24	r 0,5	1000
	20	3,00	30	r 0,5	1000
85°	6	2,75	14	r 0,5	1000
	8	2,75	14	r 0,5	1000
	10	2,75	18	r 0,5	1000
	12	2,75	18	r 0,5	1000
60°	6	0,50	14	r 0,5	800
	8	0,80	14	r 0,5	700
	10	0,80	18	r 0,5	800
	12	0,80	18	r 0,5	700
	16	2,75	24	r 2,0	1000
	20	3,00	30	r 2,0	1000
	25	3,00	35	r 2,0	1000
	6 R	1,50	14	r 0,5	800
	8 R	1,50	14	r 0,5	700
	10 R	2,75	18	r 0,5	800
	12 R	2,75	18	r 0,5	700

A°	V mm	R mm	S mm	F mm	max kN/mt
45°	6	0,80	14	r 0,5	500
	8	1,00	18	r 0,8	500
	10	1,20	18	r 0,8	500
	12	1,60	24	r 0,8	500
	16	2,75	26	r 2,0	500
35°	6	0,80	14	r 0,5	350
	8	1,00	16	r 0,5	350
	10	1,20	20	r 0,5	400
	12	1,60	22	r 0,5	400
30°	6	0,60	14	r 1,0	350
	8	0,80	18	r 1,2	350
	10	1,00	24	r 1,2	500
	12	1,50	24	r 1,2	400
	16	2,00	30	r 3,0	450
26°	6	0,80	16	r 1,0	250
	8	1,00	20	r 1,0	250
	10	1,20	24	r 1,0	250
	12	1,60	26	r 1,0	250
	20	3,00	35	r 2,0	500

V mm	A°	V mm	A°
6	88°	6	45°
8	88°	8	45°
10	88°	10	45°
6	60°	6	30°
8	60°	8	30°
10	60°		

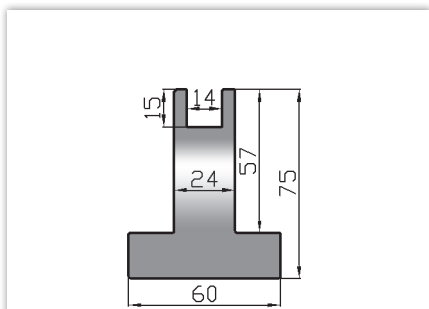
**NYLON 14**  
 lunghezze-lengths 835 mm - 415 mm

V mm	A°	V mm	A°
6	88°	6	45°
8	88°	8	45°
10	88°	10	45°
12	88°	12	45°
16	88°		
6	60°	6	30°
8	60°	8	30°
10	60°	10	30°
12	60°		
16	60°		

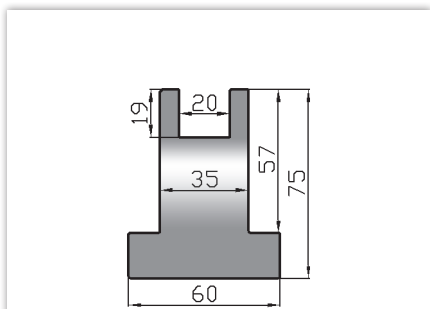
**NYLON 20**  
 lunghezze-lengths 835 mm - 415 mm

V mm	A°	V mm	A°
6	88°	6	45°
8	88°	8	45°
10	88°	10	45°
12	88°	12	45°
16	88°	16	45°
20	88°	20	45°
25	88°		
6	60°	6	30°
8	60°	8	30°
10	60°	10	30°
12	60°	12	30°
16	60°	16	30°
20	60°		

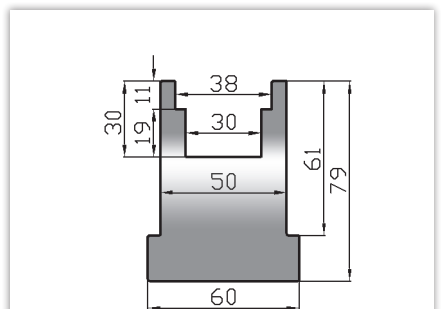
**NYLON 30**  
 lunghezze-lengths 835 mm - 415 mm



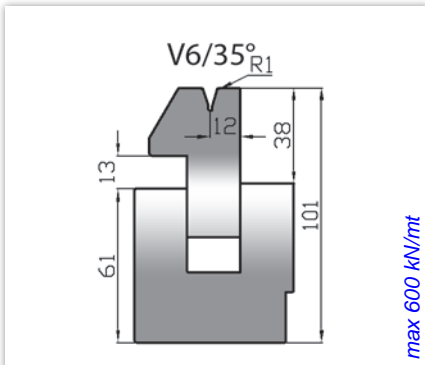
**US 220 NYL14**  
 lunghezze-lengths 835 mm - 415 mm



**US 220 NYL 20**  
 lunghezze-lengths 835 mm - 415 mm

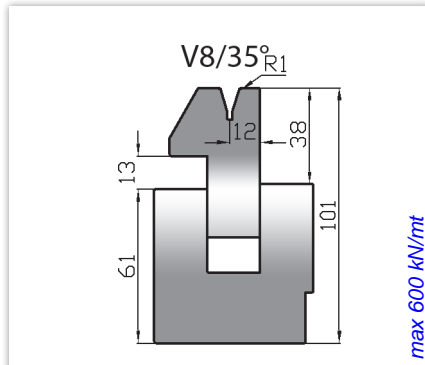


**US 220 NYL 30**  
 lunghezze-lengths 835 mm - 415 mm



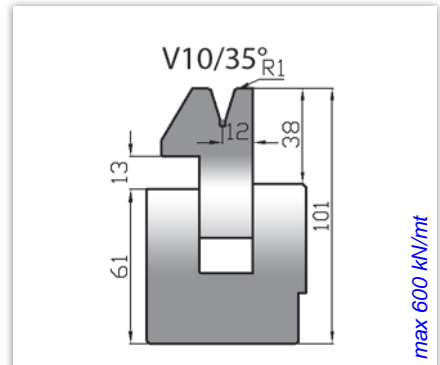
max 600 kN/mt

**US 303/35° V6**  
 altezza-height 101/88 mm  
 angolo-degree 35° raggio-radius 1,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm



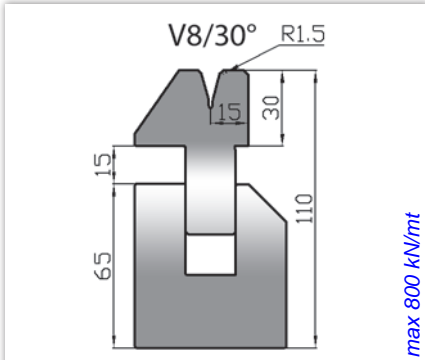
max 600 kN/mt

**US 303/35° V8**  
 altezza-height 101/88 mm  
 angolo-degree 35° raggio-radius 1,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm



max 600 kN/mt

**US 303/35° V10**  
 altezza-height 101/88 mm  
 angolo-degree 35° raggio-radius 1,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm

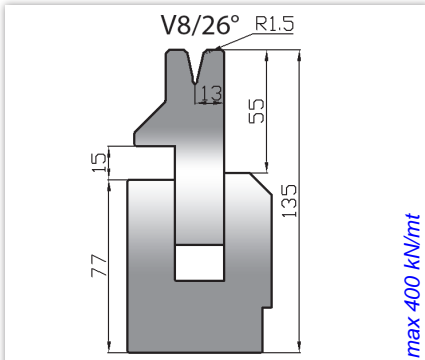


max 800 kN/mt

**US 306/30° V8**  
 altezza-height 110/95 mm  
 angolo-degree 30° raggio-radius 1,5 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm

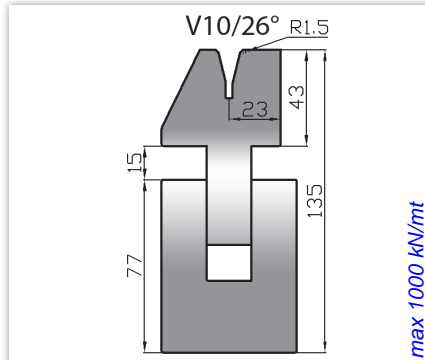
S mm	X	R 450 N/mm <sup>2</sup>	R 700 N/mm <sup>2</sup>
0,6	mm 3,0	90 kN/mt	150 kN/mt
0,8	mm 3,0	120 kN/mt	200 kN/mt
1	mm 3,5	150 kN/mt	250 kN/mt
1,2	mm 3,5	170 kN/mt	260 kN/mt
1,5	mm 4,6	220 kN/mt	380 kN/mt
2	mm 5,5	300 kN/mt	500 kN/mt
2,5	mm 6,5	550 kN/mt	900 kN/mt
3	mm 8,0	700 kN/mt	1000 kN/mt

S : spessore - thickness - R : resistenza - resistance



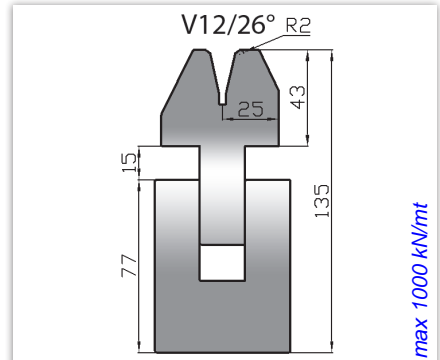
max 400 kN/mt

**US 308/26° V8**  
 altezza-height 135/120 mm  
 angolo-degree 26° raggio-radius 1,5 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm



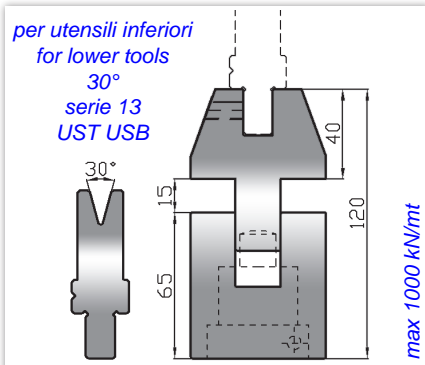
max 1000 kN/mt

**US 302/26° V10**  
 altezza-height 135/120 mm  
 angolo-degree 26° raggio-radius 1,5 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm



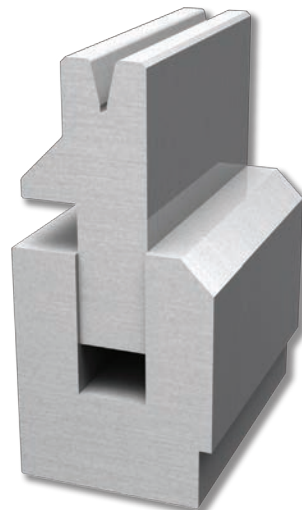
max 1000 kN/mt

**US 300/26° V12**  
 altezza-height 135/120 mm  
 angolo-degree 26° raggio-radius 2,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm

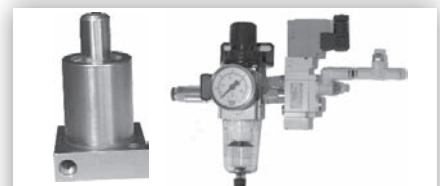


max 1000 kN/mt

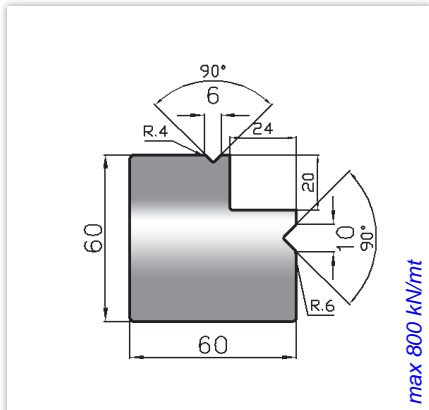
**US 301 - PNEUMATIC**  
 altezza-height 120/105 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 1000 mm - 500 mm



Utilizzare queste matrici con utensili superiori che hanno la stessa gradazione. La tempra ad induzione di questi utensili viene eseguita sia sulle parti di lavoro che su quelle di scorrimento.  
 Employ these hemming tools with upper tool having the same degree. Inductions hardened is applied on working surfaces and flowing parts.

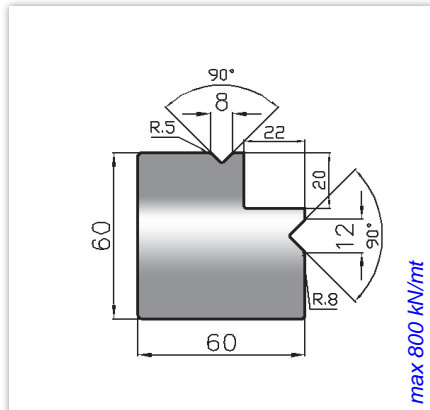


Gli utensili piegasciaccia serie 300 possono essere forniti con cilindri pneumatici per il sollevamento dell'elemento superiore.  
 The hemming tools 300 series can be supplied with pneumatic cylinders for moving upper element.  
**KIT/PNEU**



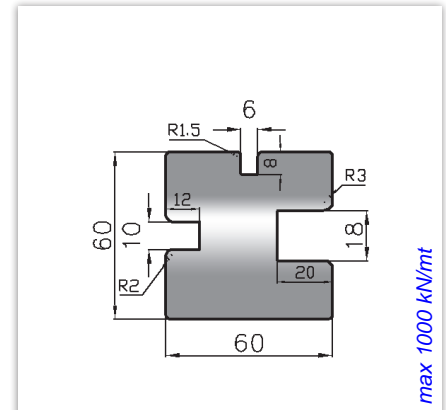
**US 216/90° V 6+10**  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt



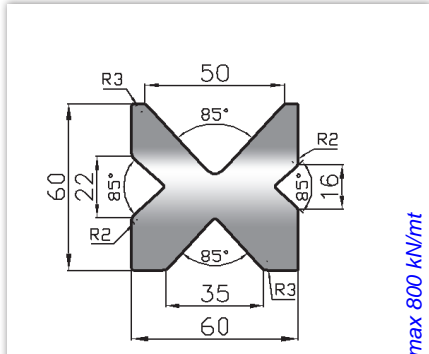
**US 217/90° V 8+12**  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt



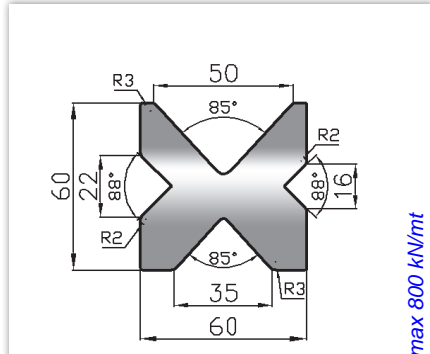
**US 208/3U 6-10-18 mm**  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



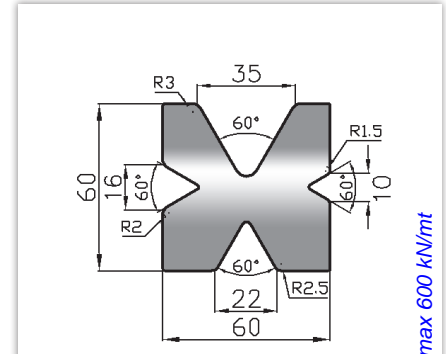
**US 205/4V**  
 dimensioni-dimensions 60x60 mm  
 cava V - slot V 16-22-35-50/85°  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt



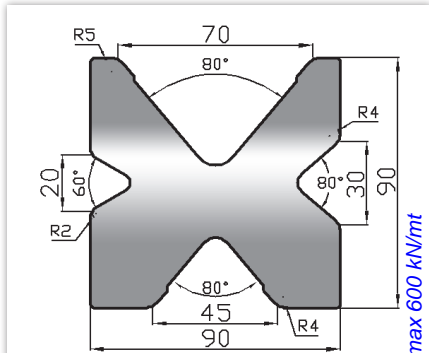
**US 209/4V**  
 dimensioni-dimensions 60x60 mm  
 cava V - slot V 16-22/88° 35-50/85°  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 800 kN/mt



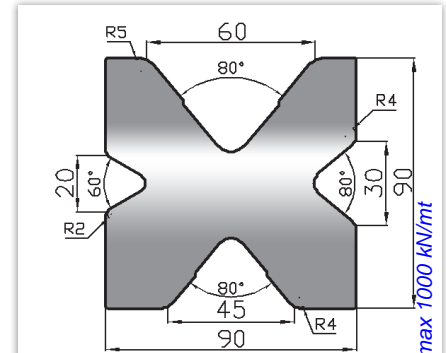
**US 210/4V**  
 dimensioni-dimensions 60x60 mm  
 cava V - slot V 10-16-22-35 / 60°  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 600 kN/mt



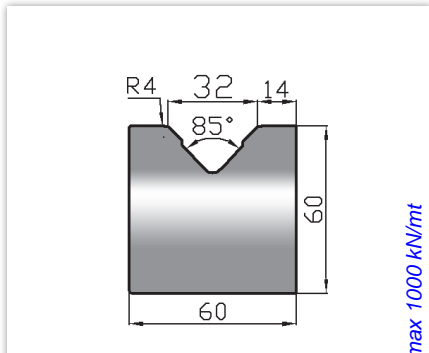
**US 203/4V (V 70 mm)**  
 dimensioni-dimensions 90x90 mm  
 cava V - slot V 20/60° 30-45-70/80°  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 600 kN/mt



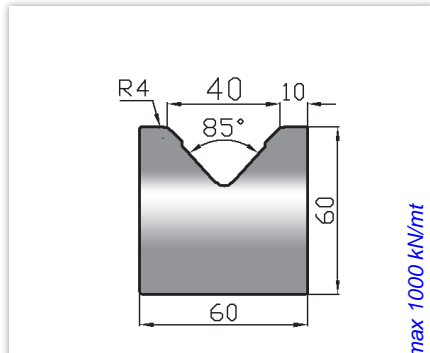
**US 204/4V (V 60 mm)**  
 dimensioni-dimensions 90x90 mm  
 cava V - slot V 20/60° 30-45-60/80°  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



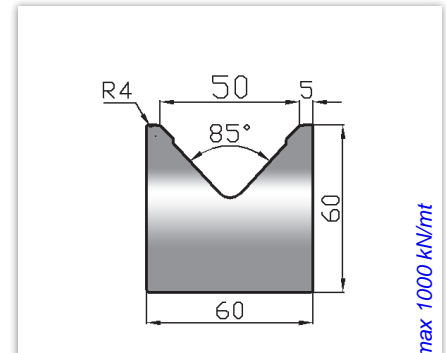
**US 211/32**  
 altezza-height 60 mm  
 angolo-degree 85° raggio-radius 4,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



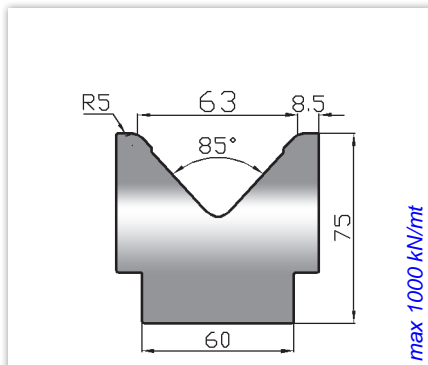
**US 211/40**  
 altezza-height 60 mm  
 angolo-degree 85° raggio-radius 4,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



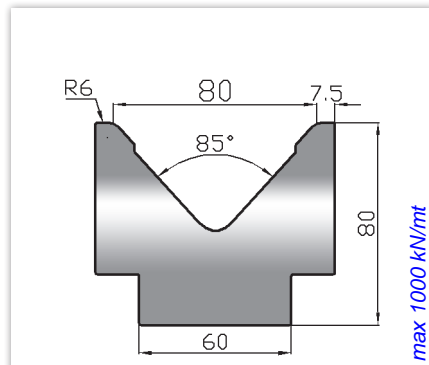
**US 211/50**  
 altezza-height 60 mm  
 angolo-degree 85° raggio-radius 4,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

max 1000 kN/mt



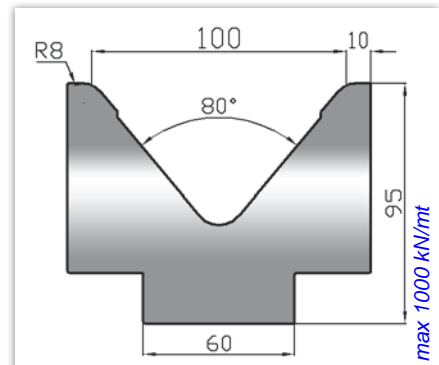
### US 211/63

altezza-height 75 mm  
 angolo-degree 85° raggio-radius 5,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



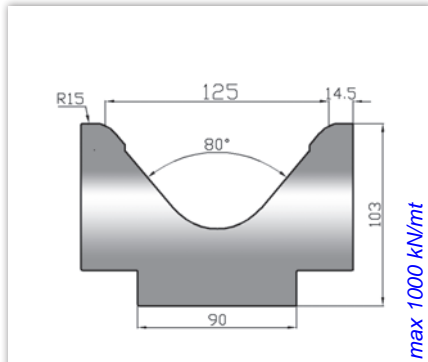
### US 211/80

altezza-height 80 mm  
 angolo-degree 85° raggio-radius 6,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



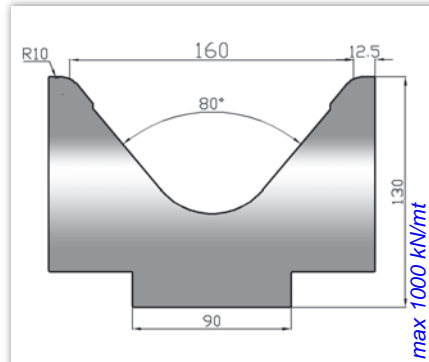
### US 211/100

altezza-height 95 mm  
 angolo-degree 80° raggio-radius 8,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



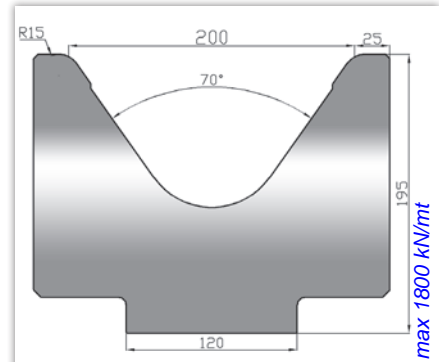
### US 211/125

altezza-height 103 mm  
 angolo-degree 80° raggio-radius 15,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



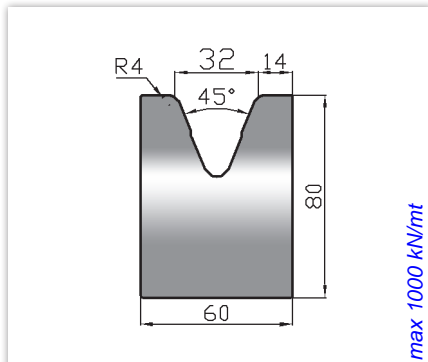
### US 211/160

altezza-height 130 mm  
 angolo-degree 80° raggio-radius 10,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



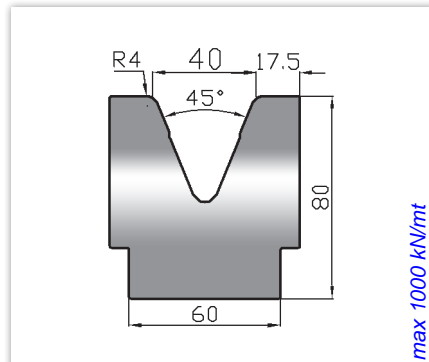
### US 211/200

altezza-height 195 mm  
 angolo-degree 70° raggio-radius 15,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 415 mm



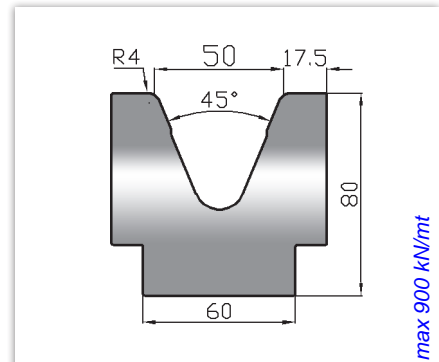
### US 220/45° V32

altezza-height 80 mm  
 angolo-degree 45° raggio-radius 4,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



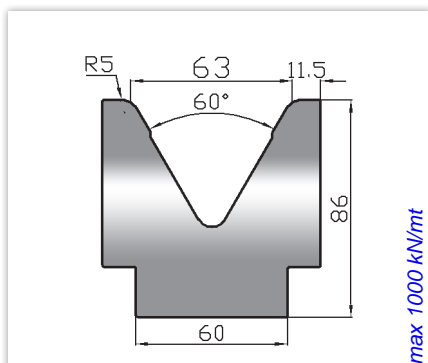
### US 220/45° V40

altezza-height 80 mm  
 angolo-degree 45° raggio-radius 4,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



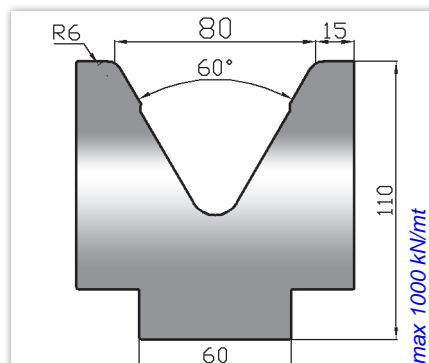
### US 220/45° V50

altezza-height 80 mm  
 angolo-degree 45° raggio-radius 4,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



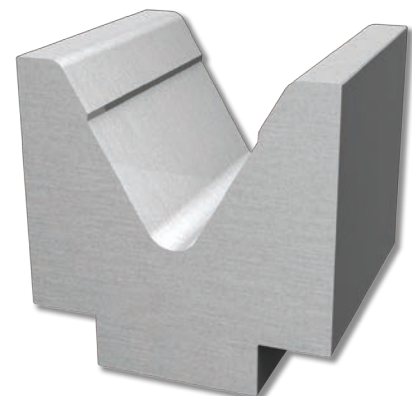
### US 220/60° V63

altezza-height 86 mm  
 angolo-degree 60° raggio-radius 5,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz



### US 220/60° V80

altezza-height 110 mm  
 angolo-degree 60° raggio-radius 6,0 mm  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz





**US 206/90° V 4 + 7**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt

**US 212/90° V 6 + 10**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt

**US 213/90° V 8 + 12**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt

**US 212/88° V 6 + 10**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt

**US 213/88° V 8 + 12**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

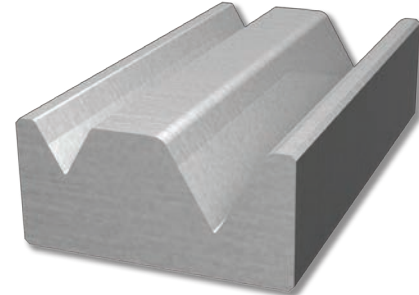
max 1000 kN/mt

**US 207/88° V 14 + 18**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt

**US 214/88° V 12 + 20**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt



**US 215/88° V 16 + 25**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt

**US 218/60° V 6 + 10**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 600 kN/mt

**US 219/60° V 8 + 12**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 800 kN/mt

**US 221/60° V 12 + 20**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 800 kN/mt

**US 222/60° V 16 + 20**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 800 kN/mt

**US 223/35° V 6 + 10**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 300 kN/mt

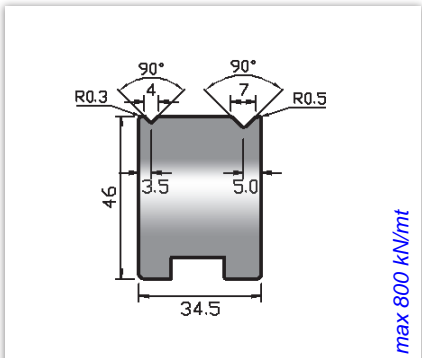
**US 224/35° V 8 + 12**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

max 300 kN/mt

**US 406/34**  
altezza-height 34 mm  
C45 rettificato-grinding  
lunghezze-lengths 830 mm - 410 mm

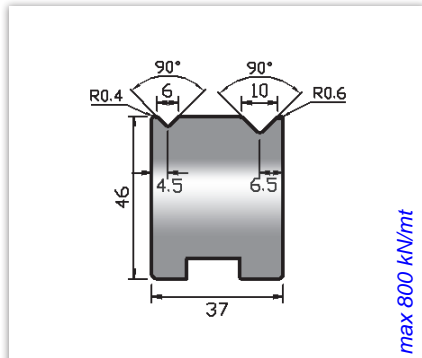
**US 407/55**  
altezza-height 55 mm  
C45 rettificato-grinding  
lunghezze-lengths 830 mm - 410 mm

