PLASMET®

CATALOGUE OF PRODUCTS
EDITION 25

KATALOG PRODUKTÓW
EDYCJA 25

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P. P. M. i U. PLASMET Sp. z o.o.
ul. M. Konopnickiej 25
37-700 Przemyśl

www.plasmet.net
biuro@plasmet.net

tel. + 48 16 678 45 29
fax + 48 16 678 45 20 wew. 40

PREZES
Krzysztof Kogut
k.kogut@plasmet.net
kom. + 48 607 332 996

DYREKTOR PRODUKCJI
Przemysław Strzępek
ps@plasmet.net
kom. + 48 665 360 542

DYREKTOR HANDLOWY
Jacek Lichota
j.lichota@plasmet.net
kom. + 48 537 277 737

TECHNOLOG
Bernadeta Strzępek
bs@plasmet.net
kom. + 48 530 861 069

Grzegorz Pezda
grzegorz@plasmet.net
kom. + 48 690 016 119

Przemysław Padło
p.padlo@plasmet.net
kom. +48 791 564 641

DZIAŁ MARKETINGU
Artur Kryński
a.krynski@plasmet.net
kom. + 48 693 299 112

Joanna Dobrucka
j.dobrucka@plasmet.net
kom. + 48 531 959 500

CONTENT | SPIS TREŚCI

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Our company is a family business with over 30 years of experience in producing tools for press brakes and guillotine knives.

We offer standard tools with Amada Promecam, Trumpf / Wila, and LVD holding systems. Punches and dies produced by us are compatible with many other edge presses such as Durma, Ermaksan, Baykal, EHT, Haco, LVD, Safan, and many others.

We also offer customized tool production services, including special punches and dies according to your design. Our team of experts is capable of assisting in the selection and design of tools, tailoring them to the end product. We manufacture tools from improved, hardened materials up to 4100 mm in length. All of our tools are hardened and ground to ensure the highest quality and durability.

In addition to bending tools, we also offer guillotine shear knives made in Poland (NG, NGH), Czech (NTE, CNTA), and others, allowing for cutting of sheets with a maximum thickness of 3 mm to 25 mm. We also manufacture knives to order according to customer drawings.

Since 2013, we have also been offering laser-hardened tools and the renovation of tools used in conjunction with laser re-hardening.

Our company is known for the quality of our products and excellent customer service.

We invite you to contact us.

Nasza firma to rodzinny biznes z ponad 30-letnim doświadczeniem w produkcji narzędzi do pras krawędziowych oraz noży do gilotyn.

Oferujemy standardowe narzędzia z mocowaniem Amada Promecam, Trumpf / Wila oraz LVD. Produkowane przez nas matryce i stemple są kompatybilne z wieloma innymi prasami krawędziowymi, takimi jak Durma, Ermaksan, Baykal, EHT, Haco, LVD, Safan i wiele innych.

Oferujemy także narzędzia na indywidualne zamówienie, w tym stemple oraz matryce specjalne według Państwa projektu. Nasz zespół ekspertów jest w stanie pomóc przy doborze i projektowaniu narzędzi, dopasowując je do produktu końcowego. Wykonujemy narzędzia z materiałów ulepszonych, zahartowanych o długości do 4100 mm. Wszystkie nasze narzędzia są hartowane i szlifowane, aby zapewnić najwyższą jakość i trwałość.

Poza narzędziami do gięcia blach, oferujemy także noże do nożyc gilotynowych produkcji polskiej (NG, NGH), czeskiej (NTE, CNTA) i innych, które umożliwiają cięcie blach o grubości maksymalnej od 3 mm do 25 mm. Wykonujemy także noże na zamówienie według rysunku klienta.

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

Nasza firma jest znana z jakości swoich produktów i doskonałej obsługi klienta.

Zapraszamy do kontaktu z nami.

NEW IN THIS EDITON OF THE CATALOG | NOWOŚCI W TEJ EDYCJI KATALOGU

Dear Customers,

We are pleased to present the 25th edition of our catalogue. In this version, you will find several new items that we would like to highlight:

– On page 24, we have included new TYPE "A" stamps – models S 2042 and S 2043, which allow for the creation of more complex shapes. Thanks to the undercut in the body, they enable bending not only simple details to a sharp angle, but also a greater number of angle irons than, for example, the S 2021 stamp.
– On page 29, you will find the inter-system adapter type "T/A" 80, which has returned to our offer!
– Pages 79-82 are dedicated to presses and tools from the Finnish manufacturer ALIKO, with whom we continue our cooperation.
– On page 14, we present our tool regeneration service. We restore their full functionality, improve their precision, and also strengthen them through hardening.

Additionally, we would like to draw your attention to tools and accessories for trace-free sheet metal bending:

– Flexi Bend Dies – a new addition to our offer, found on pages 71-78.
– Protective Tapes – on page 89.

To make it easier for you to make your selection, we have included die foot diagrams next to the relevant stamps. All available types of die feet are gathered on page 12.

We hope our offerings will be helpful and enable even more efficient work. We are grateful for all the trust placed in us, and we invite you to explore the full range of products in the new catalogue.

The Plasmet Team

Szanowni Klienci,

Z radością prezentujemy Państwu 25. edycję naszego katalogu. W tej wersji znajdą Państwo kilka nowości, na które chcielibyśmy zwrócić szczególną uwagę:

– Na stronie 24 zamieściliśmy nowe stemple TYPU „A", modele S 2042 i S 2043, które pozwalają wykonywać bardziej skomplikowane kształty. Dzięki podebraniu w korpusie pozwolą giąć nie tylko proste detale na kąt ostry, ale również większą liczbę ceowników niż np. stempel S 2021.
– Na stronie 29 znajdą Państwo adapter międzysystemowy typu „T/A" 80, który powrócił do naszej oferty!
– Strony 79-82 poświęcone są prasom i narzędziom fińskiego producenta – ALIKO, z którym kontynuujemy współpracę.
– Na stronie 14 przedstawiamy usługę regeneracji narzędzi. Przywracamy im pełną funkcjonalność, poprawiamy ich precyzję, a także wzmacniamy je poprzez hartowanie.

Dodatkowo, warto zwrócić uwagę na narzędzia i akcesoria umożliwiające bezśladowe gięcie blach:

– Matryce Flexi Bend – nowość w naszej ofercie – umieściliśmy na stronach 71-78.
– Taśmy ochronne – na stronie 89 .

Aby ułatwić Państwu wybór, do katalogu dodaliśmy schematy stóp stempli, które znajdują się obok odpowiednich stempli. Wszystkie dostępne typy stóp zostały zebrane na stronie 12.

Mamy nadzieję, że nasze propozycje będą pomocne i pozwolą na jeszcze efektywniejszą pracę. Dziękujemy za zaufanie i zapraszamy do zapoznania się z pełną ofertą w nowym katalogu.

Zespół Plasmet

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

Material

C45, 40HM, 42CrMo4 and 1.2312

Working edge hardened

55 ±2 HRc

Standard lengths

415 mm, 835 mm, 835 mm segmented

Materiał

C45, 40HM, 42CrMo4 oraz 1.2312

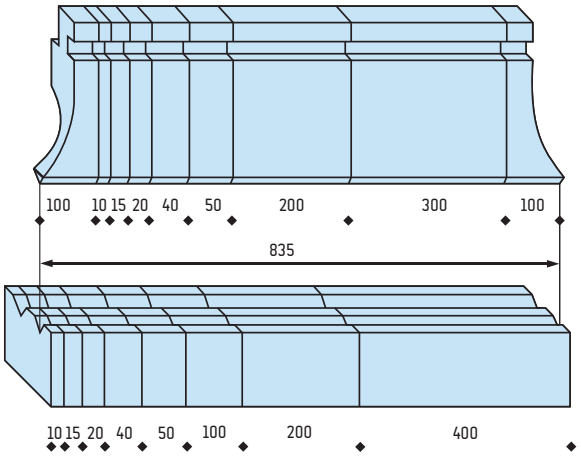
Część robocza hartowana

55 ±2 HRc

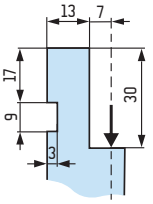
Długość standardowa

415 mm, 835 mm, 835 mm segmentowa

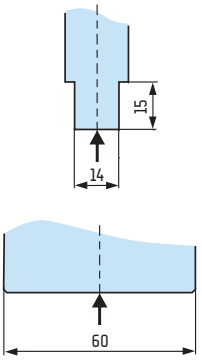
Sectionalized tool TYPE "A".
Schemat narzędzia segmentowego TYPU „A".



Punch mounting edge.
Uchwyt stempla.



Die mounting edge.
Uchwyt matrycy.



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

Material

C45, 42CrMo4 or 1.2312

Thermal enhancement to*

30 ±2 HRc (950 – 1100 MPa)

Working edge hardened

55 ±2 HRc (1500 – 1600 MPa)

Length

100, 200, 300, 500, 550 mm segmented

** applies to 1.2312*

Materiał

C45, 40HM lub 1.2312

Ulepszenie cieplne*

30 ±2 HRc (950 – 1100 MPa)

Część robocza hartowana

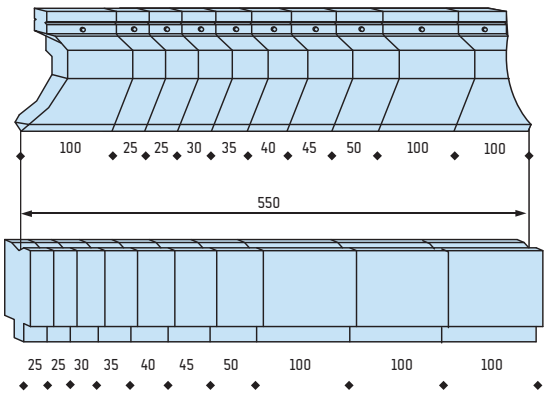
55 ±2 HRc (1500 – 1600 MPa)

Długość

100, 200, 300, 500, 550 mm segmentowa

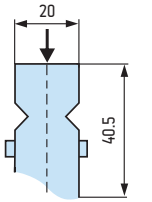
** dotyczy 1.2312*

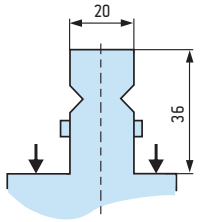
Sectionalized tool TYPE "T".
Schemat narzędzia segmentowego TYPU „T".



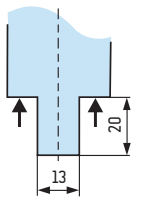
Vec size "T" measured between radiuses.
Szerokość matrycy „T" mierzona od początk promieni.

Punch mounting edge.
Uchwyt stempla.





Die mounting edge.
Uchwyt matryc.



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

Material

42CrMo4 or 1.2312

Thermal enhancement to*

30 ±2 HRc (950 – 1100 MPa)

Working edge hardened

55 ±2 HRc (1500 – 1600 MPa)

Length

515 mm, 550 mm segmented

** applies to 1.2312*

Materiał

40HM lub 1.2312

Ulepszenie cieplne*

30 ±2 HRc (950 – 1100 MPa)

Część robocza hartowana

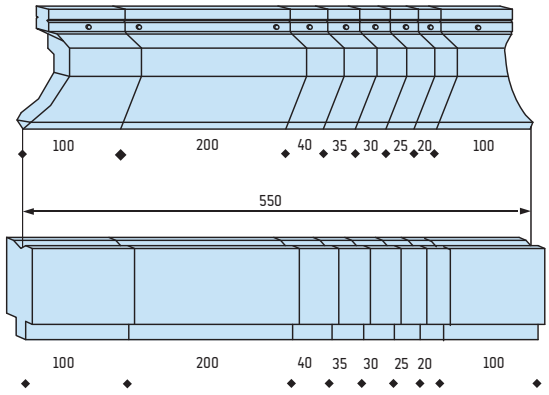
55 ±2 HRc (1500 – 1600 MPa)

Długość

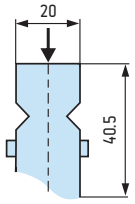
515 mm, 550 mm segmentowa

** dotyczy 1.2312*

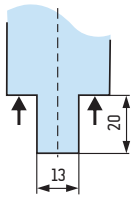
Sectionalized tool TYPE "W".
Schemat narzędzia segmentowego TYPU „W".



Punch mounting edge.
Uchwyt stempla.



Die mounting edge.
Uchwyt matryc.



standard tools TYPE "B" | narzędzia standardowe TYPU „B"

Material

42CrMo4 or 1.2312

Thermal enhancement to*

30 ±2 HRc (950 – 1100 MPa)

Working edge hardened

55 ±2 HRc (1500 – 1600 MPa)

Length

515 and 550 mm segmented

** applies to 1.2312*

Materiał

40HM lub 1.2312

Ulepszenie cieplne*

30 ±2 HRc (950 – 1100 MPa)

Część robocza hartowana

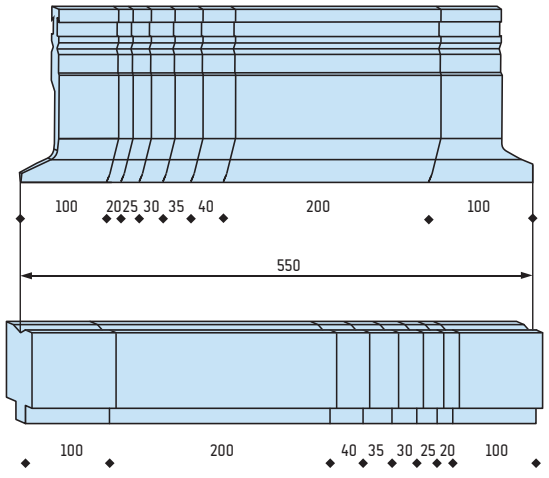
55 ±2 HRc (1500 – 1600 MPa)

Długość

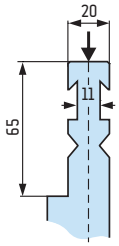
515 i 550 mm segmentowa

** dotyczy 1.2312*

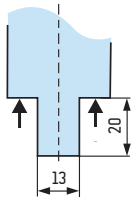
Sectionalized tool TYPE "B".
Schemat narzędzia segmentowego TYPU „B".



Punch mounting edge.
Uchwyt stempla.



Die mounting edge.
Uchwyt matrycy.



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

Material

42CrMo4 or 1.2312

Thermal enhancement to*

30 ±2 HRc (950 – 1100 MPa)

Working edge hardened

55 ±2 HRc (1500 – 1600 MPa)

Length

508 mm, 550 mm segmented

** applies to 1.2312*

Materiał

40HM lub 1.2312

Ulepszenie cieplne*

30 ±2 HRc (950 – 1100 MPa)

Część robocza hartowana

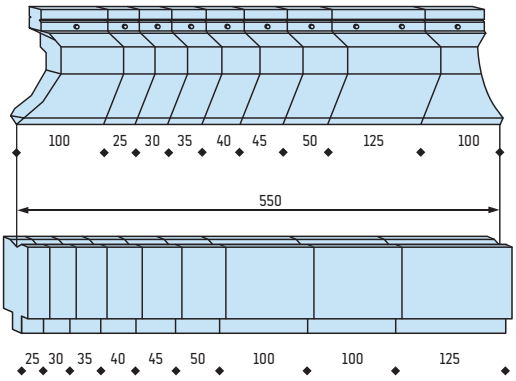
55 ±2 HRc (1500 – 1600 MPa)

Długość

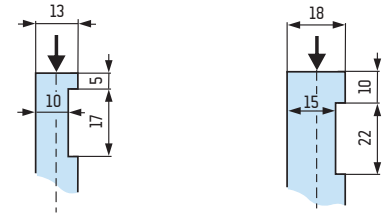
508 mm, 550 mm segmentowa

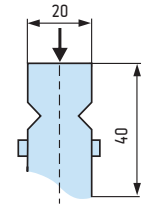
** dotyczy 1.2312*

Sectionalized tool TYPE "L".
Schemat narzędzia segmentowego TYPU „L".

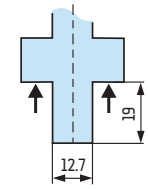


Punches TYPE "L" have three different clampings.
Stemple TYPU „L" występują z trzema typami mocowań.



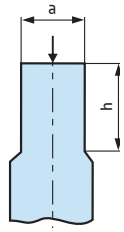


Die mounting edge.
Uchwyt matrycy.

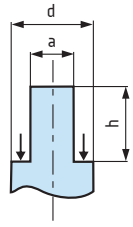


punch mounting edge | rodzaje uchwytów stempli

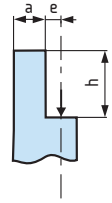
A



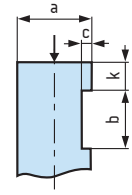
B



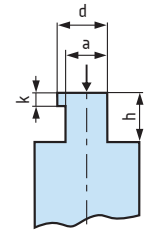
C



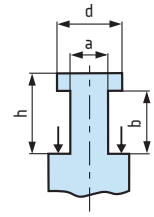
D



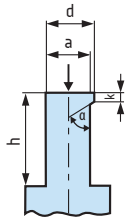
E



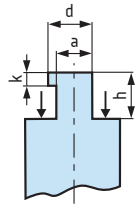
F



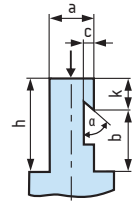
G



H



I

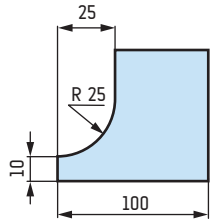


We offer punches with mounting edges as shown.
The client can order a type from the drawing specifying his dimensions.
The client may order a mounting edge to his own design.
Maximal strength of tools is valid only for air bending.

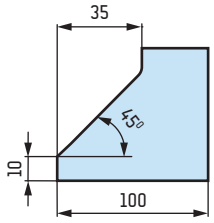
W ofercie znajdują się stemple z uchwytem standardowym oraz z innymi typami uchwytów.
Klient ma możliwość zamówienia narzędzi z uchwytem z przedstawionego zestawu po określeniu symbolu literowego (np: „E") oraz zaznaczonych wymiarów.
Można również zamówić narzędzie z uchwytem własnego projektu.
Wszystkie podane w katalogu maksymalne dopuszczalne naciski dotyczą gięcia swobodnego.

horns for TYPE ”A“ punches | **stopy stempli TYPU „A”**

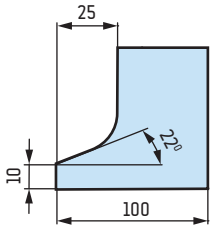
AH1



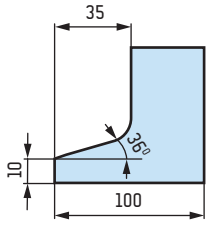
AH2



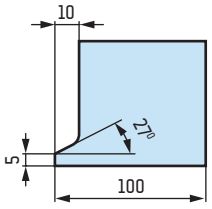
AH3



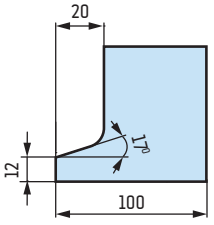
AH4



AH5

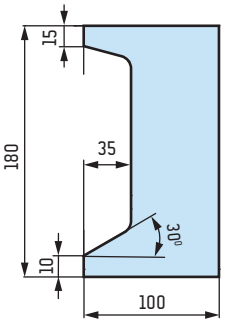


AH6

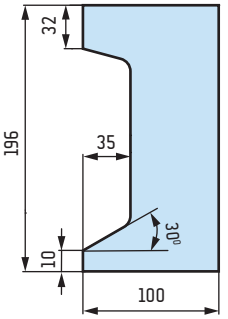


horns for TYPE “L” punches | **stopy stempli TYPU „L”**

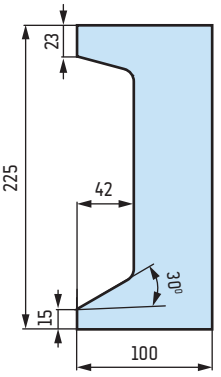
LH1



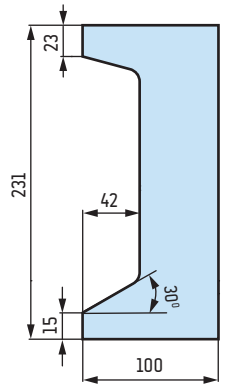
LH2



LH3

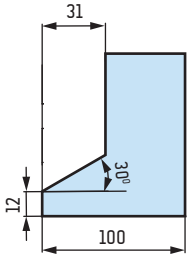


LH4



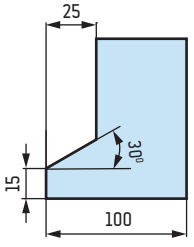
horns for TYPE ”T“ punches
stopy stempli TYPU „T”

TH



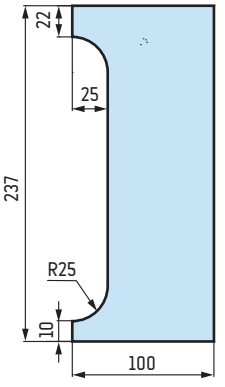
horns for TYPE ”B“ punches
stopy stempli TYPU „B”

BH



horns for TYPE ”W“ punches
stopy stempli TYPU „W”

WH



tool ordering code | sposób zamawiania

Punches i.e S 2010/88/R0.8/835
S 2010/88/R0.8/835 – *Catalogue number*
S 2010/**88**/R0.8/835 – *Angle α = 30°, 35°, 60°, 75°, 80°, 88°, 90°*
S 2010/88/**R0.8**/835 – *Working edge type – thus "F" or "R" and size*
S 2010/88/R0.8/**835** – *Length of tool – thus 835 mm, 415 mm, 835 mm sectionalized*

Dies i.e M 6112/35/835
M 6112/35/835 – *Catalogue number*
M 6112/**35**/835 – *Angle α = 30°, 35°, 60°, 85°, 88°, 90°*
M 6112/35/**835** – *Length of tool – thus 835 mm, 415 mm, 835 mm sectionalized*

Stemple np. S 2010/88/R0.8/835
S 2010/88/R0.8/835 – *Numer katalogowy stempla*
S 2010/**88**/R0.8/835 – *Kąt α = 30°, 35°, 60°, 75°, 80°, 88°, 90°*
S 2010/88/**R0.8**/835 – *Część robocza stempla („F" lub „R" oraz wielkość)*
S 2010/88/R0.8/**835** – *Długość elementu 835 mm, 415 mm, 835 mm segmentowy*

Matryce np. M 6112/35/835
M 6112/35/835 – *Numer katalogowy matrycy*
M 6112/**35**/835 – *Kąt α = 30°, 35°, 60°, 85°, 88°, 90°*
M 6112/35/**835** – *Rodzaj elementu 835 mm, 415 mm, 835 mm segmentowy*

special tools | narzędzia specjalne

Material
C45, 42CrMo4 or 1.2312
Thermal enhancement to*
30 ± 2HRc (950 – 1100 MPa)
Working edge hardened
55 ± 2HRc (1500 – 1600 MPa)
Length
up to 5000 mm
** applies to 1.2312*

Materiał
C45, 40HM lub 1.2312
Ulepszenie cieplne*
30 ± 2HRc (950 – 1100 MPa)
Część robocza hartowana
55 ± 2HRc (1500 – 1600 MPa)
Długość
do 5000 mm
** dotyczy 1.2312*

additional information | oznaczenia symboli

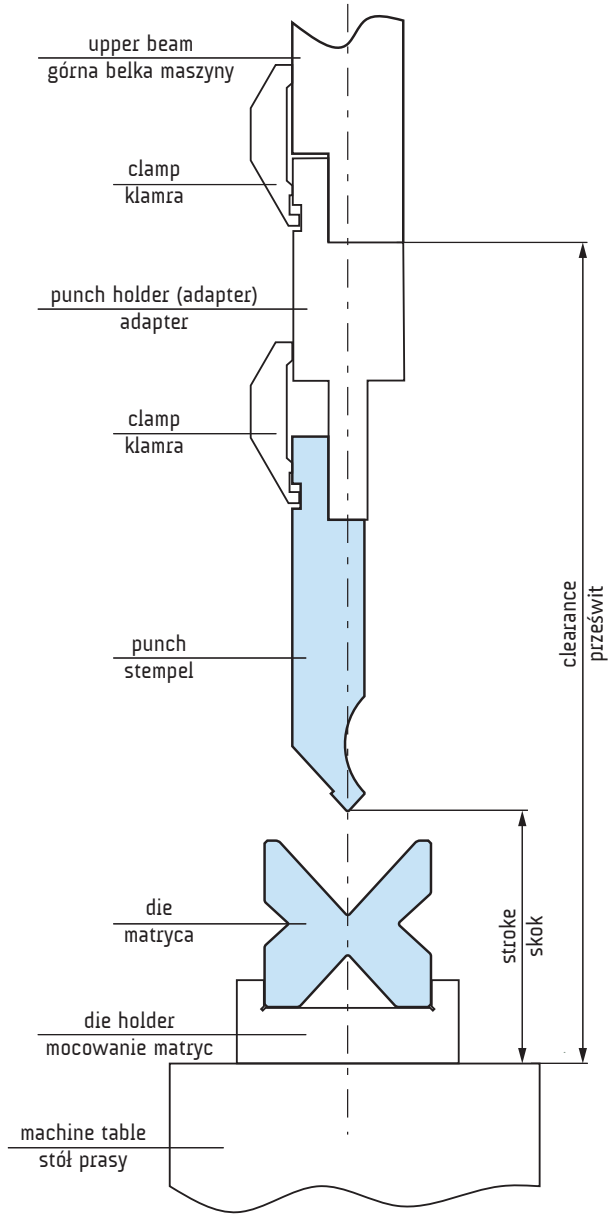
in stock / dostępne z magazynu

fast delivery possible / możliwość szybkiej dostawy

on order / na zamówienie

42CrMo4 *42CrMo4 or 1.2312 steel as standard / narzędzie wykonane ze stali 42CrMo4 lub 1.2312*

Operator's side view.
Widok od strony operatora.



Exemplary cross-section of a press brake, including holding elements and important machine parameters.

Przykładowy przekrój poprzeczny prasy krawędziowej z uwzględnieniem elementów mocujących oraz istotnych parametrów maszyny.

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

Wszystkie narzędzia standardowe Plasmet przeznaczone są do gięcia swobodnego.

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

tool refurbishment | **regeneracja narzędzi**

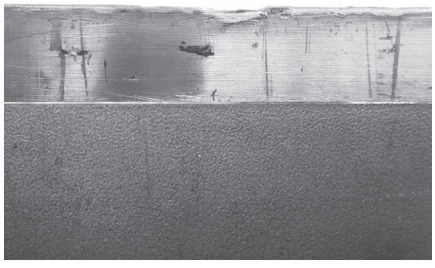
Plasmet specializes in the comprehensive regeneration of press brake tools and sharpening of guillotine blades. With a modern machinery park and a team of experts with extensive experience, we ensure that tools for all types of presses regain full functionality and long-lasting performance.

Tool regeneration includes:
– Grinding of working surfaces – a process that restores a shape close to the original, ensuring efficient operation.
– Standardizing the height of tools in the provided set – guarantees maximum precision and reliability during use.
– Removal of residues and marks.
– If the tool material allows, we apply laser hardening – a process that increases durability and resistance to wear.

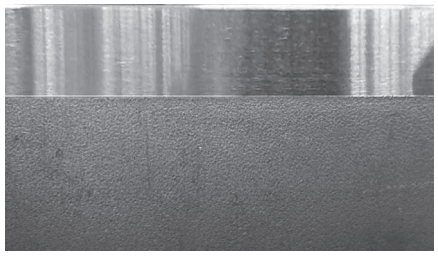
Plasmet specjalizuje się w kompleksowej regeneracji narzędzi do pras krawędziowych oraz ostrzeniu noży do gilotyn. Dzięki nowoczesnemu parkowi maszynowemu i zespołowi doświadczonych ekspertów, zapewniamy narzędziom każdego typu prasy pełną sprawność oraz długotrwałe działanie.

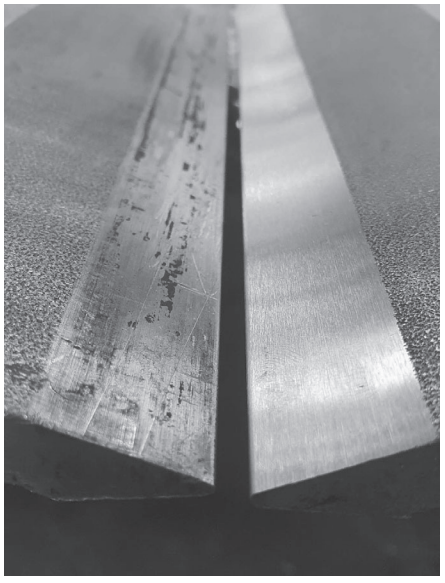
Regeneracja narzędzi obejmuje:
– Szlifowanie powierzchni roboczych narzędzia – proces, który przywraca zarys zbliżony do pierwotnego zapewniając efektywną pracę.
– Ujednolicenie wysokości narzędzi regenerowanych w dostarczonym zestawie – gwarantuje maks. precyzję i niezawodność podczas użytkowania.
– Pozbycie się nagarów i odcisków.
– Jeśli materiał narzędzi na to pozwala, stosujemy hartowanie laserowe, które zwiększa ich trwałość i odporność na zużycie.

Before refurbishmnet / Przed regeneracją

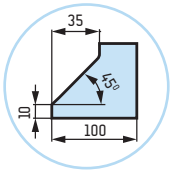


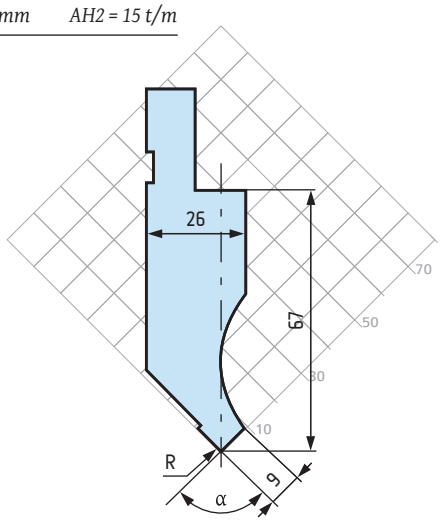
After refurbishment / Po regeneracji



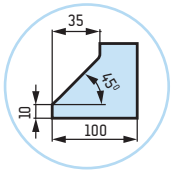


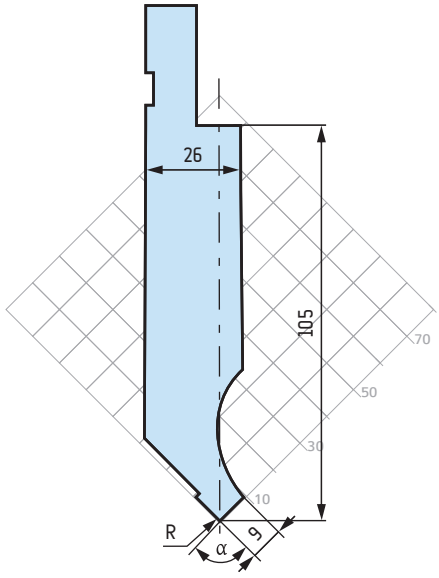
S 2010	100 t/m
α = 75°, R = 0.8 mm, H = 67.6 mm	AH2 = 25 t/m
α = 85°, R = 0.8 mm, H = 66.6 mm	AH2 = 25 t/m
α = 88°, R = 0.2 mm, H = 66.9 mm	AH2 = 18 t/m
α = 88°, R = 0.8 mm, H = 66.6 mm	AH2 = 25 t/m
α = 88°, R =1.5 mm, H = 65.9 mm	AH2 = 25 t/m
α = 88°, R =3 mm, H = 65.25 mm	AH2 = 25 t/m
α = 90°, R = 0.2 mm, H = 66.9 mm	AH2 = 15 t/m
α = 90°, R = 0.8 mm, H = 66.6 mm	AH2 = 15 t/m



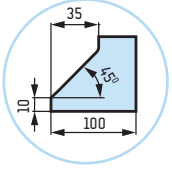


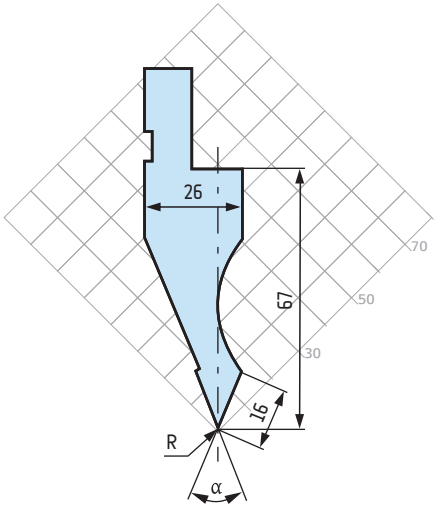
S 2010/105	100 t/m
α = 75°, 85°, 88°	
R = 0.8 mm	AH2 = 25 t/m



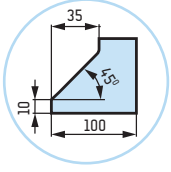


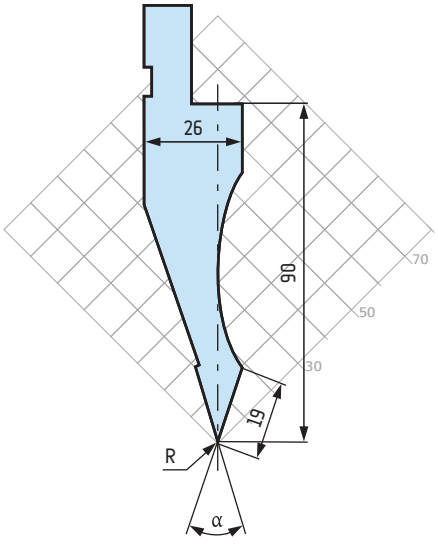
S 2011	80 t/m
α = 45°	
R = 0.4 mm, 0.8 mm	AH2 = 20 t/m
R = 1.5 mm	AH2 = 25 t/m





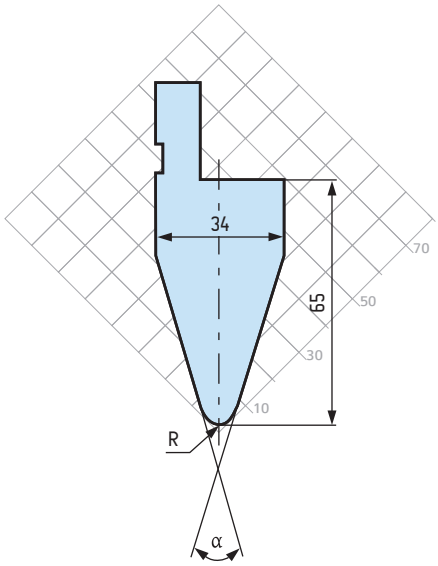
S 2012	70 t/m
α = 30°, 35°	
R = 1 mm	AH2 = 20 t/m

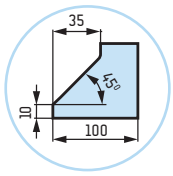




24h

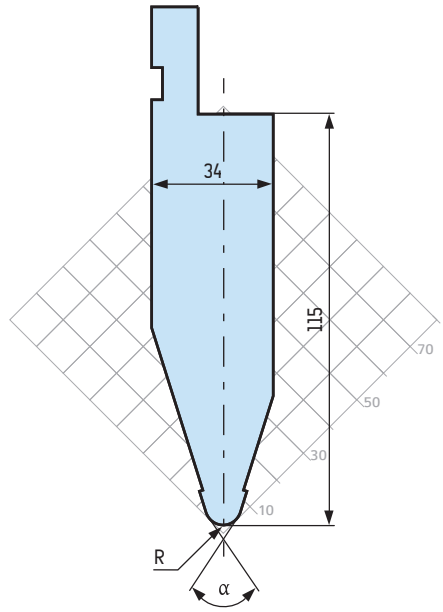
S 2013	100 t/m
$\alpha = 35^0$, R = 5 mm	AH2 = 65 t/m
$\alpha = 60^0$, R = 6 mm	AH2 = 65 t/m
$\alpha = 80^0$, R = 6 mm	AH2 = 65 t/m

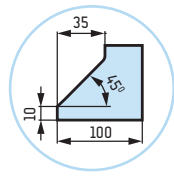




24h

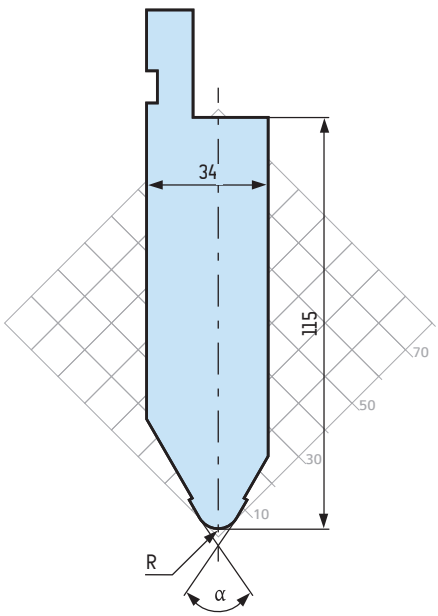
S 2013/115	100 t/m
$\alpha = 35^0$, R = 5 mm	AH2 = 65 t/m

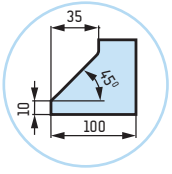




24h

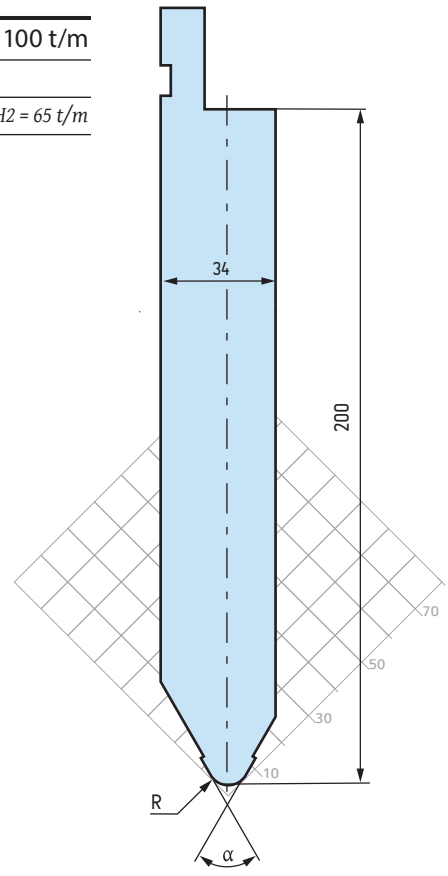
S 2013/115	100 t/m
$\alpha = 60^0$	
R = 6 mm, 10 mm	AH2 = 65 t/m

