

PLASMET®

CATALOGUE OF PRODUCTS
EDITION 25

KATALÓG PRODUKTOV
EDÍCIA 25

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EDÍCIA 25

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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 6100 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.

Naša spoločnosť je rodinná firma s viac ako 30-ročnými skúsenosťami vo výrobe ohraňovacích nástrojov a gilotínových nožov.

Ponúkame štandardné náradie s upínaním Amada Promecam, Trumpf / Wila a LVD.

Nami vyrábané matrice a raznice sú kompatibilné s mnohými ďalšími ohraňovacími lismi ako Durma, Ermaksan, Baykal, EHT, Haco, LVD, Safan a mnohými ďalšími.

Ponúkame aj nástroje na mieru, vrátane špeciálnych razníkov a matríc podľa vášho návrhu.
Náš tím odborníkov vám môže pomôcť vybrať a navrhnúť nástroje, ktoré ich prispôsobia konečnému produktu.

Nástroje vyrábame z vylepšených, tvrdených materiálov do dĺžky 6100 mm.

Všetky naše nástroje sú kalené a brúsené, aby bola zabezpečená najvyššia kvalita a odolnosť.

Okrem nástrojov na ohýbanie plechov ponúkame aj nože pre gilotínové nožnice vyrobené v Poľsku (NG, NGH), Českej republike (NTE, CNTA) a inde, ktoré umožňujú strihať plechy s maximálnou hrúbkou od 3 mm do 25 mm. Nože vyrábame aj na mieru podľa výkresu zákazníka.

Od roku 2013 ponúkame aj laserom kalené nástroje arenováciu použitých nástrojov v kombinácii s laserovým opätovným kalením.

Naša spoločnosť je známa kvalitou svojich produktov a vynikajúcim zákazníckym servisom.

Neváhajte nás kontaktovať.

NEW IN THIS EDITON OF THE CATALOG | NOVINKY V TOMTO VYDANÍ KATALÓGU

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

Vážení zákazníci,

S potešením vám predstavujeme 25. vydanie nášho katalógu. V tejto verzii nájdete niekoľko nových funkcií, na ktoré by sme vás chceli upozorniť:

– Na strane 24 sme zaradili nové razníky TYPU „A“, modely S 2042 a S 2043, ktoré umožňujú robiť zložitejšie tvary. Vďaka podrezaniu v tele vám umožnia ohýbať nielen rovné detaily do ostrého uhla, ale aj väčší počet C-sekcií ako napríklad razník S 2021.
– Na strane 29 nájdete medzisystémový adaptér typu „T/A“ 80, ktorý sa vrátil do našej ponuky!
– Strany 79-82 sú venované lisom a nástrojom od fínskeho výrobcu – ALIKO, s ktorým naďalej spolupracujeme.
– Na strane 14 predstavujeme našu službu regenerácie nástrojov. Obnovujeme ich plnú funkčnosť, zlepšujeme ich presnosť a spevňujeme ich kalením.

Okrem toho stojí za to venovať pozornosť nástrojom a príslušenstvu, ktoré umožňujú ohýbanie plechu bez stôp po ohybe:

– Matrice Flexi Bend – novinka v našej ponuke – nájdete na stranách 71-78.
– Ochranné fólie – na strane 89.

Pre uľahčenie výberu sme do katalógu pridali schémy razníkovej stopy, ktoré nájdete pri príslušných označeniach. Všetky dostupné typy stôp sú uvedené na strane 12.

Dúfame, že naše návrhy budú pre vás užitočné a umožnia vám pracovať ešte efektívnejšie. Ďakujeme za prejavenú dôveru a pozývame vás, aby ste sa oboznámili s celou ponukou v novom katalógu.

Kolektív firmy Plasmet

standard tools TYPE "A" | štandartné nástroje TYPU „A"

Material

C45, 40HM, 42CrMo4 and 1.2312

Working edge hardened

55 ±2 HRc

Standard lengths

415 mm, 835 mm, 835 mm segmented

Materiál

C45, 40HM, 42CrMo4 a 1.2312

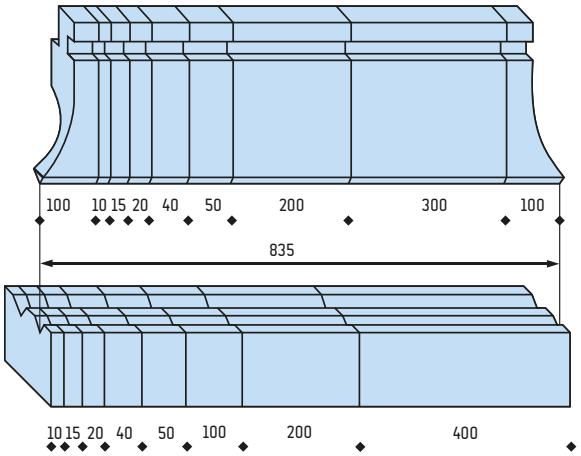
Pracovné plochy kalené

55 ±2 HRc

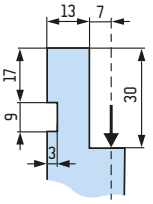
Dĺžka štandartná

415 mm, 835 mm, 835 mm segmentované

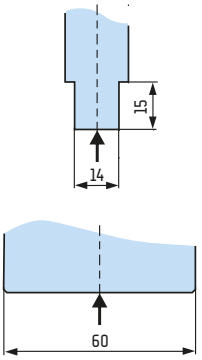
Sectionalized tool TYPE "A".
Schéma segmentového nástroja TYPU „A".



Punch mounting edge.
Upínanie razníka.



Die mounting edge.
Upínanie matríc.



standard tools TYPE "T" | štandartné nástroje 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*

Materiál

C45, 40HM alebo 1.2312

Tepelné zušľachtenie*

30 ±2 HRc (950 – 1100 MPa)

Pracovné plochy kalené

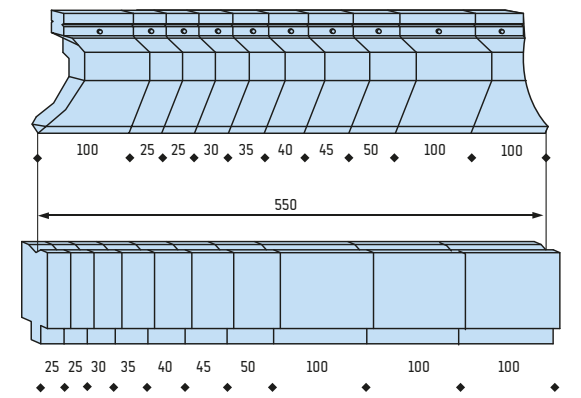
55 ±2 HRc (1500 – 1600 MPa)

Dĺžka

100, 200, 300, 500, 550 mm segmentované

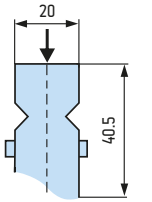
** týka sa 1.2312*

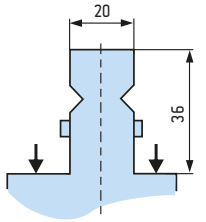
Sectionalized tool TYPE "T".
Schéma segmentového nástroja TYPU „T".



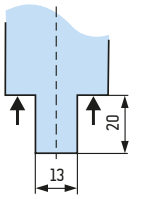
Vec size "T" measured between radiuses.
Šírka matrice "T" meraná od začiatku rádiusov .

Punch mounting edge.
Upínanie razníka.





Die mounting edge.
Upínanie matríc

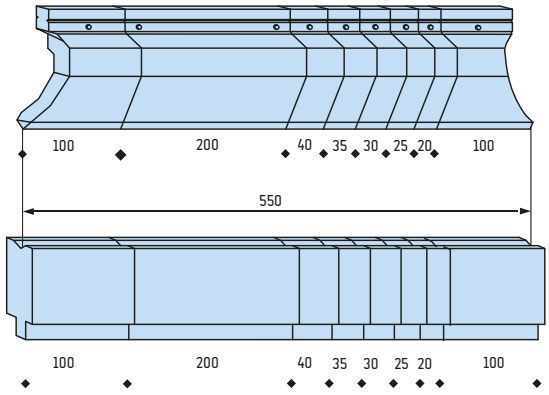


standard tools TYPE "W" | štandartné nástroje TYPU „W"

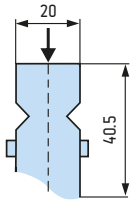
Material
42CrMo4 or 1.2312
Thermal enhancement to*
30 ±2 HRc (950 – 1100 MPa)
Working edge hardened
55 ±2 HRc (1500 – 1600 MPa)
Length
515 mm, 550 mm segmented
** applies to 1.2312*

Materiál
40HM alebo 1.2312
Tepelné zušľachtenie*
30 ±2 HRc (950 – 1100 MPa)
Pracovné plochy kalené
55 ±2 HRc (1500 – 1600 MPa)
Dĺžka
515 mm, 550 mm segmentované
** týka sa 1.2312*

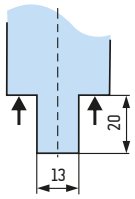
Sectionalized tool TYPE "W".
Schéma segmentového nástroja TYPU „W".



