



Die clearance

Die clearance is the total space between die and punch.

A correct clearance between the punch and the die assures normal wear of the tool and punching without defect such as: burrs on the piece in the case of excessive clearance and premature wearing of the tool and increased punching force in the case clearance being too small.

Material				
Thickness mm	Mild steel 16-20%	Stainless steel 18-24%	Aluminum 12-16%	Copper 10-14%
0,5 – 0,6	0,08-0,1	0,1- 0,12	0,06 – 0,08	0,05 – 0,06
0,8	0,14 – 0,16	0,15 – 0,2	0,1 – 0,14	0,08 – 0,1
1	0,16 – 0,2	0,18 – 0,24	0,12 – 0,16	0,1 – 0,14
1,2	0,2 – 0,24	0,24 – 0,3	0,15 – 0,2	0,12 – 0,15
1,5	0,25 – 0,3	0,27 – 0,35	0,18 – 0,24	0,15 – 0,2
2	0,34 – 0,4	0,36 – 0,45	0,24 – 0,3	0,2 – 0,25
2,5	0,45 – 0,5	0,45 – 0,55	0,32 – 0,35	0,25 – 0,3
3	0,5 – 0,6	0,6 – 0,7	0,35 -0,45	0,3 – 0,4
4	0,65 – 0,8	0,7 – 0,95	0,45 – 0,6	0,4 – 0,5
5	0,85 – 1	0,9 – 1,15	0,6 – 0,8	0,55 – 0,65
6	0,95 – 1,2	1,1 – 1,4	0,75 – 0,95	0,7 – 0,85

In case of blanking mild steel and stainless steel clearance is 15% of material thickness.

In case of blanking aluminum and copper clearance is 10% of material thickness.

Dies lock slug

SUCE lock slug dies eliminate slug pulling. This condition manifests where the slug returns to the top of the sheet during the stripping portion of the punching cycle. Because of this the slug comes between the punch and the top of the sheet on the next cycle, causing damage to the piece part and the tooling. How to avoid this problem?

The SUCE NO-SLUG has been designed with a reduction point of the shape below the surface so the slug cannot return once it passes through this point.

System E : 3 cuts with different angles insures the locking of the slug



Once the slug is separated from the punch, it is free to fall through the die. Slug pulling is eliminated. This solution isn't suggested with slug exhaust system machines ; AS lock slug design with protrusions is best solution with thickness more than 3mm, minimum cl for AS system is 0.15mm. SUCE Lock slug E and A system is a standard for all Suce dies, AS is on request , reduced land is a standard for thick turret dies rt80x5 rt80x6 rt110x5 rt110x6.

Lock slug **AS** best option when thickness > 2.5mm



lock slug AS best opt. th>2.5mm	lock slug E thick turret B,C,D,E	lock slug A thick turret A	straight and conic blank die	reduced land slitting die	conic trumpf style
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Tools sharpening

Before starting, make sure that punch and die cutting edge are in perfect condition. Accurate maintenance of the tools guarantees a normal wearing and the result of punching will be without residual burr and defects. Regular sharpening of the 0,1 mm punch and 0,2mm die guarantees a constant life time of tooling.

It is preferable that grinding operation is made with tangential grinding machine with adequate cooling in order to avoid tool tempering; after grinding it is necessary to demagnetize the tools with an appropriate demagnetizer. If a urethane ejectors is applied, restore the initial hole depth in such a way that the ejector can be compressed.

Punching force

Before starting ensure that punching force doesn't exceed the capacity of punching machine.

In order to calculate the punching force in kg , use the following formula:

$$\text{perimeter of the shape (mm)} \times \text{thickness (mm)} \times 4/5 \times \text{shear strength}^*$$

*mild steel 40-50 kg/mm² stainless steel 60-70 kg/mm² aluminium 20-25 kg/mm²

A sharpening other than the flat one reduces both punching stress and punching noise.

