

OTTIMO tools



- ☑ СТАНДАРТНЫЙ ГИБОЧНЫЙ ИНСТРУМЕНТ
- ☑ НЕСТАНДАРТНЫЙ ГИБОЧНЫЙ ИНСТРУМЕНТ
- ☑ СВЕРХТЯЖЕЛЫЙ ГИБОЧНЫЙ ИНСТРУМЕНТ
- ☑ НОЖИ ДЛЯ ГИЛЬОТИННЫХ НОЖНИЦ

PRESS BRAKE TOOLING
ГИБОЧНЫЙ ИНСТРУМЕНТ



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Компания «Limit SRL» основанная в 1977 году, находится в Италии (регион Эмилия-Романья) , специализируется в сфере производства инструмента для листогибочных прессов, как стандартного, так и специального.

Большой опыт, накопленный за 40 лет работы позволил компании успешно выйти на международный рынок. Кроме того, благодаря высокому качеству «Limit SRL» получил признание среди наиболее крупных европейских производителей металлообрабатывающего оборудования и самых взыскательных конечных пользователей. Производственный цикл предприятия построен таким образом, чтобы гарантировать максимальную надежность инструмента (за счет применения точных методов проектирования и качественных материалов), его высокую точность и абсолютную взаимозаменяемость (за счет применения современных методов закалки и высокоточной механической обработки). При этом организация производства позволяет сохранять гибкость и индивидуальный подход к каждому клиенту (специнструмент, модификации стандартного инструмента и разработка технологии «с нуля»).



Компания «Tecnolame SRL» основанная в 1980 году, находится на севере Италии, недалеко от Милана, осуществляет свою деятельность исключительно в области ножей для гильотинных ножниц, а также

крупногабаритного, уникального и специального инструмента. За годы работы компания освоила множество инновационных технологических приемов и «ноу-хау», которые позволяют выгодно выделяться на фоне конкурентов. «Tecnolame» — это современная компания, которая с каждым годом осваивает новейшие технологии, позволяющие удовлетворить самые специфические потребности клиента и обеспечить его уникальным и экономически целесообразным инструментом быстро и надежно. Таким образом, это позволяет компании оставаться постоянным партнером ведущих производителей станков по обработке листового металла уже на протяжении долгих лет.

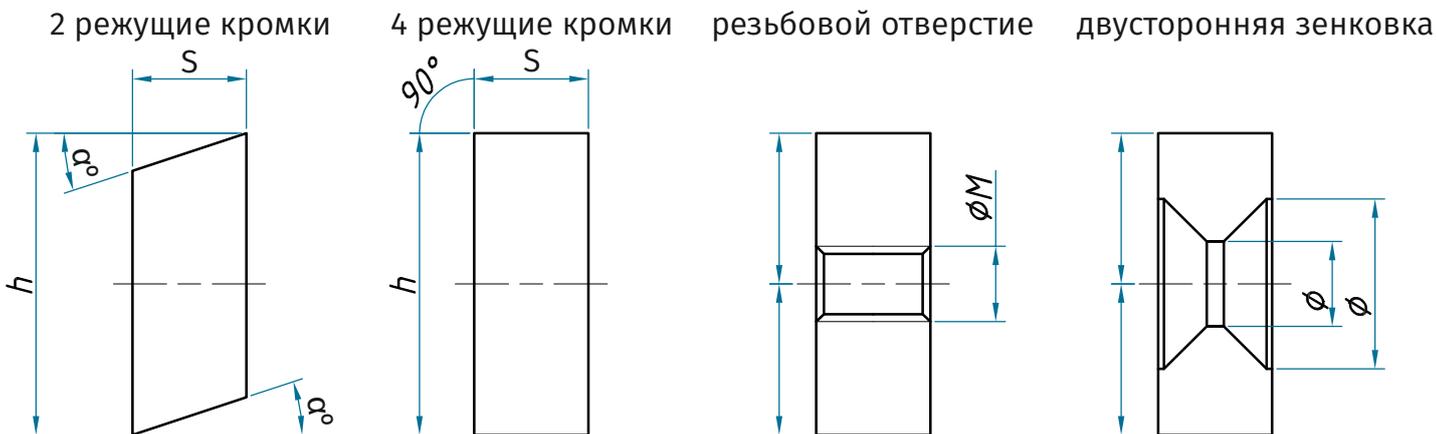
Наша компания поставляет ножи для гильотинных ножниц различного назначения и исполнения. Все ножи (лезвия) изготовлены из высококачественных инструментальных сталей. Качественные материалы, точная обработка и современные методы заправки гарантируют прочность, надежность и износостойкость ножей.

Благодаря богатому опыту и постоянному сотрудничеству с заводами-изготовителями оборудования и инструмента, наша компания, в большинстве случаев, имеет возможность подобрать требуемый нож, исходя из модели станка и года его изготовления.

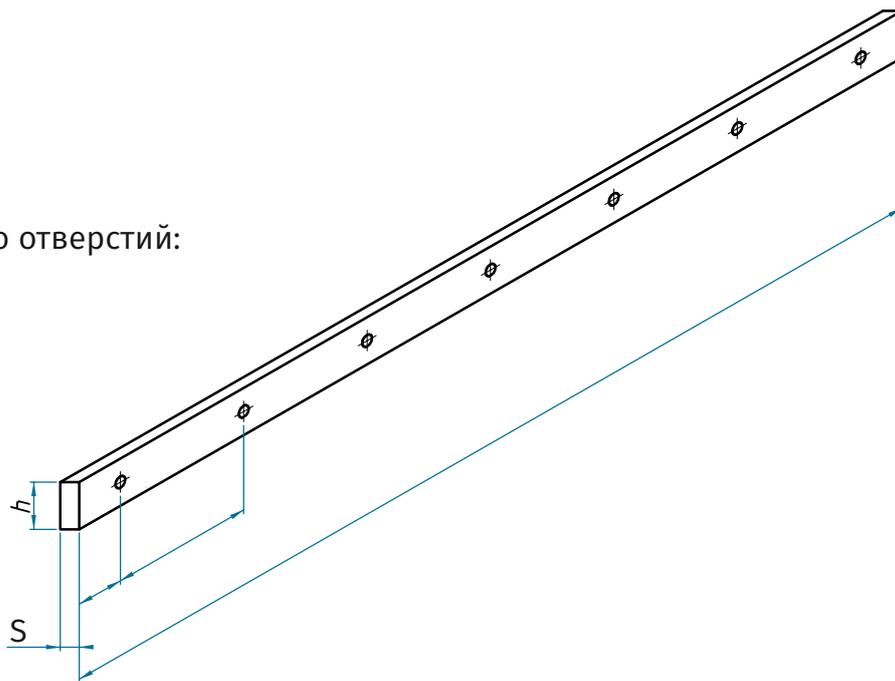
В любом случае, при запросе желательно указать следующие данные:

- ❖ Производитель, модель и год изготовления гильотинных ножниц:
- ❖ Характеристики разрезаемого материала:
 - тип материала _____ толщина мин. _____ толщина макс. _____
 - тип материала _____ толщина мин. _____ толщина макс. _____
 - тип материала _____ толщина мин. _____ толщина макс. _____
- ❖ Размер ножей:
- ❖ Количество отверстий:
- ❖ Тип отверстий: с резьбой; с зенковкой

СЕЧЕНИЕ НОЖА:



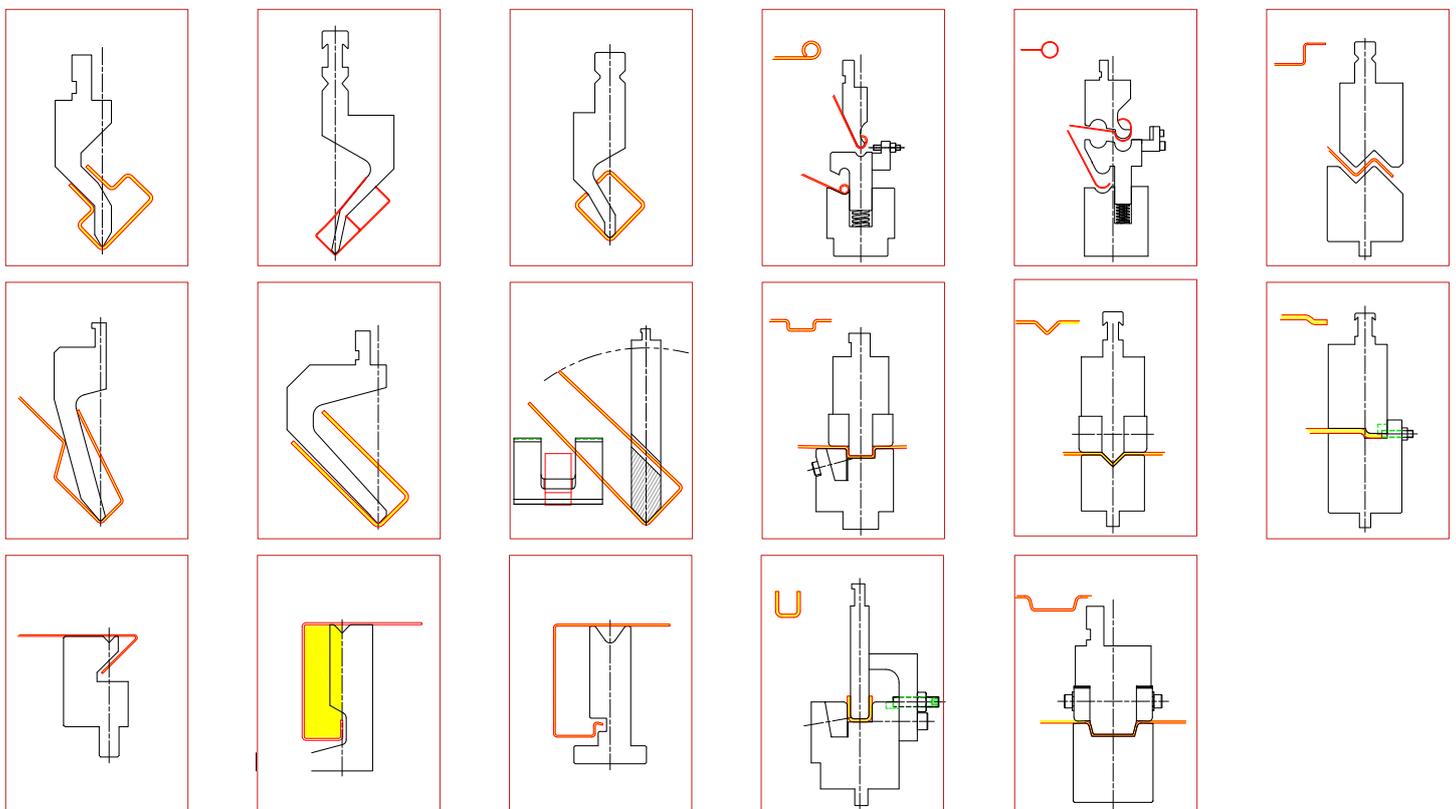
Количество отверстий:



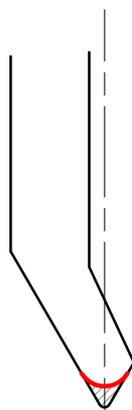
Наша компания «ОТТИМО-TOOLS» поставляет различный инструмент, в том числе нестандартный гибочный инструмент. Оставьте заявку на сайте или свяжитесь с менеджерами по телефону для получения полной информации.

Мы готовы предложить:

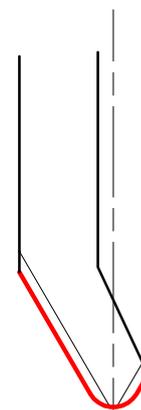
- ❖ Проектирование сложного, специального и модифицированного инструмента
- ❖ Проектирование по чертежу детали или разработка технологии «с нуля»
- ❖ Длина одной цельной секции до 13 м, максимальное удельное усилие до 500 т/м
- ❖ Применение специальных сталей и сплавов
- ❖ Составной и многопозиционный инструмент
- ❖ Наличие специальной оснастки (матрицы с изменяемой шириной ручья, адаптеры и т.д.)



Возможны различные варианты модификации стандартного инструмента. Один из вариантов модификации радиуса кончика пуансона представлен ниже:



Модификация стандартного инструмента



Модификация со специальным исполнением

Наша компания «ОТТИМО-TOOLS» поставляет различный инструмент, в том числе уникальный сверхтяжелый листогибочный инструмент. Оставьте заявку на сайте или свяжитесь с менеджерами по телефону для получения полной информации.

Мы готовы предложить:

- ❖ Проектирование по чертежу детали или разработка технологии «с нуля»
- ❖ Длина одной цельной секции до 13 м, максимальное удельное усилие до 500 т/м
- ❖ Применение специальных сталей и сплавов



10.10/90°

R	H	H1
0.2	67	97
0.8	66.7	96.7

100 T/m

10.116/90°

15 T/m

10.201

30 T/m

10.203

30 T/m

10.14/90°

R	H	H1
0.2	90	120
0.8	89.7	119.7

70 T/m

10.146/90°

R	H	H1
0.2	90	120
0.8	89.7	119.7

50 T/m

10.15/90°

R	H	H1
0.2	105	135
0.8	104.7	134.7

50 T/m

10.048

R	H	H1
0.2	120	150
0.8	119.7	149.7

50 T/m

10.16/90°

15 T/m

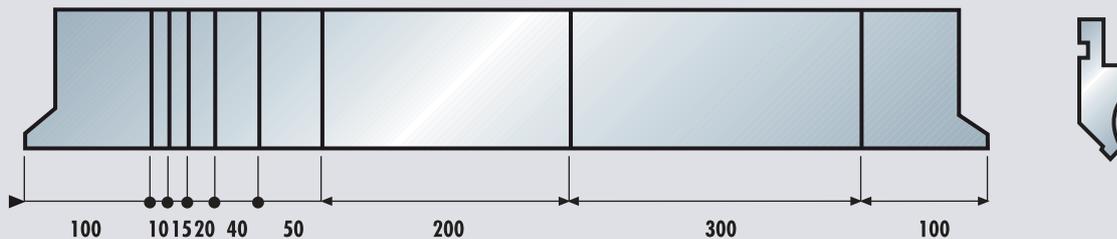
10.108

50 T/m

ATTACCO - ATTACHMENT - AUFNAHME

MOD. U MOD. B MOD. T MOD. EURO

FRAZIONATURA STANDARD 835 mm. / STANDARD SECTIONING 835 mm. / СТАНДАРТНО РАЗРЕЗАННАЯ СЕКЦИЯ ОБЩЕЙ ДЛИНОЙ 835 мм



In s. utensili sono costruiti in acciaio di qualità in due versioni:
- bonificati a 42÷48 HRC
- temprati ad induzione a 52÷60 HRC
Sono disponibili in lunghezze di: 415 mm, 835 mm e frazionati.

Our tools are made in quality steel and can be offered in two versions:
- hardened and tempered at 42 ÷ 48 HRC
- induction hardened at 52 ÷ 60 HRC
The tools are available in lengths of 415 mm, 835 mm and segmented.

Инструмент изготовлен из высококачественной стали и может быть изготовлен в двух вариантах:
- термическая объемная закалка до 42÷48 HRC
- индукционная закалка до 52÷60 HRC
Инструмент поставляется в виде секций длиной 835 мм и 415 мм, а также в виде стандартно разрезанной секции общей длиной 835 мм.