Punch mounting edge.
Upínanie razníka.



Die mounting edge.
Upínanie matríc

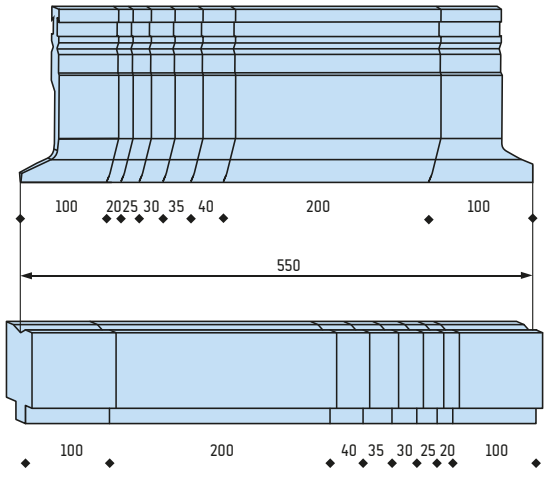


standard tools TYPE "B" | štandartné nástroje TYPU „B"

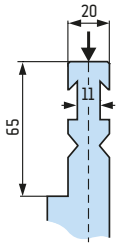
Material
42CrMo4 or 1.2312
Thermal enhancement to*
30 ±2 HRc (950 – 1100 MPa)
Working edge hardened
55 ±2 HRc (1500 – 1600 MPa)
Length
515 and 550 mm segmented
** applies to 1.2312*

Materiál
40HM alebo 1.2312
Tepelné zušľachtenie*
30 ±2 HRc (950 – 1100 MPa)
Pracovné plochy kalené
55 ±2 HRc (1500 – 1600 MPa)
Dĺžka
515 i 550 mm segmentované
** týka sa 1.2312*

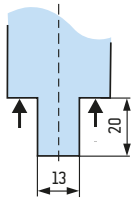
Sectionalized tool TYPE "B".
Schéma segmentového nástroja TYPU „B".



Punch mounting edge.
Upínanie razníka.



Die mounting edge.
Upínanie matríc.



standard tools TYPE "L" | štandartné nástroje 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*

Materiál

40HM alebo 1.2312

Tepelné zušľachtenie*

30 ±2 HRc (950 – 1100 MPa)

Pracovné plochy kalené

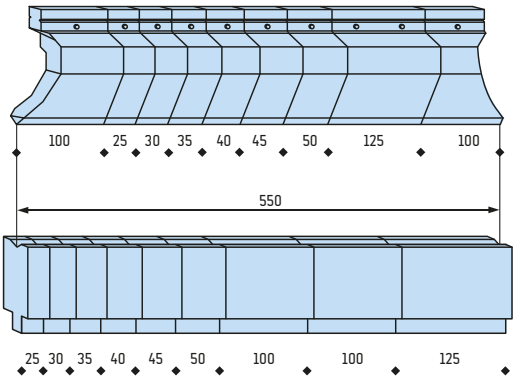
55 ±2 HRc (1500 – 1600 MPa)

Dĺžka

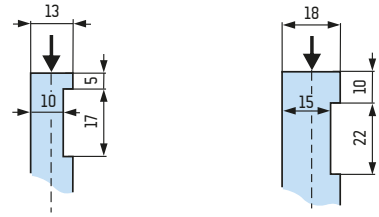
508 mm, 550 mm segmentované

** týka sa 1.2312*

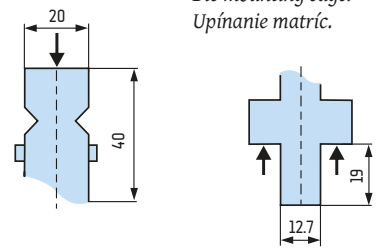
Sectionalized tool TYPE "L".
Schéma segmentového nástroja TYPU „L".



Punches TYPE "L" have three different clampings.
Razníky TYPU „L" sú dostupné s troma typmi upínania.

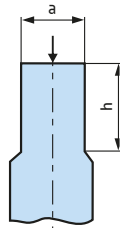


Die mounting edge.
Upínanie matríc.

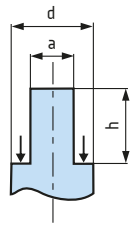


punch mounting edge | typy držiakov razníkov

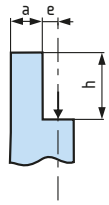
A



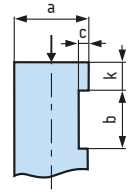
B



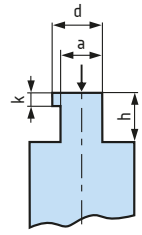
C



D



E



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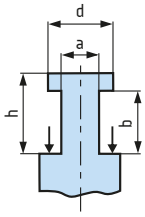

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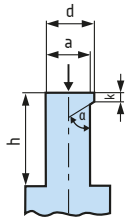

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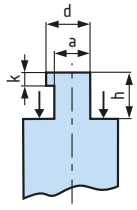
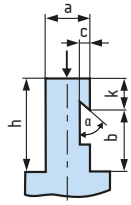


I

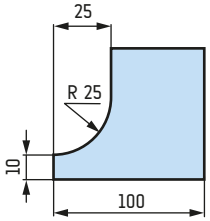


We offer punches with mounting edges as shown.
The client can order a type from the drawing specifying his dimensions.
The client may order a mounting edge to his own design.
Maximal strength of tools is valid only for air bending.

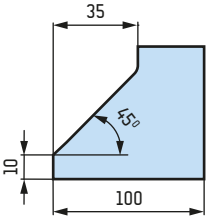
V ponuke sú razníky so štandardným upínaním aj s inými typmi upínania.
Zákazník si môže objednať náradie s upínaním z prezentovanej sady po zadaní symbolu písmena (napr. "E") a vyznačených rozmerov. Náradie si môžete objednať aj s upínaním podľa vlastného dizajnu.
Všetky maximálne prípustné tlaky uvedené v katalógu platia pre ohýbanie vo vzduchu.

horns for TYPE ”A“ punches
bočné rohy razníkov TYPU „A”

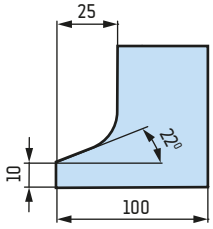
AH1



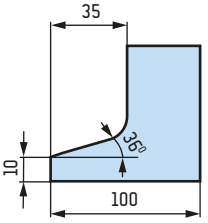
AH2



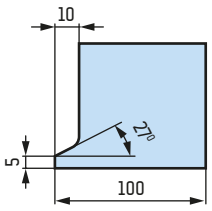
AH3



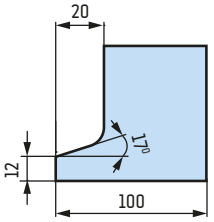
AH4



AH5

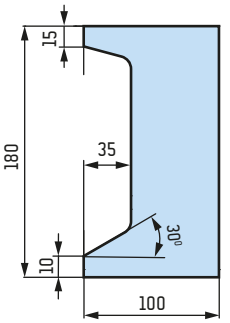


AH6

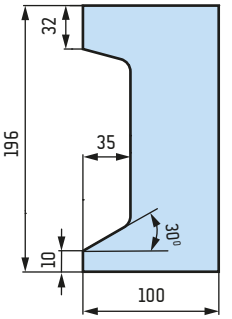


horns for TYPE “L” punches
bočné rohy razníkov TYPU „L”

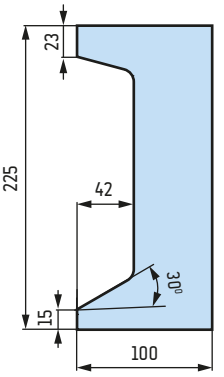
LH1



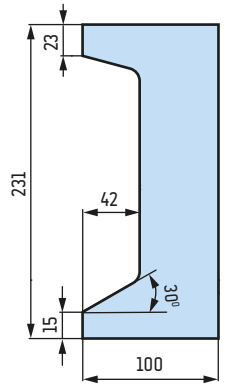
LH2



LH3

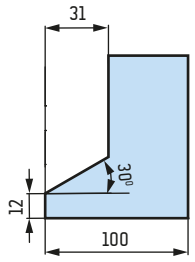


LH4



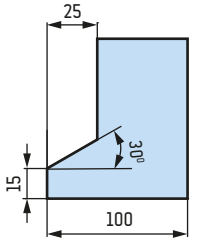
horns for TYPE ”T“ punches
bočné rohy razníkov TYPU „T”