**US 408/75**  
altezza-height 75 mm  
C45 rettificato-grinding  
lunghezze-lengths 830 mm - 410 mm



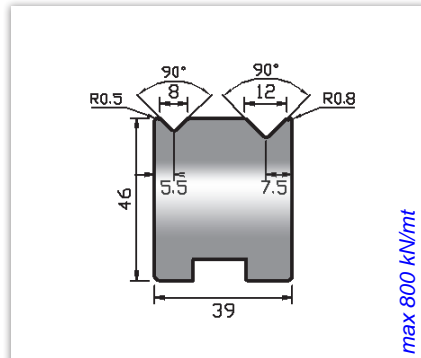
max 800 kN/mt

**US 510/90° V 4 + 7**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz



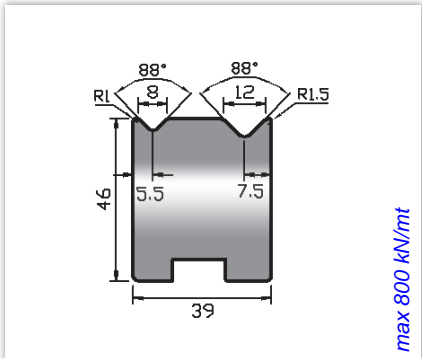
max 800 kN/mt

**US 520/90° V 6 + 10**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz



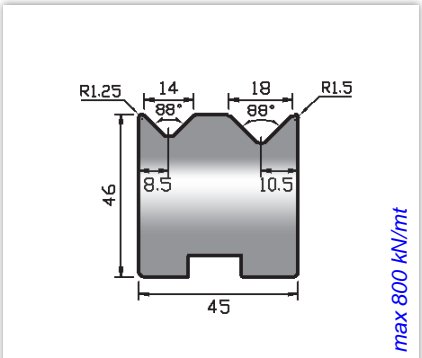
max 800 kN/mt

**US 530/90° V 8 + 12**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz



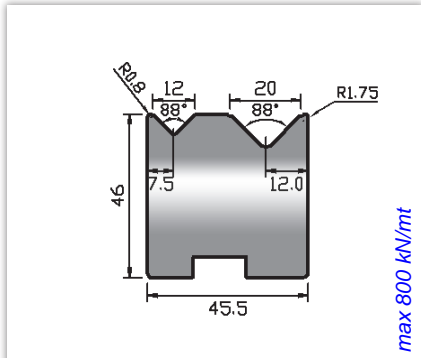
max 800 kN/mt

**US 540/88° V 8 + 12**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz



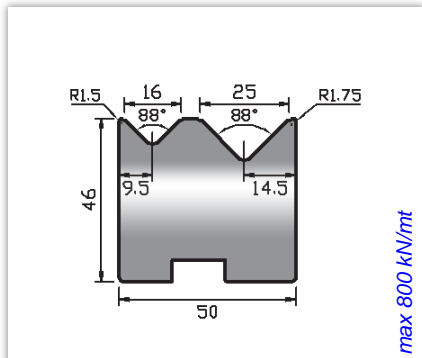
max 800 kN/mt

**US 550/88° V 14 + 18**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz



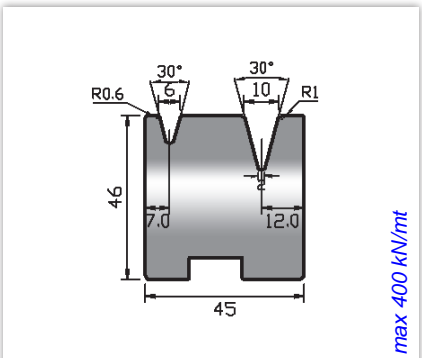
max 800 kN/mt

**US 560/88° V 12 + 20**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz



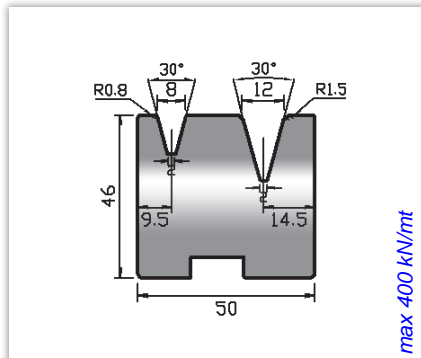
max 800 kN/mt

**US 570/88° V 16 + 25**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz



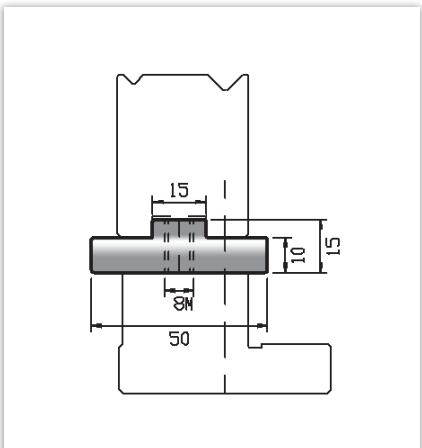
max 400 kN/mt

**US 580/30° V 6 + 10**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz

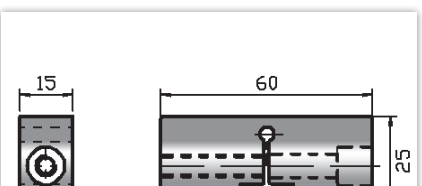
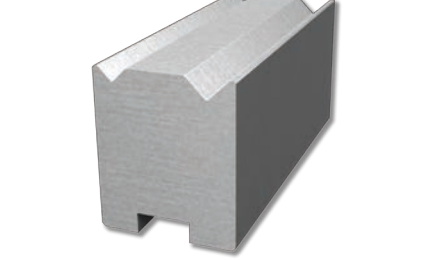


max 400 kN/mt

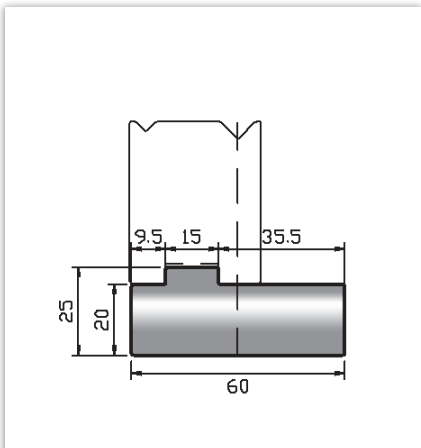
**US 590/30° V 8 + 12**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm - fraz



**US 500**  
altezza-height 10 mm  
C45 rettificato-grinding  
lunghezze-lengths 835 mm - 415 mm



**US 501**



**US 505**  
altezza-height 20 mm  
C45 rettificato-grinding  
lunghezze-lengths 835 mm - 415 mm

**US 250 - 50 x 50 mm**  
 USG 50 - 82 shore (giallo-yellow)  
 USG 50/F - 92 shore (rosso-red)  
 lunghezze-lengths 835 mm - 415 mm

**US 275 - 75 x 50 mm**  
 USG 75 - 82 shore (giallo-yellow)  
 USG 75/F - 92 shore (rosso-red)  
 lunghezze-lengths 835 mm - 415 mm

**US 2100 - 100 x 50 mm**  
 USG 100 - 82 shore (giallo-yellow)  
 USG 100/F - 92 shore (rosso-red)  
 lunghezze-lengths 835 mm - 415 mm

**US 600**  
 C45 rettificato-grinding  
 lunghezze-lengths 835 mm - 415 mm

**US 6xx/XX°**  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

	A°	V mm	H mm	R mm	S mm	max kN/mt
88°	US 604/88°	4	60	0,6	14	1000
	US 606/88°	6	60	0,8	14	1000
	US 608/88°	8	60	1,0	14	1000
	US 610/88°	10	60	1,2	18	1000
	US 612/88°	12	60	1,5	18	1000
	US 616/88°	16	60	2,0	24	1000
	US 620/88°	20	60	2,0	30	1000
30°	US 625/88°	25	60	3,0	35	1000
	US 606/30°	6	60	0,6	14	350
	US 608/30°	8	60	0,8	18	350
	US 610/30°	10	60	1,0	24	500
	US 612/30°	12	60	1,5	24	400
	US 616/30°	16	60	2,0	30	450
	US 620/30°	20	60	2,5	35	500
	US 625/30°	25	65	3,0	45	500

**ATTACCHI SPECIALI  
 SPECIAL CLAMPINGS**

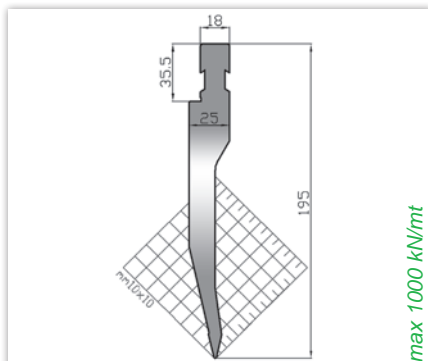
**US 7xx/XX°**  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm - fraz

	A°	V mm	D mm	S mm	max kN/mt
30°	US 706/30°	6	6 Ø	25	500
	US 708/30°	8	6 Ø	26	500
	US 710/30°	10	6 Ø	27	500
	US 712/30°	12	6 Ø	29	500
	US 716/30°	16	8 Ø	40	500
70°	US 720/30°	20	8 Ø	44	500
	US 706/70°	6	6 Ø	25	800
	US 708/70°	8	6 Ø	26	800
	US 710/70°	10	6 Ø	27	800
	US 712/70°	12	6 Ø	29	800
78°	US 716/70°	16	8 Ø	37	1000
	US 720/70°	20	8 Ø	42	1000
	US 725/70°	25	8 Ø	48	1000
	US 730/70°	30	8 Ø	60	1000
	US 740/78°	40	10 Ø	72	1100
	US 750/78°	50	10 Ø	82	1200
	US 760/78°	60	12 Ø	102	1300
	US 780/78°	80	16 Ø	132	1400

**835**      **415**

**10 15 20 40 50 100 200 370**

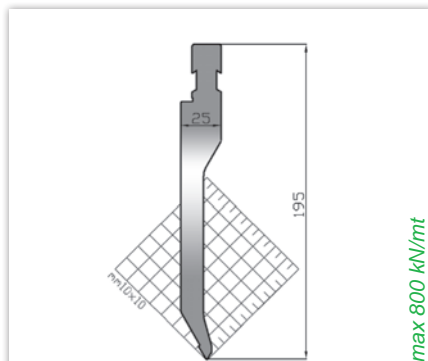
**LUNGHEZZE - LENGTHS**      835 mm 415 mm fraz



max 1000 kN/mt

### USC 195/26° R0,8

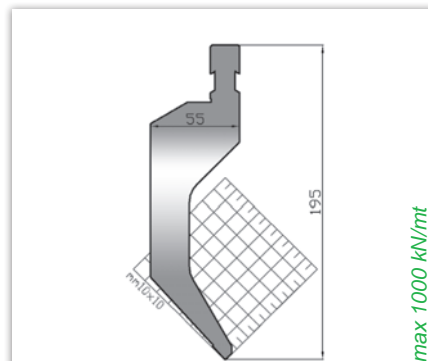
altezza-height 195 mm  
 angolo-degree 26° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 525 mm - fraz A - fraz B



max 800 kN/mt

### USC 195/60° R0,8

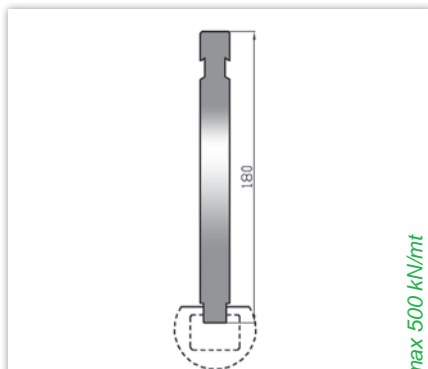
altezza-height 195 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 525 mm - fraz A - fraz B



max 1000 kN/mt

### USC 195/85° R0,8

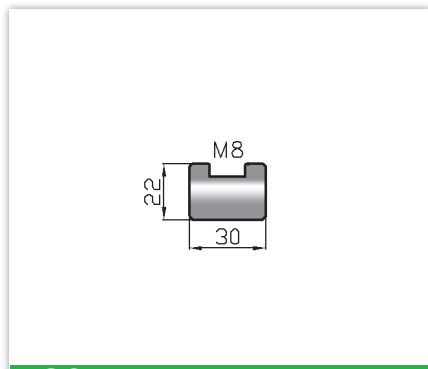
altezza-height 195 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 525 mm - fraz A - fraz B



max 500 kN/mt

### USC 180

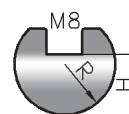
altezza-height 180 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 C45 rettificato-grinding  
 lunghezze-lengths 525 mm



### USC 310

C45 rettificato-grinding  
**USC 310 T**  
 C45 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 525 mm

3 fori/holes mm. 53,5-209...-53.5=mm 525



raggio-radius altezza-height

	raggio-radius	altezza-height
USC 305/R 8	8	10 mm
USC 305/R 9	9	10 mm
USC 305/R 10	10	12 mm
USC 305/R 12,5	12,5	17 mm
USC 305/R 15	15	20 mm
USC 305/R 17,5	17,5	22 mm
USC 305/R 20	20	24 mm
USC 305/R 22,5	22,5	25 mm
USC 305/R 25	25	29 mm
USC 305/R 27,5	27,5	34 mm
USC 305/R 30	30	34 mm
USC 305/R 35	35	45 mm
USC 305/R 40	40	44 mm
USC 305/R 45	45	50 mm
USC 305/R 50	50	54 mm

C45 rettificato-grinding

**(N)** 39NiCrMo3 NITRURATO rettificato-grinding  
 lunghezze-lengths 525 mm

525 mm

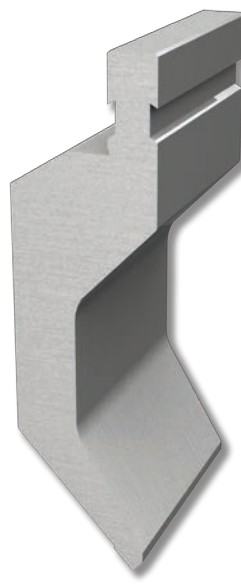
495 fraz A

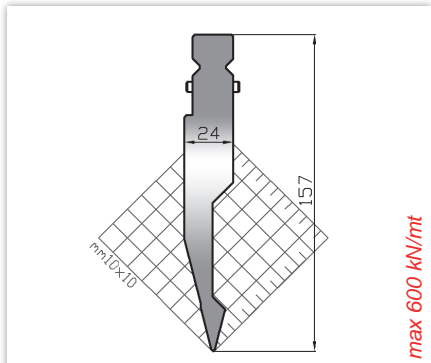
mm 25+30+35+40+45+50+100+170

500 fraz B

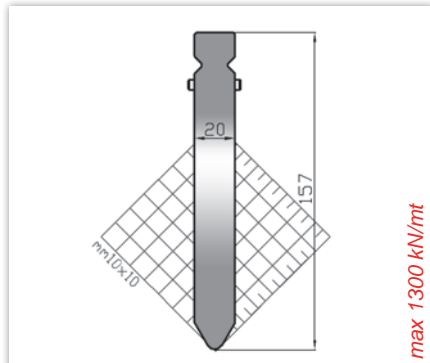
mm 100sx+100dx+300

LUNGHEZZE - LENGTHS

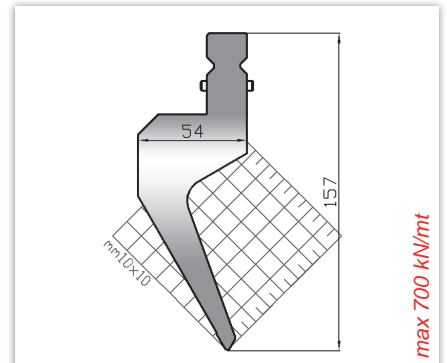




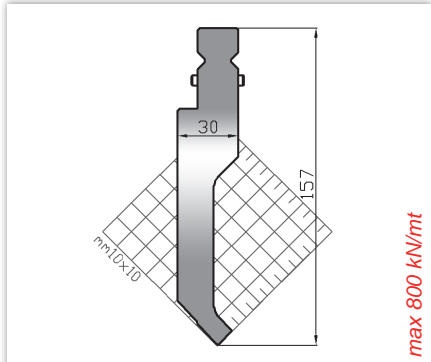
**UST 157 X / 28° R1,0**  
 altezza-height 157 mm  
 angolo-degree 28° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L  
 max 600 kN/mt



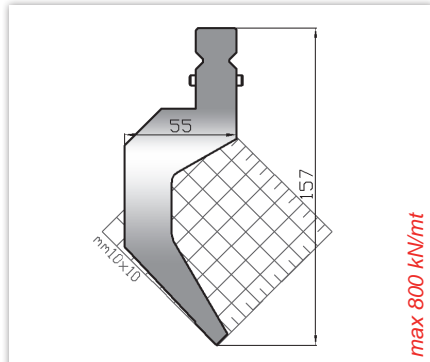
**UST 157 S / 60° R4,0**  
 altezza-height 157 mm  
 angolo-degree 60° raggio-radius 4,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L  
 max 1300 kN/mt



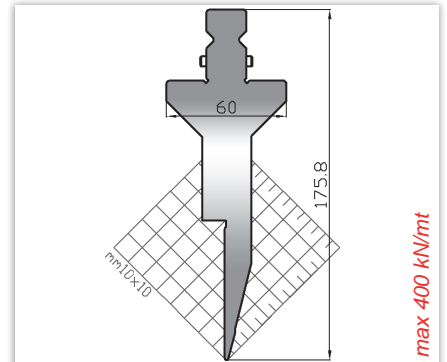
**UST 157 C / 60° R1,0**  
 altezza-height 157 mm  
 angolo-degree 60° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L  
 max 700 kN/mt



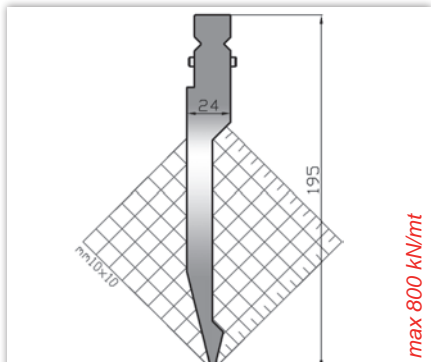
**UST 157 D / 86° R1,0**  
 altezza-height 157 mm  
 angolo-degree 86° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L  
 max 800 kN/mt



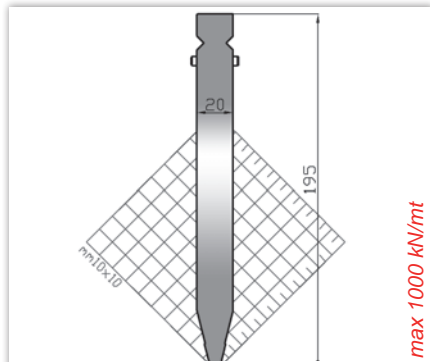
**UST 157 C / 86° R1,0**  
 altezza-height 157 mm  
 angolo-degree 86° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L  
 max 800 kN/mt



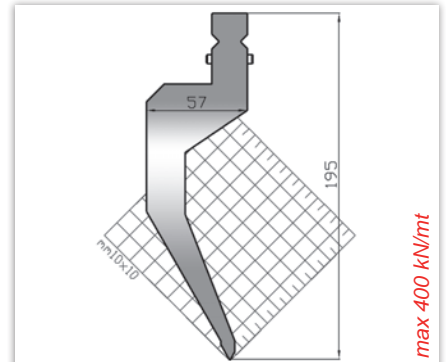
**UST 176 SP / 28° R1,0**  
 altezza-height 175,8 mm  
 angolo-degree 28° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L  
 max 400 kN/mt



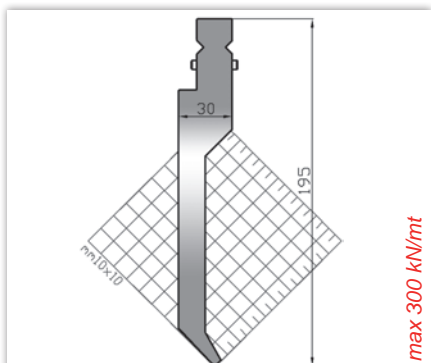
**UST 195 X / 28° R1,0**  
 altezza-height 195 mm  
 angolo-degree 28° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz B  
 max 800 kN/mt



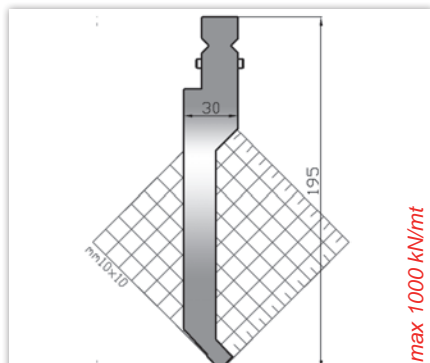
**UST 195 S / 28° R3,0**  
 altezza-height 195 mm  
 angolo-degree 28° raggio-radius 3,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz B  
 max 1000 kN/mt



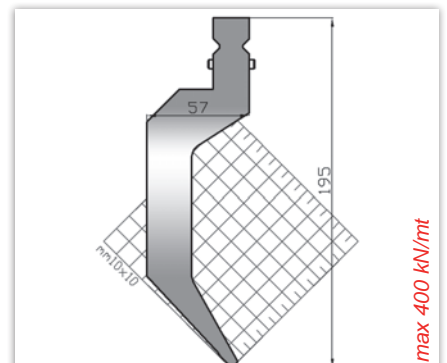
**UST 195 C / 60° R0,8**  
 altezza-height 195 mm  
 angolo-degree 60° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz B  
 max 400 kN/mt



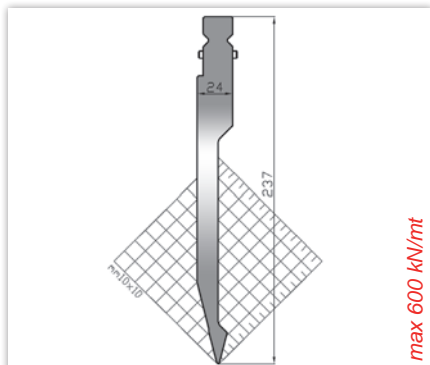
**UST 195 D / 86° R0,6**  
 altezza-height 195 mm  
 angolo-degree 86° raggio-radius 0,6 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz B  
 max 300 kN/mt



**UST 195 D / 86° R0,8**  
 altezza-height 195 mm  
 angolo-degree 86° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz B  
 max 1000 kN/mt



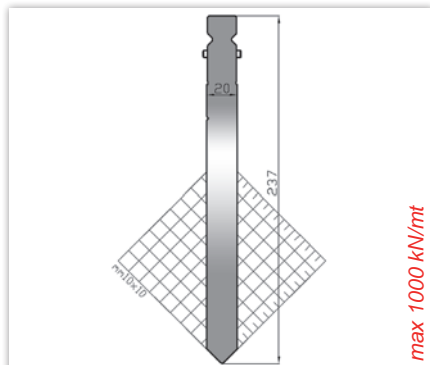
**UST 195 C / 86° R0,8**  
 altezza-height 195 mm  
 angolo-degree 86° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz B  
 max 400 kN/mt



max 600 kN/mt

**UST 237 X / 28° R1,0**

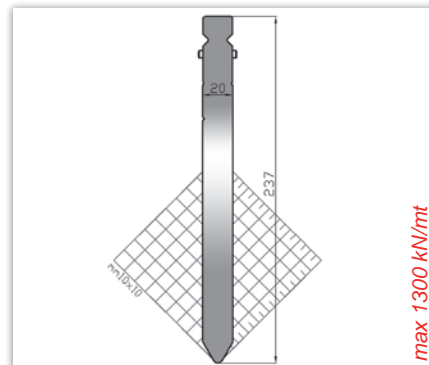
altezza-height 237 mm  
 angolo-degree 28° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 515 mm - 550 fraz L



max 1000 kN/mt

**UST 237 S / 90° R1,2**

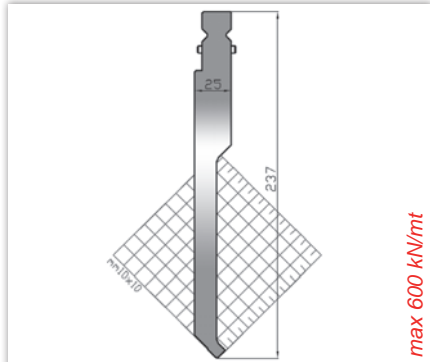
altezza-height 237 mm  
 angolo-degree 90° raggio-radius 1,2 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 515 mm - 550 fraz L



max 1300 kN/mt

**UST 237 S / 60° R3,0**

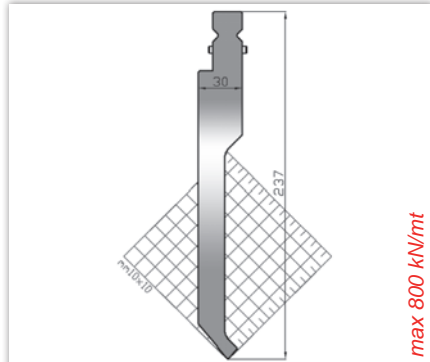
altezza-height 237 mm  
 angolo-degree 60° raggio-radius 3,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 515 mm - 550 fraz L



max 600 kN/mt

**UST 237 D / 90° R0,6**

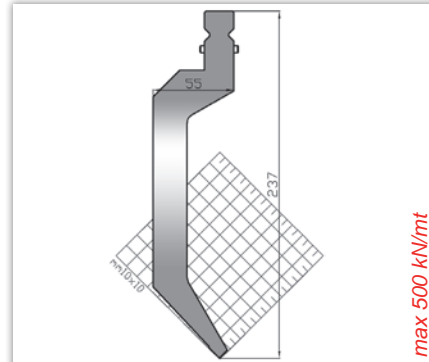
altezza-height 237 mm  
 angolo-degree 90° raggio-radius 0,6 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 515 mm - 550 fraz L



max 800 kN/mt

**UST 237 D / 80° R1,0**

altezza-height 237 mm  
 angolo-degree 80° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 515 mm - 550 fraz L

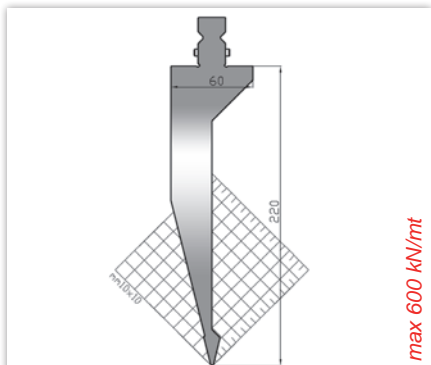


max 500 kN/mt

**UST 237 C / 86° R1,0**

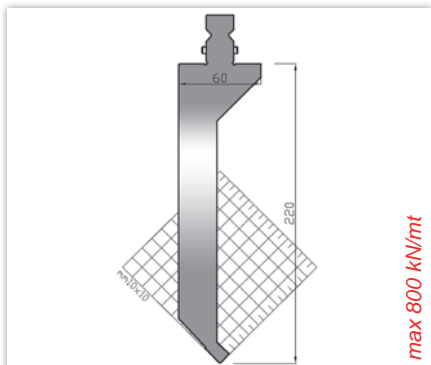
altezza-height 237 mm  
 angolo-degree 86° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 515 mm - 550 fraz L





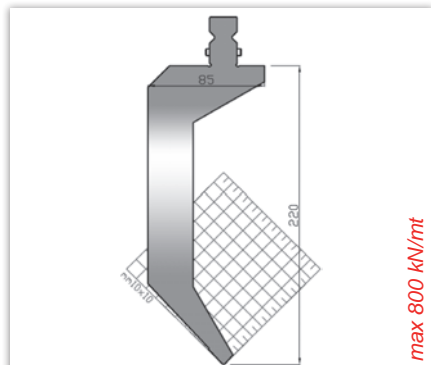
**UST 28° R1,0/S**  
 altezza-height 220 mm  
 angolo-degree 28° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L

max 600 kN/mt



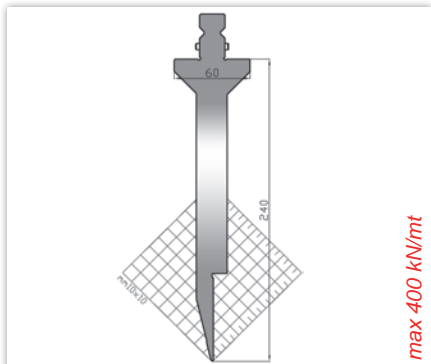
**UST 86° R1,0/A**  
 altezza-height 220 mm  
 angolo-degree 86° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L

max 800 kN/mt



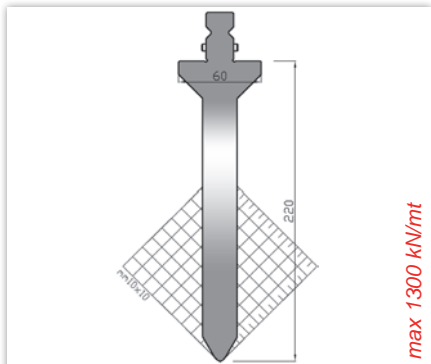
**UST 86° R1,0/S**  
 altezza-height 220 mm  
 angolo-degree 86° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L

max 800 kN/mt



**UST 28° R1,0/SP**  
 altezza-height 240 mm  
 angolo-degree 28° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L

max 400 kN/mt



**UST 60° R4,0/S**  
 altezza-height 220 mm  
 angolo-degree 60° raggio-radius 4,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-L

max 1300 kN/mt



500 mm - 515 mm

attacco utensile con spine o pulsante  
 tool clamping with pins or push-button

frazionatura / sect. A

L.mm.	25	30	35	40	45	50	100 L	100 R	100	
1250	2	1	1	1	1	1	1	1	8	= 17 pz / pcs
2050	2	1	1	1	1	1	1	1	16	= 25 pz / pcs
2550	2	1	1	1	1	1	1	1	21	= 30 pz / pcs
3050	2	1	1	1	1	1	1	1	26	= 35 pz / pcs
4050	2	1	1	1	1	1	1	1	36	= 45 pz / pcs



frazionatura / sect. B

L.mm.	25	30	35	40	45	50	100 L	100 R	100	200	300	
1250	2	1	1	1	1	1	1	1	1	2	1	= 13 pz / pcs
2050	2	1	1	1	1	1	1	1	1	3	3	= 16 pz / pcs
2550	2	1	1	1	1	1	1	1	1	4	4	= 18 pz / pcs
3050	2	1	1	1	1	1	1	1	1	5	5	= 20 pz / pcs
4050	2	1	1	1	1	1	1	1	1	7	7	= 24 pz / pcs

frazionatura / sect. C

L.mm.	25	30	35	40	45	50	
250	2	1	1	1	1	1	= 7 pz / pcs

frazionatura / sect. L

L.mm.	20	25	30	35	40	100 L	100 R	200	
550	1	1	1	1	1	1	1	1	= 8 pz / pcs

LUNGHEZZE - LENGTHS

**UST 256** altezza-height 256 mm  
raggio-radius min 8 mm - max 50 mm  
C45 rettificato-grinding  
lunghezze-lengths 830 mm - 412 mm

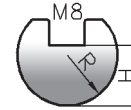
max 1000 kN/mt

**UST 140** altezza-height 140 mm  
raggio-radius min 8 mm - max 50 mm  
C45 rettificato-grinding  
lunghezze-lengths 830 mm - 412 mm

max 1000 kN/mt

**UST 310**  
C45 rettificato-grinding  
**UST 310 T**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

4 fori/holes mm. 104-209...-104 = mm 835  
2 fori/holes mm. 103-209...-103 = mm 415



	raggio-radius	altezza-height
<b>US 305/R 8</b>	8	10 mm
<b>US 305/R 9</b>	9	10 mm
<b>US 305/R 10</b>	10	12 mm
<b>US 305/R 12,5</b>	12,5	17 mm
<b>US 305/R 15</b>	15	20 mm
<b>US 305/R 17,5</b>	17,5	22 mm
<b>US 305/R 20</b>	20	24 mm
<b>US 305/R 22,5</b>	22,5	25 mm
<b>US 305/R 25</b>	25	29 mm
<b>US 305/R 27,5</b>	27,5	34 mm
<b>US 305/R 30</b>	30	34 mm
<b>US 305/R 35</b>	35	45 mm
<b>US 305/R 40</b>	40	44 mm
<b>US 305/R 45</b>	45	50 mm
<b>US 305/R 50</b>	50	54 mm

C45 rettificato-grinding  
(N) 39NiCrMo3 NITRURATO rettificato-grinding  
lunghezze-lengths 835 mm - 415 mm

**UST 130**  
C45 rettificato-grinding  
lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt

**US 131 Z 1,0 - 12 mm**  
C45 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 835 mm - 415 mm

ZIPA°	Z mm	A°	MAX spessore thickness	altezza height mm
<b>US 131/ 1</b>	1,0	160°	0,5 mm	37
<b>US 131/1,5</b>	1,5	160°	0,6 mm	37
<b>US 131/ 2</b>	2,0	150°	0,8 mm	37
<b>US 131/2,5</b>	2,5	140°	1,0 mm	37
<b>US 131/ 3</b>	3,0	90°	1,0 mm	37
<b>US 131/3,5</b>	3,5	90°	1,2 mm	37
<b>US 131/ 4</b>	4,0	90°	1,2 mm	37
<b>US 131/4,5</b>	4,5	90°	1,5 mm	37
<b>US 131/ 5</b>	5,0	90°	1,5 mm	37
<b>US 131/5,5</b>	5,5	90°	1,5 mm	37
<b>US 131/ 6</b>	6,0	90°	1,5 mm	37
<b>US 131/6,5</b>	6,5	90°	1,5 mm	37
<b>US 131/ 7</b>	7,0	90°	2,0 mm	37
<b>US 131/7,5</b>	7,5	90°	2,0 mm	37
<b>US 131/ 8</b>	8,0	90°	2,5 mm	37
<b>US 131/ 9</b>	9,0	90°	2,5 mm	45
<b>US 131/10</b>	10,0	90°	3,0 mm	45
<b>US 131/11</b>	11,0	90°	3,0 mm	45
<b>US 131/12</b>	12,0	90°	3,0 mm	45

**UST 138 L8 + M8**  
altezza-height 195 - 100 mm  
angolo-degree 24° raggio-radius 0,6-1,0 mm  
42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 500 mm - 550 fraz

max 800 kN/mt

**UST 138 L10 + M10**  
altezza-height 195 - 100 mm  
angolo-degree 24° raggio-radius 0,6-1,0 mm  
42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 500 mm - 550 fraz

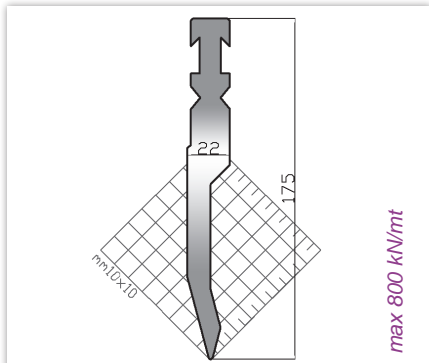
max 800 kN/mt

**UST 138 L12 + M12**  
altezza-height 195 - 100 mm  
angolo-degree 24° raggio-radius 0,6-1,0 mm  
42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58  
lunghezze-lengths 500 mm - 550 fraz

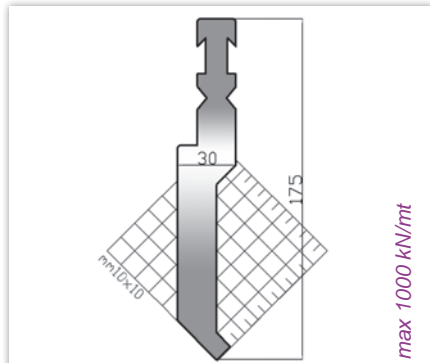
max 800 kN/mt

Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura. Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.  
We suggest to use these tools on synchronized press brakes as it is necessary to change quickly press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on bend crushed.