10.10/88°	10.116/88°	10.200	10.202																														
100 T/m	15 T/m	30 T/m	30 T/m																														
<table border="1" style="font-size: small;"> <thead> <tr><th>R</th><th>H</th><th>H1</th></tr> </thead> <tbody> <tr><td>0.2</td><td>67</td><td>97</td></tr> <tr><td>0.8</td><td>66.7</td><td>96.7</td></tr> <tr><td>3</td><td>65.7</td><td>95.7</td></tr> </tbody> </table>	R	H	H1	0.2	67	97	0.8	66.7	96.7	3	65.7	95.7	<p>R = 0,2</p>	<table border="1" style="font-size: small;"> <thead> <tr><th>R</th><th>H</th><th>H1</th></tr> </thead> <tbody> <tr><td>0.2</td><td>70</td><td>100</td></tr> <tr><td>0.8</td><td>69.7</td><td>99.7</td></tr> </tbody> </table>	R	H	H1	0.2	70	100	0.8	69.7	99.7	<table border="1" style="font-size: small;"> <thead> <tr><th>R</th><th>H</th><th>H1</th></tr> </thead> <tbody> <tr><td>0.2</td><td>100</td><td>130</td></tr> <tr><td>0.8</td><td>99.7</td><td>129.7</td></tr> </tbody> </table>	R	H	H1	0.2	100	130	0.8	99.7	129.7
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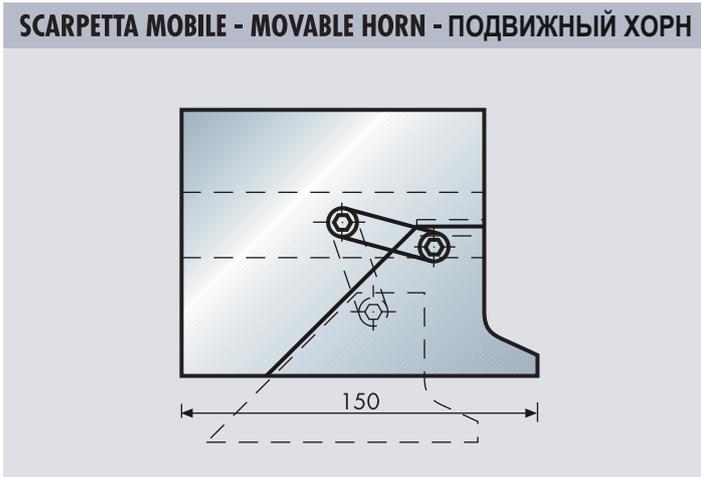
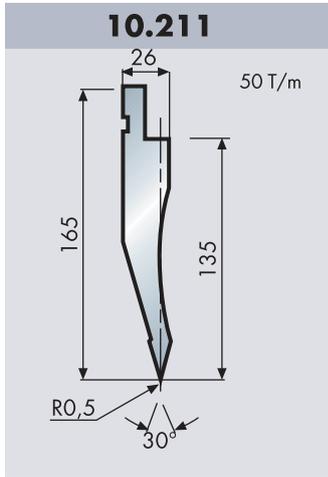
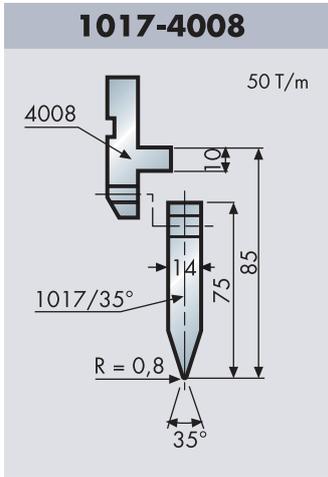
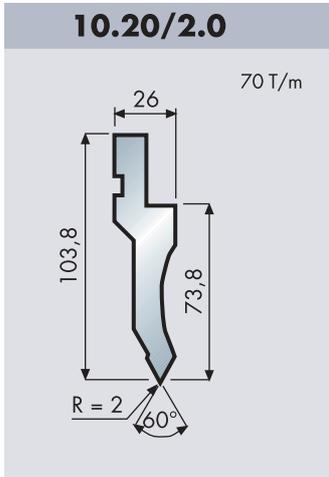
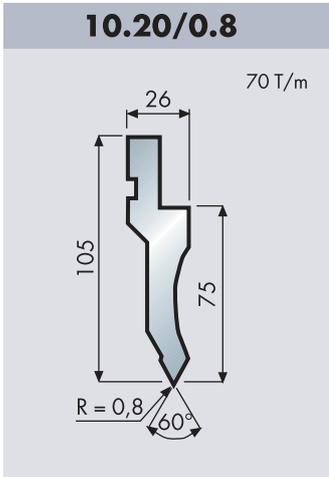
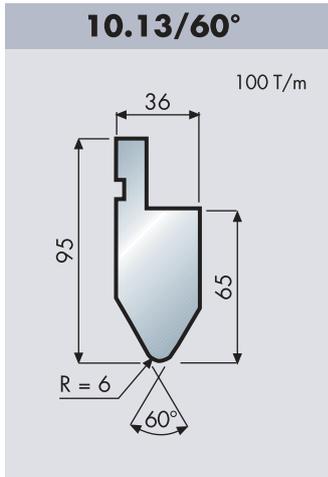
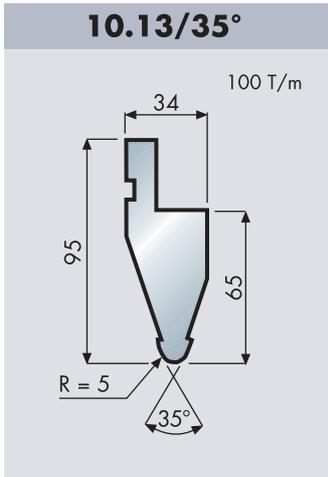
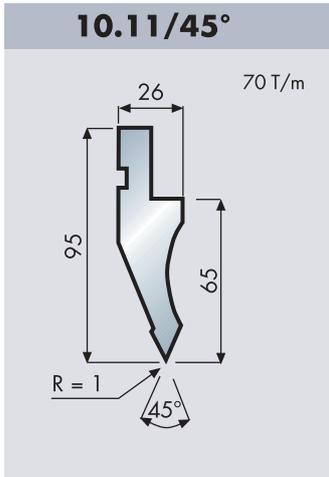
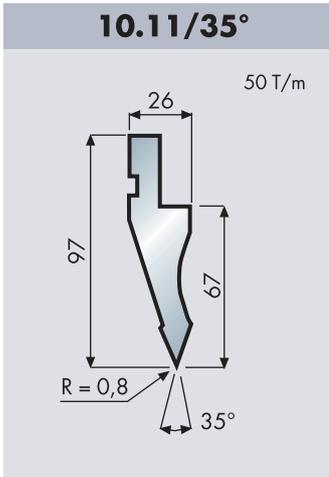
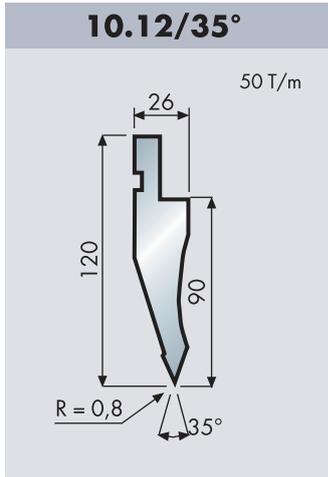
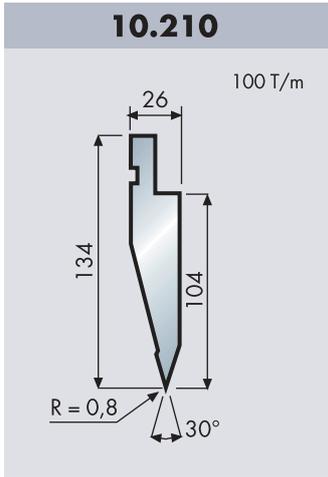
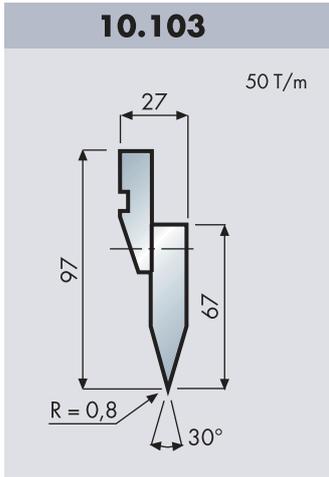
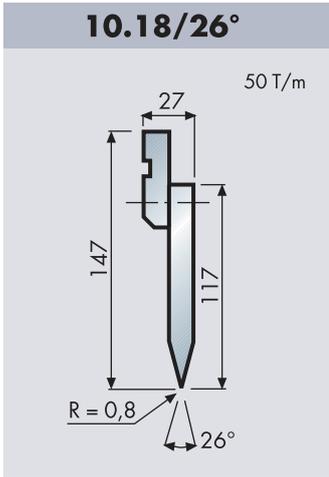
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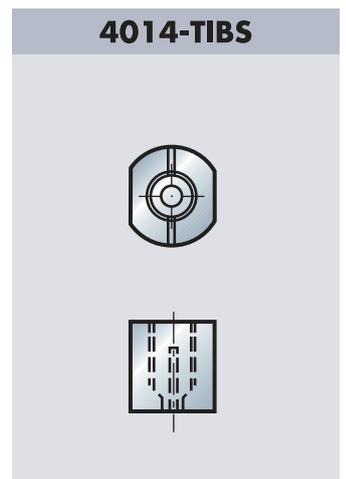
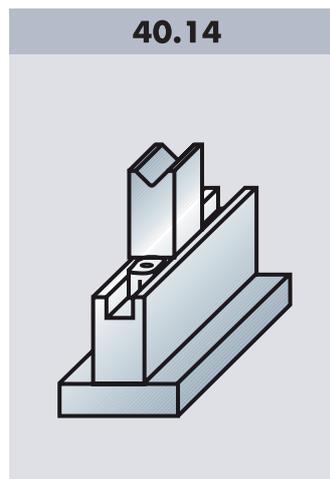
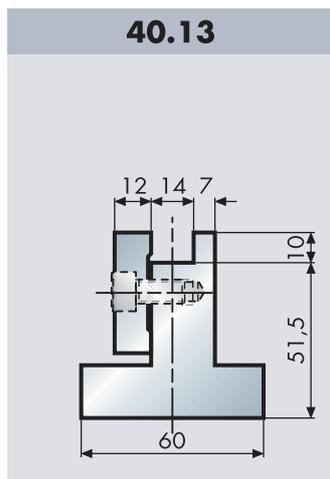
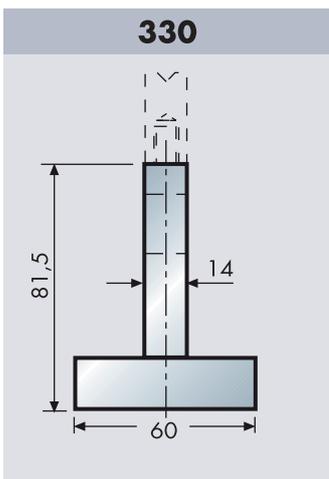
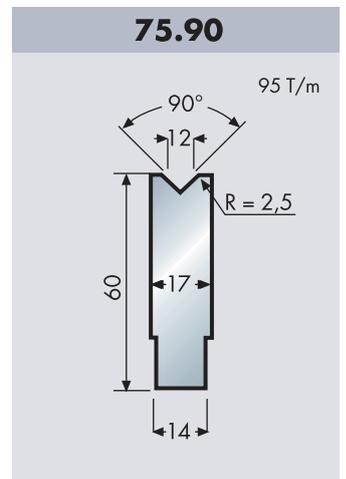
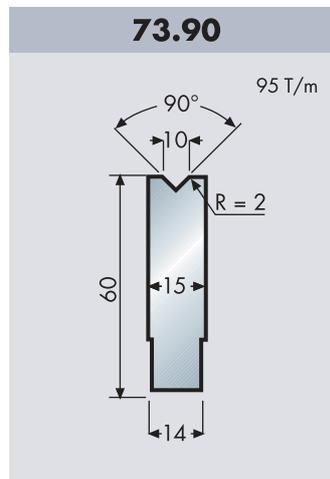
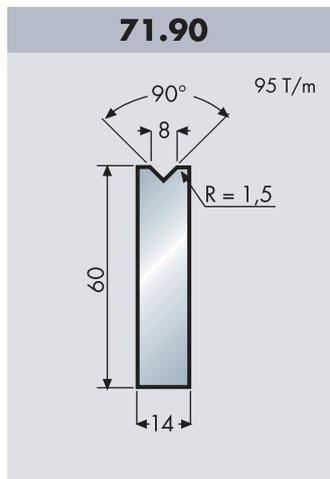
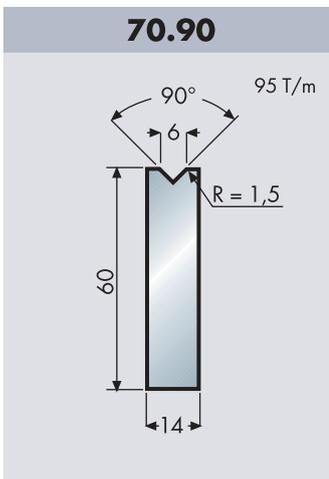
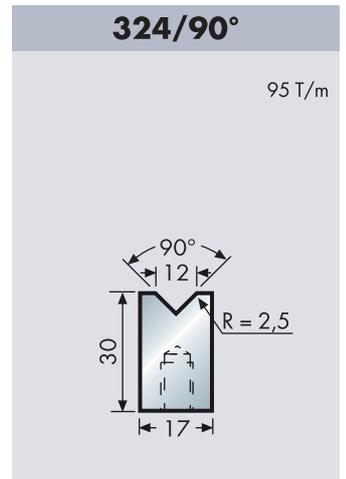
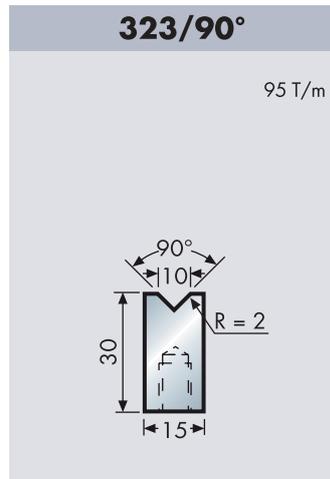
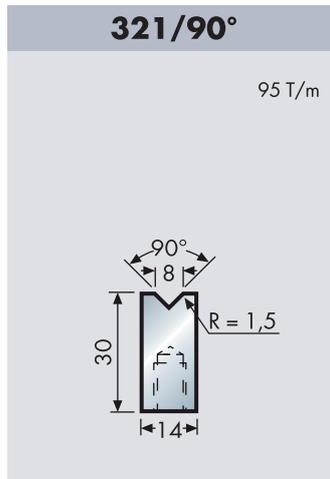
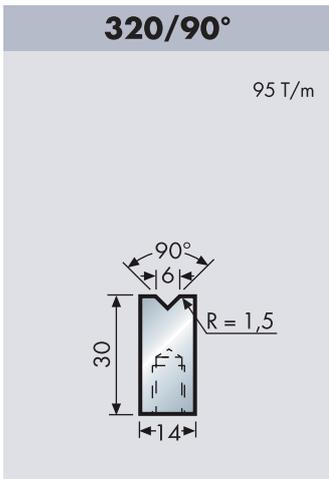
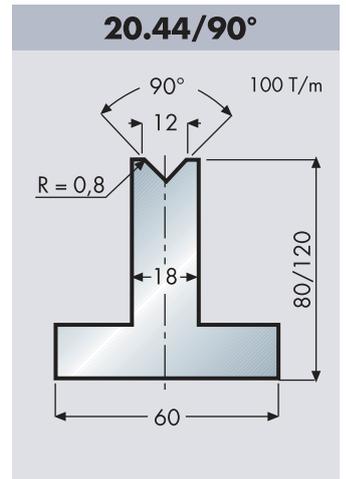
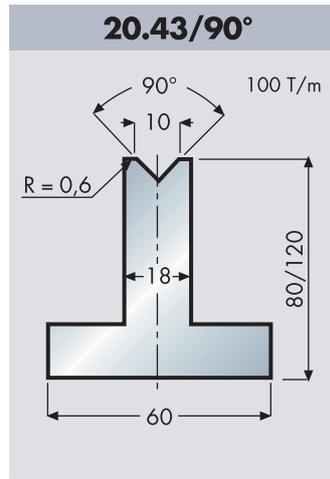
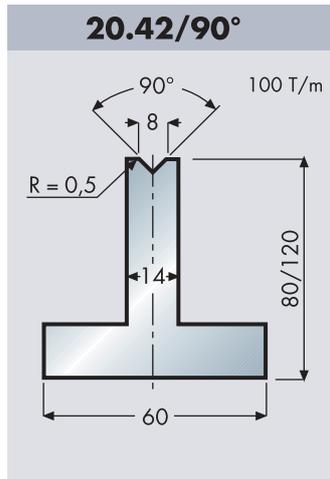
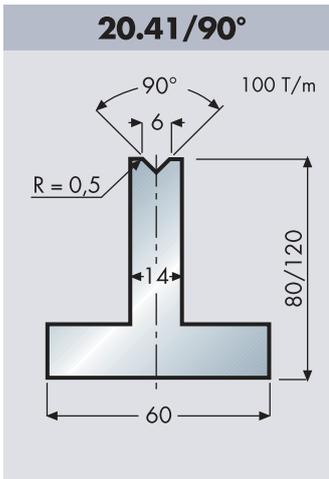
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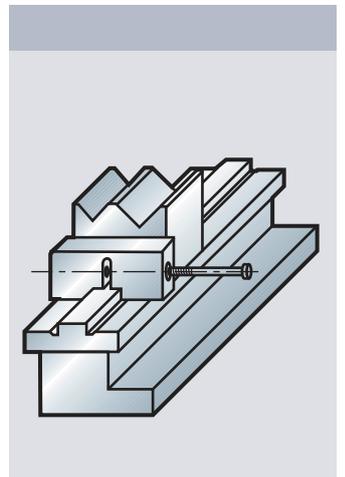
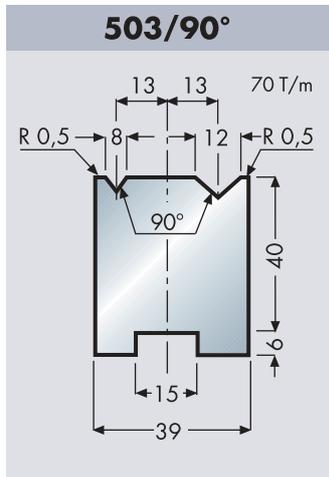
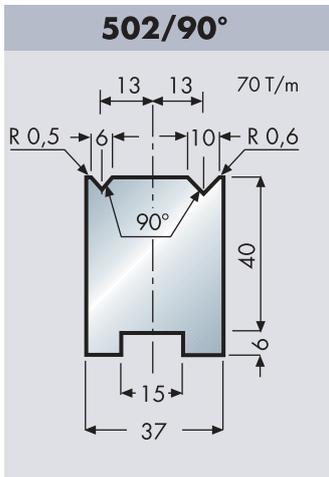
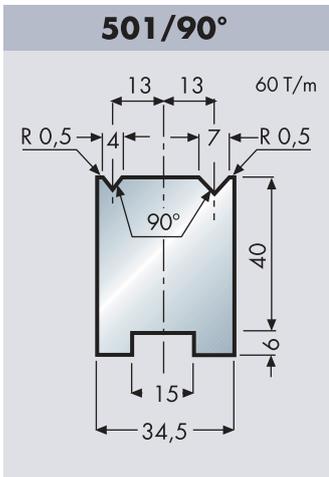
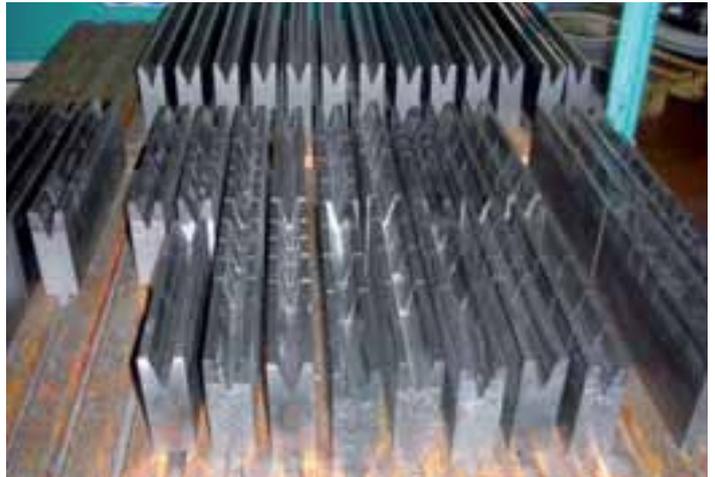
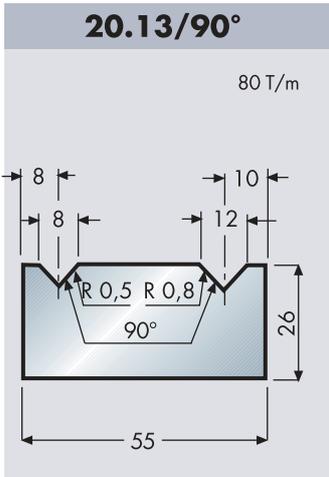
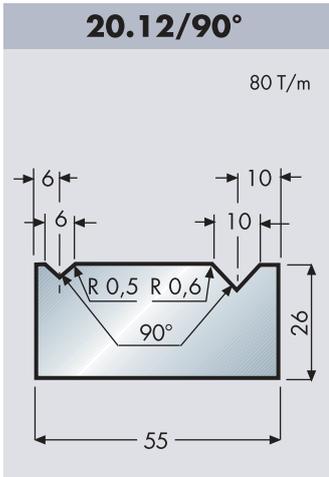
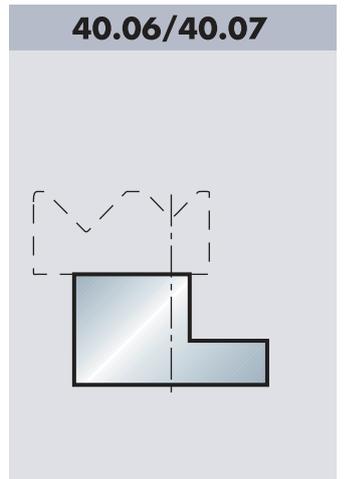
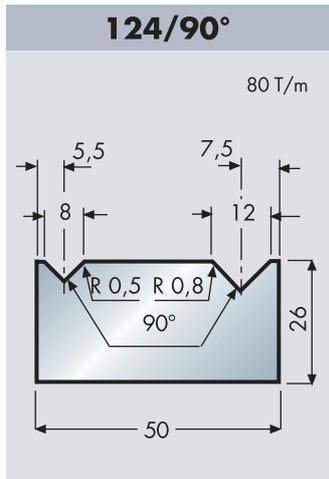
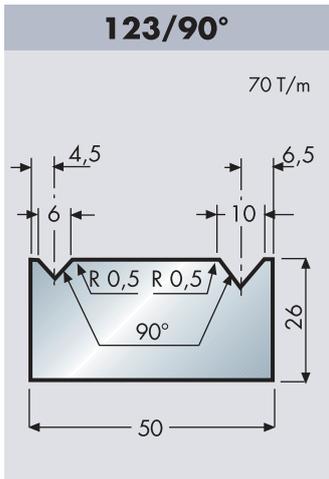
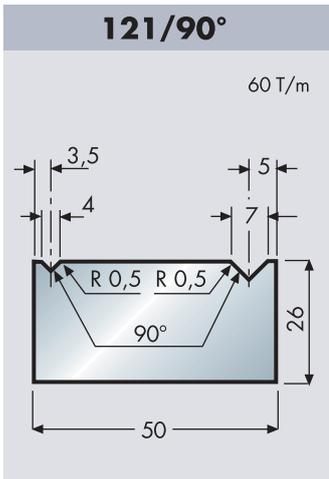
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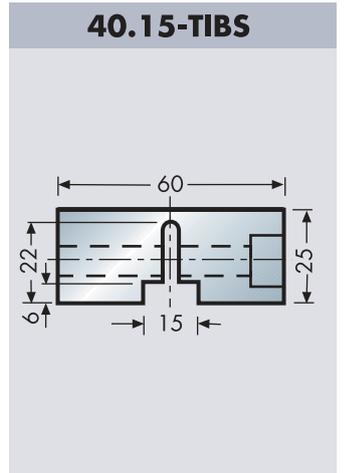
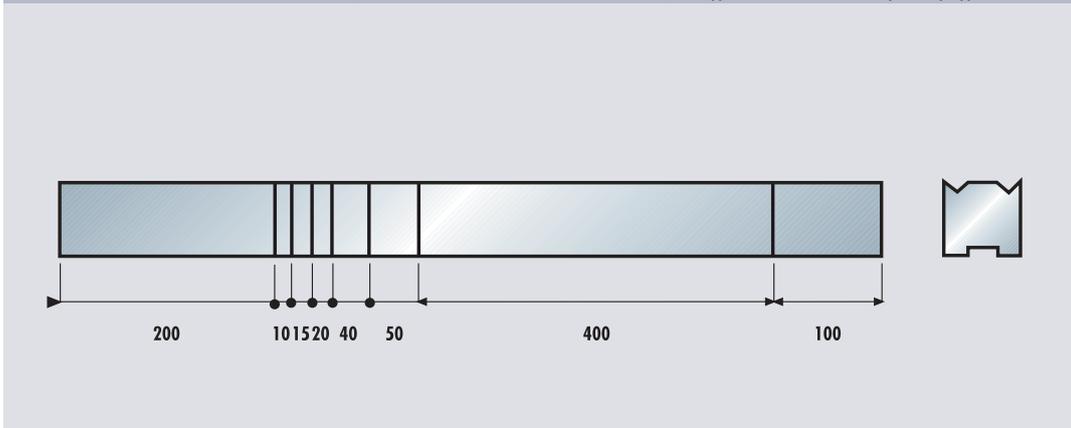


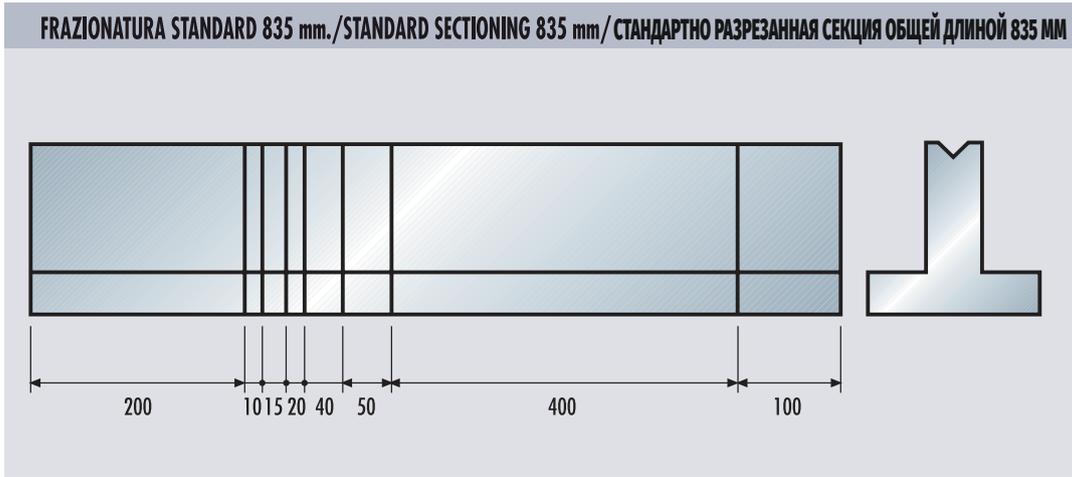
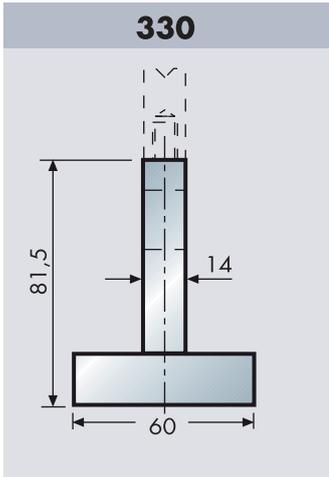
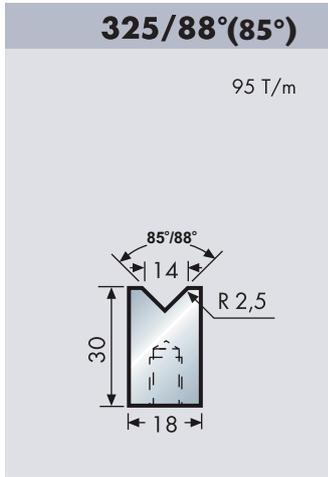
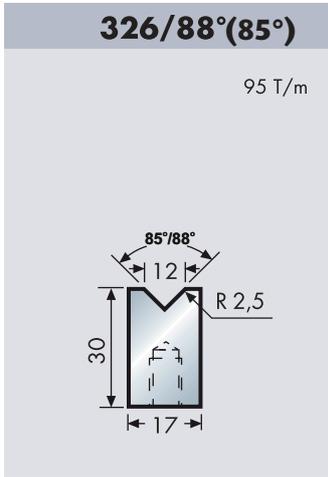
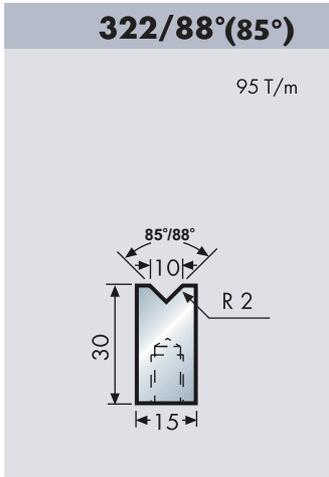
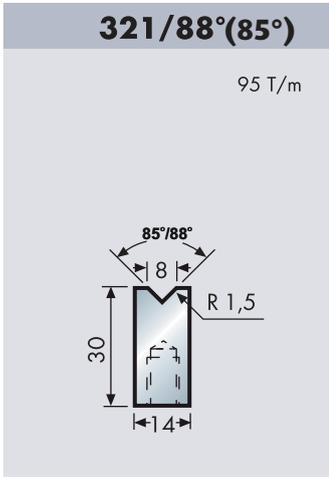
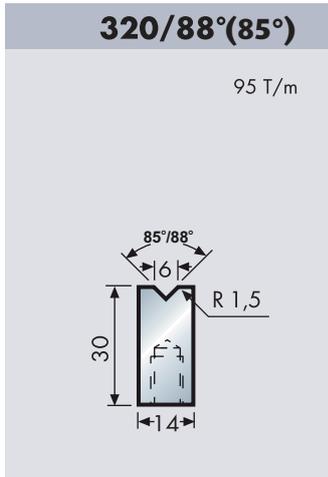
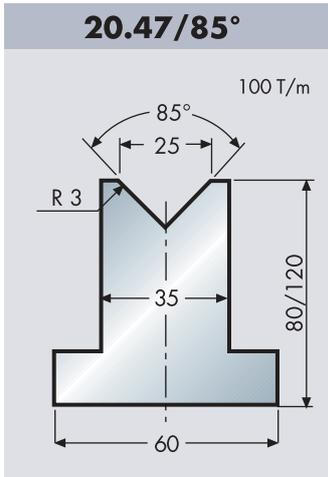
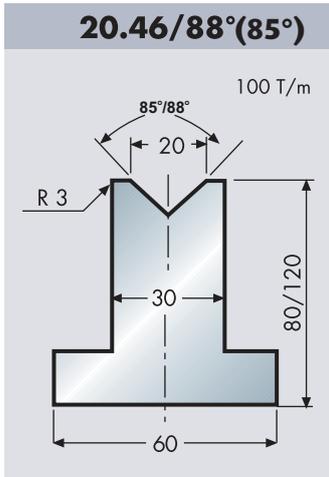
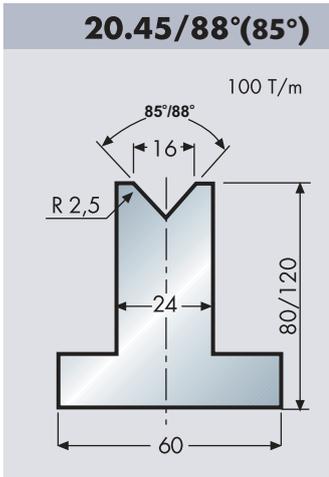
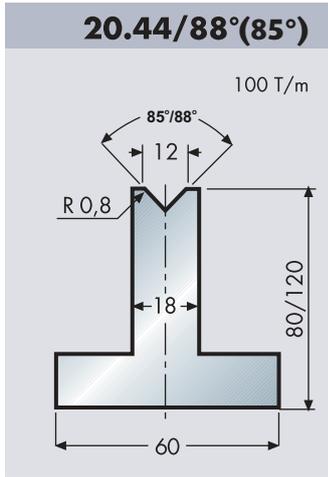
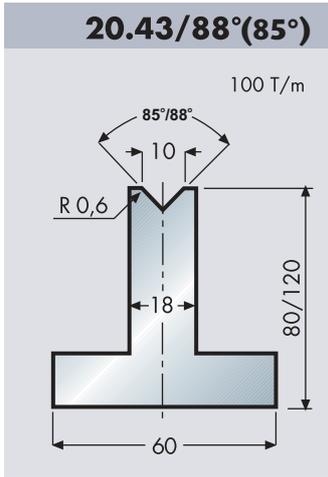
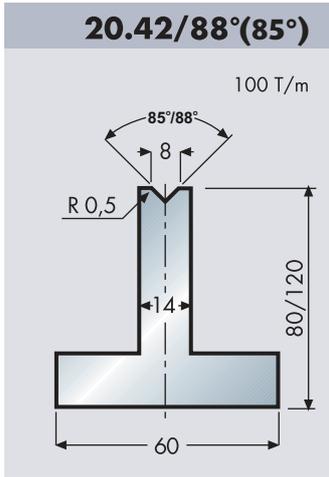
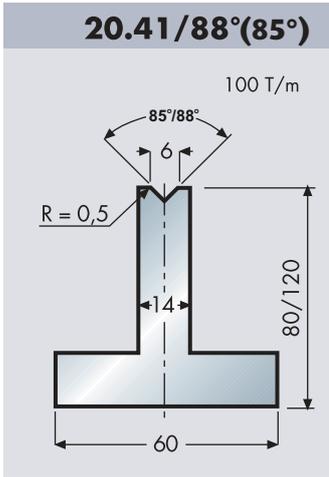