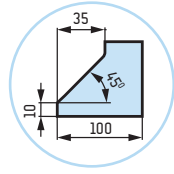




24h

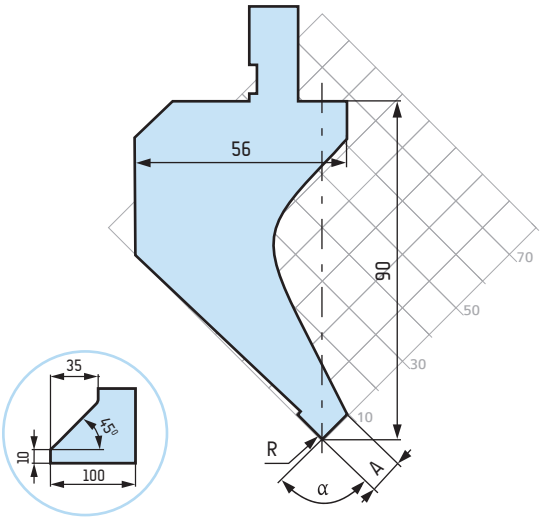
S2013/200	100 t/m
$\alpha = 60^0$	
R = 6 mm	AH2 = 65 t/m





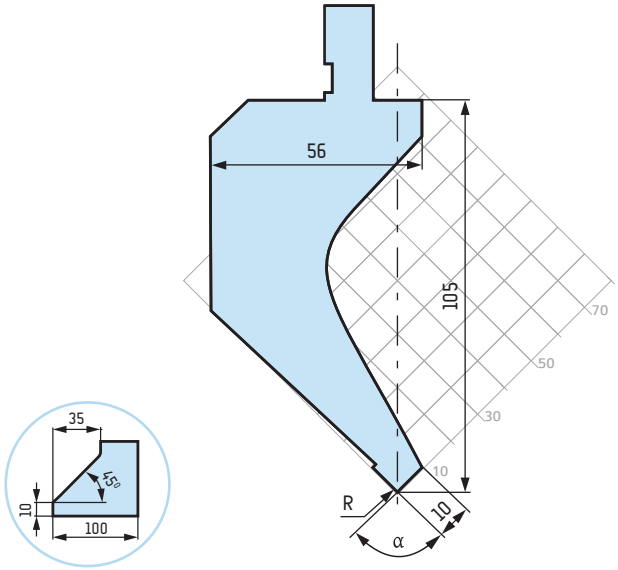
24h

S 2014	60 t/m
*α = 75⁰, A = 9 mm, R = 0 8 mm *20 t/m*	*AH2 = 7 t/m*
α = 85⁰, A = 9 mm, R = 0 8 mm	*AH2 = 15 t/m*
*α = 88⁰, A = 6 mm, R = 0.2 mm, 0.8 mm *50 t/m*	*AH2 = 15 t/m*
α = 88⁰, A = 9 mm , R = 0.2 mm, 0.8 mm	*AH2 = 15 t/m*



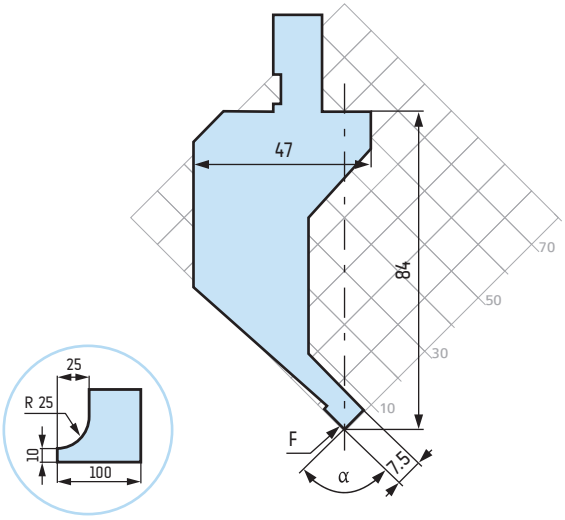
24h

S 2015	50 t/m
α = 85⁰, R = 0.8 mm	*AH2 = 12 t/m*
α = 88⁰, R = 0.2 mm, 0.8 mm	*AH2 = 12 t/m*
α = 90⁰, R = 0.8 mm	*AH2 = 12 t/m*



24h

S 2016	15 t/m
α = 88⁰, 90⁰	
F = 0.6 mm	*AH1 = 6 t/m*

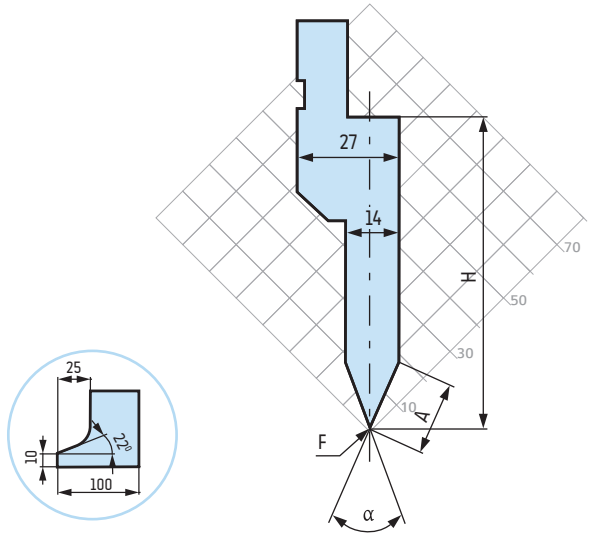


24h

S 2017/26	100 t/m
H = 117 mm, A = 27 mm	
α = 26⁰,	
R = 0.8 mm	*AH3 = 17 t/m*

24h

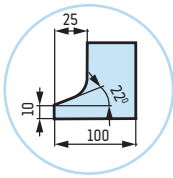
S 2017/35	100 t/m
H = 85 mm, A = 21 mm	
α = 35⁰	
F = 0.8 mm	*AH3 = 12 t/m*

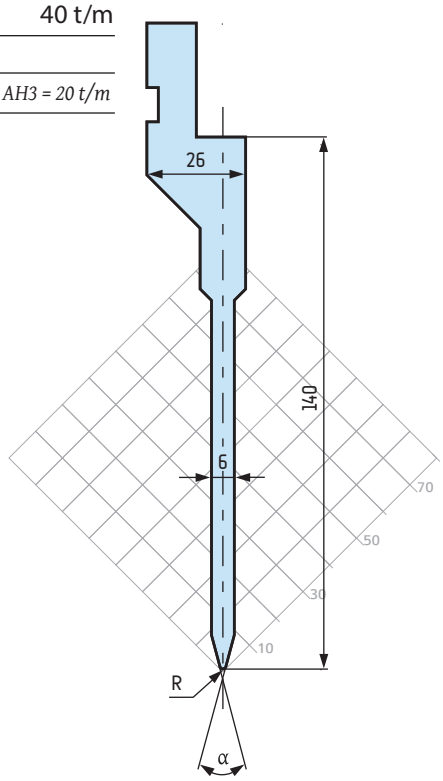


42CrMo4

S 2017/30 — 40 t/m

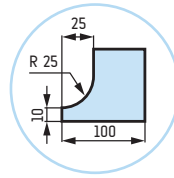
$\alpha = 30^0$	
$R = 0.8$ mm	$AH3 = 20$ t/m

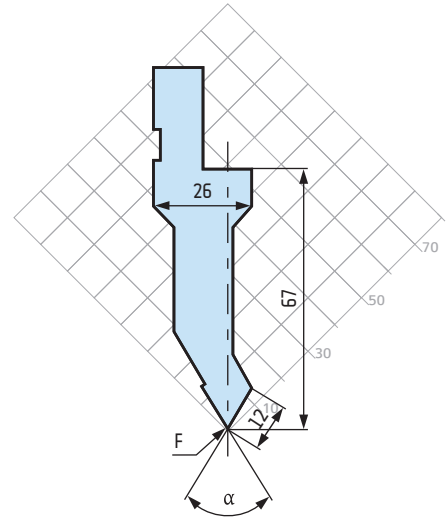




S 2018 — 60 t/m

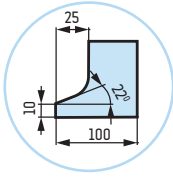
$\alpha = 60^0$	
$F = 0.8$ mm	$AH1 = 15$ t/m

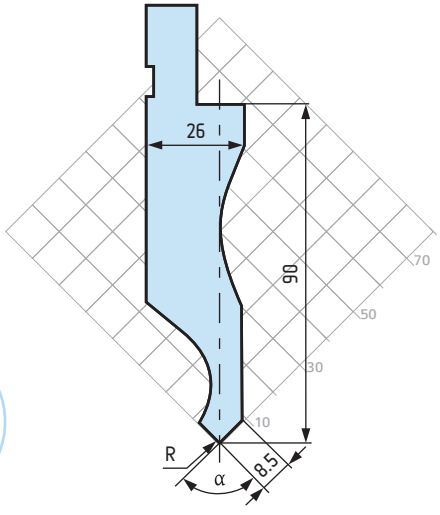




S 2019 — 70 t/m

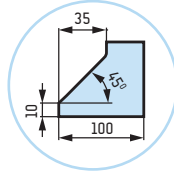
$\alpha = 88^0$	
$R = 0.8$ mm	$AH3 = 15$ t/m

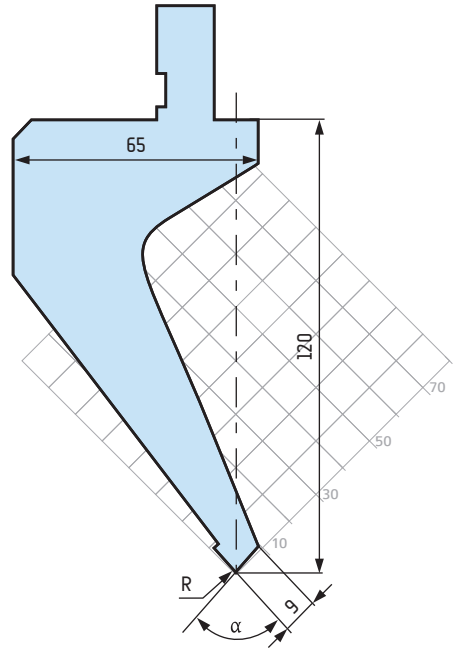




S 2020 — 50 t/m

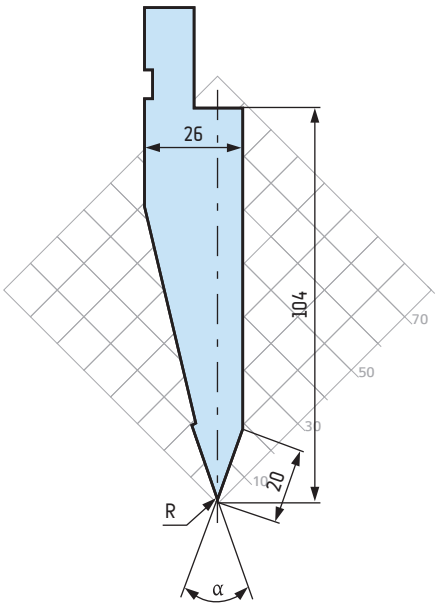
$\alpha = 75^0$, $R = 0.8$ mm	$AH2 = 15$ t/m
$\alpha = 85^0$, $R = 0.2$ mm, $R = 0.8$ mm	$AH2 = 12$ t/m
$\alpha = 88^0$, $R = 0.2$ mm, $R = 0.8$ mm	$AH2 = 12$ t/m

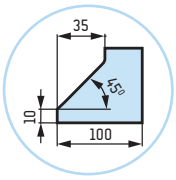




24h

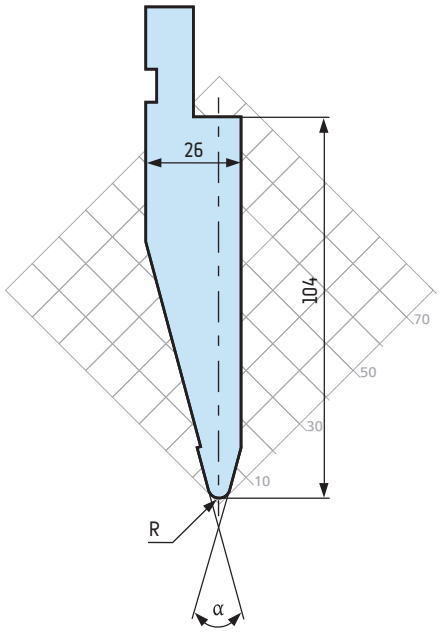
S 2021	100 t/m
$\alpha = 30^0$	
$R = 0.8$ mm	$AH2 = 30$ t/m

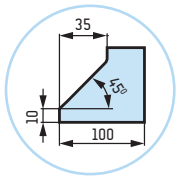




24h

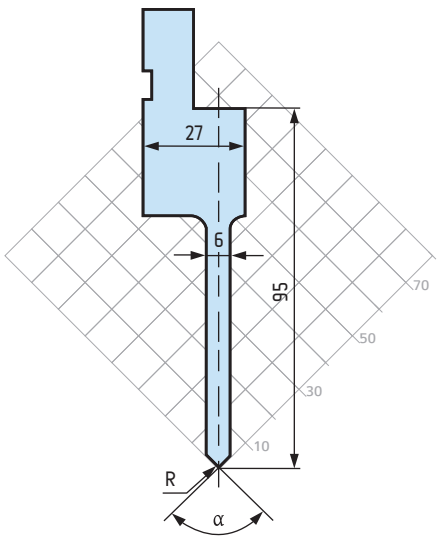
S 2021/R3	100 t/m
$\alpha = 30^0$	
$R = 3$ mm	$AH2 = 35$ t/m

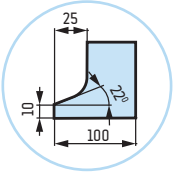




24h

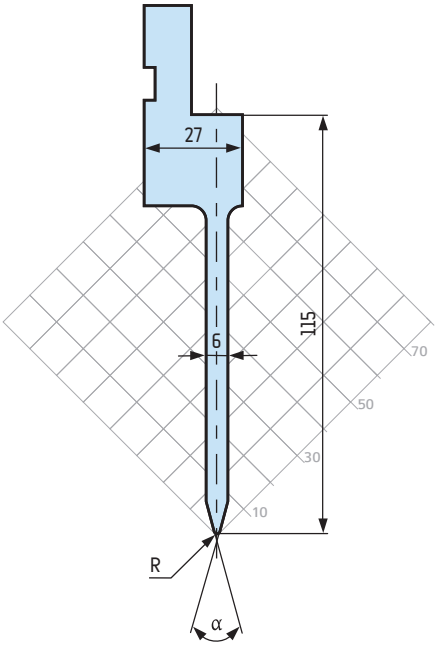
S 2022	50 t/m
$\alpha = 75^0$, $R = 0.8$ mm	$AH3 = 14$ t/m
$\alpha = 88^0$, $R = 0.2$ mm	$AH3 = 14$ t/m
$\alpha = 90^0$, $R = 0.2$ mm	$AH3 = 14$ t/m

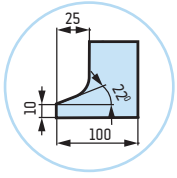




24h

S 2022/115	45 t/m
$\alpha = 30^0$	
$R = 0.8$ mm	$AH3 = 15$ t/m



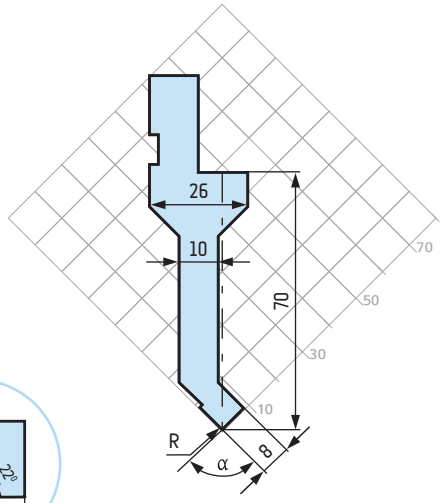


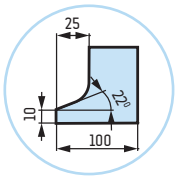
24h

S 2023 30 t/m

α = 85°, 88°, 90°

R = 0.2 mm *AH3 = 8 t/m*



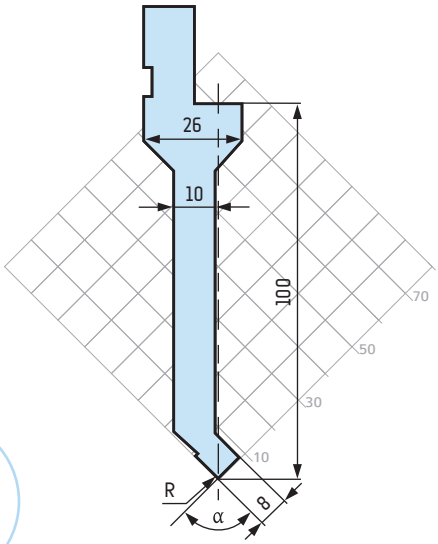


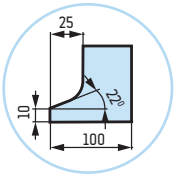
24h

S 2024 30 t/m

α = 85°, 88°, 90°

R = 0.2 mm *AH3 = 8 t/m*



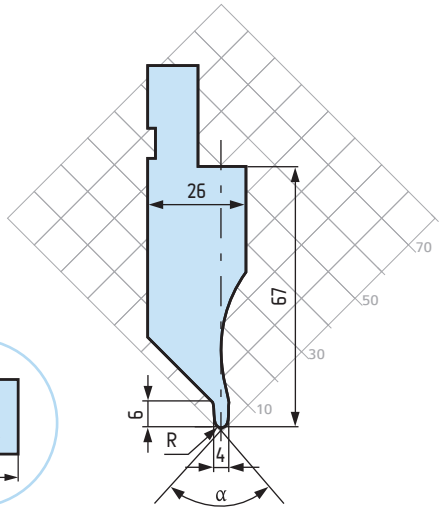


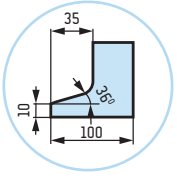
24h

S 2025 40 t/m

α = 88°, 90°

R = 0.2 mm *AH4= 13 t/m*



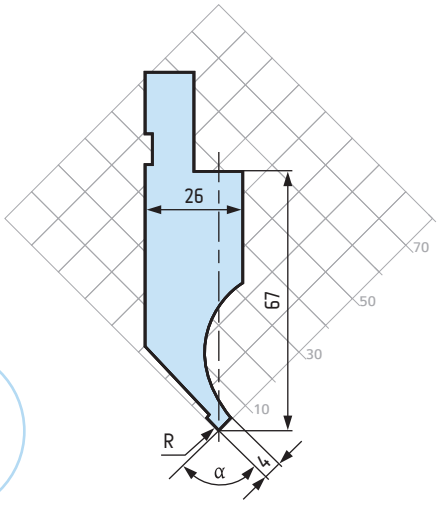


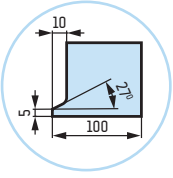
24h

S 2026 20 t/m

α = 88°, 90°

R = 0.2 mm *AH5 = 7.5 t/m*

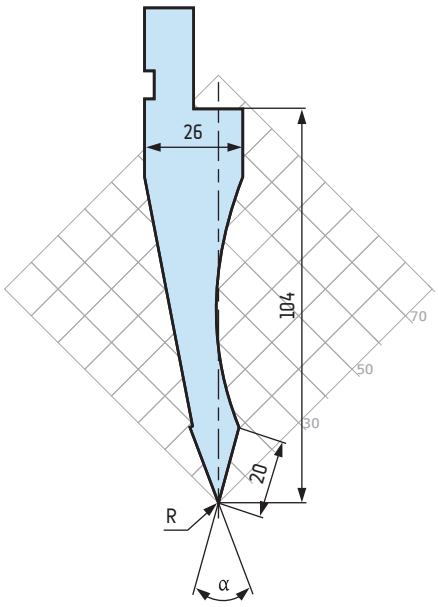


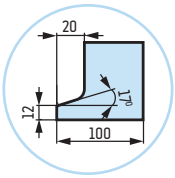


S 2027 — 70 t/m

α = 30°

R = 0.8 mm — *AH6 = 20 t/m*

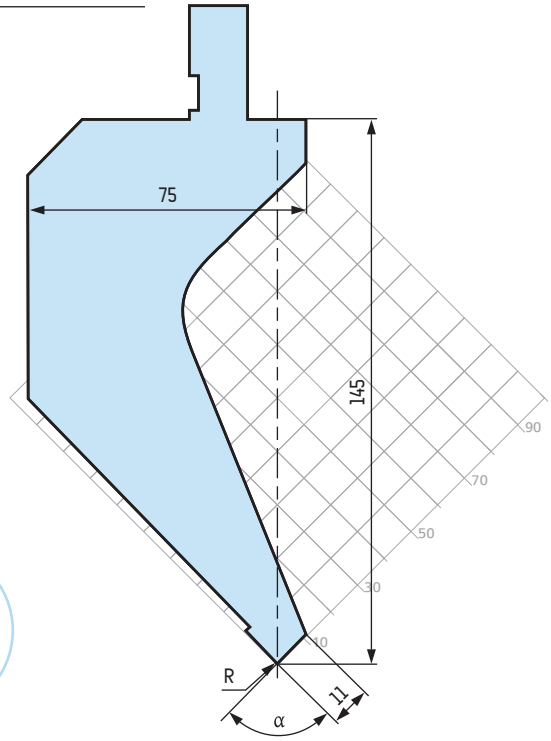


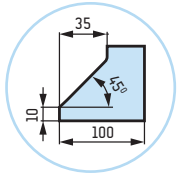


S 2028 — 80 t/m

α = 85°, 88°

R = 0.8 mm — *AH2 = 22 t/m*

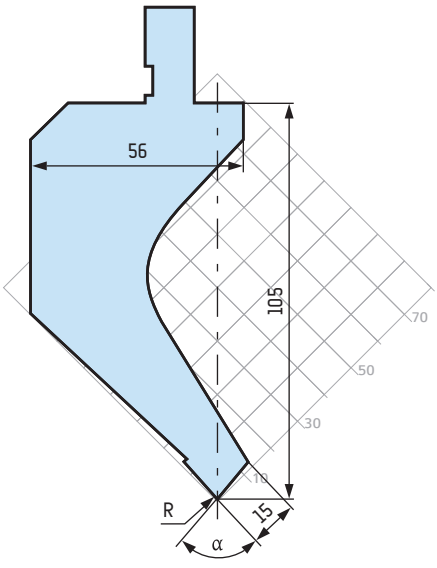


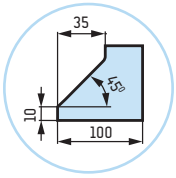


S 2029 — 70 t/m

α = 85°

R = 5 mm, 6.5 mm — *AH2 = 20 t/m*

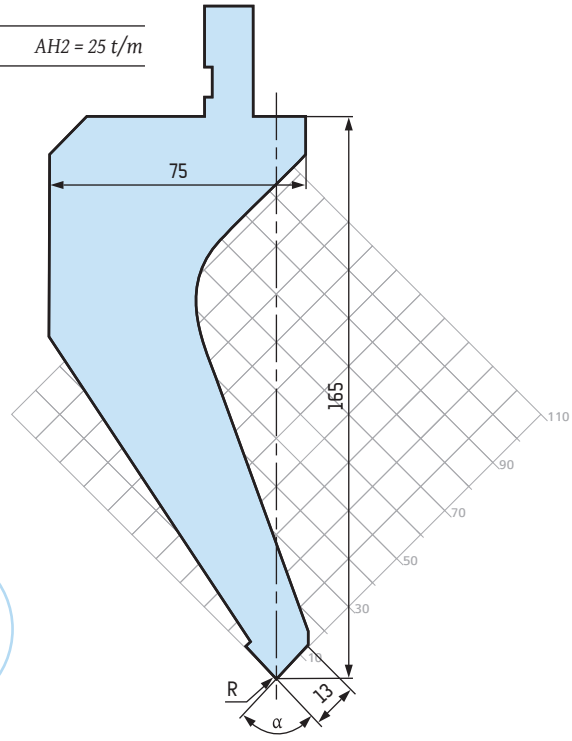


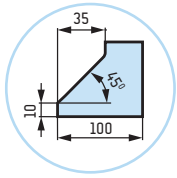


S 2030 — 60 t/m

α = 85°, 88°

R = 0.8 mm — *AH2 = 25 t/m*



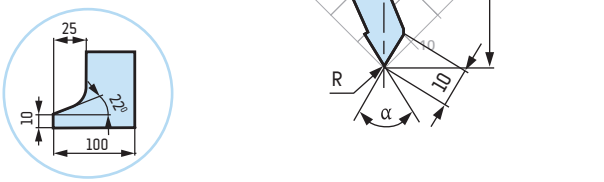


24h

S 2031 55 t/m

α = 60°

R = 0.8 mm *AH3 = 10 t/m*

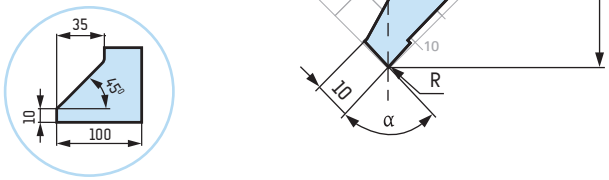


24h

S 2032 45 t/m

α = 88°

R = 0.8 mm *AH2 = 12 t/m*

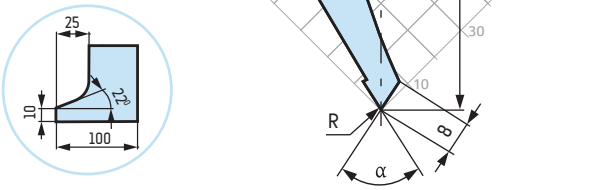


24h 42CrMo4

S 2034 35 t/m

α = 60°

R = 0.8 mm *AH3 = 10 t/m*

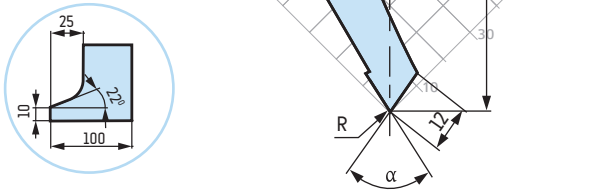


24h 42CrMo4

S 2035 35 t/m

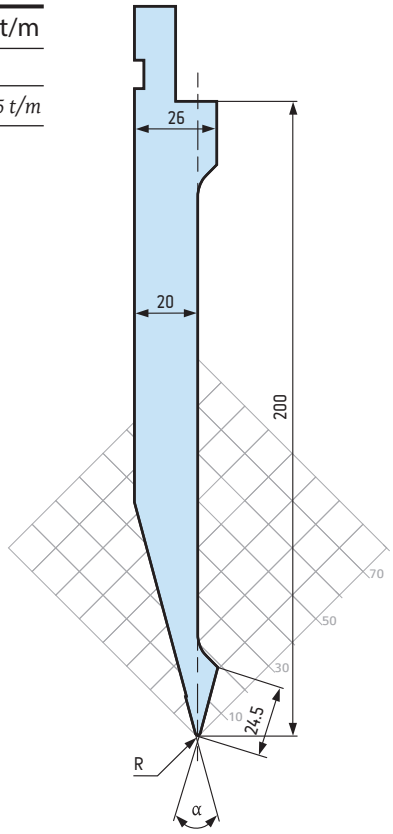
α = 60°

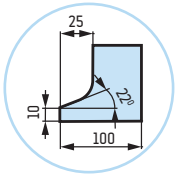
R = 0.8 mm *AH3 = 25 t/m*



42CrMo4

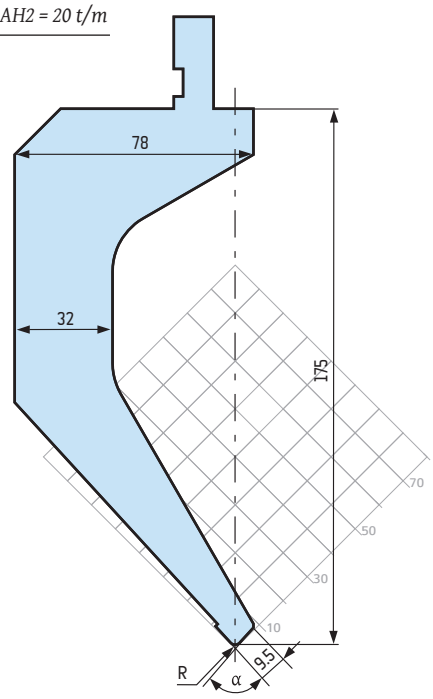
S 2036	50 t/m
$\alpha = 30^0$	
$R = 0.8$ mm	$AH3 = 25$ t/m

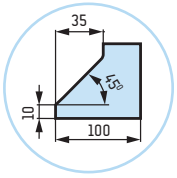




42CrMo4

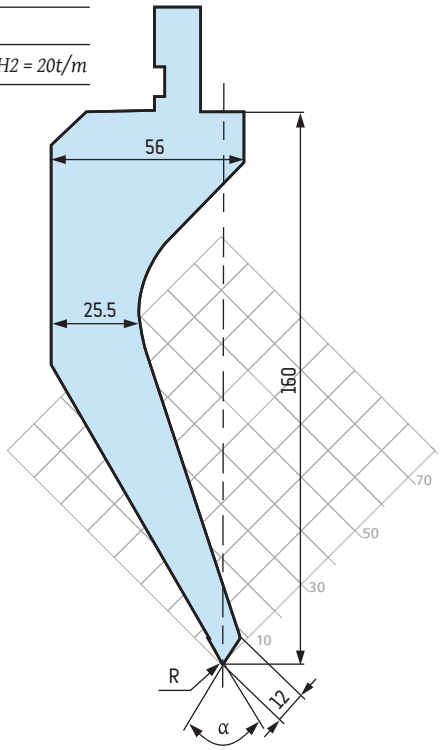
S 2037	70 t/m
$\alpha = 85^0$	
$R = 0.8$ mm	$AH2 = 20$ t/m

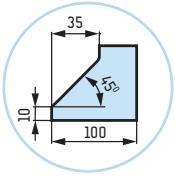




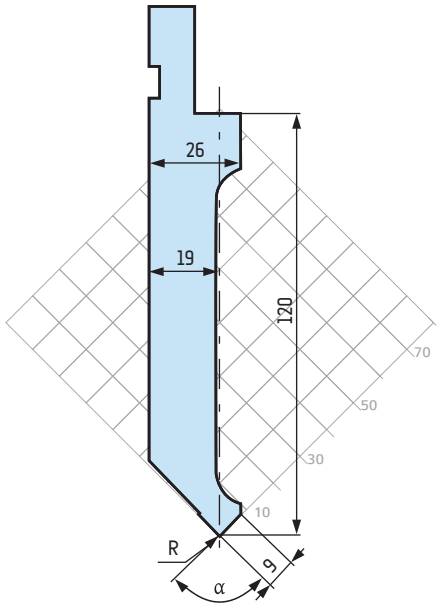
42CrMo4

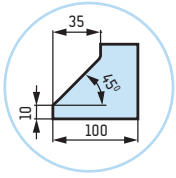
S 2038	70 t/m
$\alpha = 60^0$	
$R = 0.8$ mm	$AH2 = 20$t/m





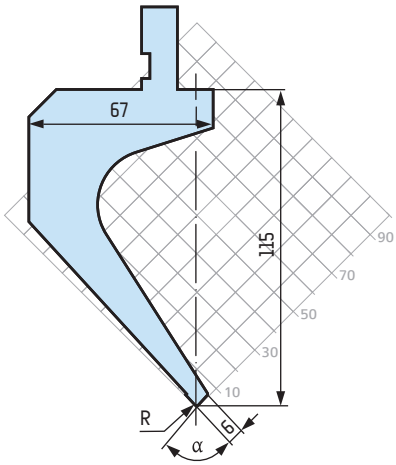
S 2039	100 t/m
$\alpha = 88^0$	
$R = 0.5$ mm	$AH2 = 25$ t/m

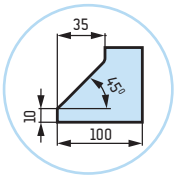




42CrMo4

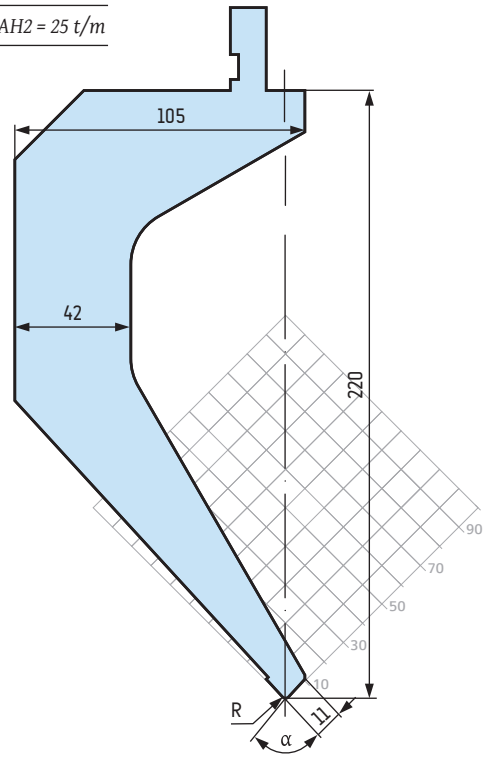
S 2040	30 t/m
$\alpha = 85^0$	
R = 0.8 mm	*AH2 = 10 t/m*

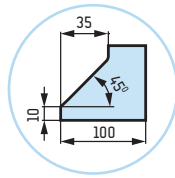




42CrMo4

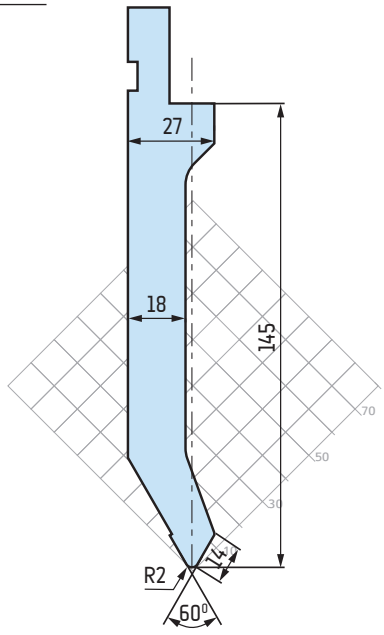
S 2041	80 t/m
$\alpha = 85^0$	
R = 1.5 mm	*AH2 = 25 t/m*

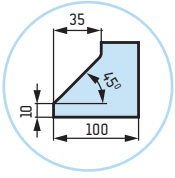




42CrMo4

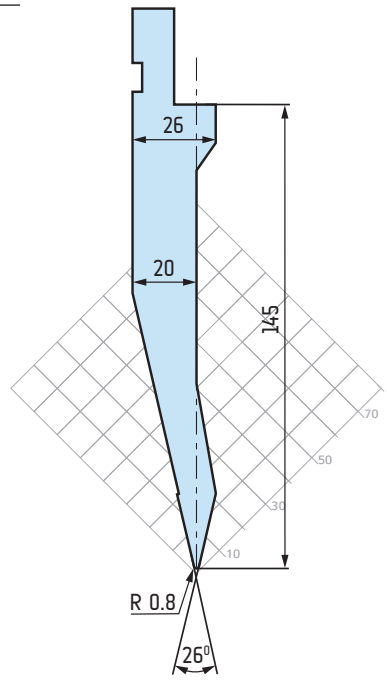
S 2042	70 t/m
$\alpha = 60^0$	
R = 2 mm	*AH2 = 25 t/m*

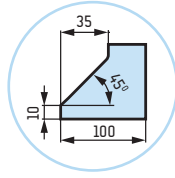




42CrMo4

S 2043	50 t/m
$\alpha = 26^0$	
R = 0.8 mm	*AH2 = 25 t/m*





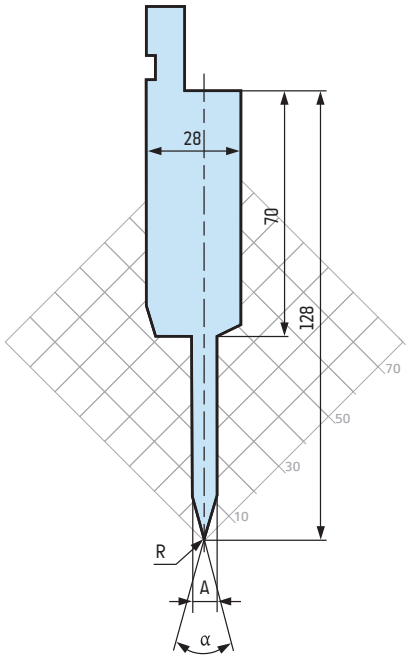
flattening tools | **zestaw do zagniatania**

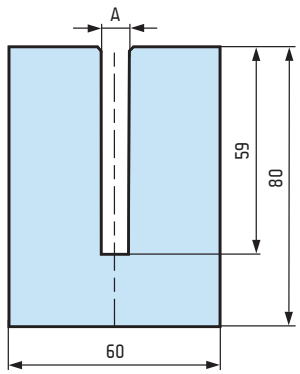
42CrMo4

S 2033	70 t/m
α = 28°	
R = 0.6 mm	
A = 6.5 mm, 8 mm, 10 mm, 12 mm	

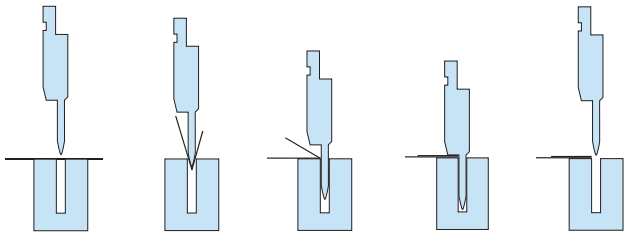
42CrMo4

M 3000	70 t/m
A = 6.5 mm, 8 mm, 10 mm, 12 mm	

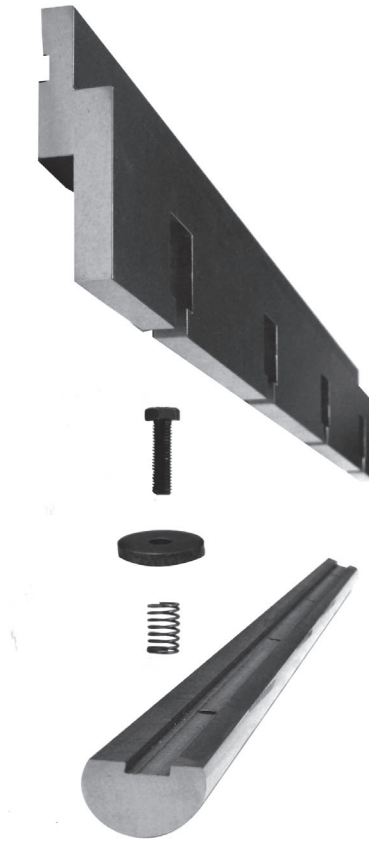


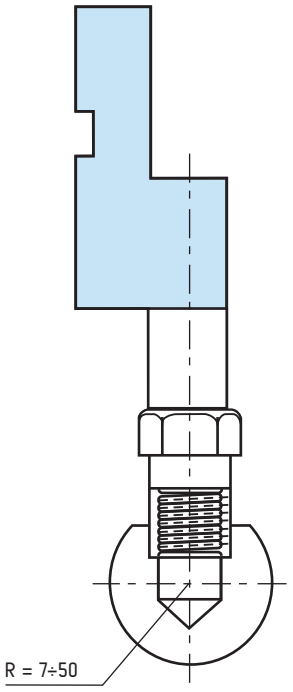


example of use S 2033 and M 3000
przykład zastosowania S 2033 i M 3000



assembly | **sposób mocowania**

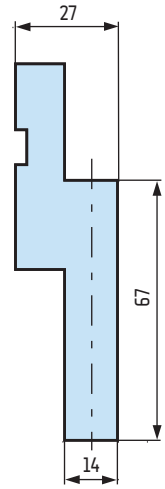




for inserts R 7 – R 50 | **dla wkładek R 7 – R 50**

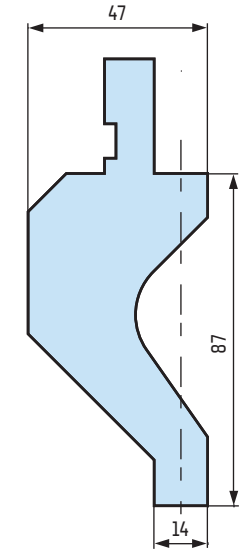
24h

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



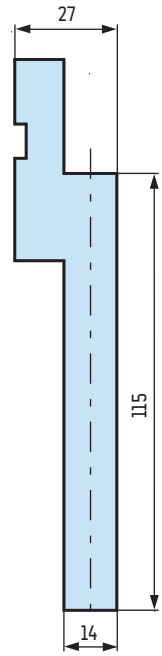
24h

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



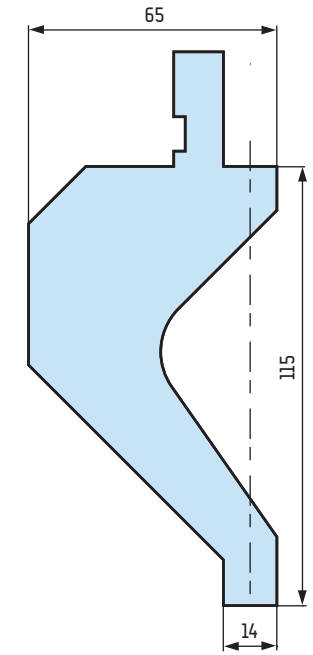
24h

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



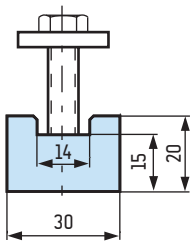
24h

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

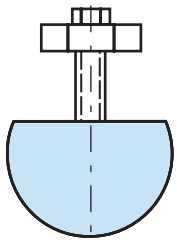


inserts R 7 – R 50 | **wkładki R 7 – R 50**

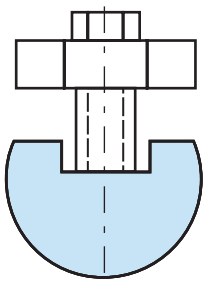
FLATTENING INSERT | **WKŁADKA PŁASKA**



WKŁADKA R 7 – R 12



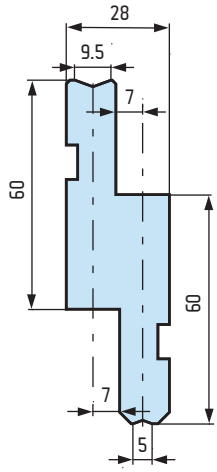
WKŁADKA R 12.5 – R 50



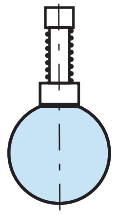
for inserts R 3 – R 6.5 | **dla wkładek R 3 – R 6.5**

STEMPEL R – R 80 t/m

Double radius punch.
Stempel podwójny promieniowy.