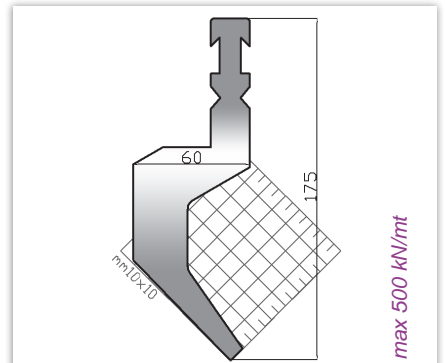




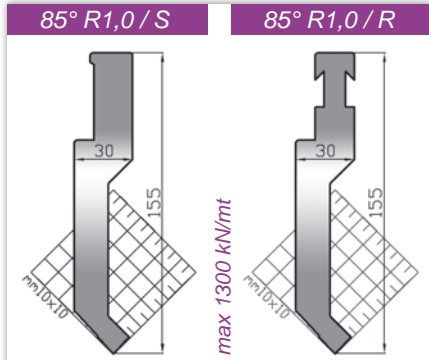
**USB 175/30° R1 RFA**  
 altezza-height 175 mm  
 angolo-degree 30° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz  
 max 800 kN/mt



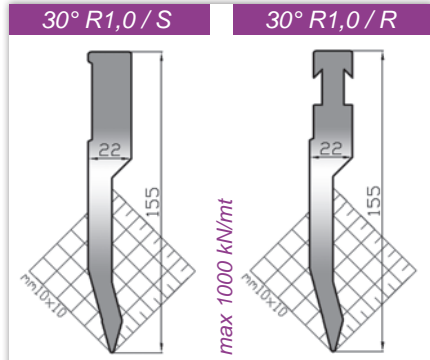
**USB 175/88° D R1 RFA**  
 altezza-height 175 mm  
 angolo-degree 88° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz  
 max 1000 kN/mt



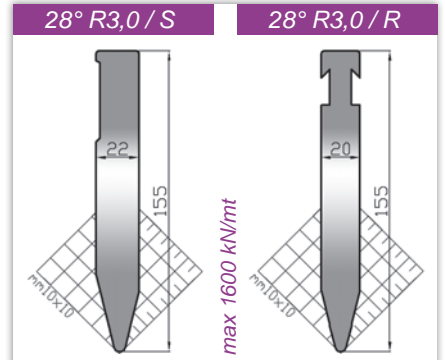
**USB 175/88°C R1,5 RFA**  
 altezza-height 175 mm  
 angolo-degree 88° raggio-radius 1,5 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz  
 max 500 kN/mt



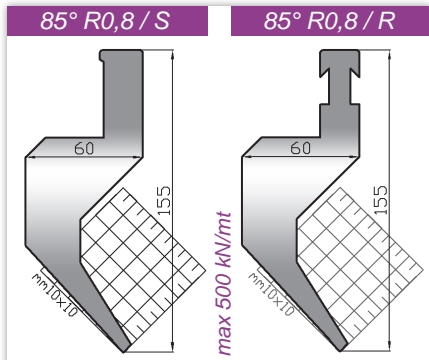
**USB 155/85° D**  
 altezza-height 155 mm  
 angolo-degree 85° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz  
 max 1300 kN/mt



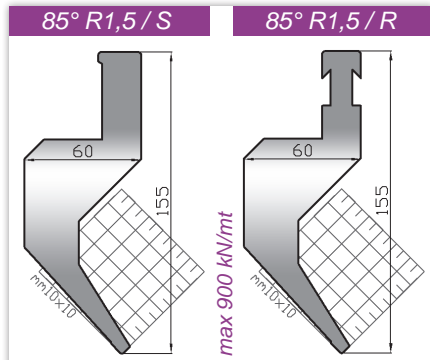
**USB 155/30°**  
 altezza-height 155 mm  
 angolo-degree 30° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz  
 max 1000 kN/mt



**USB 155/28°**  
 altezza-height 155 mm  
 angolo-degree 28° raggio-radius 3,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz  
 max 1600 kN/mt

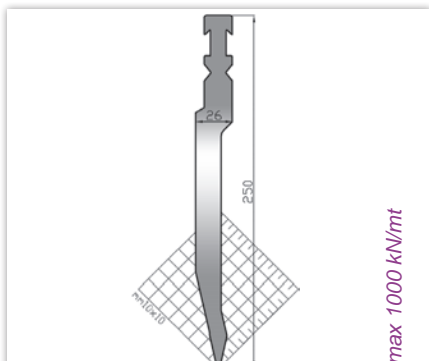


**USB 155/85° C**  
 altezza-height 155 mm  
 angolo-degree 85° raggio-radius 0,8 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz  
 max 500 kN/mt

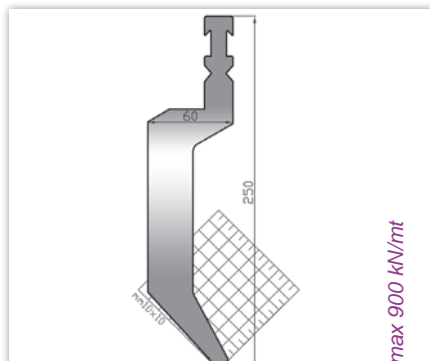


**USB 155/85° C**  
 altezza-height 155 mm  
 angolo-degree 85° raggio-radius 1,5 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz  
 max 900 kN/mt

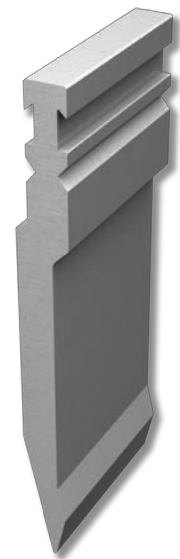
500 mm  
 1000 mm  
 1100 mm fraz  
 mm 10-15-20-30-40-50-60  
 75-100-200-300-100sx-100dx  
**LUNGHEZZE - LENGTHS**



**USB 250/26° R1,0 RFA**  
 altezza-height 250 mm  
 angolo-degree 26° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 508-1100 fraz  
 max 1000 kN/mt



**USB 250/85° R1,5 RFA**  
 altezza-height 250 mm  
 angolo-degree 85° raggio-radius 1,5 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 508-1100 fraz  
 max 900 kN/mt



508 mm  
 1100 mm fraz  
 mm 10-15-20-30-50-300-375  
 100dx-200sx  
**LUNGHEZZE - LENGTHS**

**USB 140/S**      **USB 140/R**

**USB 140**  
 altezza-height 140 mm  
 raggio-radius min 8 mm - max 50 mm  
**C45 rettificato-grinding**  
 lunghezze-lengths 830 mm - 412 mm

max 1000 kN/mt

**US 310**  
**C45 rettificato-grinding**  
**US 310 T**  
**C45 rettificato-grinding**  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm

4 fori/holes mm. 104-209...-104 = mm 835  
 2 fori/holes mm. 103-209...-103 = mm 415

	raggio-radius	altezza-height
<b>US 305/R 8</b>	8	10 mm
<b>US 305/R 9</b>	9	10 mm
<b>US 305/R 10</b>	10	12 mm
<b>US 305/R 12,5</b>	12,5	17 mm
<b>US 305/R 15</b>	15	20 mm
<b>US 305/R 17,5</b>	17,5	22 mm
<b>US 305/R 20</b>	20	24 mm
<b>US 305/R 22,5</b>	22,5	25 mm
<b>US 305/R 25</b>	25	29 mm
<b>US 305/R 27,5</b>	27,5	34 mm
<b>US 305/R 30</b>	30	34 mm
<b>US 305/R 35</b>	35	45 mm
<b>US 305/R 40</b>	40	44 mm
<b>US 305/R 45</b>	45	50 mm
<b>US 305/R 50</b>	50	54 mm

**C45 rettificato-grinding**  
**(N) 39NiCrMo3 NITRURATO rettificato-grinding**  
 lunghezze-lengths 835 mm - 415 mm

**USB 130**  
**C45 rettificato-grinding**  
 lunghezze-lengths 835 mm - 415 mm

max 1000 kN/mt

**US 131 Z 1,0 - 12 mm**  
**C45 rettificato-grinding**  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 835 mm - 415 mm

<b>ZIP A°</b>	<b>Z</b> mm	<b>A°</b>	<b>MAX</b> spessore thickness	altezza height mm
<b>US 131/ 1</b>	1,0	160°	0,5 mm	37
<b>US 131/1,5</b>	1,5	160°	0,6 mm	37
<b>US 131/ 2</b>	2,0	150°	0,8 mm	37
<b>US 131/2,5</b>	2,5	140°	1,0 mm	37
<b>US 131/ 3</b>	3,0	90°	1,0 mm	37
<b>US 131/3,5</b>	3,5	90°	1,2 mm	37
<b>US 131/ 4</b>	4,0	90°	1,2 mm	37
<b>US 131/4,5</b>	4,5	90°	1,5 mm	37
<b>US 131/ 5</b>	5,0	90°	1,5 mm	37
<b>US 131/5,5</b>	5,5	90°	1,5 mm	37
<b>US 131/ 6</b>	6,0	90°	1,5 mm	37
<b>US 131/6,5</b>	6,5	90°	1,5 mm	37
<b>US 131/ 7</b>	7,0	90°	2,0 mm	37
<b>US 131/7,5</b>	7,5	90°	2,0 mm	37
<b>US 131/ 8</b>	8,0	90°	2,5 mm	37
<b>US 131/ 9</b>	9,0	90°	2,5 mm	45
<b>US 131/10</b>	10,0	90°	3,0 mm	45
<b>US 131/11</b>	11,0	90°	3,0 mm	45
<b>US 131/12</b>	12,0	90°	3,0 mm	45

**V8**

**USB 138 L8 + M8**  
 altezza-height 195 - 100 mm  
 angolo-degree 24° raggio-radius 0,6-1,0 mm  
**42CrMo4 rettificato-grinding**  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - 550 fraz

max 800 kN/mt

max 500 kN/mt

**V10**

**USB 138 L10 + M10**  
 altezza-height 195 - 100 mm  
 angolo-degree 24° raggio-radius 0,6-1,0 mm  
**42CrMo4 rettificato-grinding**  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - 550 fraz

max 800 kN/mt

max 500 kN/mt

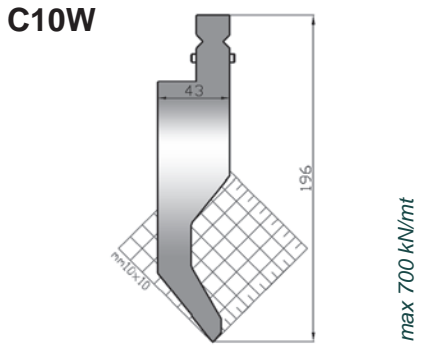
**V12**

**USB 138 L12 + M12**  
 altezza-height 195 - 100 mm  
 angolo-degree 24° raggio-radius 0,6-1,0 mm  
**42CrMo4 rettificato-grinding**  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - 550 fraz

max 800 kN/mt

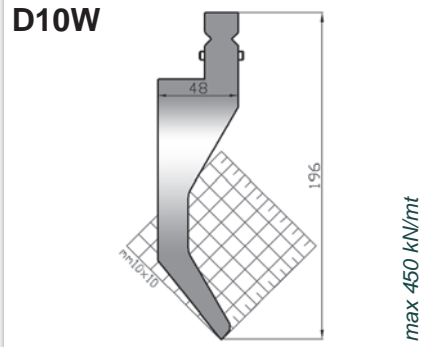
max 500 kN/mt

Si consiglia di utilizzare questi utensili su presse piegatrici sincronizzate in quanto occorre variare rapidamente la corsa della pressa tra la fase di piegatura e quella di schiacciatura. Non è possibile aumentare il raggio della matrice in quanto si potrebbero verificare deformazioni anomale della piega schiacciata.  
 We suggest to use these tools on synchronized press brakes as it is necessary to change quickly press stroke between bending and crushing position. It is not possible to increase lower tool radius because it would have some deformations on bend crushed.



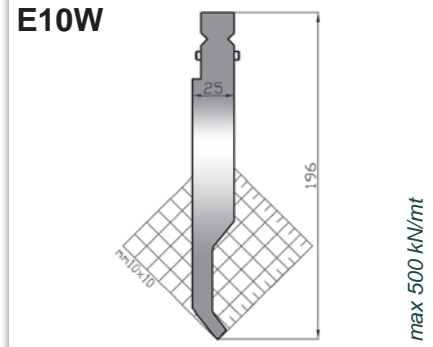
**C10W**  
 USL 196/78° AW R1,0  
 altezza-height 196 mm  
 angolo-degree 78° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 700 kN/mt



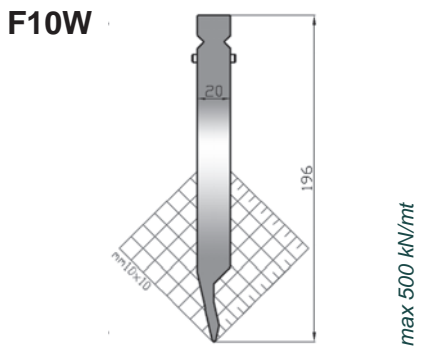
**D10W**  
 USL 196/78° BW R1,0  
 altezza-height 196 mm  
 angolo-degree 78° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 450 kN/mt



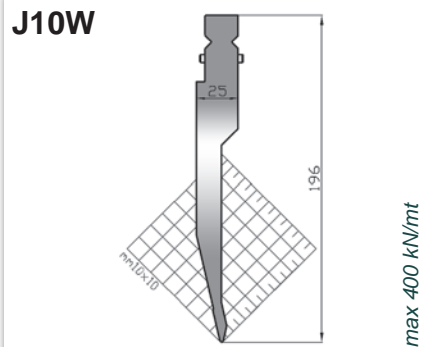
**E10W**  
 USL 196/78° CW R1,0  
 altezza-height 196 mm  
 angolo-degree 78° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 500 kN/mt



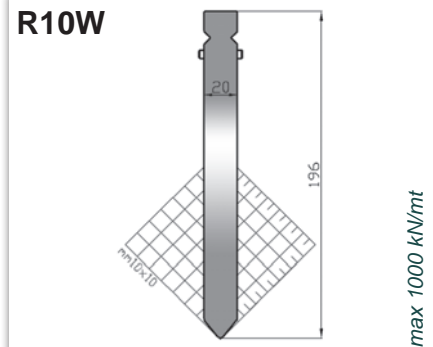
**F10W**  
 USL 196/26° EW R1,0  
 altezza-height 196 mm  
 angolo-degree 26° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 500 kN/mt



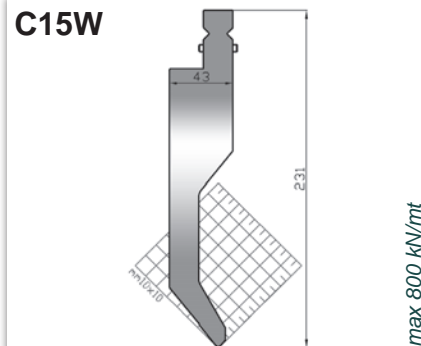
**J10W**  
 USL 196/26° FW R1,0  
 altezza-height 196 mm  
 angolo-degree 26° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 400 kN/mt



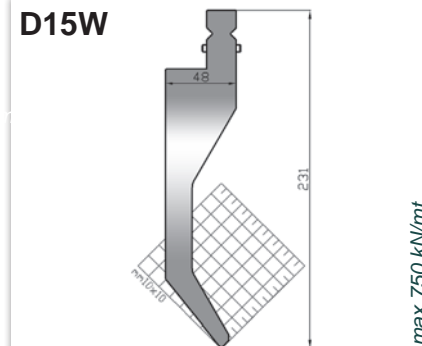
**R10W**  
 USL 196/78° DW R2,0  
 altezza-height 196 mm  
 angolo-degree 78° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 1000 kN/mt



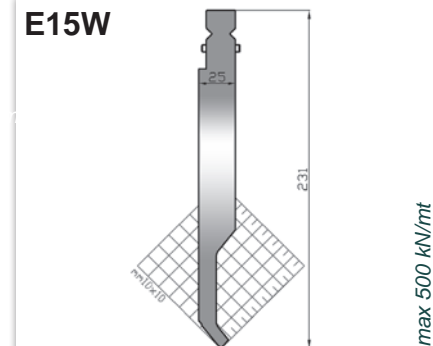
**C15W**  
 USL 231/78° AW R2,0  
 altezza-height 231 mm  
 angolo-degree 78° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 800 kN/mt



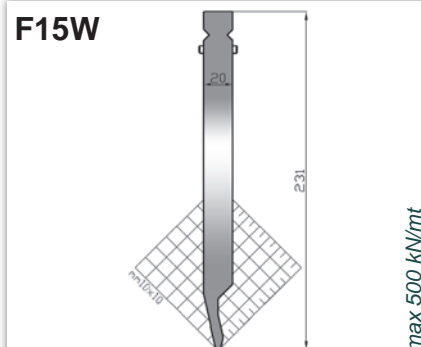
**D15W**  
 USL 231/78° BW R2,0  
 altezza-height 231 mm  
 angolo-degree 78° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 750 kN/mt



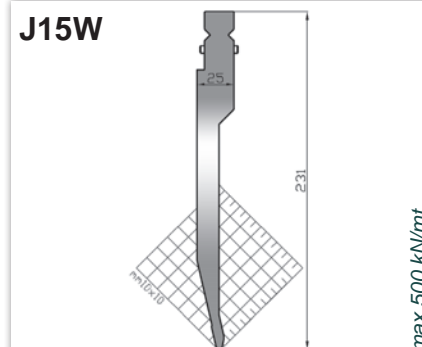
**E15W**  
 USL 231/78° CW R2,0  
 altezza-height 231 mm  
 angolo-degree 78° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 500 kN/mt



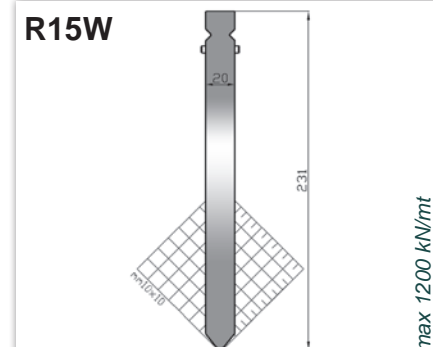
**F15W**  
 USL 231/26° EW R2,0  
 altezza-height 231 mm  
 angolo-degree 26° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 500 kN/mt



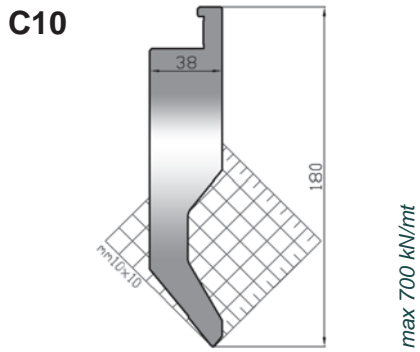
**J15W**  
 USL 231/26° FW R2,0  
 altezza-height 231 mm  
 angolo-degree 26° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 500 kN/mt



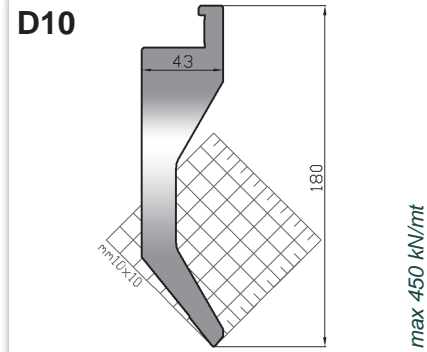
**R15W**  
 USL 231/78° DW R3,0  
 altezza-height 231 mm  
 angolo-degree 78° raggio-radius 3,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 1200 kN/mt



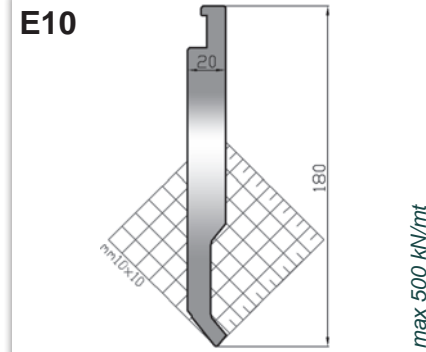
**C10**  
**USL 180/78° A R1,0**  
 altezza-height 180 mm  
 angolo-degree 78° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 700 kN/mt



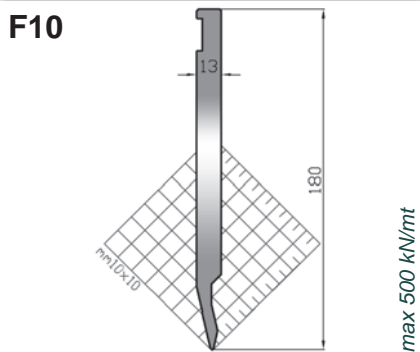
**D10**  
**USL 180/78° B R1,0**  
 altezza-height 180 mm  
 angolo-degree 78° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 450 kN/mt



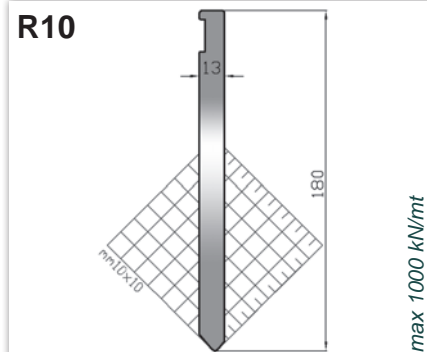
**E10**  
**USL 180/78° C R1,0**  
 altezza-height 180 mm  
 angolo-degree 78° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 500 kN/mt



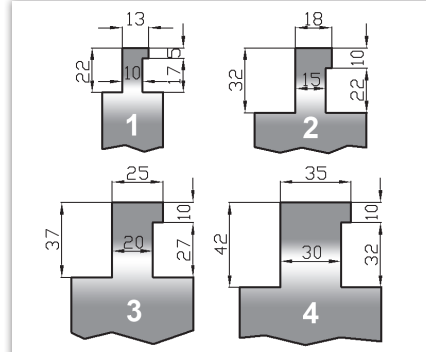
**F10**  
**USL 180/26° E R1,0**  
 altezza-height 180 mm  
 angolo-degree 26° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 500 kN/mt



**R10**  
**USL 180/78° D R2,0**  
 altezza-height 180 mm  
 angolo-degree 78° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

max 1000 kN/mt



**ATTACCHI-CLAMPINGS**  
 utensili tipo - tools type  
**C10 D10 E10 F10 R10**

508 mm

attacco utensile con spine o pulsante  
 tool clamping with pins or push-button

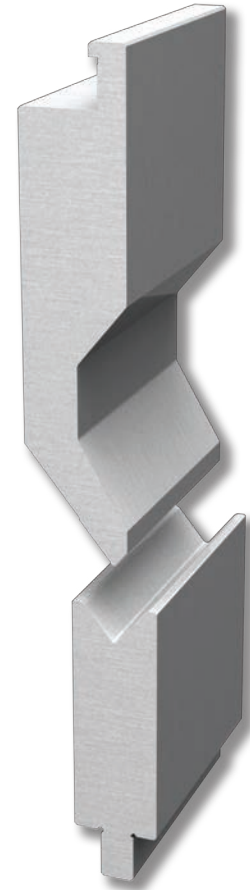
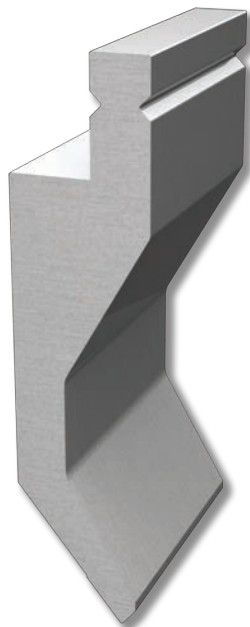
500 fraz  
 mm 250-250

550 fraz  
 mm 25-30-35-40-45-50-125-100sx-100dx

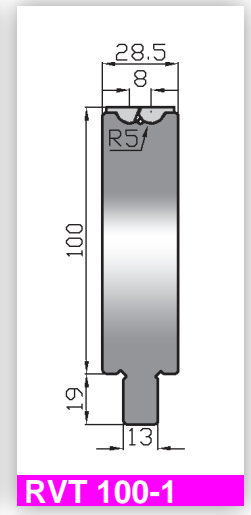
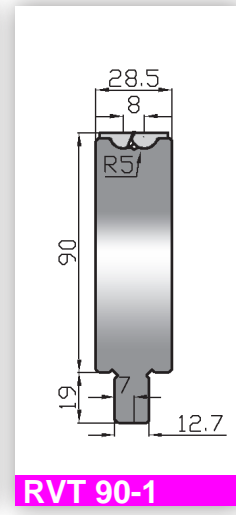
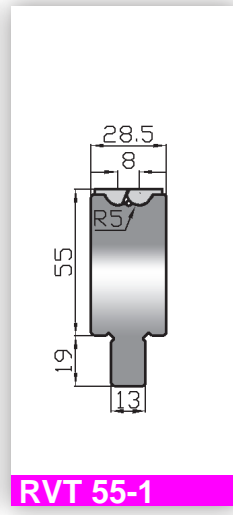
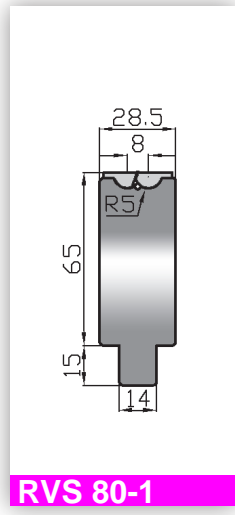
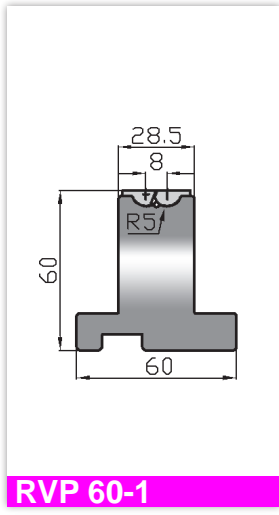
LUNGHEZZE - LENGTHS



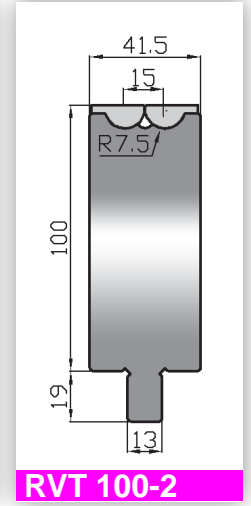
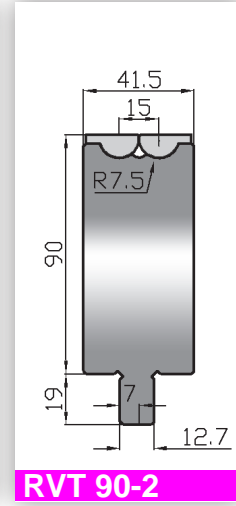
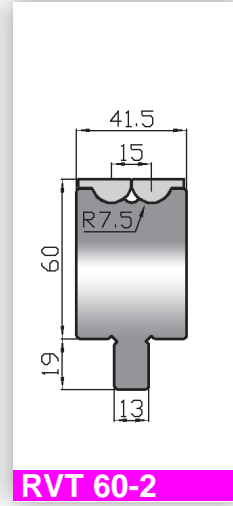
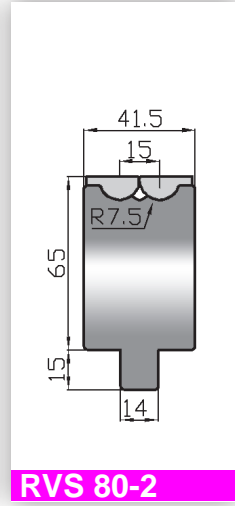
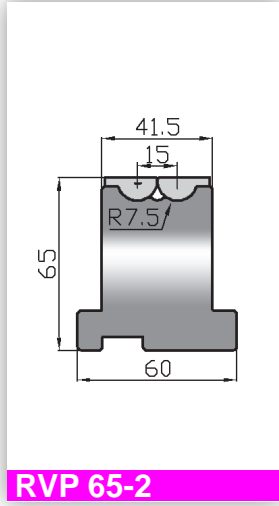
pulsante  
 push-button