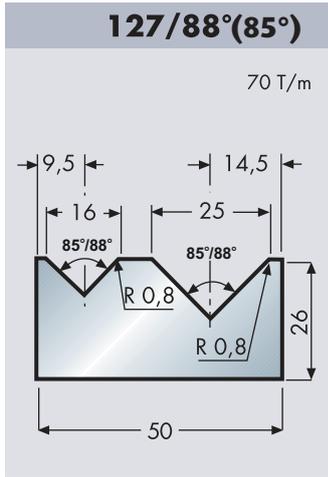
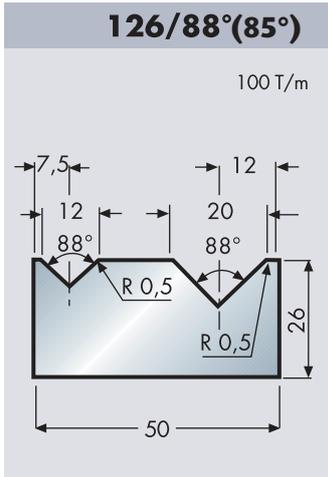
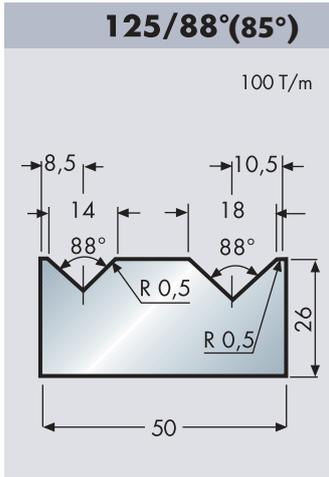
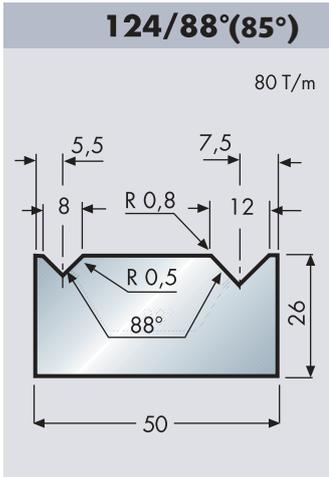
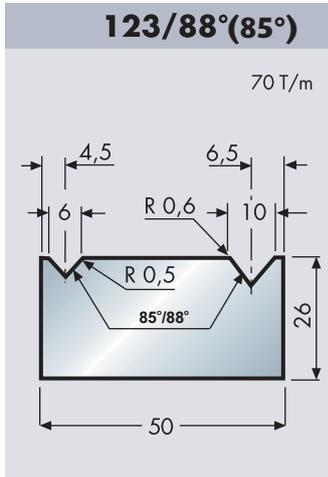
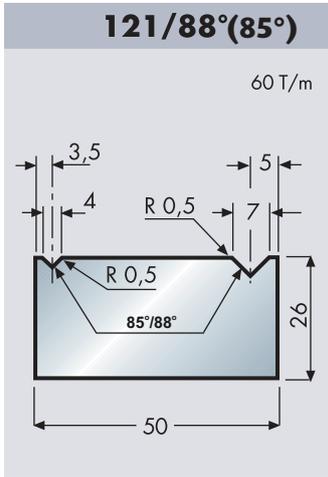
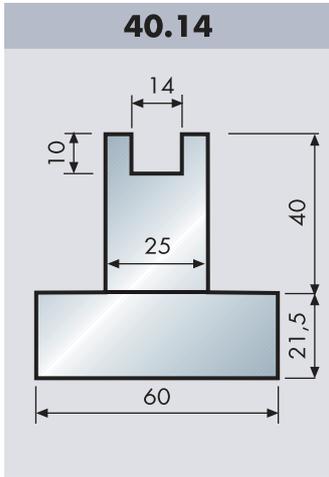
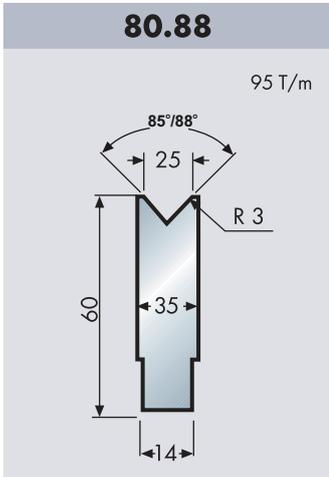
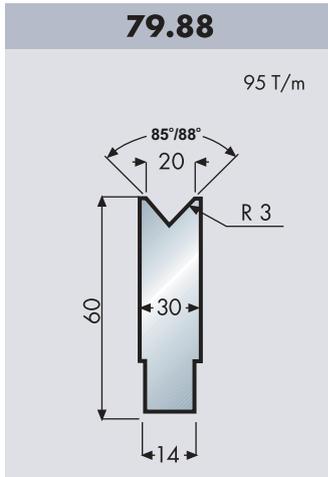
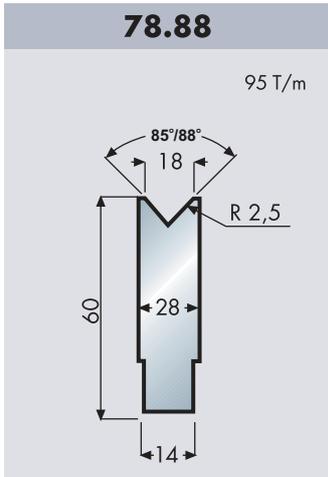
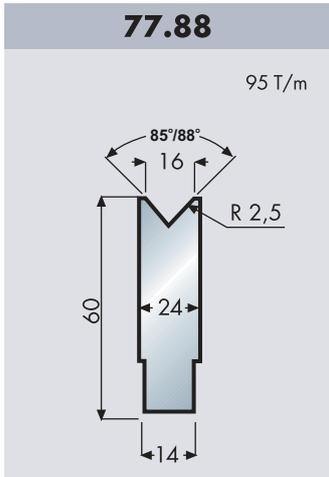
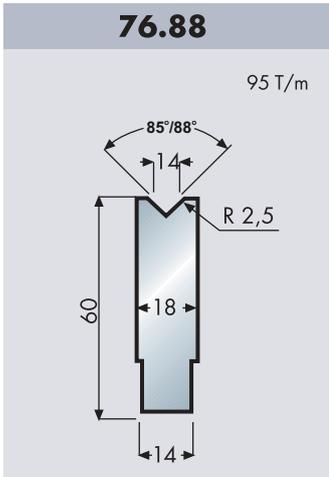
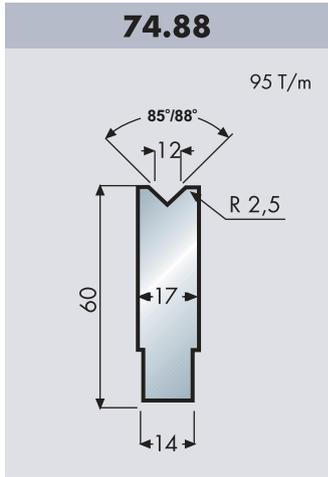
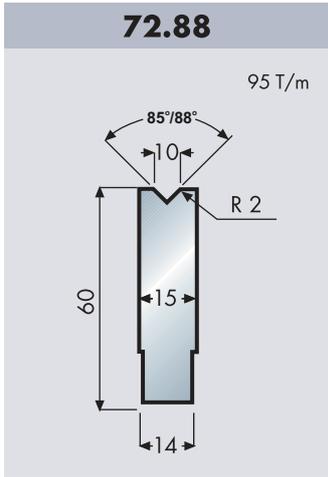
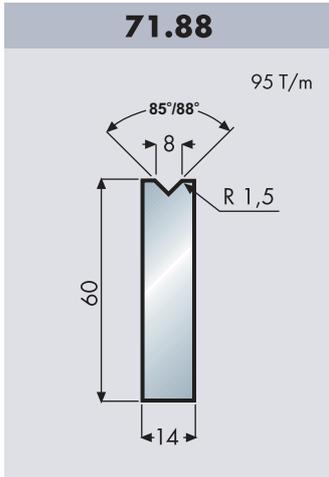
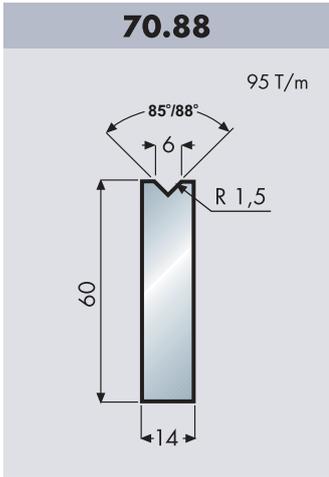


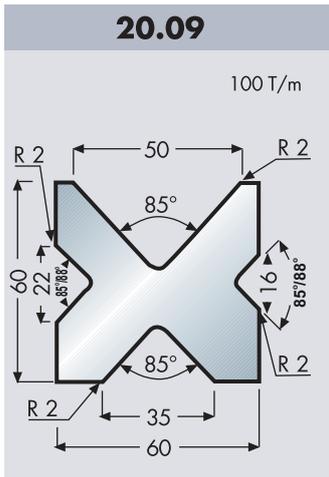
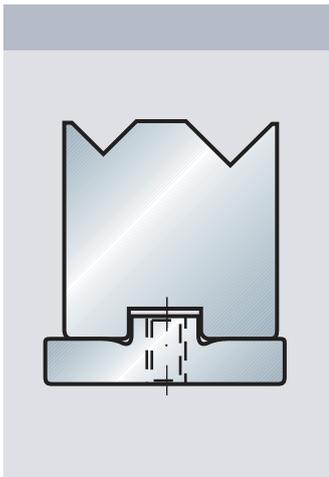
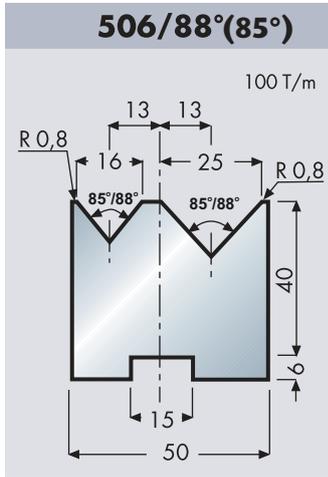
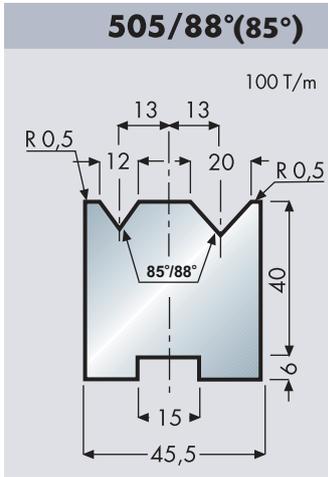
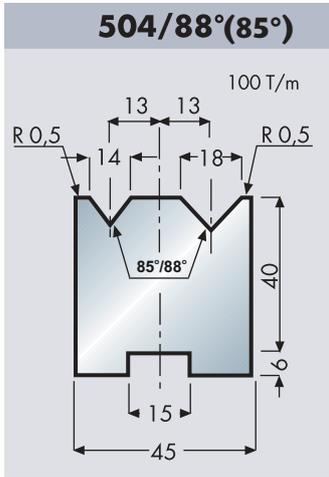
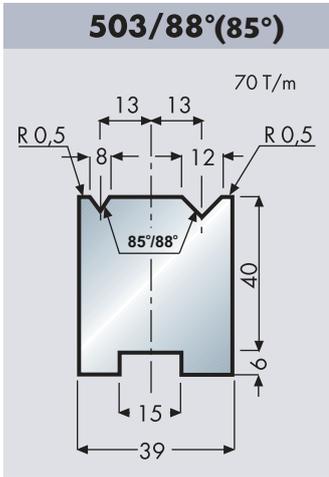
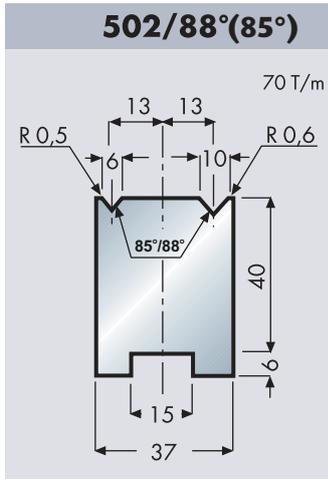
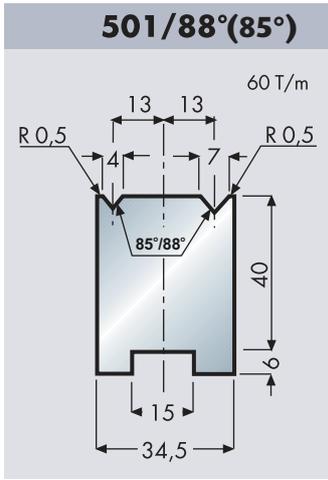
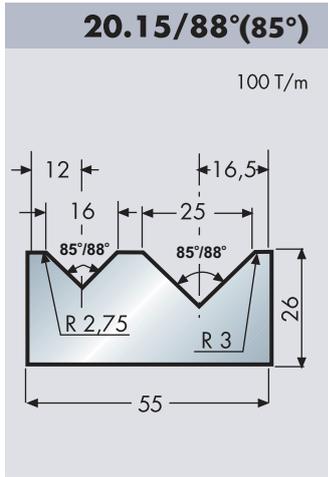
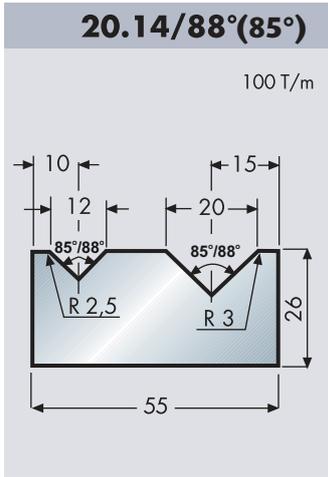
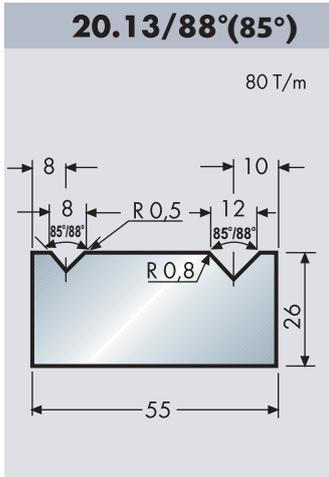
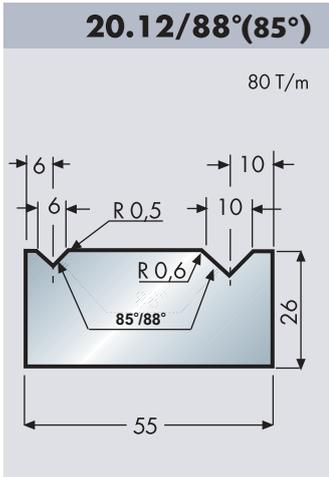


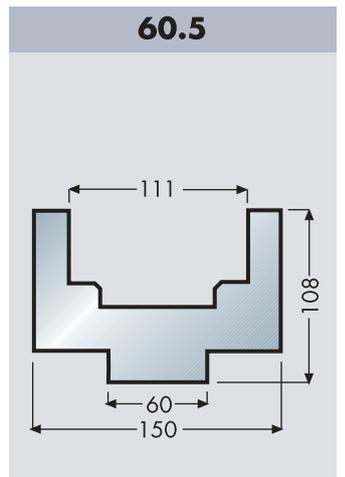
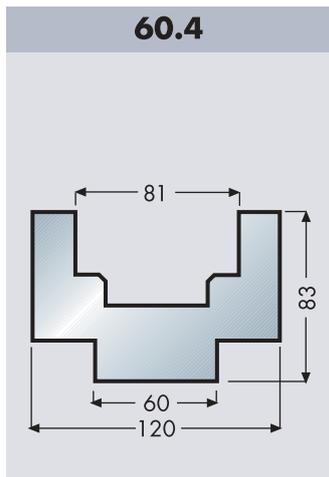
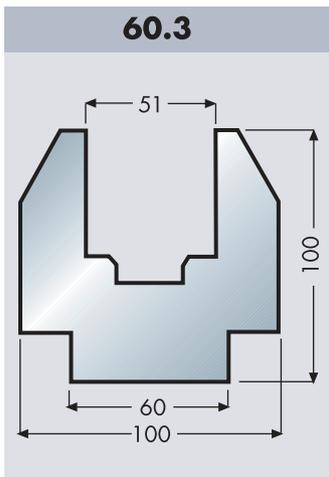
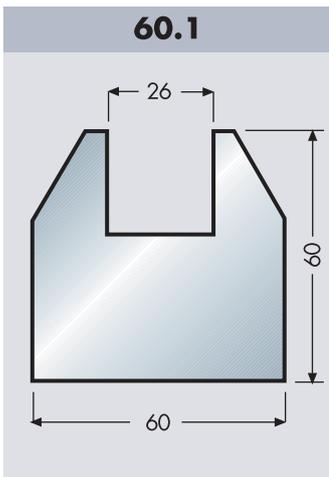
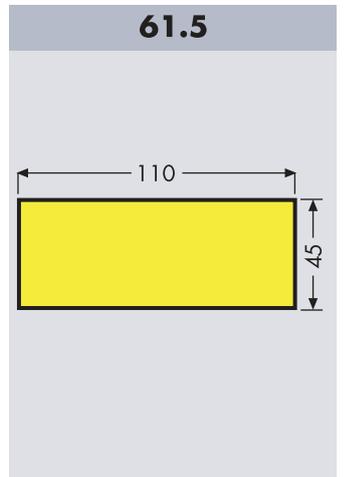
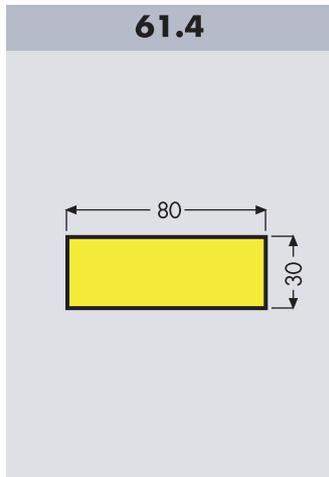
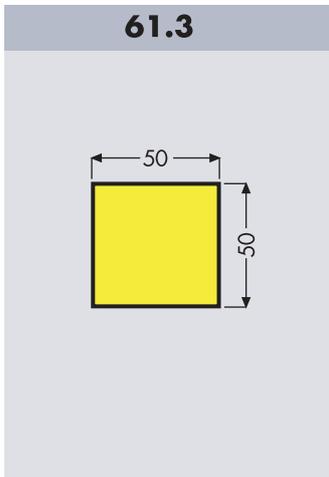
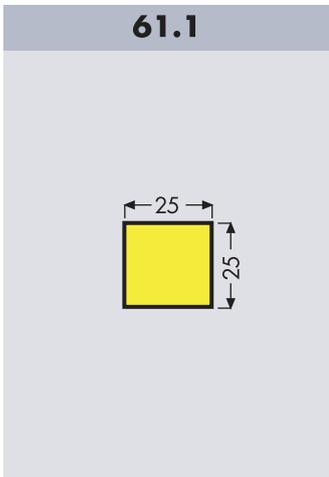
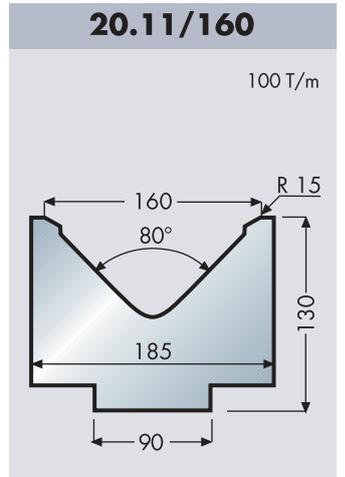
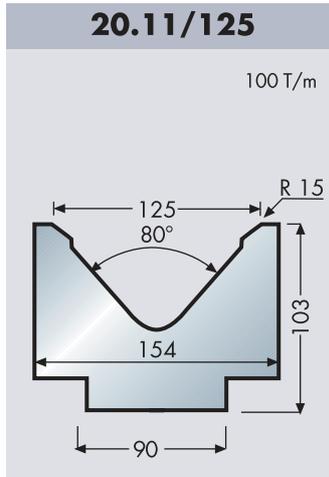
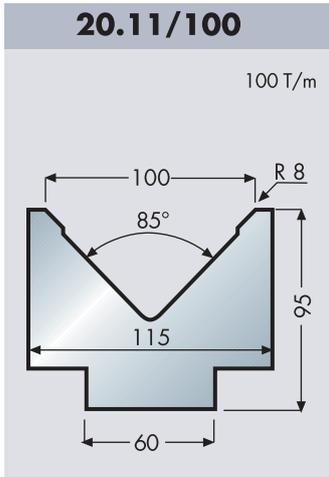
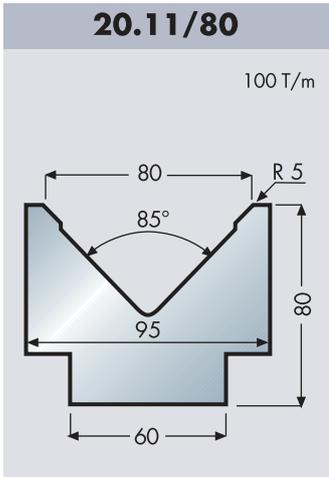
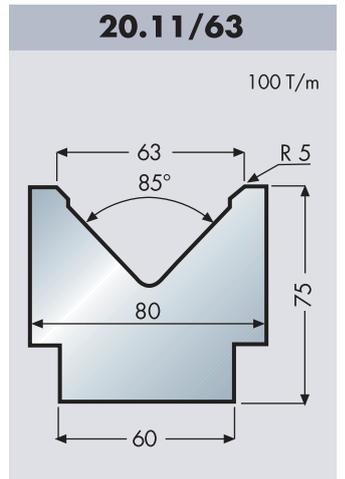
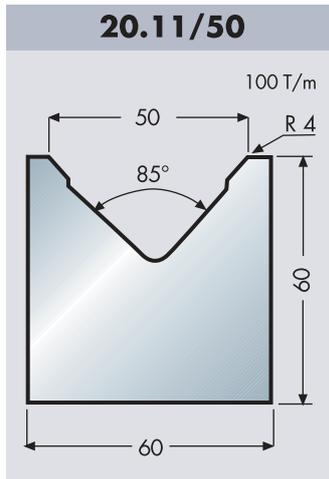
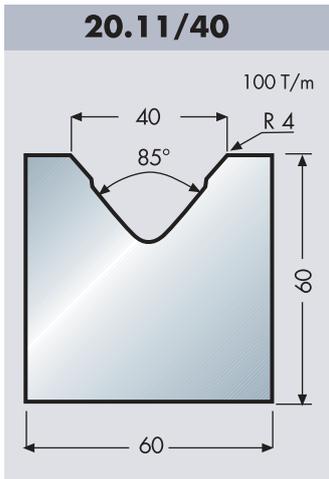
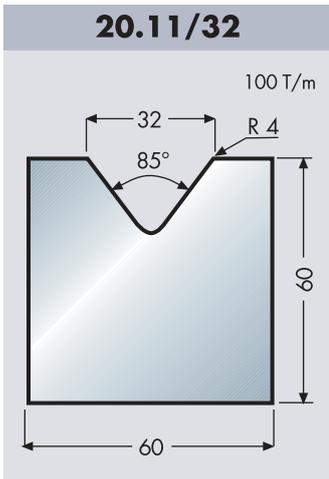
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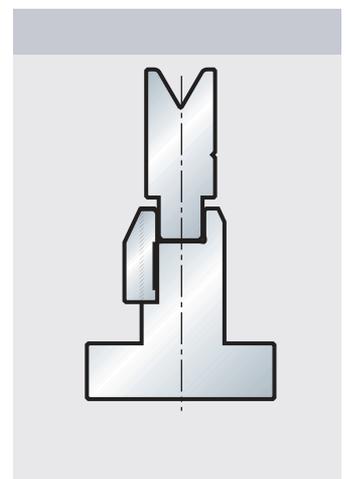
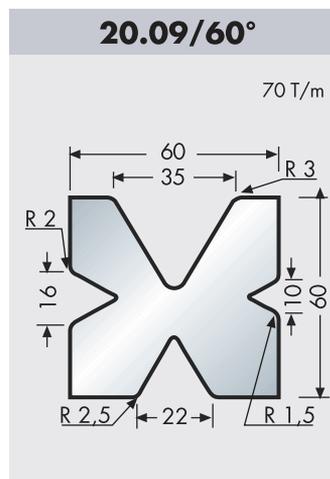
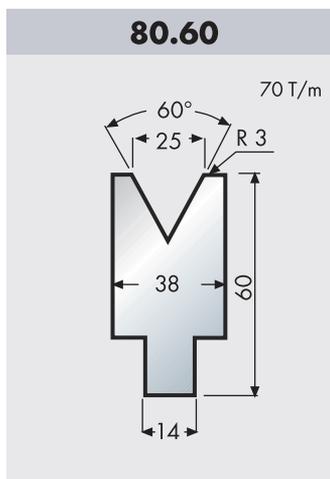
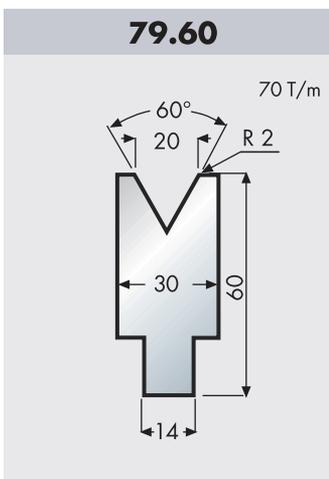
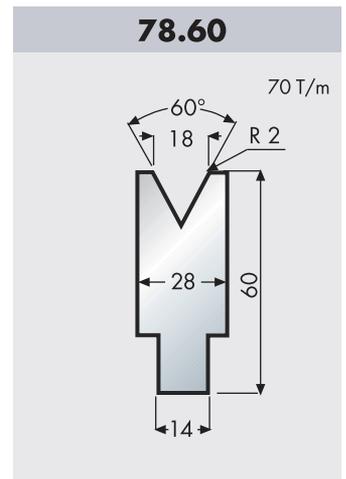
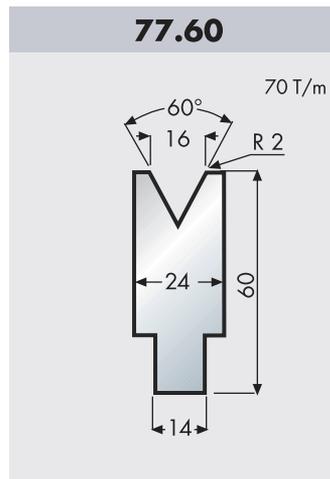
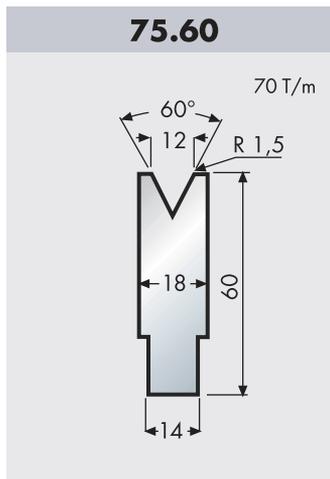
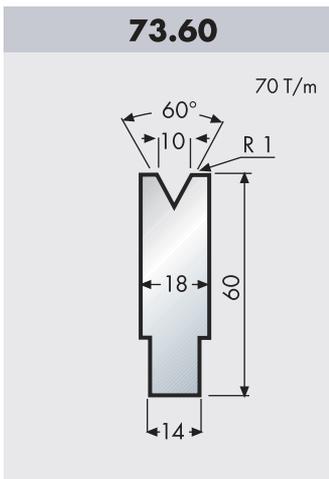
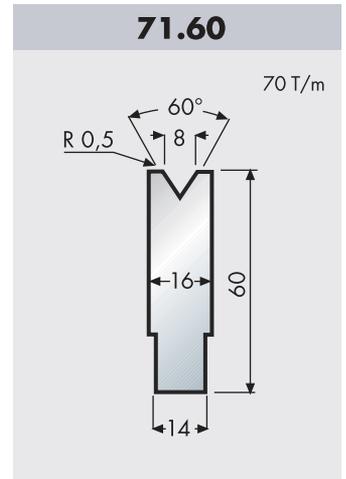
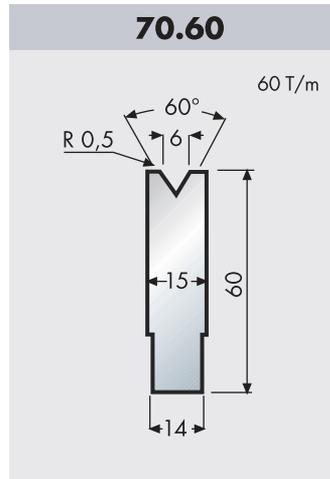
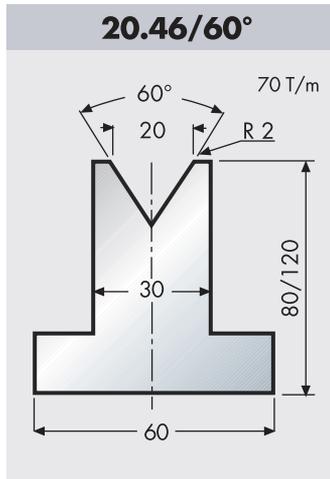
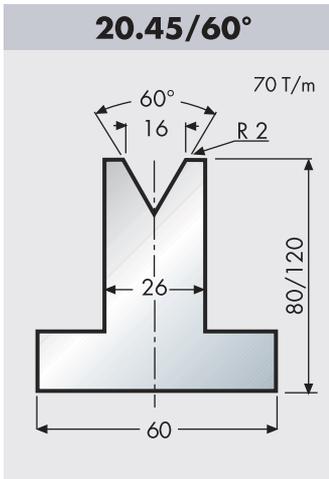
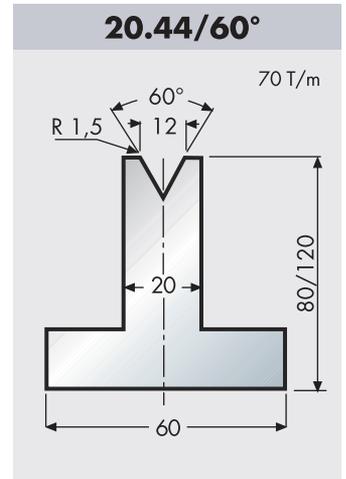
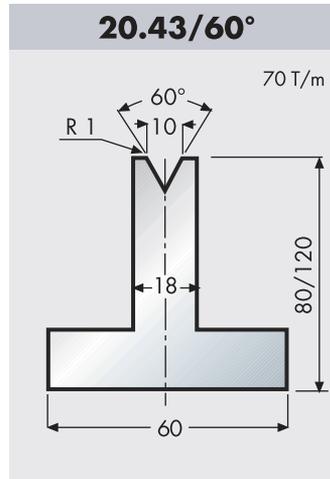
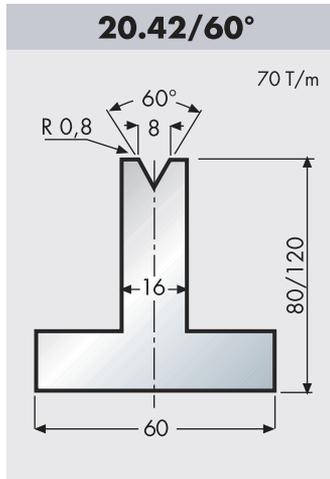
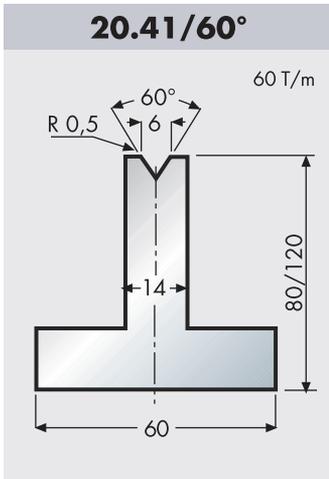