WKŁADKA R 3 – R 6.5

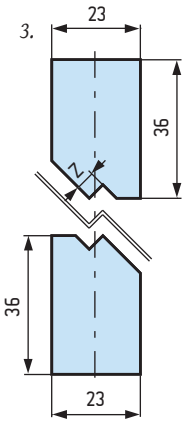


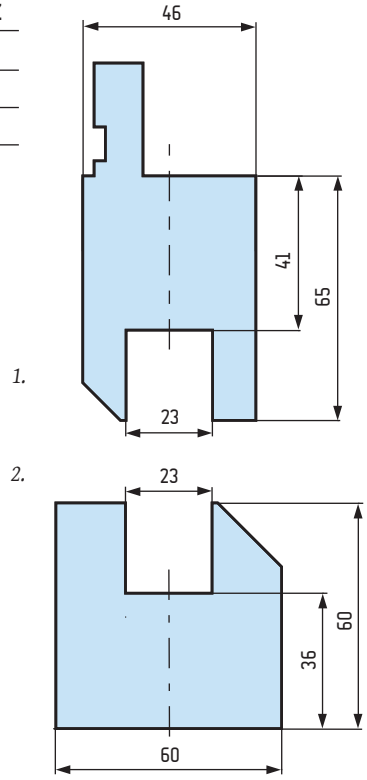
Z SHAPE TOOL | **ZESTAW DO Z**

1. Z Punch / Stempel Z

2. Z Die / Matryca Z

3. Z Insert (set) / Wkładka Z (kpl)





joiners | adaptersy

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

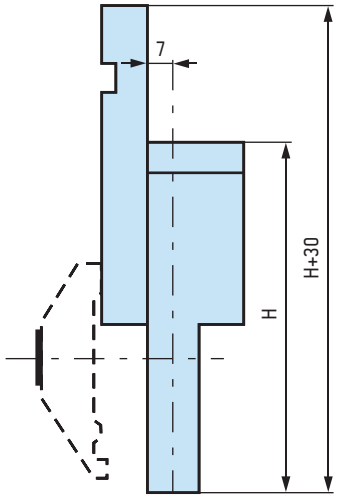
TYPE "A" | TYP „A"

H = 100 mm, L = 150 mm

H = 120 mm, L = 150 mm

H = 140 mm, L = 150 mm

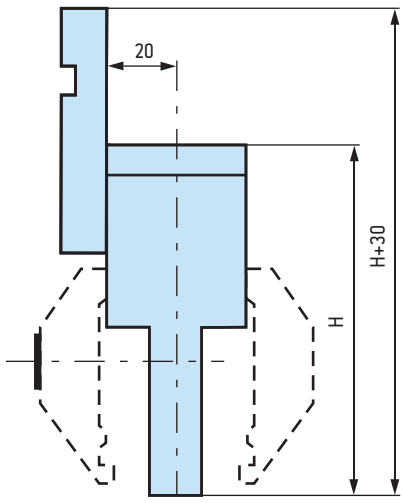
H = 150 mm, L = 150 mm



TYPE "B" | TYP „B"

H = 120 mm, L = 150 mm

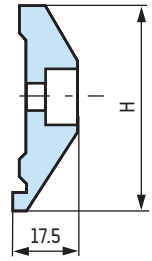
H = 170 mm, L = 150 mm



clamping washers | podkładki mocujące (klamry)

TYPE "S" | TYP „S"

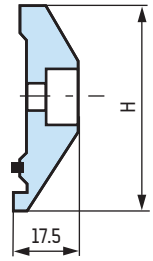
H = 58 mm, L = 150 mm



TYPE "P" | TYP „P"

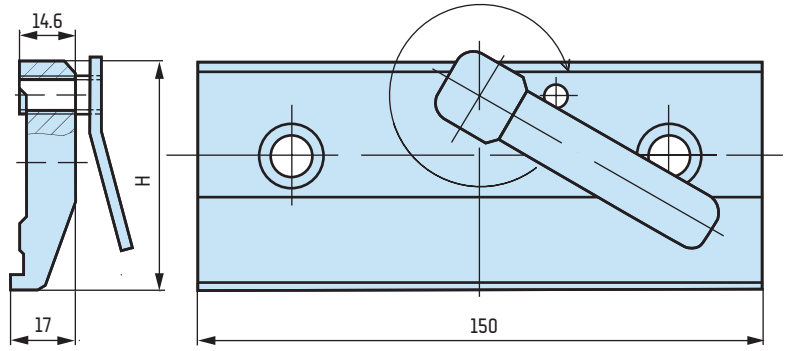
with plastic insert / z wkładką plastikową

H = 58 mm, L = 150 mm



TYPE "QR" | TYP „QR"

H = 60 mm, L = 150 mm



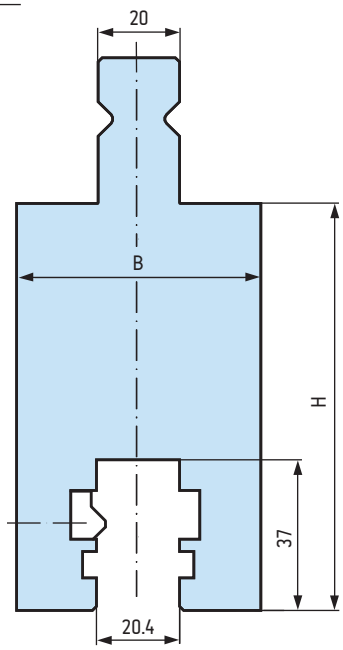
type "T" adaptor | adapter typu „T"

24h 42CrMo4

TYPE "T/T" | TYP „T/T"

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

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

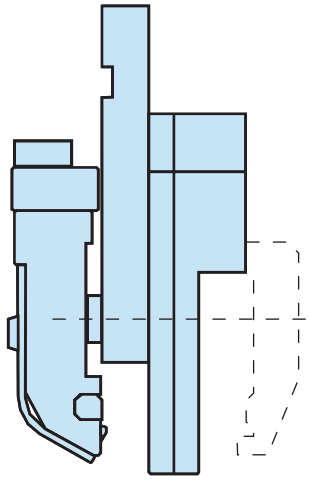


TEDA adapters for quick installation of tools
adaptery do szybkiego montażu narzędzi TEDA

More information on p. 91
Więcej informacji na str. 91

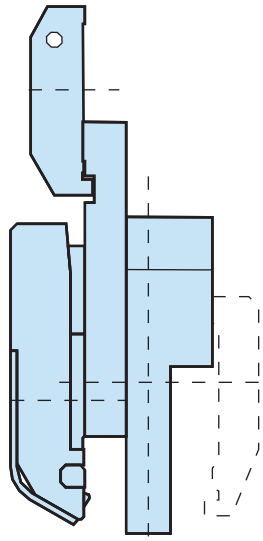
SPEED GRIP

13000-M MANUAL | **RĘCZNY**



SPEED GRIP

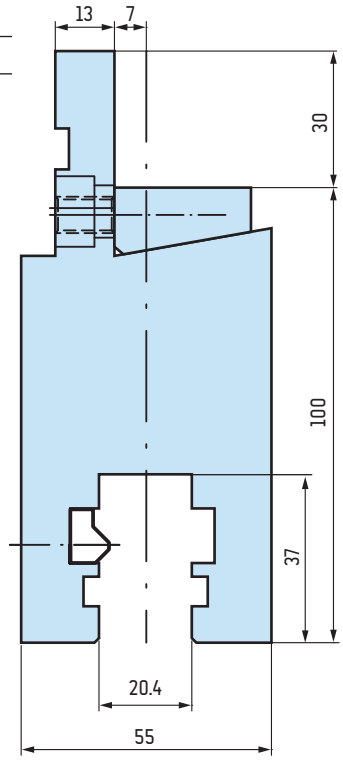
13000-ST PNEUMATIC | **PNEUMATYCZNY**



system changing adaptors
adaptery międzysystemowe

TYPE "A/W" | TYP „A/W"

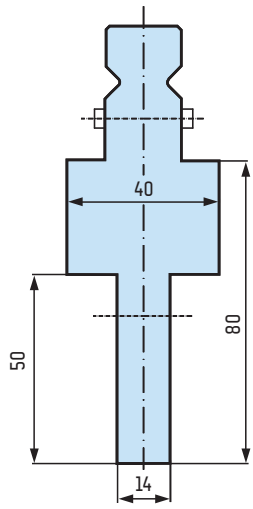
H = 100 mm, L = 150 mm



24h

TYPE "T/A" 80 | TYP „T/A" 80

H = 80 mm, L = 150 mm

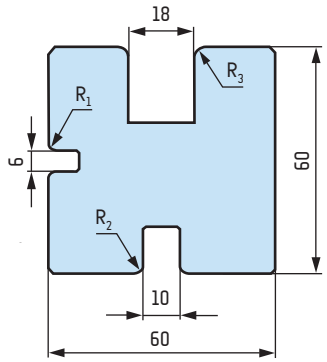


multiple vee dies | matryce wielorowkowe

24h

MR 100 t/m

R_1 = 1,5 mm, R_2 = 2 mm, R_3 = 3 mm



24h 42CrMo4

M 4 80 t/m

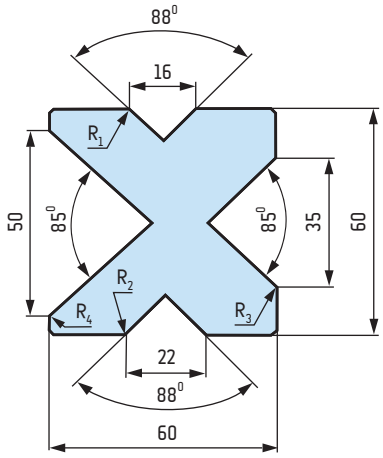
$\alpha = 85^0, 88^0$

R_1 = 2 mm, R_2 = 2 mm, R_3 = 2 mm, R_4 = 2,5 mm

M 4 80 t/m

$\alpha = 85^0, 88^0$

R_1 = 2 mm, R_2 = 2 mm, R_3 = 2 mm, R_4 = 2,5 mm

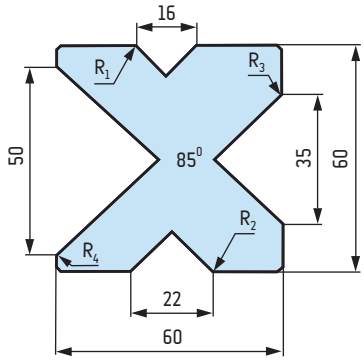


24h

M 4/85° 80 t/m

$\alpha = 85^0$

R_1 = 1.5 mm, R_2 = 1.5 mm, R_3 = 2 mm, R_4 = 2.5 mm

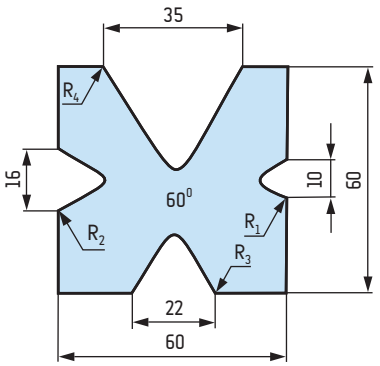


24h

M 4/60° 60 t/m

$\alpha = 60^0$

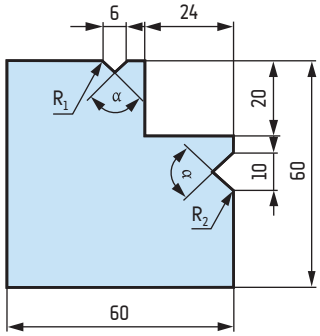
R_1 = 1 mm, R_2 = 2 mm, R_3 = 2 mm, R_4 = 3 mm



M 2/6 – 10 100 t/m

$\alpha = 90^0$

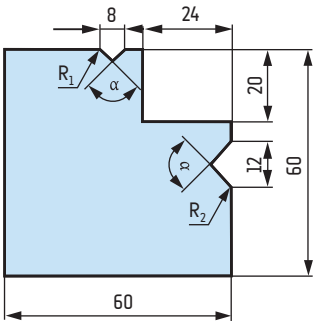
R_1 = 1 mm, R_2 = 1 mm



M 2/8 –12 80 t/m

$\alpha = 90^0$

R_1 = 1 mm, R_2 = 1 mm



with groove | rowkowe

M 6019 — 80 t/m

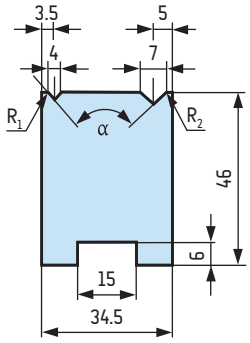
$\alpha = 90^0$

$R_1 = 0.3$ mm, $R_2 = 0.5$ mm

M 6119 — 80 t/m

$\alpha = 88^0$

$R_1 = 0.3$ mm, $R_2 = 0.5$ mm



M 6020 — 80 t/m

$\alpha = 90^0$

$R_1 = 0.4$ mm, $R_2 = 0.6$ mm

M 6220 — 35 t/m*

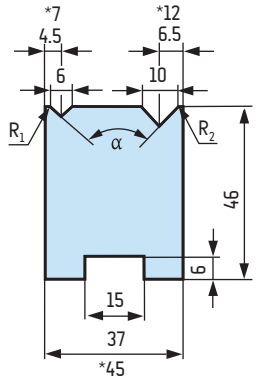
$\alpha = 30^0$

$R_1 = 0.8$ mm, $R_2 = 2$ mm

M 6120 — 80 t/m

$\alpha = 88^0$

$R_1 = 0.4$ mm, $R_2 = 0.6$ mm



M 6021 — 80 t/m

$\alpha = 90^0$

$R_1 = 0.5$ mm, $R_2 = 0.8$ mm

M 6221 — 40 t/m *

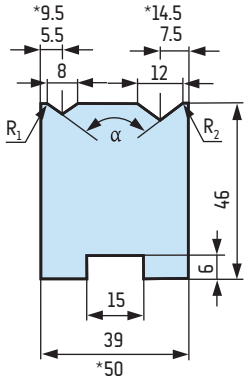
$\alpha = 30^0$

$R_1 = 1$ mm, $R_2 = 1.5$ mm

M 6121 — 80 t/m

$\alpha = 88^0$

$R_1 = 0.5$ mm, $R_2 = 0.8$ mm



M 6022 — 80 t/m

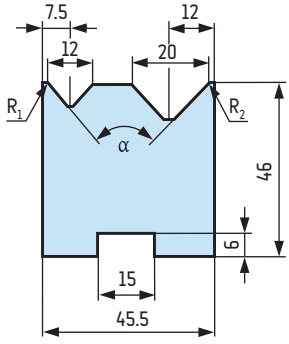
$\alpha = 90^0$

$R_1 = 0.8$ mm, $R_2 = 2$ mm

M 6122 — 80 t/m

$\alpha = 88^0$

$R_1 = 1.6$ mm, $R_2 = 1.75$ mm



M 6023 — 80 t/m

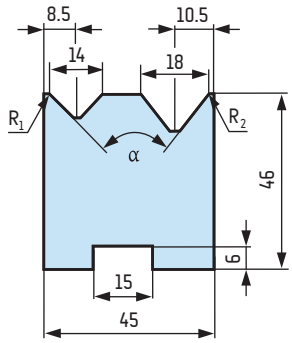
$\alpha = 90^0$

$R_1 = 1.25$ mm, $R_2 = 1.5$ mm

M 6123 — 80 t/m

$\alpha = 88^0$

$R_1 = 1$ mm, $R_2 = 1.5$ mm



M 6024 — 80 t/m

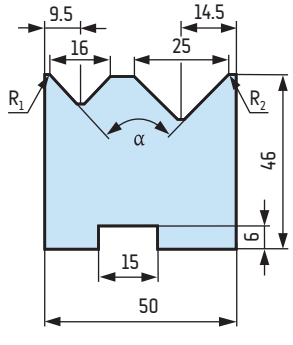
$\alpha = 90^0$

$R_1 = 2.5$ mm, $R_2 = 3$ mm

M 6124 — 80 t/m

$\alpha = 88^0$

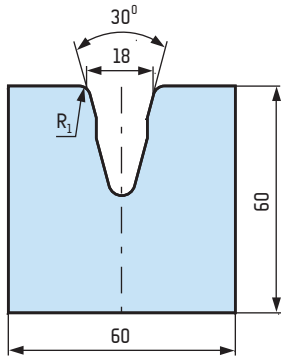
$R_1 = 2.5$ mm, $R_2 = 3$ mm



1V dies | matryce 1V

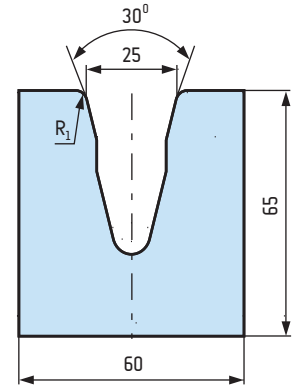
24h

M 3330/18	100 t/m
$\alpha = 30^0$	
$V = 18\ mm$	
$R_1 = 3\ mm$	



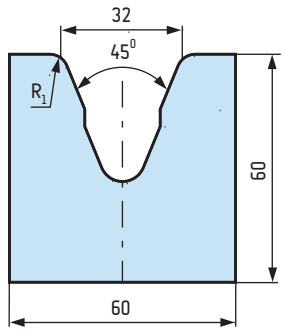
24h

M 3330/25	100 t/m
$\alpha = 30^0$	
$V = 25\ mm$	
$R_1 = 4\ mm$	



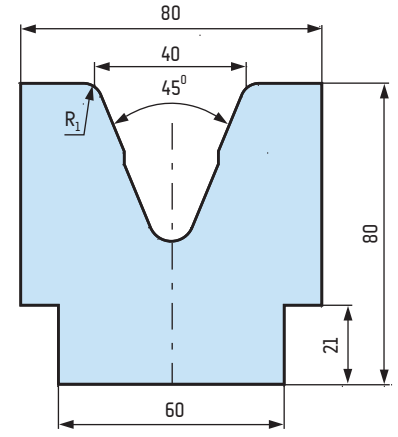
24h

M 3345/32	100 t/m
$\alpha = 45^0$	
$V = 32\ mm$	
$R_1 = 5\ mm$	



24h

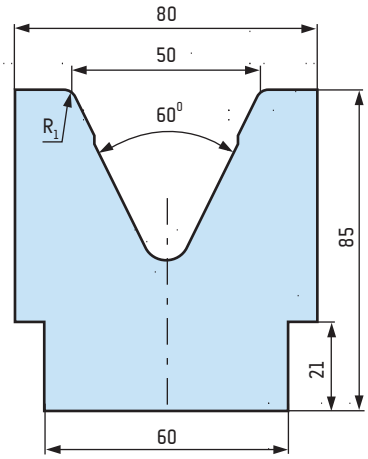
M 3345/40	100 t/m
$\alpha = 45^0$	
$V = 40\ mm$	
$R_1 = 5\ mm$	



1V dies | matryce 1V

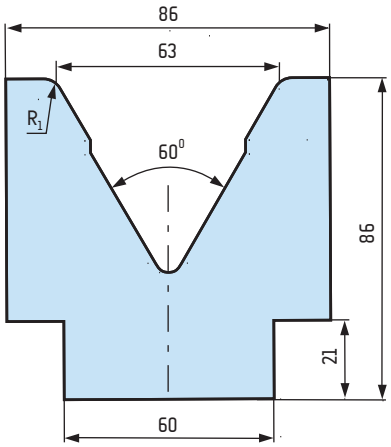
24h

M 3360/50	100 t/m
$\alpha = 60^0$	
$V = 50\ mm$	
$R_1 = 5\ mm$	



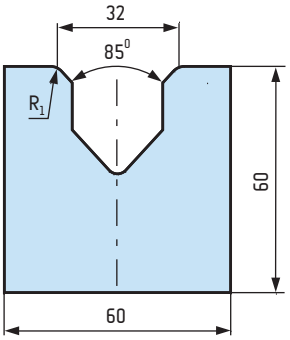
24h

M 3360/63	100 t/m
$\alpha = 60^0$	
$V = 63\ mm$	
$R_1 = 5\ mm$	



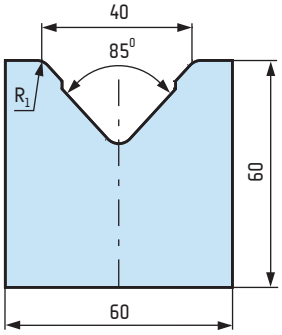
24h

M 3385/32	100 t/m
$\alpha = 85^0$	
$V = 32\ mm$	
$R_1 = 4\ mm$	



24h

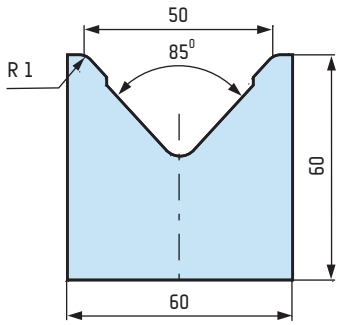
M 3385/40	100 t/m
$\alpha = 85^0$	
$V = 40\ mm$	
$R_1 = 4\ mm$	



1V dies | matryce 1V

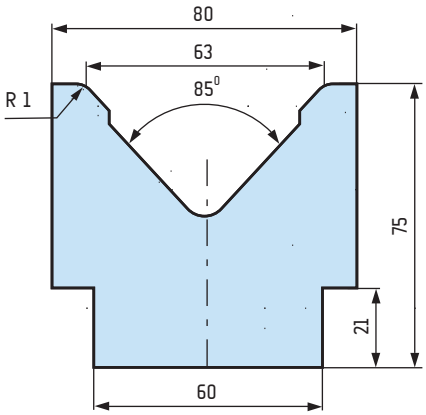
24h

M 3385/50	100 t/m
$\alpha = 85^0$	
$V = 50$ mm	
$R_1 = 4$ mm	



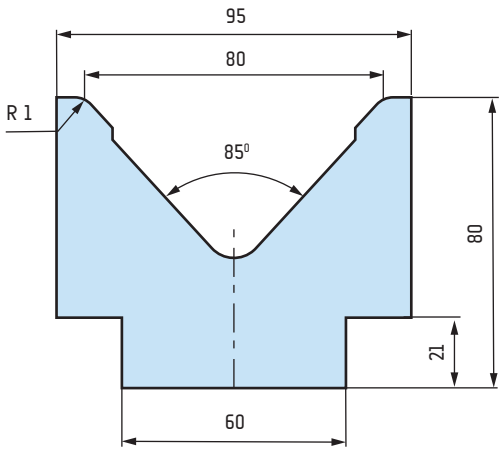
24h

M 3385/63	100 t/m
$\alpha = 85^0$	
$V = 63$ mm	
$R_1 = 5$ mm	



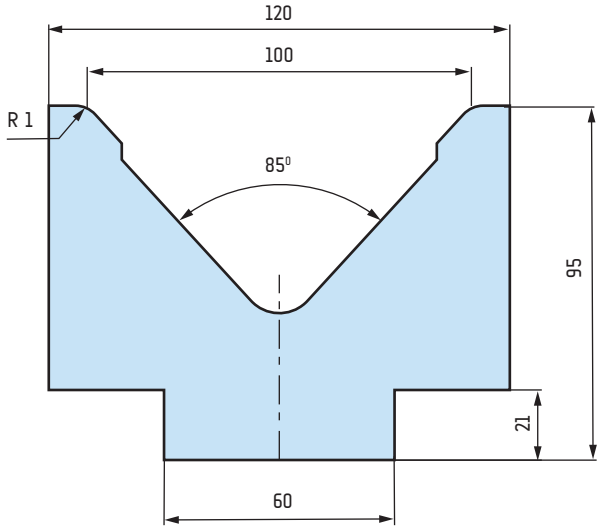
24h

M 3385/80	100 t/m
$\alpha = 85^0$	
$V = 80$ mm	
$H = 80$ mm	
na zamówienie $H = 95$ mm	
$R_1 = 6$ mm	



24h

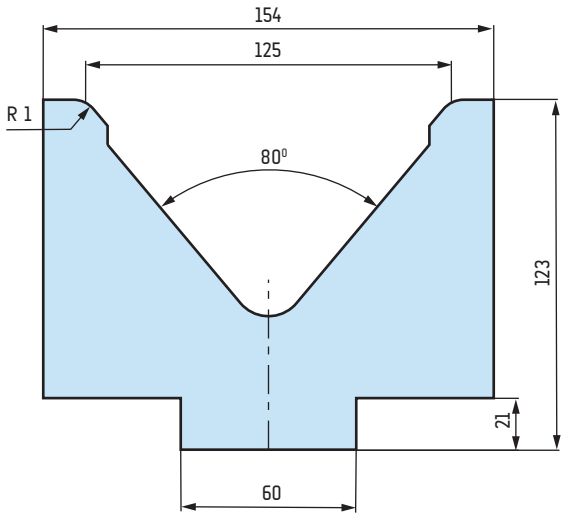
M 3385/100	100 t/m
$\alpha = 85^0$	
$V = 100$ mm	
$H = 95$ mm	
na zamówienie $H = 110$ mm	
$R_1 = 7$ mm	



1V dies | matryce 1V

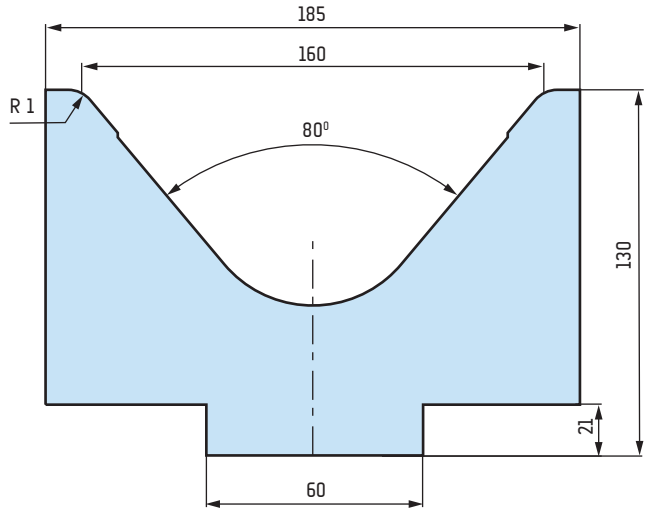
24h

M3380/125	100 t/m
$\alpha = 80^0$	
$V = 125$ mm	
$H = 123$ mm	
$R_1 = 9$ mm	



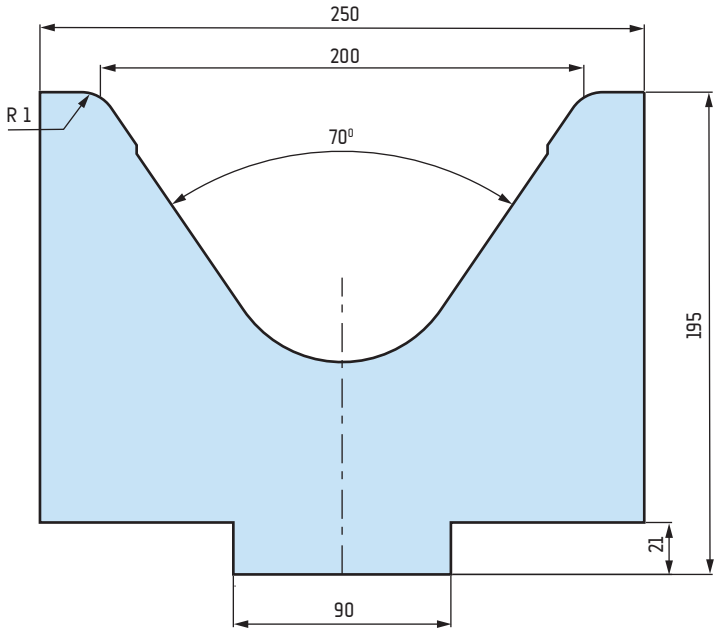
24h

M3380/160	100 t/m
$\alpha = 80^0$	
$V = 160$ mm	
$H = 130$ mm	
$R_1 = 10$ mm	



24h

M 3370/200	100 t/m
$\alpha = 70^0$	
$V = 200$ mm	
$H = 195$ mm	
$R_1 = 15$ mm	



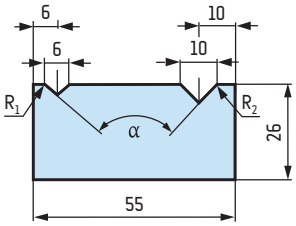
Dies fixed using die supports A 34, A39, A 55 or A 75 –> p. 83
Matryce montowane przy pomocy podpór A 34, A 39, A 55 lub A 75 –> str. 83

bolt fastened | mocowane śrubami

M 6112 — 100 t/m

α = 90°

R_1 = 0.4 mm, R_2 = 0.8 mm



M 6212 — 60 t/m

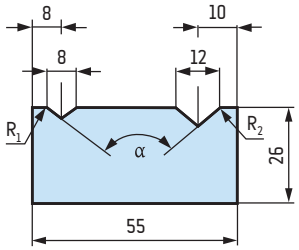
α = 60°

R_1 = 0.7 mm, R_2 = 1 mm

M 6113 — 100 t/m

α = 90°

R_1 = 0.5 mm, R_2 = 0.8 mm



M 6213 — 80 t/m

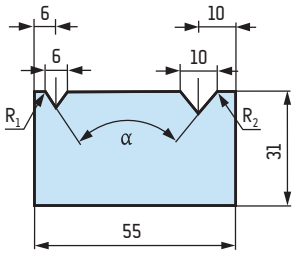
α = 60°

R_1 = 0.7 mm, R_2 = 1 mm

M 6312 — 30 t/m

α = 35°

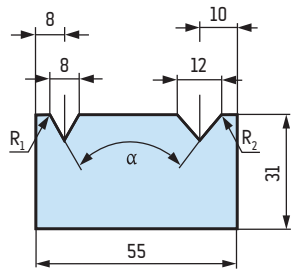
R_1 = 0.7 mm, R_2 = 1 mm



M 6313 — 30 t/m

α = 35°

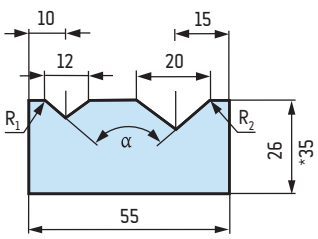
R_1 = 1.5 mm, R_2 = 2 mm



M 6114 — 100 t/m

α = 88°

R_1 = 2.5 mm, R_2 = 3 mm



M 6214 — 80 t/m *

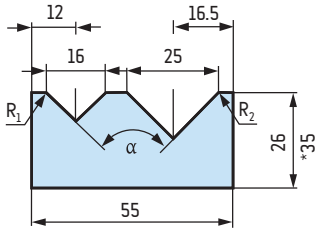
α = 60°

R_1 = 2.5 mm, R_2 = 3 mm

M 6115 — 100 t/m

α = 88°

R_1 = 2.5 mm, R_2 = 3 mm



M 6215 — 80 t/m *

α = 60°

R_1 = 2.5 mm, R_2 = 3 mm

TYPE ”A“ DIES | MATRYCE TYPU „A“

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

24h

M 6130 30 t/m

A = 8 mm, B = 16 mm

R_1 = 1 mm, R_2 = 1 mm

24h

M 6230 35 t/m

A = 10 mm, B = 20 mm

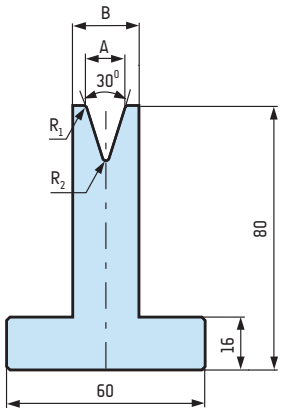
R_1 = 1 mm, R_2 = 1 mm

24h

M 6330 35 t/m

A = 12 mm, B = 22 mm

R_1 = 1 mm, R_2 = 1 mm



24h

M 6430 45 t/m

A = 16 mm, B = 30 mm

R_1 = 2 mm, R_2 = 2 mm

24h

M 6530 30 t/m

A = 6 mm, B = 14 mm

R_1 = 0.8 mm, R_2 = 0.8 mm

24h

M 6630 50 t/m

A = 20 mm, B = 35 mm

R_1 = 4 mm, R_2 = 4 mm

24h

M 6135 35 t/m

A = 8 mm, B = 14 mm

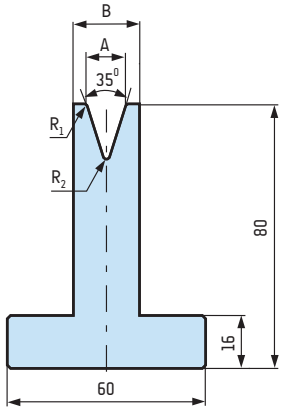
R_1 = 1.5 mm, R_2 = 0.8 mm

24h

M 6235 40 t/m

A = 12 mm, B = 18 mm

R_1 = 2 mm, R_2 = 1 mm



24h

M 6145 50 t/m

A = 10 mm, B = 16 mm

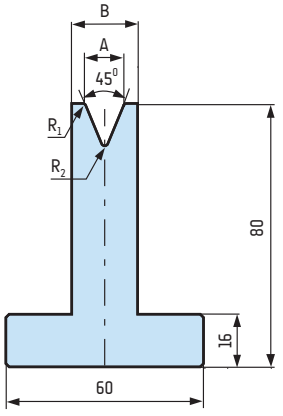
R_1 = 2 mm, R_2 = 1 mm

24h

M 6245 50 t/m

A = 12 mm, B = 18 mm

R_1 = 2.5 mm, R_2 = 1 mm



TYPE ”A“ DIES | MATRYCE TYPU „A“

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

M 6160 60 t/m
A = 8 mm, B = 14 mm
R_1 = 1.5 mm, R_2 = 0.8 mm

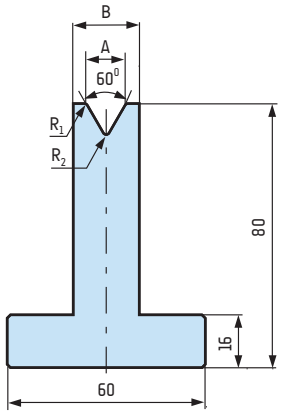
M 6260 60 t/m
A = 10 mm, B = 16 mm
R_1 = 2 mm, R_2 = 1 mm