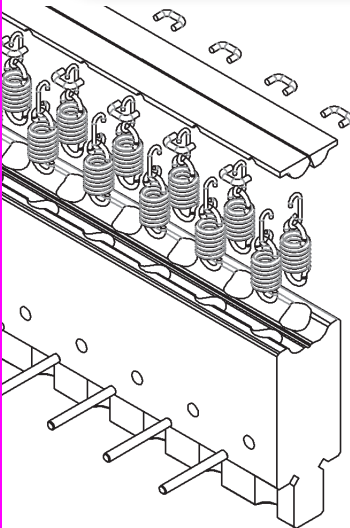
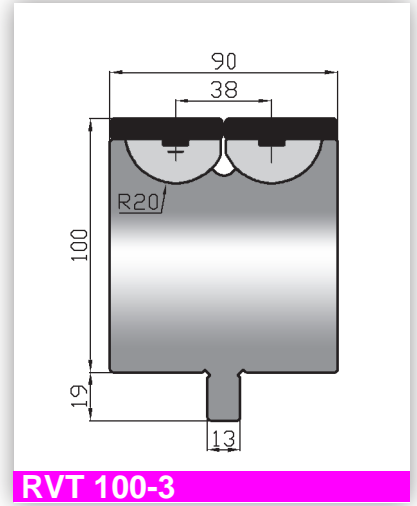
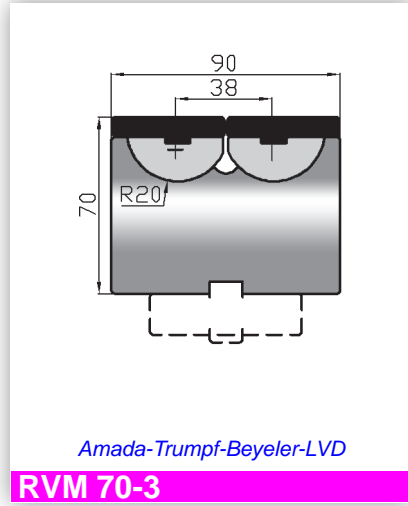
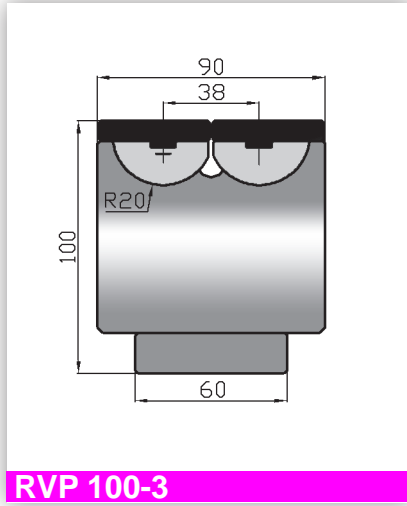
**type 1 (rel.7)**



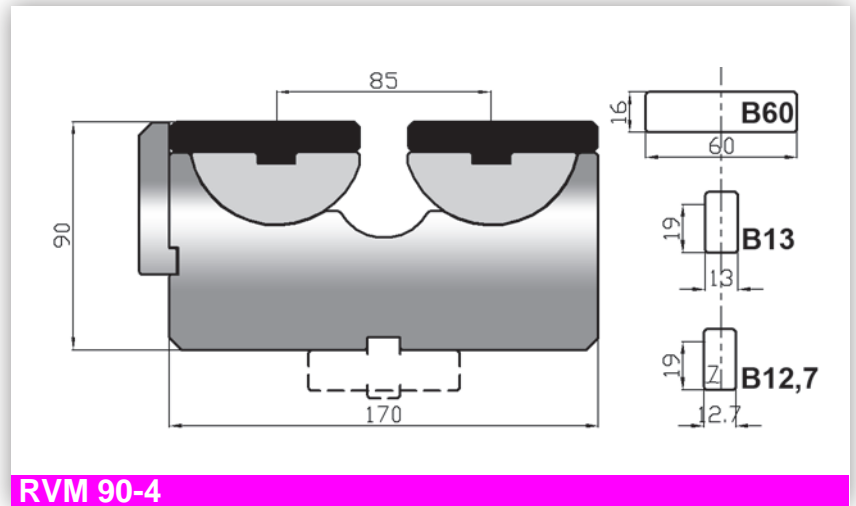
**type 2 (rel.2)**

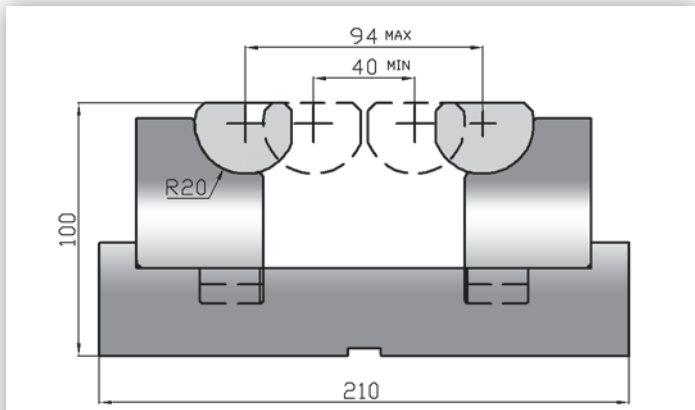


**type 3 (rel.2)**

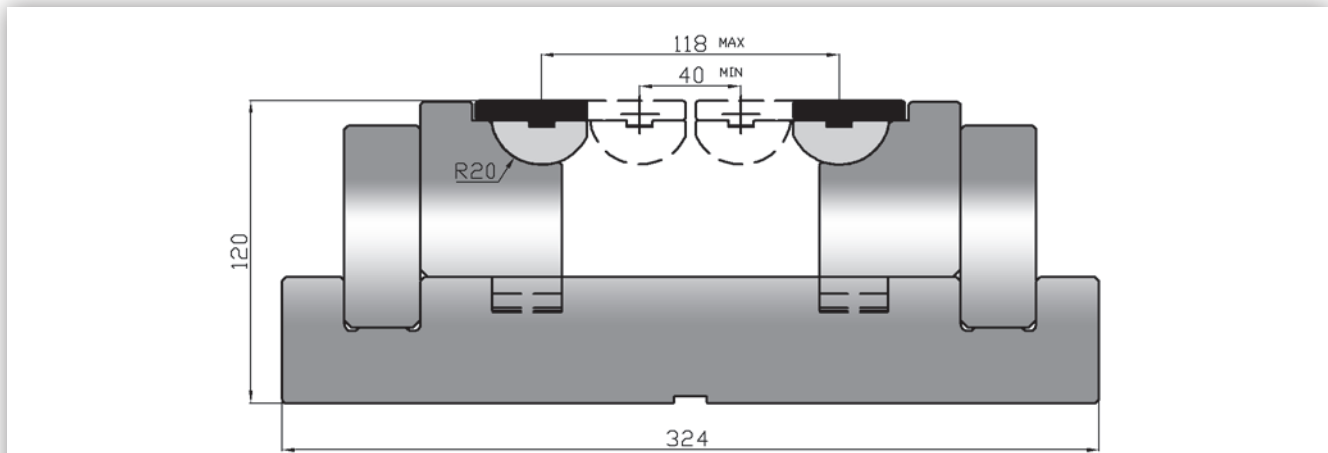


**type 4 (rel.2)**

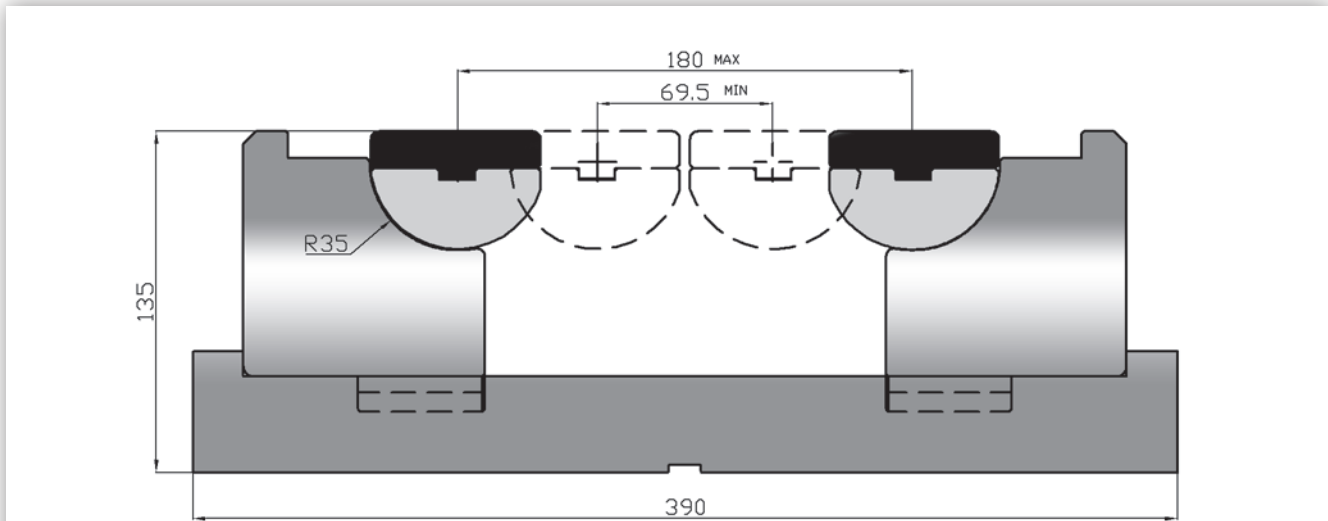




**RVPV3** V regolabile - adjustable V

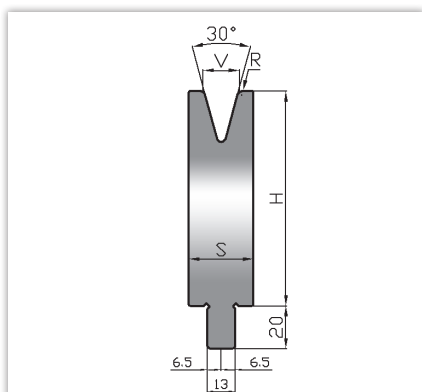


**RVHD3** V regolabile - adjustable V



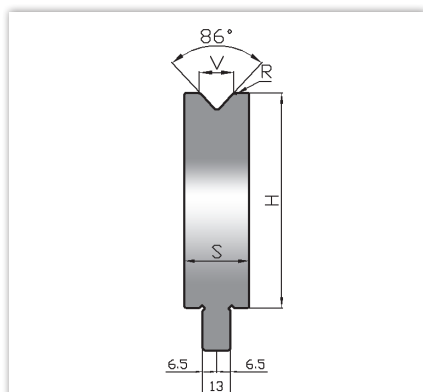
**RVPV4** V regolabile - adjustable V

tipo - type	V mm	max thickness mm	spessore thickness mm	bordo flange min. mm	forza force kN/mt	angolo angle min.	carico load max kN/mt	lunghezze- lengths
<b>type 1 (rel.7)</b>	<b>8</b>	1,5	0,7	3,0	60	40°	1000	500 mm
			1,0	3,9	110	35°	1000	440 mm fraz 15-20-25-30-50-100-200
			1,5	4,2	260	35°	1000	
<b>type 2 (rel.2)</b>	<b>15</b>	3,0	2,0	8,5	200	59°	1500	500 mm
			3,0	9,3	460	46°	1500	450 mm fraz 20-25-30-35-40-100-200
			3,2	9,3	550	47°	1500	
<b>type 3 (rel.2)</b>	<b>38</b>	6,0	4	22,5	270	47°	2500	500 mm
			6	22,5	800	50°	2500	455 mm fraz 45-50-60-100-200
<b>type 4 (rel.2)</b>	<b>85</b>	12,0	6	56,6	260	78°	3000	500 mm
			8	56,6	500	76°	3000	200 mm
			12	56,6	1290	73°	3000	
<b>RVPV3</b>			V 40 - 94 mm				2500	500 mm
<b>RVHD3</b>			V 40 - 118 mm				3500	200 mm
<b>RVPV4</b>			V 69,5 - 180 mm				3000	200 mm



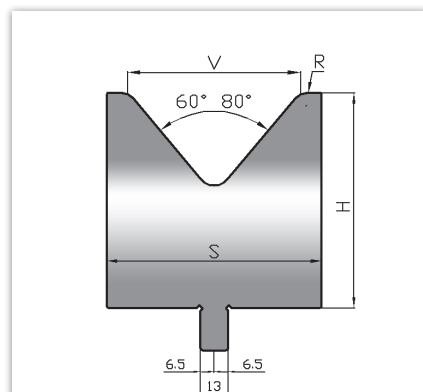
30°	V mm	R mm	H mm	S mm	kN/mt max
UST100N/30°V06	6	0,6	100	20	400
UST100N/30°V08	8	1,0	100	20	400
UST100N/30°V10	10	1,0	100	20	400
UST100N/30°V12	12	1,0	100	25	400
UST100N/30°V16	16	1,6	100	30	500
UST100N/30°V20	20	2,0	100	35	600
UST100N/30°V24	24	2,5	100	40	650
UST100N/30°V30	30	3,0	100	55	900
UST100N/30°V40	40	5,0	100	60	900
UST150N/30°V06	6	0,6	150	20	400
UST150N/30°V08	8	1,0	150	20	400
UST150N/30°V10	10	1,0	150	20	400
UST150N/30°V12	12	1,0	150	25	400
UST150N/30°V16	16	1,6	150	30	500
UST150N/30°V20	20	2,0	150	35	600
UST150N/30°V24	24	2,5	150	40	650
UST150N/30°V30	30	3,0	150	55	900
UST150N/30°V40	40	5,0	150	60	900

altezza-height 100-150 mm  
 angolo-degree 30°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-M



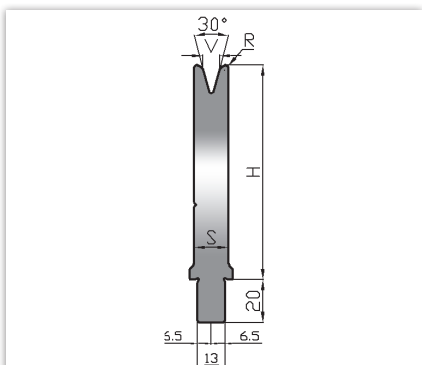
86°	V mm	R mm	H mm	S mm	kN/mt max
UST100N-S/86°V4	4	0,6	100	8	250
UST100N/86°V06	6	0,6	100	20	1200
UST100N/86°V08	8	0,8	100	20	1150
UST100N/86°V10	10	1,0	100	20	1100
UST100N/86°V12	12	1,0	100	25	1200
UST100N/86°V16	16	1,6	100	30	1200
UST100N/86°V20	20	2,0	100	30	1150
UST100N/86°V24	24	2,5	100	35	1200
UST100N/86°V30	30	3,0	100	45	1200
UST100N/86°V40	40	3,0	100	55	1200
UST100N/86°V50	50	3,0	100	75	1500
UST150N/86°V06	6	1,6	150	20	1200
UST150N/86°V08	8	2,0	150	20	1150
UST150N/86°V10	10	2,5	150	20	1100
UST150N/86°V12	12	3,0	150	25	1200
UST150N/86°V16	16	3,0	150	30	1200
UST150N/86°V20	20	3,0	150	30	1150

altezza-height 100-150 mm  
 angolo-degree 86°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-M



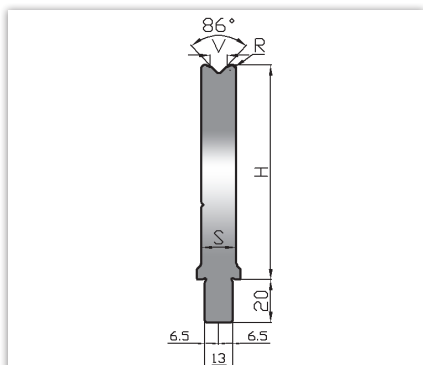
80°-60°	V mm	R mm	H mm	S mm	kN/mt max
UST150N/80°V24	24	2,0	150	35	1000
UST150N/80°V30	30	5,0	150	45	900
UST150N/80°V40	40	5,0	150	55	1200
UST150N/80°V50	50	5,0	150	75	1500
UST100N/80°V60	60	5,0	100	75	1500
UST100N/80°V70	70	5,0	100	85	1500
UST100N/80°V80	80	5,0	100	100	1500
UST120N/80°V90	90	8,0	120	110	1500
UST120N/80°V100	100	8,0	120	120	1500
UST120N/60°V120	120	8,0	120	145	1000

altezza-height 100-120-150 mm  
 angolo-degree 80° - 60°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 500 mm - fraz A-B-C-M



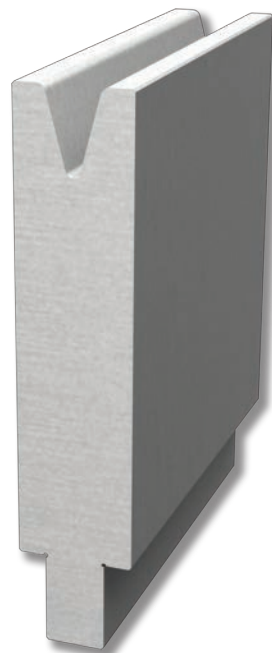
30°	V mm	R mm	H mm	S mm	kN/mt max
UST100N-S/30°V06	6	2,0	100	16	400
UST100N-S/30°V08	8	2,5	100	16	400
UST100N-S/30°V10	10	2,5	100	20	400
UST100N-S/30°V12	12	3,0	100	20	400

altezza-height 100 mm  
 angolo-degree 30°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 515 mm - 550 fraz M



86°	V mm	R mm	H mm	S mm	kN/mt max
UST100N-S/86°V08	8	2,5	100	16	400
UST100N-S/86°V12	12	2,5	100	20	500

altezza-height 100 mm  
 angolo-degree 86°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 515 mm - 550 fraz M



LUNGHEZZE-LENGTHS 500 mm - frazionatura/sect. A - B - C - M

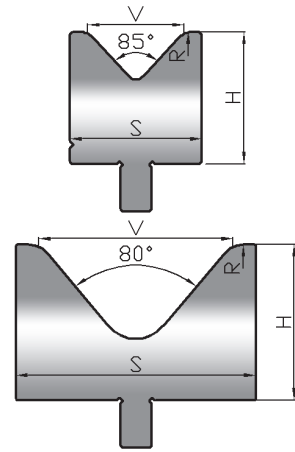
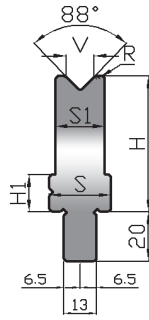
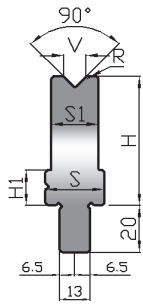
frazionatura/sect. A									
L.mm.	25	30	35	40	45	50	100		
1250	2	1	1	1	1	1	10	=17	
2050	2	1	1	1	1	1	18	=25	
2550	2	1	1	1	1	1	23	=30	
3050	2	1	1	1	1	1	28	=35	
4050	2	1	1	1	1	1	38	=45	

frazionatura/sect. B											
L.mm.	25	30	35	40	45	50	100	200	300	500	
1250	2	1	1	1	1	1	3	2	1	0	=13
2050	2	1	1	1	1	1	3	1	1	2	=14
2550	2	1	1	1	1	1	3	1	1	3	=15
3050	2	1	1	1	1	1	3	1	1	4	=16
4050	2	1	1	1	1	1	3	1	1	6	=18

frazionatura/sect. C									
L.mm.	25	30	35	40	45	50			
250	2	1	1	1	1	1			=7

frazionatura/sect. M									
L.mm.	20	25	30	35	40	100	200		
550	1	1	1	1	1	2	1		=8



90°	V mm	R mm	H-H1 mm	S-S1 mm	kN/mt max
USB55/90°V06	6	0,4	55-15	25-15	1150
USB55/90°V08	8	0,5	55-15	25-15	1100
USB55/90°V10	10	1,0	55-15	25-20	1100
USB55/90°V12	12	1,5	55-15	25-20	1200
USB55/90°V16	16	2,0	55	30	1200

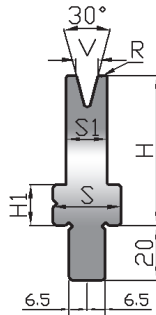
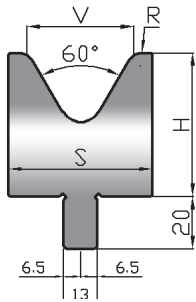
88°	V mm	R mm	H-H1 mm	S-S1 mm	kN/mt max
USB55/88°V10	10	1,0	55-15	25-20	1100
USB55/88°V12	12	1,5	55-15	25-20	1200
USB55/88°V16	16	2,0	55	30	1200
USB55/88°V20	20	2,0	55	30	1100
USB55/88°V24	24	3,0	55	40	1200

85°- 80°	V mm	R mm	H mm	S mm	kN/mt max
USB55/85°V32	32	4,0	55	50	1200
USB55/85°V40	40	4,0	55	55	1200
USB65/80°V80	80	10	65	100	1700
USB85/80V100	100	12	85	125	2300

altezza-height 55 mm  
 angolo-degree 90°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz

altezza-height 55 mm  
 angolo-degree 88°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz

altezza-height 55-65-85 mm  
 angolo-degree 85° - 80°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz

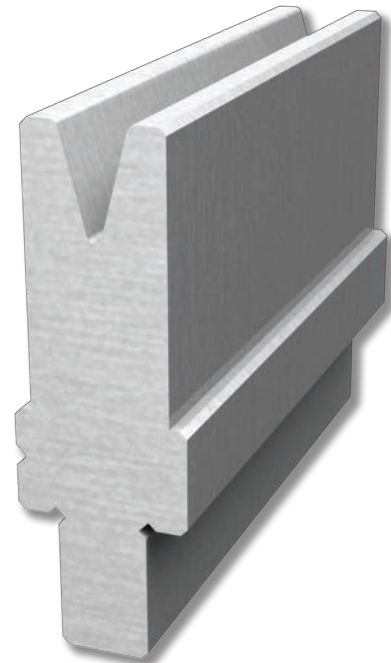


60°	V mm	R mm	H mm	S mm	kN/mt max
USB55/60°V40	40	5,0	55	55	1300
USB55/60°V50	50	5,0	55	70	1200
USB65/60°V60	60	7,0	65	80	1100

30°	V mm	R mm	H-H1 mm	S-S1 mm	kN/mt max
USB55/30°V06	6	0,6	55-15	25-15	350
USB55/30°V08	8	0,8	55-15	25-15	200
USB70/30°V08	8	0,7	70-15	25-20	200
USB55/30°V10	10	1,0	55-15	25-20	350
USB70/30°V10	10	1,0	70-15	25-20	350
USB55/30°V12	12	1,5	55-15	25-20	300
USB70/30°V12	12	1,5	70	25-25	300
USB55/30°V16	16	2,0	55	30-30	450
USB70/30°V16	16	2,0	70	30-30	450
USB55/30°V20	20	2,5	55	35-35	500
USB55/30°V24	24	3,0	55	40-40	550
USB60/30°V32	32	4,0	60	60-60	650

altezza-height 55-65 mm  
 angolo-degree 60°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz

altezza-height 55-60-70 mm  
 angolo-degree 30°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths mm 500-1000-1100 fraz

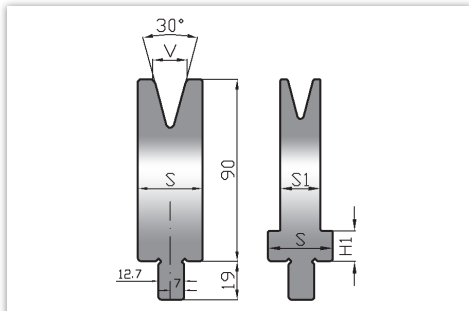


500 mm - 1000 mm

1100 mm fraz 10-15-20-30-40-50-60-75-100-100-200-400

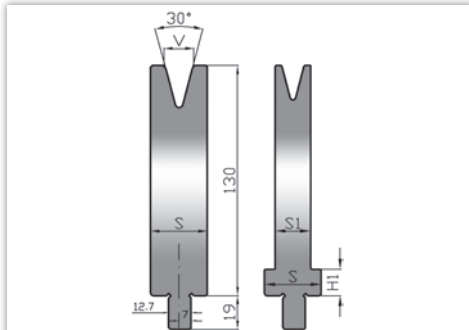
LUNGHEZZE-LENGTHS





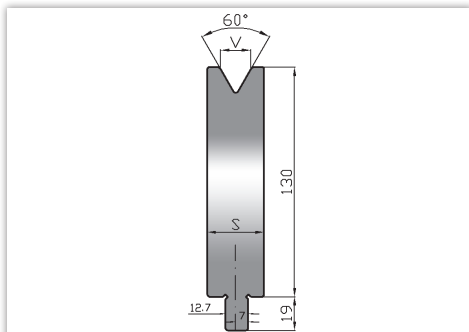
30°	V mm	R mm	H-H1 mm	S-S1 mm	kN/mt max
USL109/30°V06	6	0,8	90-15	32-16	200
USL109/30°V08	8	1,0	90-15	32-18	220
USL109/30°V10	10	1,2	90-15	32-25	300
USL109/30°V12	12	1,6	90	32	380
USL109/30°V16	16	3,0	90	32	380
USL109/30°V20	20	3,0	90	40	380
USL109/30°V24	24	3,0	90	50	550

altezza-height 90 mm  
 angolo-degree 30°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz



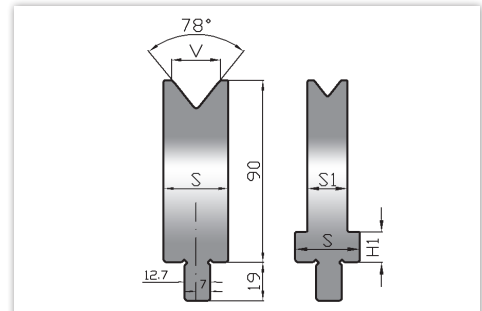
30°	V mm	R mm	H-H1 mm	S-S1 mm	kN/mt max
USL149/30°V06	6	0,8	130-15	32-16	200
USL149/30°V08	8	1,0	130-15	32-18	220
USL149/30°V10	10	1,2	130-15	32-25	300
USL149/30°V12	12	1,6	130	32	380
USL149/30°V16	16	3,0	130	40	380
USL149/30°V20	20	3,0	130	40	380

altezza-height 130 mm  
 angolo-degree 30°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz



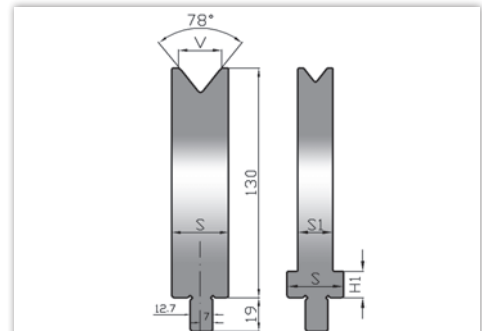
60°	V mm	H mm	S mm	kN/mt max
USL149/60°V30	30	130	40	500
USL149/60°V40	40	130	55	660
USL149/60°V50	50	130	70	1050
USL149/60°V60	60	130	80	1200
USL149/60°V80	80	130	102	1750
USL149/60°V100	100	130	120	1600
USL149/60°V120	120	130	145	1300

altezza-height 130 mm  
 angolo-degree 60°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz



78°	V mm	R mm	H-H1 mm	S-S1 mm	kN/mt max
USL109/78°V06	6	1,0	90-15	32-12	400
USL109/78°V08	8	1,0	90-15	32-12	400
USL109/78°V10	10	1,0	90-15	32-14	500
USL109/78°V12	12	2,0	90-15	32-18	600
USL109/78°V16	16	2,5	90-15	32-25	800
USL109/78°V20	20	3,0	90	32	1000
USL109/78°V24	24	3,0	90	32	1000
USL109/78°V30	30	3,0	90	40	1100
USL109/78°V40	40	4,0	90	50	1300
USL109/78°V50	50	4,0	90	60	1500
USL109/78°V60	60	4,0	90	70	1500
USL109/78°V80	80	5,0	90	90	1500
USL109/78°V100	100	8,0	90	120	1200

altezza-height 90 mm  
 angolo-degree 78°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz



78°	V mm	R mm	H-H1 mm	S-S1 mm	kN/mt max
USL149/78°V06	6	1,0	130-15	32-12	400
USL149/78°V08	8	1,0	130-15	32-12	400
USL149/78°V10	10	1,0	130-15	32-14	500
USL149/78°V12	12	2,0	130-15	32-18	600
USL149/78°V16	16	2,5	130-15	32-25	800
USL149/78°V20	20	3,0	130	32	1000
USL149/78°V24	24	3,0	130	32	1000
USL149/78°V30	30	3,0	130	40	1100
USL149/78°V40	40	4,0	130	50	1300
USL149/78°V50	50	4,0	130	70	1500
USL149/78°V60	60	4,0	130	70	1500
USL149/78°V80	80	5,0	130	95	1500

altezza-height 130 mm  
 angolo-degree 78°  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 lunghezze-lengths 508 mm - 500 / 550 fraz

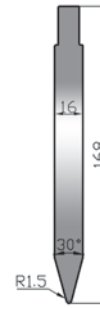
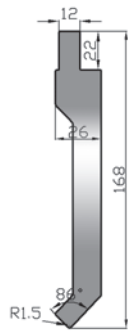
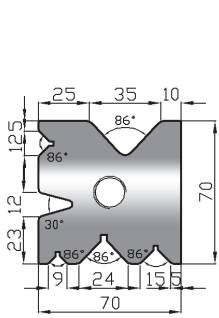
508 mm

500 fraz mm 250-250

550 fraz mm 25-25-30-35-40-45-50-100-200

LUNGHEZZE-LENGTHS

**kN 300 - 600**



**USH M70**

**USH 168/A**

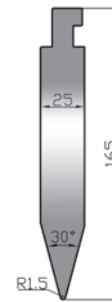
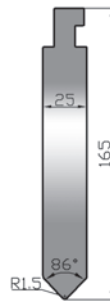
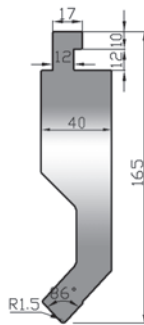
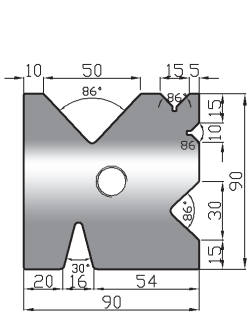
**USH 168/B**

**USH 168/C**

**USH 168/D**

**USH 168/E**

**kN 800 - 1350**



**USH M90**

**USH 165/A**

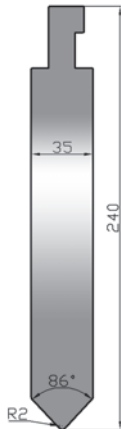
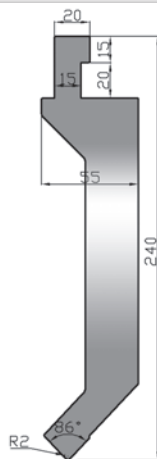
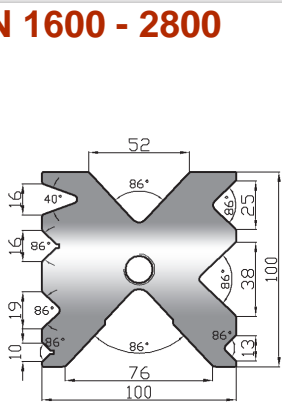
**USH 165/B**

**USH 165/C**

**USH 165/D**

**USH 165/E**

**kN 1600 - 2800**



**USH M100**

**USH 240/A**

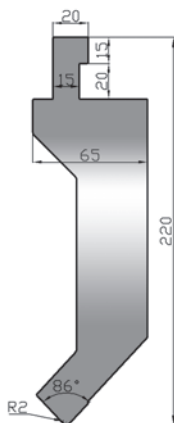
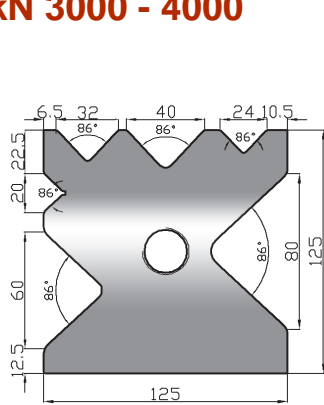
**USH 240/B**