TH



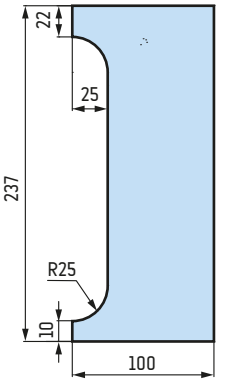
horns for TYPE ”B“ punches
bočné rohy razníkov TYPU „B”

BH



horns for TYPE ”W“ punches
bočné rohy razníkov TYPU „W”

WH



tool ordering code | spôsob objednávania

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*

Razníky np. S 2010/88/R0.8/835
S 2010/88/R0.8/835 – *Katalógové číslo razníka*
S 2010/**88**/R0.8/835 – *Uhol α = 30°, 35°, 60°, 75°, 80°, 88°, 90°*
S 2010/88/**R0.8**/835 – *Pracovná časť razníka („F" alebo „R" oa veľkosť)*
S 2010/88/R0.8/**835** – *Dĺžka elementu 835 mm, 415 mm, 835 mm segmentovaná*

Matrice np. M 6112/35/835
M 6112/35/835 – *Katalógové číslo matrice*
M 6112/**35**/835 – *Uhol α = 30°, 35°, 60°, 85°, 88°, 90°*
M 6112/35/**835** – *Dĺžka nástroja 835 mm, 415 mm, 835 mm segmentovaná*

special tools | špeciálne nástroje

Material	**Materiál**
C45, 42CrMo4 or 1.2312	*C45, 40HM alebo 1.2312*
Thermal enhancement to*	**Tepelné zušľachtenie***
30 ± 2HRc (950 – 1100 MPa)	*30 ± 2HRc (950 – 1100 MPa)*
Working edge hardened	**Pracovné plochy kalené**
55 ± 2HRc (1500 – 1600 MPa)	*55 ± 2HRc (1500 – 1600 MPa)*
Length	**Dĺžka**
up to 5000 mm	*do 5000 mm*
** applies to 1.2312*	** týka sa 1.2312*

additional information | označenia symbolov

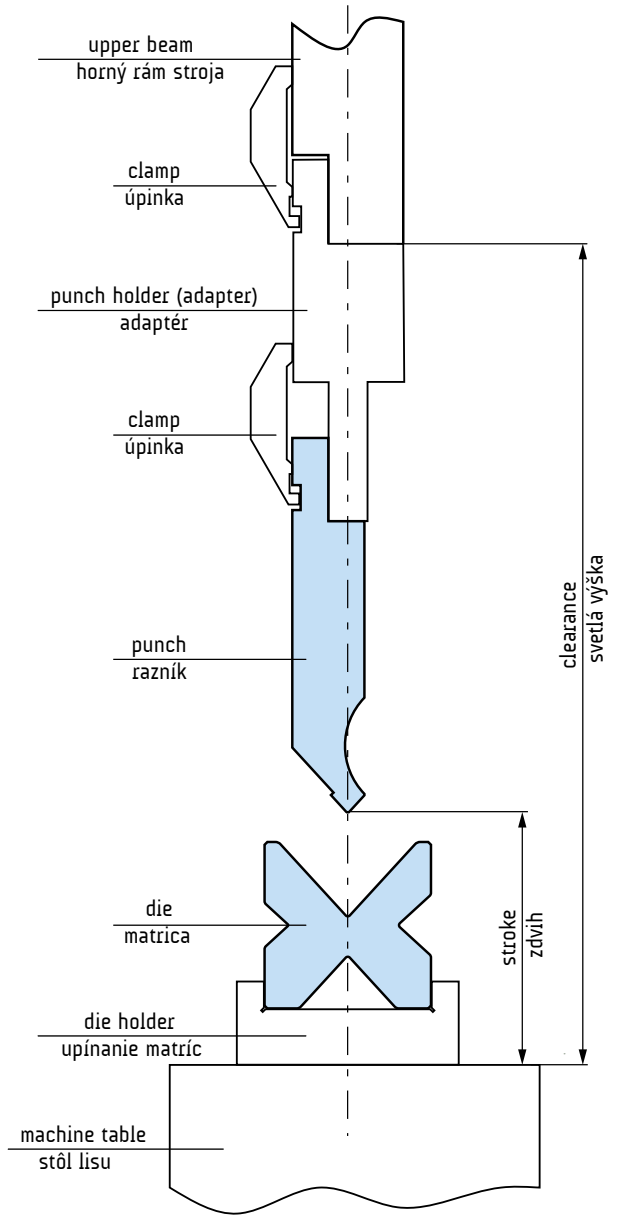
in stock / dostupné zo skladu

fast delivery possible / možné rýchle dodanie on

on order / na objednávku

42CrMo4 *42CrMo4 or 1.2312 steel as standard / nástroje vyrobené z ocele 42CrMo4 alebo 1.2312*

Operator's side view.
Pohľad zo strany operátora.



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

Príklad prierezu ohraňovacieho lisu, vrátane upevňovacích prvkov a dôležitých parametrov stroja.

Nástroje sú vyrobené najmä z vyššie uvedených druhov ocelí alebo inej ocele podobnej pevnosti.

Všetky štandardné nástroje PLASMET sú navrhnuté na ohýbanie vo vzduchu.

Predložený katalóg nepredstavuje obchodnú ponuku v zmysle Občianskeho zákonníka, ale slúži len na informačné účely.

tool refurbishment | regenerácia náradia

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.

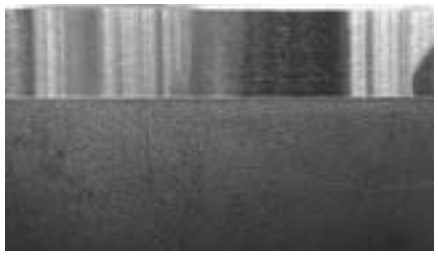
Plasmet sa špecializuje na komplexnú regeneráciu nástrojov ohraňovacích lisov a brúsenie gilotínových nožov. Vďaka nášmu modernému strojovému parku a tímu skúsených odborníkov zabezpečujeme plnú efektivitu a dlhodobú prevádzku všetkých typov lisovacích nástrojov..

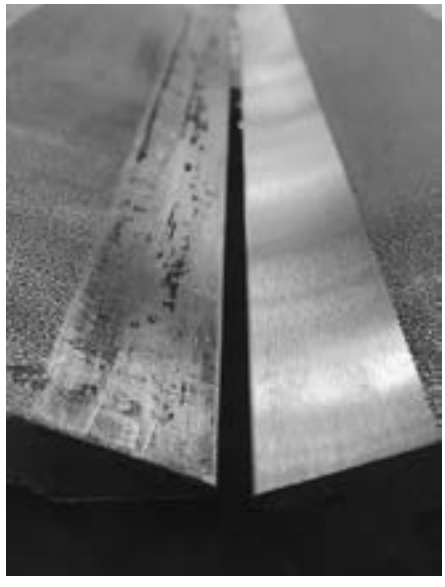
Regenerácia nástroja zahŕňa:
– Brúsenie pracovných plôch nástroja – proces, ktorý obnovuje obrys blízky originálu a zabezpečuje efektívnu prácu.
– Zjednotenie výšky repasovaného náradia v dodanej sade – zaručuje maximálnu presnosť a spoľahlivosť pri používaní.
– Zbavenie sa uhlíkových usadenín a stôp po používaní.
– Ak to nástrojový materiál umožňuje, používame kalenie laserom, čím sa zvyšuje ich životnosť a odolnosť proti opotrebeniu.