M 6360 60 t/m
A = 12 mm, B = 18 mm
R_1 = 2.5 mm, R_2 = 1 mm

M 6460 60 t/m
A = 16 mm, B = 24 mm
R_1 = 1.5 mm, R_2 = 1.5 mm

M 6560 60 t/m
A = 20 mm, B = 30 mm
R_1 = 2 mm, R_2 = 2 mm

M 6660 60 t/m
A = 25 mm, B = 40 mm
R_1 = 3 mm, R_2 = 3 mm



M 6085 100 t/m
A = 8 mm, B = 14 mm
R_1 = 1 mm, R_2 = 0.5 mm

M 6185 100 t/m
A = 12 mm, B = 18 mm
R_1 = 2.5 mm, R_2 = 1 mm

M 6285 100 t/m
A = 16 mm, B = 24 mm
R_1 = 2.5 mm, R_2 = 1 mm

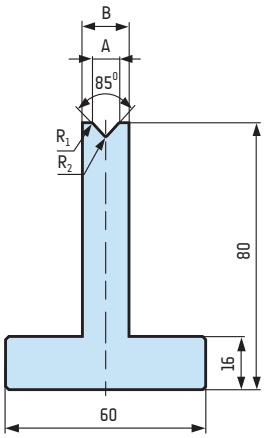
M 6385 100 t/m
A = 20 mm, B = 30 mm
R_1 = 3 mm, R_2 = 1.5 mm

M 6485 100 t/m
A = 25 mm, B = 40 mm
R_1 = 3 mm, R_2 = 3 mm

M 6585 100 t/m
A = 10 mm, B = 18 mm
R_1 = 1 mm, R_2 = 1 mm

M 6685 100 t/m
A = 14 mm, B = 18 mm
R_1 = 2.6 mm, R_2 = 0.4 mm

M 6785 100 t/m
A = 6 mm, B = 14 mm
R_1 = 0.5 mm, R_2 = 0.5 mm



M 6088 100 t/m
A = 8 mm, B = 14 mm
R_1 = 1 mm, R_2 = 0.5 mm

M 6188 100 t/m
A = 12 mm, B = 18 mm
R_1 = 2.5 mm, R_2 = 1 mm

M 6288 100 t/m
A = 16 mm, B = 24 mm
R_1 = 2.5 mm, R_2 = 1 mm

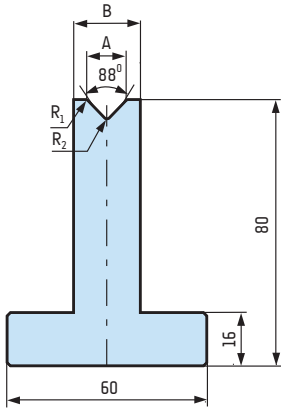
M 6388 100 t/m
A = 20 mm, B = 30 mm
R_1 = 3 mm, R_2 = 1.5 mm

M 6488 100 t/m
A = 25 mm, B = 40 mm
R_1 = 3 mm, R_2 = 3 mm

M 6588 100 t/m
A = 10 mm, B = 18 mm
R_1 = 1 mm, R_2 = 1 mm

M 6688 100 t/m
A = 14 mm, B = 18 mm
R_1 = 2.6 mm, R_2 = 0.4 mm

M 6788 100 t/m
A = 6 mm, B = 14 mm
R_1 = 0.5 mm, R_2 = 0.5 mm



TYPE "A" DIES | MATRYCE TYPU „A"

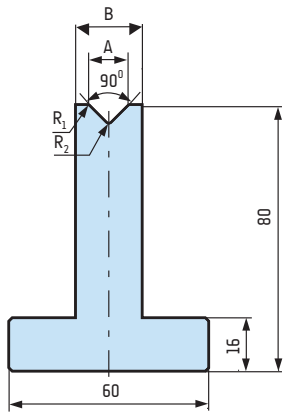
dies with base H = 80 mm | matryce z podstawą H = 80 mm

M 6190 100 t/m
A = 6 mm, B = 12 mm
R_1 = 1.5 mm, R_2 = 0.5 mm

M 6290 100 t/m
A = 8 mm, B = 14 mm
R_1 = 1.5 mm, R_2 = 0.8 mm

M 6390 100 t/m
A = 10 mm, B = 16 mm
R_1 = 2 mm, R_2 = 1 mm

M 6490 100 t/m
A = 12 mm, B = 18 mm
R_1 = 2.5 mm, R_2 = 1.5 mm



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

M 9130 30 t/m
A = 8 mm, B = 18 mm
R_1 = 1 mm, R_2 = 1 mm

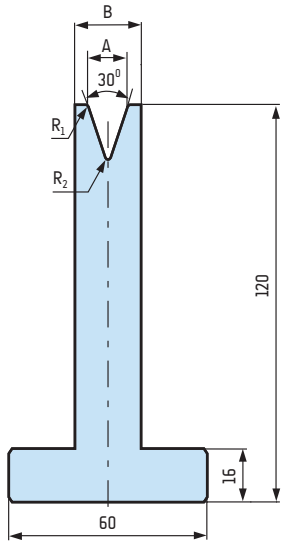
M 9230 35 t/m
A = 10 mm, B = 24 mm
R_1 = 1 mm, R = 1 mm

M 9330 35 t/m
A = 12 mm, B = 24 mm
R_1 = 1 mm, R_2 = 1 mm

M 9430 45 t/m
A = 16 mm, B = 30 mm
R_1 = 2 mm, R_2 = 2 mm

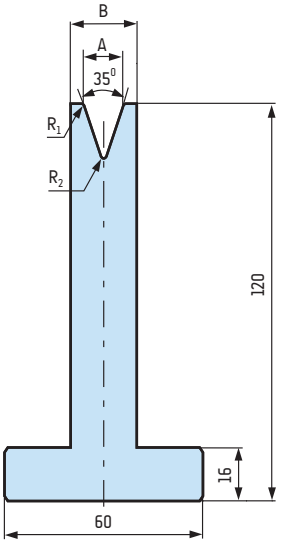
M 9530 30 t/m
A = 6 mm, B = 14 mm
R_1 = 0.8 mm, R = 0.8 mm

M 9630 50 t/m
A = 20 mm, B = 35 mm
R_1 = 4 mm, R_2 = 4 mm



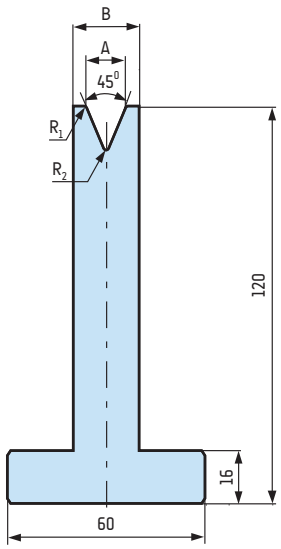
M 9135 35 t/m
A = 8 mm, B = 18 mm
R_1 = 1.5 mm, R_2 = 0.8 mm

M 9235 40 t/m
A = 12 mm, B = 18 mm
R_1 = 2 mm, R_2 = 1 mm



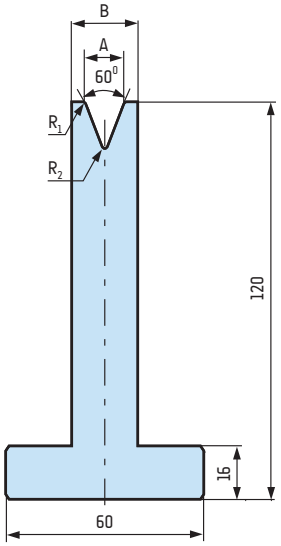
TYPE "A" DIES | MATRYCE TYPU „A"

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



M 9145 50 t/m
A = 10 mm, B = 18 mm
R_1 = 2 mm, R_2 = 1 mm

M 9245 50 t/m
A = 12 mm, B = 18 mm
R_1 = 2.5 mm, R_2 = 1 mm



M 9160 60 t/m
A = 8 mm, B = 14 mm
R_1 = 1.5 mm, R_2 = 0.8 mm

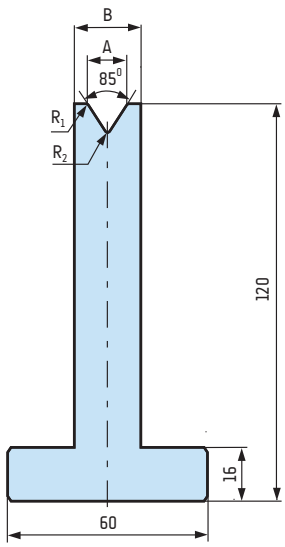
M 9260 60 t/m
A = 10 mm, B = 18 mm
R_1 = 2 mm, R_2 = 1 mm

M 9360 60 t/m
A = 12 mm, B = 18 mm
R_1 = 2.5 mm, R_2 = 1 mm

M 9460 60 t/m
A = 16 mm, B = 24 mm
R_1 = 1.5 mm, R_2 = 1.5 mm

M 9560 60 t/m
A = 20 mm, B = 30 mm
R_1 = 2 mm, R_2 = 2 mm

M 9660 60 t/m
A = 25 mm, B = 40 mm
R_1 = 3 mm, R_2 = 3 mm



M 9085 100 t/m
A = 8 mm, B = 14 mm
R_1 = 1 mm, R_2 = 0.5 mm

M 9185 100 t/m
A = 12 mm, B = 18 mm
R_1 = 2.5 mm, R_2 = 1 mm

M 9285 100 t/m
A = 16 mm, B = 24 mm
R_1 = 2.5 mm, R_2 = 1 mm

M 9385 100 t/m
A = 20 mm, B = 30 mm
R_1 = 3 mm, R_2 = 1.5 mm

M 9485 100 t/m
A = 25 mm, B = 40 mm
R_1 = 3 mm, R_2 = 3 mm

M 9585 100 t/m
A = 10 mm, B = 18 mm
R_1 = 1 mm, R_2 = 1 mm

M 9685 100 t/m
A = 14 mm, B = 18 mm
R_1 = 2.6 mm, R_2 = 0.4 mm

M 9785 100 t/m
A = 6 mm, B = 14 mm
R_1 = 0.5 mm, R_2 = 0.5 mm

TYPE ”A“ DIES | MATRYCE TYPU „A”

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

M 9088 100 t/m
A = 8 mm, B = 14 mm
R_1 = 1 mm, R_2 = 0.5 mm

M 9188 100 t/m
A = 12 mm, B = 18 mm
R_1 = 2.5 mm, R_2 = 1 mm

M 9288 100 t/m
A = 16 mm, B = 24 mm
R_1 = 2.5 mm, R_2 = 1 mm

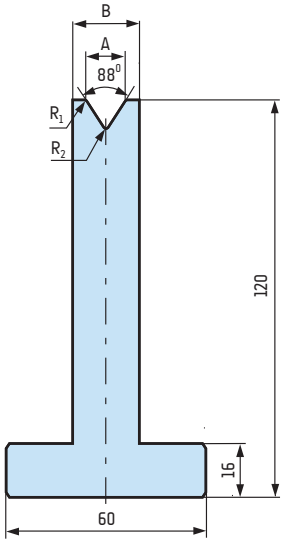
M 9388 100 t/m
A = 20 mm, B = 30 mm
R_1 = 3 mm, R_2 = 1.5 mm

M 9488 100 t/m
A = 25 mm, B = 40 mm
R_1 = 3 mm, R_2 = 3 mm

M 9588 100 t/m
A = 10 mm, B = 18 mm
R_1 = 1 mm, R_2 = 1 mm

M 9688 100 t/m
A = 14 mm, B = 18 mm
R_1 = 2.6 mm, R_2 = 0.4 mm

M 9788 100 t/m
A = 6 mm, B = 14 mm
R_1 = 0.5 mm, R_2 = 0.5 mm

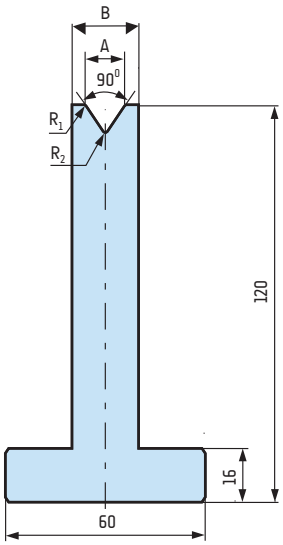


M 9190 100 t/m
A = 6 mm, B = 14 mm
R_1 = 1.5 mm, R_2 = 0.5 mm

M 9290 100 t/m
A = 8 mm, B = 14 mm
R_1 = 1.5 mm, R_2 = 0.8 mm

M 9390 100 t/m
A = 10 mm, B = 18 mm
R_1 = 2 mm, R_2 = 1 mm

M 9490 100 t/m
A = 12 mm, B = 18 mm
R_1 = 3 mm, R_2 = 0.8 mm



TYPE "A" DIES | MATRYCE TYPU „A"

Dies fixed using die supports A 31 or A 61 –> p. 84
Matryce montowane przy pomocy podpór A 31 lub A 61 –> str. 84

insert dies | matryce wkładkowe

42CrMo4

M 8130 35 t/m

α = 30°

A = 6 mm, B = 16 mm

R_1 = 1 mm

42CrMo4

M 8230 35 t/m

α = 30°

A = 8 mm, B = 19 mm

R_1 = 1.5 mm

42CrMo4

M 8330 50 t/m

α = 30°

A = 10 mm, B = 24 mm

R_1 =2 mm

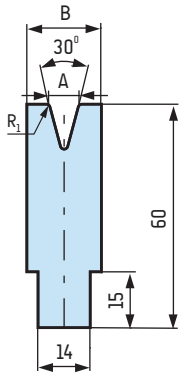
42CrMo4

M 8430 40 t/m

α = 30°

A = 12 mm, B = 25 mm

R_1 = 2.5 mm



42CrMo4

M 8160 60 t/m

α = 60°

A = 6 mm, B = 14 mm

R_1 = 0.6 mm

42CrMo4

M 8260 60 t/m

α = 60°

A = 8 mm, B = 15 mm

R_1 = 0.8 mm

42CrMo4

M 8360 60 t/m

α = 60°

A = 10 mm, B = 18 mm

R_1 = 1 mm

42CrMo4

M 8460 60 t/m

α = 60°

A = 12 mm, B = 18 mm

R_1 = 1.2 mm

42CrMo4

M 8560 60 t/m

α = 60°

A = 16 mm, B = 24 mm

R_1 = 1.6 mm

42CrMo4

M 8660 60 t/m

α = 60°

A = 20 mm, B = 30 mm

R_1 = 2 mm

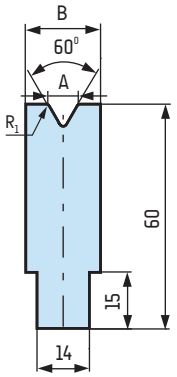
42CrMo4

M 8760 60 t/m

α = 60°

A = 25 mm, B = 33 mm

R_1 = 2.5 mm



TYPE "A" DIES | MATRYCE TYPU „A"

Dies fixed using die supports A 31 or A 61 –> p. 84
Matryce montowane przy pomocy podpór A 31 lub A 61 –> str. 84

insert dies | matryce wkładkowe

42CrMo4

M 8188 100 t/m

$\alpha = 88^0$

A = 6 mm, B = 14 mm

$R_1 = 1.5$ *mm*

42CrMo4

M 8288 100 t/m

$\alpha = 88^0$

A = 8 mm, B = 14 mm

$R_1 = 1.5$ *mm*

42CrMo4

M 8388 100 t/m

$\alpha = 88^0$

A = 10 mm, B = 15 mm

$R_1 = 2$ *mm*

42CrMo4

M 8488 100 t/m

$\alpha = 88^0$

A = 12 mm, B = 17 mm

$R_1 = 2.5$ *mm*

42CrMo4

M 8588 100 t/m

$\alpha = 88^0$

A = 14 mm, B = 18 mm

$R_1 = 2.5$ *mm*

42CrMo4

M 8688 100 t/m

$\alpha = 88^0$

A = 16 mm, B = 21 mm

$R_1 = 2.5$ *mm*

42CrMo4

M 8788 100 t/m

$\alpha = 88^0$

A = 18 mm, B = 23 mm

$R_1 = 2.5$ *mm*

42CrMo4

M 8888 100 t/m

$\alpha = 88^0$

A = 20 mm, B = 25 mm

$R_1 = 3$ *mm*

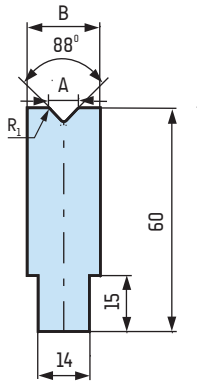
42CrMo4

M 8988 100 t/m

$\alpha = 88^0$

A = 25 mm, B = 30 mm

$R_1 = 3$ *mm*



42CrMo4

M 8190 100 t/m

$\alpha = 90^0$

A = 6 mm, B = 14 mm

$R_1 = 1.5$ *mm*

42CrMo4

M 8290 100 t/m

$\alpha = 90^0$

A = 8 mm, B = 14 mm

$R_1 = 1.5$ *mm*

42CrMo4

M 8390 100 t/m

$\alpha = 90^0$

A = 10 mm, B = 15 mm

$R_1 = 2$ *mm*

42CrMo4

M 8490 100 t/m

$\alpha = 90^0$

A = 12 mm, B = 17 mm

$R_1 = 2.5$ *mm*

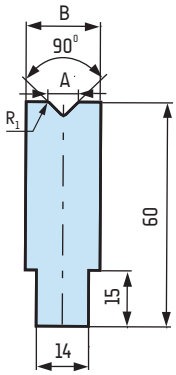
42CrMo4

M 8590 100 t/m

$\alpha = 90^0$

A = 14 mm, B = 18 mm

$R_1 = 2.5$ *mm*



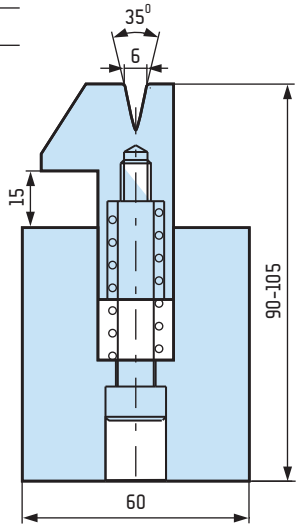
TYPE "A" DIES | MATRYCE TYPU „A"

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

flattening dies | matryce do zagniatania

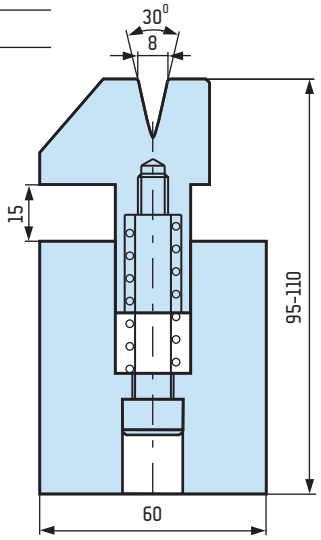
24h

M 3033/6	60 t/m
$\alpha = 35^0$	
$V = 6$ mm	
$R_1 = 1$ mm	



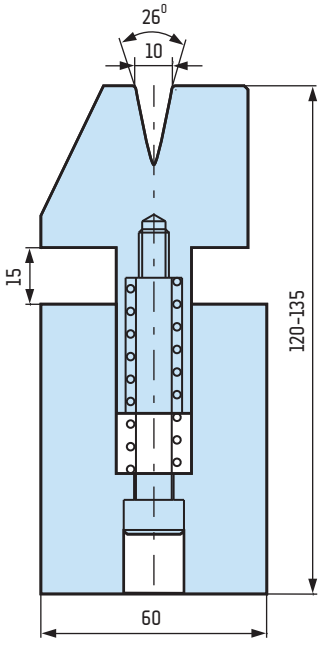
24h

M 3033/8	80 t/m
$\alpha = 30^0$	
$V = 8$ mm	
$R_1 = 1$ mm	



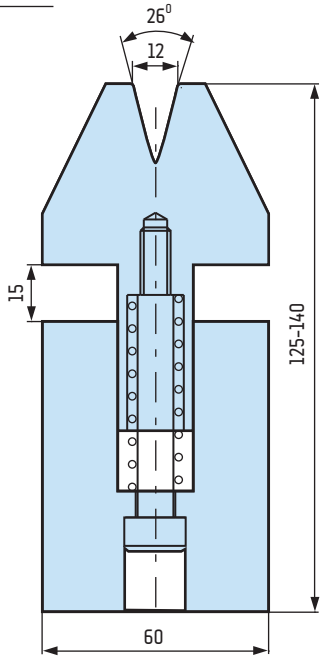
24h

M 3033/10	100 t/m
$\alpha = 26^0$	
$V = 10$ mm	
$R_1 = 1$ mm	



24h

M 3033/12	100 t/m
$\alpha = 26^0$	
$V = 12$ mm	
$R_1 = 1$ mm	



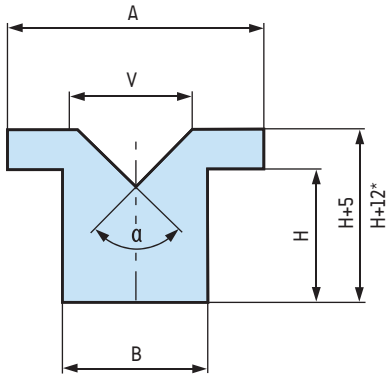
dies with plastic inserts | matryce z wkładkami plastikowymi

INSERT W 24 | **WKŁADKA W 24**	20 t/m
B = 14 mm, H = 15 mm, A = 24 mm	
α = 35°, V = 6 mm / 8 mm / 10 mm	
α = 45°, V = 6 mm / 8 mm / 10 mm / 12 mm	
α = 60°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm	
α = 88°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm	

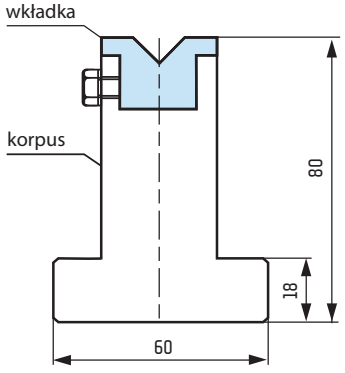
INSERT W 35 | **WKŁADKA W 35**	20 t/m
B = 20 mm, H = 19 mm, A = 35 mm	
α = 35°, V = 6 mm / 8 mm / 10 mm	
α = 45°, V = 6 mm / 8 mm / 10 mm / 12 mm	
α = 60°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm	
α = 88°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm / 25 mm	

INSERT W 35 | **WKŁADKA W 38**	20 t/m
B = 30 mm, H = 19 mm, A = 38 mm	
α = 30°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm	
α = 60°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm	
α = 88°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm / 25 mm	

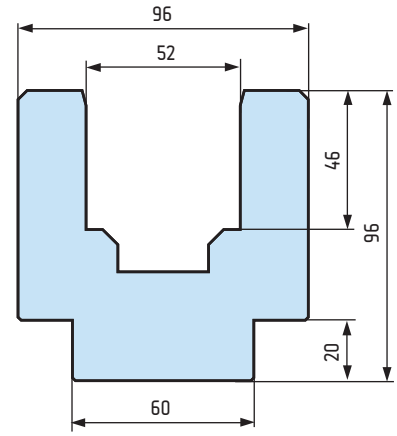
** for W 38 / dla W 38*



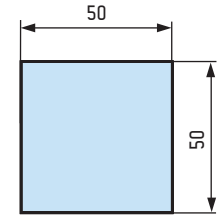
BODY | **KORPUS W 24 / W 35 / W 38**



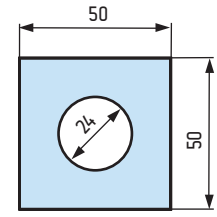
BODY W 50 | **KORPUS W 50**



INSERT 50 FULL | **WKŁADKA 50 PEŁNA**



INSERT 50 WITH HOLE | **WKŁADKA 50 Z OTWOREM**

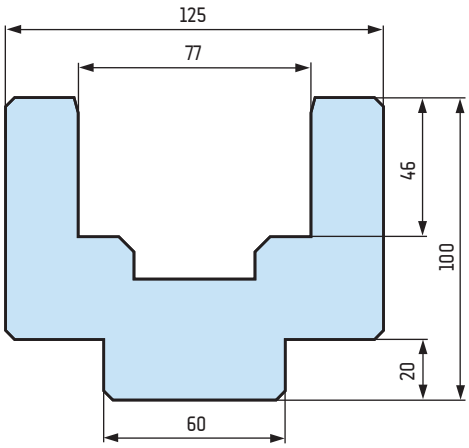


Polyamid inserts allow to minimize bending marks on coated or stainless steel.

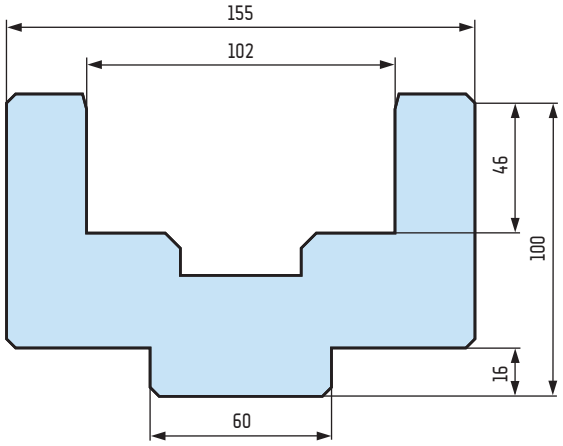
Wkładki poliamidowe pozwalają zminimalizować ślady przy gięciu cienkich blach pokrywanych lub nierdzewnych.

dies with plastic inserts | matryce z wkładkami plastikowymi

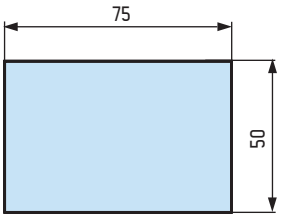
BODY W 75 | **KORPUS W 75**



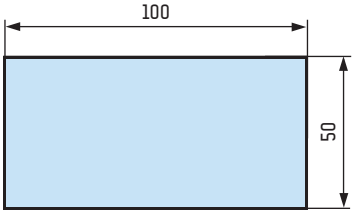
BODY W 100 | **KORPUS W 100**



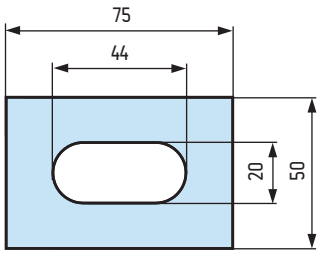
INSERT 75 FULL | **WKŁADKA 75 PEŁNA**



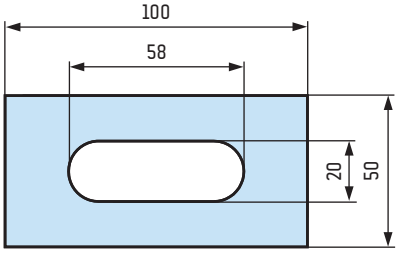
INSERT 100 FULL | **WKŁADKA 100 PEŁNA**



INSERT 75 WITH HOLE | **WKŁADKA 75 Z OTWOREM**



INSERT 100 WITH HOLE | **WKŁADKA 100 Z OTWOREM**



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

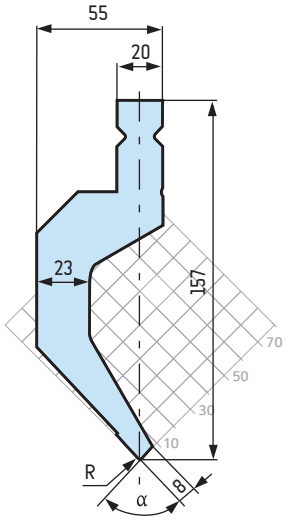
Wkładki gumowe pozwalają na gięcie bez uszkodzeń blachy. Szczególnie polecane ze stemplami „R".

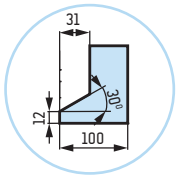
42CrMo4

S 2200 80 t/m

$\alpha = 86^0$

$R = 1$ mm $TH = 16$ t/m



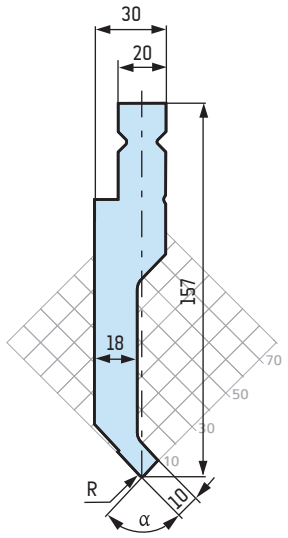


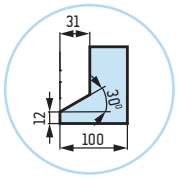
42CrMo4

S 2201 80 t/m

$\alpha = 86^0$

$R = 1$ mm $TH = 22$ t/m



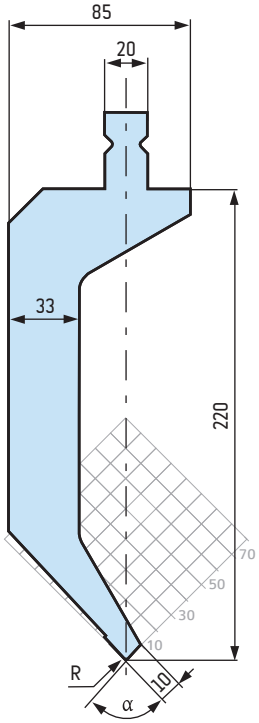


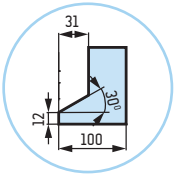
42CrMo4

S 2200 W 80 t/m

$\alpha = 86^0$

$R = 1$ mm $TH = 20$ t/m



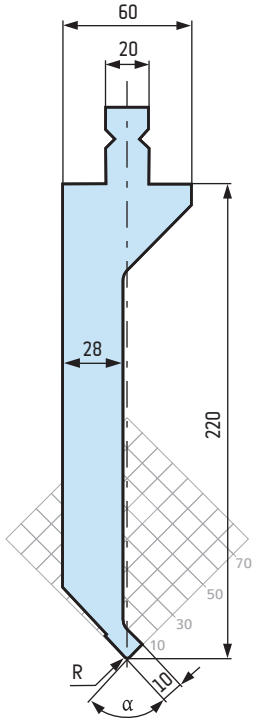


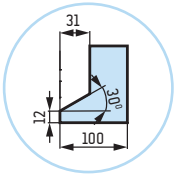
42CrMo4

S 2201 W 80 t/m

$\alpha = 86^0$

$R = 1$ mm $TH = 27$ t/m





42CrMo4

S 2202 60 t/m

$\alpha = 28^0$

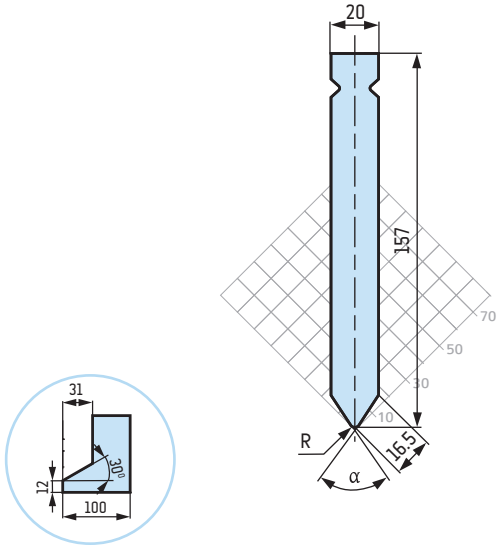
R = 1 mm *TH = 10 t/m*

42CrMo4

S 2203 130 t/m

$\alpha = 60^0$

R = 4 mm *TH = 60 t/m*

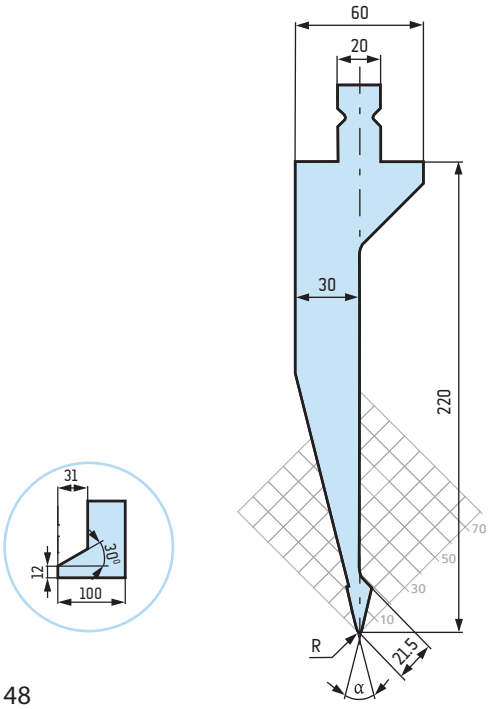


42CrMo4

S 2202 W 60 t/m

$\alpha = 28^0$

R = 1 mm *TH = 12 t/m*

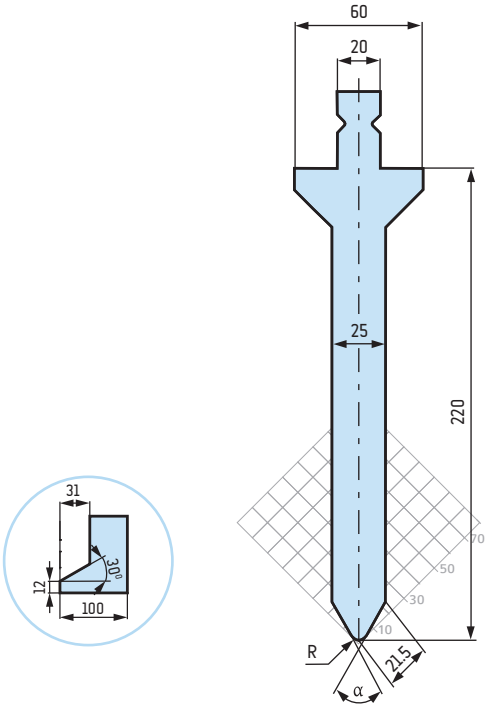


42CrMo4

S 2203 W 130 t/m

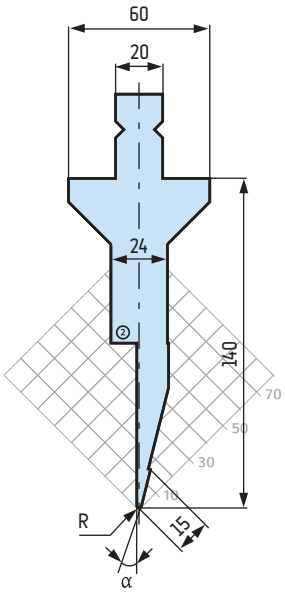
$\alpha = 60^0$

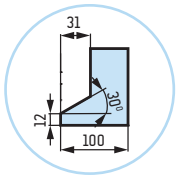
R = 4 mm *TH = 85 t/m*



42CrMo4

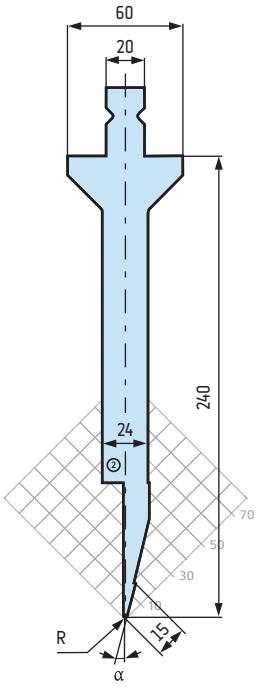
S 2204	40 t/m
② 130 t/m	
$\alpha = 14^0$	
$R = 1$ mm	$TH = 22$ t/m

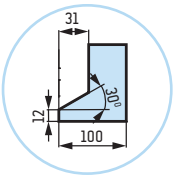




42CrMo4

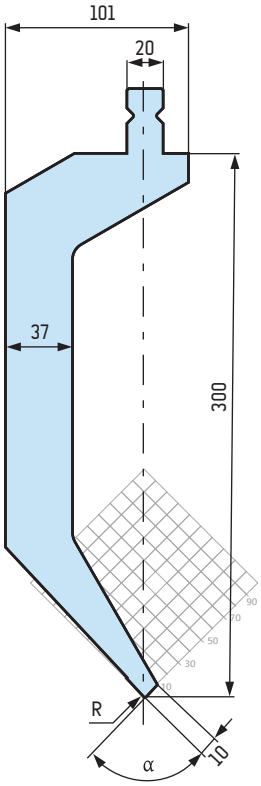
S 2204 W	40 t/m
② 130 t/m	
$\alpha = 14^0$	
$R = 1$ mm	$TH = 30$ t/m