Therefore to ascertain the true punching force, multiply the pressure calculated using the above formula by the **sharpening factor**:

Sharpening height (mm)	Thickness (mm)					
	1-1,5	2	3	4	5	6
1	0,75	0,9	1	1	1	1
1,5*	0,5	0,6	0,7	0,95	1	1
3**	0,5	0,5	0,5	0,6	0,7	0,75

* standard shear height thick turret style

** standard shear height Trumpf style

The shear options

Double valley Cod 3P	Roof top Cod V	Inverted roof top Cod VR	Whisper Cod W	Four ways Cod 4P
Best option when shape is long, but susceptible to breakage	Best option when punching force is high, punching surface 75%	Best option for nibbling but inverted stresses could cause breakage	Recommended only for blanking (turret machine)	Recommended for round and square

Punches are flat, above shear are available upon request ;each type of sharpening reduces noise up to 50%



General rules

In order to optimize the use of tooling we would recommend the following basic guidelines:

- a) the punching surface must not be lower than 60% of the used punch surface, isn't recommended to punch the edge of the sheet less than 2.5 times material thickness
- b) in case of nibbling, minimum feed must be 0,5 x thickness , smaller round punch with thickness 1mm is 4mm , smaller round punch with thickness 2mm is 6mm , smaller round punch with thickness 3mm is 8mm.
- c) before exceeding tons capability calculate punching force with formula on page 3.
- d) the tool dimension must not be lower than the material thickness and the shorter side must be at least 5% of the longest side.
- e) the advantage of the technical improvements of some models of dies punching penetration should be at least 2.5mm.
- f) slitting tools must be appropriately sharpened.
- g) the use of the steels commonly called High Speed Steel for our punches allows the punching of any steel. However, in order to considerably increase the punching effectiveness and reduce cold welds, apply some type of coating, such as TICN, HDP, FNC and use oil lubricant on sheet surface.
- h) ensure that tooling cutting edges are without seizing or cold welding material; if any , remove them with a diamond file.
- i) radius on punch corner is 0.25mm, constant radius on the corner of the dies ensures proper wear and a uniform burr.
- l) delivery time trumpf and thick turret tooling: 2/3 days standard, 5/7 coating tools, some items are available in stock.



S H A P E S					
	T	S1	S1R	S2	S2R
	C=	A=	A= R1=	A= B=	A= B= R1=
S3	S4	S5	S6	S7	S8
A=	A=	A= B= R1=	A= C=	A= B=	A= B= C=
					D=
S9	S10	S11	S12	D1	D2
A= B=	A= C=	A= C=	A= B= C=	A= B= C=	A= B= R1=
				R1=	R2= R3= R4=
D3	D4	D5	D6	D7	D8
A= B= R1=	A= B= C=	A= B=	A= R1= R2=	A= R1= R2=	A= B= R1=
B=	D= R1= B=			R3=	R2= R3= R4=
C1	C2	C3	C4	C5	C6
A= B= R=	A= B= R=	A= B= R1=	A= R1= R2=	A= B= R1=	A= B= R1=
		R2= R3= R4=	R3=	R2=	R2= R3=
C7	C8	F6	F7	F8	F9
A= B= C=	A= B= C=	A= B= C=	A= B= C=	A= B= C=	A= B= C=
D= R1= R2=		D= B=	D=		
F10	F11	F12	F13	F15	F16
A= C= R1=	A= B= C=	A= B= C=	A= B= C=	A= B= C=	A= B= C=
				D= R1=	D=

Round : T

Standard shape:

S1 , S1R , S2 , S2R , S3 , S4 , S5 , S6 , S7 , S8 , S9 , S10 , S11 , S12

Special 1:

D1 , D2 , D3 , D4 , D5 , D6 , D7 , D8

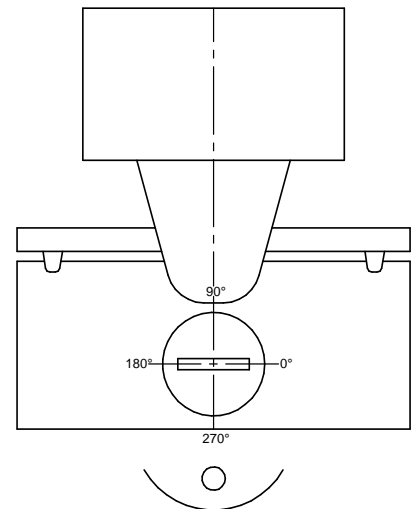
Special 0:

C1 , C2 , C3 , C4 , C5 , C6 R>2.9mm , C7 , C8

Special 2:

C1 , C2 , C3 , C4 , C5 , C6 R<2.9mm , F6 , F7 , F8 , F9 , F10 , F11 , F12 , F13 , F15 , F16

A and B pin die reference Thick turret



Amada diagram



ISODUR

A tough, “long distance runner” with an optimum chemical composition

ESR electro slug remelting : a tried and tested remelting technology developed by Bohler gives the material the homogeneity it needs. A prerequisite for the best performance