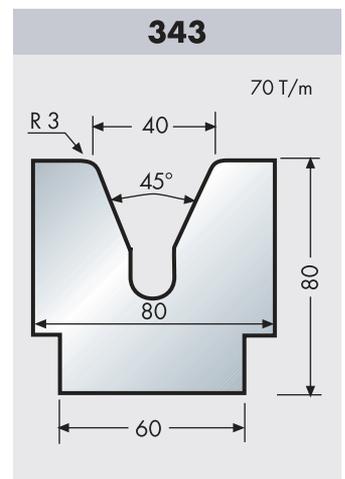
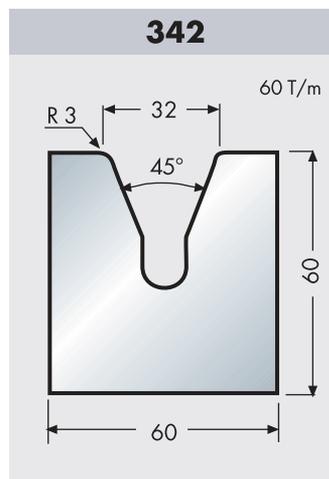
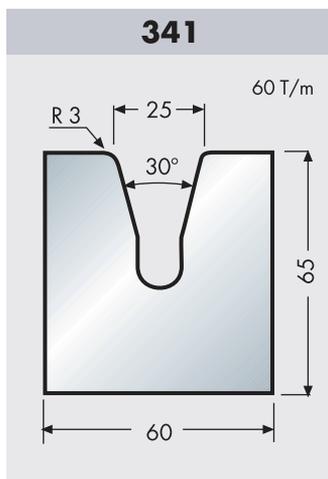
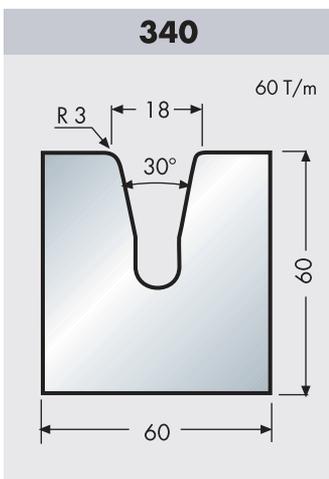
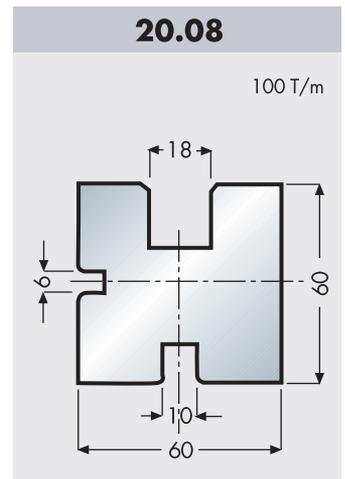
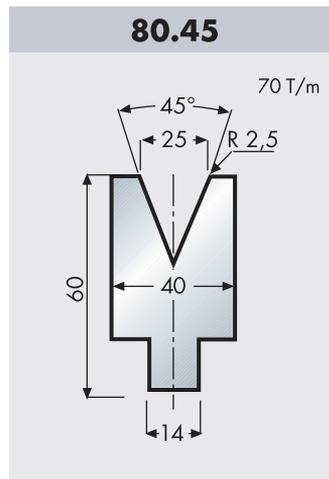
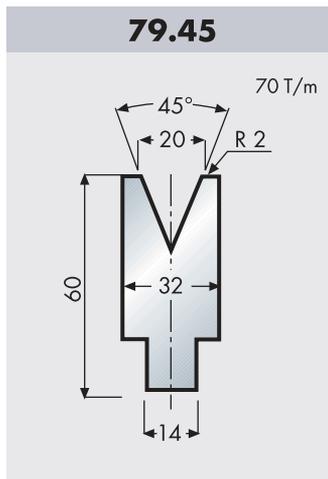
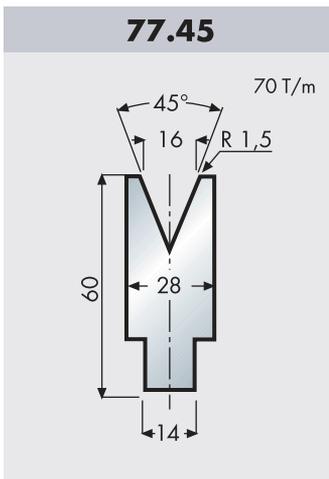
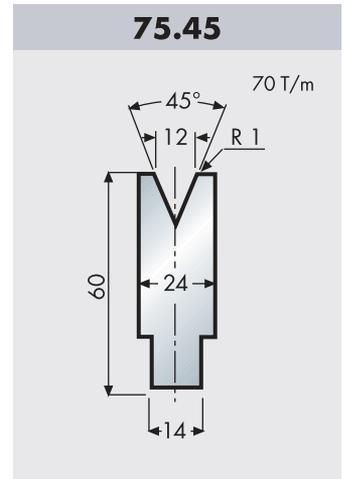
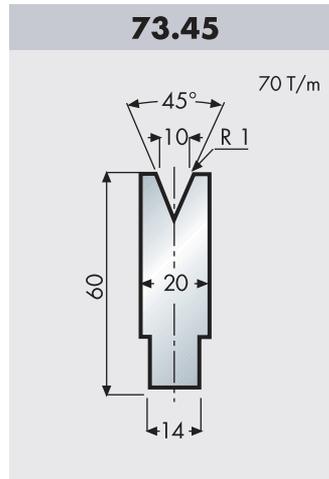
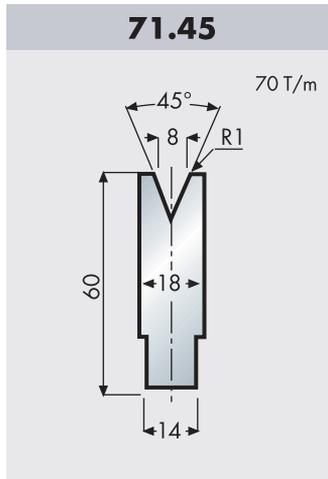
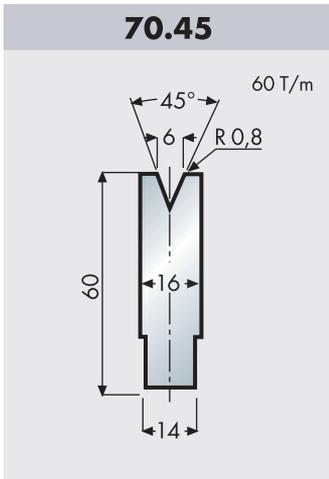
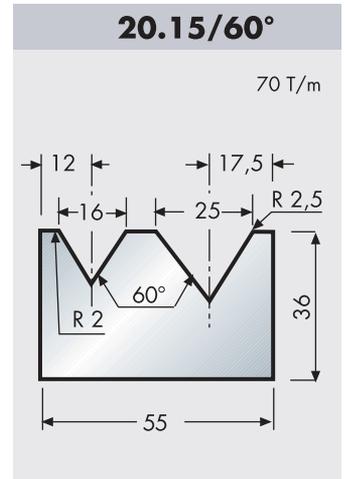
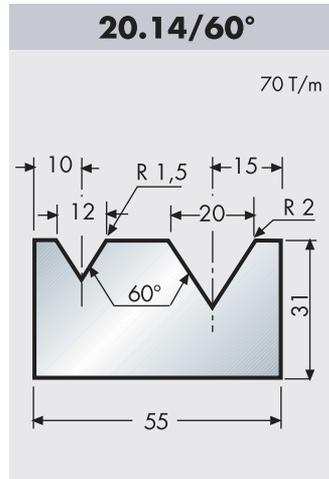
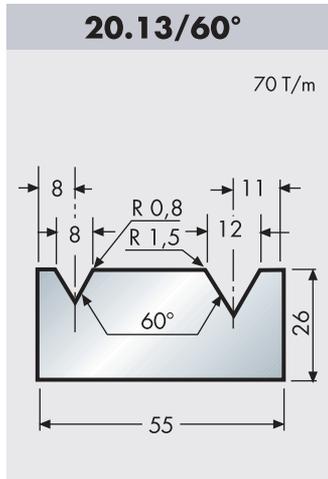
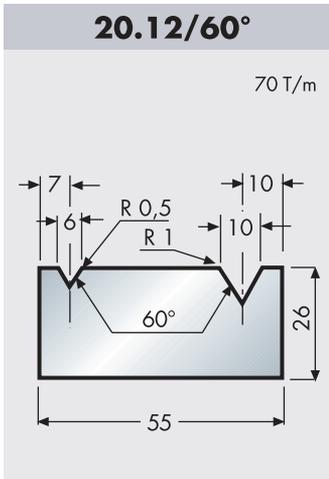


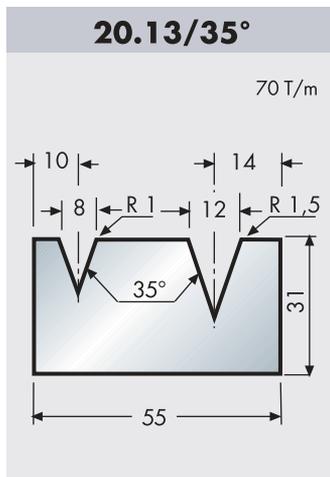
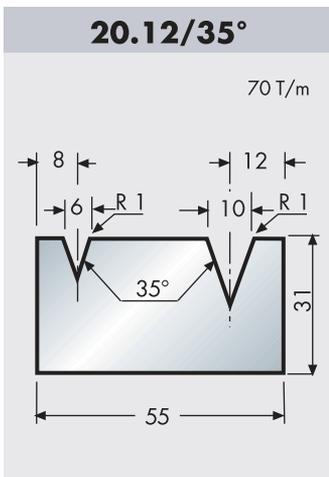
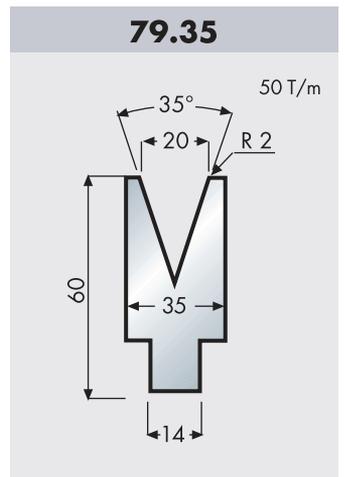
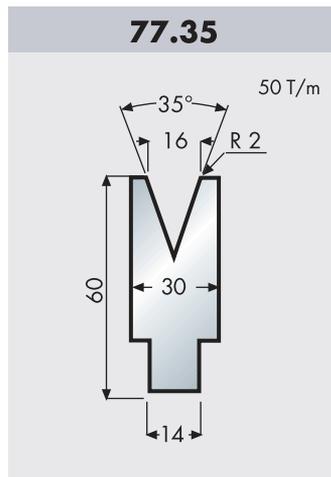
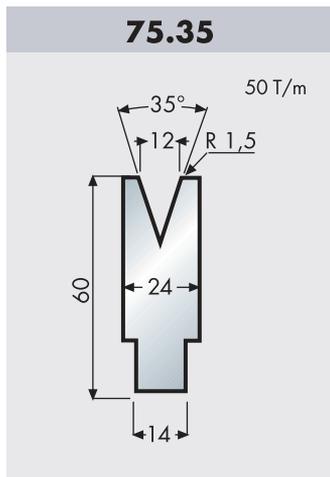
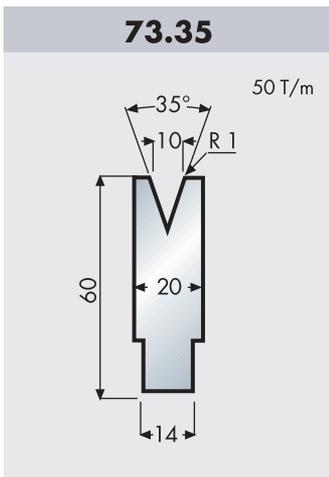
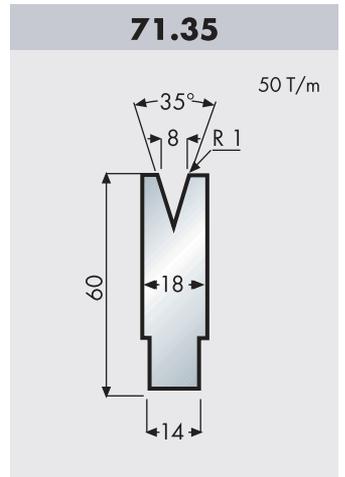
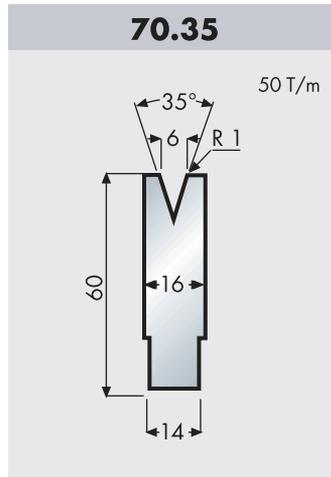
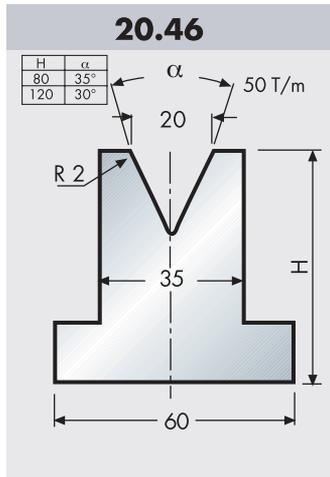
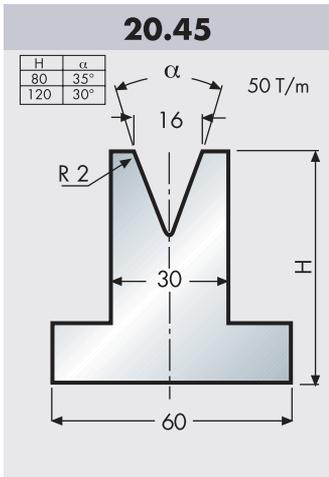
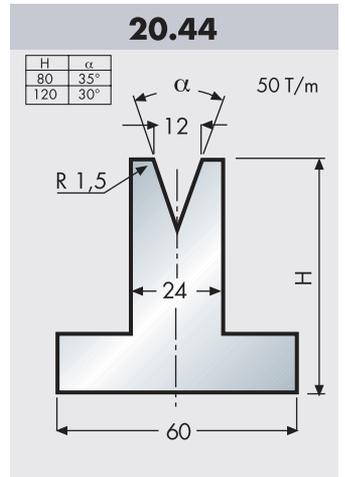
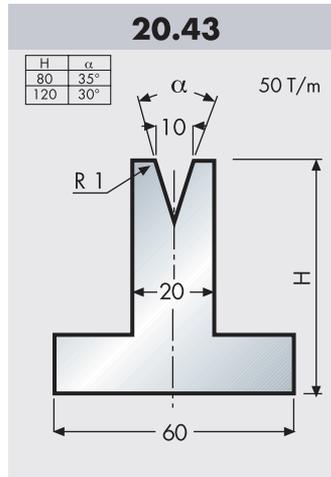
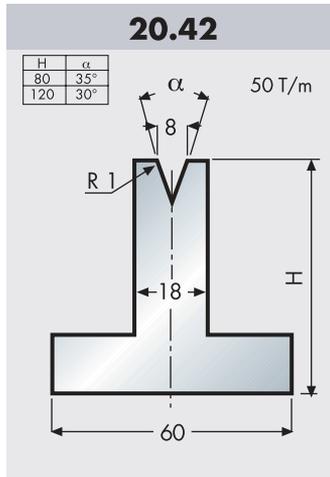
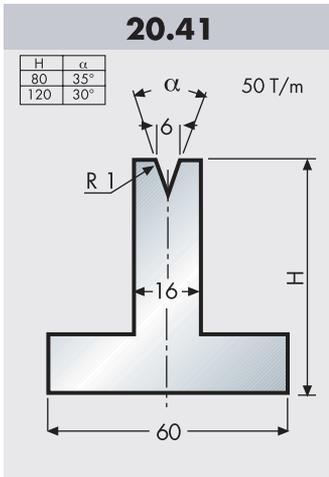


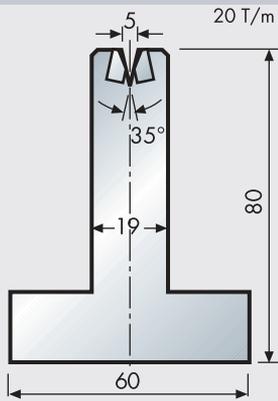
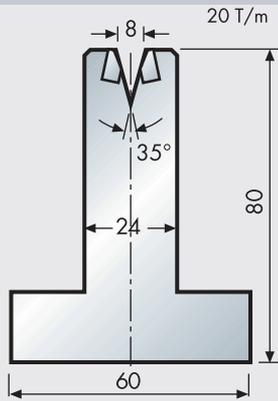
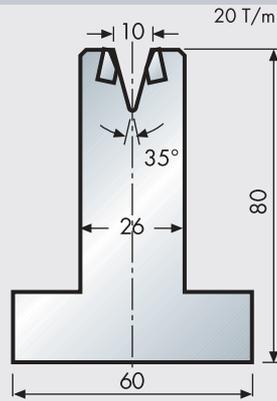
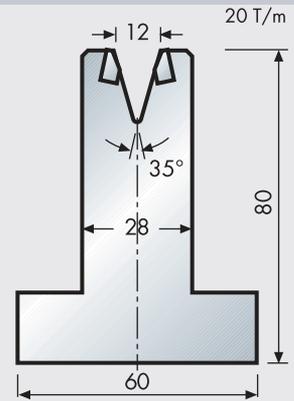
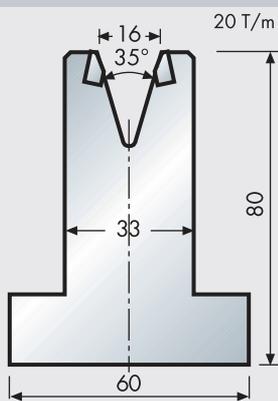
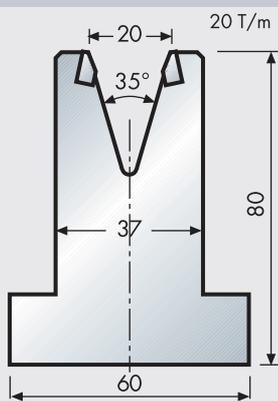
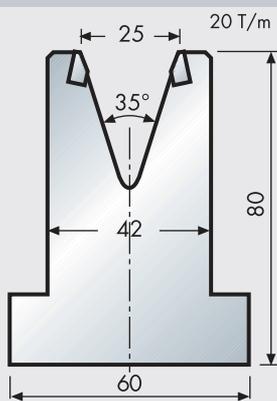
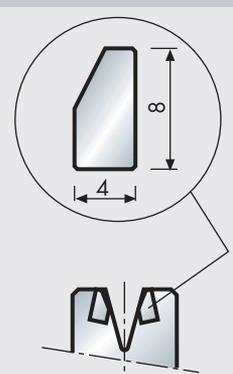










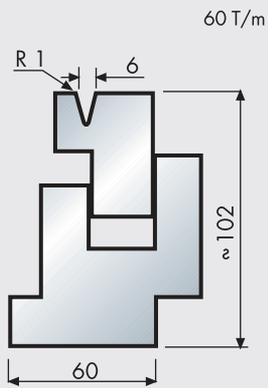
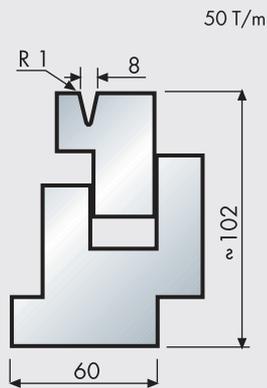
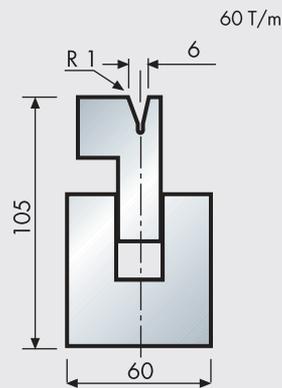
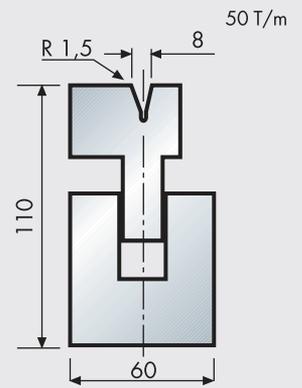
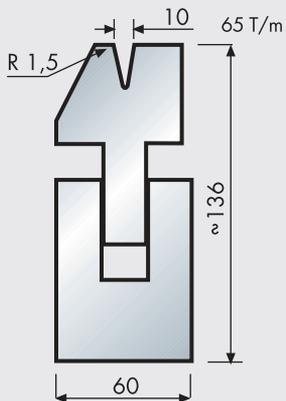
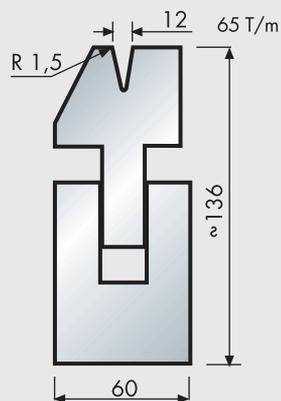
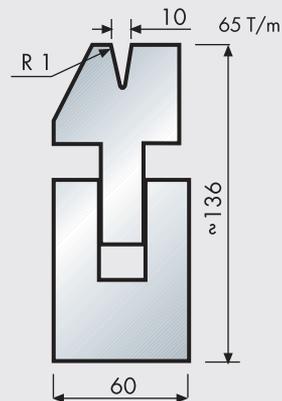
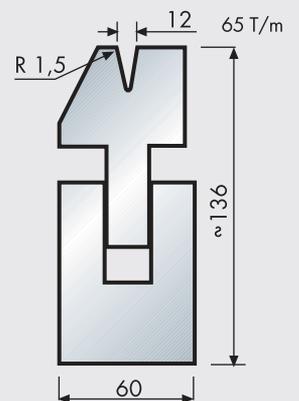
20.30/35°

20.32/35°

20.33/35°

20.34/35°

20.35/35°

20.36/35°

20.37/35°

20.30-T


Questa matrice a T è nata per evitare i segni sulla lamiera ed è molto adatta ad eseguire contropieghe ravvicinate.

È inoltre possibile sostituire i ricambi in gomma, in modo da utilizzare la matrice per più tempo e riducendo notevolmente i costi.

This kind of die is mainly used to bend delicate sheets that must not show sliding signs. The T shape very thin for a die with rubber, is used to make closed underfolded bendings. The plastic insert is also supplied as a spare and can be replaced by the customer himself, to guarantee less costs and a longer die life

Данный инструмент предназначен для гибки деликатных металлов, наличие царапин на которых недопустимо. Пластиковые вставки поставляются в качестве расходных материалов, их замена крайне проста и не требует специальных навыков, что позволяет снизить расходы на обслуживание и гарантировать продолжительный срок жизни инструмента.

30.01/6-35°

30.01/8-35°

30.02/6-35°

30.02/8-30°

30.01/10-35°

30.01/12-35°

30.01/10-26°

30.01/12-26°

30.01/30.02 PNEUMATIC / PNEUMATIC / PNEUMATISCH

I piegasciaccia mod. 30.01 e mod. 30.02 possono essere forniti con azionamento pneumatico, manuale o con elettrovalvola comandata dal CNC della pressa.

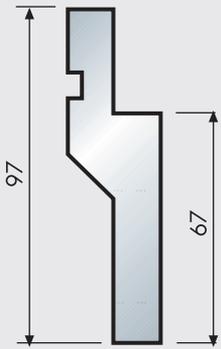
On request, the whole range of mod. 30.01 and 30.02 is available with pneumatic drive, manual drive or with solenoid valve controlled by the cnc of press brake.

По запросу любой инструмент модельного ряда 30.01 и 30.02 может быть изготовлен с пневматическим приводом подъема, с ручным управлением или управлением через клапан от системы ЧПУ листогибочного пресса.