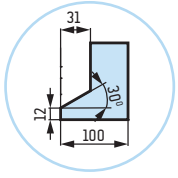




42CrMo4

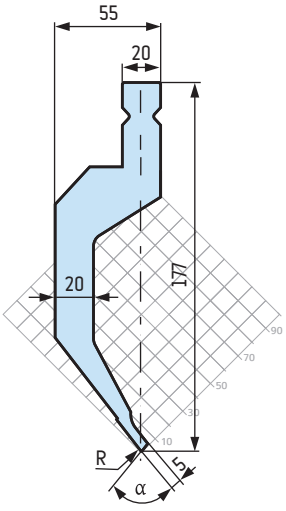
S 2300 W	80 t/m
$\alpha = 86^0$	
$R = 1$ mm	$TH = 22$ t/m

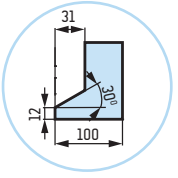




42CrMo4

S 2280	20 t/m
$\alpha = 80^0$	
$R = 0.5$ mm	$TH = 7$ t/m

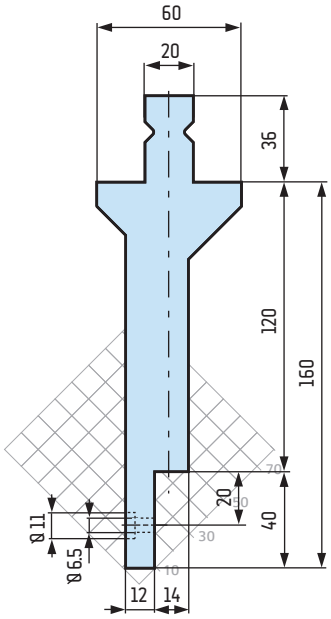




insert punch | stempel z wkładką

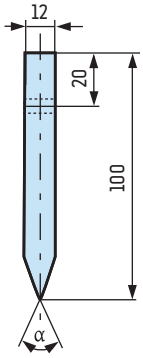
42CrMo4

S 2206 100 t/m



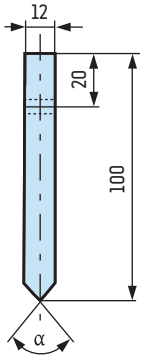
WKŁADKA R 0.3 – R 6

α = 28⁰



WKŁADKA R 0.2 – R 1.5

α = 84⁰, 86⁰, 90⁰

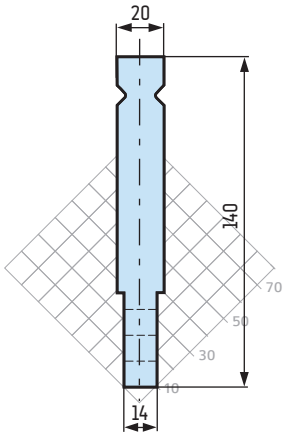


radius punch | stempel promieniowy

42CrMo4

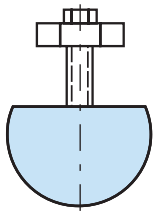
S 2207 80 t/m

L = 415 mm, 835 mm



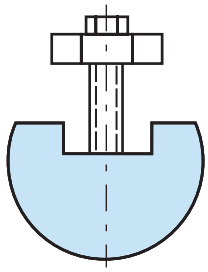
WKŁADKA R 7 – R 12

L = 415 mm, 835 mm



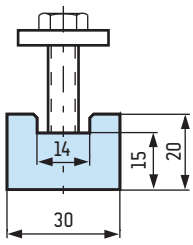
WKŁADKA R 12.5 – R 50

L = 415 mm, 835 mm



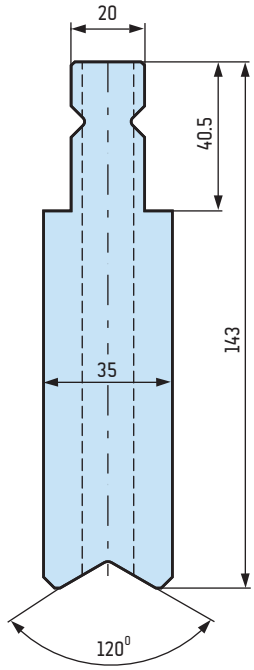
FLATTENING INSERT | **WKŁADKA PŁASKA**

L = 415 mm, 835 mm



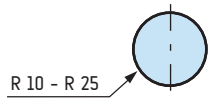
42CrMo4

S 2208 R 10 – R 25 100 t/m



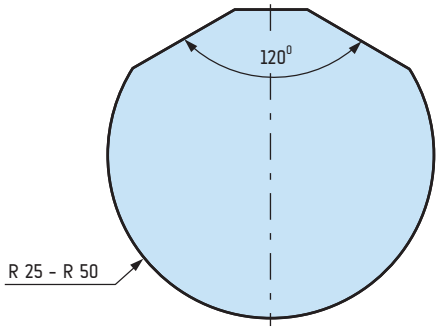
R 10 – R 25

** for punch / dla stempli S 2208*



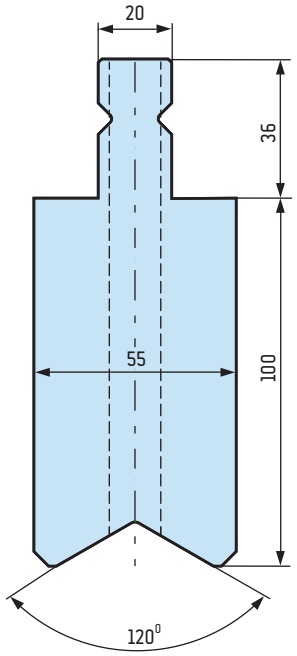
R 25 – R 50

** for punch / dla stempli S 2208*



42CrMo4

S 2208 W R 25 – R 50 100 t/m



flattening tools | **zestaw do zagniatania**

42CrMo4

S 2205 70 t/m

α = 26°

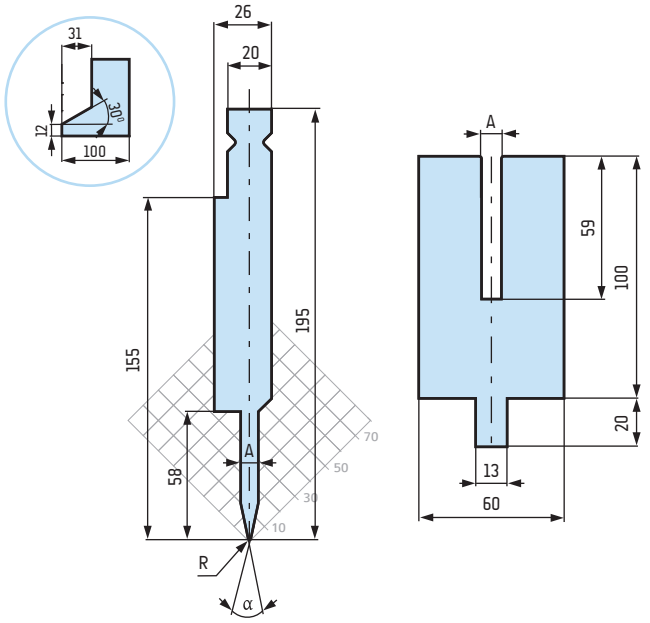
A = 8 mm, 10 mm, 12 mm

R = 0.6 mm *TH = 30 t/m*

42CrMo4

M 2000 70 t/m

A = 8 mm, 10 mm, 12 mm



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

42CrMo4

M 7106 100 t/m
A = 6 mm, B = 20 mm
R_1 = 0.6 mm

42CrMo4

M 7108 100 t/m
A = 8 mm, B = 20 mm
R_1 = 0.8 mm

42CrMo4

M 7110 100 t/m
A = 10 mm, B = 20 mm
R_1 = 1 mm

42CrMo4

M 7112 100 t/m
A = 12 mm, B = 25 mm
R_1 = 1 mm

42CrMo4

M 7116 100 t/m
A = 16 mm, B = 30 mm
R_1 = 1.6 mm

42CrMo4

M 7120 100 t/m
A = 20 mm, B = 30 mm
R_1 = 2 mm

42CrMo4

M 7124 100 t/m
A = 24 mm, B = 35 mm
R_1 = 2.5 mm

42CrMo4

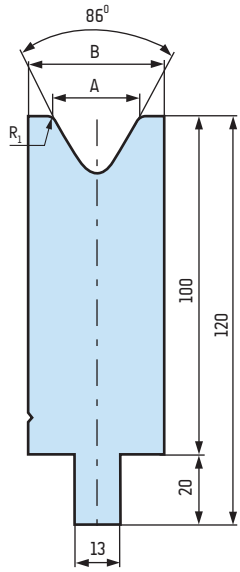
M 7130 100 t/m
A = 30 mm, B = 45 mm
R_1 = 3 mm

42CrMo4

M 7140 100 t/m
A = 40 mm, B = 55 mm
R_1 = 3 mm

42CrMo4

M 7150 100 t/m
A = 50 mm, B = 75 mm
R_1 = 3 mm



42CrMo4

M 7224 100 t/m
A = 24 mm, B = 35 mm
R_1 = 2.5 mm

42CrMo4

M 7230 100 t/m
A = 30 mm, B = 45 mm
R_1 = 5 mm

42CrMo4

M 7240 100 t/m
A = 40 mm, B = 55 mm
R_1 = 5 mm

42CrMo4

M 7250 100 t/m
A = 50 mm, B = 65 mm
R_1 = 5 mm

42CrMo4

M 7260 100 t/m
A = 60 mm, B = 75 mm
R_1 = 5 mm

42CrMo4

M 7280 100 t/m
A = 80 mm, B = 100 mm
R_1 = 5 mm

42CrMo4

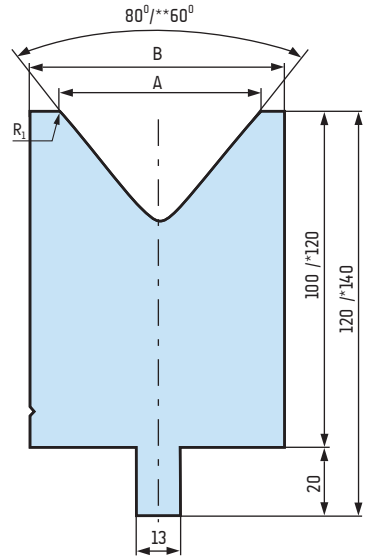
M 7290 100 t/m*
A = 90 mm, B = 110 mm
R_1 = 8 mm

42CrMo4

M 72100 100 t/m*
A = 100 mm, B = 120 mm
R_1 = 8 mm

42CrMo4

M 72120 100 t/m**
A = 120 mm, B = 145 mm
H = 120 mm
α = 60°
R_1 = 8 mm



42CrMo4

M 7306 50 t/m
A = 6 mm, B = 20 mm
R_1 = 0.6 mm

42CrMo4

M 7308 40 t/m
A = 8 mm, B = 20 mm
R_1 = 1 mm

42CrMo4

M 7310 40 t/m
A = 10 mm, B = 20 mm
R_1 = 1 mm

42CrMo4

M 7312 40 t/m
A = 12 mm, B = 25 mm
R_1 = 1 mm

42CrMo4

M 7316 45 t/m
A = 16 mm, B = 30 mm
R_1 = 1.6 mm

42CrMo4

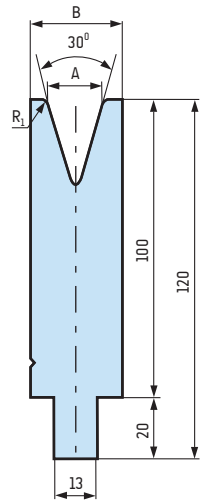
M 7320 50 t/m
A = 20 mm, B = 35 mm
R_1 = 2 mm

42CrMo4

M 7324 50 t/m
A = 24 mm, B = 40 mm
R_1 = 2.5 mm

42CrMo4

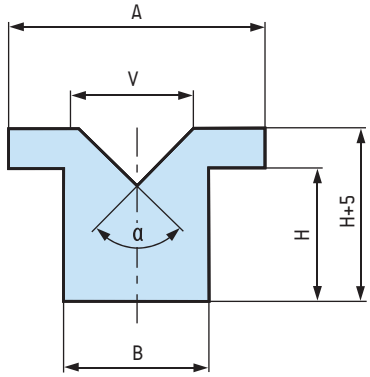
M 7330 70 t/m
A = 30 mm, B = 55 mm
R_1 = 3 mm



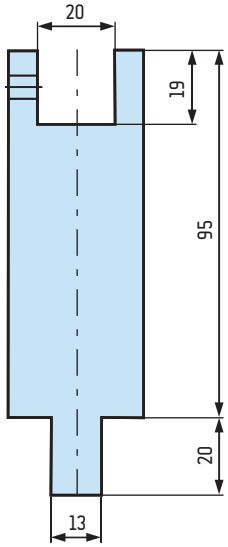
TYPE ”T“ DIES | MATRYCE TYPU „T”

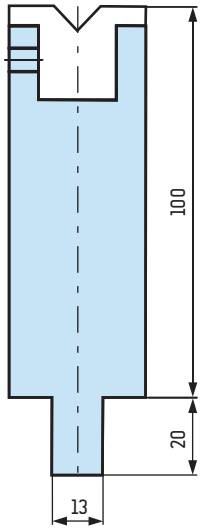
dies with plastic inserts
matryce z wkładkami poliamidowymi

INSERT W 35-T | **WKŁADKA W 35-T**	20 t/m
B = 20 mm, H = 19 mm, A = 35 mm	
α = 35°, V = 6 mm / 8 mm / 10 mm	
α = 45°, V = 6 mm / 8 mm / 10 mm / 12 mm	
α = 60°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm	
α = 88°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm / 25 mm	



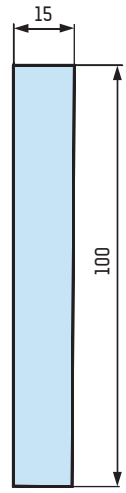
BODY | **KORPUS W 35-T**



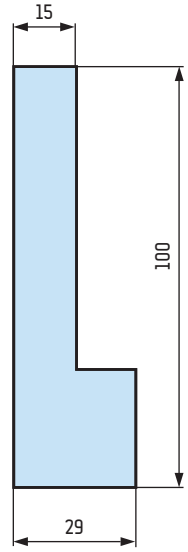


flattening inserts
wkładki do zapłaszczania

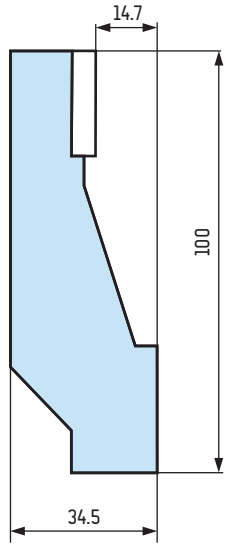
INSERT T 1 | **WKŁADKA T 1**



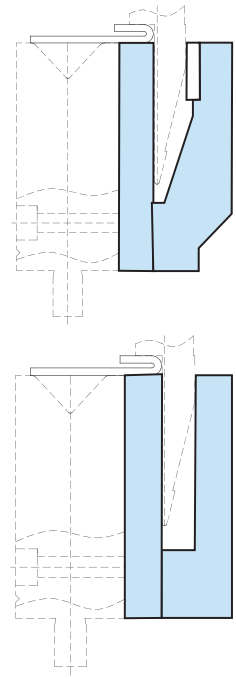
INSERT T 2 | **WKŁADKA T 2**



INSERT T 3 | **WKŁADKA T 3**



ASSAMBLE | **PRZYKŁAD MONTAŻU**

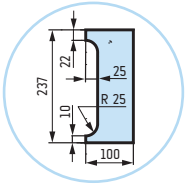


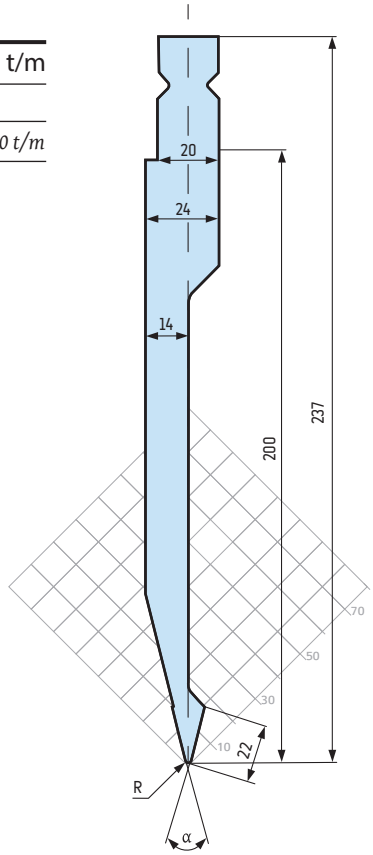
42CrMo4

S 2231 60 t/m

α = 28°

R = 1 mm *WH = 20 t/m*



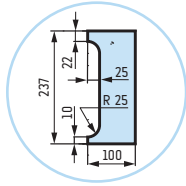


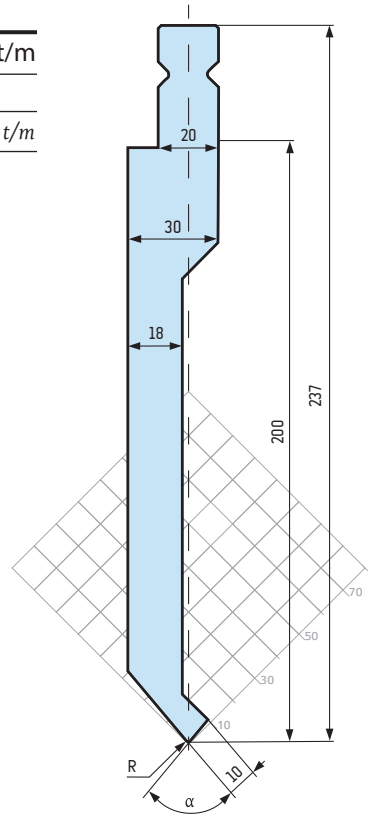
42CrMo4

S 2232 70 t/m

α = 80°

R = 1 mm *WH = 15 t/m*



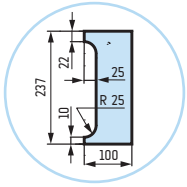


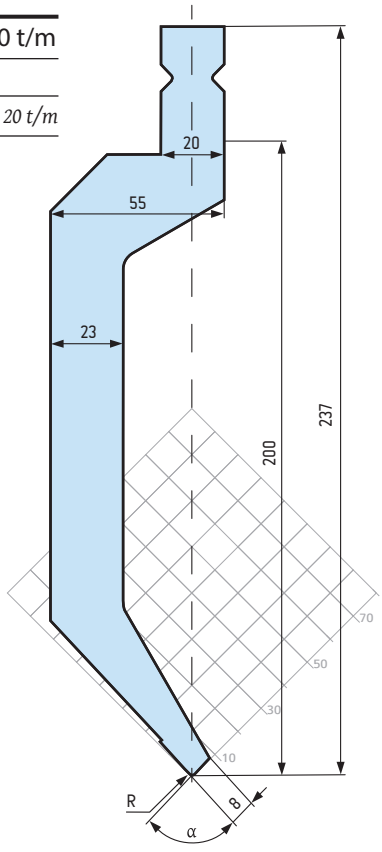
42CrMo4

S 2233 50 t/m

α = 86°

R = 1 mm *WH = 20 t/m*



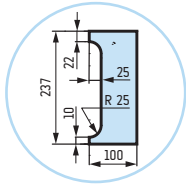


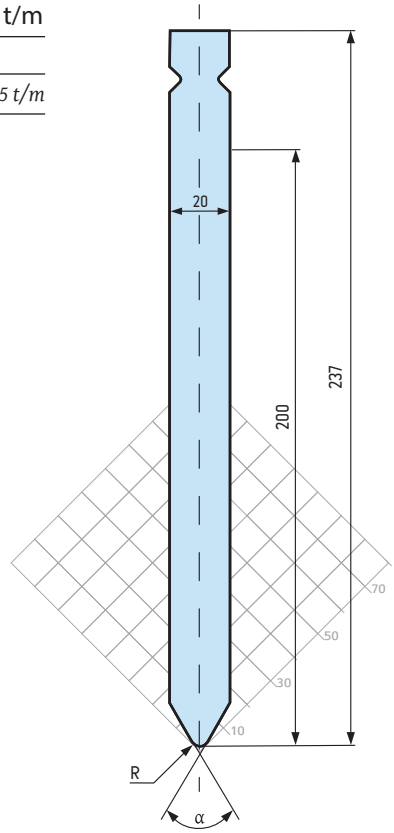
42CrMo4

S 2234 160 t/m

α = 60°

R = 3 mm *WH = 55 t/m*





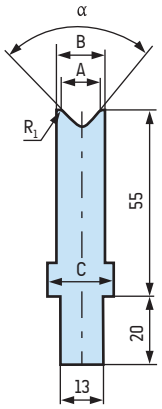
TYPE ”W“ DIES 55 MM | MATRYCE TYPU „W” 55 MM

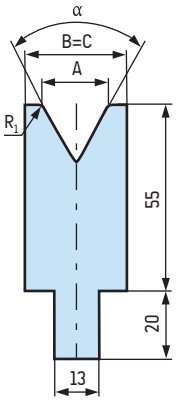
42CrMo4

M 7406	100 t/m
$\alpha = 90^0$	
A = 6 mm, B = 15 mm, C = 20 mm	
R_1 = 0.6 mm	

42CrMo4

M 7408	100 t/m
$\alpha = 90^0$	
A = 8 mm, B = 15 mm, C = 20 mm	
R_1 = 1 mm	





42CrMo4

M 7410	100 t/m
$\alpha = 88^0$	
A = 10 mm, B = 20 mm, C = 20 mm	
R_1 = 1 mm	

42CrMo4

M 7412	100 t/m
$\alpha = 88^0$	
A = 12 mm, B = 20 mm, C = 20 mm	
R_1 = 1.5 mm	

42CrMo4

M 7416	100 t/m
$\alpha = 88^0$	
A = 16 mm, B = 30 mm, C = 30 mm	
R_1 = 1.5 mm	

42CrMo4

M 7420	100 t/m
$\alpha = 88^0$	
A = 20 mm, B = 30 mm, C = 30 mm	
R_1 = 2 mm	

42CrMo4

M 7424	100 t/m
$\alpha = 88^0$	
A = 24 mm, B = 40 mm, C = 40 mm	
R_1 = 2 mm	

42CrMo4

M 7432	100 t/m
$\alpha = 85^0$	
A = 32 mm, B = 50 mm, C = 50 mm	
R_1 = 4 mm	

42CrMo4

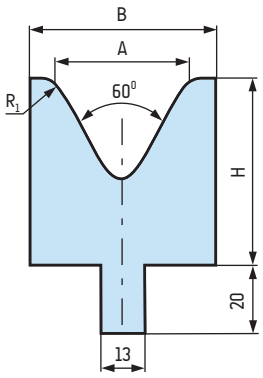
M 7440	100 t/m
$\alpha = 85^0$	
A = 40 mm, B = 55 mm, C = 55 mm	
R_1 = 4 mm	