Before refurbishmnet / Pred regeneráciou

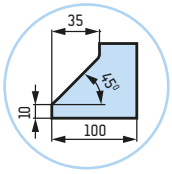


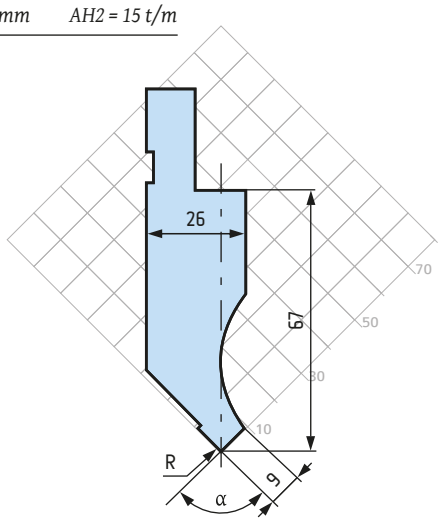
After refurbishment / Po regenerácii



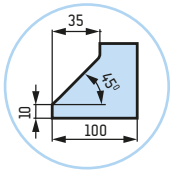


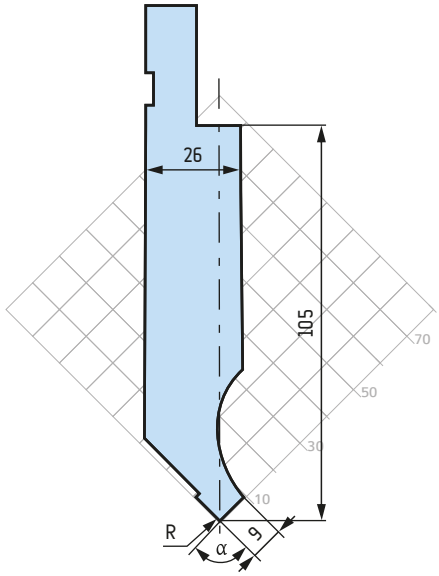
S 2010	100 t/m
α = 75°, R = 0.8 mm, H = 67.6 mm	*AH2 = 25 t/m*
α = 85°, R = 0.8 mm, H = 66.6 mm	*AH2 = 25 t/m*
α = 88°, R = 0.2 mm, H = 66.9 mm	*AH2 = 18 t/m*
α = 88°, R = 0.8 mm, H = 66.6 mm	*AH2 = 25 t/m*
α = 88°, R =1.5 mm, H = 65.9 mm	*AH2 = 25 t/m*
α = 88°, R =3 mm, H = 65.25 mm	*AH2 = 25 t/m*
α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



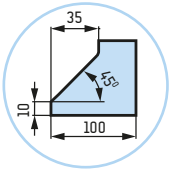


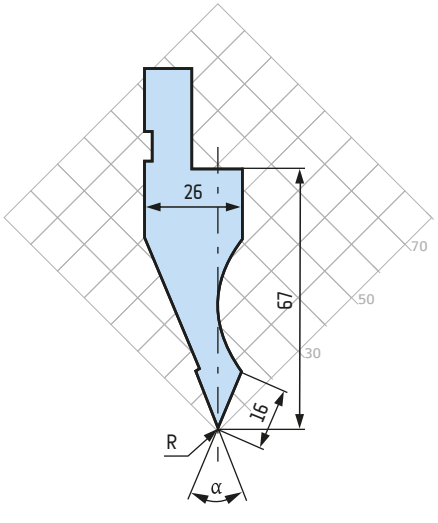
S 2010/105	100 t/m
α = 75°, 85°, 88°	
R = 0.8 mm	*AH2 = 25 t/m*



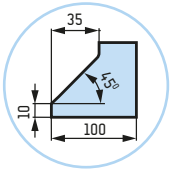


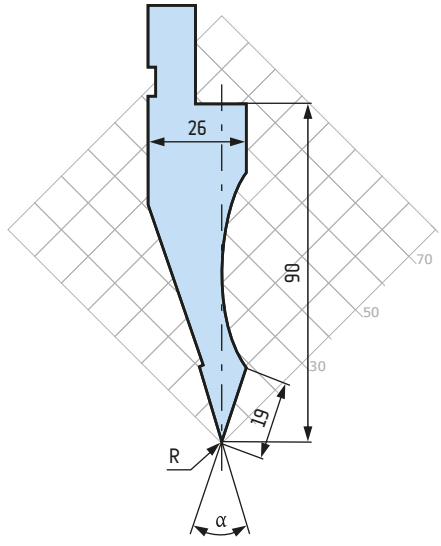
S 2011	80 t/m
α = 45°	
R = 0.4 mm, 0.8 mm	*AH2 = 20 t/m*
R = 1.5 mm	*AH2 = 25 t/m*





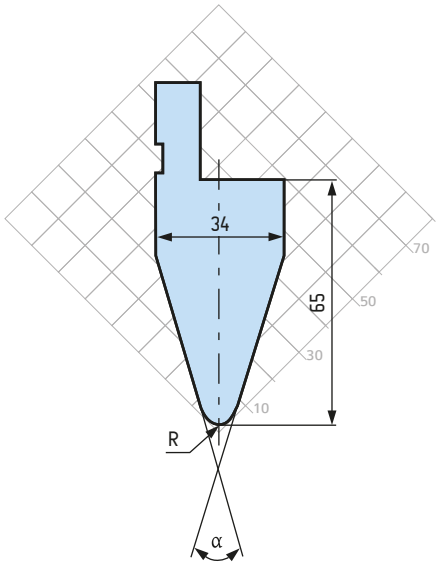
S 2012	70 t/m
α = 30°, 35°	
R = 1 mm	*AH2 = 20 t/m*

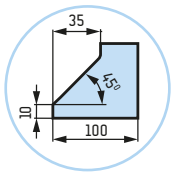




24h

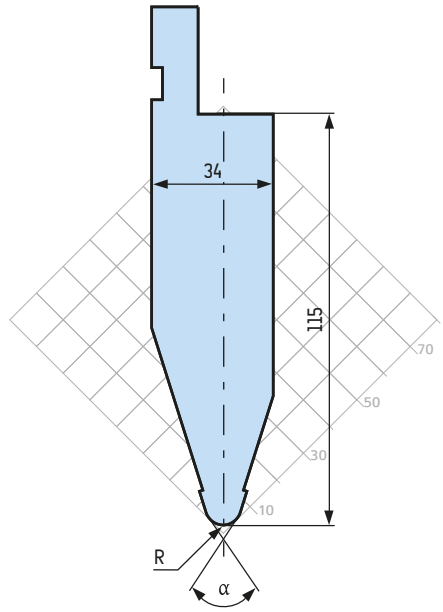
S 2013	100 t/m
α = 35°, R = 5 mm	*AH2 = 65 t/m*
α = 60°, R = 6 mm	*AH2 = 65 t/m*
α = 80°, R = 6 mm	*AH2 = 65 t/m*

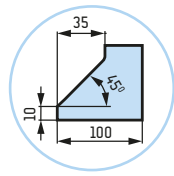




24h

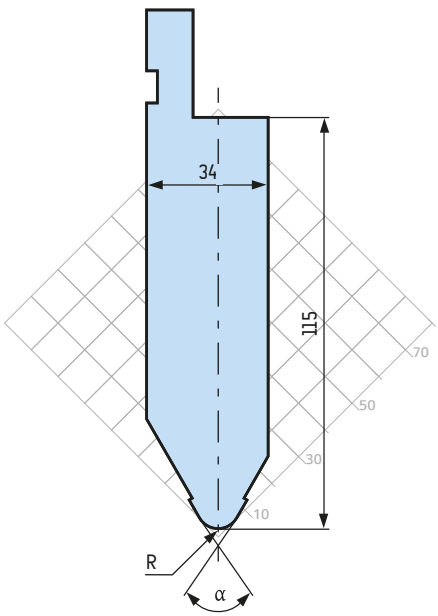
S 2013/115	100 t/m
α = 35°, R = 5 mm	*AH2 = 65 t/m*

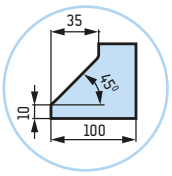




24h

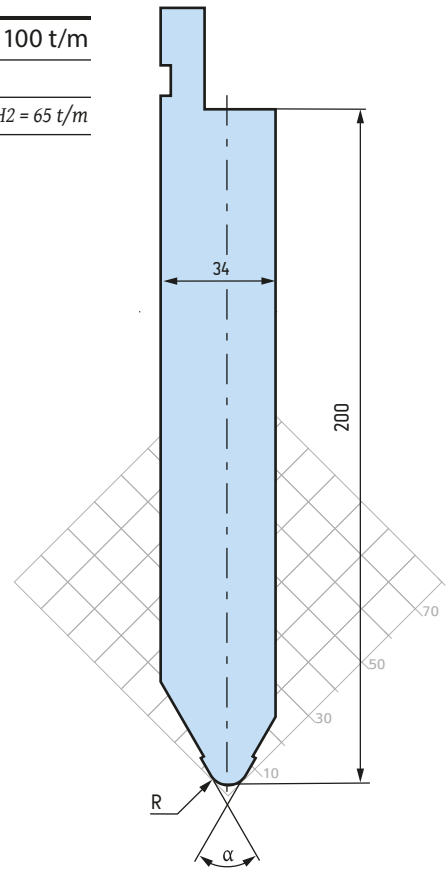
S 2013/115	100 t/m
α = 60°	
R = 6 mm, 10 mm	*AH2 = 65 t/m*