**USH 240/C**

**USH 240/D**

**USH 240/E**

**kN 3000 - 4000**



**USH M125**

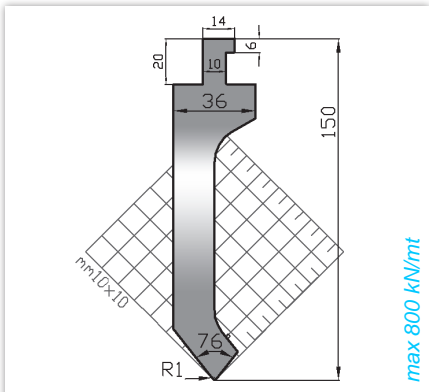
**USH 220/A**

**USH 220/B**

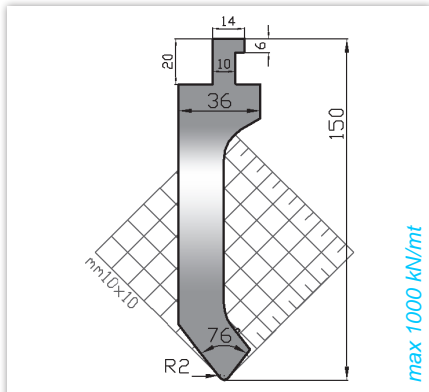
**USH 220/C**

**USH 220/D**

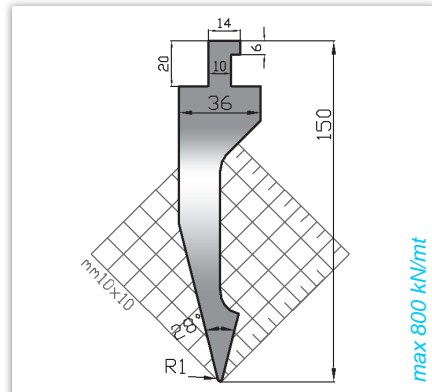
**USH 220/E**



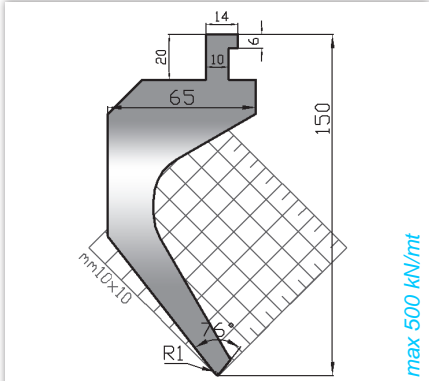
**USN-PN-160** 150x36 mm  
 altezza-height 130 mm  
 angolo-degree 76° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 800 kN/mt



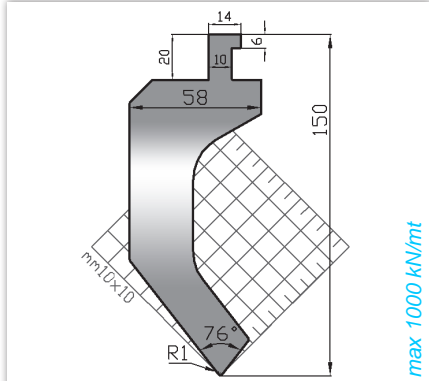
**USN-PN-165** 150x36 mm  
 altezza-height 130 mm  
 angolo-degree 76° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 1000 kN/mt



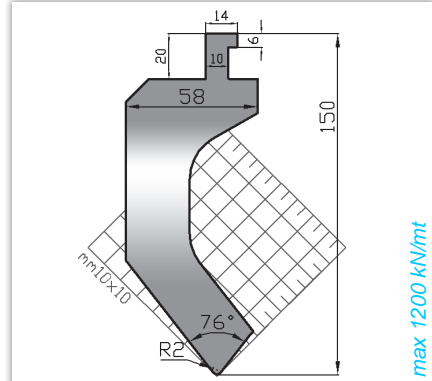
**USN-PN-150** 150x36 mm  
 altezza-height 130 mm  
 angolo-degree 28° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 800 kN/mt



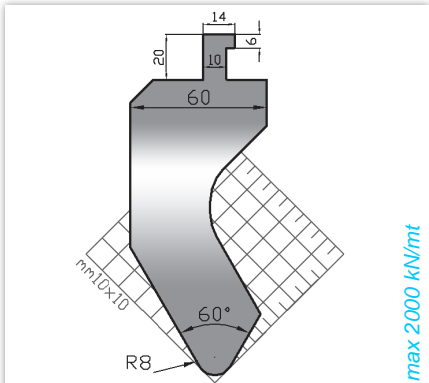
**USN-PN-190** 150x65 mm  
 altezza-height 130 mm  
 angolo-degree 76° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 500 kN/mt



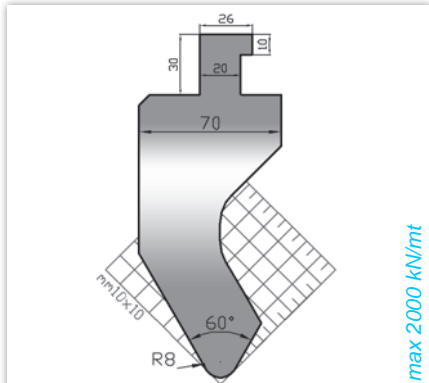
**USN-PN-140** 150x58 mm  
 altezza-height 130 mm  
 angolo-degree 76° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 1000 kN/mt



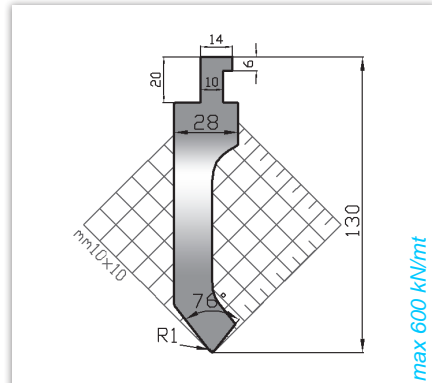
**USN-PN-145** 150x58 mm  
 altezza-height 130 mm  
 angolo-degree 76° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 1200 kN/mt



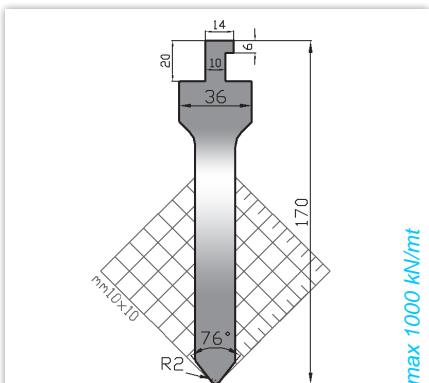
**USN-PN-170** 150x60 mm  
 altezza-height 130 mm  
 angolo-degree 60° raggio-radius 8,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 2000 kN/mt



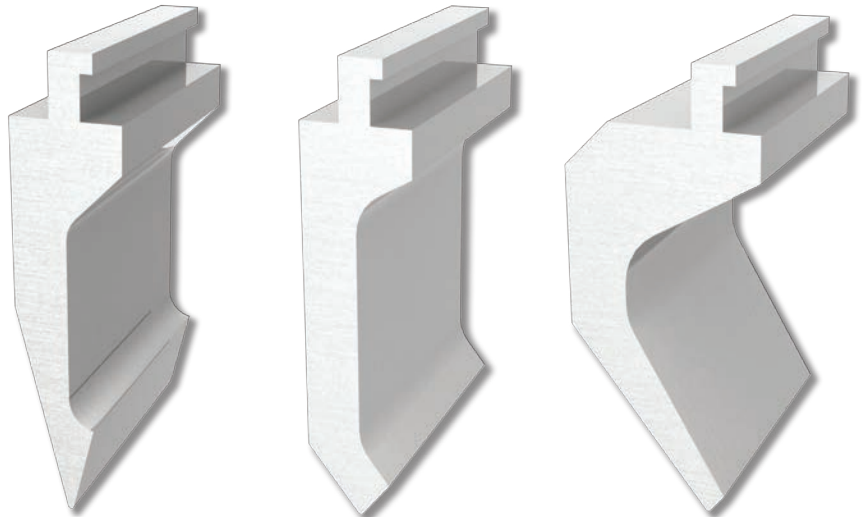
**USN-PN-180** 170x70 mm  
 altezza-height 140 mm  
 angolo-degree 60° raggio-radius 8,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 2000 kN/mt

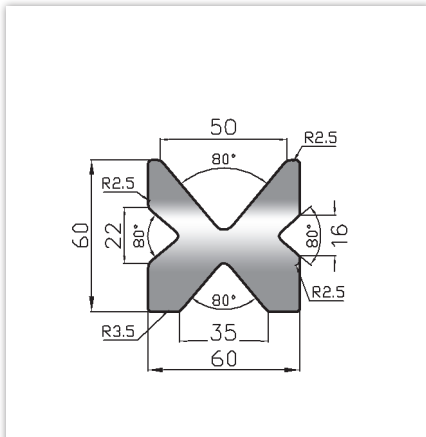


**USN-PN-110** 130x28 mm  
 altezza-height 110 mm  
 angolo-degree 76° raggio-radius 1,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 600 kN/mt



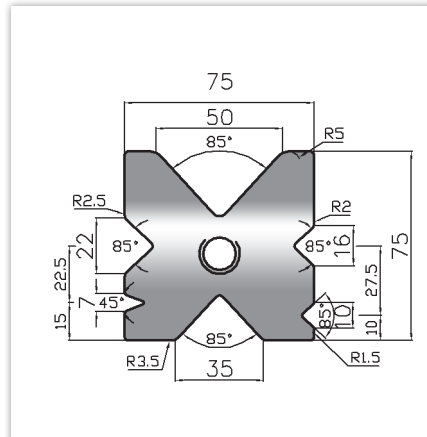
**USN-PN-195** 170x36 mm  
 altezza-height 150 mm  
 angolo-degree 76° raggio-radius 2,0 mm  
 42CrMo4 rettificato-grinding  
 temprato ind.-induction hardened HRC 52/58  
 max 1000 kN/mt





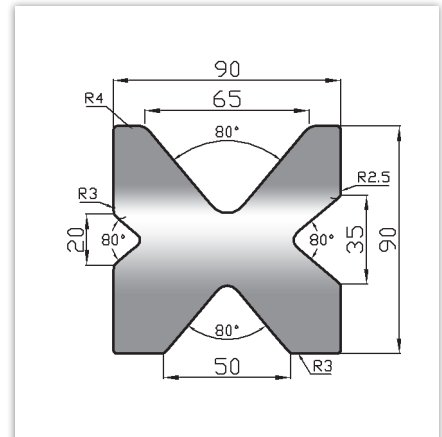
**USN-MN-925** 60x60 mm

42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58



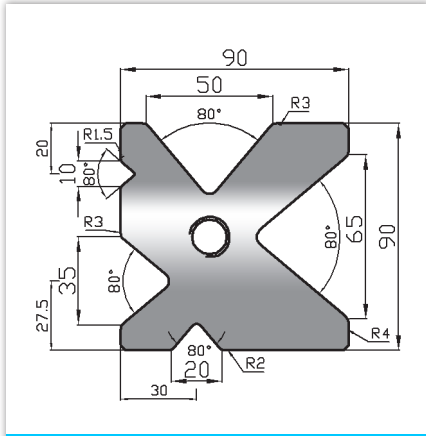
**USN-MN-1000** 75x75 mm

42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58



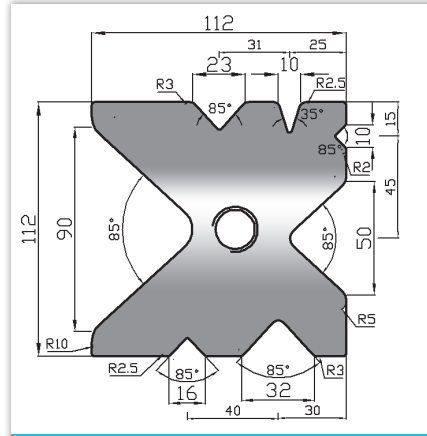
**USN-MN-155** 90x90 mm

42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58



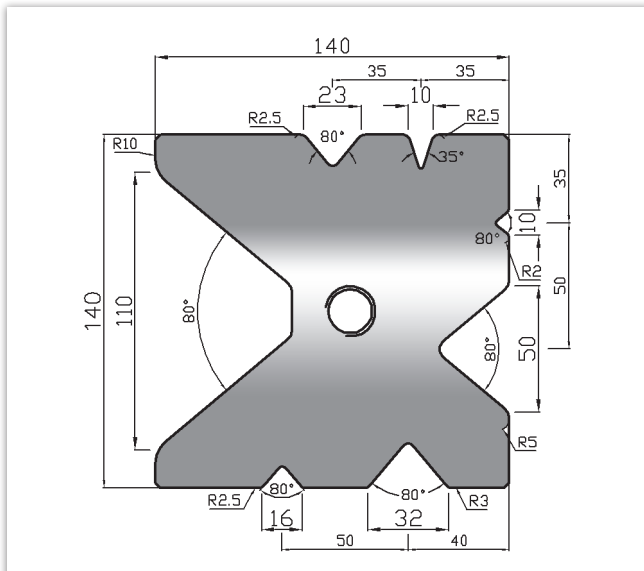
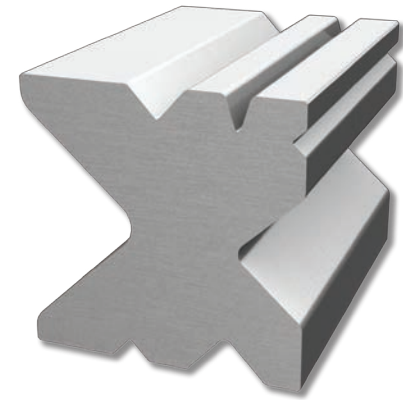
**USN-MN-135** 90x90 mm

42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58



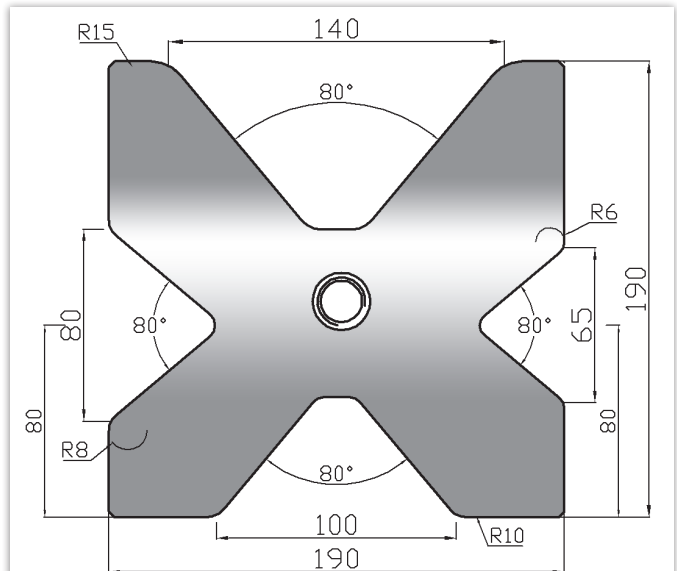
**USN-MN-915** 112x112 mm

42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58



**USN-MN-920** 140x140 mm

42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58



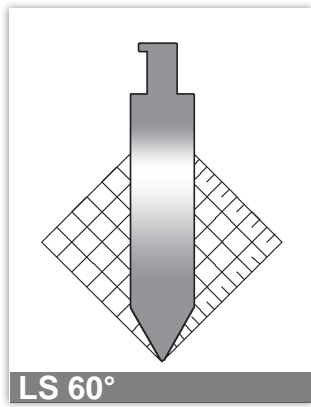
**USN-MN-159** 190x190 mm

42CrMo4 rettificato-grinding  
temprato ind.-induction hardened HRC 52/58

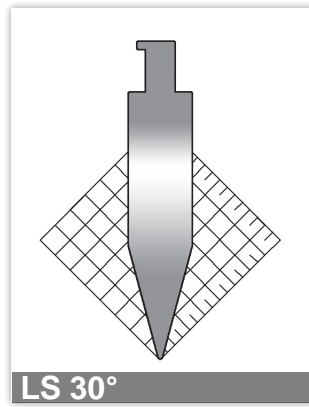


type

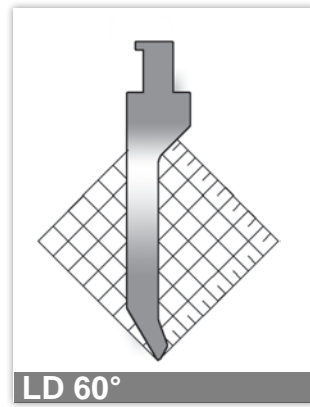
tipo Newton



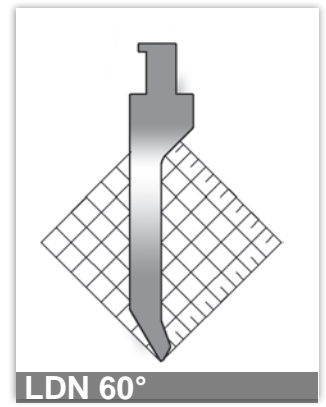
LS 60°



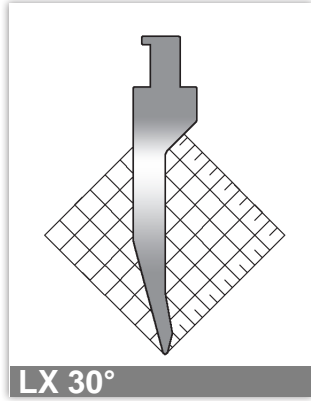
LS 30°



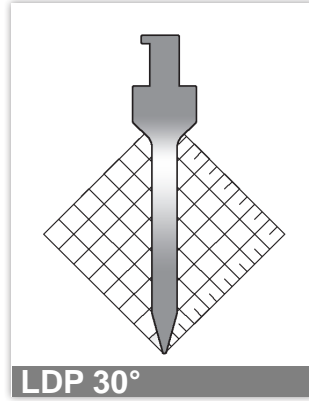
LD 60°



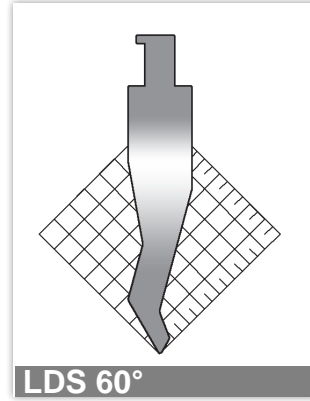
LDN 60°



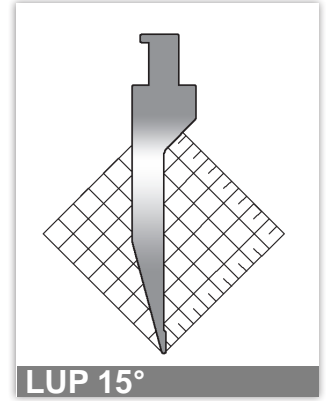
LX 30°



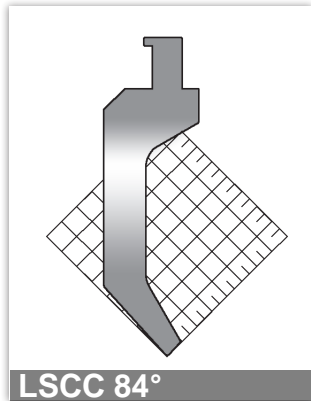
LDP 30°



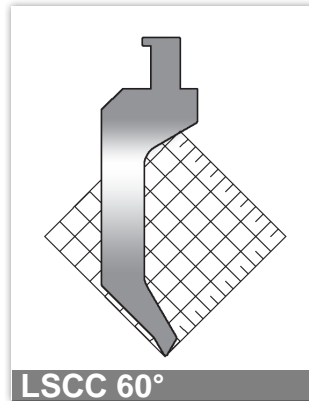
LDS 60°



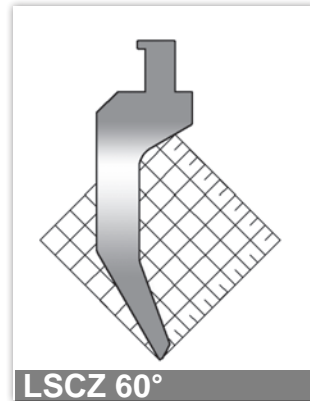
LUP 15°



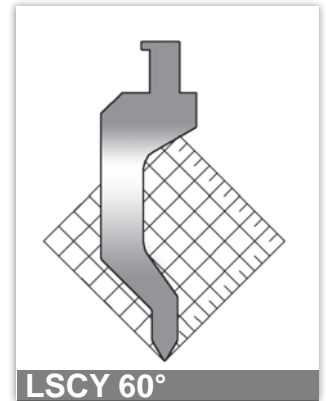
LSCC 84°



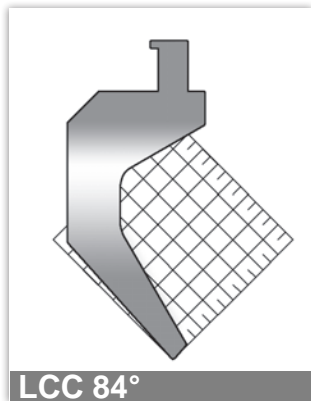
LSCC 60°



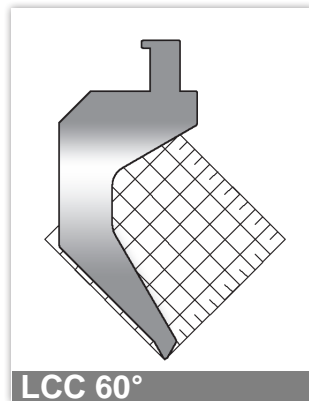
LSCZ 60°



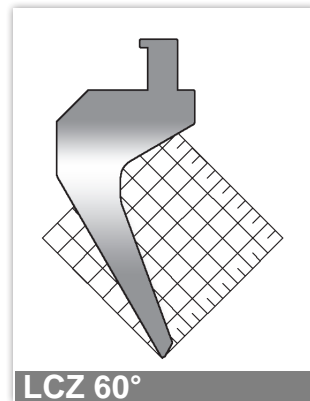
LSCY 60°



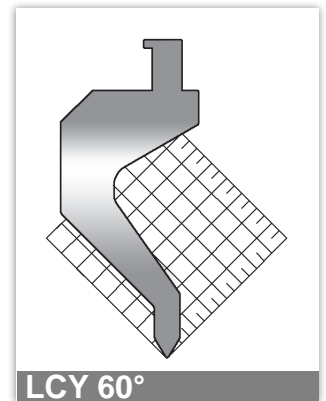
LCC 84°



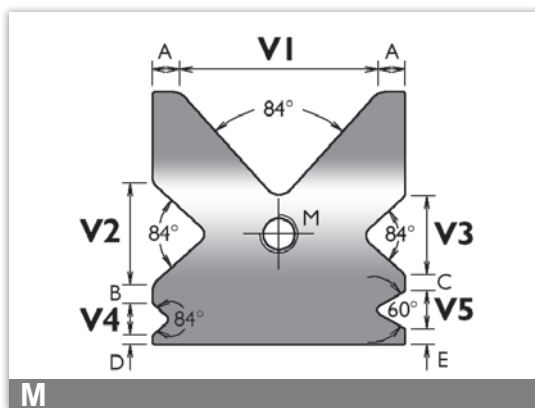
LCC 60°



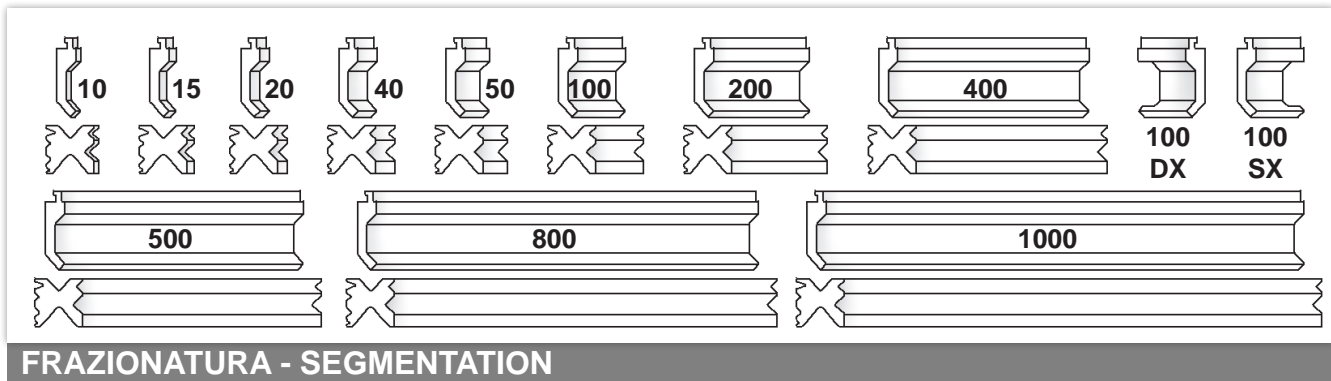
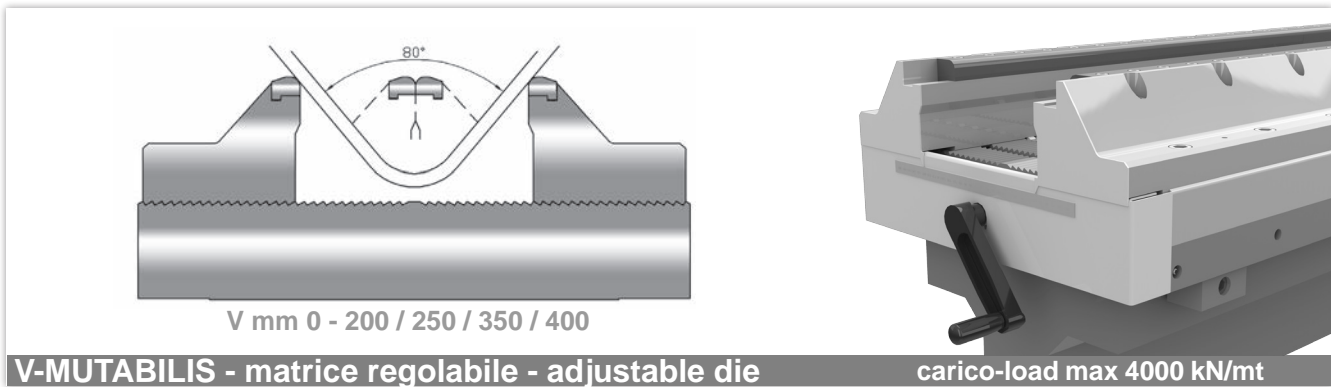
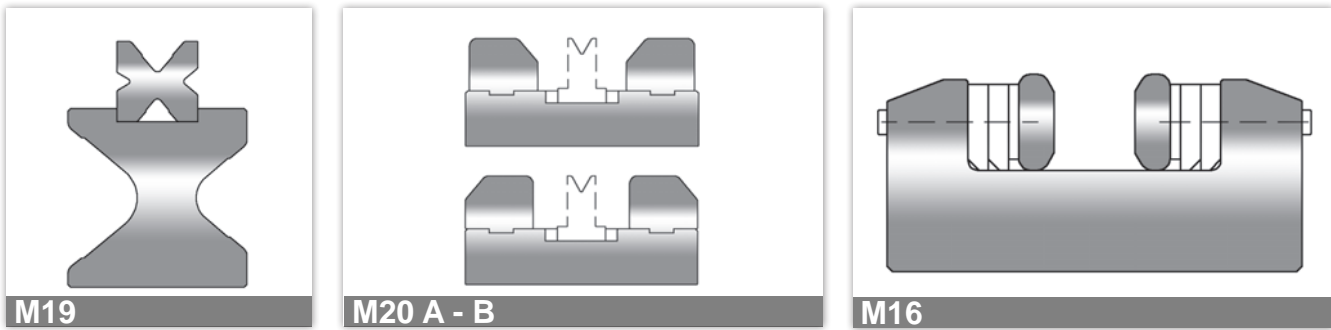
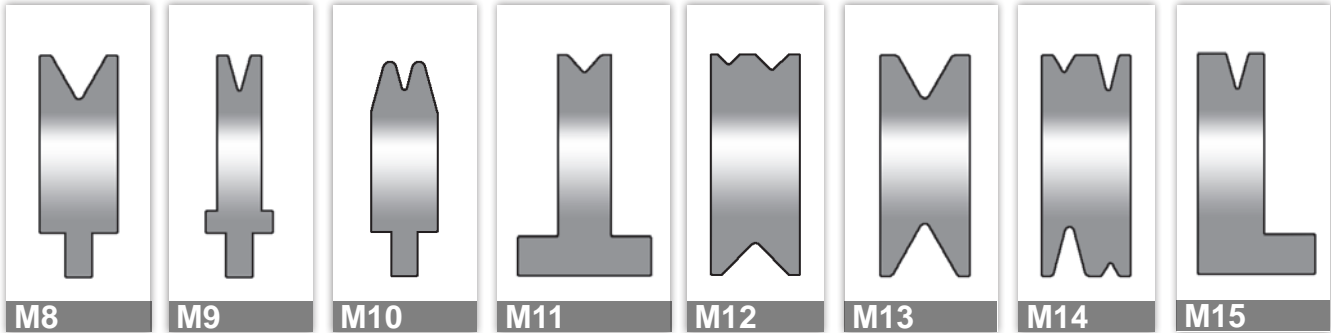
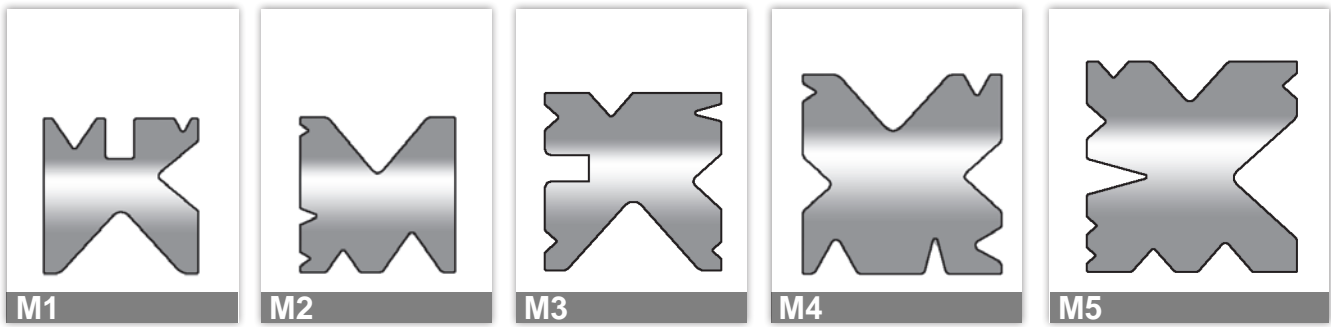
LCZ 60°