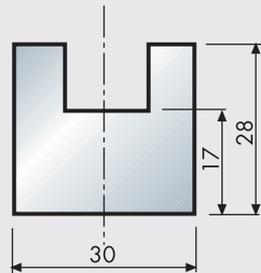
40.05

100 T/m



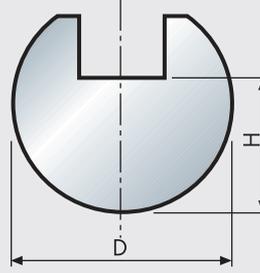
40.02

100 T/m



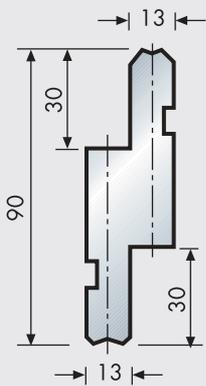
40.09

100 T/m

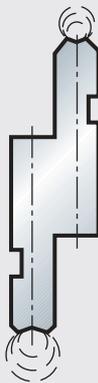
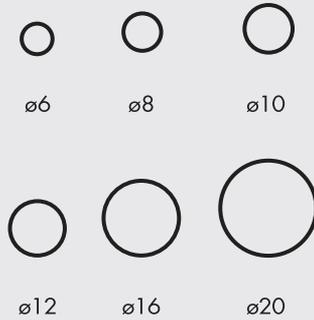


D	20	25	30	35	40	50	60	80	100
H	12	17	20	22	24	29	34	44	70

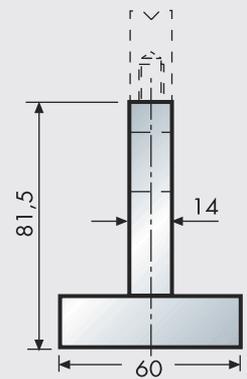
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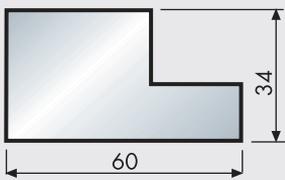
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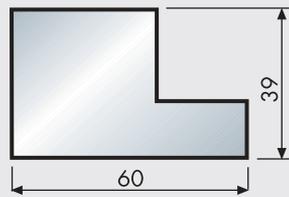
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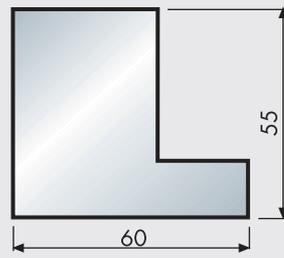
40.06/34



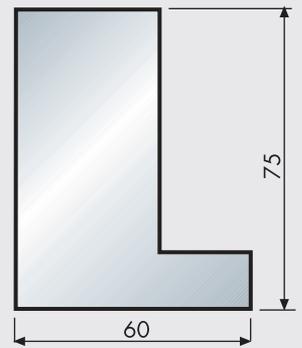
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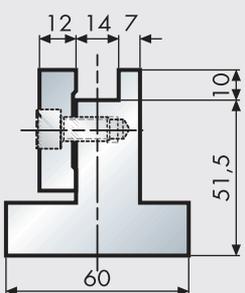
40.07/55



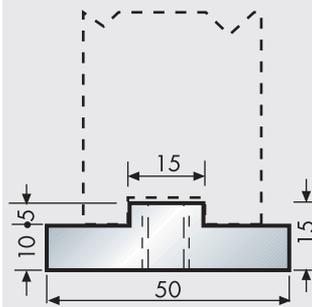
40.07/75



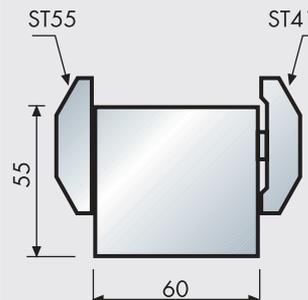
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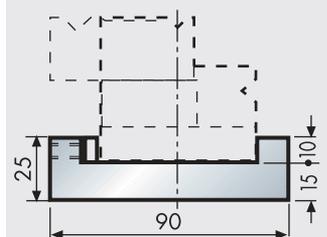
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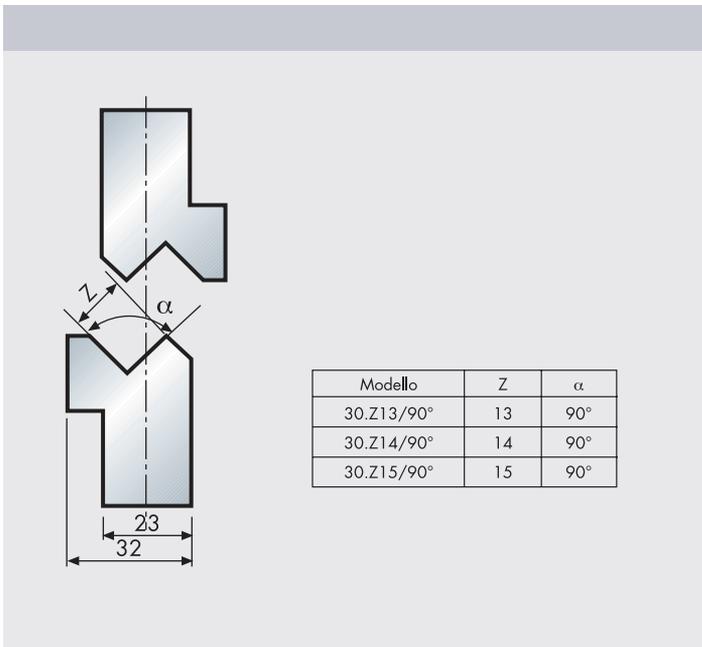
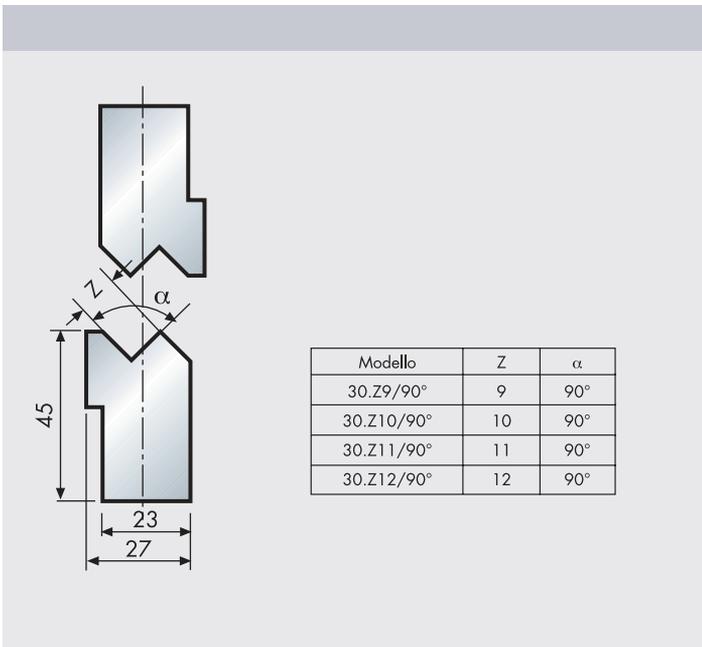
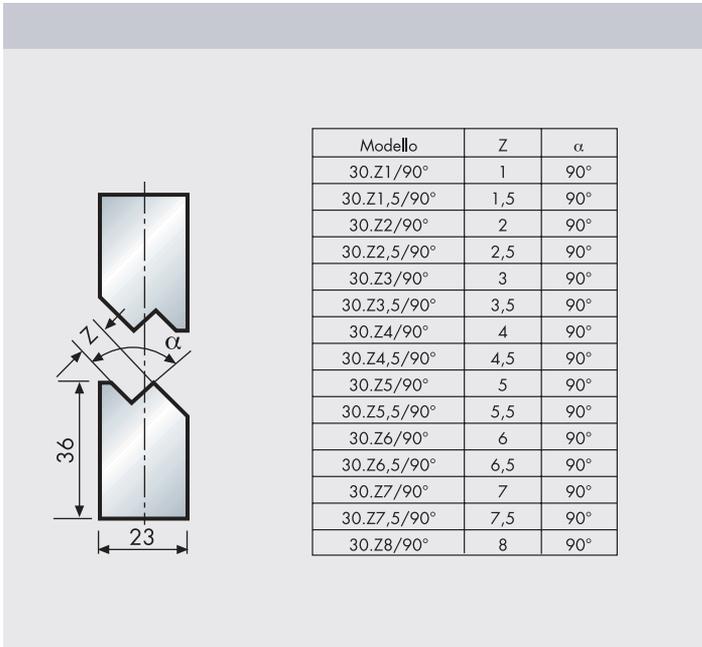
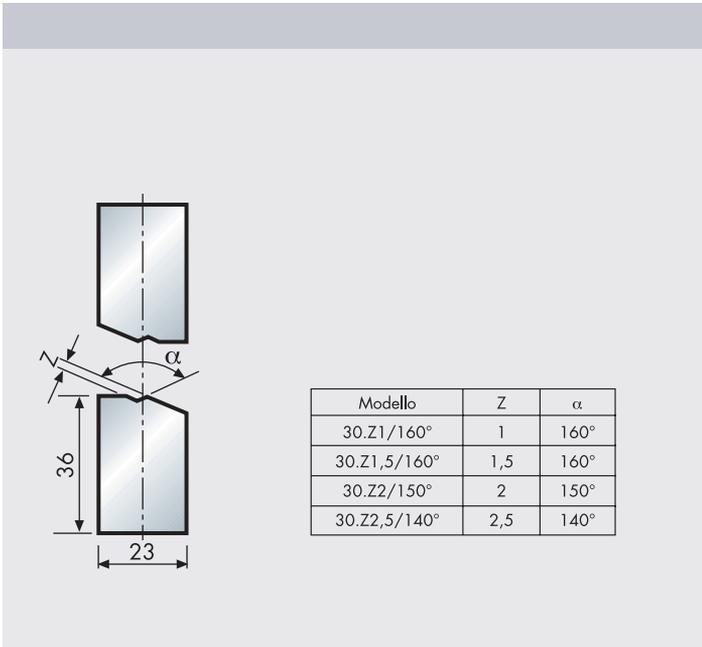
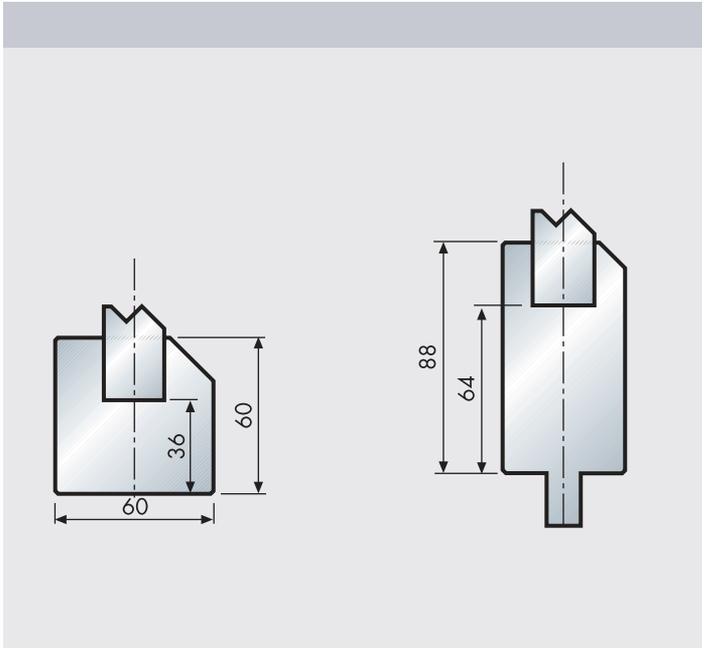
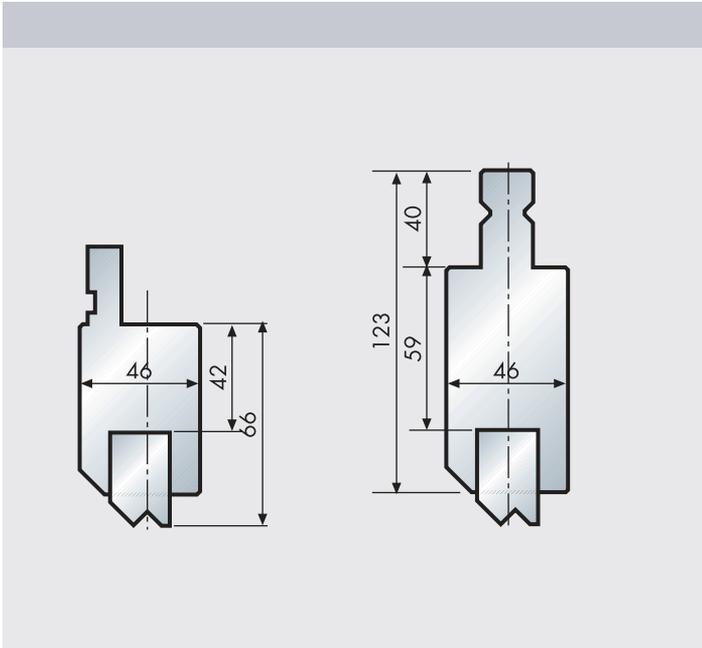


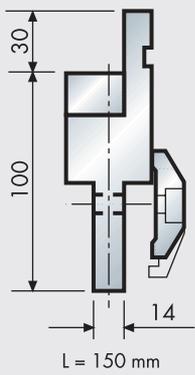
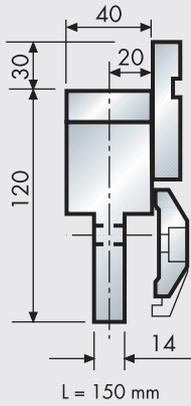
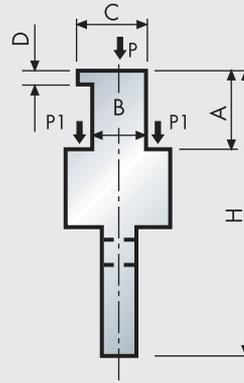
40.55



40.60





40.03

40.50

40.20


Per ogni Vs. richiesta, vi preghiamo di indicare:

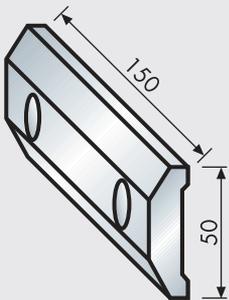
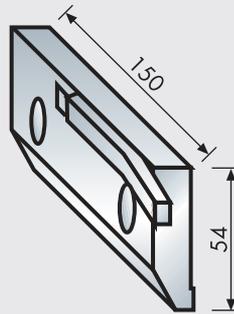
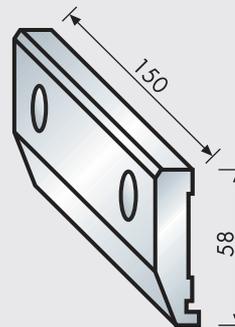
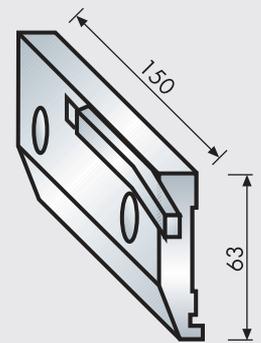
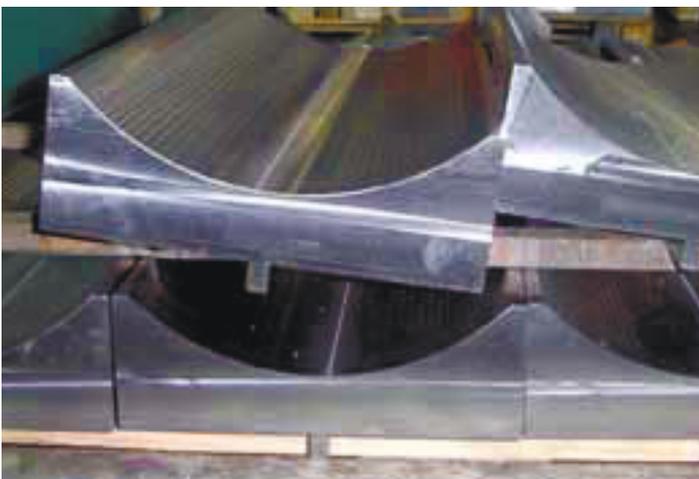
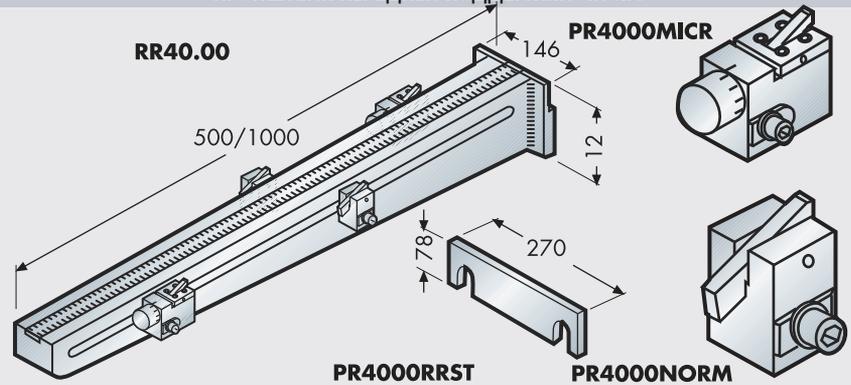
- altezza totale H;
- misure dell'attacco A-B-C-D;
- se la pressa spinge in P o in P1;
- lunghezza.

For any enquiry, please state:

- total height H
- dimensions of tongue A-B-C-D
- whether the press-brake pushes on P or P1
- length

При спещзапросе укажите:

- Общую высоту
- Присоединительные размеры A-B-C-D
- Точка приложения усилия P или P1
- Длина

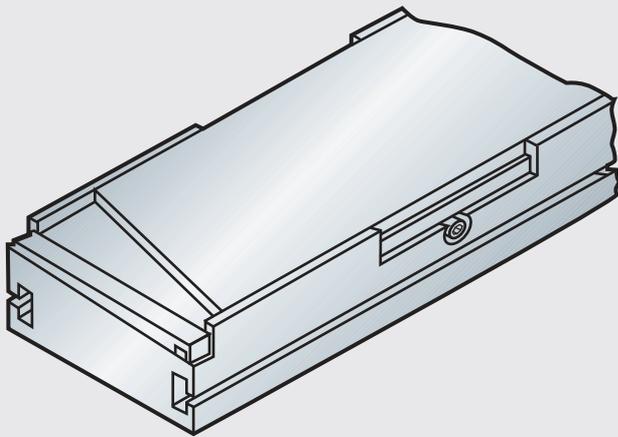
ST41

ST42

ST43

ST44

RIFERIMENTI PER PRESSE PIEGATRICI / ARM GAUGES FOR PRESSBRAKES /
КРОНШТЕЙН ПЕРЕДНЕЙ ПОДДЕРЖКИ ЛИСТА


SISTEMI DI COMPENSAZIONE / DEFLECTION COMPENSATING SYSTEMS / СИСТЕМЫ КОМПЕНСАЦИИ ПРОГИБА


Azionamento da controllo numerico
 Numerical control drive
**Моторизованный привод
 с цифровым управлением**



Azionamento manuale
 Manual drive
Ручной привод

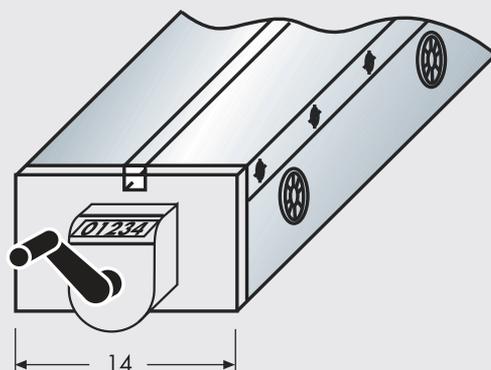
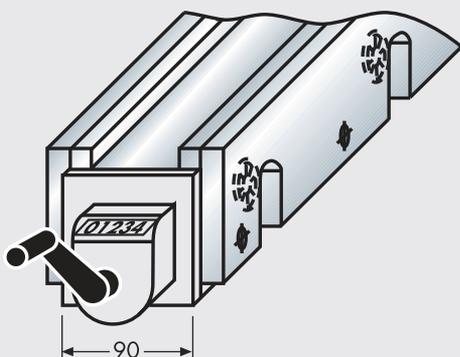

TAVOLA SPECIALE DI COMPENSAZIONE A CUNEI / SPECIAL DEFLECTION COMPENSATING WEDGE-SHAPED TABLE / СПЕЦИАЛЬНЫЕ КЛИНЬЕВЫЕ СТОЛЫ КОМПЕНСАЦИИ ПРОГИБА


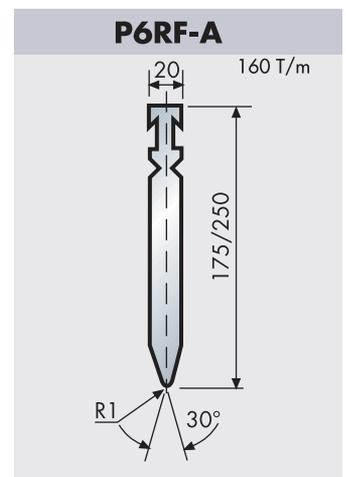
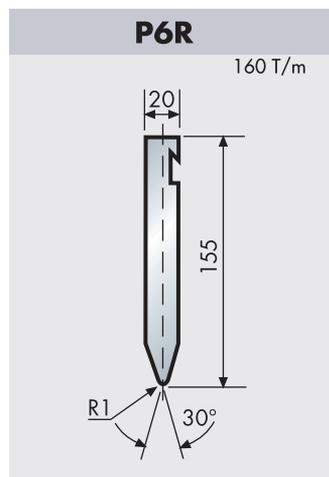
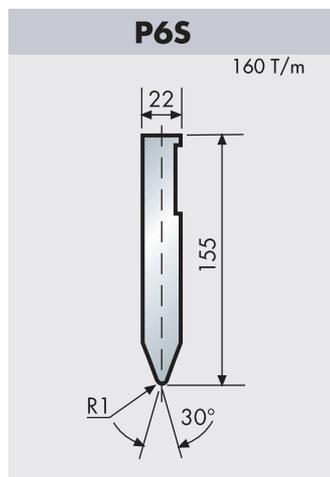
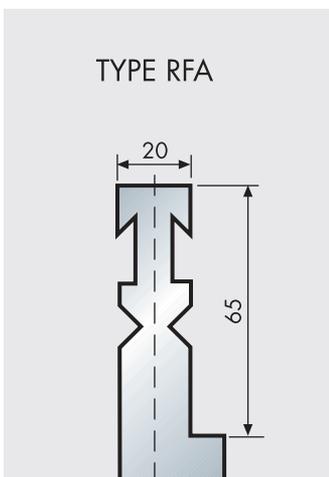
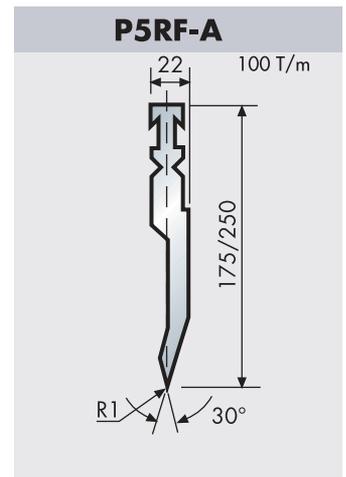
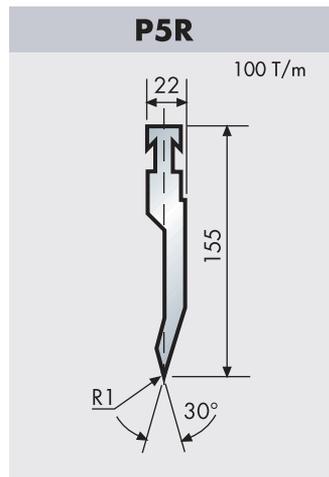
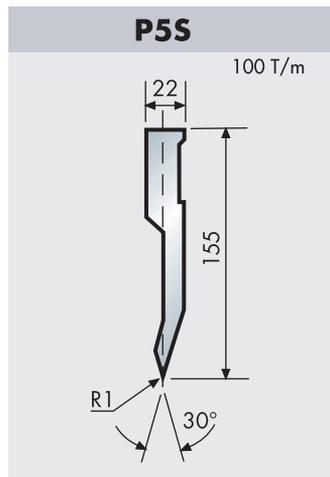
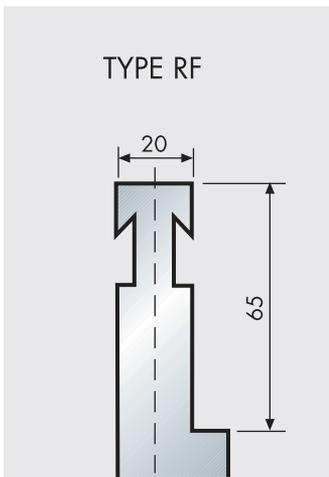
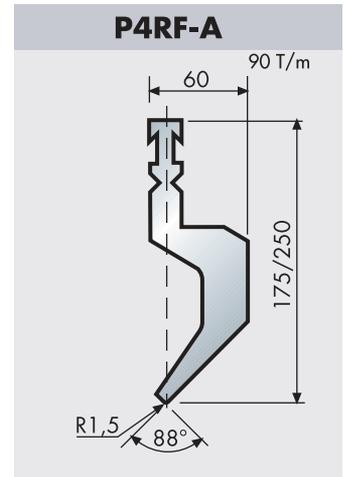
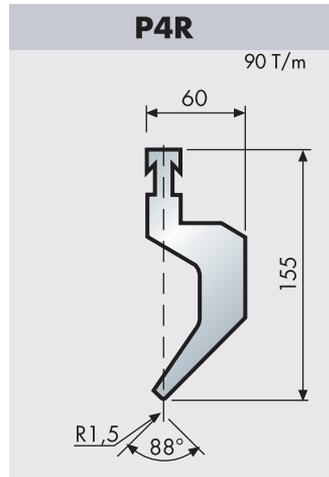
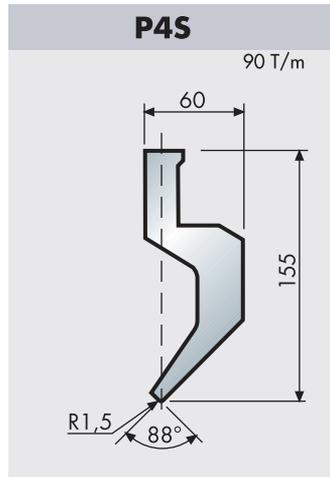
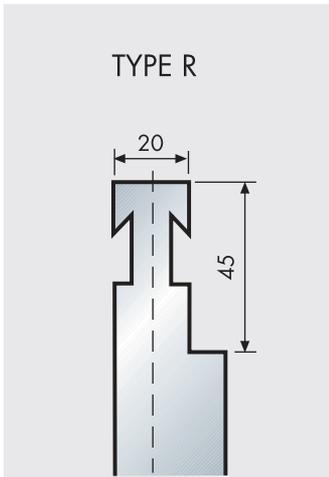
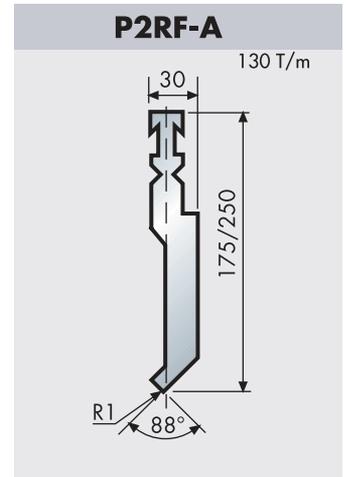
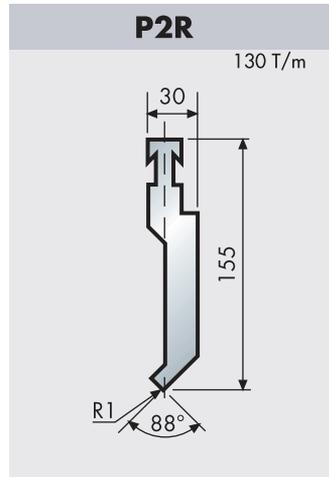
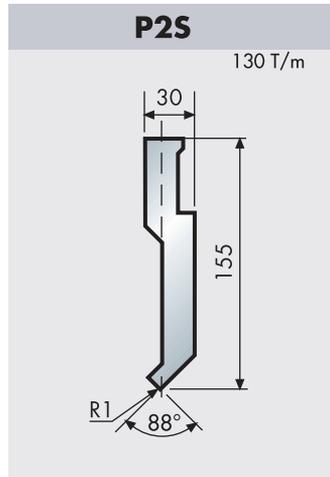
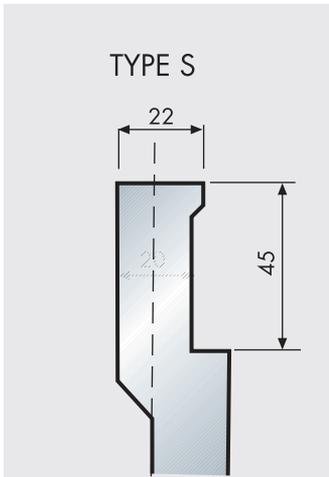
Questo sistema serve per compensare le flessioni della tavola superiore e inferiore della pressa piegatrice e garantisce angoli di piega costanti su tutta la lunghezza della lamiera. Le flessioni vengono compensate tramite un sistema di cunei longitudinali o trasversali. La tavola viene calcolata in base alle caratteristiche strutturali della pressa piegatrice e personalizzata secondo le esigenze del cliente. Possono essere realizzate con compressione longitudinale, trasversale o combinata, a comando manuale o collegata al CNC della macchina.