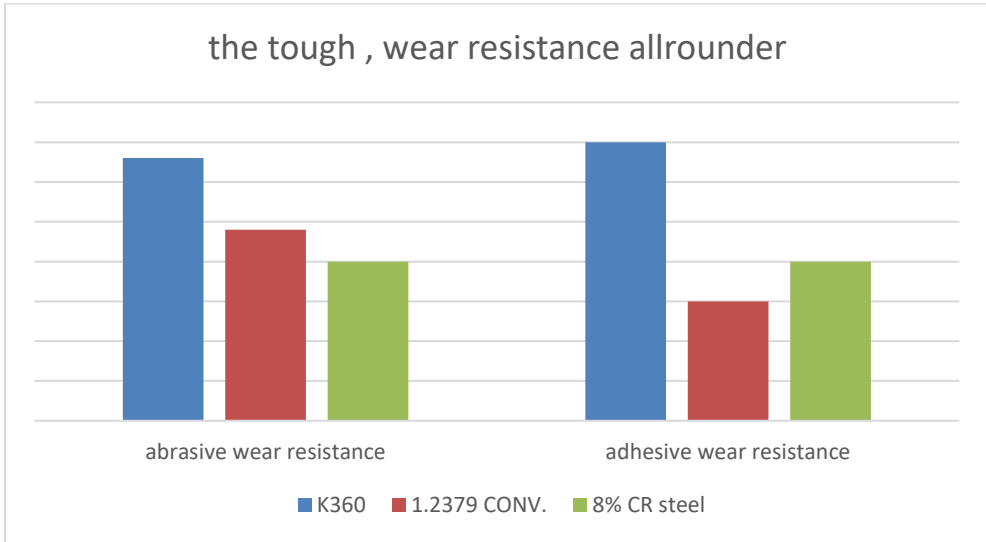
ESR Manufacture improved service life due:

- Least possible inclusion content
- Lower micro and macro segregation
- Good homogeneity and higher degree of purity
- A homogeneous structure throughout the entire cross-section and bar length
- Producing larger bar dimensions at a constant carbide distribution
- Uniform correction of dimensions
- A broad range of application due to a high degree of toughness



K360 Chemical composition:

Carbonium	1,25%
Chromium	8,75%
Molybdenum	2,70%
Vanadium	1,18%



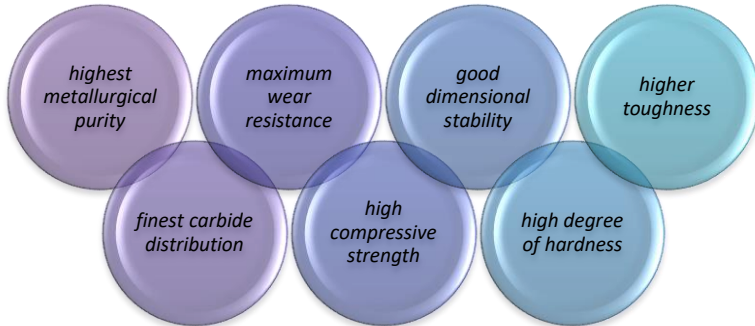
The new K360 isodur is a further development of the 8% chromium steels and has been developed to meet the needs of customers now more than ever. High toughness and, a remarkably high compressive strength , together with good resistance make this steel a real problem solver.

This steel is particularly outstanding when adhesive and abrasive wear resistance are necessary; it allows a considerable increase in performance , your productivity will increase and your costs per part will be reduced



Powder steel metallurgy

Today Suce provides, in addition to the traditional HSS punches, of new variety of tools, Trumpf style and Thick turret style made in powder steel metallurgical.



K490 Chemical composition:

Carbonium	1,40%
Chromium	6,40%
Molybdenum	1,50%
Vanadium	3,70%
Tungsten	3,50%

One of them is **K490**.

Research shows that the **K490 Microclean**, thanks to its chemical composition, is the best steel in the punching market. If you compare it with other powder steels, for example M4 and PM23, you will find that it assures twice the toughness with the same wear resistance.