LCY 60°



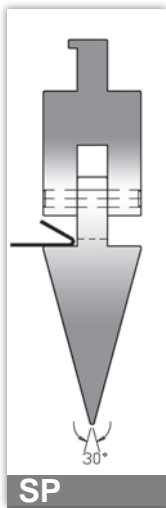
tipo type	dimensioni dimensions	84°				60°						
		V1	V2	V3	V4	V5	A	B	C	D	E	M
mm												
M 60	60x60	40	25	20	10	12	10	6	5	3	5	
M 70	70x70	50	32	25	10	12	10	6	5	3	5	M12
M 80	80x80	63	32	25	10	12	8,5	6	5	3	5	M12
M 90	90x90	70	40	25	10	12	10	6	5	3	5	M16
M 100	100x100	80	40	32	10	12	10	9	5	3	5	M16
M 110	110x110	90	50	32	10	12	10	9	5	3	5	M16
M 120	120x120	90	50	40	12	16	15	10	10	5	5	M16
M 130	130x130	110	50	40	12	16	10	10	10	5	5	M16
M 140	140x140	110	50	40	16	20	15	10	10	5	5	M20



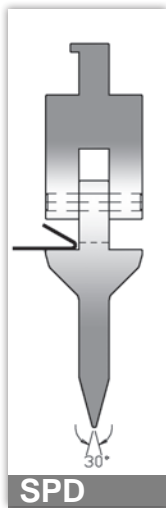
acciai - steels			
C 45	C 45	W 1.1191	R 600/750 N/mm <sup>2</sup>
42CR	42 CrMo4	W 1.7225	R 850/1000 N/mm <sup>2</sup>
2311	40 CrMnMo 7	W 1.2311	R 950/1100 N/mm <sup>2</sup>
2312	40 CrMnMoS8,6	W 1.2312	R 950/1050 N/mm <sup>2</sup>

trattamenti termici - heat treatment	
T	tempra ad induzione-induction hard.HRC 52-58
N	nitratato - nitrided
lavorazioni - working	
P	piallatura - planing
R	rettifica - grinding

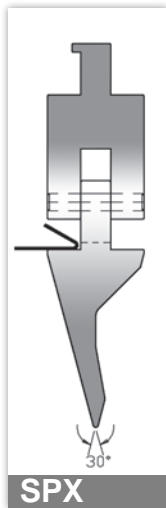
**INFORMAZIONI TECNICHE - TECHNICAL INFORMATION**



SP



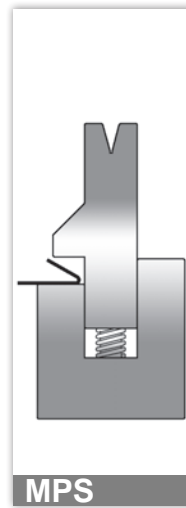
SPD



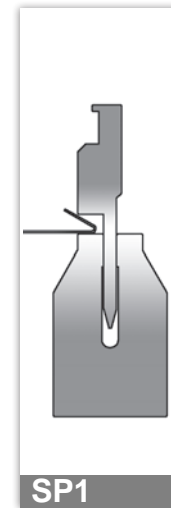
SPX



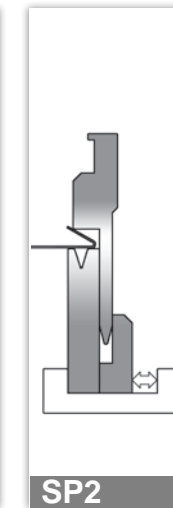
MP



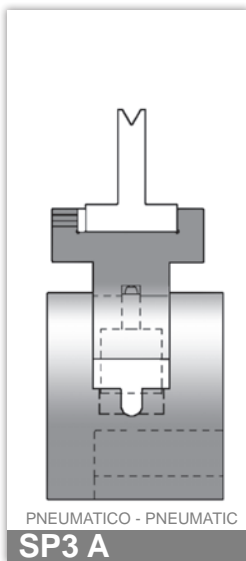
MPS



SP1

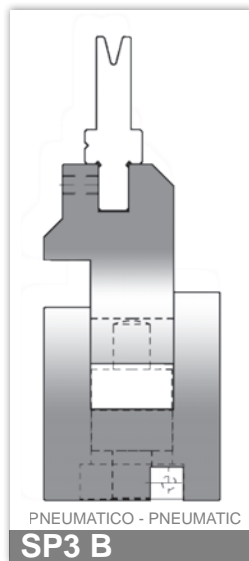


SP2



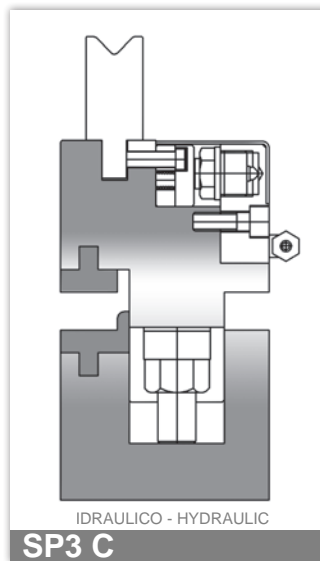
PNEUMATICO - PNEUMATIC

SP3 A



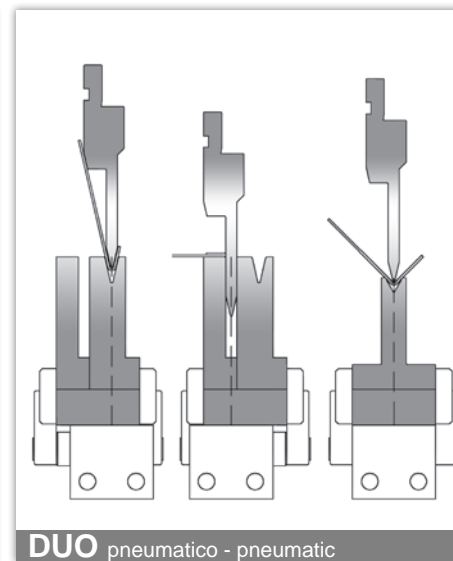
PNEUMATICO - PNEUMATIC

SP3 B

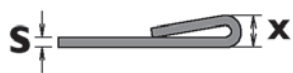


IDRAULICO - HYDRAULIC

SP3 C

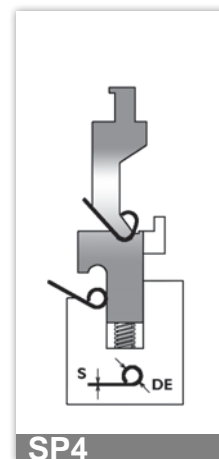


DUO pneumatico - pneumatic

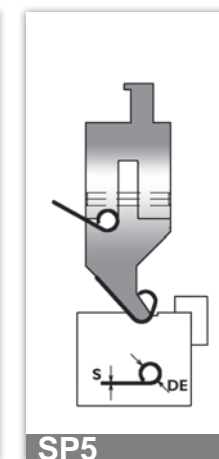


S mm	X	R 450 N/mm <sup>2</sup>	R 700 N/mm <sup>2</sup>	S mm	X	R 450 N/mm <sup>2</sup>	R 700 N/mm <sup>2</sup>
0,6	mm 3,0	90 kN/mt	150 kN/mt	0,6	mm 1,2	230 kN/mt	350 kN/mt
0,8	mm 3,0	120 kN/mt	200 kN/mt	0,8	mm 1,6	320 kN/mt	500 kN/mt
1	mm 3,5	150 kN/mt	250 kN/mt	1	mm 2,0	400 kN/mt	600 kN/mt
1,2	mm 3,5	170 kN/mt	260 kN/mt	1,2	mm 2,4	500 kN/mt	800 kN/mt
1,5	mm 4,6	220 kN/mt	380 kN/mt	1,5	mm 3,0	630 kN/mt	950 kN/mt
2	mm 5,5	300 kN/mt	500 kN/mt	2	mm 4,0	800 kN/mt	1300 kN/mt
2,5	mm 6,5	550 kN/mt	900 kN/mt	2,5	mm 5,0	900 kN/mt	1800 kN/mt
3	mm 8,0	700 kN/mt	1000 kN/mt	3	mm 6,0	1000 kN/mt	2100 kN/mt

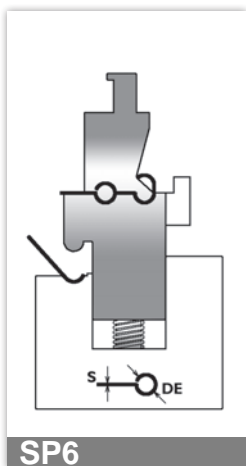
S : spessore - thickness - R : resistenza - resistance



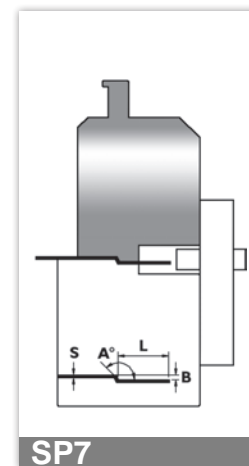
SP4



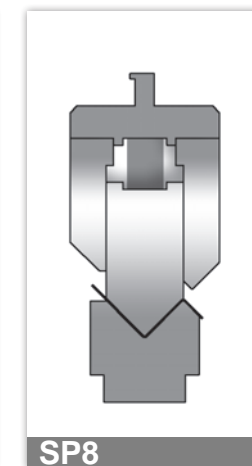
SP5



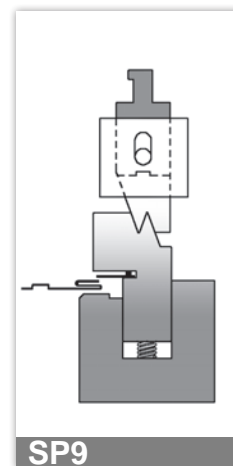
SP6



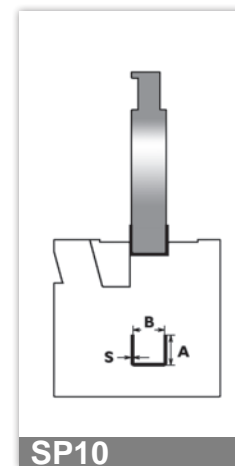
SP7



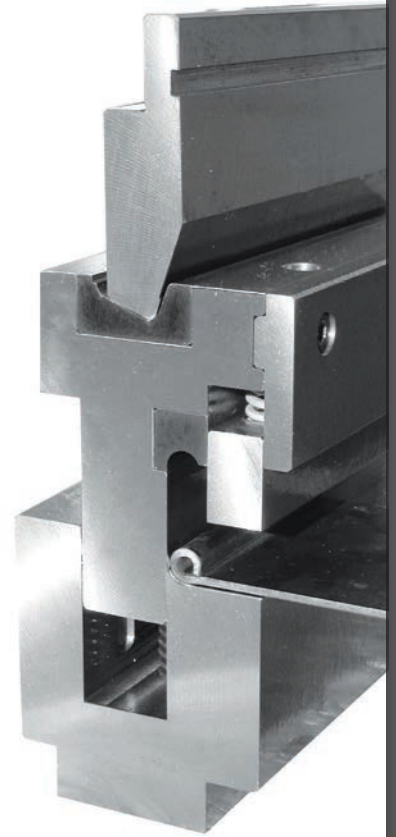
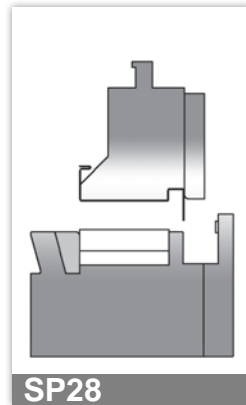
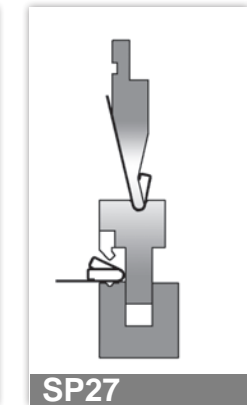
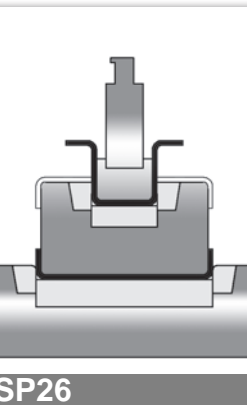
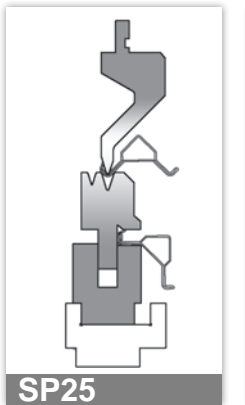
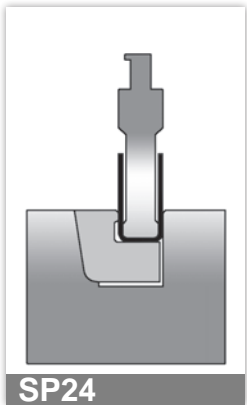
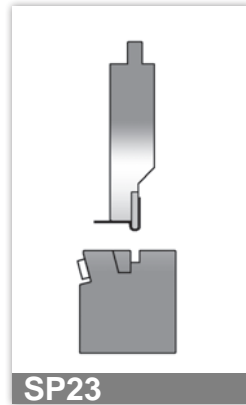
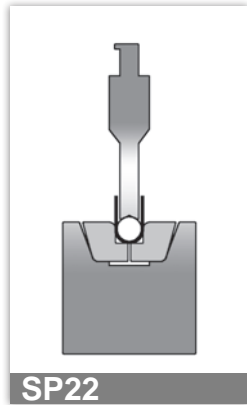
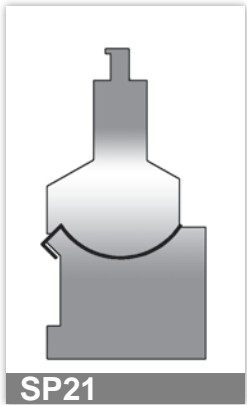
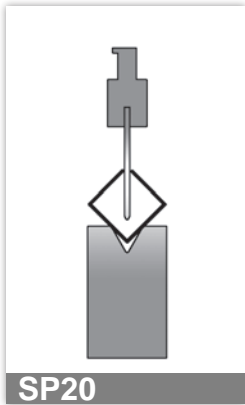
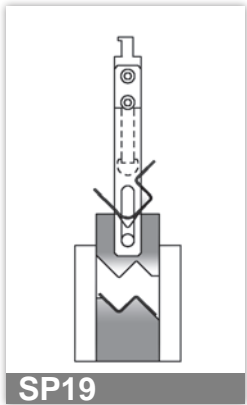
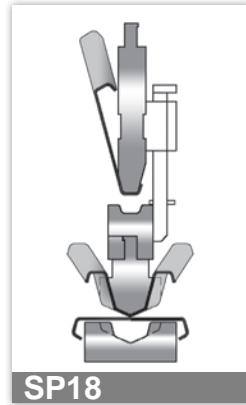
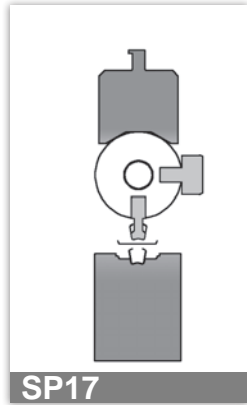
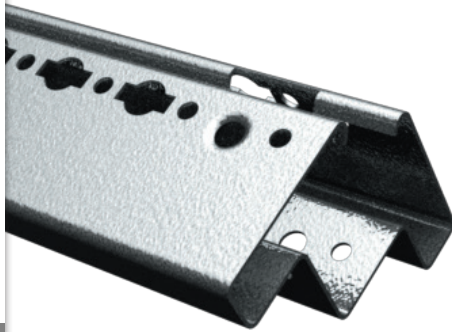
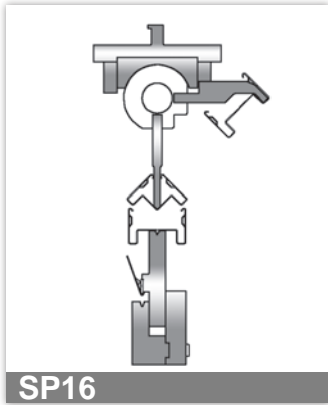
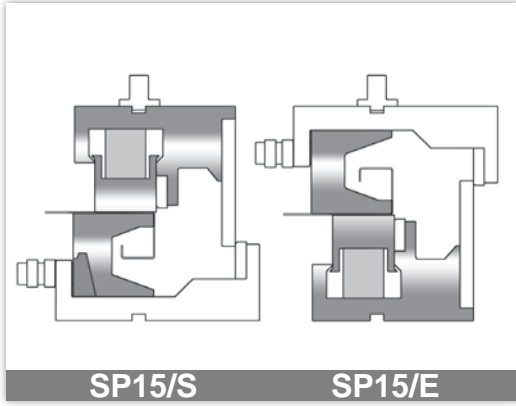
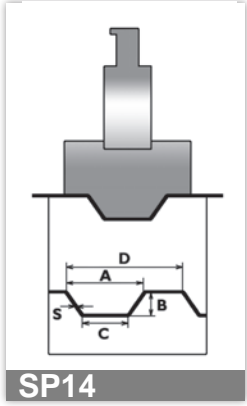
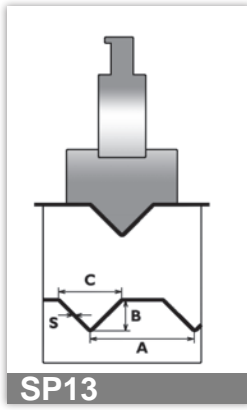
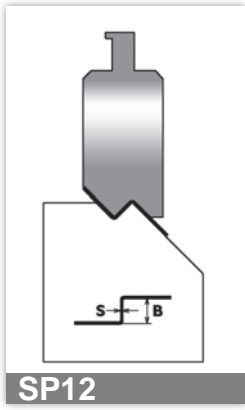
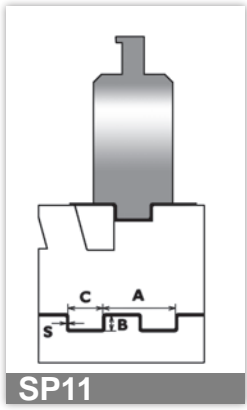
SP8



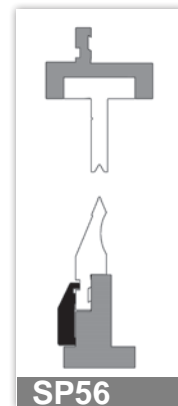
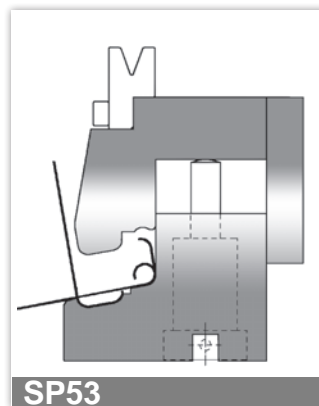
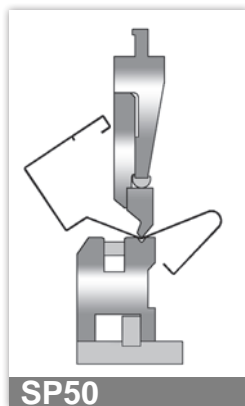
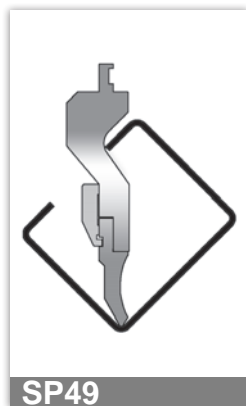
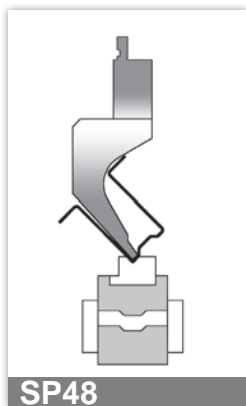
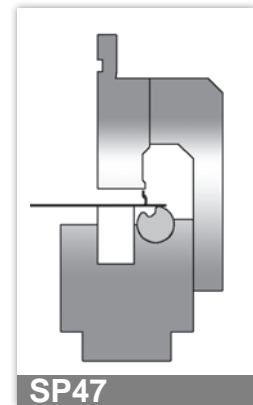
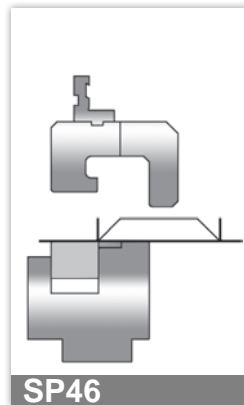
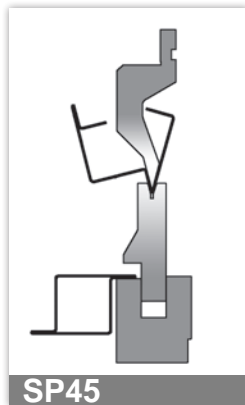
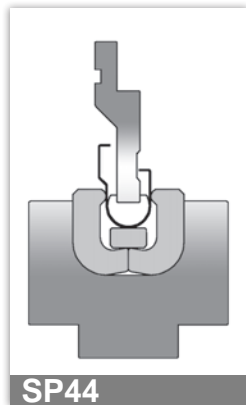
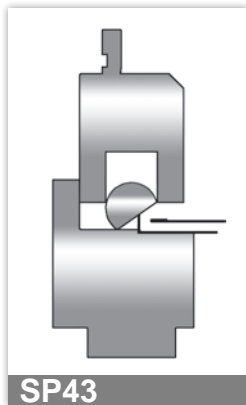
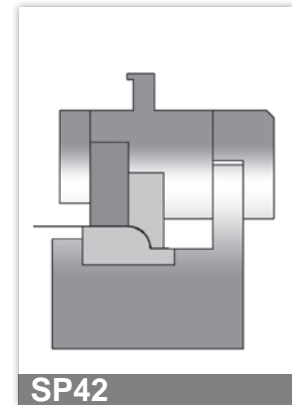
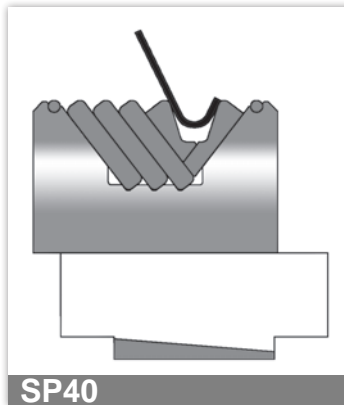
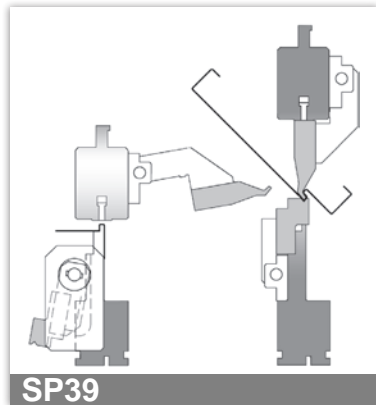
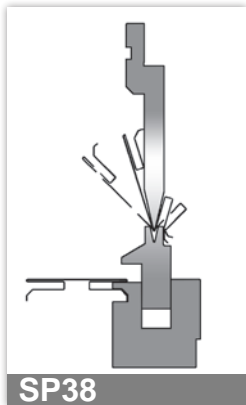
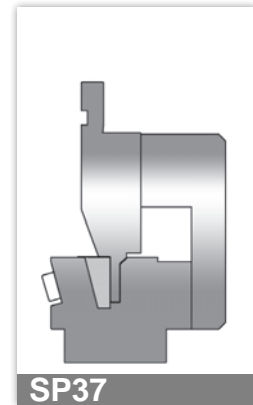
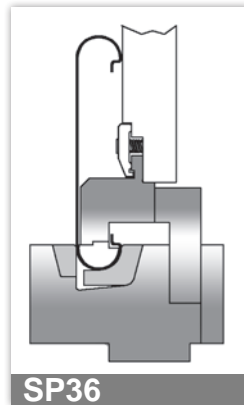
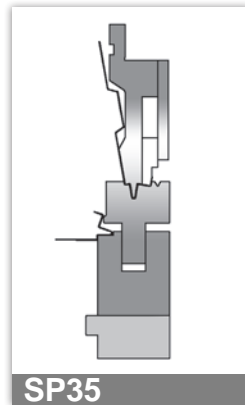
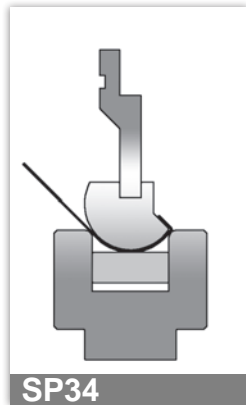
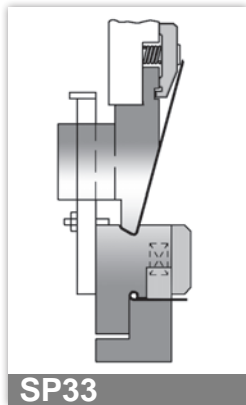
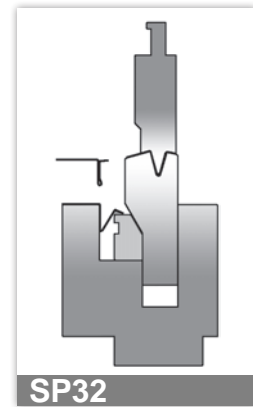
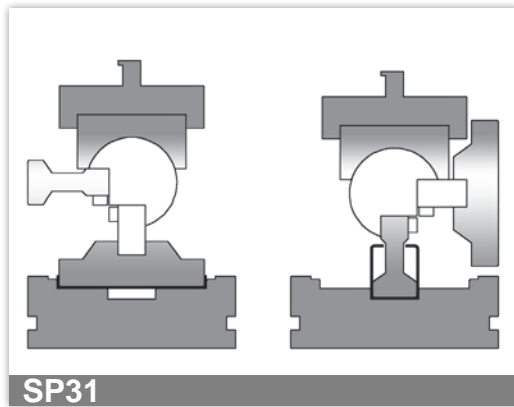
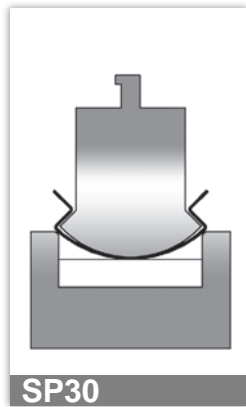
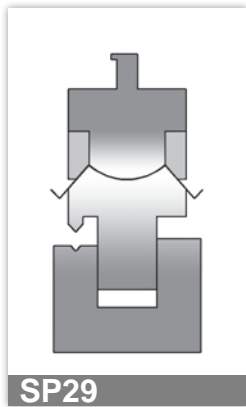
SP9

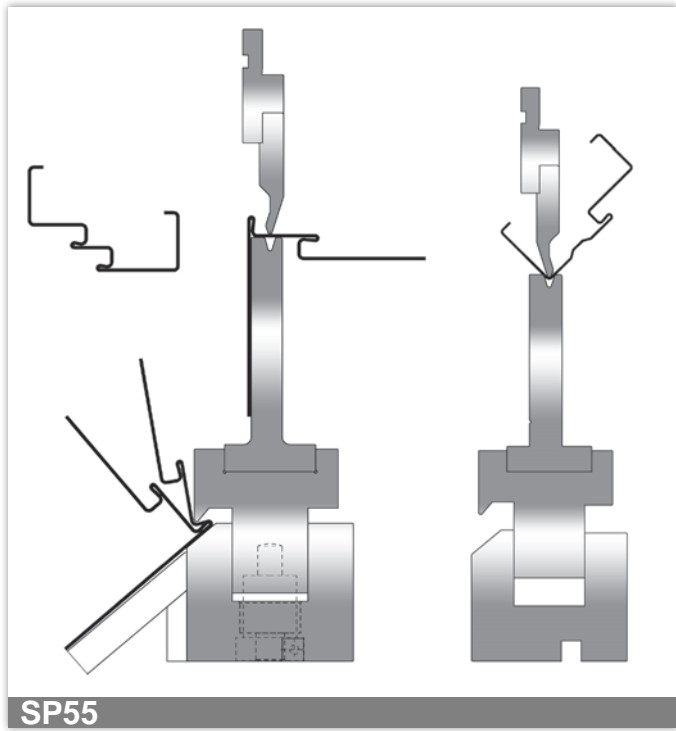


SP10

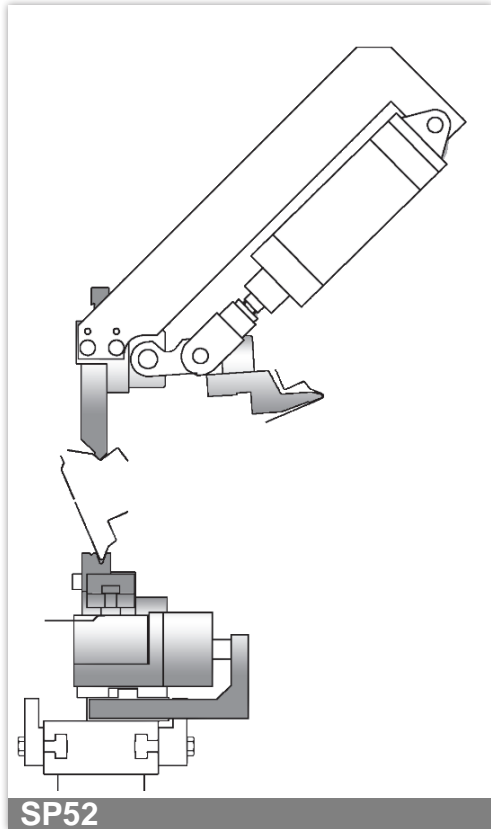
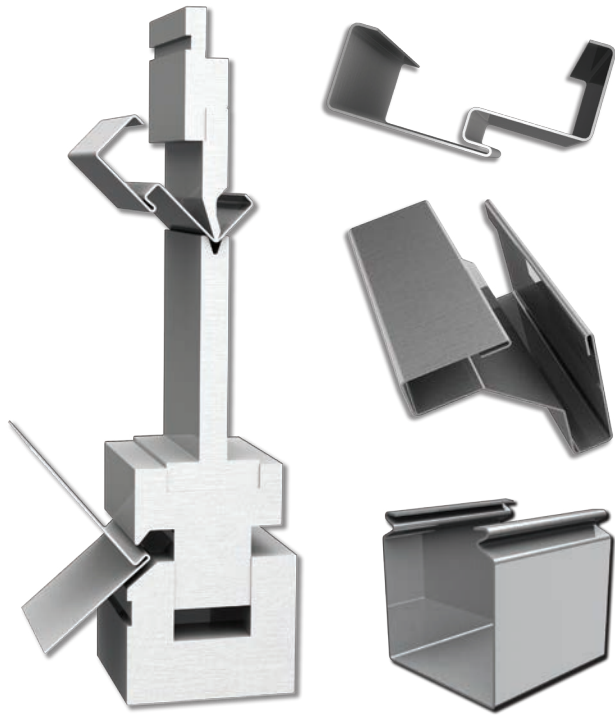