42CrMo4

M 7540	80 t/m
A = 40 mm, B = 55 mm	
H = 55 mm	
R_1 = 4 mm	

42CrMo4

M 7560	60 t/m
A = 60 mm, B = 80 mm	
H = 65 mm	
R_1 = 7 mm	



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

42CrMo4

M 7606 35 t/m

A = 6 mm, B = 15 mm, C = 20 mm

H = 55 mm

R_1 = 0.8 mm

42CrMo4

M 7608 35 t/m

A = 8 mm, B = 15 mm, C = 20 mm

H = 55 mm

R_1 = 2 mm

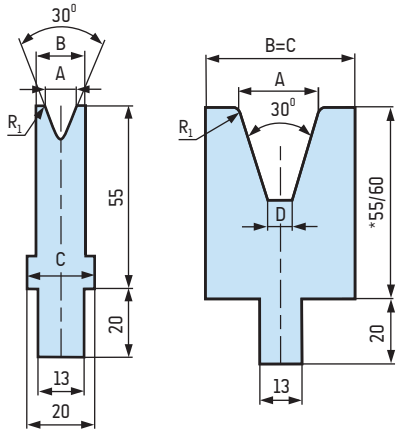
42CrMo4

M 7610 40 t/m

A = 10 mm, B = 20 mm, C = 20 mm

H = 55 mm

R_1 = 1 mm



42CrMo4

M 7612 40 t/m

A = 12 mm, B = 20 mm, C = 20 mm

H = 55 mm

R_1 = 1.5 mm

42CrMo4

M 7616 45 t/m

A = 16 mm, B = 30 mm, C = 30 mm

H = 55 mm

R_1 = 2 mm

42CrMo4

M 7620 50 t/m

A = 20 mm, B = 35 mm, C = 35 mm

H = 55 mm

R_1 = 2.5 mm

42CrMo4

M 7624 50 t/m

A = 24 mm, B = 40 mm, C = 40 mm

H = 55 mm

R_1 = 3 mm

42CrMo4

M 7632 50 t/m

A = 32 mm, B = 60 mm, C = 60 mm

H = 60 mm

R_1 = 2 mm

42CrMo4

M 7706 100 t/m

α = 86°

A = 6 mm, B = 16 mm, C = 25 mm

R_1 = 1 mm

42CrMo4

M 7708 100 t/m

α = 86°

A = 8 mm, B = 16 mm, C = 25 mm

R_1 = 1 mm

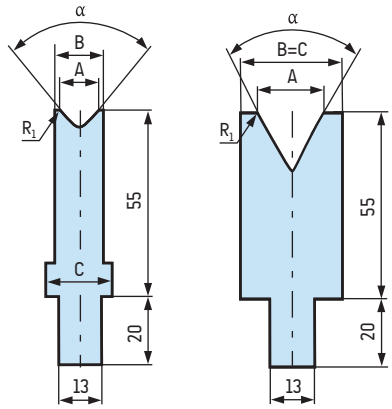
42CrMo4

M 7710 100 t/m

α = 86°

A = 10 mm, B = 20 mm, C = 25 mm

R_1 = 1 mm



42CrMo4

M 7712 100 t/m

α = 86°

A = 12 mm, B = 20 mm, C = 25 mm

R_1 = 1 mm

42CrMo4

M 7716 100 t/m

α = 86°

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

R_1 = 1.5 mm

42CrMo4

M 7720 100 t/m

α = 86°

A = 20 mm, B = 30 mm, C = 30 mm

R_1 = 2 mm

42CrMo4

M 7824 100 t/m

α = 80°

A = 24 mm, B = 35 mm, C = 35 mm

R_1 = 2.5 mm

42CrMo4

M 7830 100 t/m

α = 80°

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

R_1 = 3 mm

42CrMo4

M 7840 100 t/m

α = 80°

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

R_1 = 4 mm

42CrMo4

M 7850 100 t/m

α = 80°

A = 50 mm, B = 75 mm, C = 75 mm

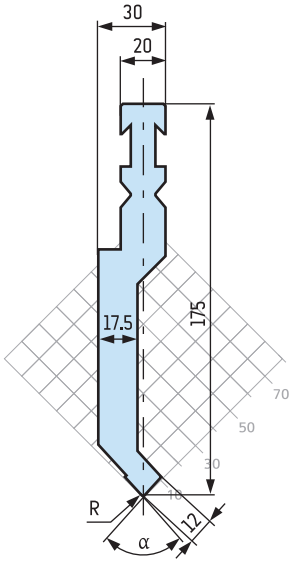
R_1 = 5 mm

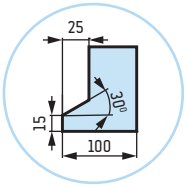
42CrMo4

S 2403 80 t/m

$\alpha = 85^0$

R = 1 mm *BH = 27 t/m*



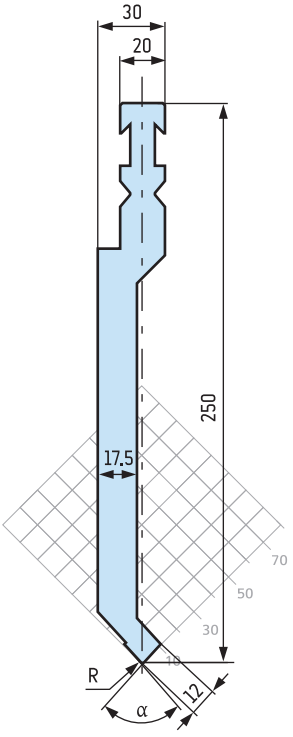


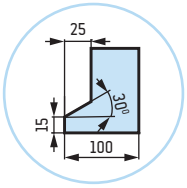
42CrMo4

S 2403 W 70 t/m

$\alpha = 85^0$

R = 1 mm *BH = 30 t/m*



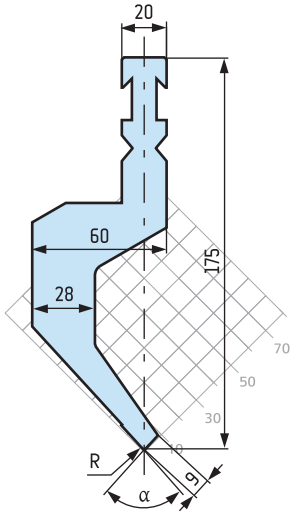


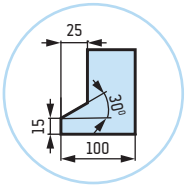
42CrMo4

S 2404 40 t/m

$\alpha = 85^0$

R = 1 mm *BH = 15 t/m*



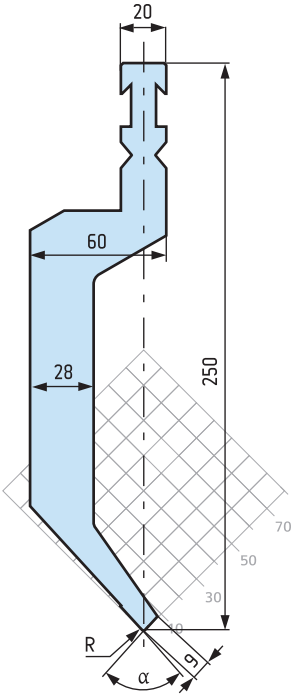


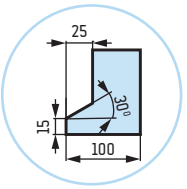
42CrMo4

S 2404 W 40 t/m

$\alpha = 85^0$

R = 1 mm *BH = 15 t/m*



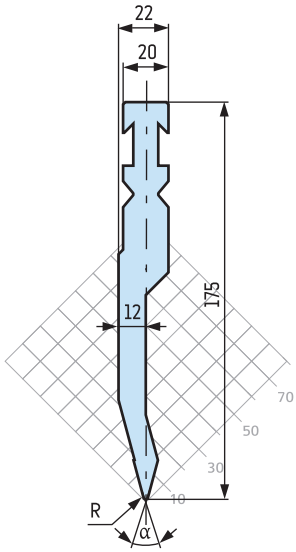


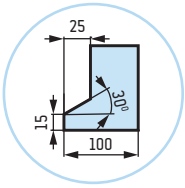
42CrMo4

S 2405 100 t/m

$\alpha = 30^0$

R = 1 mm *BH = 30 t/m*



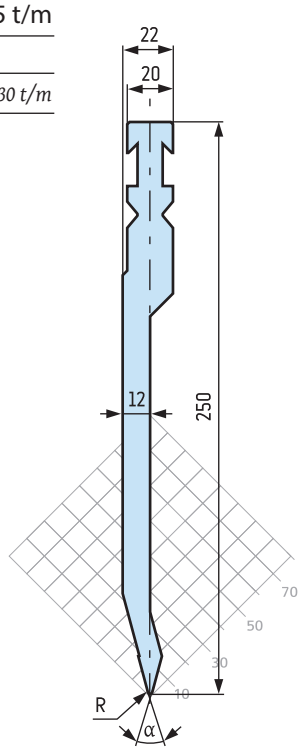


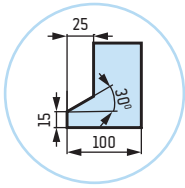
42CrMo4

S 2405 W 75 t/m

$\alpha = 30^0$

R = 1 mm *BH = 30 t/m*



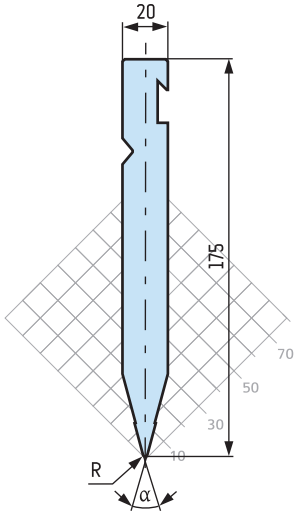


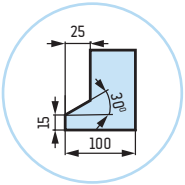
42CrMo4

S 2406 160 t/m

$\alpha = 30^0$

R = 1 mm *BH = 45 t/m*



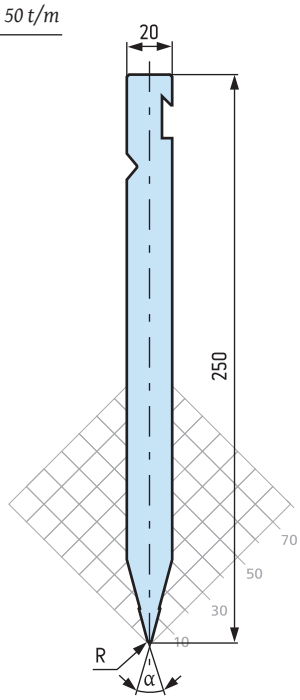


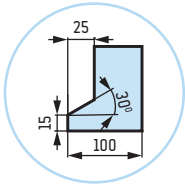
42CrMo4

S 2406 W 140 t/m

$\alpha = 30^0$

R = 1 mm *BH = 50 t/m*



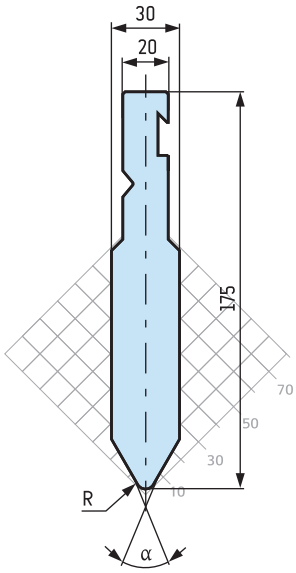


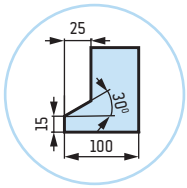
42CrMo4

S 2409 160 t/m

α = 60°

R = 4 mm *BH = 60 t/m*



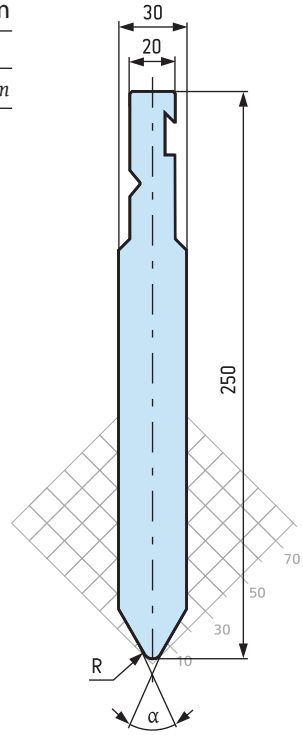


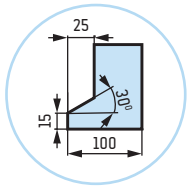
42CrMo4

S 2409 W 160 t/m

α = 60°

R = 4 mm *BH = 60 t/m*





42CrMo4

S 2433 70 t/m

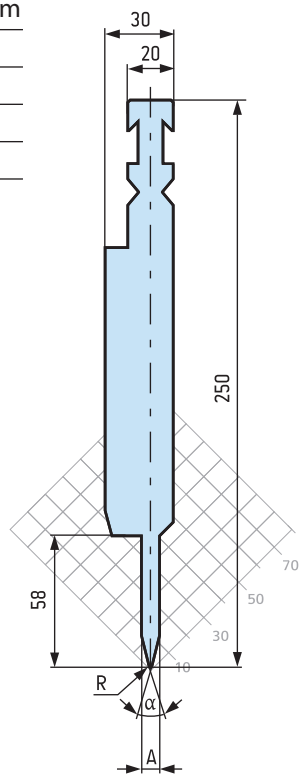
α = 28°

A = 8 mm, 10 mm, 12 mm

R = 0.6 mm

L = 500 mm

** Do użycia w zestawie z matrycą M 2000*

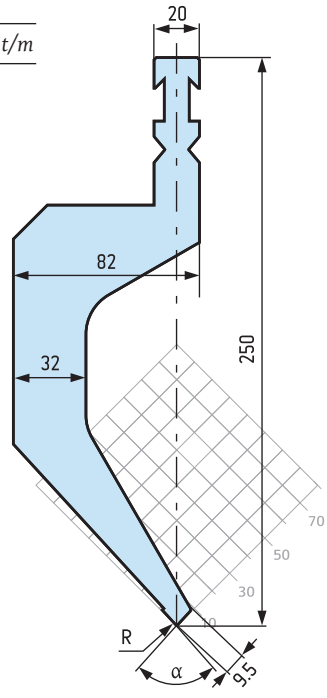


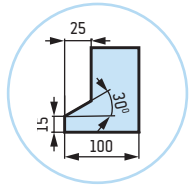
42CrMo4

S 2437 70 t/m

α = 85°

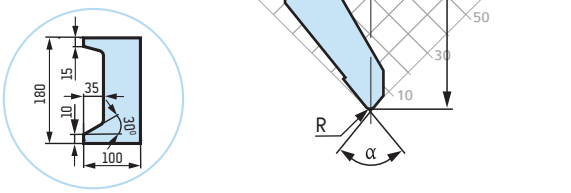
R = 0.8 mm *BH = 20 t/m*





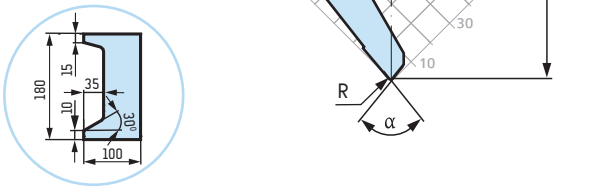
42CrMo4

S 2510 C	70 t/m
$\alpha = 78^0$	
$R = 2$ mm	$LH1 = 18$ t/m



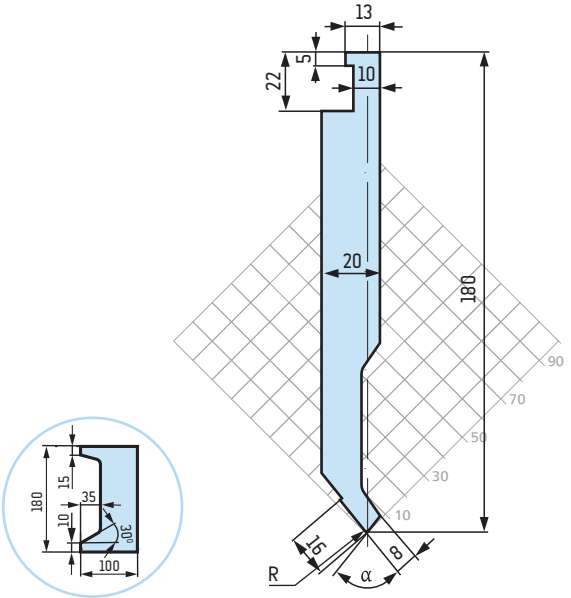
42CrMo4

S 2510 D	40 t/m
$\alpha = 78^0$	
$R = 1$ mm	$LH1 = 15$ t/m



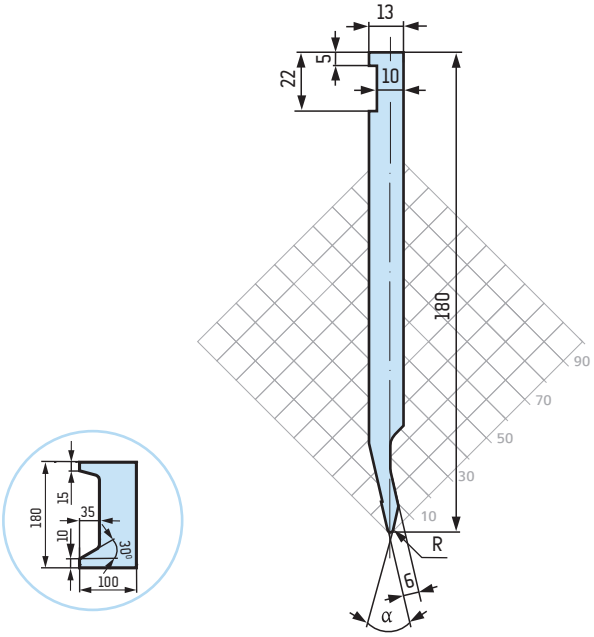
42CrMo4

S 2510 E	40 t/m
$\alpha = 78^0$	
$R = 1$ mm	$LH1 = 13$ t/m



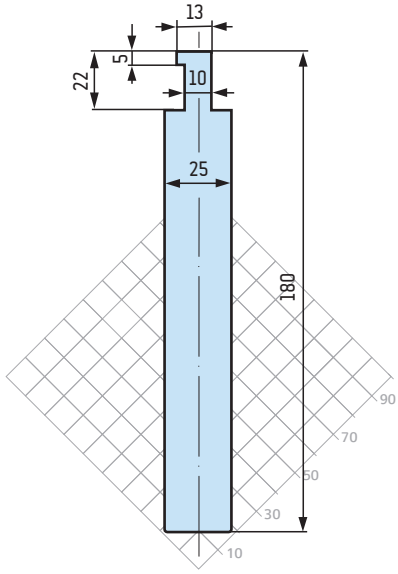
42CrMo4

S 2510 F	40 t/m
$\alpha = 26^0$	
$R = 1$ mm	$LH1 = 10$ t/m



42CrMo4

S 2510 H 150 t/m

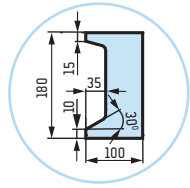


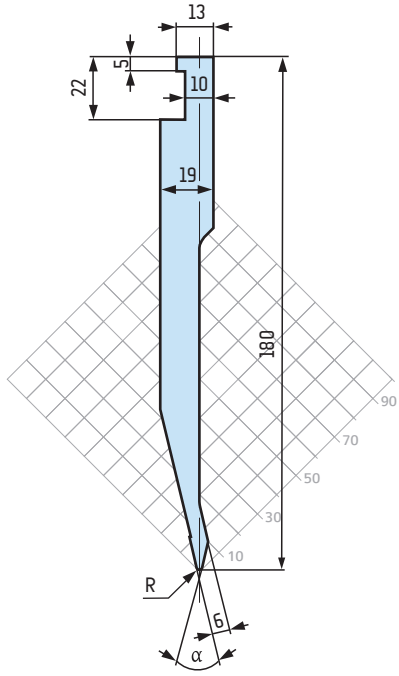
42CrMo4

S 2510 J 40 t/m

α = 26°

R = 1 mm *LH1 = 11 t/m*





42CrMo4

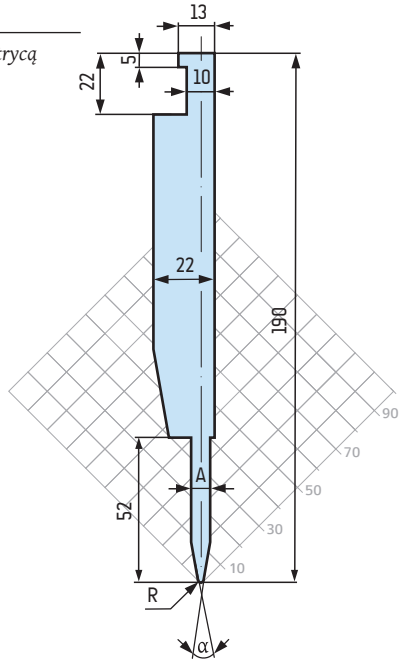
S 2510 P 40 t/m

α = 20°

R = 1 mm

A = 8 mm, 10 mm, 12 mm

* *Do użycia w zestawie z matrycą M 5000*

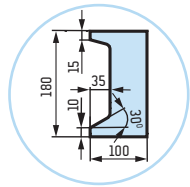


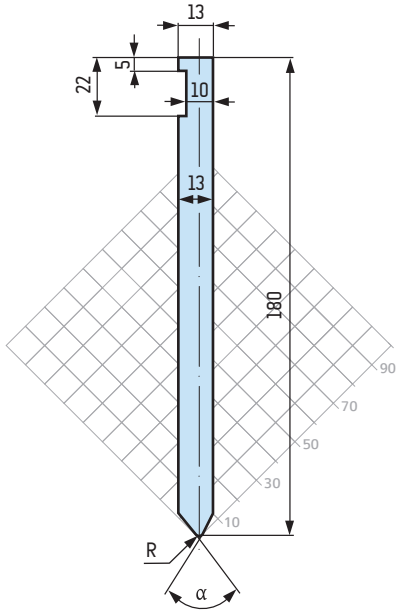
42CrMo4

S 2510 R 80 t/m

α = 78°

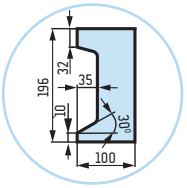
R = 2 mm *LH1 = 30 t/m*

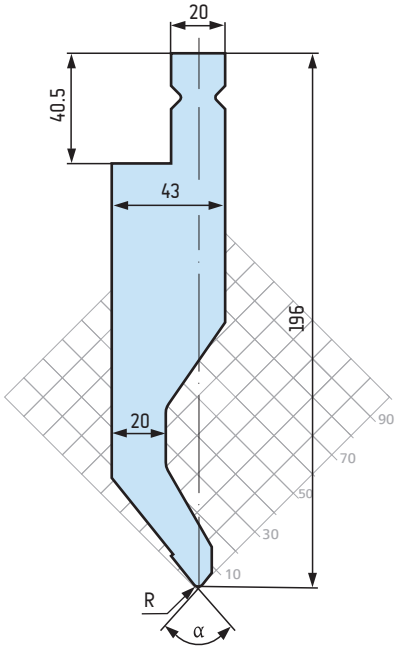




42CrMo4

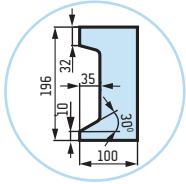
S 2610 C	70 t/m
$\alpha = 78^0$	
$R = 2\ mm$	$LH2 = 20\ t/m$

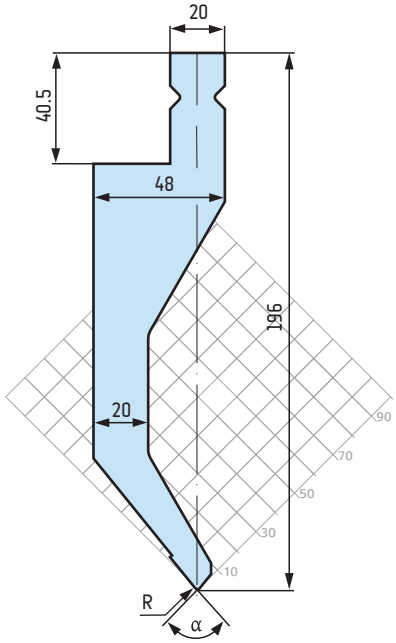




42CrMo4

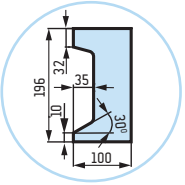
S 2610 D	50 t/m
$\alpha = 78^0$	
$R = 1\ mm$	$LH2 = 15\ t/m$

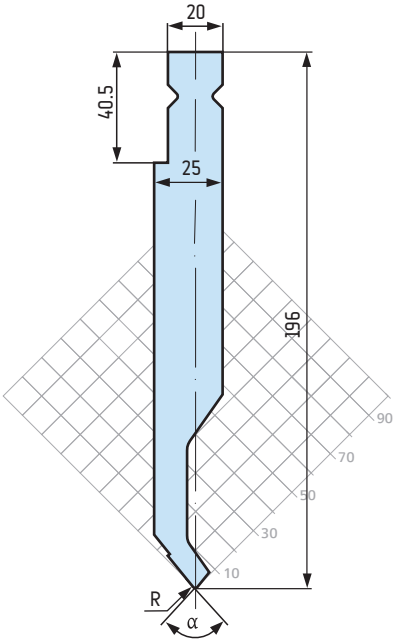




42CrMo4

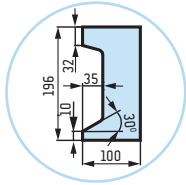
S 2610 E	40 t/m
$\alpha = 78^0$	
$R = 1\ mm$	$LH2 = 13\ t/m$

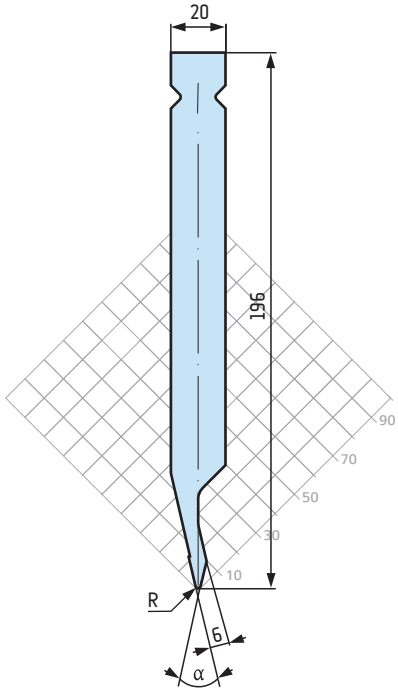




42CrMo4

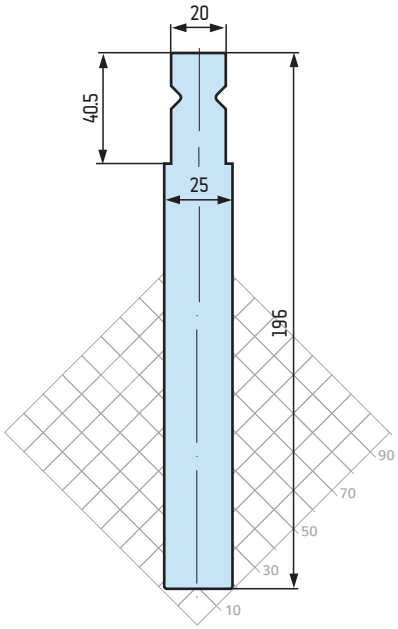
S 2610 F	40 t/m
$\alpha = 26^0$	
$R = 1\ mm$	$LH2 = 10\ t/m$





42CrMo4

S 2610 H 160 t/m

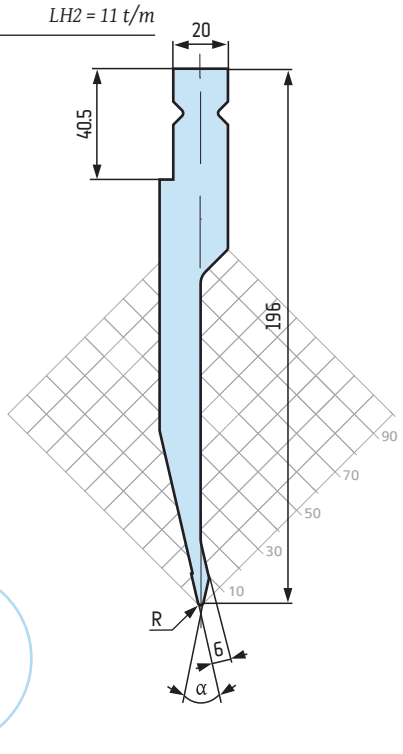


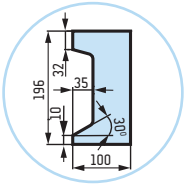
42CrMo4

S 2610 J 40 t/m

α = 26⁰

R = 1 mm *LH2 = 11 t/m*





42CrMo4

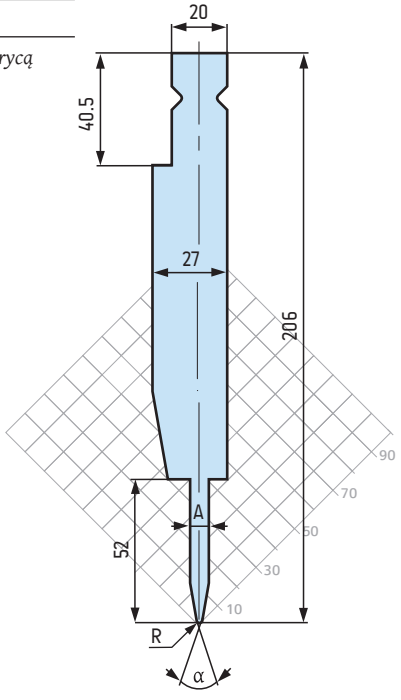
S 2610 P 40 t/m

α = 20⁰

R = 1 mm

A = 8 mm, 10 mm, 12 mm

* *Do użycia w zestawie z matrycą M 5000*

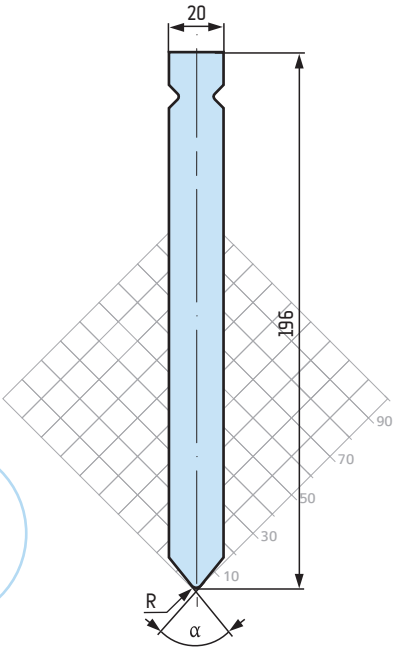


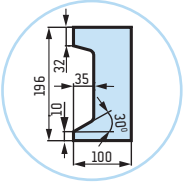
42CrMo4

S 2610 R 120 t/m

α = 78⁰

R = 2 mm *LH2 = 50 t/m*



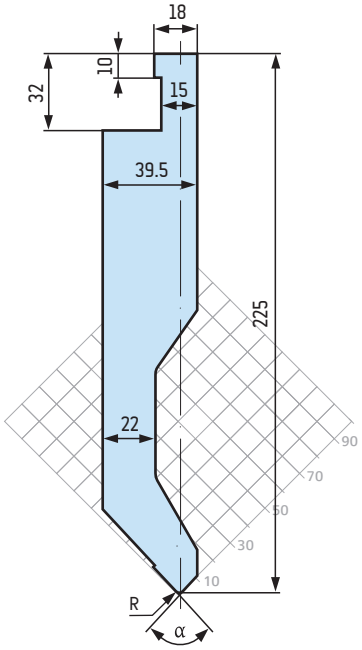


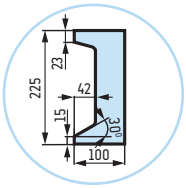
42CrMo4

S 2515 C 80 t/m

$\alpha = 78^0$

R = 2 mm *LH3 = 22 t/m*



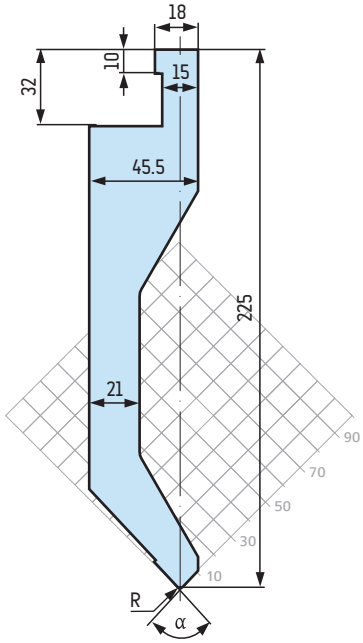


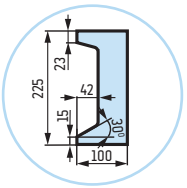
42CrMo4

S 2515 D 75 t/m

$\alpha = 78^0$

R = 2 mm *LH3 = 20 t/m*



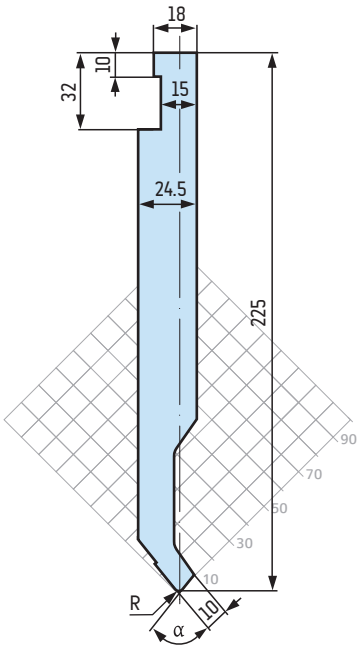


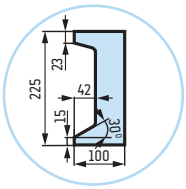
42CrMo4

S 2515 E 50 t/m

$\alpha = 78^0$

R = 2 mm *LH3 = 19 t/m*



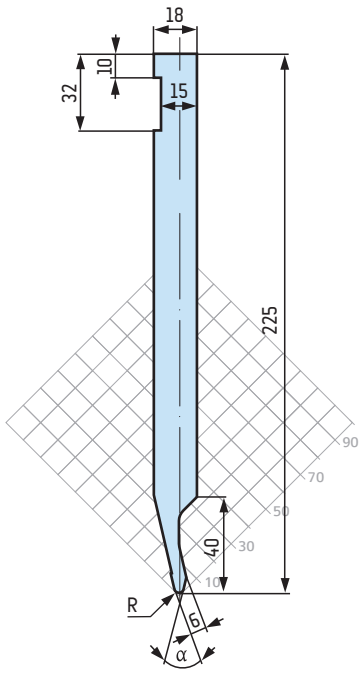


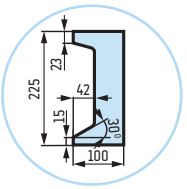
42CrMo4

S 2515 F 50 t/m

$\alpha = 26^0$

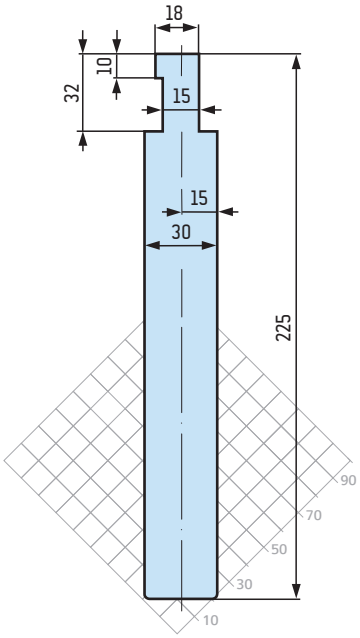
R = 2 mm *LH3 = 17 t/m*





42CrMo4

S 2515 H 150 t/m

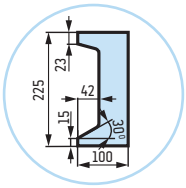


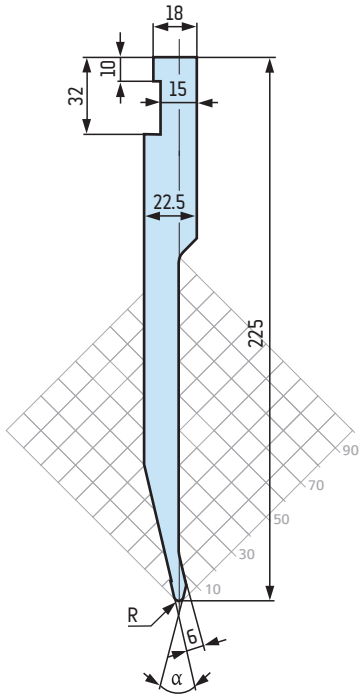
42CrMo4

S 2515 J 50 t/m

α = 26⁰

R = 2 mm *LH3 = 15 t/m*





42CrMo4

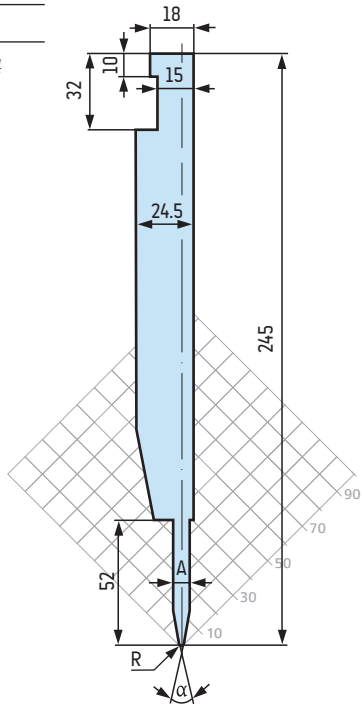
S 2515 P 40 t/m

α = 20⁰

A = 8 mm, 10 mm, 12 mm

R = 1 mm

** Do użycia w zestawie z matrycą M 5000*

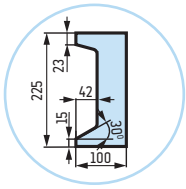


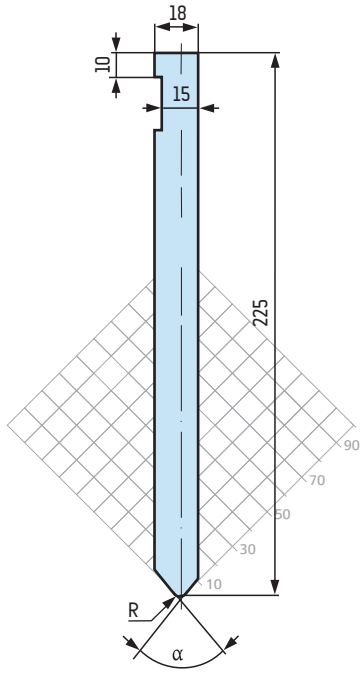
42CrMo4

S 2515 R 120 t/m

α = 78⁰

R = 2 mm *LH3 = 40 t/m*



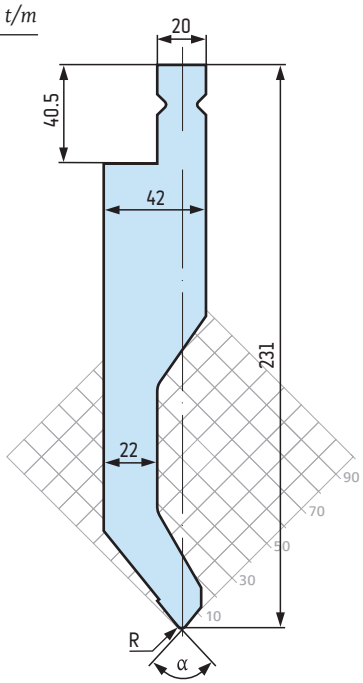


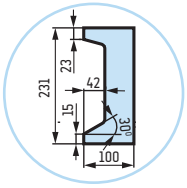
42CrMo4

S 2615 C 80 t/m

$\alpha = 78^0$

R = 2 mm *LH4 = 22 t/m*



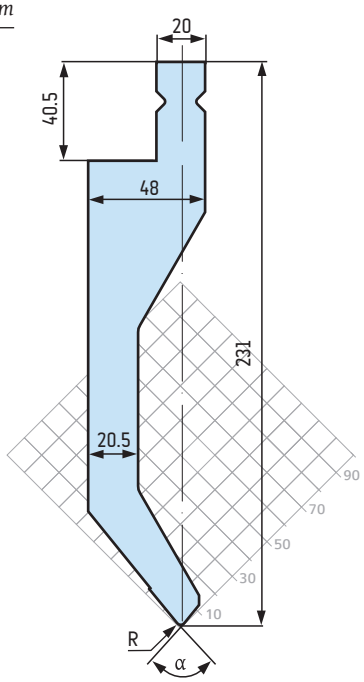


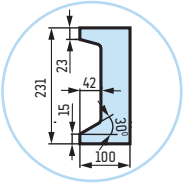
42CrMo4

S 2615 D 75 t/m

$\alpha = 78^0$

R = 2 mm *LH4 = 20 t/m*



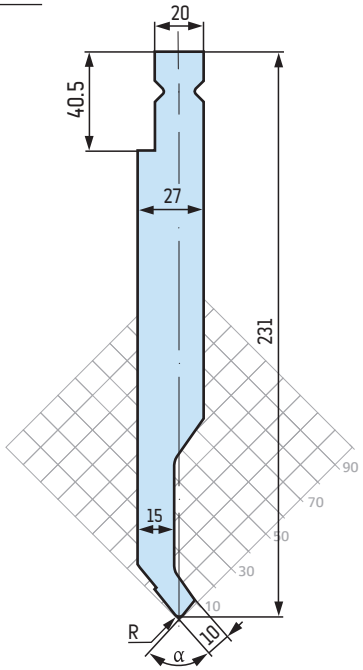


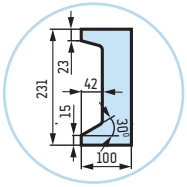
42CrMo4

S 2615 E 50 t/m

$\alpha = 26^0$

R = 2 mm *LH4 = 19 t/m*



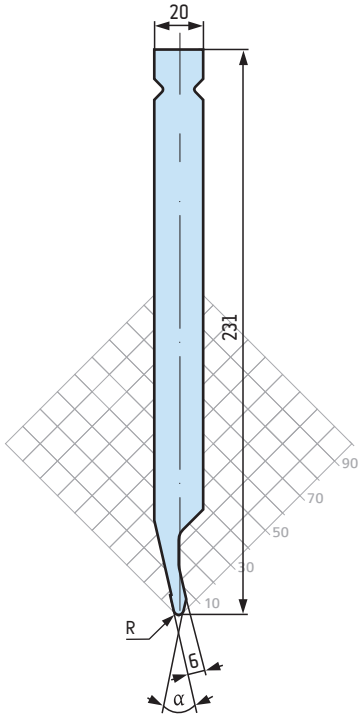


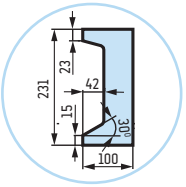
42CrMo4

S 2615 F 50 t/m

$\alpha = 26^0$

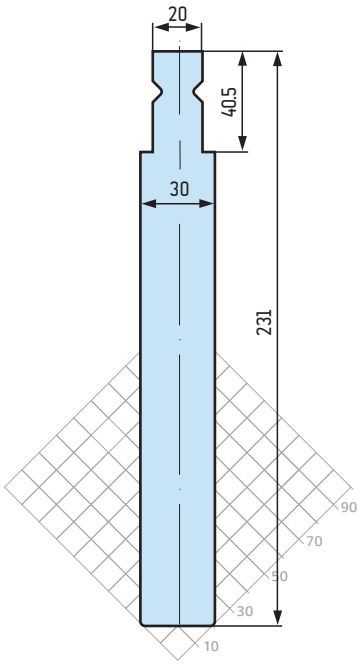
R = 2 mm *LH4 = 17t/m*





42CrMo4

S 2615 H 150 t/m

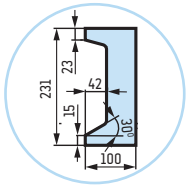


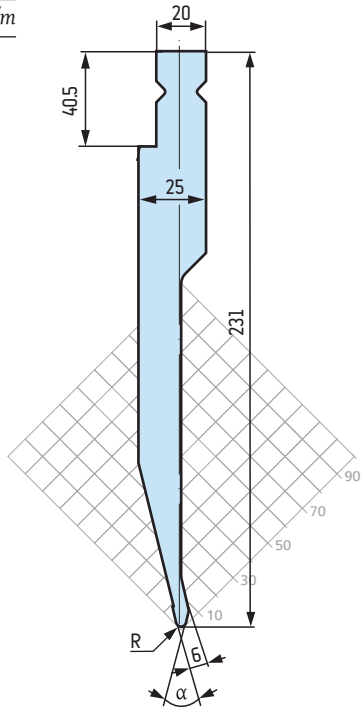
42CrMo4

S 2615 J 50 t/m

α = 26°

R = 2 mm *LH4 = 15 t/m*





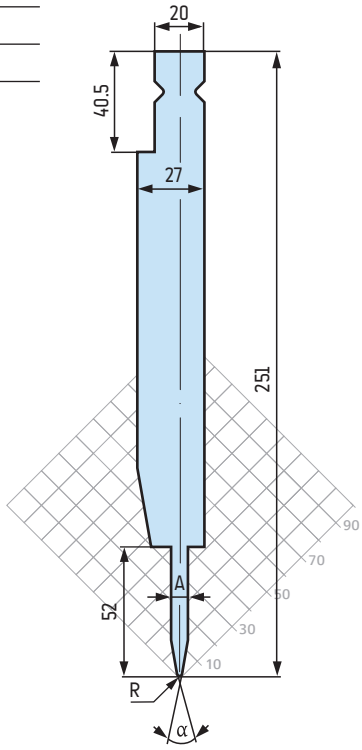
42CrMo4

S 2615 P 40 t/m

α = 20°

A = 8 mm, 10 mm, 12 mm

R = 1 mm

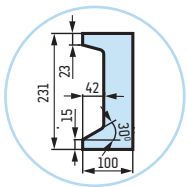


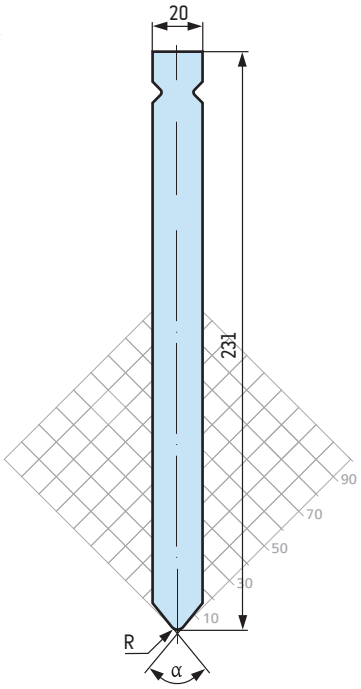
42CrMo4

S 2615 R 120 t/m

α = 78°

R = 3 mm *LH4 = 40 t/m*





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

42CrMo4

M 5106 20 t/m

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

R_1 = 0.8 mm

42CrMo4

M 5108 20 t/m

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

R_1 = 1 mm

42CrMo4

M 5110 30 t/m

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

R_1 = 1 mm

42CrMo4

M 5112 35 t/m

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

R_1 = 1.5 mm

42CrMo4

M 5116 35 t/m

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

R_1 = 2 mm

42CrMo4

M 5120 35 t/m

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

R_1 = 2 mm

42CrMo4

M 5124 55 t/m

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

R_1 = 3 mm

42CrMo4

M 5130 60 t/m

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

R_1 = 3 mm

42CrMo4

M 5140 60 t/m

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

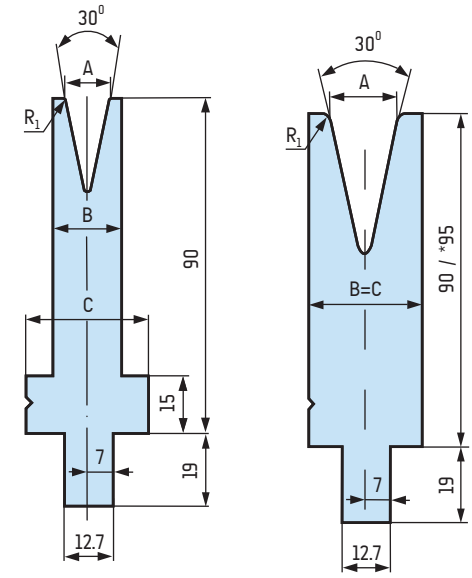
R_1 = 4 mm

42CrMo4

M 5150* 80 t/m

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

R_1 = 5 mm



42CrMo4

M 5206 40 t/m

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

R_1 = 1 mm

42CrMo4

M 5208 40 t/m

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

R_1 = 1 mm

42CrMo4

M 5210 50 t/m

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

R_1 = 1 mm

42CrMo4

M 5212 60 t/m

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

R_1 = 1 mm

42CrMo4

M 5216 80 t/m

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

R_1 = 1.5 mm

42CrMo4

M 5220 100 t/m

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

R_1 = 2 mm

42CrMo4

M 5224 100 t/m

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

R_1 = 2.5 mm

42CrMo4

M 5230 110 t/m

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

R_1 = 3 mm

42CrMo4

M 5240 130 t/m

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

R_1 = 3 mm

42CrMo4

M 5250 150 t/m

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

R_1 = 4 mm

42CrMo4

M 5260 150 t/m

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

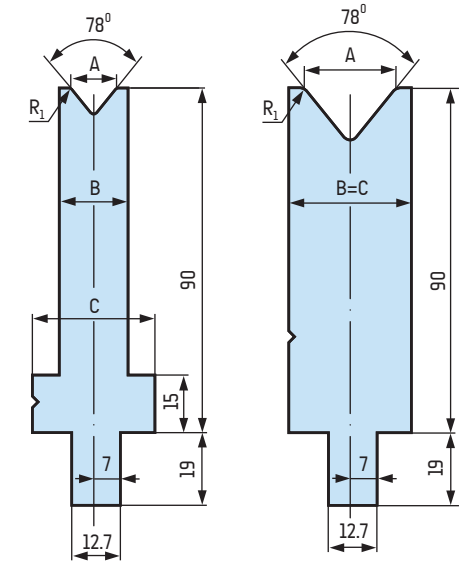
R_1 = 4 mm

42CrMo4

M 5280 150 t/m

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

R_1 = 6 mm



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

42CrMo4

M 5306 20 t/m

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

R_1 = 0.8 mm

42CrMo4

M 5308 20 t/m

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

R_1 = 1 mm

42CrMo4

M 5310 30 t/m

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

R_1 = 1 mm

42CrMo4

M 5312 35 t/m

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

R_1 = 1.5 mm

42CrMo4

M 5316 35 t/m

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

R_1 = 2 mm

42CrMo4

M 5320 35 t/m

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

R_1 = 2 mm

42CrMo4

M 5324 55 t/m

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

R_1 = 3 mm

42CrMo4

M 5330 60 t/m

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

R_1 = 3 mm

42CrMo4

M 5340 60 t/m

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

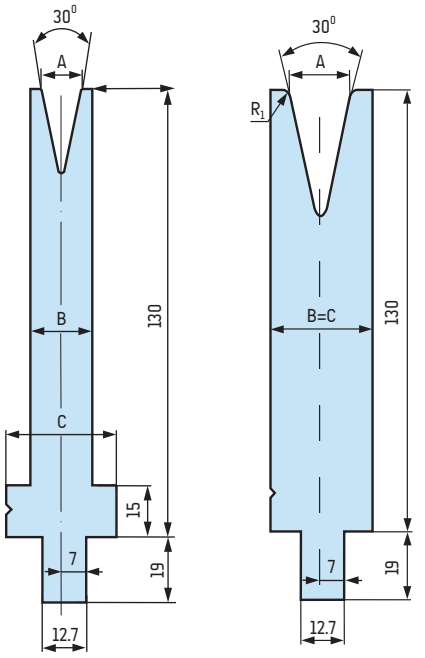
R_1 = 4 mm

42CrMo4

M 5350 70 t/m

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

R_1 = 5 mm



42CrMo4

M 5406 40 t/m

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

R_1 = 1 mm

42CrMo4

M 5408 40 t/m

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

R_1 = 1 mm

42CrMo4

M 5410 50 t/m

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

R_1 = 1 mm

42CrMo4

M 5412 60 t/m

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

R_1 = 1 mm

42CrMo4

M 5416 80 t/m

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

R_1 = 1.5 mm

42CrMo4

M 5420 100 t/m

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

R_1 = 2 mm

42CrMo4

M 5424 100 t/m

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

R_1 = 2.5 mm

42CrMo4

M 5430 110 t/m

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

R_1 = 3 mm

42CrMo4

M 5440 130 t/m

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

R_1 = 3 mm

42CrMo4

M 5450 150 t/m

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

R_1 = 4 mm

42CrMo4

M 5460 150 t/m

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

R_1 = 4 mm

42CrMo4

M 5480 150 t/m

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

R_1 = 6 mm

42CrMo4

M 54100 150 t/m

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

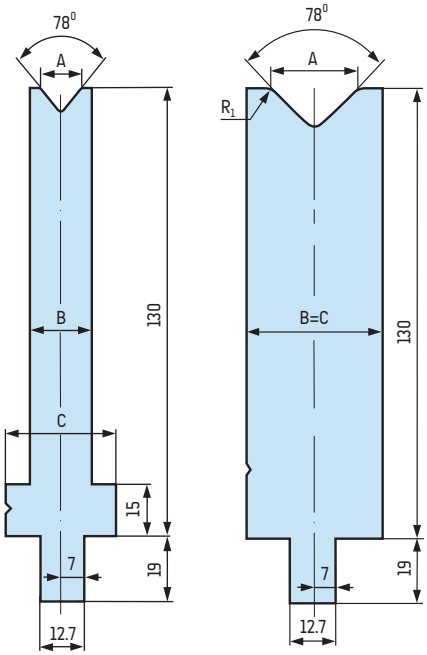
R_1 = 6 mm

42CrMo4

M 54120 150 t/m

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

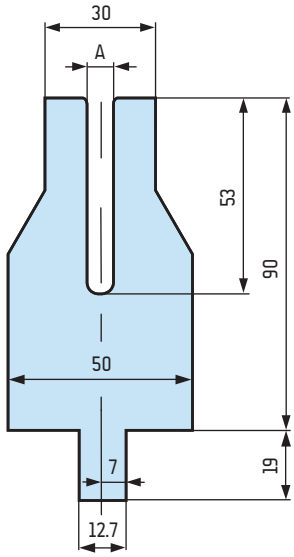
R_1 = 12 mm

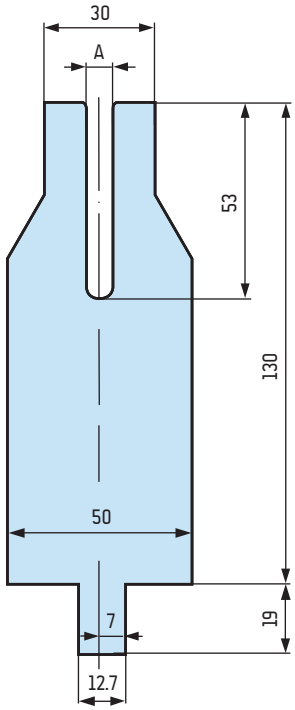


flattening dies | matryce do zagniatania

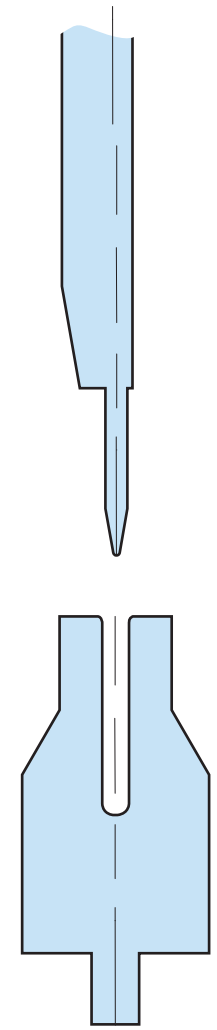
42CrMo4

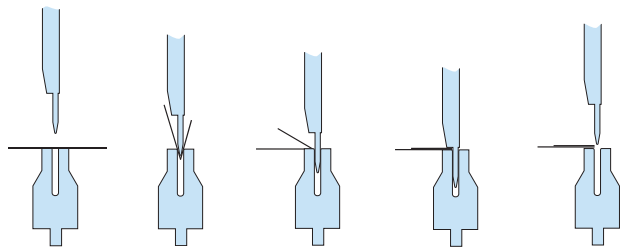
M 5000	50 t/m
A = 8 mm, 10 mm, 12 mm	
H = 90 mm, 130 mm	





example of use | przykład zastosowania





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

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

FLEXI BEND DIES | MATRYCE FLEXI BEND

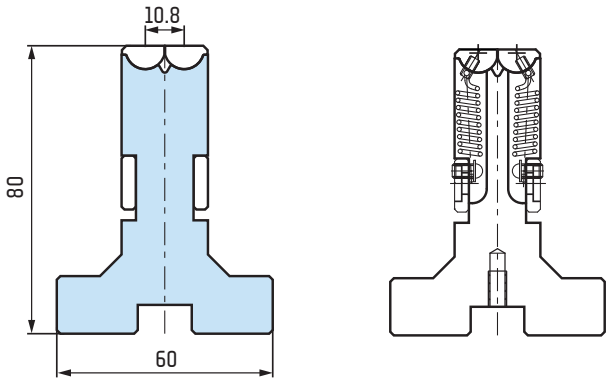
dies with movable inserts | matryce z ruchomymi wkładkami