This new material is characterized by:

- **A high adhesive and abrasive wear resistance**

More hits between regrind operations increases tool life, wear resistance double than traditional HSS M2

- **A high toughness** reduces risk of breaking the punch

In the catalogue **POWDER STEEL punches are marked in RED**, available items:



Trumpf Gr0 D6 D10.5	Trumpf Multitool 5 – 10	Trumpf Gr1	Thick turret Smart staz.A Wilson s90	Thick turret Mate ultra style	Thick turret Mate ultra style Wilson s90 style	Trumpf blade Thick turret Slitting blade
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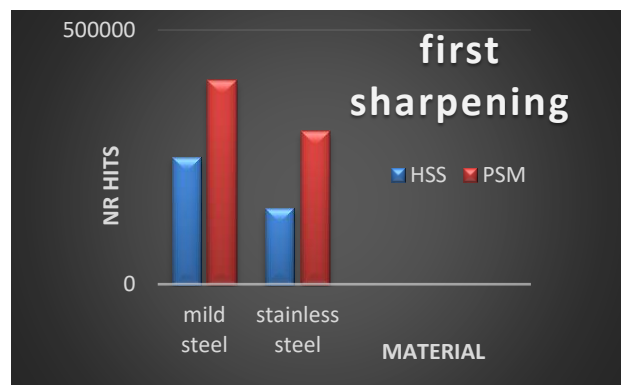
Test result

In order to ensure the best choice of steel for our tools, are carried out periodically punching test with punching machine



200.000 hits
stainless steel
AISI 304
it doesn't need to be sharpened!

Graphic shows nr of hits before first sharpening mild and stainless steel with HSS and PSM tool
Tool tested square 6mm



Coating

HDP ACTION

high density plasma

Among other innovations brought by the HDP technology is a very versatile coating which can be widely used for various applications. HDP was developed to find a universal solution for the most traditional machining processes and to guarantee a constant yield and best performance of the tools.



Available with punches:

Trumpf, Amada, Finn Power, Euromac, Lvd, Rainer, Salvagnini, Tecnology, Wiedemann, Boschert, Tailift, Danobat, Durma, Ermaksan...

Test result



Coating is intact after 125.000 hits nibbling 1mm stainless steel

CHARACTERISTICS:

- Extraordinary toughness** - this is the strong point of this coating and makes it versatile and particularly suitable for various applications
- Adhesion to the surface** - the HDP technology makes it possible to obtain maximum adherence of the coating to the surface and makes the “tool/coating” combination become a whole.
- Microhardness** - the very compact HDP Red layer, with a thickness of only 3 microns, gives a hardness which represents a solid barrier against wear and guarantees a unique performance.
- Low friction coefficient** - this is another important characteristic, which becomes evident thanks to the glossy layer. The low friction coefficient has been made possible thanks to the HDP technology which makes the application of coatings almost “dropletfree” (residual macro-particles on the surface). If they are not removed, these droplets affect the surface roughness.

Structure	MicroHardness (HV 0.05)	Friction coefficient (100 cr6)	Thickness (micron)	Deposition temperature (°C)	Max temperature (max°C)	Colour
Multilayer	3.800	0.25	1-3	480	400	RED



Coating

Double coating FNC

The double coating is obtained by overlaying the traditional TiCN with Movic self-lubricating coating.



MOVIC is a self-lubricating and anti-adhesive coating based on MoS₂ (Molybdenum), which is produced by PVD sputtering Magnetron technology.

MOVIC has been developed in the aerospace to find alternatives to traditional oils (eg oil, grease) when their use is not permitted and it has shown excellent tribological features that made it very interesting for a variety of new applications.

Available with punches:

Trumpf, Amada, Finn Power, Euromac, Lvd, Rainer, Salvagnini, Tecnology, Wiedemann, Boschert, Tailift, Danobat, Durma, Ermaksan...

SPECIFICATIONS:

- Self-lubricating single-phase coating based on MoS₂.
- "Soft" coating with very low coefficient of friction (friction coefficient in dry air <0.05).
- Single-layer coating that can be combined with any hard coating.
- Functional Thickness of Coating <0.5 microns.
- Deposition temperature <150 ° C.
- Soft wear residues, lubricants (behavior Fail-safe: no abrasive particles from wear of the coating).
- Excellent running for rough surfaces. (Coating becomes smoother during the running in.)
- Positive transfer of lubricant film on the side in contact.
- can be easily re-covered without removal. If necessary the removal is easily achievable.