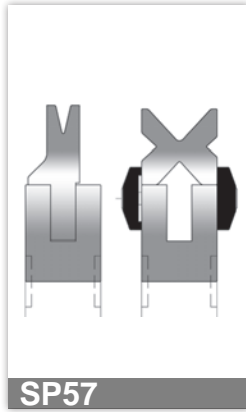




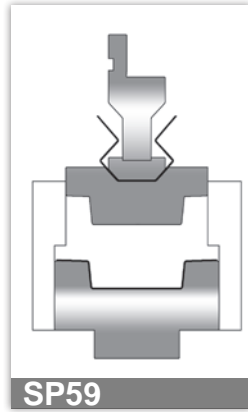
SP55



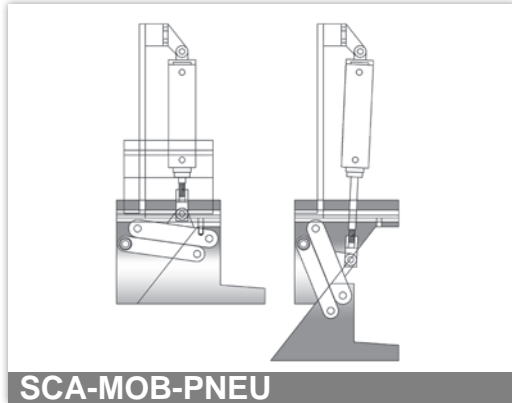
SP52



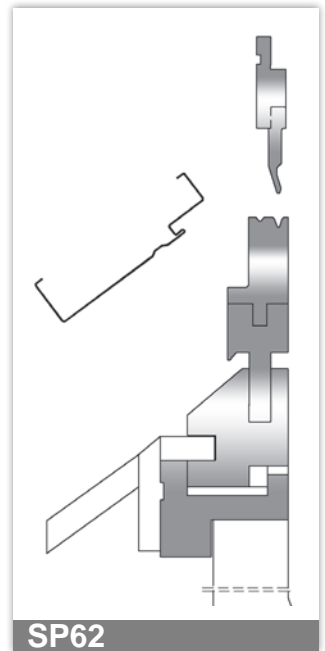
SP57



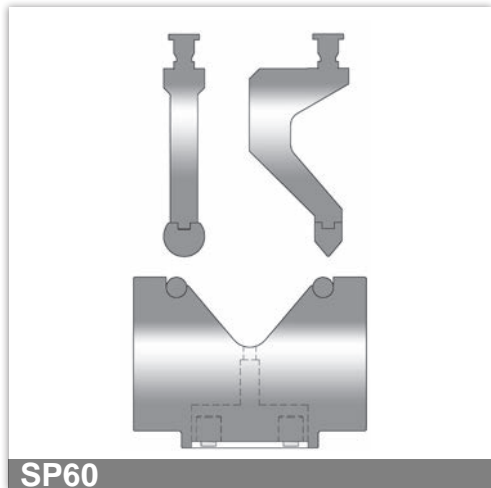
SP59



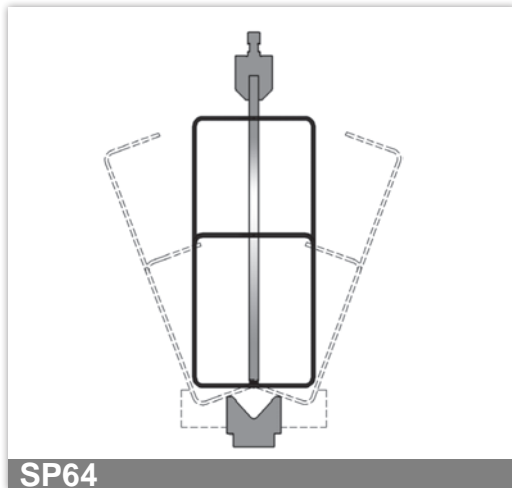
SCA-MOB-PNEU



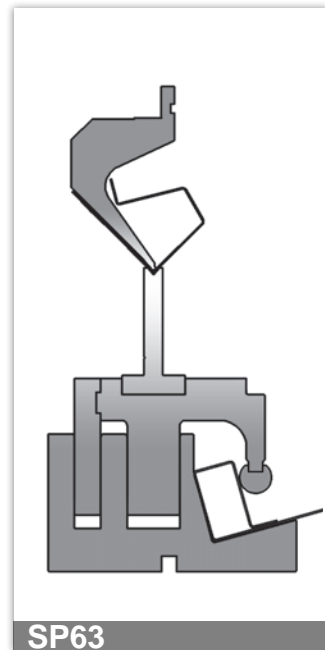
SP62



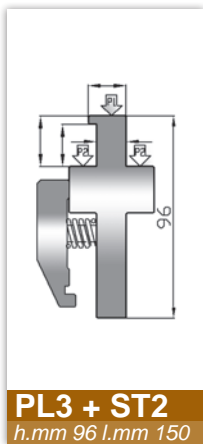
SP60



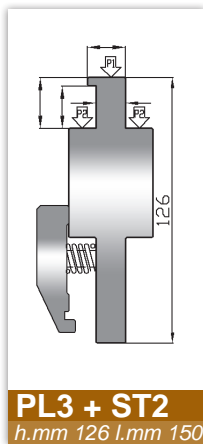
SP64



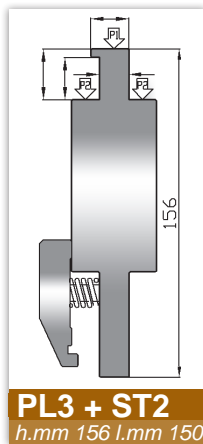
SP63



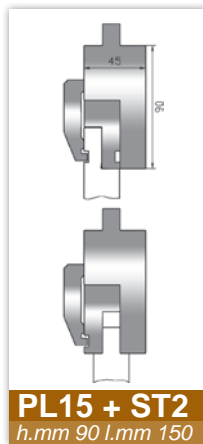
**PL3 + ST2**  
h.mm 96 l.mm 150



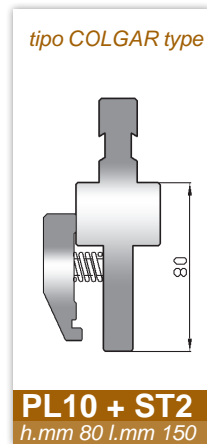
**PL3 + ST2**  
h.mm 126 l.mm 150



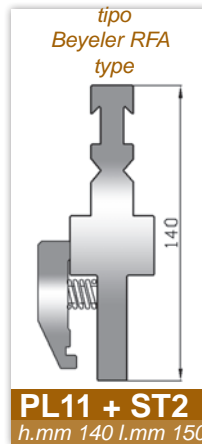
**PL3 + ST2**  
h.mm 156 l.mm 150



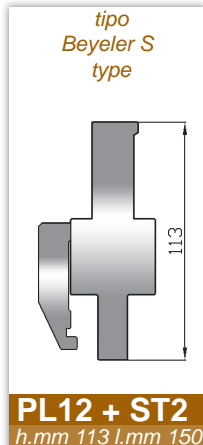
**PL15 + ST2**  
h.mm 90 l.mm 150



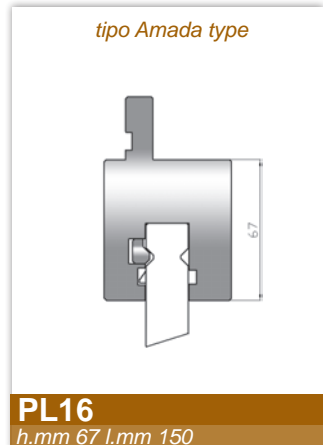
**PL10 + ST2**  
h.mm 80 l.mm 150



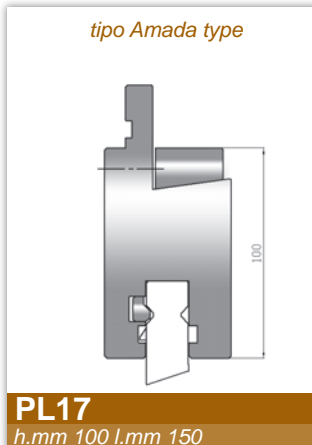
**PL11 + ST2**  
h.mm 140 l.mm 150



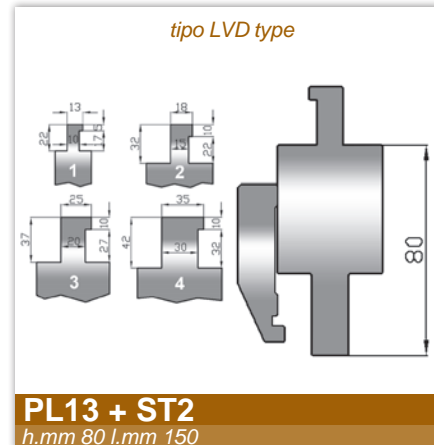
**PL12 + ST2**  
h.mm 113 l.mm 150



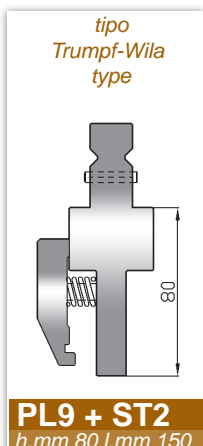
**PL16**  
h.mm 67 l.mm 150



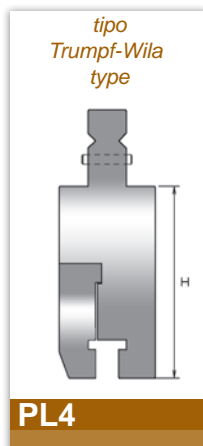
**PL17**  
h.mm 100 l.mm 150



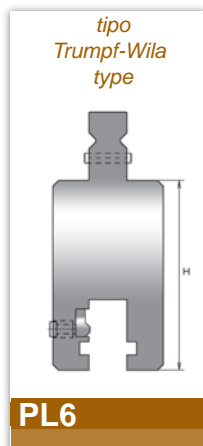
**PL13 + ST2**  
h.mm 80 l.mm 150



**PL9 + ST2**  
h.mm 80 l.mm 150



**PL4**



**PL6**

ST2/L - ST2/X  
possono essere fornite con inserto in ADIPRENE /G  
can be supplied with ADIPRENE /G insert



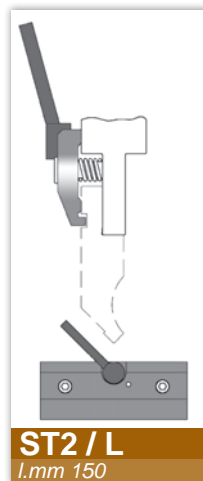
**ST2 h53**  
l.mm 150



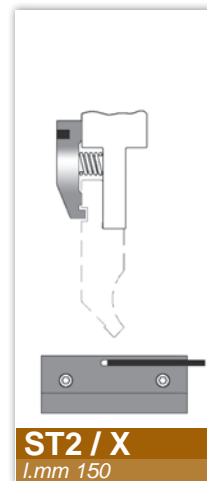
**ST2 h60**  
l.mm 150



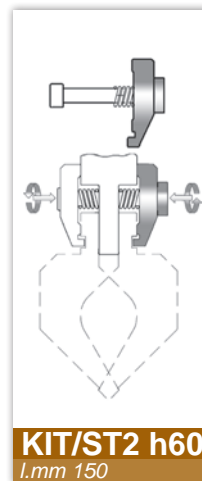
**ST1**  
l.mm 150



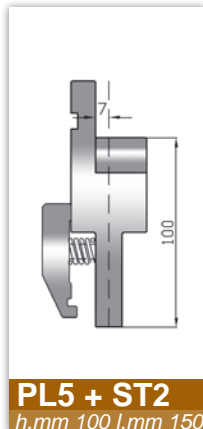
**ST2 / L**  
l.mm 150



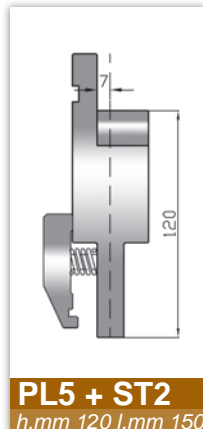
**ST2 / X**  
l.mm 150



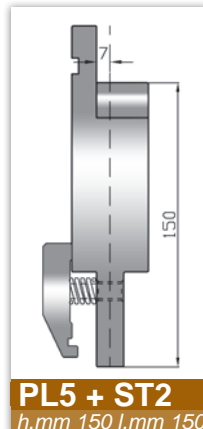
**KIT/ST2 h60**  
l.mm 150



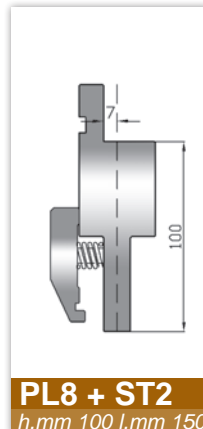
**PL5 + ST2**  
h.mm 100 l.mm 150



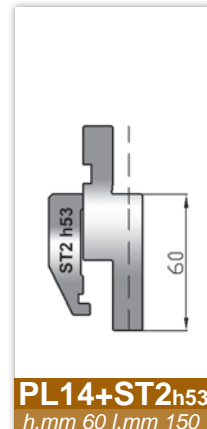
**PL5 + ST2**  
h.mm 120 l.mm 150



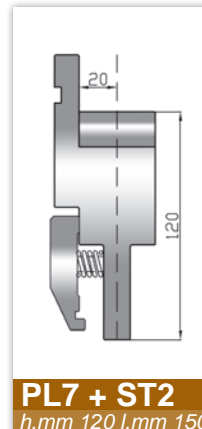
**PL5 + ST2**  
h.mm 150 l.mm 150



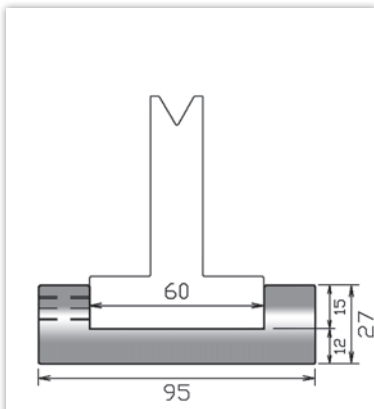
**PL8 + ST2**  
h.mm 100 l.mm 150



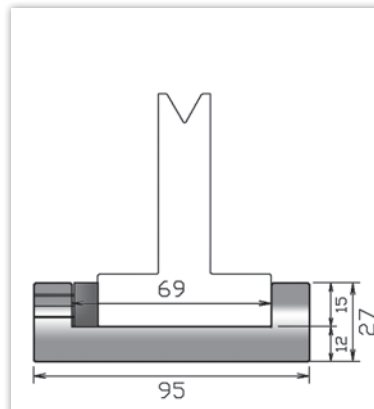
**PL14 + ST2 h53**  
h.mm 60 l.mm 150



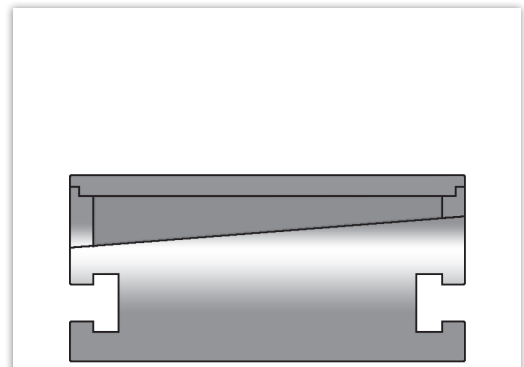
**PL7 + ST2**  
h.mm 120 l.mm 150



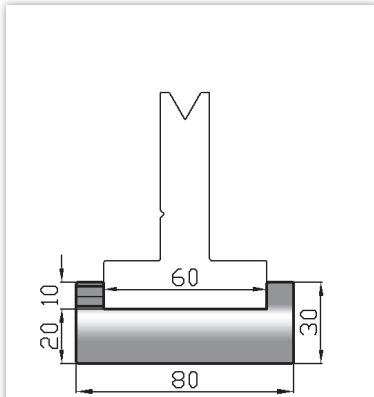
**PM6**  
l.mm 2100 - 2600 - 3100 - 4100



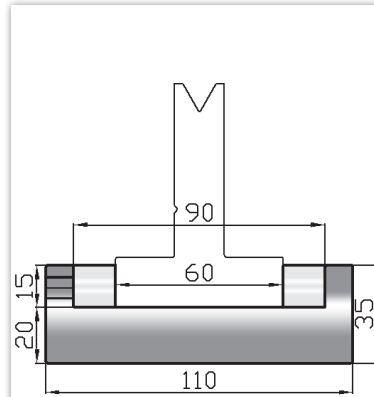
**PM7**  
l.mm 2100 - 2600 - 3100 - 4100



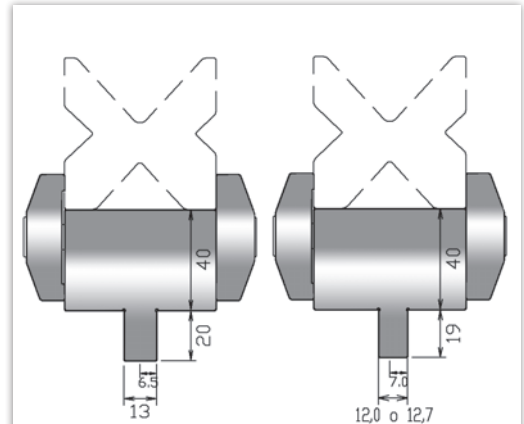
**PM5**



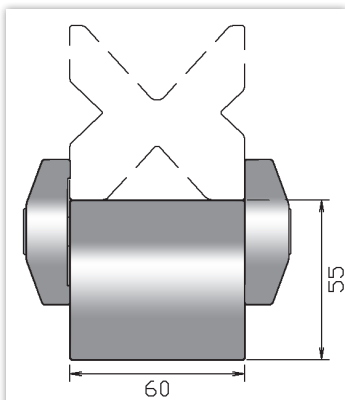
**PM6 SHORT mm 60**  
l.mm 520 - 1050



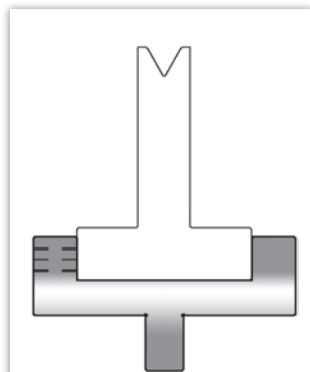
**PM6 SHORT mm 60/90**  
l.mm 520 - 1050



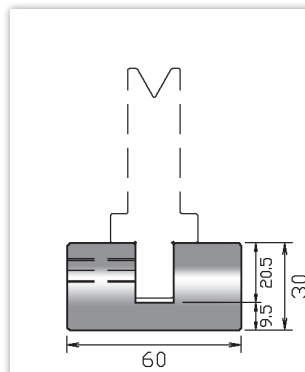
**PM9 / T**      **PM9 / L**  
l.mm 835 - 415      l.mm 835 - 415



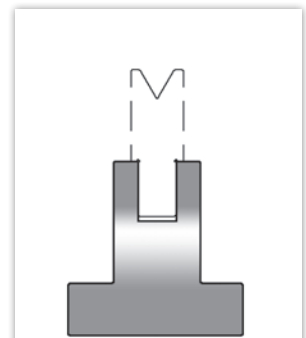
**PM9 / 60**  
l.mm 835 - 415



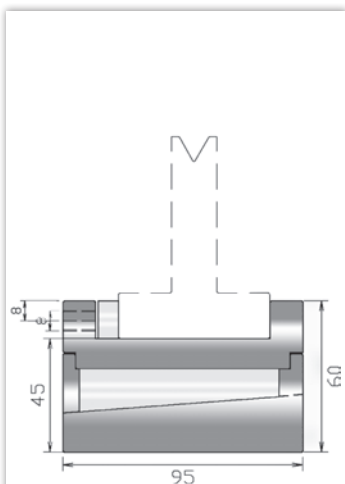
**PM8**  
l.mm 2100 - 2600 - 3100 - 4100



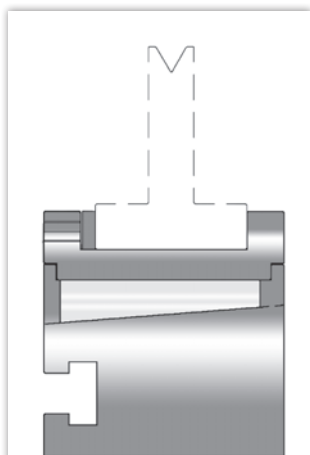
**PM10**



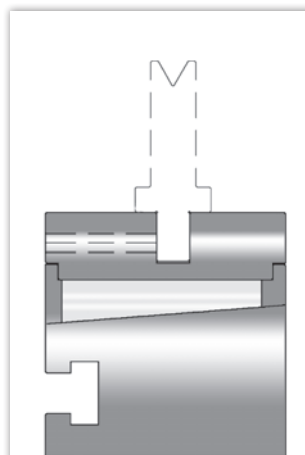
**PM11**



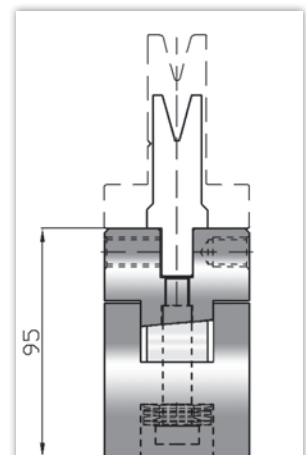
**PM12**



**PM13**

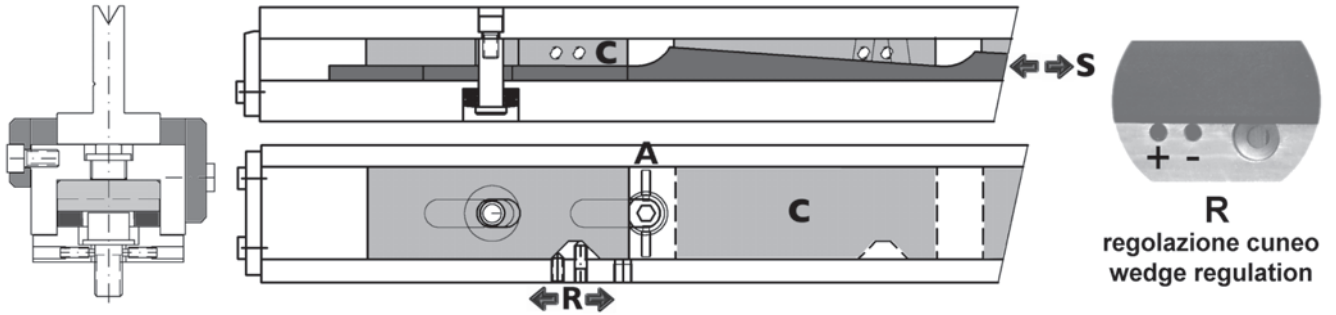


**PM14**



**PM15**

tavola portamatrici per pressa piegatrice con sistema automatico di centinatura  
die-holder table for press brakes with automatic crowning system



Con l'utilizzo di questo sistema è possibile compensare meccanicamente la flessione che si verifica sulle presse piegatrici durante la fase di piegatura e che determina angoli di piega irregolari. La flessione varia in funzione della lunghezza di piegatura ed in base al rapporto tra la larghezza della cava ed il tipo e spessore della lamiera.

Il sistema TABLUS (**brevettato**) è composto da una barra speciale (**S**) che scorre in contrapposizione a dei cunei (**C**). Ogni cuneo, se necessario, può essere calibrato singolarmente (**R**).

La barra è azionabile manualmente (**sistema TCM-TSM**) oppure attraverso un motoriduttore controllato dal DNC della pressa piegatrice (**sistema TCMR-TSMR**).

La regolazione della TABLUS viene effettuata in modo rapido e preciso prima della fase di piegatura. Ogni singola TABLUS è prodotta in base alle caratteristiche della pressa piegatrice su cui verrà utilizzata, in modo da ottimizzare il suo funzionamento.

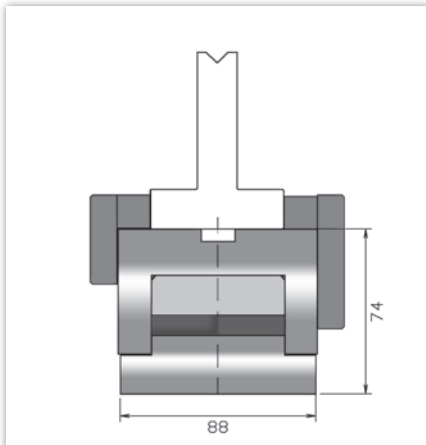
Questo avviene attraverso l'utilizzo di uno speciale software, denominato **DATA TABLUS**, che calcola le flessioni della pressa piegatrice e fornisce indicazioni su come realizzare il sistema di centinatura. Si ottiene quindi un sistema in grado di garantire una regolazione centesimale ed accurata. Esistono più versioni di TABLUS che si differenziano in base al tipo di matrici utilizzate. Le versioni TCM-TCMR vengono fornite complete di staffe per il bloccaggio manuale delle matrici. Su richiesta può essere fornito un sistema pneumatico per il bloccaggio rapido. TABLUS viene fornita pronta per il fissaggio e l'allineamento alla pressa piegatrice.

**DATA TABLUS esempio - example**

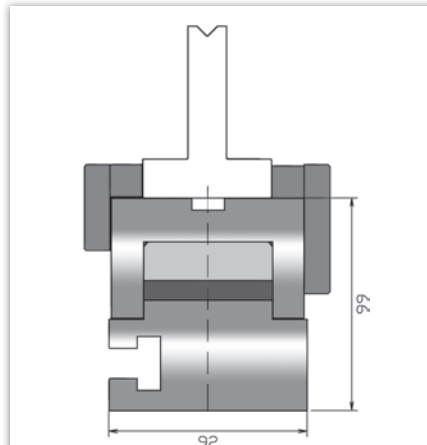
P				L				cuneo	distanze	STRISCIA <b>S</b> max compensazione con regolazione 30 mm	CUNEO <b>C</b> max compensazione con regolazione 8 mm
forza pressa		kN	1200	* lunghezza pressa		mm	3100				
<b>PESTONE</b>											
LIP	distanza appoggi	mm	2650	<b>TRAVERSA INFERIORE</b>							
LCP	lunghezza centrale	mm	2260	LIT	distanza appoggi	mm	2650	1	150	0,30 mm	0,08 mm
HP	altezza centrale	mm	1235	LCT	** lunghezza centrale	mm	2600	2	350	0,62 mm	0,17 mm
HEP	altezza esterna	mm	495	HT	altezza centrale	mm	845	3	550	0,88 mm	0,24 mm
SP	spessore pestone	mm	50	HET	** altezza esterna	mm	435	4	750	1,07 mm	0,28 mm
				ST	spessore traversa	mm	100	5	950	1,18 mm	0,32 mm
				LIP <sub>m</sub>	LIP < LIP <sub>m</sub> = cunei negativi limite cunei negativi	mm	2430	6	1150	1,27 mm	0,34 mm
				* lunghezza L sempre pari a multiplo di 200+100 ** per traversa senza rientranze LCT=L e HET=HT				7	1350	1,32 mm	0,35 mm
				<b>RINFORZO SU TRAVERSA INFERIORE</b>				8	1550	1,34 mm	0,36 mm
				STINF	mm	120	9	1750	1,32 mm	0,35 mm	
				HTINF	mm	250	10	1950	1,27 mm	0,34 mm	
							11	2150	1,18 mm	0,32 mm	
							12	2350	1,07 mm	0,28 mm	
							13	2550	0,88 mm	0,24 mm	
							14	2750	0,62 mm	0,17 mm	
							15	2950	0,30 mm	0,08 mm	

This system provides mechanical compensation of deflections appearing during the bending process. Deflection changes depending on bending length, die slot width, type of material and its thickness. TABLUS system (**patented**) is composed by a special rod (**S**) which is placed between opposite wedges (**C**). Every wedge can be calibrated if necessary (**R**).

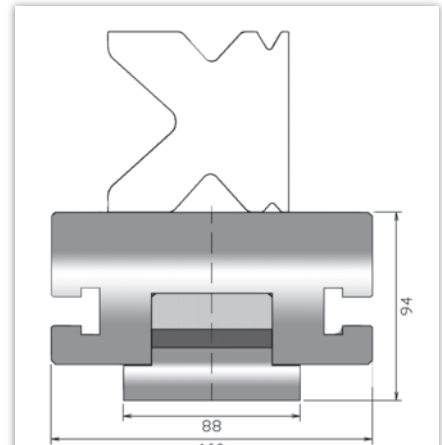
The rod is driven manually (**TCM-TSM system**) or by a motoreducer controlled by CNC (**TCMR-TSMR system**). The adjustment of TABLUS system is a fast and accurate procedure to execute before bending. Every TABLUS system is produced on the base of the press brake characteristics to optimize its functioning. That is provided by the use of special software **DATA TABLUS**, which calculates press brake deflections and provides crowning system throughout control commands. This system grants a very high accuracy. There are more versions of TABLUS system depending on the type of the used dies. TCM and TCMR versions are supplied with manual die clampings. On request we supply pneumatic system for fast clamping. TABLUS is ready for installation and leveling already.