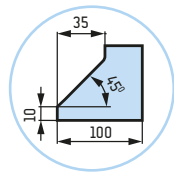




24h

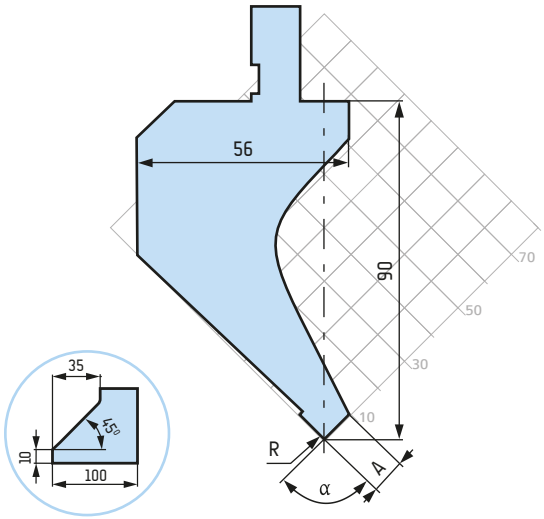
S2013/200	100 t/m
α = 60°	
R = 6 mm	*AH2 = 65 t/m*





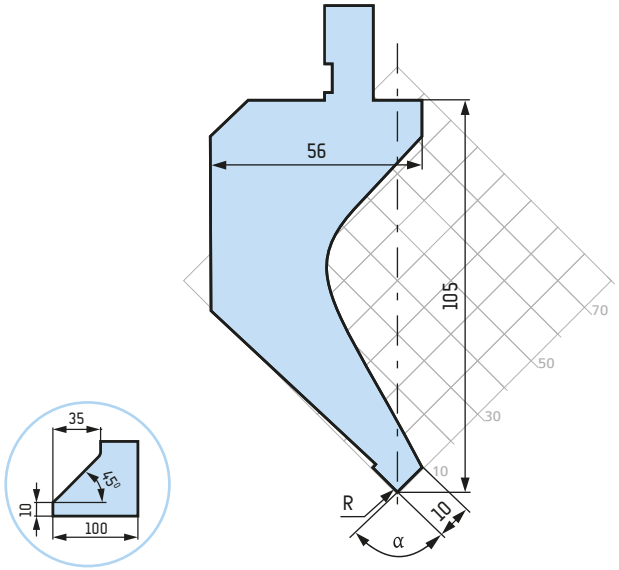
24h

S 2014	60 t/m
*α = 75°, A = 9 mm, R = 0 8 mm *20 t/m*	*AH2 = 7 t/m*
α = 85°, A = 9 mm, R = 0 8 mm	*AH2 = 15 t/m*
*α = 88°, A = 6 mm, R = 0.2 mm, 0.8 mm *50 t/m*	*AH2 = 15 t/m*
α = 88°, A = 9 mm , R = 0.2 mm, 0.8 mm	*AH2 = 15 t/m*



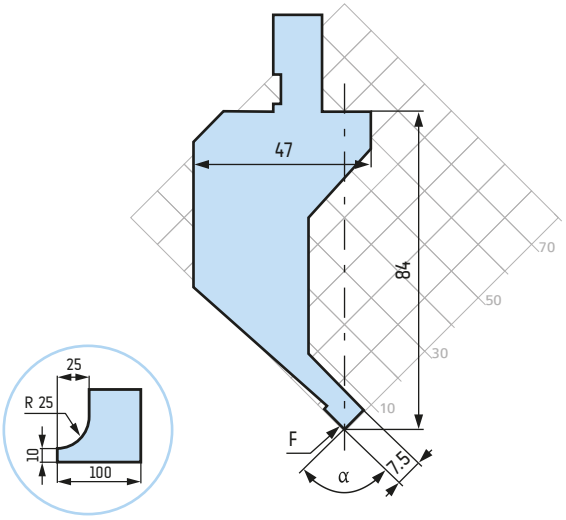
24h

S 2015	50 t/m
α = 85°, R = 0.8 mm	*AH2 = 12 t/m*
α = 88°, R = 0.2 mm, 0.8 mm	*AH2 = 12 t/m*
α = 90°, R = 0.8 mm	*AH2 = 12 t/m*



24h

S 2016	15 t/m
α = 88°, 90°	
F = 0.6 mm	*AH1 = 6 t/m*

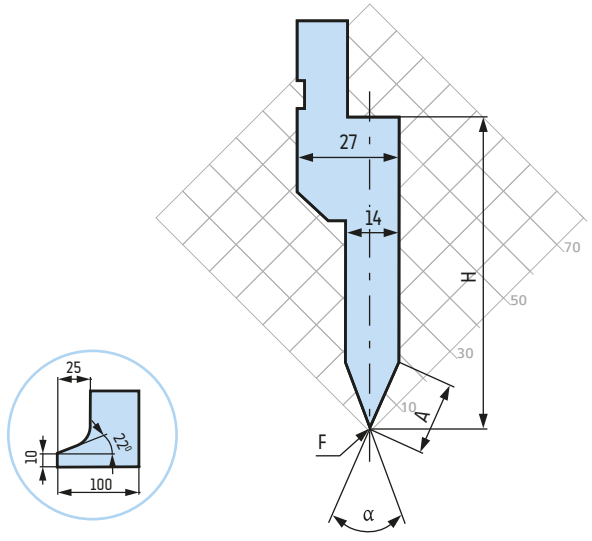


24h

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

24h

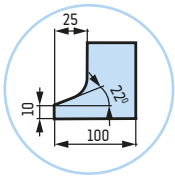
S 2017/35	100 t/m
H = 85 mm, A = 21 mm	
α = 35°	
F = 0.8 mm	*AH3 = 12 t/m*