Structure	Micro-Hardness (HV 0.05)	Friction Coefficient (100 cr6)	Thickness (micron)	Deposition temperature (°C)	Max temperature (max°C)	Colour
Single layer	–	<0.1	1	<150	-	GREY



MULTITOOL Index



- P11 - multitool style Mate 20-8 & 24-8 , 10-16 , 6_8-24 , die shims
- P12 - multitool style Mate XMTE6 , XMTE12.7 , XMTE4 for EUROMAC
- P13 - PRIMAPOWER MT20Ri , MT8Ri , MT3Ri , PASS style MT8Ri3-16
- P14 - PRIMAPOWER MT8Ri3-16 , ERMAKSAN multitool 6-22mm , DURMA multitool 6-24



MULTITOOL Mate style 20-8 & 24-8mm

Data:
Max size 8,00mm

Regrinding life: Punch 1mm , Die 0,5mm
Regrinding life*: Punch 2mm , Die 1,5mm

*with Euromac MTE10



	item	PUNCH HSS	€	PUNCH PSM	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMAOPSM2006T		AMAOPSM2002T		AMAOPLM20T		AMA0MAM2001T	
STANDARD				AMAOPSM2002S		AMAOPLM20S		AMA0MAM2001S	
SPECIAL 0				AMAOPSM2002C		AMAOPLM20D		AMA0MAM2001D	
SPECIAL 1				AMAOPSM2002D		AMAOPLM20D		AMA0MAM2001D	
SPECIAL 2				AMAOPSM2002F		AMAOPLM20D		AMA0MAM2001D	

Coating	HDP	FNC
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MULTITOOL Mate style 10-16mm

Data:
Max size 16,00mm

Regrinding life: Punch 1mm , Die 0,5mm



	item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMAOPUM1606T		AMAOPLM16T		AMA0MAM1601T	
STANDARD		AMAOPUM1606S		AMAOPLM16S		AMA0MAM1601S	
SPECIAL 0		AMAOPUM1606C		AMAOPLM16D		AMA0MAM1601D	
SPECIAL 1		AMAOPUM1606D		AMAOPLM16D		AMA0MAM1601D	
SPECIAL 2		AMAOPUM1606F		AMAOPLM16D		AMA0MAM1601D	

Coating	HDP	FNC
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MULTITOOL Mate style 6-8-24mm

Data:
Max size 24,00mm

Regrinding life: Punch 1mm , Die 0,5mm
Regrinding life*: Punch 2mm , Die 1,5mm
*with Euromac MTE10



	item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMAOPUM2406T		AMAOPLM24T		AMA0MAM2401T	
STANDARD		AMAOPUM2406S		AMAOPLM24S		AMA0MAM2401S 0°-90°135°	
SPECIAL 0		AMAOPUM2406C		AMAOPLM24D		AMA0MAM2401D 0°-90°135°	
SPECIAL 1		AMAOPUM2406D		AMAOPLM24D		AMA0MAM2401D 0°-90°135°	
SPECIAL 2		AMAOPUM2406F		AMAOPLM24D		AMA0MAM2401D 0°-90°135°	

Coating	HDP	FNC
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DIE SHIMS

	item	Set n.24 pz Mt 24-8mm	€	Set n.10 pz Mt 10-16mm	€	Set n.6 pz Mt 6/8-24mm	€
0,1mm		AMA0MAM20SP10		AMA0MAM16SP10		AMA0MAM24SP01	
0,2mm		AMA0MAM20SP20		AMA0MAM16SP20		AMA0MAM24SP02	
0,5mm		AMA0MAM20SP60		AMA0MAM16SP60		AMA0MAM24SP05	



EUROMAC MULTITOOL XMTE6

Mate style XMTE6 24mm
 Data:
 Regrinding life:
 Punch 2.6mm , *Adjustable 9mm
 Die 1,5mm
 Max size 24,00mm,
 Max size die is 24.4mm



item	PUNCH ISODUR	€	PUNCH ADJUSTABLE ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMA0PUM24C6T		AMA0PUM24D6T		AMA0PLM24CT		AMA0MAM2401T	
STANDARD	AMA0PUM24C6S		AMA0PUM24D6S		AMA0PLM24CS		AMA0MAM24B1S	
SPECIAL 0	AMA0PUM24C6C		AMA0PUM24D6C		AMA0PLM24CD		AMA0MAM24B1D	
SPECIAL 1	AMA0PUM24C6D		AMA0PUM24D6D		AMA0PLM24CD		AMA0MAM24B1D	
SPECIAL 2	AMA0PUM24C6F		AMA0PUM24D6F		AMA0PLM24CD		AMA0MAM24B1D	