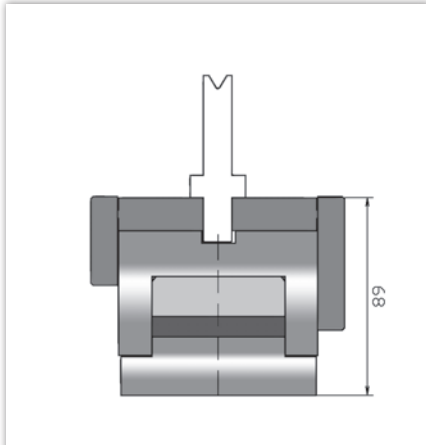
**TCM - TCMR 60/90**  
3100-4100-5100-6100 mm L



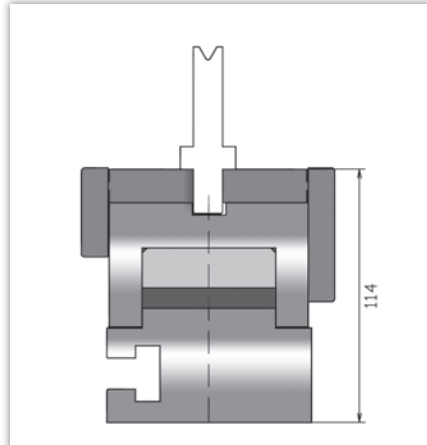
**TCM - TCMR 60/90 + T**  
3100-4100-5100-6100 mm L



**TM - TMR 160**  
3100-4100-5100-6100 mm L



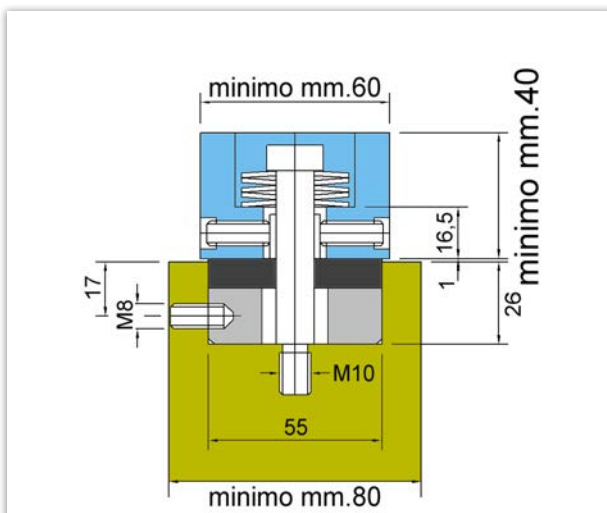
**TCM - TCMR 13/60/90**  
3100-4100-5100-6100 mm L



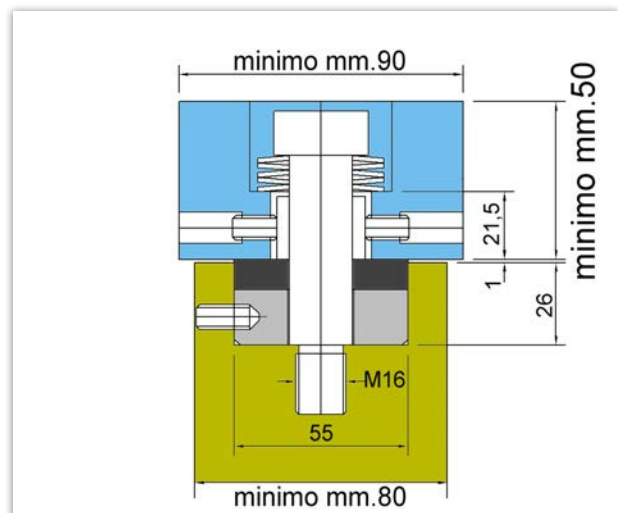
**TCM - TCMR 13/60/90 + T**  
3100-4100-5100-6100 mm L



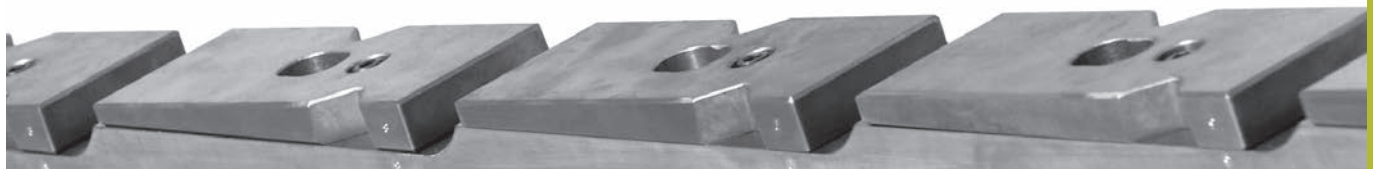
**sistema automatico di centinatura integrato nella traversa della pressa piegatrice**  
**automatic crowning system integrated inside press brake lower beam**



**TSM - TSMR 60**  
3100-4100-5100-6100 mm L



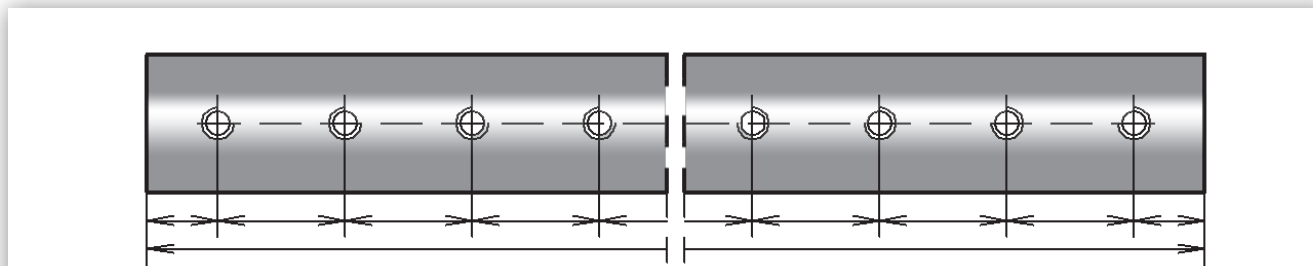
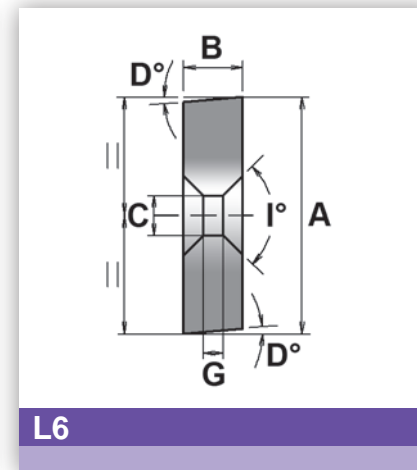
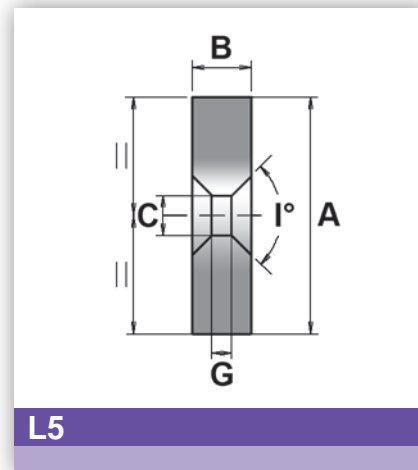
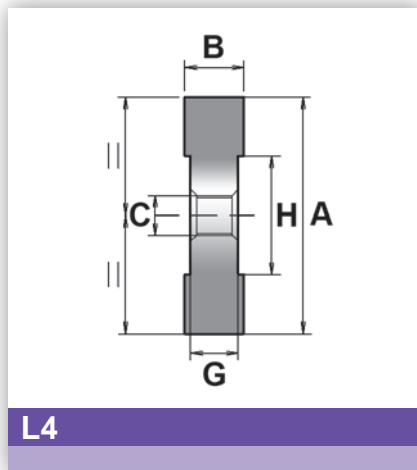
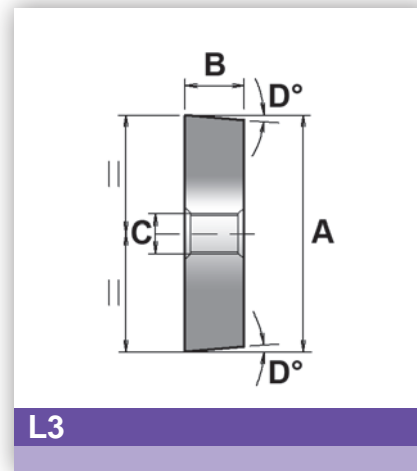
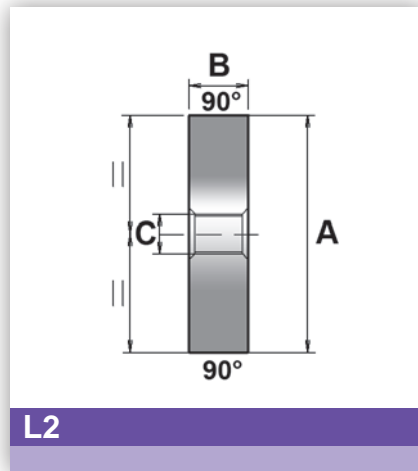
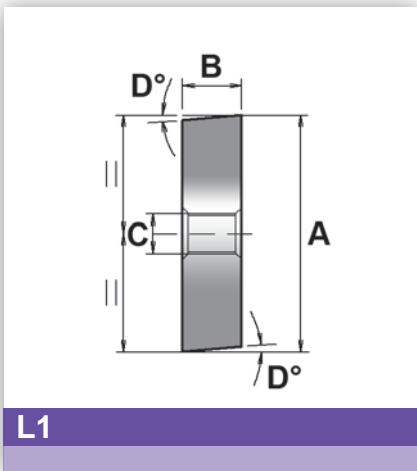
**TSM - TSMR 90**  
3100-4100-5100-6100 mm L



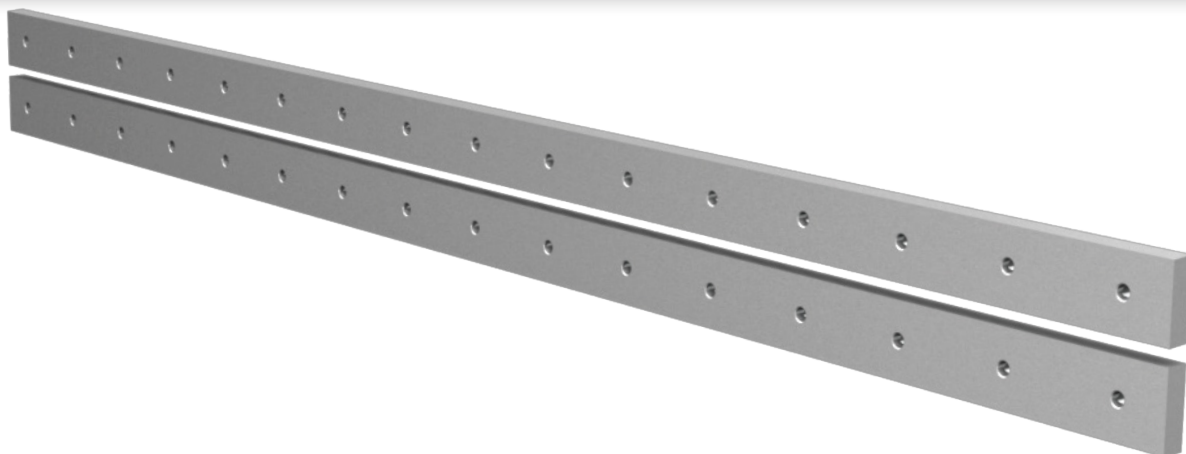
LAME PER CESOIA - SHEAR BLADES

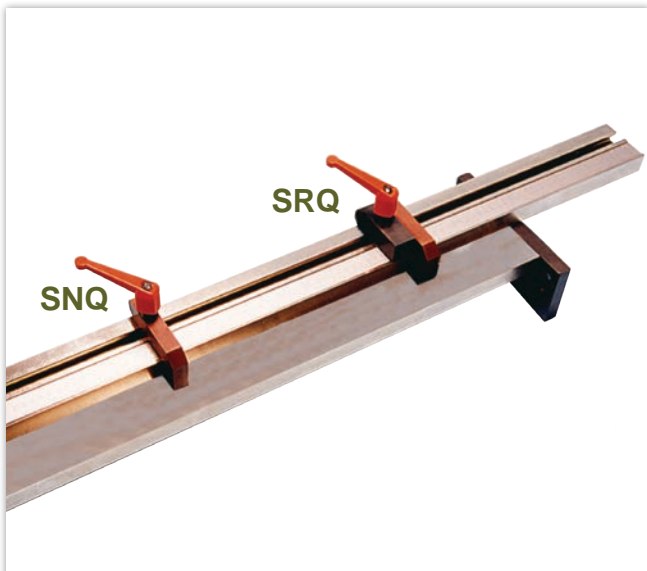
capacità di taglio - cutting capacity

acciaio-steel	lamiera in ferro iron sheet	acciaio inox stainless steel
PV	mm 0 ÷ 40	mm 0 ÷ 15

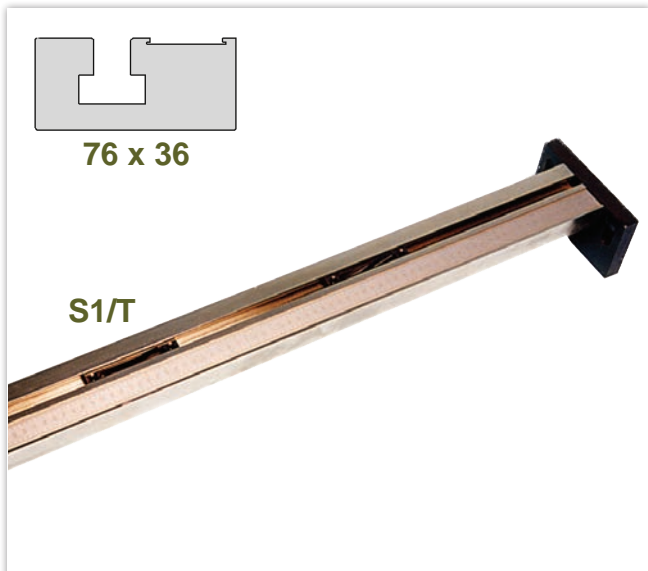


dimensioni - dimensions

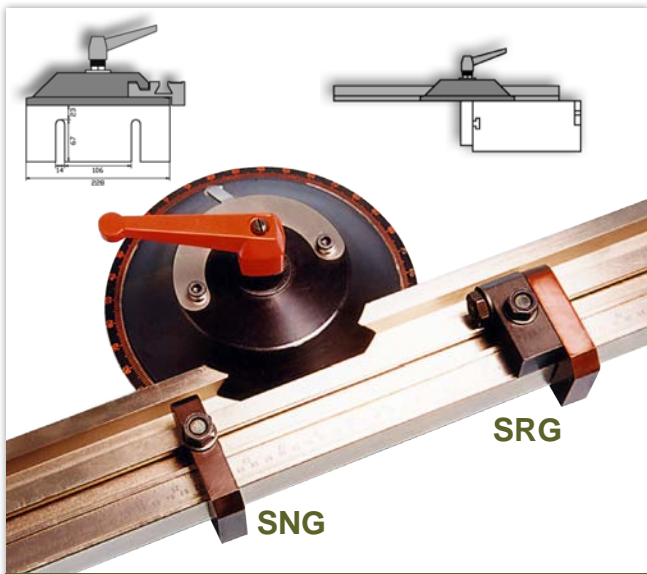




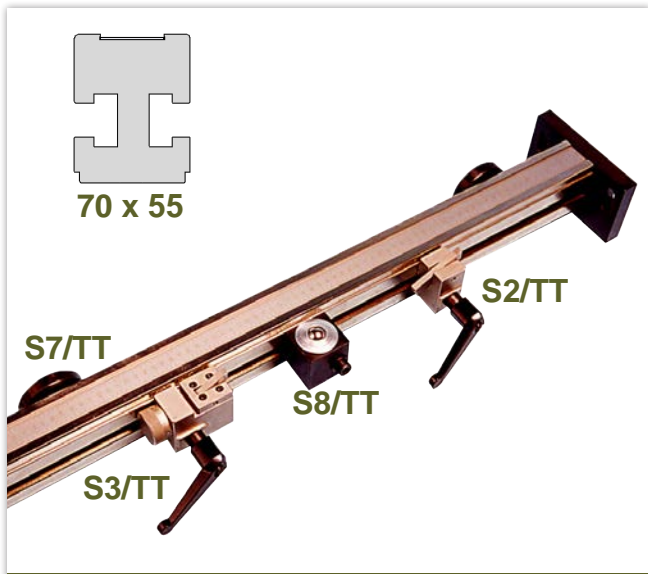
**SQ** SQUADRA PER CESOIA  
SQUARING ARM FOR SHEAR  
*temprata ad induzione - induction hardened*



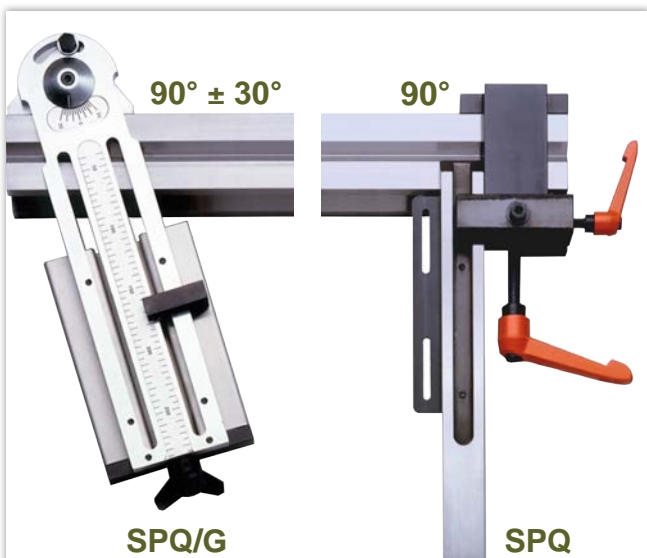
**R20** RIFERIMENTO PER CESOIA  
REFERENCE FOR SHEAR



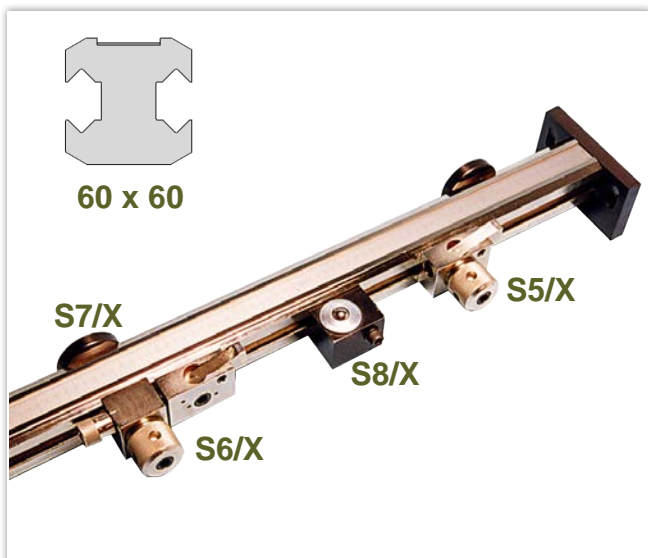
**G** GONIOMETRO PER CESOIA  
GONIOMETER FOR SHEAR  
*temprato ad induzione - induction hardened*



**R30** RIFERIMENTO PER CESOIA  
REFERENCE FOR SHEAR



**SPQ** SQUADRA PER PRESSA  
PRESS BRAKE SQUARING



**R40** RIFERIMENTO PER CESOIA  
REFERENCE FOR SHEAR



**SS** RIFERIMENTO PER PRESSA  
REFERENCE FOR PRESS BRAKE  
*lunghezze - lengths 500 / 1000 / 1500 mm*

**RR** RIFERIMENTO PER PRESSA  
REFERENCE FOR PRESS BRAKE  
*lunghezze - lengths 500 / 1000 / 1500 mm*

Questa attrezzatura utilizza solo utensili standard tipo US  
On this forming die can be used US type standard tools only

**UP** UNITA' DI PIEGATURA 835 - 415 mm L.  
FORMING DIE 835 - 415 mm L.

**GIMEC - TEND**  
coppia di tenditori per pellicola antigraffio  
pair of tensioners for die cover film

**URET** PELLICOLA ANTIGRAFFIO  
DIE COVER FILM  
*dimensioni-dimensions mm.100 x 0,5 / rotoli - rolls 30 / 20 / 10 mt*



**ARM 4 / 835** 4 cassettei - drawers  
mm 850x1050px1240h

**ARM 5 / 835** 5 cassettei - drawers  
mm 1040x1050x1240 h

idoneo per utensili - suitable for tools  
tipo EUROPA type

**ARM 4 / 1020** 4 cassettei - drawers  
mm 850x1360px1240h

**ARM 5 / 1020** 5 cassettei - drawers  
mm 1040x1360x1240 h

idoneo per utensili - suitable for tools  
tipo Trumpf-Wila Beyeler-Bystronic type



## ARM4 - ARM5

## ARMADIO UTENSILI TOOLS CABINET



**ARM-OPEN / 835** mm 860x860x1580 h

6 ripiani con traversini l.mm.835  
2 cassettei per frazionati (capienza max 54 utensili)

6 shelves with 835 mm.l. ties  
2 drawers for sectioned tools (max cap.54 tools)

idoneo per utensili - suitable for tools  
tipo EUROPA type



## ARM-OPEN

## ARMADIO UTENSILI TOOLS CABINET



**ARM-WHEELS 1** mm 1160x1060x1520 h

idoneo per utensili - suitable for tools  
tipo EUROPA type (30 ripiani-shelves)

**ARM-WHEELS 2** mm 1160x1060x1520 h

idoneo per utensili - suitable for tools  
tipo Trumpf-Wila type (21 ripiani-shelves)

**ARM-WHEELS 3** mm 1160x1060x1520 h

idoneo per utensili - suitable for tools  
tipo Beyeler-Bystronic type (21 ripiani-shelves)



## ARM-WHEELS

## ARMADIO UTENSILI TOOLS CABINET

# TECNICHE DI PIEGATURA - BENDING TECHNIQUES

## PIEGATURA IN ARIA - AIR BENDING



Nella piegatura in aria l'angolo di piega è determinato dalla posizione che la punta dell'utensile superiore raggiunge rispetto ai due spigoli della matrice, posizione variabile a seconda dello spessore, della resistenza e dell'elasticità della lamiera. I vantaggi nell'utilizzo di questa tecnica di piegatura consistono nell'impiego di una minima forza di piegatura e nella possibilità di piegare qualsiasi spessore, compatibilmente al tipo di pressa ed utensili disponibili. Inoltre gli stessi utensili possono essere utilizzati per differenti tipi di materiale e si possono ottenere angoli inferiori ai 90° e raggi interni di piegatura variabili in proporzione alla larghezza della matrice. Gli svantaggi consistono nel dover utilizzare lamiere con spessore e resistenza costanti per ottenere risultati soddisfacenti. *During the air bending the bending angle is determined by the position reached by the upper tool end position in relation to the die edges. The position changes in connection to thickness, resistance and stretch of material. The advantages in the use of this method are in the use of min bending force and in the possibility to bend any thickness being subject to press brake type and tool types. Moreover, the same tools can be used for different material types, for angles lower than 90 degrees and in inner radius changeable proportionally to the die slot width. The disadvantages are in the use of metal sheet having exact thickness and resistance in order to get profitable results.*

## CONIATURA - COINING



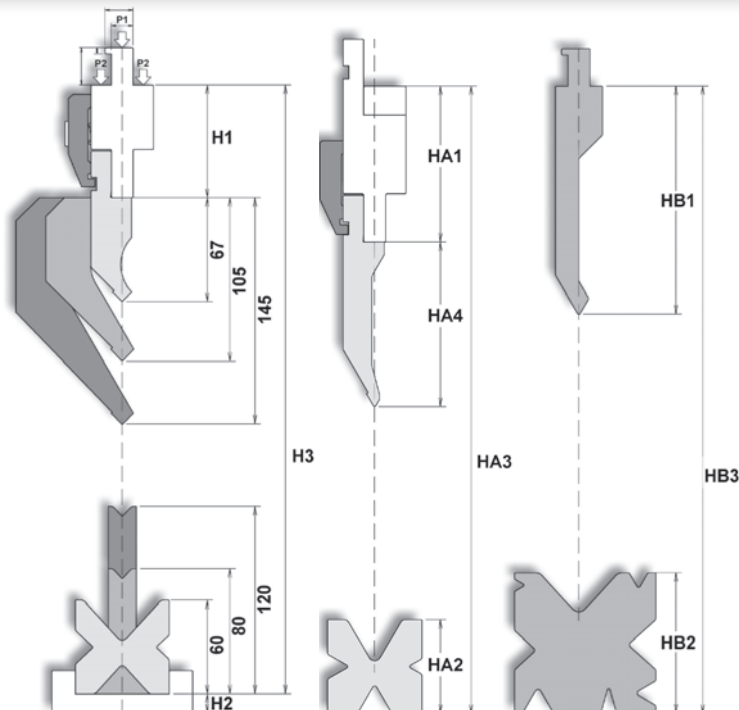
La conatura è un procedimento di piegatura che permette di ottenere pieghe perfettamente a 90° anche in presenza di consistenti differenze di spessore e di resistenza della lamiera. Per contro richiede una forza superiore rispetto alle altre tecniche di piegatura, quantificabile da 5 a 7 volte quella necessaria per la piegatura in aria. Infatti la punta dell'utensile superiore deve coniare il normale raggio di piegatura facendolo combinare con la forma dell'utensile stesso. Si possono pertanto ottenere pieghe perfette con raggi di curvatura molto piccoli. Gli utensili devono essere calibrati in base allo spessore ed al tipo di lamiera, che non deve comunque superare il limite massimo di mm.2 *Forming is a bending method which allows to obtain exact 90 degrees angles even if when thickness and resistance are very different. The method demands max force in comparison to the other bending methods, 5-7 times more than in the air bending. As a matter of fact, the upper tool end has to form the normal bending radius by matching it with the shape of the same tool. This method grants optimal results with very little inner radius. The tools shall be calibrated depending on material thickness and type. Nevertheless the sheet thickness shall not exceed max. 2 mm.*

## PIEGATURA A FONDO MATRICE - BENDING ON LOWER TOOL BOTTOM

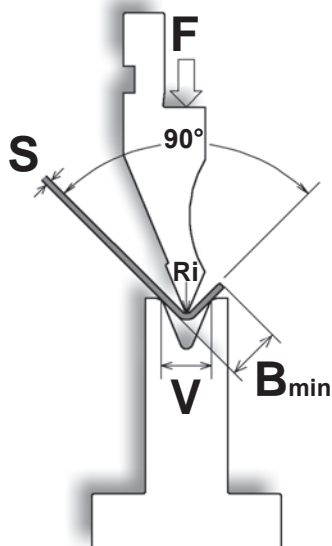


La piegatura a fondo matrice opera, nella fase iniziale, come per la piegatura in aria, mentre nella fase finale preme sul raggio interno della lamiera piegata determinando l'angolo di piegatura. Praticamente l'angolo di piegatura viene raggiunto agendo sulla forza applicata alla punta dell'utensile superiore nella fase di chiusura. Essendo il raggio di curvatura della lamiera variabile in funzione dello spessore e dell'apertura della matrice, diventa necessario variare la forma degli utensili, anche in considerazione dei diversi ritorni elastici tra i vari materiali. Nell'utilizzo di questa tecnica di piegatura le irregolarità dello spessore e le variazioni della resistenza della lamiera hanno una minima influenza. Pertanto con un corretto accoppiamento degli utensili ed una costante forza di piegatura si può ottenere una sicura ripetibilità dell'angolo di piega. Gli aspetti negativi consistono in un leggero aumento della forza di piegatura (+20% rispetto alla piegatura in aria, a parità di condizioni), nella impossibilità di ottenere angoli inferiori ai 90° e nel utilizzo di lamiere con spessore massimo di mm.5. *Die bottom bending is carried out at its first stage in the same way as air bending, whilst during the final stage the upper tool presses the sheet against the die bottom forming final angle. The bending angle is achieved by acting on the force applied on the upper tool end during the final stage. Since the die radius changes in relation to the thickness and opening of the die, it becomes necessary to change the shape of the tools, also in consideration of the different elastic stretches between the materials. In the use of this bending methods, the differences of sheet thickness and strength are minimal. Therefore, with a correct combination of tool and constant bending force you can get a good repeatability of bent angle. The disadvantages are in a small increasing of the bending force (+20% more than in the air bending method in presence of the same conditions), in the impossibility to get angles lower than 90 degrees and in the use of sheets with max. thickness 5 mm.*

**ZONA DI LAVORO  
WORKING AREA**



# TAVOLA DI PIEGATURA - BENDING CHART



## ATTENZIONE

NON SUPERARE IL CARICO MASSIMO AMMESSO DAGLI UTENSILI, IN QUANTO PUO' DARE LUOGO AL DANNEGGIAMENTO DEGLI UTENSILI O CAUSARE DANNI FISICI ALL'OPERATORE.

Il carico massimo ammissibile varia in base al tipo di utensili utilizzati. Calcolare sempre una pressione inferiore rispetto al carico indicato.

## WARNING

EXCEEDING THE MAXIMUM ALLOWABLE TONNAGE FOR THE TOOLING CAN BE VERY DANGEROUS AND MAY RESULT IN TOOLING DAMAGE OR MAY CAUSE BODILY INJURY BY SPLINTERING.

The maximum allowable pressure may vary, depending on the punch and die used. Always calculate the maximum pressure with the lowest rating of the punch or die.

piegatura in aria-air bending

**F** = kN al metro - kN for meter

**S** = spessore lamiera - sheet thickness

**R** = resistenza lamiera - sheet resistance

<b>S</b> mm.		0,6		0,8		1,0		1,2		1,5		2,0	
<b>V</b> mm.		6	8	6	8	6	8	8	10	10	12	12	16
<b>F</b> kN/mt.	R.200 N/mm <sup>2</sup>	20	10	30	20	60	40	60	40	70	60	110	80
	R.450 N/mm <sup>2</sup>	40	30	70	50	130	80	130	100	160	130	250	170
	R.700 N/mm <sup>2</sup>	60	40	110	80	190	130	200	150	250	200	390	260
<b>Ri</b>	Ri mm.	1,0	1,3	1,0	1,3	1,0	1,3	1,3	1,7	1,7	2,0	2,0	2,7
<b>B</b>	90°=B min.mm.	4,5	6,0	4,6	6,1	4,7	6,2	6,3	7,7	7,8	9,2	9,5	12,3
	60°=B min.mm.	6,3	8,3	6,4	8,4	6,5	8,5	8,6	10,6	10,8	12,8	13,0	17,0
	35°=B min.mm.	10,3	13,6	10,4	13,7	10,5	13,8	13,9	17,2	17,4	20,7	21,0	27,6

<b>S</b> mm.		2,5		3		4		5		6		8	
<b>V</b> mm.		16	20	20	25	32	40	40	50	50	63	63	80
<b>F</b> kN/mt.	R.200 N/mm <sup>2</sup>	130	90	140	110	150	110	190	140	210	160	310	220
	R.450 N/mm <sup>2</sup>	290	210	320	240	340	250	420	320	480	360	690	500
	R.700 N/mm <sup>2</sup>	440	330	500	370	530	390	660	490	750	550	1070	780
<b>Ri</b>	Ri mm.	2,7	3,3	3,3	4,2	5,3	6,7	6,7	8,3	8,3	10,5	10,5	13,3
<b>B</b>	90°=B min.mm.	12,6	15,4	15,6	19,2	24,6	30,3	30,8	37,9	38,4	47,5	48,5	60,6
	60°=B min.mm.	17,3	21,3	21,5	26,5	34,0	42,0	42,5	52,5	53,0	66,0	67,0	84,0
	35°=B min.mm.	27,9	34,5	34,8	43,1	55,2	68,5	69,0	85,6	86,1	107,8	108,8	137,0

<b>S</b> mm.		10		12		15		20		25		30	
<b>V</b> mm.		80	100	100	125	160	200	200	250	250	320	320	400
<b>F</b> kN/mt.	R.200 N/mm <sup>2</sup>	380	280	430	320	390	290	560	420	700	510	770	590
	R.450 N/mm <sup>2</sup>	840	630	960	720	870	660	1260	950	1580	1150	1740	1320
	R.700 N/mm <sup>2</sup>	1310	980	1490	1120	1350	1020	1960	1480	2450	1790	2710	2050
<b>Ri</b>	Ri mm.	13,3	16,7	16,7	20,8	26,7	33,3	33,3	41,7	41,7	53,3	53,3	66,7
<b>B</b>	90°=B min.mm.	61,6	75,7	76,7	94,4	120,6	148,9	151,4	186,8	189,3	238,8	241,3	297,8
	60°=B min.mm.	85,0	105,0	106,0	131,0	167,5	207,5	210,0	260,0	262,5	332,5	335,0	415,0
	35°=B min.mm.	138,0	171,3	172,3	213,8	273,5	340,1	342,6	425,7	428,2	544,6	547,1	680,1

Edizione 2 - Giugno 2016 - progetto grafico e realizzazione Roberto Giussani

Copyright Gimec srl - Tutti i diritti riservati

Nessuna parte di questa pubblicazione può essere riprodotta, trasmessa, trascritta, archiviata in un sistema di reperimento o tradotta in qualsiasi forma o con qualsiasi mezzo, senza il consenso scritto della Gimec srl. Inoltre ci riserviamo il diritto di modificare qualsiasi caratteristica tecnica o costruttiva senza l'impegno di comunicazioni preventive.