It is well-known that the angle of bending is not constant on the total length due to the deflections which form during the working on the press brakes. That problem is solved by means of deflection compensating tables which through a manual or automatic wedge-shaped system, follow the diagram of the deflections to balance it. There are two kinds of compensation: longitudinal for a linear diagram and transversal for restricted adjustments.

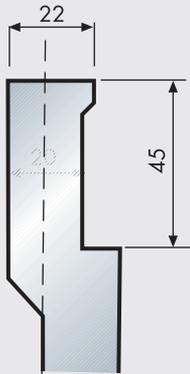
Известно, что уголгиба может быть непостоянным вдоль линии гибки вследствие деформаций станка при нагружении.

Данную проблему можно устранить при помощи столов со встроенной системой компенсации прогиба. Привод такого стола может быть ручной или автоматический. Существует два типа компенсации: продольная с приводом для регулировки в зависимости от условий нагружения и поперечная для первичной настройки системы.

TAVOLA DI COMPENSAZIONE STANDARD AD AZIONAMENTO MANUALE / STANDARD DEFLECTION COMPENSATING TABLE WITH MANUAL DRIVE / СТАНДАРТНЫЕ СТОЛЫ КОМПЕНСАЦИИ ПРОГИБЫ С РУЧНЫМ ПРИВОДОМ


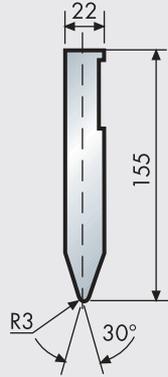


TYPE S



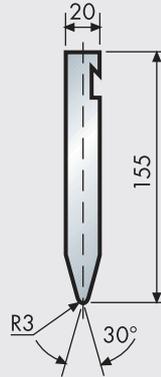
P7S

160 T/m



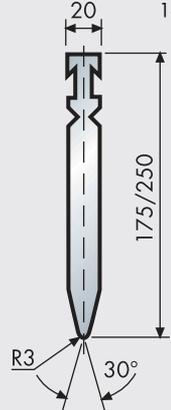
P7R

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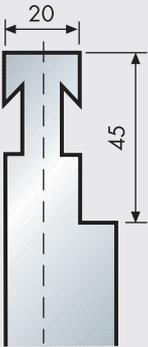


P7RF-A

160 T/m

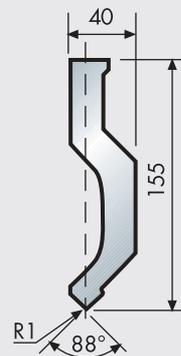


TYPE R



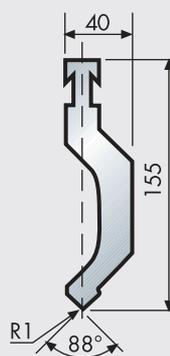
P8S

100 T/m



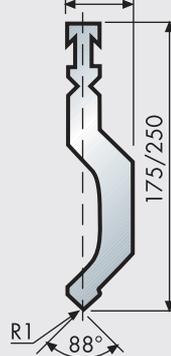
P8R

100 T/m

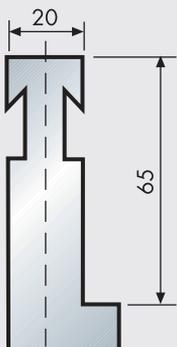


P8RF-A

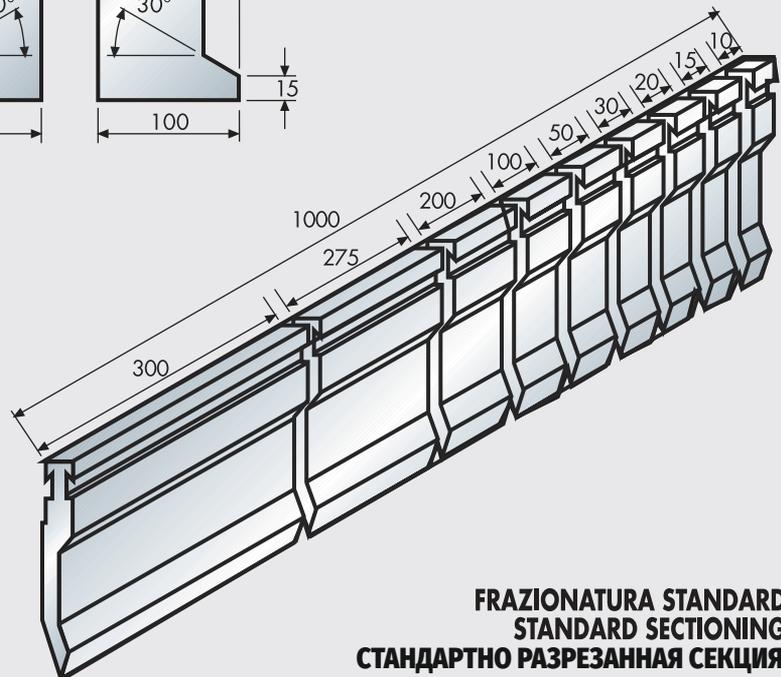
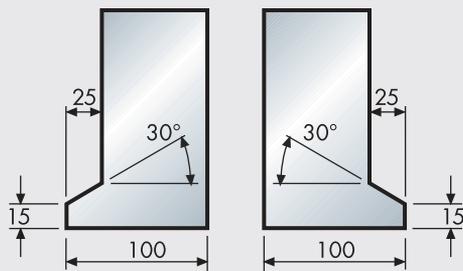
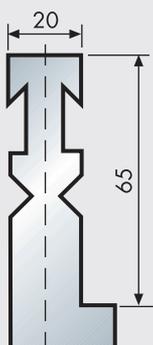
100 T/m



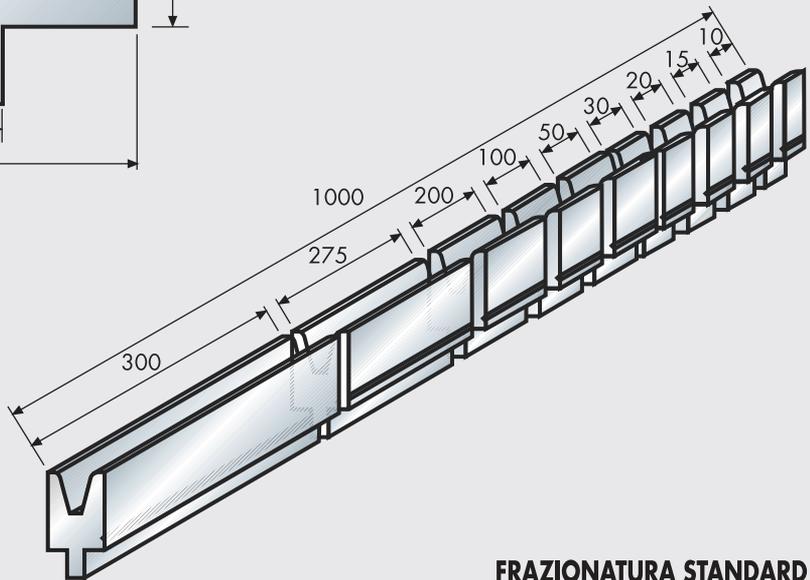
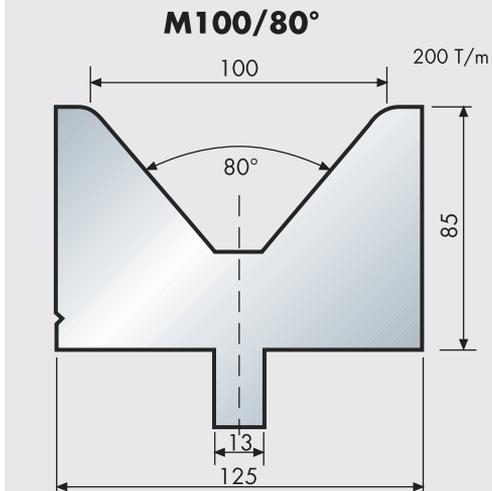
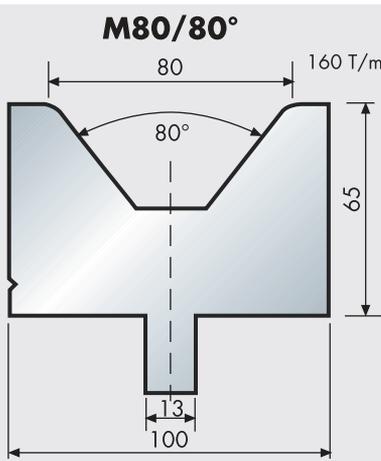
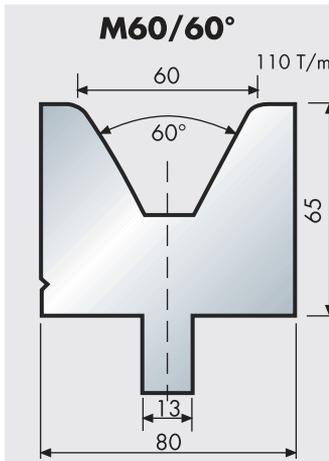
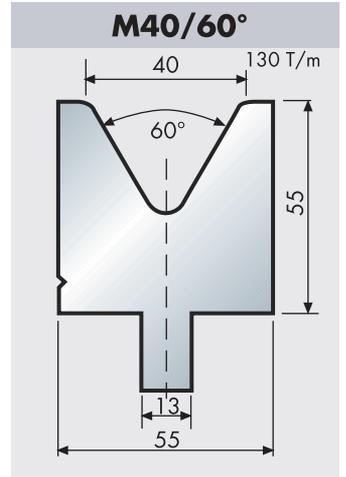
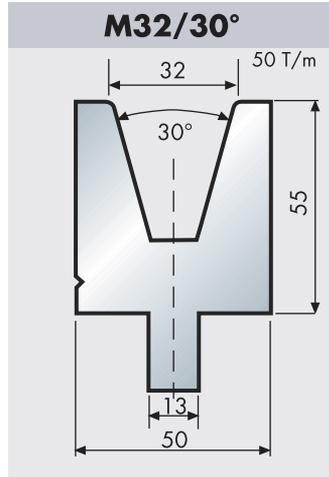
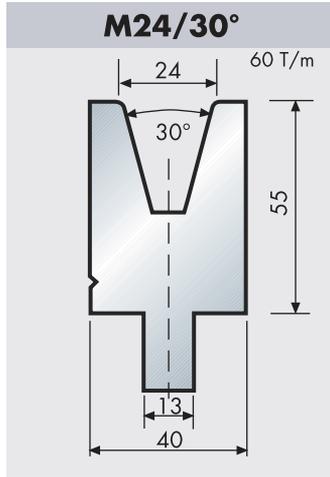
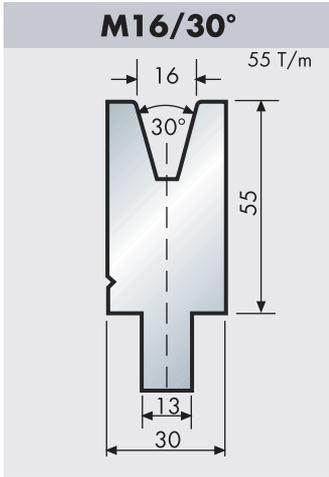
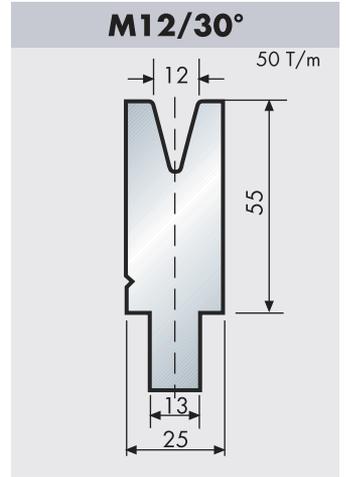
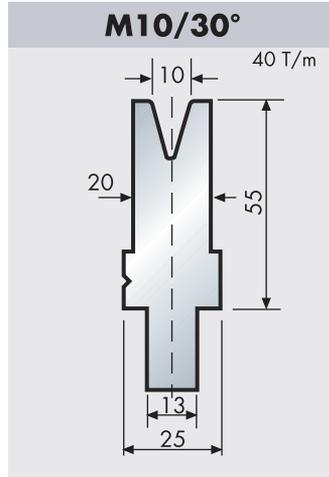
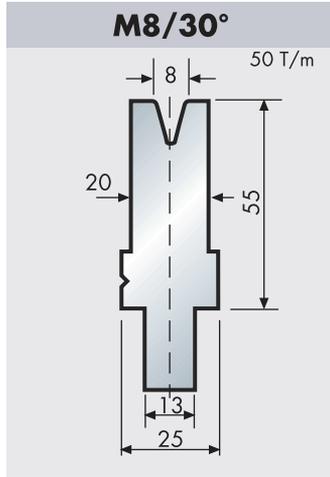
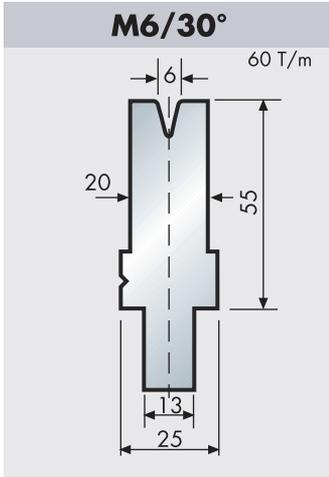
TYPE RF



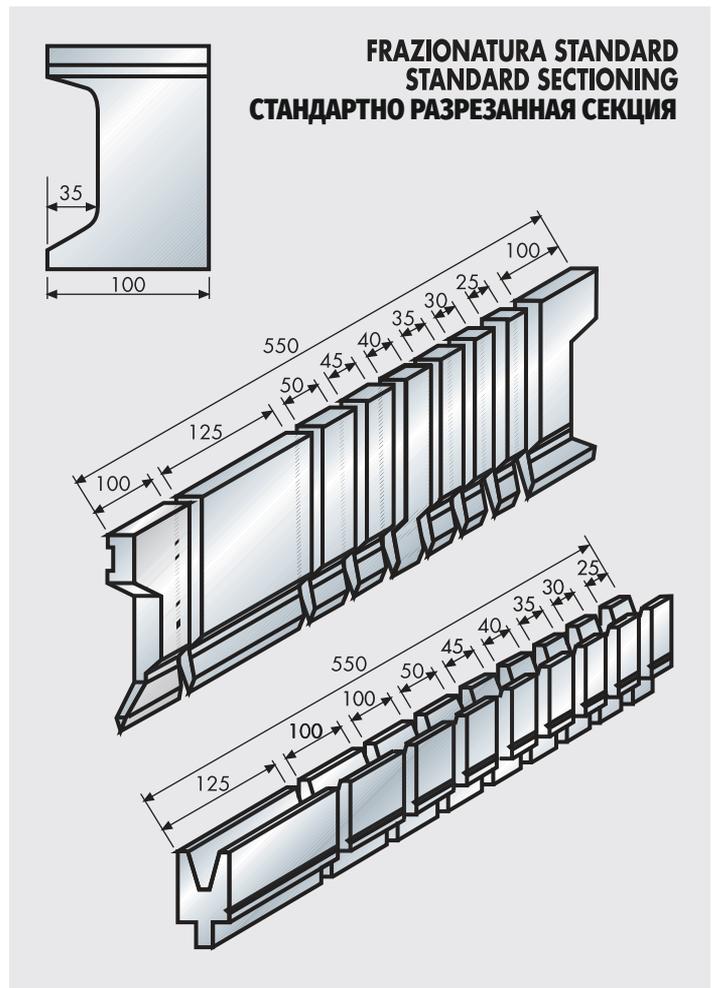
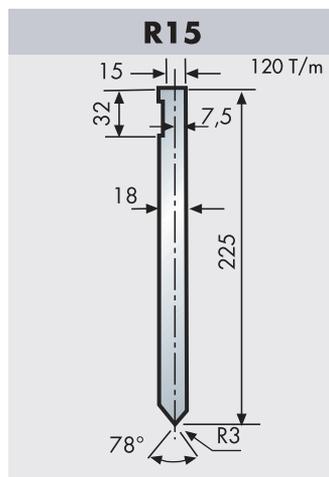
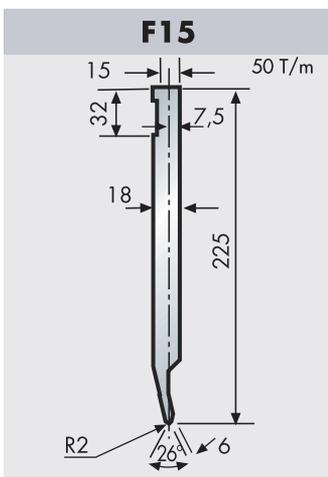
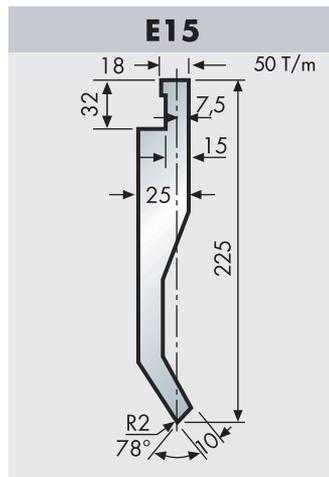
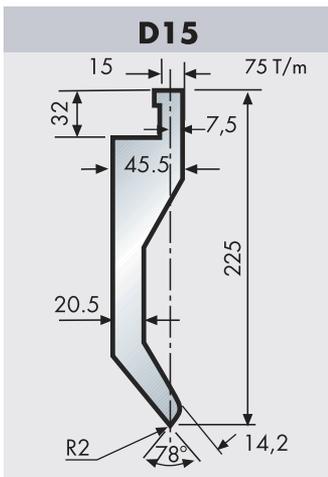
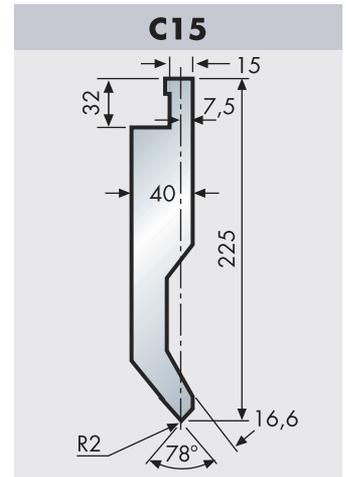
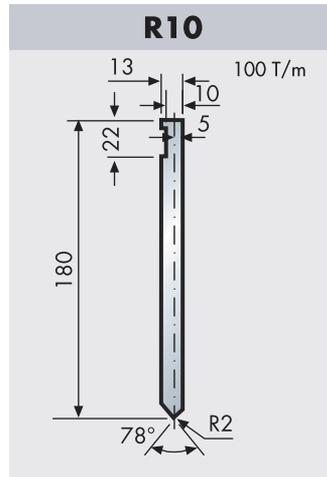
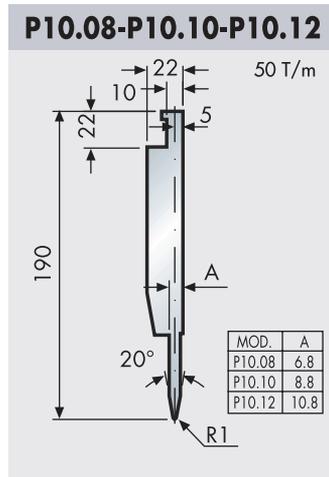
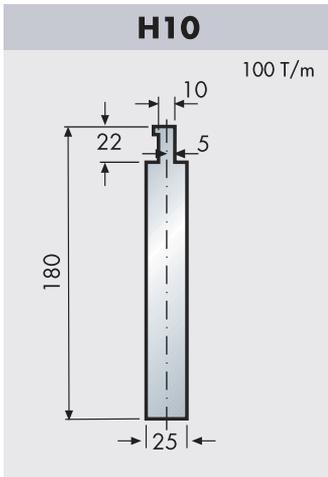
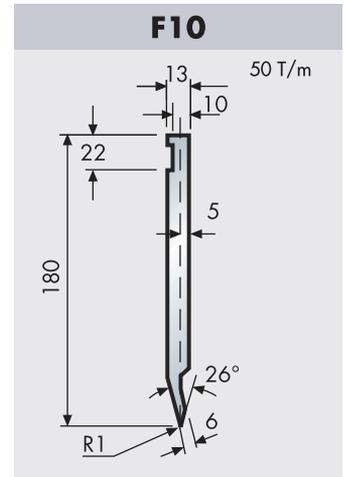
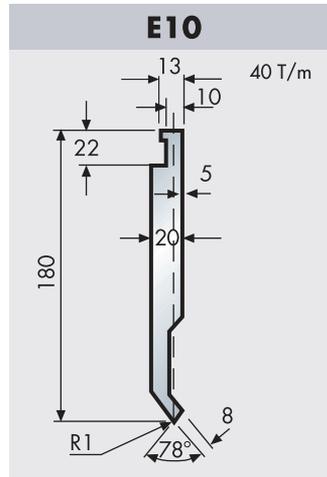
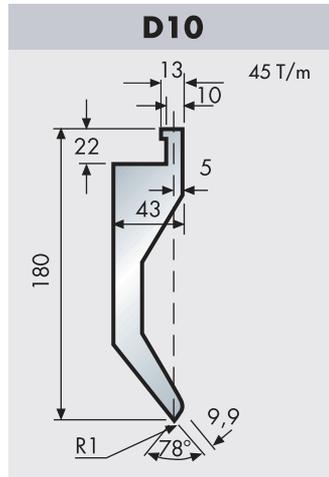
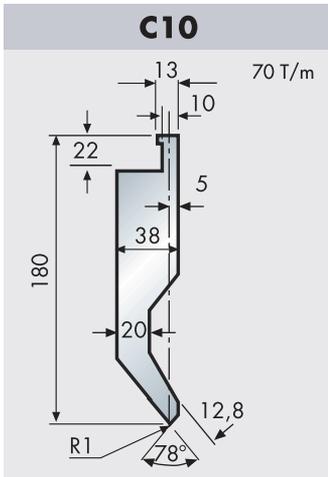
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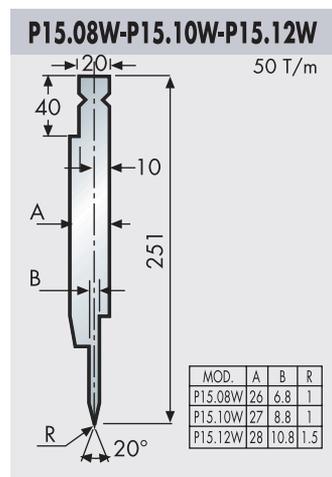
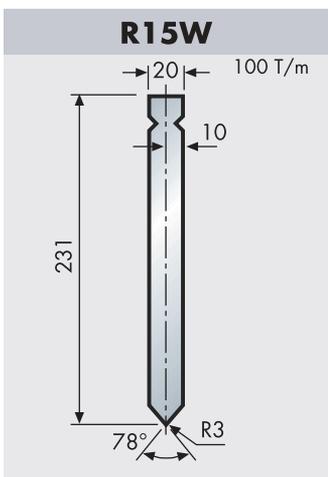
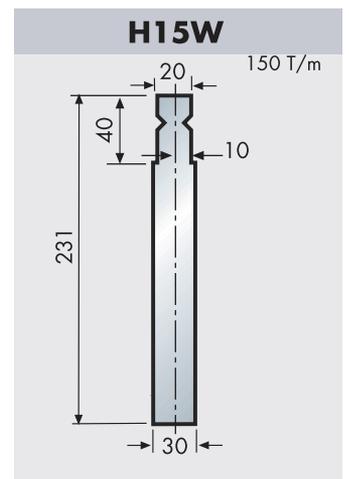
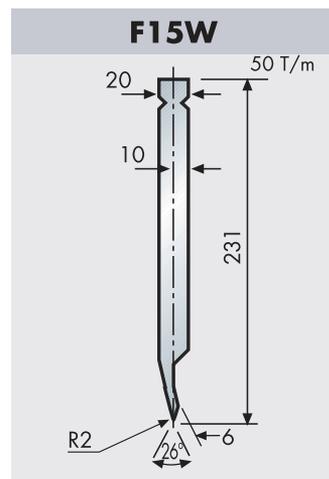
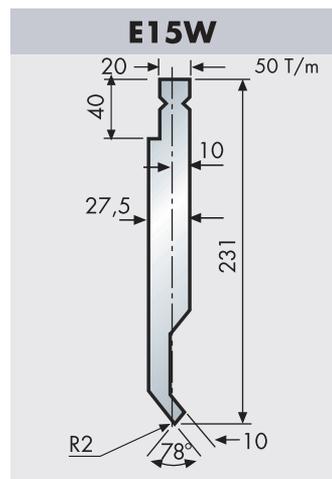
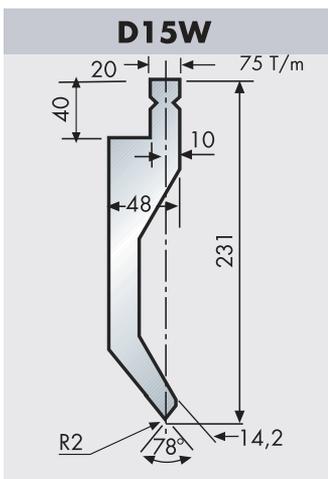
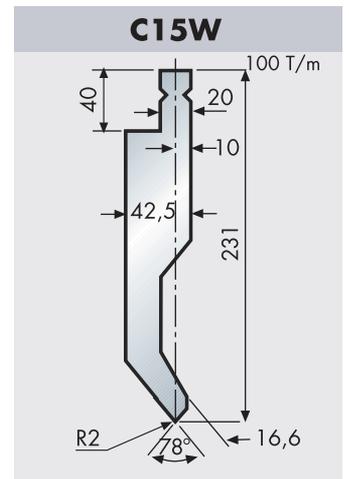
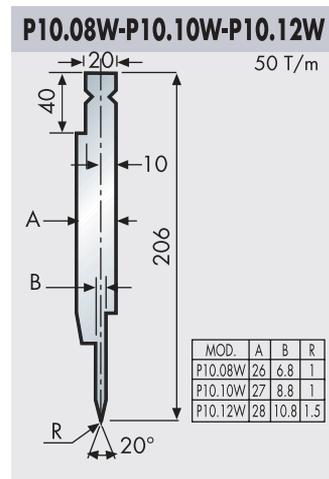
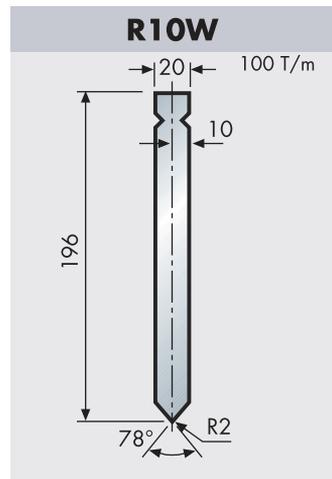
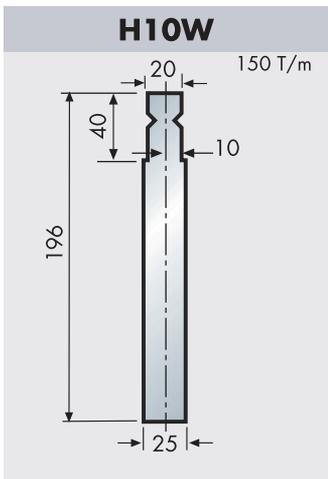
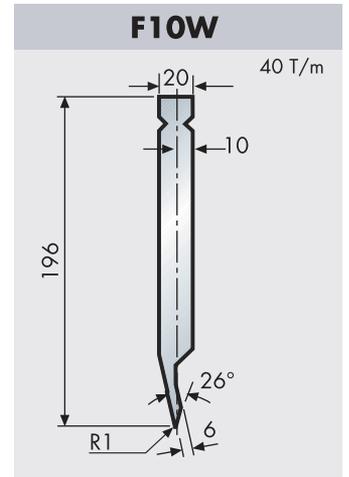
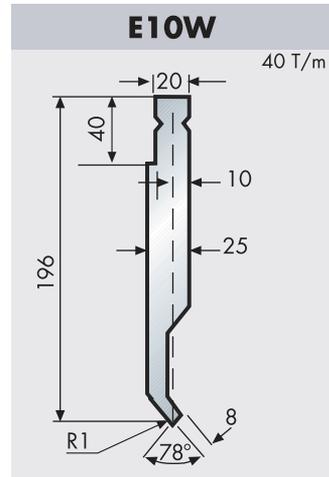
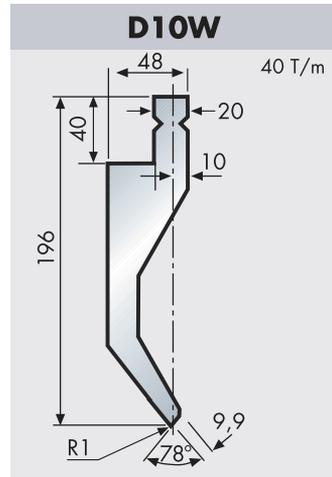
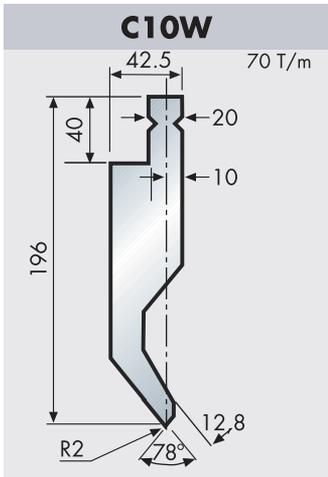