PUNCH CHUCK	€	PUNCH HEAD	€
AMA0PP24		AMA0TEM24	
PUNCH MAX DIM 10,4	€		
AMB105PST006T			

Coating	PUNCH INSERT HDP	PUNCH INSERT FNC	HDP	FNC
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EUROMAC MULTITOOL XMTE12.7

Mate style XMTE12.7 mm
 Data:
 Regrinding life:
 Punch 2.6mm
 Punch adjustable* 9mm
 Die 1,5mm
 Max size 12,70mm
 Max size die is 13.2mm
 *only keyed station

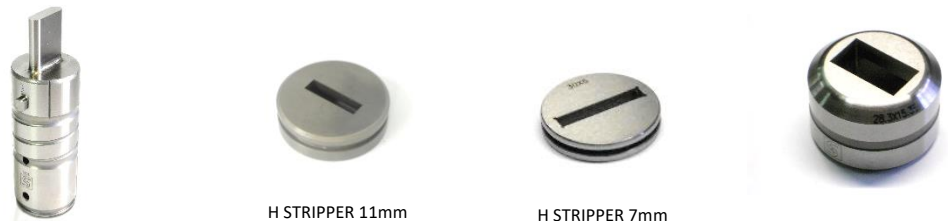


item	PUNCH ISODUR	€	PUNCH ISODUR ADJUSTABLE	€	PUNCH HEAD	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMA0PUM1006T		AMA0PUM10B6T		AMA0TEM10		AMA0PLM10T		AMA0MAM1001T	
STANDARD	AMA0PUM1006S		AMA0PUM10B6S		AMA0TEM10		AMA0PLM10S		AMA0MAM1001S	
SPECIAL 0	AMA0PUM1006C		AMA0PUM10B6C		AMA0TEM10		AMA0PLM10D		AMA0MAM1001D	
SPECIAL 1	AMA0PUM1006D		AMA0PUM10B6D		AMA0TEM10		AMA0PLM10D		AMA0MAM1001D	
SPECIAL 2	AMA0PUM1006F		AMA0PUM10B6F		AMA0TEM10		AMA0PLM10D		AMA0MAM1001D	

Coating	HDP	FNC
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EUROMAC MULTITOOL XMTE4

Mate style XMTE4 4B 31.7mm
 Data:
 Regrinding life:
 Punch 8mm , Die 2,5mm
 Max size 31,70mm
 Max tonnage: 22tons



item	PUNCH SMART ISODUR	€	STRIPPER XMTE4	€	STRIPPER STD B	€	B DIE ISODUR	€
ROUND	AMB1IPLNL6T		AMB1PLMT4T		AMB1PLWTT		AMB1MAT006T	
STANDARD	AMB1IPLNL6S		AMB1PLMT4S		AMB1PLWTS		AMB1MAT006S	
SPECIAL 0	AMB1IPLNL6D		AMB1PLMT4D		AMB1PLWTD		AMB1MAT006D	
SPECIAL 1	AMB1IPLNL6C		AMB1PLMT4D		AMB1PLWTD		AMB1MAT006D	
SPECIAL 2	AMB1IPLNL6F		AMB1PLMT4D		AMB1PLWTD		AMB1MAT006D	



PRIMA POWER MULTITOOL

Wilson style MT20Ri , MT20i 8mm

Data:
Max size 8mm



item	PUNCH HSS	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMAOPUM2006T		AMAOPLM20T		AMA0MAM2001T	
STANDARD	AMAOPUM2006S		AMAOPLM20S		AMA0MAM2001S	
SPECIAL 0	AMAOPUM2006C		AMAOPLM20D		AMA0MAM2001D	
SPECIAL 1	AMAOPUM2006D		AMAOPLM20D		AMA0MAM2001D	
SPECIAL 2	AMAOPUM2006F		AMAOPLM20D		AMA0MAM2001D	

Coating **HDP** **FNC**

PRIMAPOWER MULTITOOL

Wilson style MT8Ri , MT8i 16mm

Data:
Max size 16mm



item	PUNCH HSS	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMAOPUM806T		AMAOPLM8T		AMA0MAM801T	
STANDARD	AMAOPUM806S		AMAOPLM8S		AMA0MAM801S	
SPECIAL 0	AMAOPUM806C		AMAOPLM8D		AMA0MAM801D	
SPECIAL 1	AMAOPUM806D		AMAOPLM8D		AMA0MAM801D	
SPECIAL 2	AMAOPUM806F		AMAOPLM8D		AMA0MAM801D	