MODEL XT 1	**blachy 0.3 do 1.2 mm**	
FBXT 1	*matryca z rowkiem 15x8 mm*	*AMADA*
MODEL XT 2	**blachy 0.5 do 2.0 mm**	
FBXT 2	*matryca z rowkiem 15x8 mm*	*AMADA*
MODEL 1	**blachy 0.7 do 1.5 mm (max 2 mm)**	
FBP60-1	*matryca z podstawą 60 mm*	*AMADA*
FBS80-1	*matryca z płetwą 14 mm*	*AMADA*
FBT55-1	*matryca z płetwą 13 mm*	*WILA*
FBT90-1	*matryca z płetwą 12.7 mm*	*LVD*
FBT100-1	*matryca z płetwą 13 mm*	*WILA*
MODEL 2	**blachy 2 do 3.2 mm (max 4 mm)**	
FBP65-2	*matryca z podstawą 60 mm*	*AMADA*
FBS80-2	*matryca z płetwą 14 mm*	*AMADA*
FBT60-2	*matryca z płetwą 13 mm*	*WILA*
FBT90-2	*matryca z płetwą 12.7 mm*	*LVD*
FBT100-2	*matryca z płetwą 13 mm*	*WILA*
MODEL 2.5	**blachy 2 do 6 mm**	
FBM-2.5	*matryca z podstawą 60 mm* *z możliwością mocownia płetw pod WILA i LVD*	*AMADA*
MODEL 3	**blachy 2 do 6 mm**	
FBP100-3	*matryca z podstawą 60 mm*	*AMADA*
FBT100-3	*matryca z płetwą 13 mm*	*WILA*
FBM70-3	*z możliwością mocowania płetw AMADA, WILA i LVD*	
MODEL 3.5	**blachy 6 do 10 mm**	
FBM-3.5	*z możliwością mocowania płetw AMADA, WILA i LVD*	
MODEL 4	**blachy 6 do12 mm**	
FBM90-4	*z możliwością mocowania płetw AMADA, WILA i LVD*	
Matryce regulowane		
FBHD2	*zakres regulacji: 16-30 mm*	
FBHD2.5	*zakres regulacji: 28-69 mm*	
FBHD3 Z	*zakres regulacji: 39-118 mm*	
FBHD4	*zakres regulacji: 70-220 mm*	

MODEL XT 1	**thickness 0.3 to 1.2 mm**	
FBXT 1	*die with groove 15x8 mm*	*AMADA*
MODEL XT 2	**thickness 0.5 to 2.0 mm**	
FBXT 2	*die with groove 15x8 mm*	*AMADA*
MODEL 1	**thickness 0.7 to 1.5 mm (max 2 mm)**	
FBP60-1	*die with 60 mm base*	*AMADA*
FBS80-1	*die with 14 mm tang*	*AMADA*
FBT55-1	*die with 13 mm tang*	*WILA*
FBT90-1	*die with 12.7 mm tang*	*LVD*
FBT100-1	*die with 13 mm tang*	*WILA*
MODEL 2	**thickness 2 to 3.2 mm (max 4 mm)**	
FBP65-2	*die with 60 mm base*	*AMADA*
FBS80-2	*die with 14 mm tang*	*AMADA*
FBT60-2	*die with 13 mm tang*	*WILA*
FBT90-2	*die with 12.7 mm tang*	*LVD*
FBT100-2	*die with 13 mm tang*	*WILA*
MODEL 2.5	**thickness 2 to 6 mm**	
FBM-2.5	*die with 60 mm base* *optional tang for WILA and LVD*	*AMADA*
MODEL 3	**thickness 2 to 6 mm**	
FBP100-3	*die with 60 mm base*	*AMADA*
FBT100-3	*die with 13 mm tang*	*WILA*
FBM70-3	*optional tang for AMADA, WILA and LVD*	
MODEL 3.5	**thickness 6 to 10 mm**	
FBM-3.5	*optional tang for AMADA, WILA and LVD*	
MODEL 4	**thickness 6 to12 mm**	
FBM90-4	*optional tang for AMADA, WILA and LVD*	
Adjustable dies		
FBHD2	*adjustment range: 16-30 mm*	
FBHD2.5	*adjustment range: 28-69 mm*	
FBHD3 Z	*adjustment range: 39-118 mm*	
FBHD4	*adjustment range: 70-220 mm*	

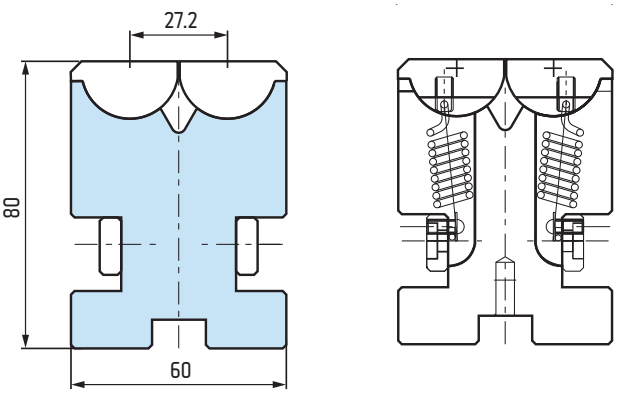
FLEXI 10.8 100 t/m

H = 80 mm



FLEXI 27.2 150 t/m

H = 80 mm



Flexi Bend matrices are modern bending dies for press brakes with tilting inserts, compatible with any type of press. Their versatility makes them an ideal choice for the production of precision metal components.

Advantages of Flexi Bend matrices:

1. Shorter bending arms – Tilting inserts enable precise bending, even for small profiles, eliminating deformation.
2. Edge without marks – Minimal friction ensures no bending marks or scratches on the edges, ensuring a high-quality finish.
3. Reduced distortion – Minimizes the risk of deformation near holes, preserving the integrity of the sheet metal.
4. Minimal finishing work – Fewer marks mean no need for polishing, which reduces costs and saves production time.

With Flexi Bend matrices, high-quality products can be achieved with lower costs and shorter production cycles.

Matryce Flexi Bend to nowoczesne matryce do pras krawędziowych z uchylnymi wkładkami, kompatybilne z każdym typem prasy. Dzięki wszechstronności są idealnym wyborem w produkcji precyzyjnych elementów metalowych.

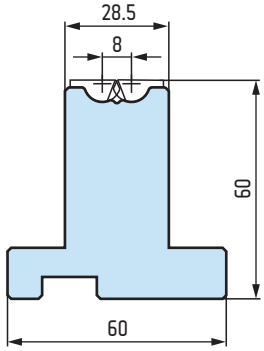
Zalety matryc Flexi Bend:

1. Krótsze ramiona gięcia – Uchylnie wkładki umożliwiają precyzyjne gięcie, nawet przy małych profilach, eliminując deformacje.
2. Krawędzie bez śladów – Minimalne tarcie zapobiega powstawaniu śladów gięcia i zarysowań, zapewniając estetykę wykończenia.
3. Mniejsze odkształcenia – Zmniejsza ryzyko deformacji przy bliskich otworach, zachowując integralność blachy.
4. Minimalna obróbka końcowa – Mniej śladów to brak potrzeby polerowania, co obniża koszty i oszczędza czas produkcji.

Z Flexi Blend uzyskujemy wysoką jakość produktów przy niższych kosztach i krótszych cyklach produkcji.

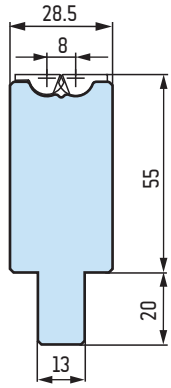
FBP60-1 50 t/m

L = 100 mm, 500 mm, 440 mm segm.



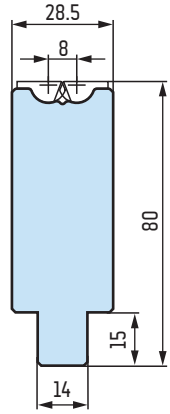
FBT55-1 50 t/m

L = 100 mm, 500 mm, 440 mm segm.



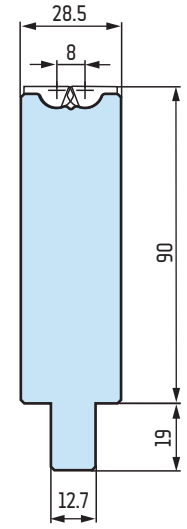
FBS80-1 50 t/m

L = 100 mm, 500 mm, 440 mm segm.



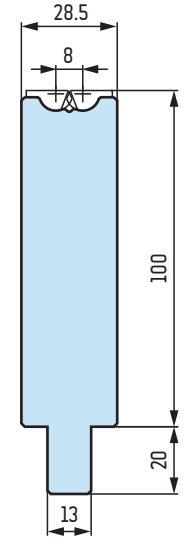
FBT90-1 50 t/m

L = 100 mm, 500 mm, 440 mm segm.



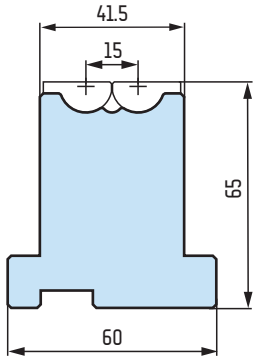
FBT100-1 50 t/m

L = 100 mm, 500 mm, 440 mm segm.



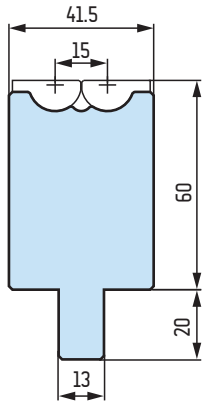
FBP65-2 150 t/m

L = 100 mm, 500 mm, 450 mm segm.



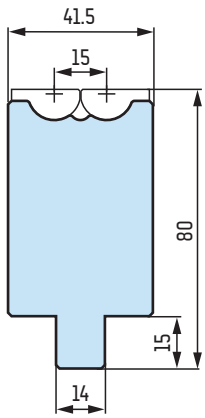
FBT60-2 150 t/m

L = 100 mm, 500 mm, 450 mm segm.



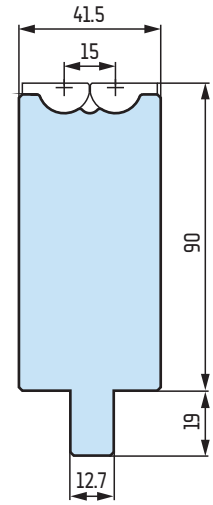
FBS80-2 150 t/m

L = 100 mm, 500 mm, 450 mm segm.



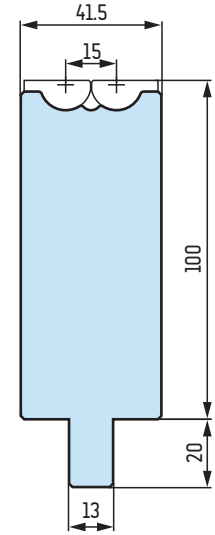
FBT90-2 150 t/m

L = 100 mm, 500 mm, 450 mm segm.



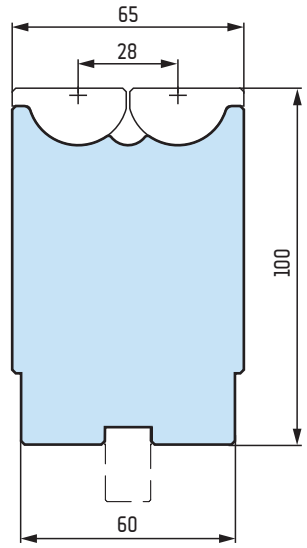
FBT100-2 150 t/m

L = 100 mm, 500 mm, 450 mm segm.



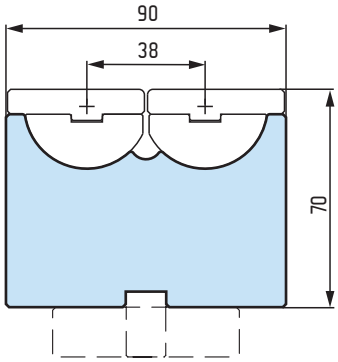
FBM2.5 250 t/m

L = 100 mm, 500 mm, 470 mm segm.



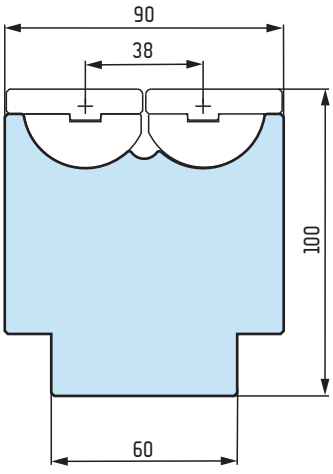
FBP70-3 250 t/m

L = 100 mm, 500 mm, 455 mm segm.



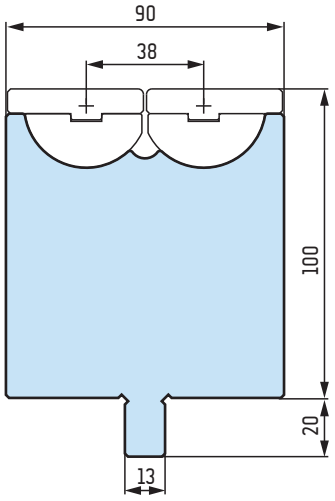
FBP100-3 250 t/m

L = 100 mm, 500 mm, 455 mm segm.



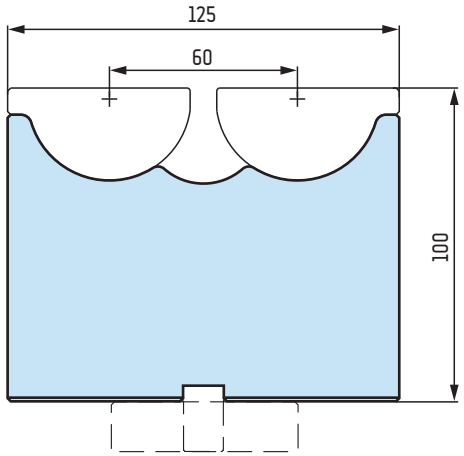
FBT100-3 250 t/m

L = 100 mm, 500 mm, 455 mm segm.



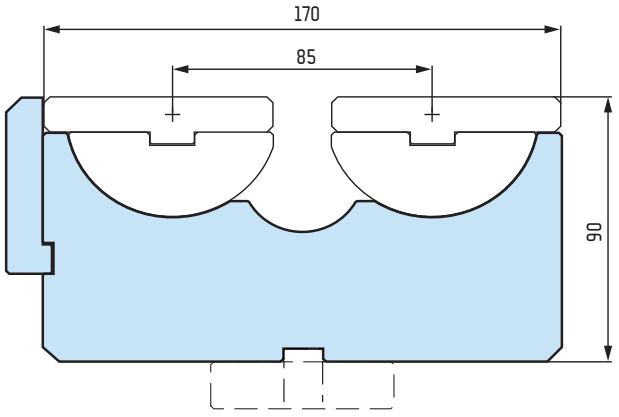
FBM3.5 250 t/m

L = 250 mm, 500 mm



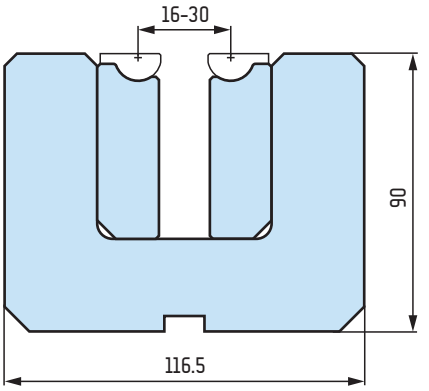
FBM90-4 300 t/m

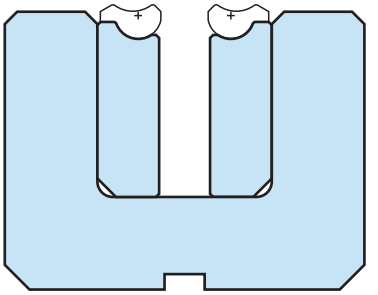
L = 250 mm, 500 mm

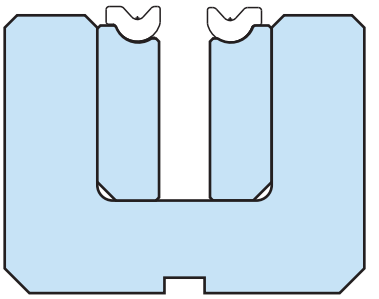


FBHD2 200 t/m

L = 250 mm, 500 mm

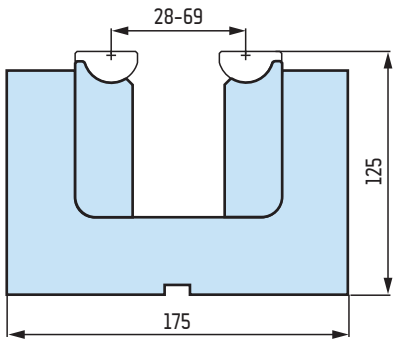


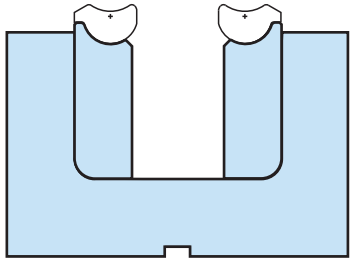


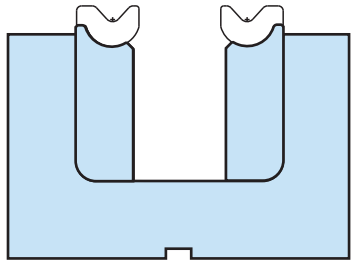


FBHD2.5 250 t/m

L = 250 mm, 500 mm

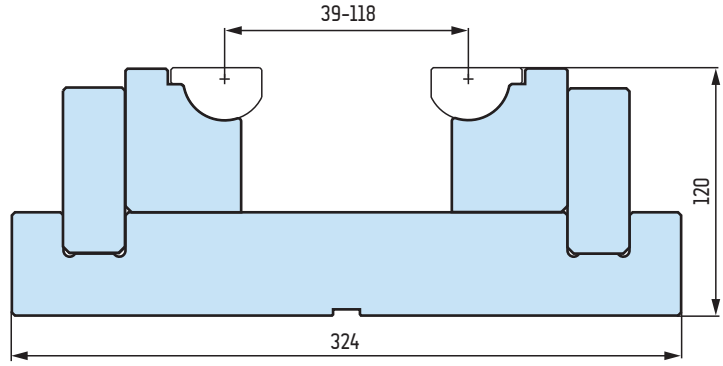


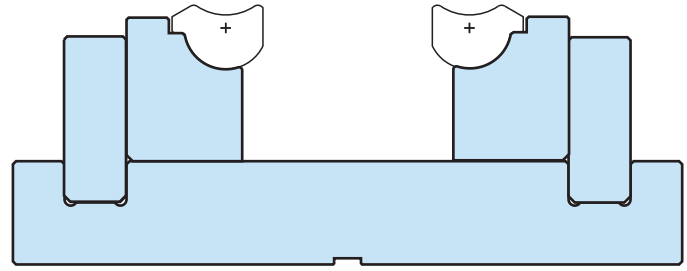


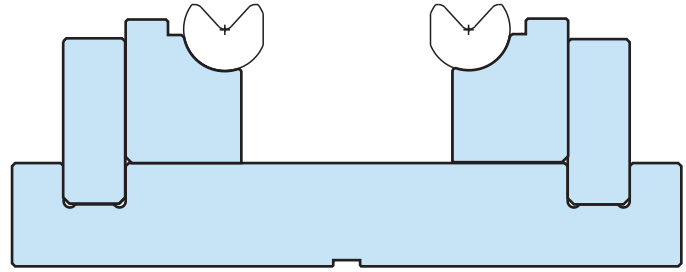


FBHD3 350 t/m

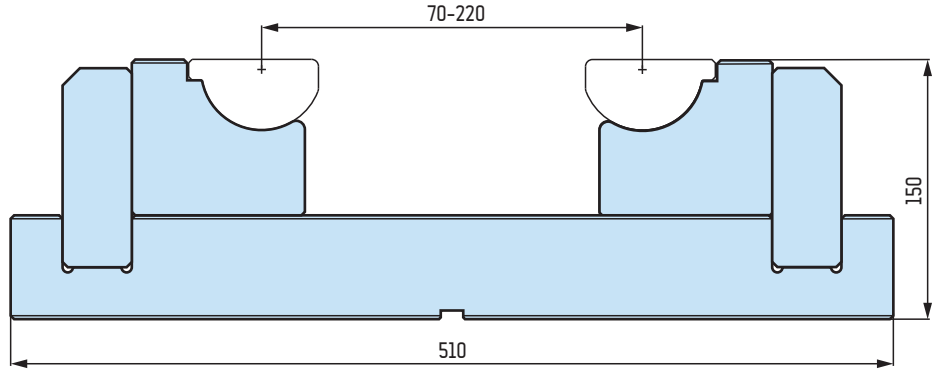
L = 250 mm, 500 mm

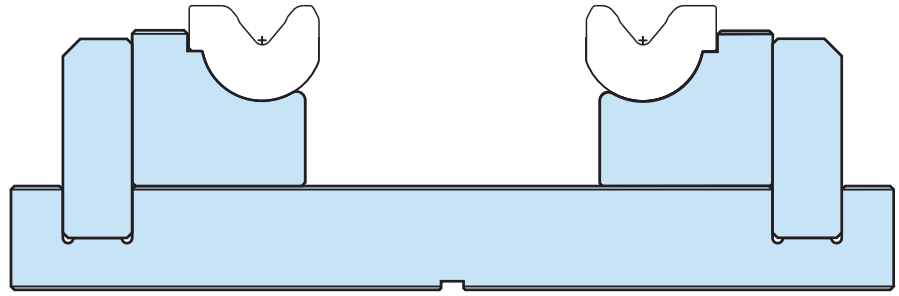


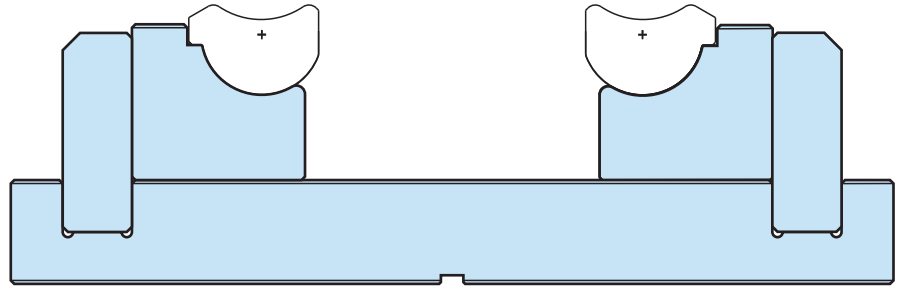




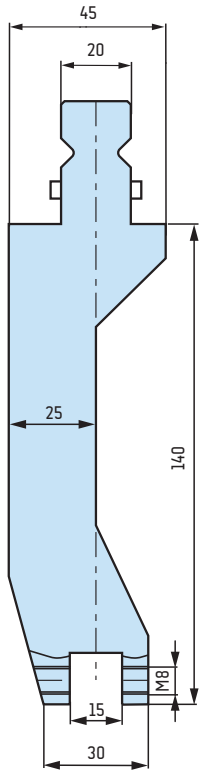
FBHD4	350 t/m
L = 250 mm, 500 mm	



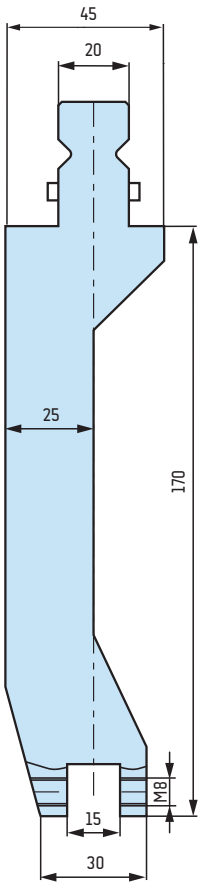




S22140/FR

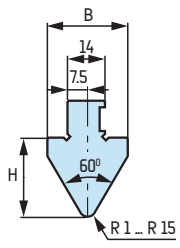


S22170/FR

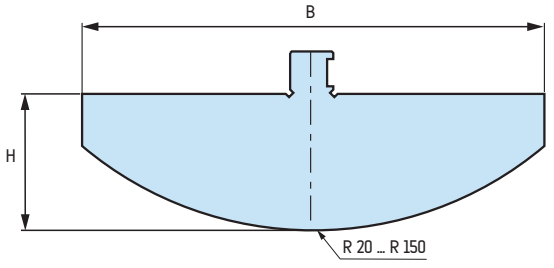


SYMBOL	B	H	R	α
IK H30 R1	*30*	*30*	*1*	*60°*
IK H30 R2	*30*	*30*	*2*	*60°*
IK H30 R3	*30*	*30*	*3*	*60°*
IK H30 R4	*30*	*30*	*4*	*60°*
IK H30 R5	*30*	*30*	*5*	*60°*
IK H30 R6	*30*	*30*	*6*	*60°*
IK H30 R8	*30*	*30*	*8*	*60°*
IK H30 R10	*30*	*30*	*10*	*60°*
IK H30 R12	*30*	*30*	*12*	*60°*
IK H30 R15	*30*	*30*	*15*	*60°*
IK H30 R20	*30*	*30*	*20*	
IK H30 R20	*30*	*30*	*25*	
IK H30 R30	*50*	*30*	*30*	
IK H30 R35	*60*	*30*	*35*	
IK H30 R40	*70*	*30*	*40*	
IK H40 R50	*90*	*40*	*50*	
IK H40 R40	*70*	*40*	*40*	
IK H35 R50	*80*	*35*	*50*	
IK H35 R60	*90*	*35*	*50*	
IK H40 R70	*100*	*50*	*70*	
IK H50 R80	*120*	*50*	*80*	
IK H50 R85	*130*	*50*	*85*	
IK H50 R90	*130*	*50*	*90*	
IK H50 R100	*140*	*50*	*100*	
IK H50 R115	*150*	*70*	*115*	
IK H80 R150	*210*	*80*	*150*	

WKŁADKI IK R1-R15

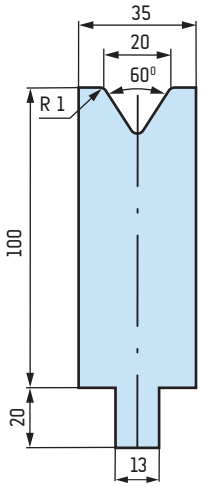


WKŁADKI IK R20 - R150



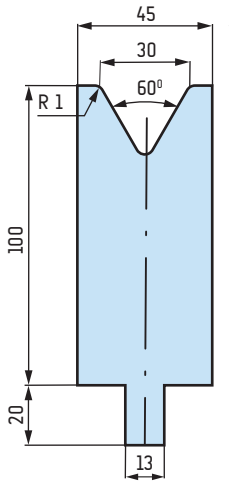
42CrMo4

M 7020	120 t/m
$\alpha = 60^0$	
$V = 20$ mm	
$H = 100$ mm	
$R_1 = 2$ mm	



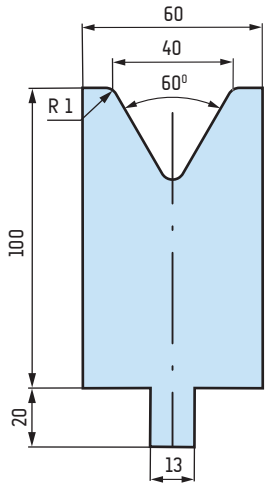
42CrMo4

M 7030	150 t/m
$\alpha = 60^0$	
$V = 30$ mm	
$H = 100$ mm	
$R_1 = 3$ mm	



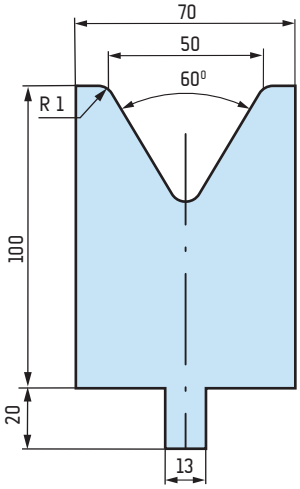
42CrMo4

M 7040	200 t/m
$\alpha = 60^0$	
$V = 40$ mm	
$H = 100$ mm	
$R_1 = 4$ mm	



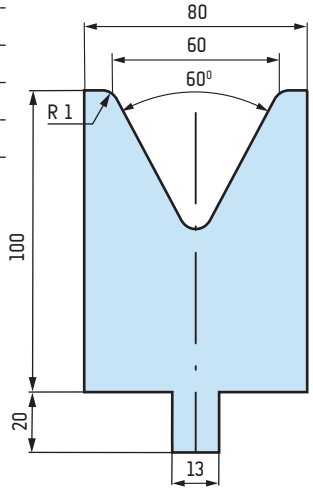
42CrMo4

M 7050	200 t/m
$\alpha = 60^0$	
$V = 50$ mm	
$H = 100$ mm	
$R_1 = 5$ mm	



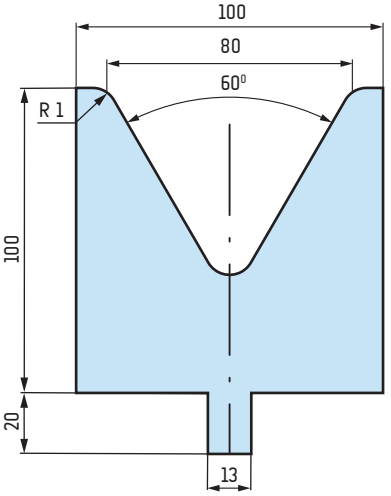
42CrMo4

M 7060	200 t/m
$\alpha = 60^0$	
$V = 60$ mm	
$H = 100$ mm	
$R_1 = 6$ mm	



42CrMo4

M 7080	200 t/m
$\alpha = 60^0$	
$V = 80$ mm	
$H = 100$ mm	
$R_1 = 8$ mm	



ALIKO CNC ADJUSTABLE LOWER TOOLS | MATRYCE REGULOWANE CNC

FAST V-OPENINGS ADJUSTMENT STRAIGHT FROM CNC-CONTROL

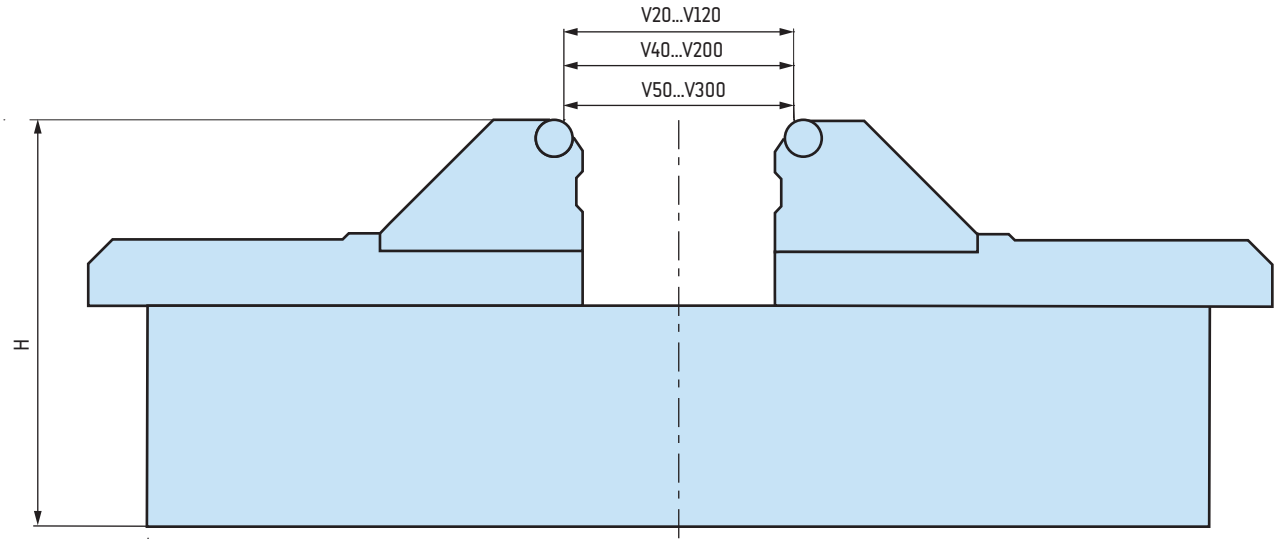
The design of the tool pays special attention to durability and precision control. V-opening adjustment range and tool length can be customized according to customer needs.

- *Motorized V-opening adjustment, precise positioning every 10 mm*
- *Fast V-opening adjustment straight from CNC-control*
- *Strong and durable construction*
- *Excellent load resistance*
- *V-opening conner rolls to reduce the power needed in bending and improve tools duration*
- *Suitable for most press brakes*
- *Almost maintenance free*

SZYBKA REGULACJA ROZMIARU V MATRYCY BEZPOŚREDNIO ZE STEROWANIA CNC

Konstrukcja narzędzia ze szczególnym uwzględnieniem trwałości i precyzji sterowania. Zakres regulacji szerokośc V matrycy, i długość narzędzia można dostosować do potrzeb klienta.