**FRAZIONATURA STANDARD
STANDARD SECTIONING
СТАНДАРТНО РАЗРЕЗАННАЯ СЕКЦИЯ**

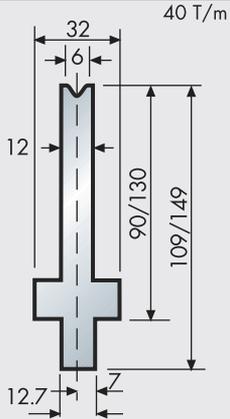


**FRAZIONATURA STANDARD
STANDARD SECTIONING
СТАНДАРТНО РАЗРЕЗАННАЯ СЕКЦИЯ**

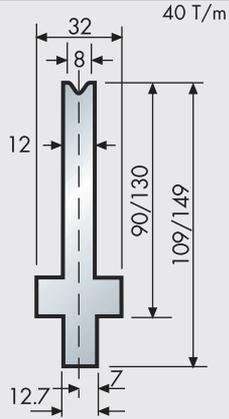




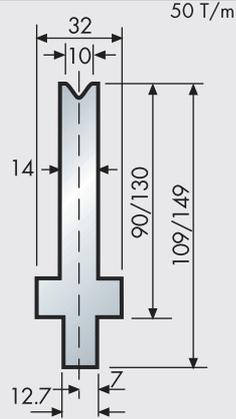
V6/78°



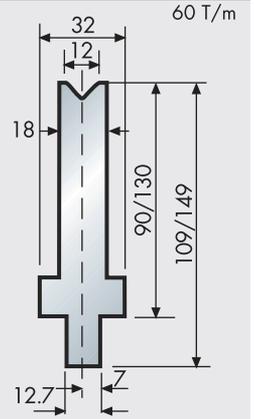
V8/78°



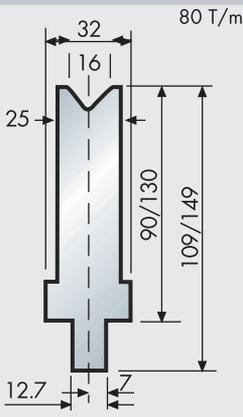
V10/78°



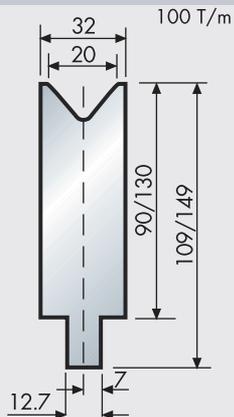
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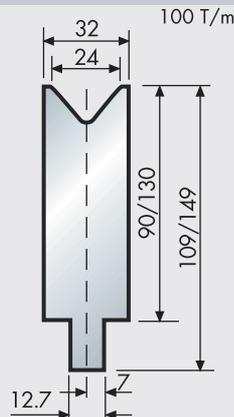
V16/78°



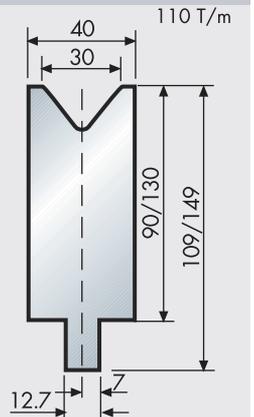
V20/78°



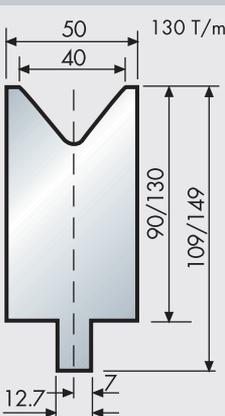
V24/78°



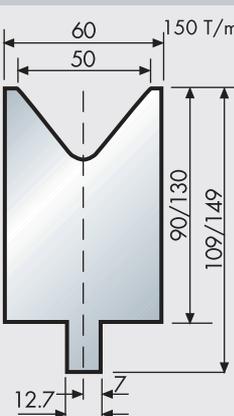
V30/78°



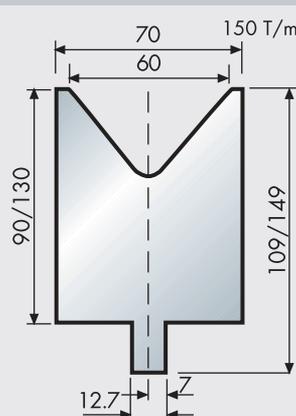
V40/78°



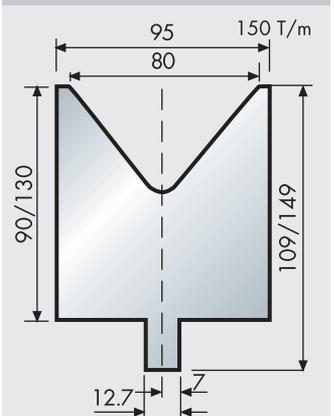
V50/78°

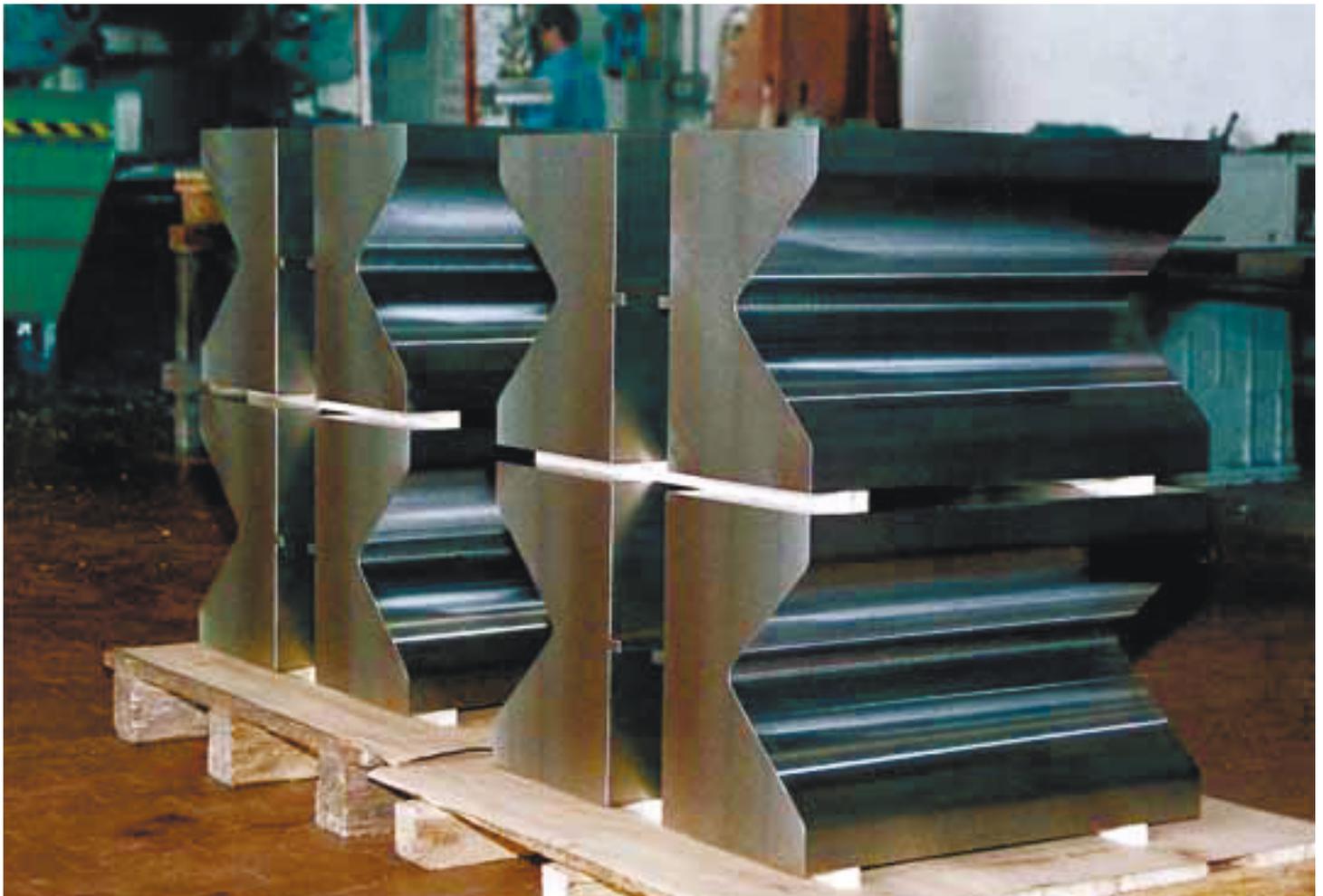
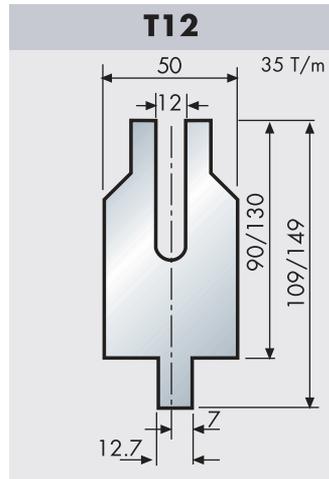
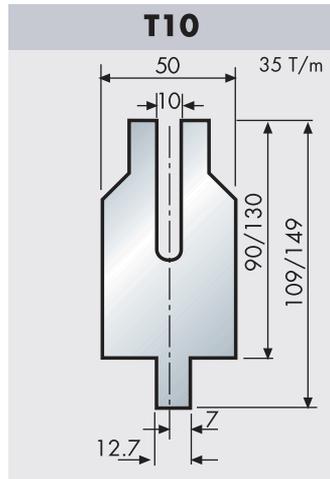
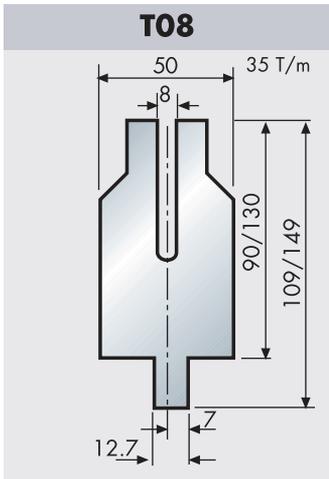
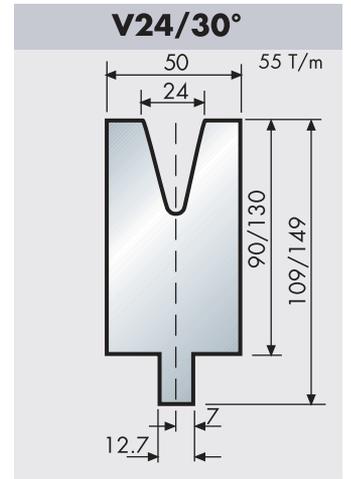
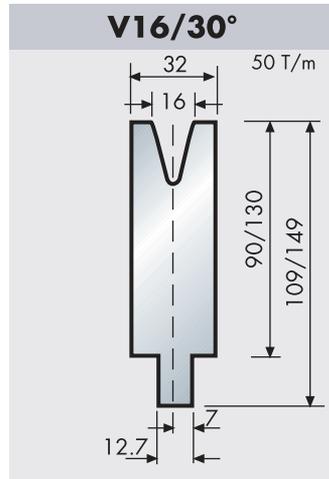
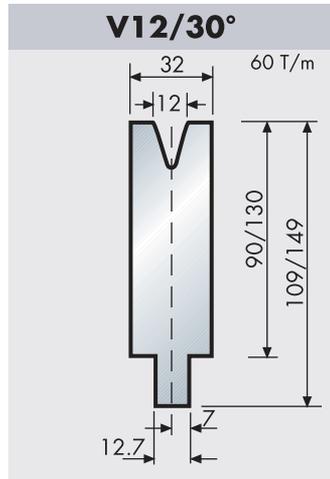
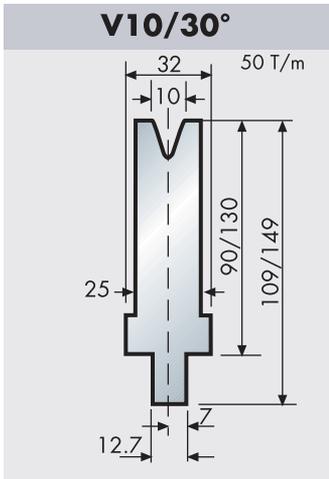


V60/78°

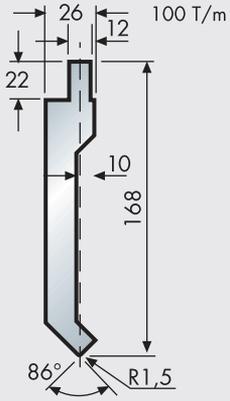


V80/78°

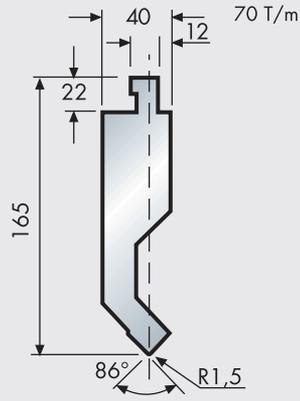




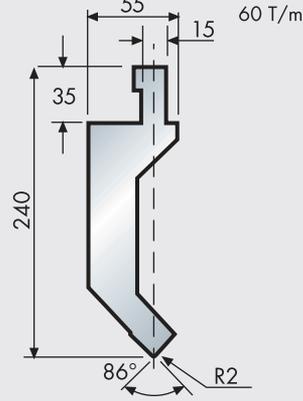
P60C



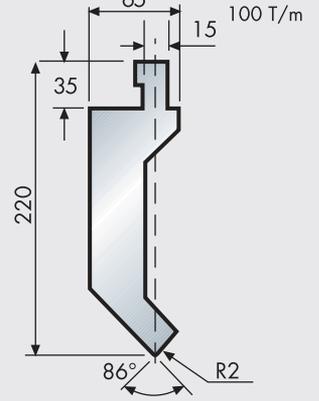
P110C



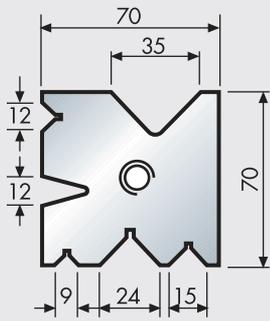
P200C



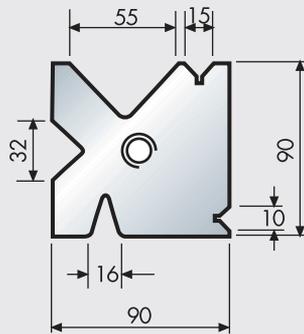
P400C



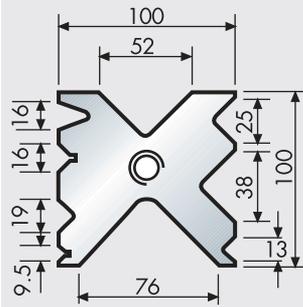
PV70



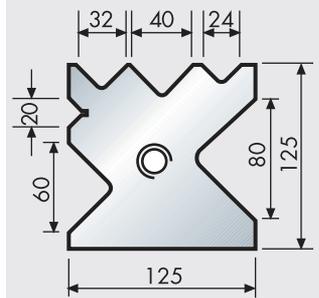
PV90



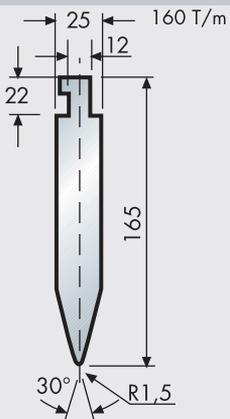
PV100



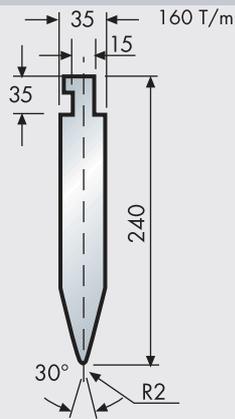
PV125



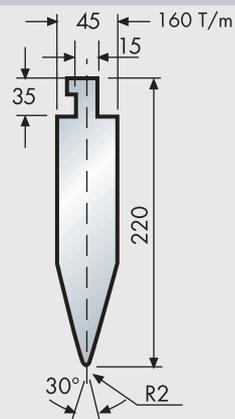
P110A

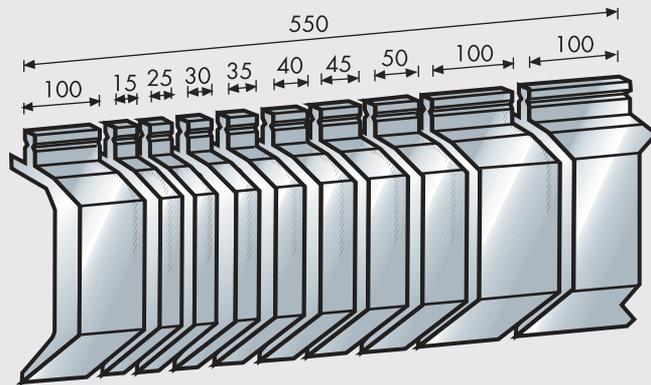
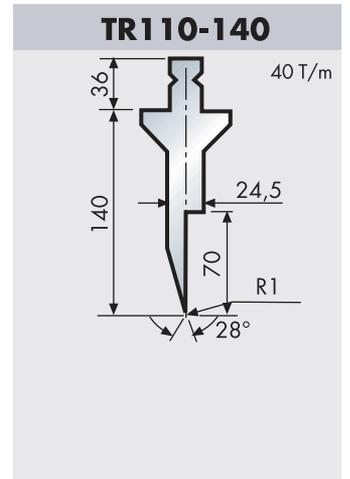
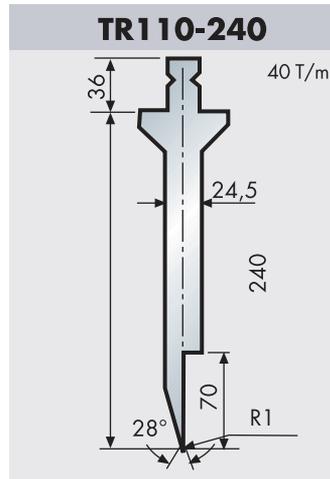
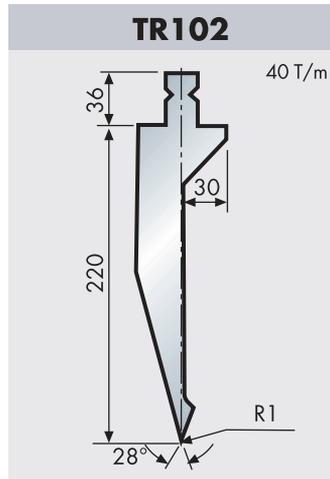
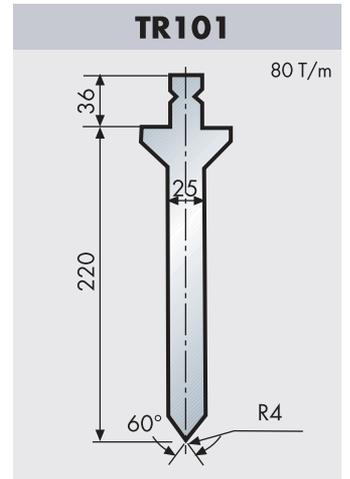
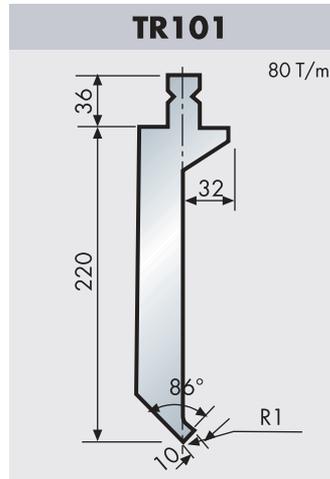
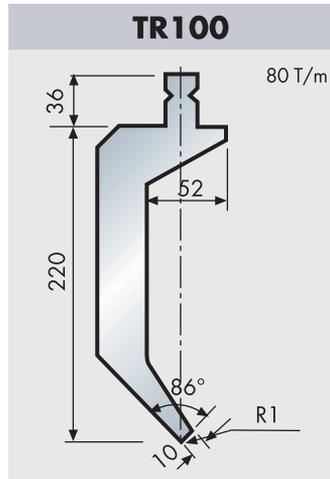