Coating **HDP** **FNC**

PRIMAPOWER MULTITOOL

Wilson style MT3Ri 31.7mm

Data:
Max size 31.7mm



item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMB1PWT06T		AMAOPLMT3T		AMB1MAMT306T	
STANDARD	AMB1PWT06S		AMAOPLMT3S		AMB1MAMT306S	
SPECIAL 0	AMB1PWT06C		AMAOPLMT3D		AMB1MAMT306D	
SPECIAL 1	AMB1PWT06D		AMAOPLMT3D		AMB1MAMT306D	
SPECIAL 2	AMB1PWT06F		AMAOPLMT3D		AMB1MAMT306D	

Coating **HDP** **FNC**



PRIMAPOWER MULTITOOL MT8Ri3-16

Data:
Max size 16,00mm
Max thickness 4ms , 3ss



	item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMMTPU8RI06T		AMMTPLM8T		AMA0MAM1601T	
STANDARD		AMMTPU8RI06S		AMMTPLMTS		AMA0MAM1601S	
SPECIAL 0		AMMTPU8RI06C		AMMTPLMTD		AMA0MAM1601D	
SPECIAL 1		AMMTPU8RI06D		AMMTPLMTD		AMA0MAM1601D	
SPECIAL 2		AMMTPU8RI06F		AMMTPLMTD		AMA0MAM1601D	

Coating HDP FNC

ERMAKSAN MT6 - 22

Max 22mm
Max thickness:
3mm
Max punching
force 9Kn ,
Grinding life mm:
Punch 6, Die 0,5



	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	GUIDE	€	PUNCH DRIVER	€	DIE ISODUR	€
ROUND	AMMTPU2206T		AMMTPA2206T		AMMTGU22T		AMMT6-22LL		AMA0MAM2401T	
STANDARD	AMMTPU2206S		AMMTPA2206S		AMMTGU22S		AMMT6-22LL		AMA0MAM24B1S	
SPECIAL 0	AMMTPU2206C		AMMTPA2206C		AMMTGU22D		AMMT6-22LL		AMA0MAM24B1D	
SPECIAL 1	AMMTPU2206D		AMMTPA2206D		AMMTGU22D		AMMT6-22LL		AMA0MAM24B1D	
SPECIAL 2	AMMTPU2206F		AMMTPA2206F		AMMTGU22D		AMMT6-22LL		AMA0MAM24B1D	
Coating HDP	ROUND		SHAPE							
Coating FNC	ROUND		SHAPE							

DURMA MULTITOOL

Data:
Max size 24,00mm, max size die is 24.4mm



	item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMA0PUM24B6T		AMA0PLM24BT		AMA0MAM2401T	
STANDARD		AMA0PUM24B6S		AMA0PLM24BS		AMA0MAM24B1S	
SPECIAL 0		AMA0PUM24B6C		AMA0PLM24BD		AMA0MAM24B1D	
SPECIAL 1		AMA0PUM24B6D		AMA0PLM24BD		AMA0MAM24B1D	
SPECIAL 2		AMA0PUM24B6F		AMA0PLM24BD		AMA0MAM24B1D	

Coating HDP FNC



Sales condition

Availability of products in the catalogue is subject to change. Our sales department will check the availability of products before confirming your order.

Delivery :

The order confirmation provides an estimate of the date on which the order will be dispatched from the Suce warehouse. In the case of orders requiring an advanced payment we will provide an estimated delivery date as soon as we receive confirmation of payment.

Minimum invoice value : €100

Payment :

Payment terms are detailed in the order confirmation. Our finance department may charge interest on payment received more than 10 working days after the payment dead line.

Freight : according to Incoterms rules and are detailed in order confirmation

Cancellation , returns and complains :

Any claims will be considered if made within 2 weeks of receiving the goods. The return of materials must be authorized and managed by Suce. A return charge of 20% of the product's value will be applied to cover the costs of return.

Cancellations can be made free of charge up to 24h after order confirmation. Cancellations made after 24h could be subject to a charge.

Credit :

Customers with a credit account should be aware of their credit limit. Our finance department will provide instructions in the event that your order exceeds your credit limit.



notes

A large rectangular area with horizontal lines, intended for taking notes.





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