- *Zautomatyzowana szerokość V, precyzyjne pozycjonowanie co 10 mm*
- *Szybka regulacja rozmiaru V matrycy prosto ze sterowania CNC*
- *Mocna i trwała konstrukcja*
- *Doskonała odporność na obciążenia*
- *Rolki na krawędziach formujących matrycy dla zmniejszenia siły potrzebnej do zginania i poprawienia trwałości narzędzi*
- *Nadaje się do większości pras krawędziowych*
- *Praktycznie bezobsługowe*



Model	V-openings, mm	Height, mm	Max. loadability α 80°, t/m
ALIKO CNC-VARIO DIE 120	V20-120	200	250
ALIKO CNC-VARIO DIE 200	V40-200	330	400
ALIKO CNC-VARIO DIE 300	V50-300	400	400

Model	szerokość V, mm	Wysokość, mm	Max. obciążenie α 80°, t/m
MATRYCA ALIKO CNC-VARIO 120	V20-120	200	250
MATRYCA ALIKO CNC-VARIO 200	V40-200	330	400
MATRYCA ALIKO CNC-VARIO 300	V50-300	400	400

ALIKO UPPER TOOL CLAMPING SYSTEMS | SYSTEMY MOCOWANIA STEMPLI ALIKO

HYDRAULIC UPPER TOOL CLAMPING

- *Fast fixing, positioning and replacement*
- *Heavy Duty fixing profile*
- *Tool fixing loadability 250 t/m or 400 t/m*
- *Suitable for all press brake models*

MECHANICAL UPPER TOOL CLAMPING FOR STANDARD, HEAVY DUTY AND GIANT SOLUTIONS

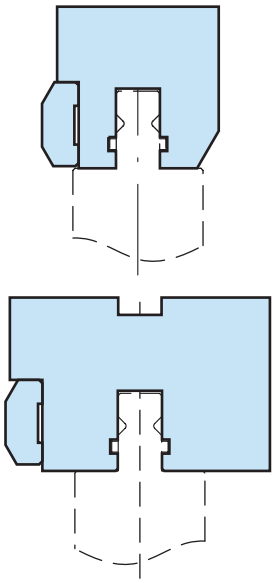
- *"WILA"-type tooling compatible*
- *Maximum load 400 t/m or 600 t/m*
- *Quick fixing, positioning and replacement of the upper tool*

HYDRAULICZNY SYSTEM MOCOWANIA STEMPLI

- *Szybkie mocowanie, pozycjonowanie i demontaż narzędzi*
- *Wytrzymały przekrój Heavy Duty*
- *Obciążenie miejscowe na poziomie 250 t/m lub 400 t/m*
- *Pasuje do wszystkich rodzajów pras*

MECHANICZNY SYSTEM MOCOWANIA STEMPLI DLA MASZYN STANDARDOWYCH, HEAVY DUTY I MASZYN OGROMNYCH

- *Kompatybilny z narzędziami z mocowaniem WILA*
- *Maksymalne obciążenie 400 t/m lub 600 t/m*
- *Szybkie mocowanie, pozycjonowanie i wymiana stempli*



ALIKO LOWER TOOL CLAMPING SYSTEMS | SYSTEMY MOCOWANIA MATRYC ALIKO

LOWER TOOL CLAMPING

- *Fast tool change, automatic centering*
- *Lower tools easy to handle*
- *Possibility to use sectioning*
- *Loadability up to 600 t/m*
- *Loading bridge option*

ALIKO LOWER TOOL CLAMPING SOLUTIONS INCLUDE

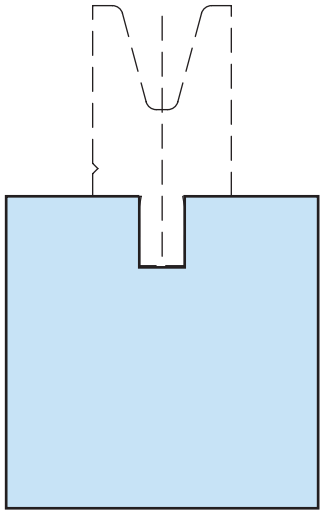
- *Mechanical lower tool clamping*
- *Pneumatic lower tool clamping*
- *Pneumatic lower tool clamping with V-loading bridge*
- *Hydraulic lower tool clamping*
- *Lower tool adapters*

MOCOWANIE MATRYC

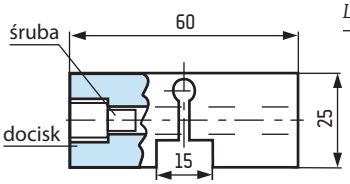
- *Szybka zmiana matryc, automatyczne centrowanie*
- *Łatwe przenoszenie matryc*
- *Możliwość użycia matryc dzielonych*
- *Obciążenie do 600 t/m*
- *Opcja systemu transportu matryc*

RODZAJE SYSTEMÓW MOCOWANIA MATRYC ALIKO

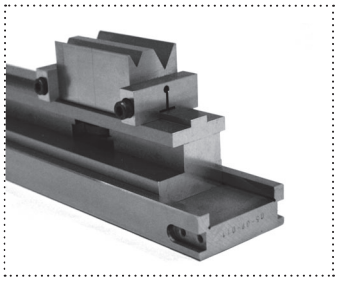
- *Mechaniczne mocowanie matryc*
- *Pneumatyczne mocowanie matryc*
- *Pneumatyczne mocowanie matryc z systemem transportu narzędzi*
- *Hydrauliczne mocowanie matryc*
- *Adaptery do matryc*



2 V

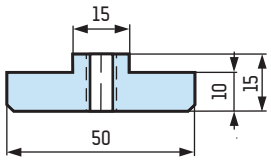


ASSEMBLY | **PRZYKŁAD MONTAŻU**



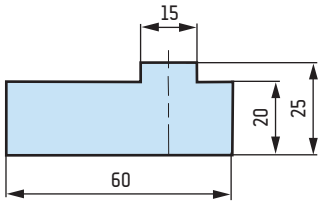
A

L = 415 mm, 835 mm



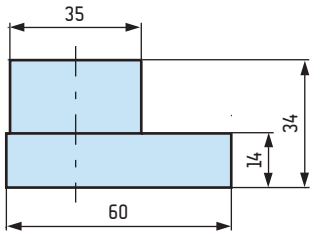
A 20

L = 415 mm, 835 mm



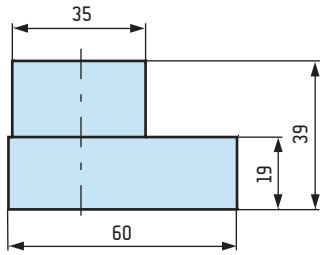
A 34

L = 412 mm, 830 mm



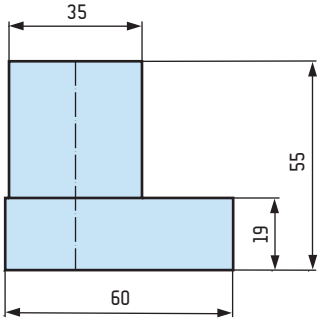
A 39

L = 412 mm, 830 mm



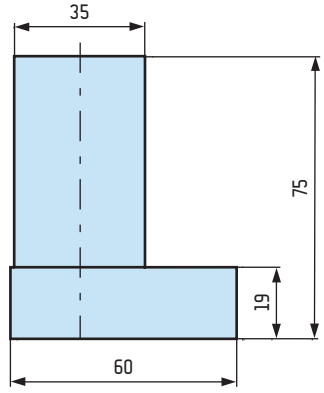
A 55

L = 412 mm, 830 mm



A 75

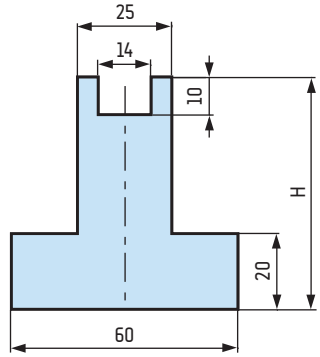
L = 412 mm, 830 mm



A 31

L = 415 mm, 835 mm

H = 31 mm



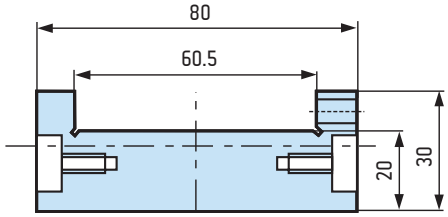
A 61

L = 415 mm, 835 mm

H = 61.5 mm

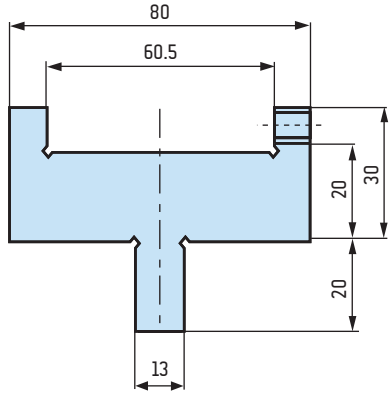
B 60

L = 1050 mm



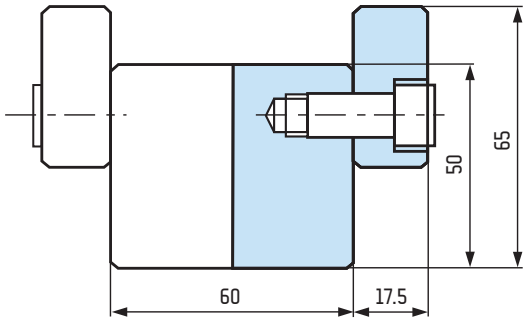
B 60 / T-A

L = 1050 mm



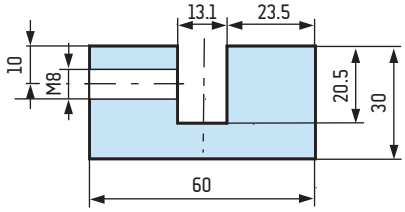
C 60

L = 835 mm



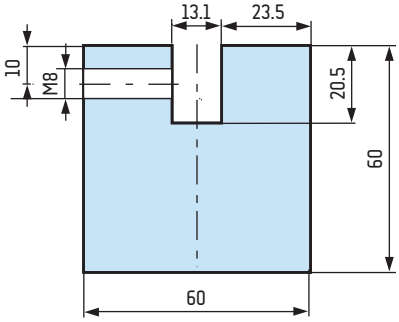
D 30

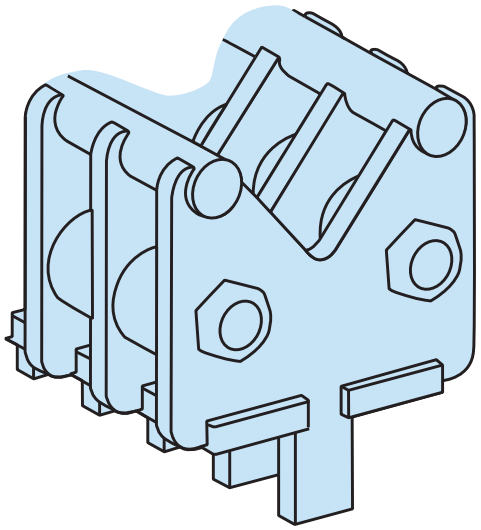
L = 1000 mm



D 60

L = 1000 mm





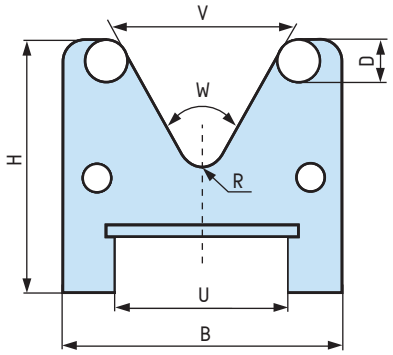
Compound dies meet the high demands of customers who need continual product improvement. By using new production techniques a new tooling product has been developed offering great value for money. It can be used for almost any application and will be a major advantage for use in the midrange and heavy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

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

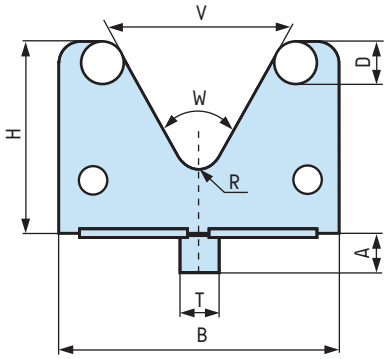
V	D	W°	B	H	R	t/m
16	6	**28**	30	**55**	2	**30**
20	6	**28**	34	**55**	2	**35**
24	8	**28**	40	**55**	3	**40**
32	10	**28**	53	**55**	5	**45**
32	10	**85**	53	**55**	5	**60**
40	10	**85**	62	**55**	5	**60**
48	10	**85**	70	**55**	5	**60**
mm	mm	°	mm	**mm**	mm	

V	D	W°	B	H	R	t/m
50	15	**14**	88	**90**	7	**100**
60	15	**40**	98	**110**	10	**120**
80	20	**50**	130	**130**	10	**160**
100	20	**60**	150	**140**	18	**200**
120	25	**60**	180	**160**	18	**250**
150	25	**60**	212	**180**	25	**300**
200	30	**80**	270	**220**	30	**350**
250	30	**80**	325	**300**	40	**400**
300	40	**80**	400	**360**	40	**500**
400	50	**80**	524	**400**	50	**600**
mm	mm	°	mm	**mm**	mm	

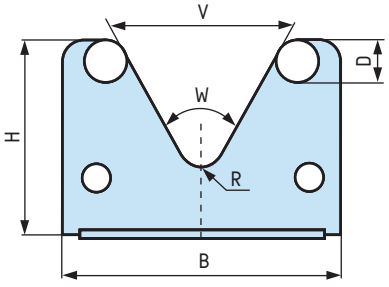
S



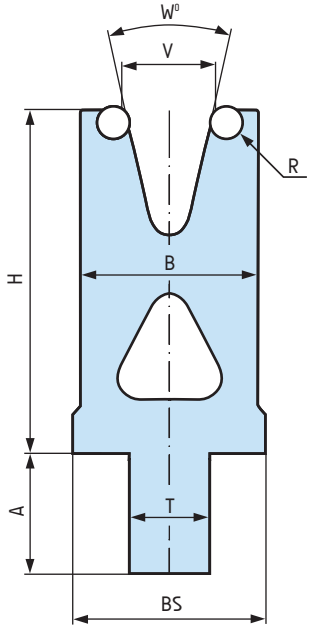
T



U



COMPOUND DIES | MATRYCE SKŁADANE



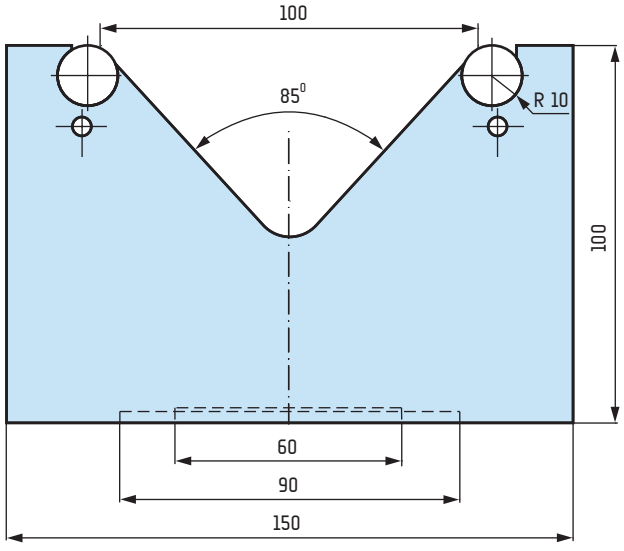
Compound dies are press brake dies for "airbending" only. The high precision, high quality, hardened and anodised, aluminium die body, contains the two hardened and ground die bars. The die bars are interchangeble in case of wear.

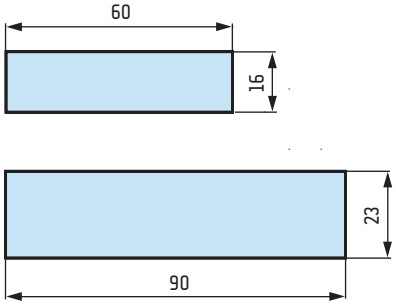
Matryce kompozytowe, wykonane z wytrzymałych stopów utwardzonego aluminium. Matryce posiadają wysokiej jakości wymienne wkładki stalowe, hartowane i szlifowane.

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

ROLL DIES | MATRYCE ROLKOWE

example | **przykład**





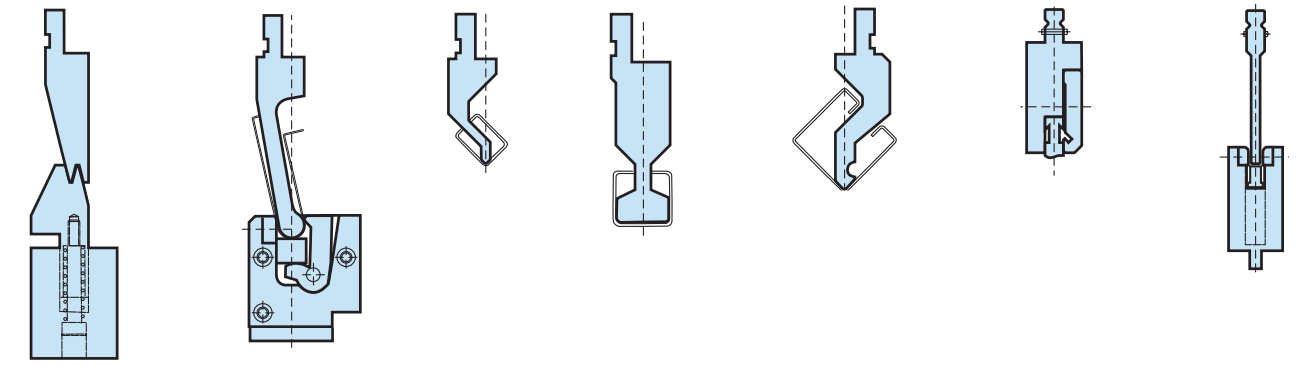
Round inserts hardened up to 60 HRc.
Rectandular inserts 60 mm or 90 mm wide allow the die to be fixed on smaller machine beams.

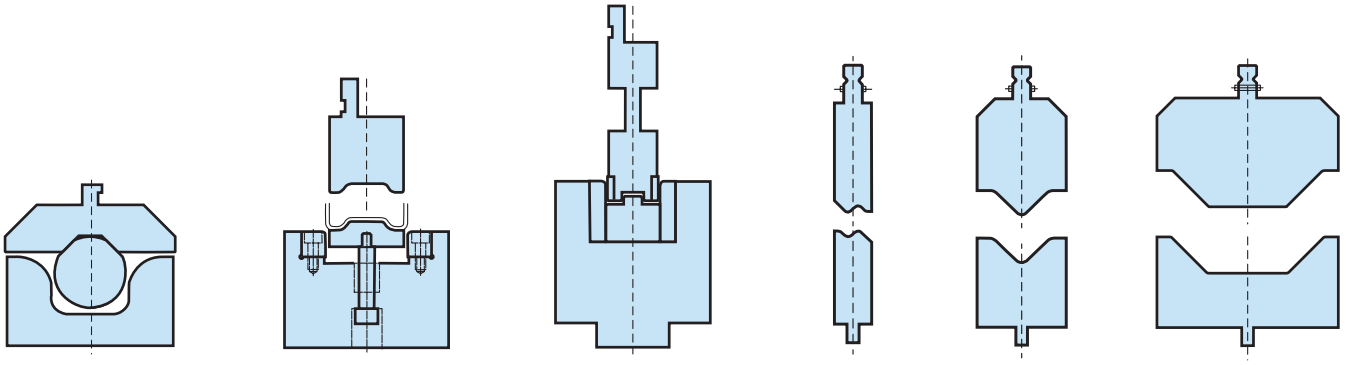
Matryce z rolkami o twardości do 60 HRc.
Wkładki o szerokości 60 mm lub 90 mm mogą służyć do zamocowaniana na węższym stole.

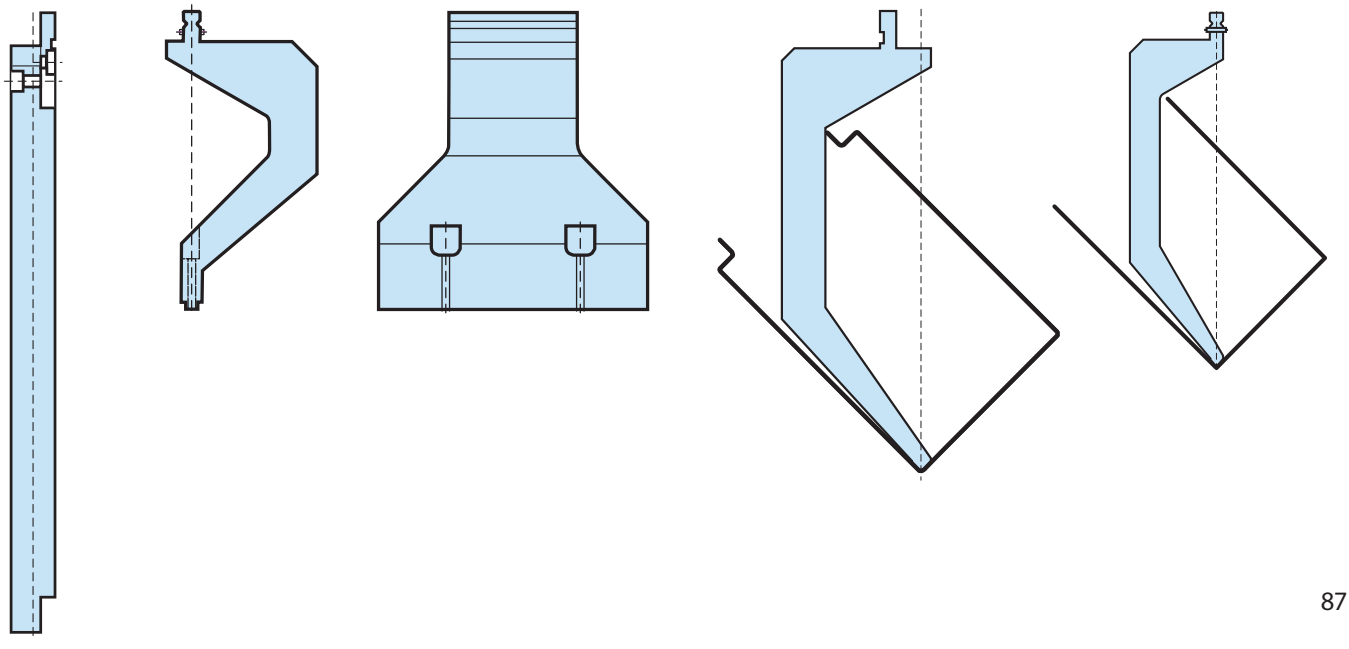
special tooling examples | **przykłady narzędzi specjalnych**

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

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

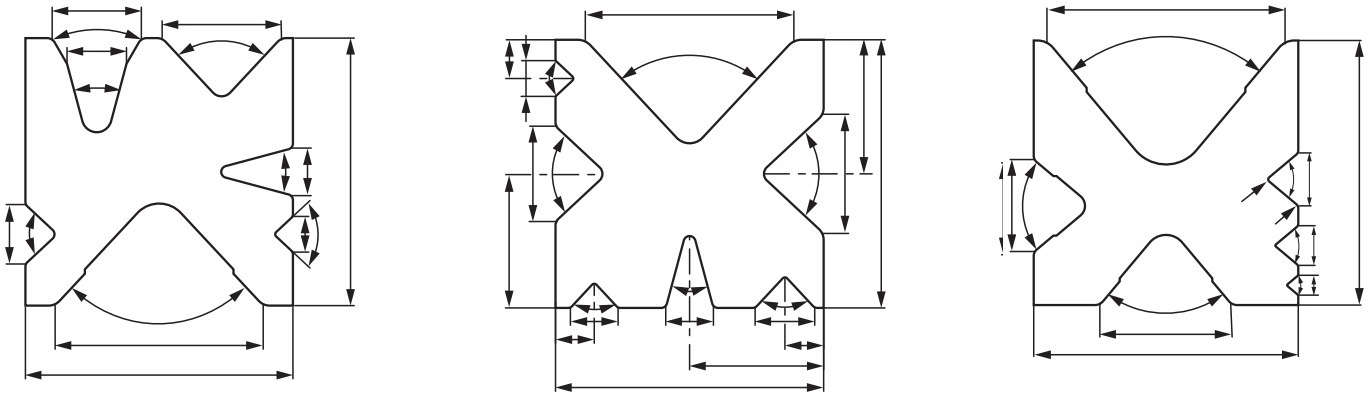






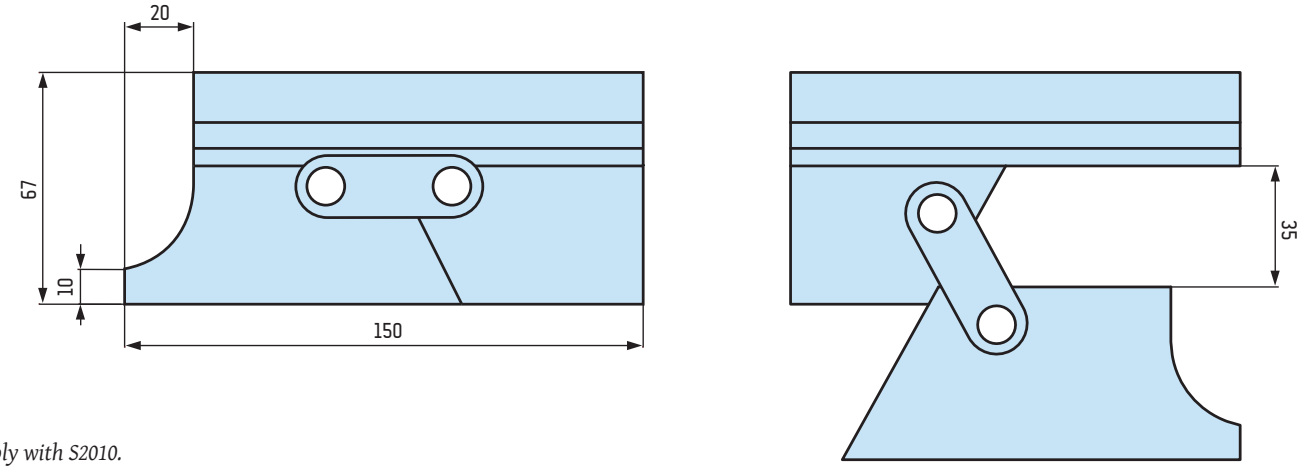
multi-v dies | matryce multi-v

Insert dimensions.
Przy zamówieniu uzupełnić wymiary.

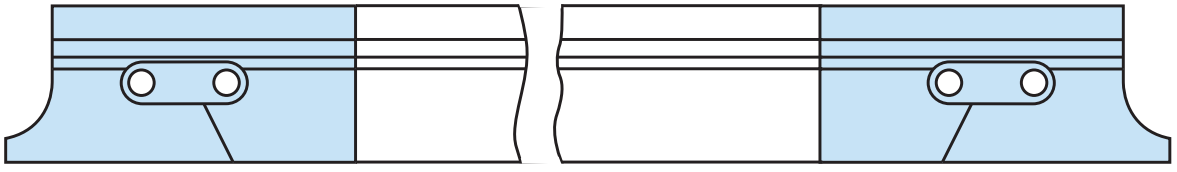


BOX-CLOSING PUNCH | STEMPEL DO ZAMYKANIA PUDEŁEK

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



Assembly with S2010.
Złożenie z S2010.



protective tape | taśma ochronna

24h

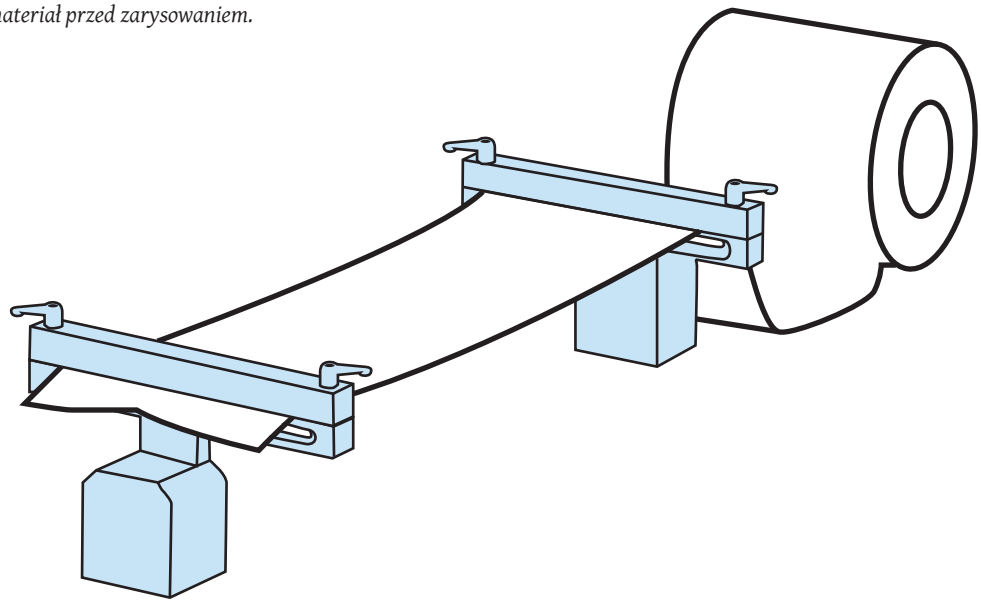
Tape size
thicknes = 0.4 mm, width = 100 mm
thicknes = 0.5 mm, width = 100 mm
thicknes = 0.8 mm, width = 100 mm

Wymiary taśmy
grubość = 0.4 mm, szerokość = 100 mm
grubość = 0.5 mm, szerokość = 100 mm
grubość = 0.8 mm, szerokość = 100 mm

Holder for protective tape
suitable for dies size 13 mm to 60 mm

Uchwyt do folii ochronnej
mocowanie do matryc od 13 mm do 60 mm

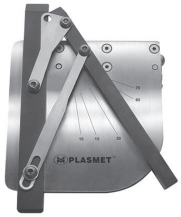
Plastic tape protecting sheet metal from damage.
Plastikowa taśma zabezpieczająca gięty materiał przed zarysowaniem.



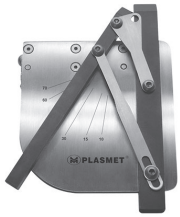
magnetic squaring arm | magnetyczny ustawiak kąta gięcia

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

Magnetyczny ustawiak kąta gięcia występuje w wersji lewej i prawej.



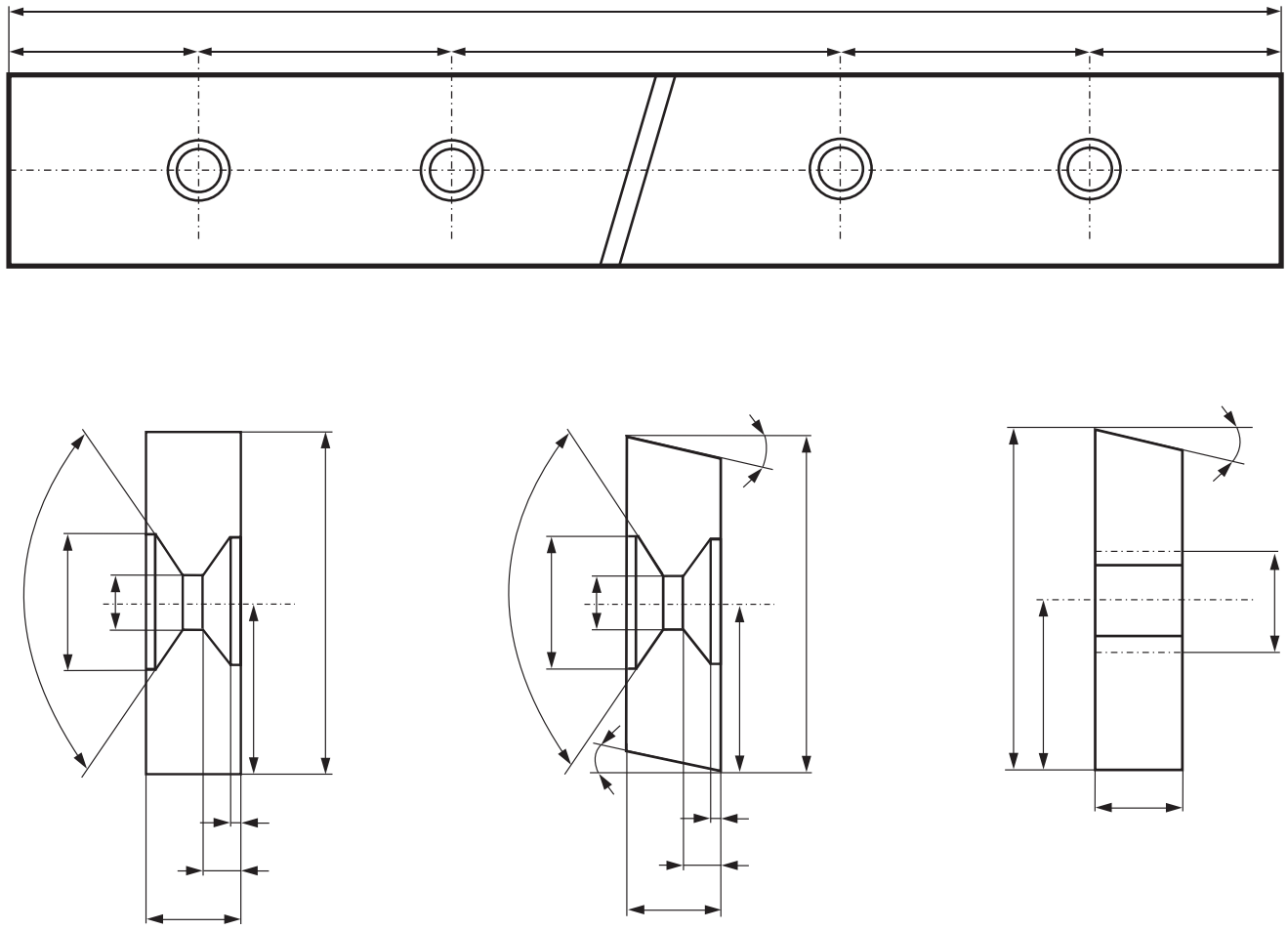
Ustawiak lewy.
Left squaring arm.



Ustawiak prawy.
Right squaring arm.

shear blades | noże do gilotyn

Insert dimensions.
Przy zamówieniu uzupełnić wymiary.



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

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

TEDA adapters – main models | adaptery TEDA – podstawowe modele

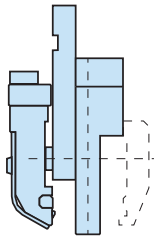
Main benefits:
– standard type "A" tool
– no tool modification
– tool frontal insertion / removal
– easy assembly on any press brake (new or already in use)
– no modification of press necessary

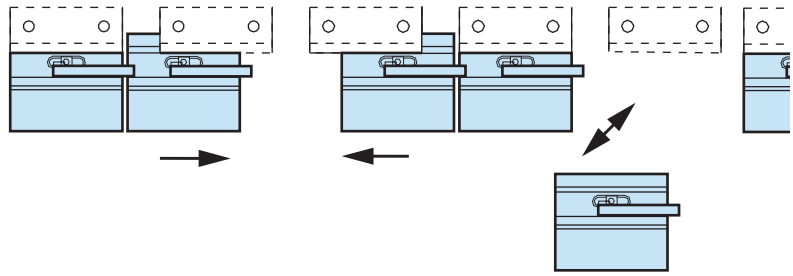
Główne korzyści:
– standardowe narzędzia typu „A"
– bez modyfikacji narzędzi
– narzędzia montowane / demontowane od frontu
– łatwy montaż na dowolnej prasie krawędziowej (nowej lub już używanej)
– nie ma konieczności modyfikacji prasy

SPEED GRIP 13000-M MANUAL | RĘCZNY

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

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





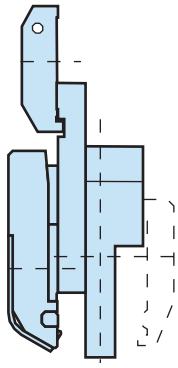
SPEED GRIP 13000-ST PNEUMATIC | PNEUMATYCZNE

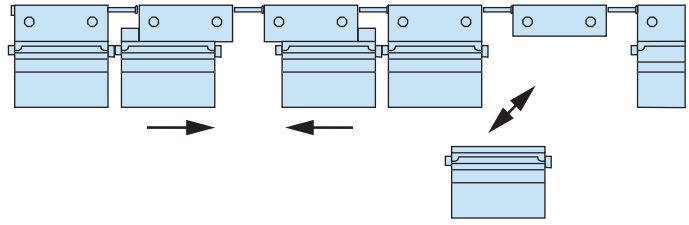
One selector only for the whole line. Air transmission by TEDA patented "STAR SYSTEM".

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

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

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

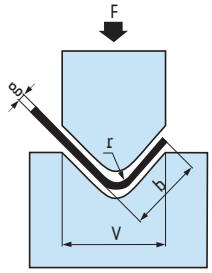




We also offer pneumatic die holders and special punch holders and adapters.
Compared to traditional manual clampings with screws SPEED GRIP grants about 80% timesaving.

Oferujemy również pneumatyczne mocowanie matryc, oraz adaptery i uchwyty specjalne.
W porównaniu do tradycyjnych ręcznych zamocowanych śrubami adatery SPEED GRIP dają około 80% oszczędności czasu.

PRESSURE TABLE | TABELA DOBORU SIŁ



The table shows bending pressure for sheets with air bending.
Parametry gięcia swobodnego blach przy gięciu w powietrzu.

F [t] – pressure on 1 m / siła na 1 m
V – vee size / szerokość wyjęcia
b – minimum lenght of bending arm / minimalna długość zaginanego ramienia
r – inner radius on steel / promień wewnętrzny giętej blachy

RM = 45 kg/mm²

g	V	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	140	160	200	250
	b	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	100	113	140	180
	r	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	23	26	33	40
0.5		4	3																				
0.6		6	4	3	3																		
0.8			7	6	5	4																	
1.0			13	10	8	6	5																
1.2					13	10	8	6	5														
1.5							13	10	9	8	7												
2.0							25	20	17	14	13	10											
2.5									29	24	21	16	12										
3.0										38	32	24	17	13									
4.0												47	34	25	19	14							
5.0													57	42	32	24	18						
6.0														65	48	36	26	20					
8.0															94	69	50	38	29	25			
10.0																	84	63	48	41	35		
12.0																	130	96	72	62	53	40	31
16.0																			139	120	101	76	58
20.0																						126	95

RM = 70 kg/mm²

g	V	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	140	160	200	250
	b	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	100	113	140	180
	r	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	23	26	33	40
0.5		7	4																				
0.6		10	6	5	4																		
0.8			11	9	8	6																	
1.0			19	16	13	10	8																
1.2					20	15	12	10	8														
1.5							20	16	14	12	10												
2.0							39	31	26	22	20	15											
2.5									44	38	33	25	18										
3.0										58	50	37	27	20									
4.0												73	53	39	30	22							
5.0													89	66	49	37	27						
6.0														101	75	55	41	31					
8.0															147	107	78	59	45	39			
10.0																	131	98	74	64	55		
12.0																	202	149	112	97	82	62	48
16.0																			217	187	157	118	90
20.0																						196	148

recomended vee size / rekomendowane szerokości wyjęć