P200A

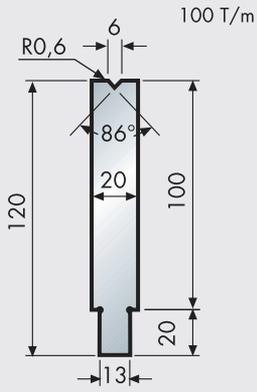
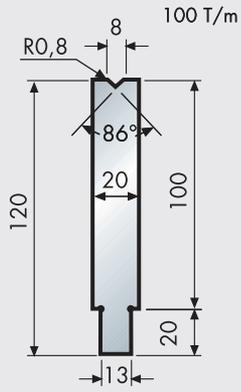
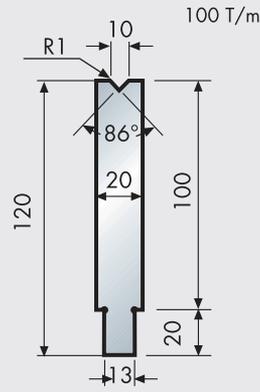
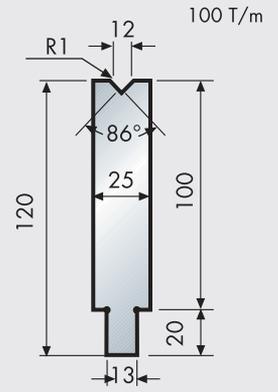
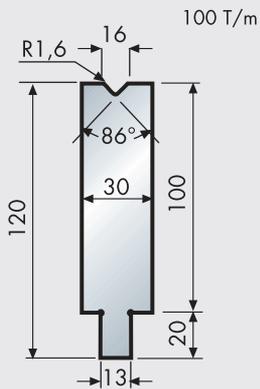
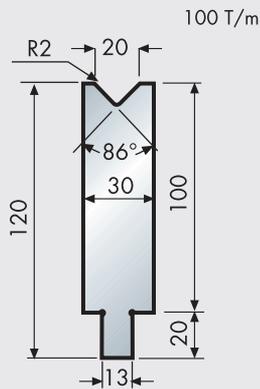
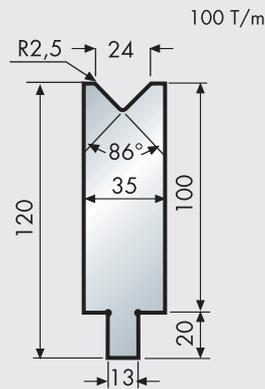
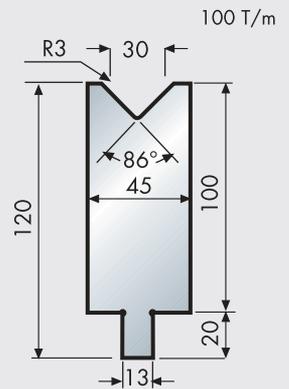
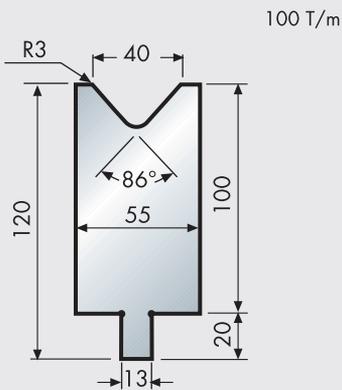
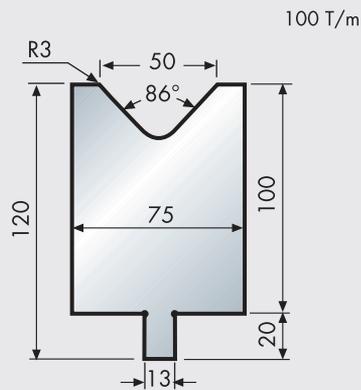
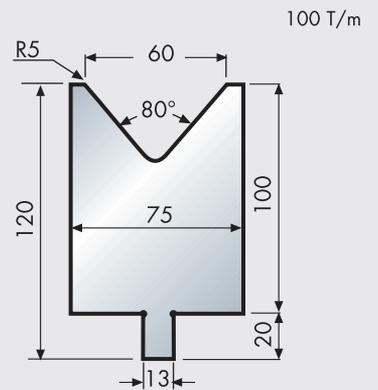
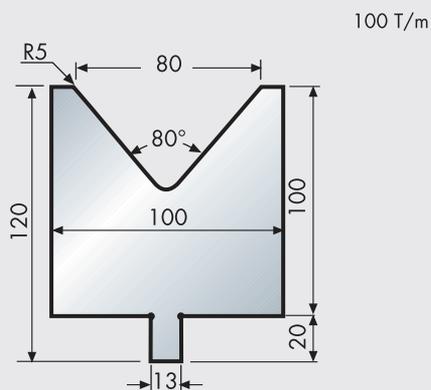
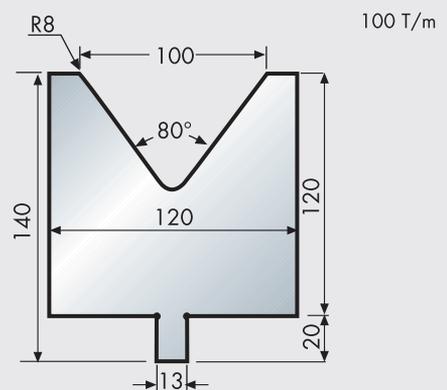


P400A

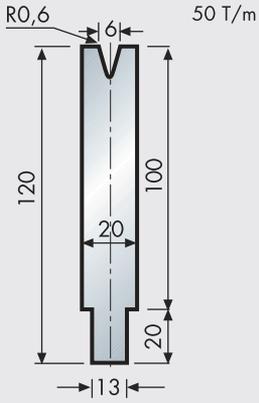




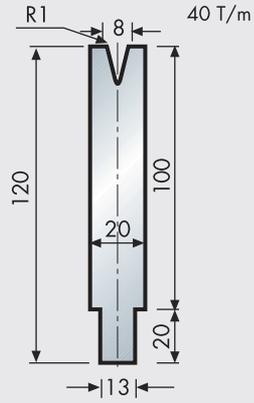
**FRAZIONATURA STANDARD
STANDARD SECTIONING
СТАНДАРТНО РАЗРЕЗАННАЯ СЕКЦИЯ**

TM 6/86°

TM 8/86°

TM 10/86°

TM 12/86°

TM 16/86°

TM 20/86°

TM 24/86°

TM 30/86°

TM 40/86°

TM 50/86°

TM 60/80°

TM 80/80°

TM 100/80°


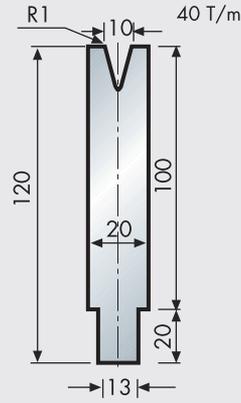
TM 6/30°



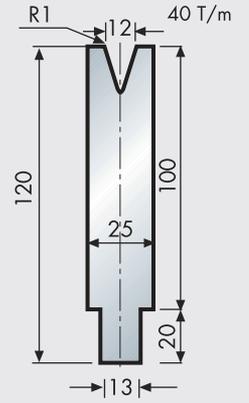
TM 8/30°



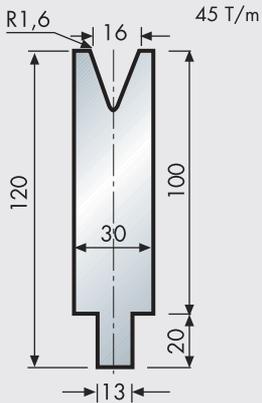
TM 10/30°



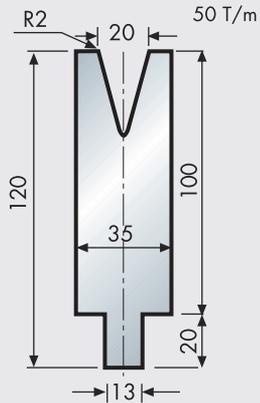
TM 12/30°



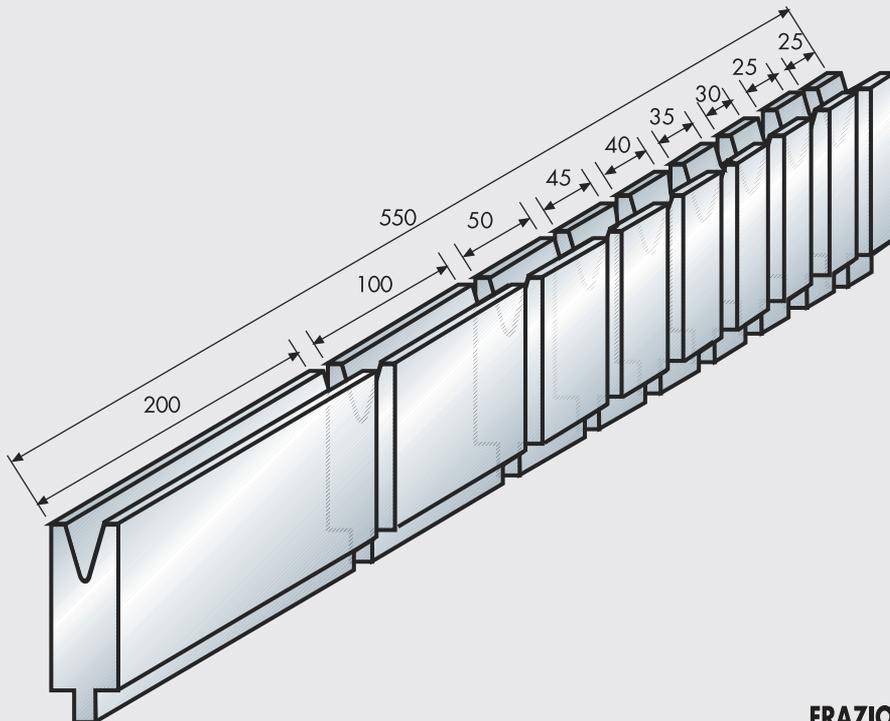
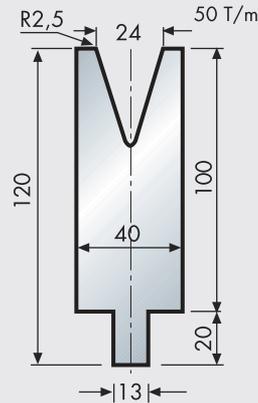
TM 16/30°



TM 20/30°



TM 24/30°



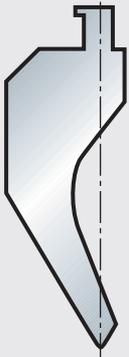
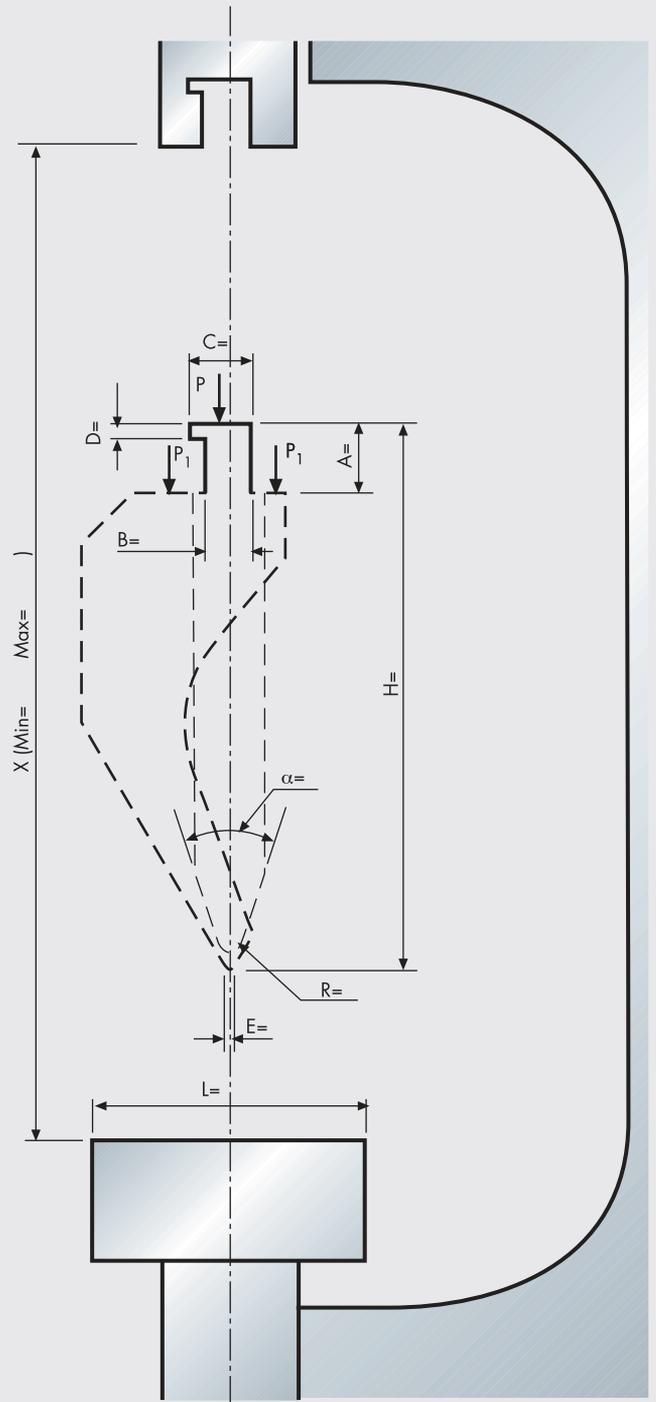
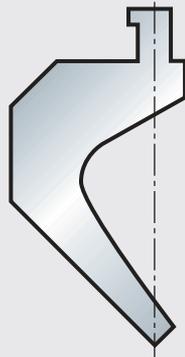
**FRAZIONATURA STANDARD
STANDARD SECTIONING
СТАНДАРТНО РАЗРЕЗАННАЯ СЕКЦИЯ**

10.01

10.03

10.04

10.05

10.06

10.08


Per ogni Vs. richiesta di Contro V speciali, vogliate indicare:

- altezza totale H;
- Misure all'attacco A-B-C-D;
- gradi della punta α° ;
- misura del piano in punta E, oppure del raggio R;
- se la pressa spinge in P o in P1;
- lunghezza.

For any enquiry on special top tools, please state:

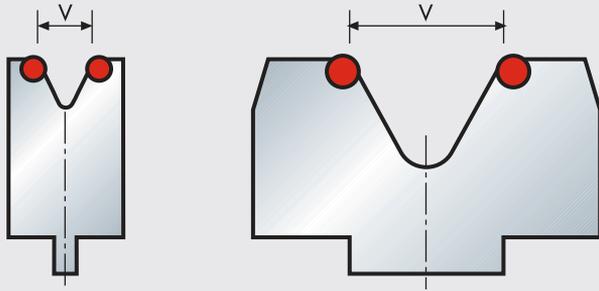
- total height H
- dimensions of tongue A-B-C-D
- degrees on the nose α°
- measure of flat on E or radius R
- whether the press-brake pushes on P or P1
- length

При заказе специнструмента укажите следующие параметры:

- общая высота
- размеры A-B-C-D
- угол кончика пуансона α°
- радиус кончика пуансона R или E
- Точка приложения усилия P или P1
- длина



20.51 MATRICE CON RULLINI / LOWER DIE WITH ROLLERS / МАТРИЦА С ОПОРНЫМИ РОЛИКАМИ

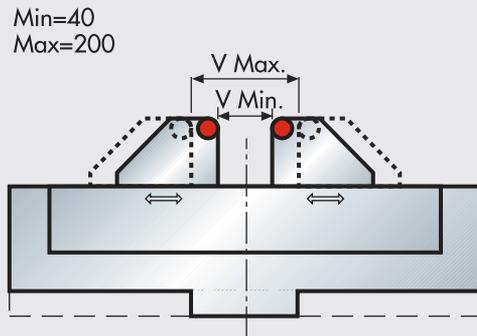
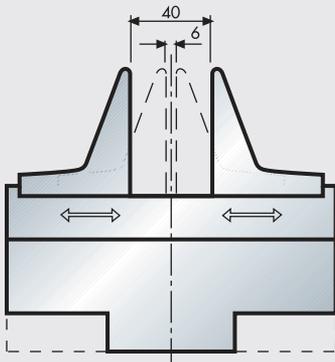


Le matrici con rulli temperati permettono di piegare lamiere delicate senza lasciare graffi causati dallo scorrimento della lamiera sui raggi della matrice; inoltre permettono alla pressa, a parità di spessore e tipo di materiale di piegare lamiere di grosso spessore utilizzando minore potenza.

This lower die with hardened rollers improves the flow of the sheet during the bending operation. It is available in two versions depending on the thickness and type of material being used.

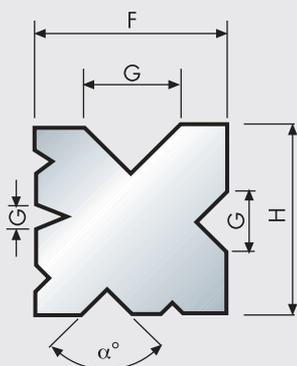
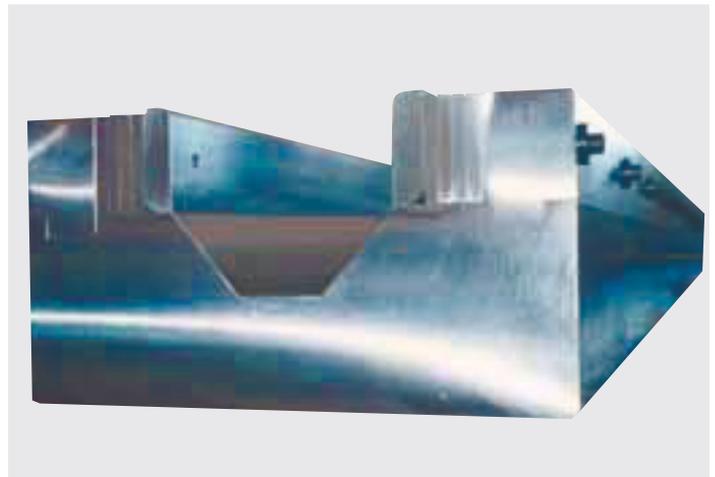
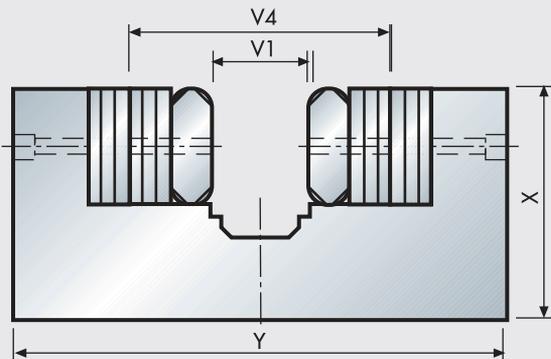
Данная матрица позволяет металлу свободно перемещаться по роликам в процессе гибки. Возможны два варианта исполнения в зависимости от толщины и типа обрабатываемого материала.

20.61 MATRICE CON V VARIABILE / LOWER DIE WITH VARIABLE OPENING / МАТРИЦА С ПЕРЕМЕННОЙ ШИРИНОЙ РУЧЬА



Min=40
Max=200

20.71 MATRICE CON V VARIABILE AD INSERTI / VARIABLE "V" OPENING WITH INSERTS / МАТРИЦА С РЕГУЛИРОВКОЙ ШИРИНЫ РУЧЬА ВСТАВКАМИ



Per ogni Vs. richiesta di matrici speciali, vogliate indicare:

- lunghezza;
- dimensioni F x H;
- numero e disposizione delle cave da eseguire;
- larghezza delle cave G;
- gradi delle cave α°

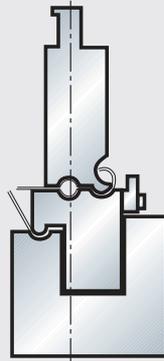
For any enquiry on special lower dies, please state:

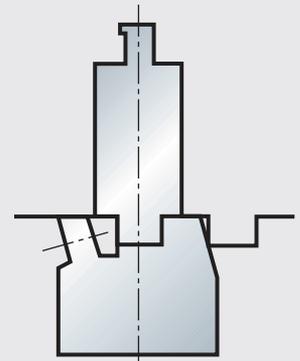
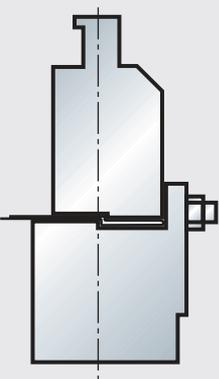
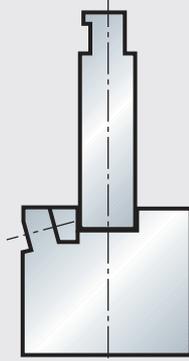
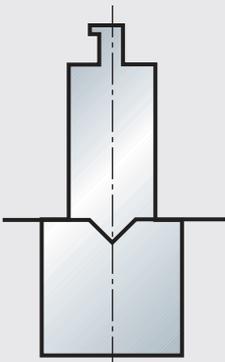
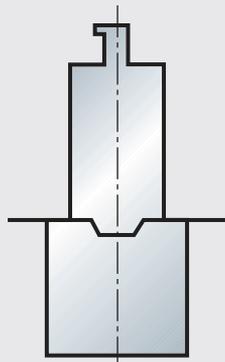
- length
- dimensions F x H
- number and position of grooves
- width of grooves G
- degrees on grooves α°

При заказе специнструмента укажите следующие параметры:

- длина
- размеры F x H
- количество и расположение ручьев
- ширина ручья G
- угол ручья α°

30.03

30.04

30.05

30.06

30.08

30.09

30.10

30.11


Per ogni Vs. richiesta di stampi speciali, vogliate indicare:

- disegno della lamiera piegata con lunghezza della piega ed eventuali tolleranze su dimensioni e gradi
- tipo di lamiera (inox, ferro, Alluminio, etc.) e spessore
- eventuale presenza di rivestimento plastico sulla lamiera
- tipo di pressa piegatrice (costruttore)
- pressione max. della pressa in tonnellate
- luce massima e corsa della pressa
- misure dell'attacco per punzone e matrice

For any enquiry on special tools, please indicate as follows:

- drawing of the sheet metal profile, with length of bend, tolerances on dimensions and degrees
- kind of sheet (stainless steel, iron, aluminium, etc.) and thickness
- possible plastic coating on the sheet
- kind of press brake (builder)
- maximum pressure of press-brake in tons
- maximum light and press brake stroke
- attachment measures for punch and die

При заказе специнструмента приложите следующие данные:

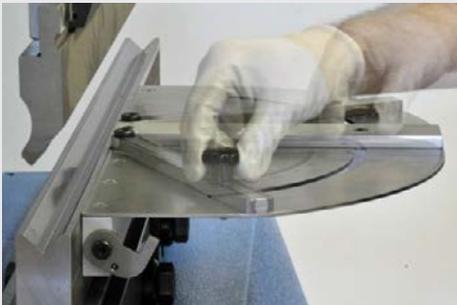
- чертеж / эскиз желаемого профиля с указанием длины по линии гибки, углов гибки и допусков на размеры
- тип материала листа (нержавеющая сталь, сталь, алюминий и т.д.) и его толщину
- покрытие листа, если такое имеется
- модель и производитель станка, на котором планируется обработка
- номинальное усилие листогибочного пресса
- открытая высота и ход ползуна (верхней траверсы)
- присоединительные размеры для пуансона и матрицы или тип крепления



Pellicola antigraffio
Die cover film
Пленка для гибки без следов (царапин)



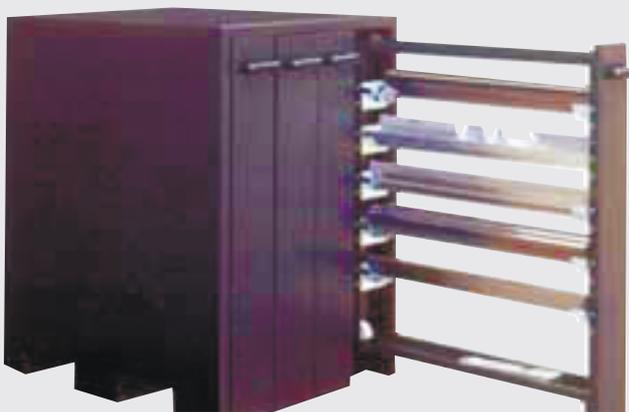
Coppia di tenditori
Pair of tighteners
Пара натяжителей пленки



Squadra di riferimento goniometrica
Square arm with goniometer
Кронштейн с транспортиром

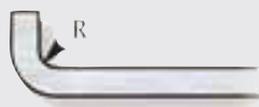


Squadra di riferimento fissa
Square arm
Кронштейн поддержки листа



Armadio porta utensili per: Amada, Beyeler,
LVD, Colly, EHT, Trumpf
Press brake tooling cabinet for: Amada, Beyeler,
LVD Colly EHT Trumpf
**Шкаф для хранения инструмента: Amada, Beyeler,
LVD, Colly, EHT, Trumpf**



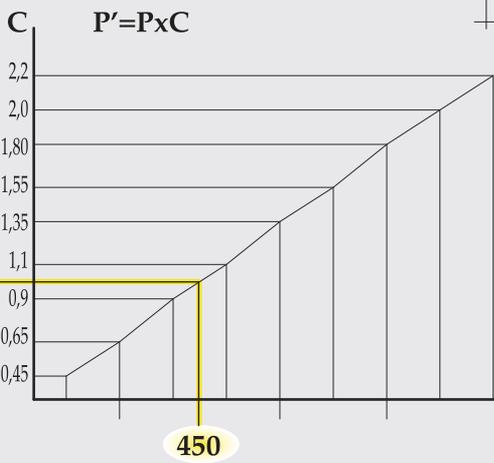


V	R	B																				
			0,5	0,8	1	1,2	1,5	2	2,5	3	4	5	6	8	10	12	15	20	25	30		
4	0,7	2,6	40	105																		
6	0,9	3,9	26	69	106	153																
8	1,5	5,2	20	55	80	115	180															
10	1,7	6,5		41	65	95	145	260														
12	2	7,8			55	80	120	215	335													
16	2,7	10,4				60	90	160	250	360												
20	3,4	13					75	130	200	290	520											
24	3,9	15,6						106	166	240	426	666										
30	5	20							140	190	340	540	770									
35	6	23								170	300	460	660									
40	7	26								150	260	400	580	1030								
50	8,5	32									210	320	460	820	1280							
55	9	36										300	420	750	1170							
60	10	39										270	390	690	1070							
70	11,7	45											330	590	920	1320						
80	13,5	52											290	520	800	1160	1800					
90	15	58												460	710	1030	1600					
100	17	65												410	640	930	1440					
120	20	78													540	770	1200					
140	24	91														660	1030	1830				
160	25	104															900	1598	2495			
200	31	130																719	1278	1997		
250	39	163																	1022	1598	2300	
300	47	195																		852	1331	1917

T = 420-480 N/mm² (C=1)

P (kN/m)

T = Resistenza della lamiera / Предел прочности
= Condizione ottimale / Оптимальные условия



Sheet metal tooling and machinery Technology and Solutions

OTTIMO tools



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лит. А, оф. 302



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