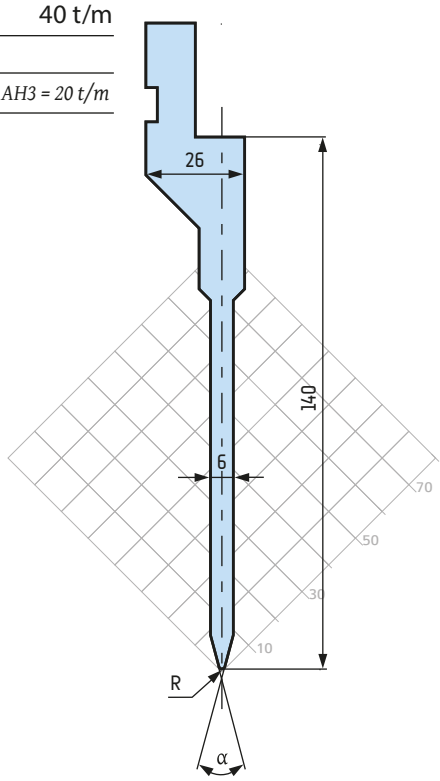


24h 42CrMo4

S 2017/30 — 40 t/m

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

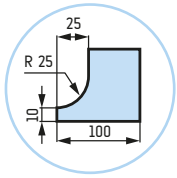


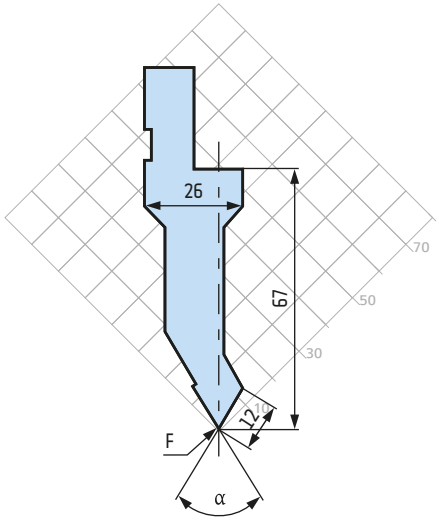


24h

S 2018 — 60 t/m

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

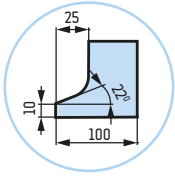


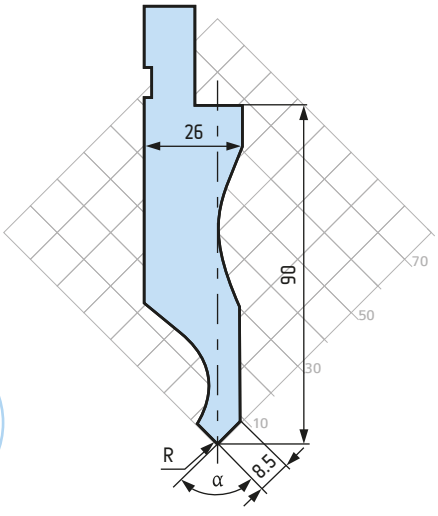


24h

S 2019 — 70 t/m

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

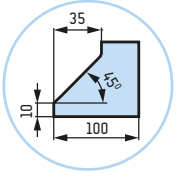


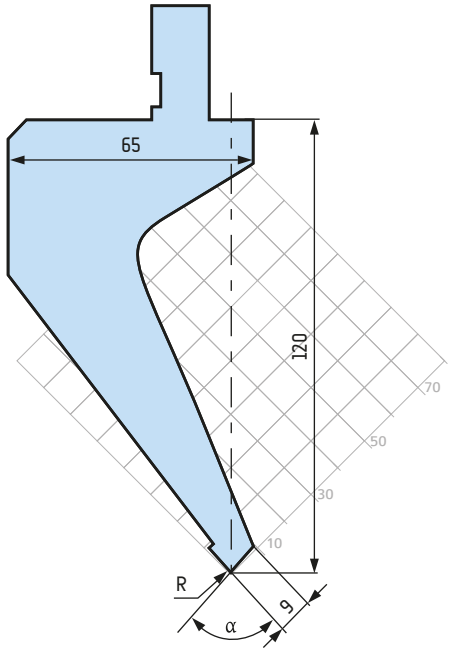


24h

S 2020 — 50 t/m

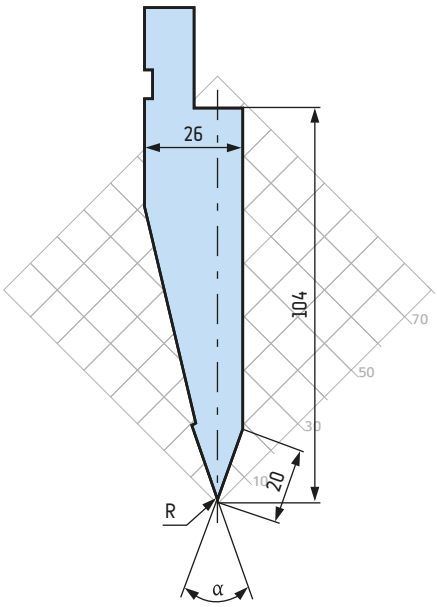
$\alpha = 75^0$, $R = 0.8$ mm	$AH2 = 15$ t/m
$\alpha = 85^0$, $R = 0.2$ mm, $R = 0.8$ mm	$AH2 = 12$ t/m
$\alpha = 88^0$, $R = 0.2$ mm, $R = 0.8$ mm	$AH2 = 12$ t/m

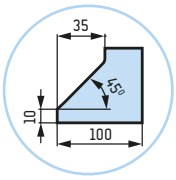




24h

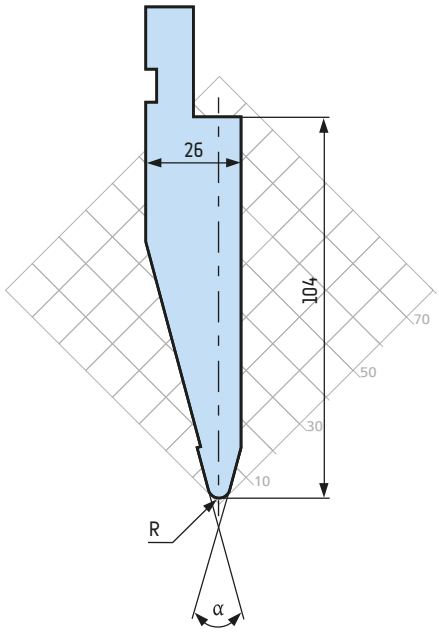
S 2021	100 t/m
$\alpha = 30^0$	
$R = 0.8$ mm	$AH2 = 30$ t/m

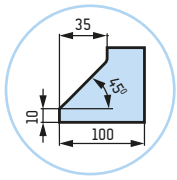




24h

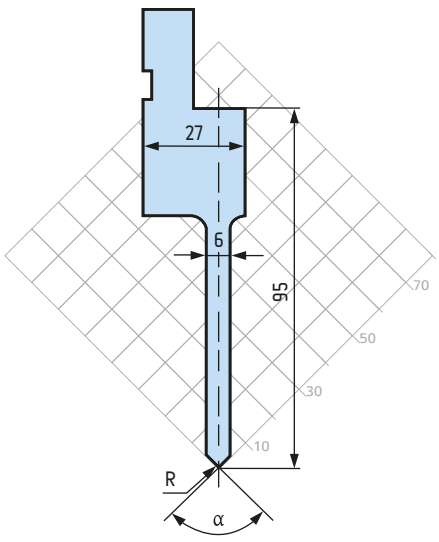
S 2021/R3	100 t/m
$\alpha = 30^0$	
$R = 3$ mm	$AH2 = 35$ t/m

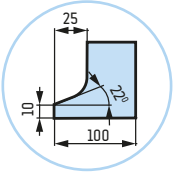




24h

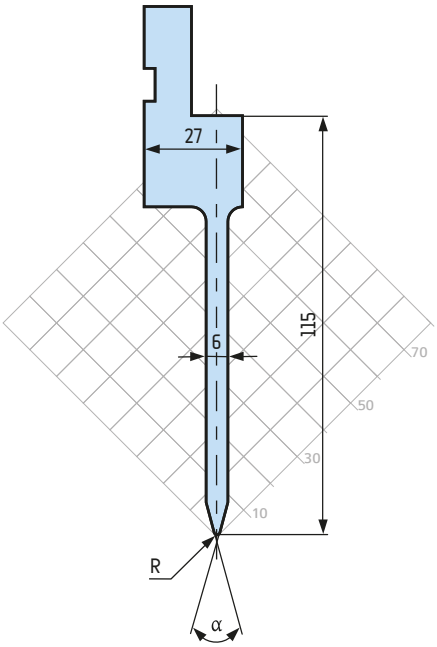
S 2022	50 t/m
$\alpha = 75^0$, $R = 0.8$ mm	$AH3 = 14$ t/m
$\alpha = 88^0$, $R = 0.2$ mm	$AH3 = 14$ t/m
$\alpha = 90^0$, $R = 0.2$ mm	$AH3 = 14$ t/m

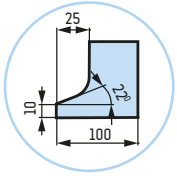




24h

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



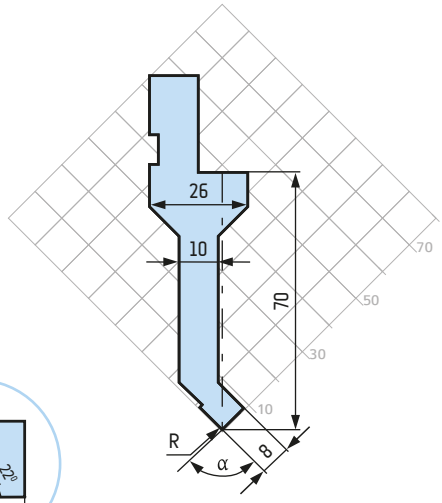


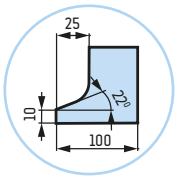
24h

S 2023 30 t/m

α = 85°, 88°, 90°

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



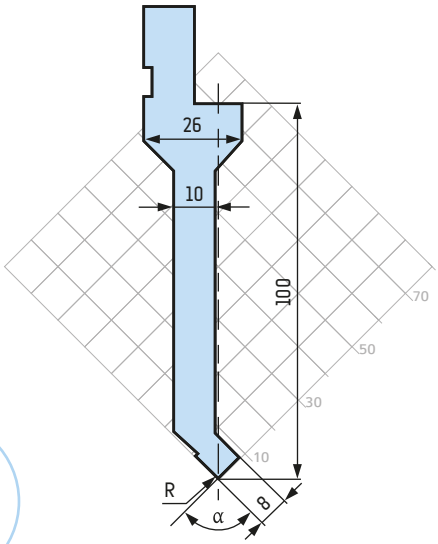


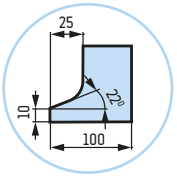
24h

S 2024 30 t/m

α = 85°, 88°, 90°

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



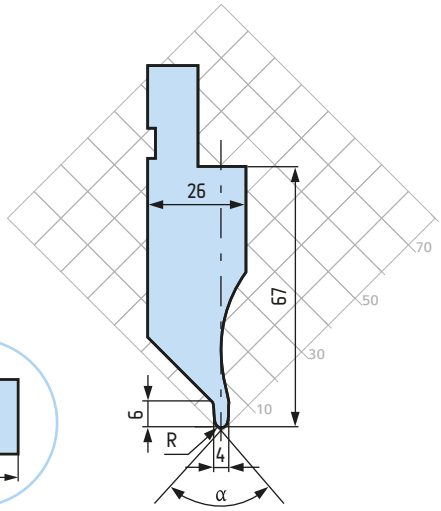


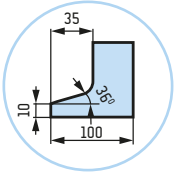
24h

S 2025 40 t/m

α = 88°, 90°

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



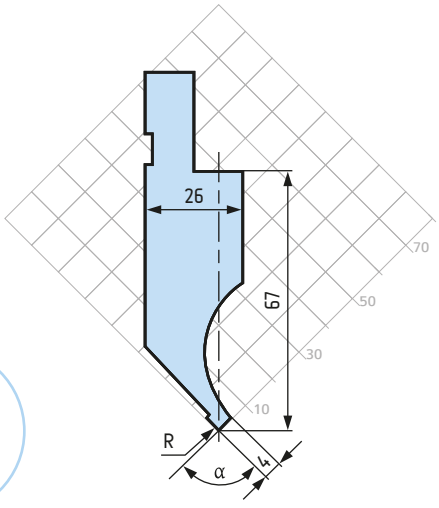


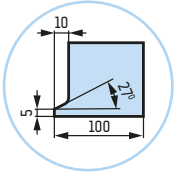
24h

S 2026 20 t/m

α = 88°, 90°

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



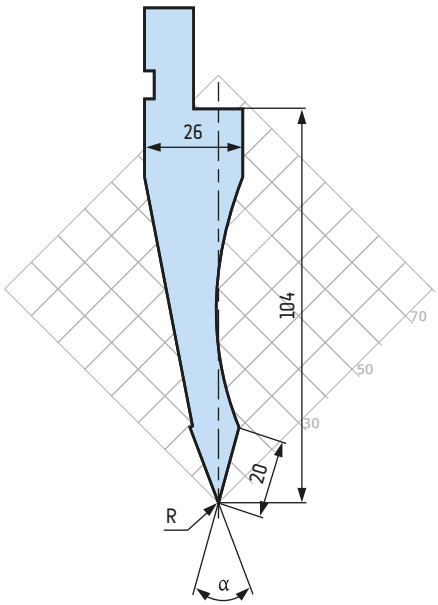


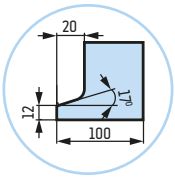
24h

S 2027 70 t/m

$\alpha = 30^0$

R = 0.8 mm *AH6 = 20 t/m*



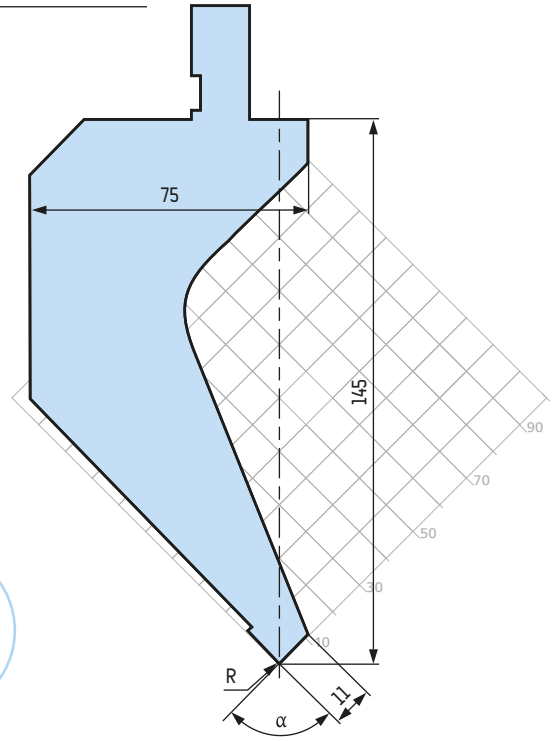


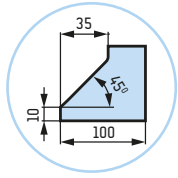
24h

S 2028 80 t/m

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

R = 0.8 mm *AH2 = 22 t/m*



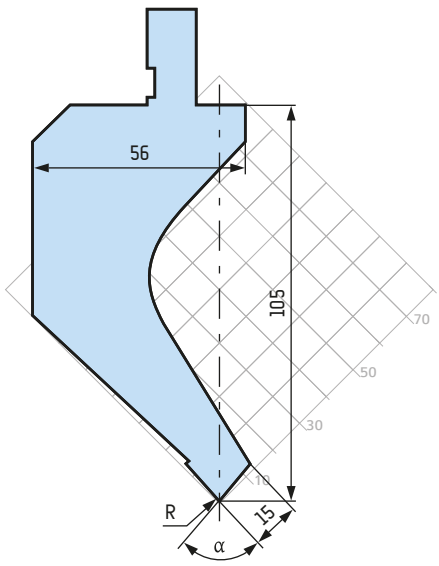


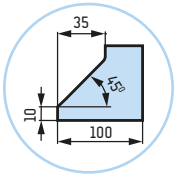
24h

S 2029 70 t/m

$\alpha = 85^0$

R = 5 mm, 6.5 mm *AH2 = 20 t/m*



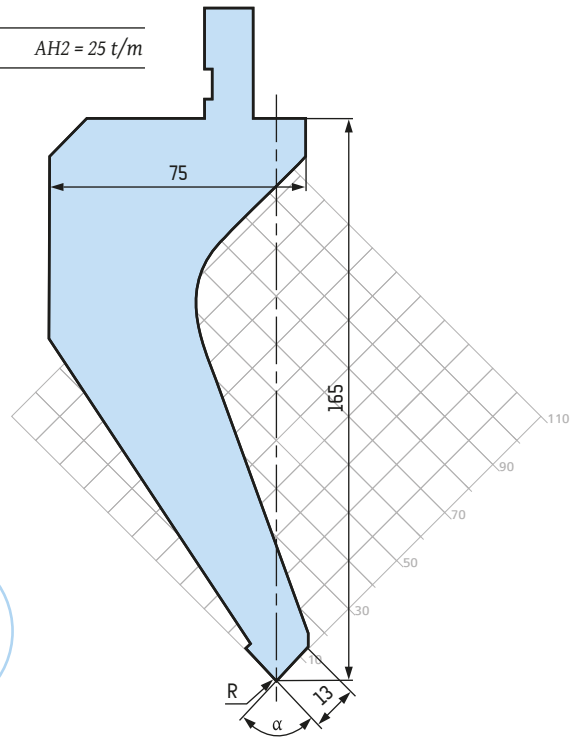


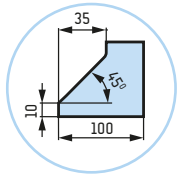
24h

S 2030 60 t/m

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

R = 0.8 mm *AH2 = 25 t/m*



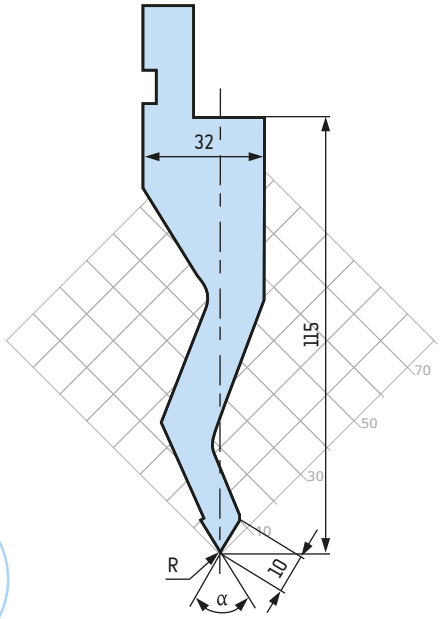


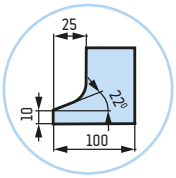
24h

S 2031 55 t/m

α = 60°

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



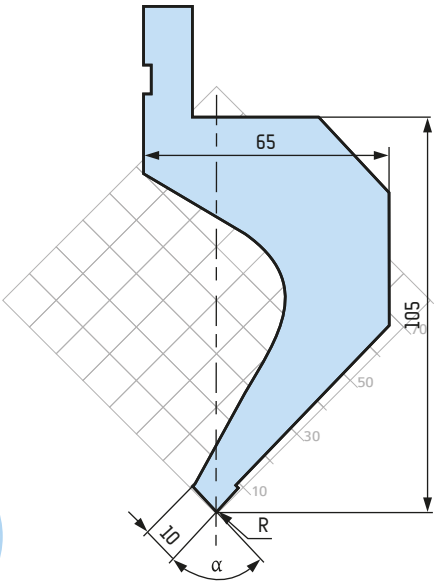


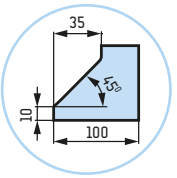
24h

S 2032 45 t/m

α = 88°

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



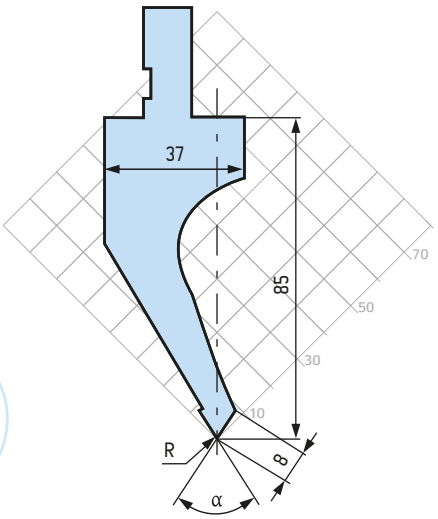


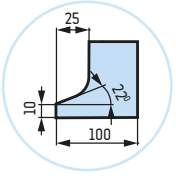
24h 42CrMo4

S 2034 35 t/m

α = 60°

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



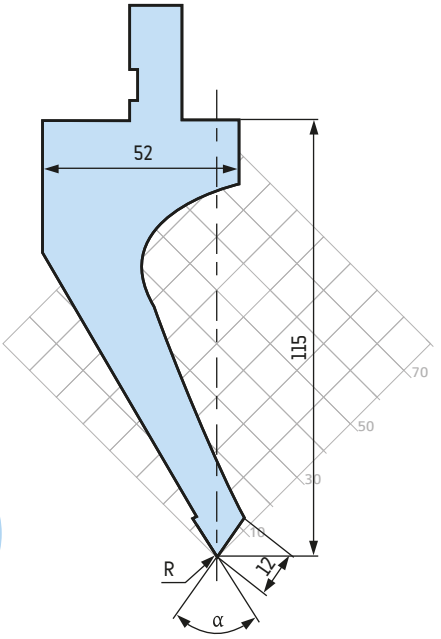


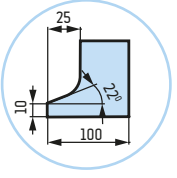
24h 42CrMo4

S 2035 35 t/m

α = 60°

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



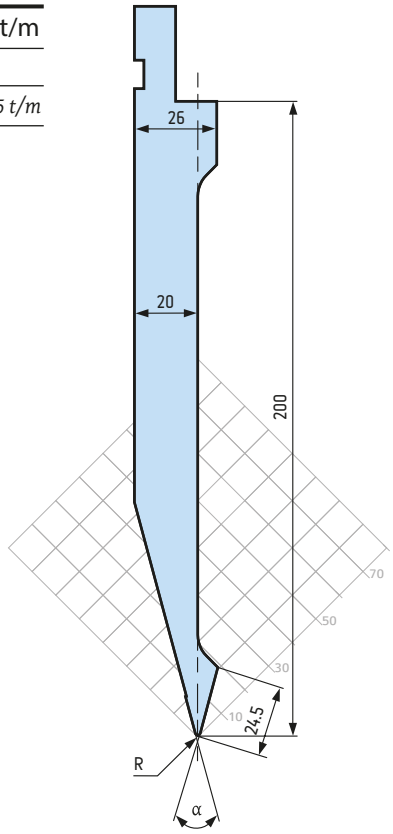


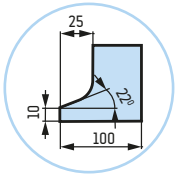
42CrMo4

S 2036 50 t/m

α = 30°

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



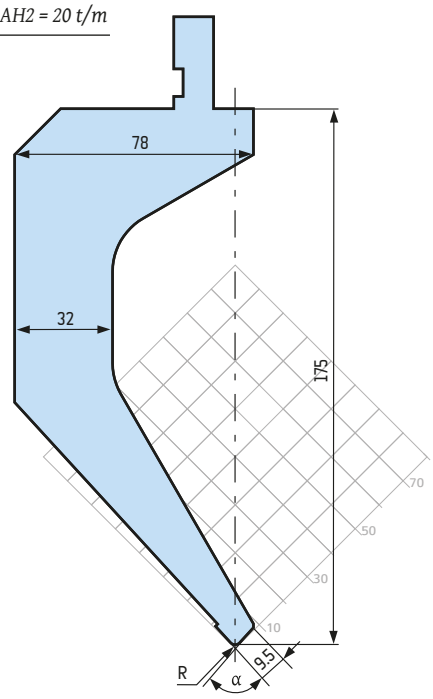


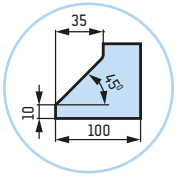
42CrMo4

S 2037 70 t/m

α = 85°

R = 0.8 mm *AH2 = 20 t/m*



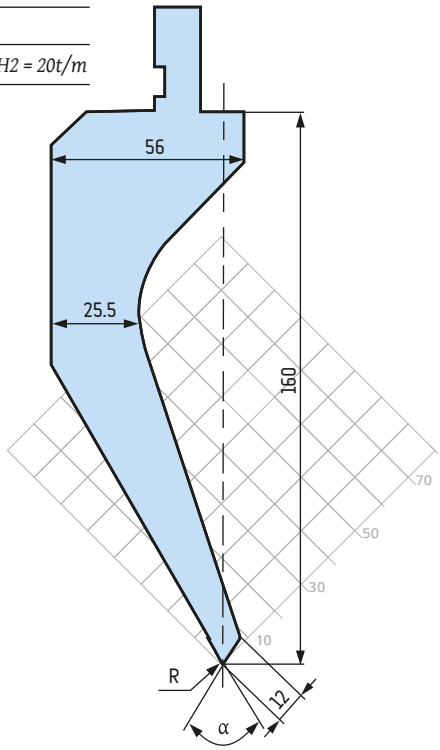


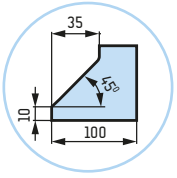
42CrMo4

S 2038 70 t/m

α = 60°

R = 0.8 mm *AH2 = 20t/m*

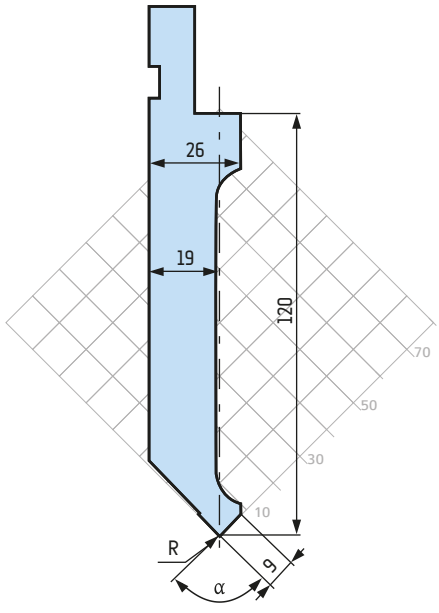


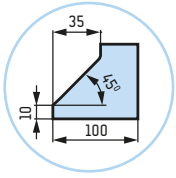


S 2039 100 t/m

α = 88°

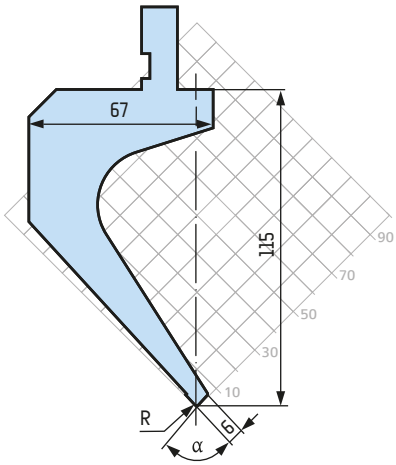
R = 0.5 mm *AH2 = 25 t/m*

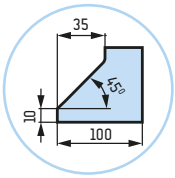




42CrMo4

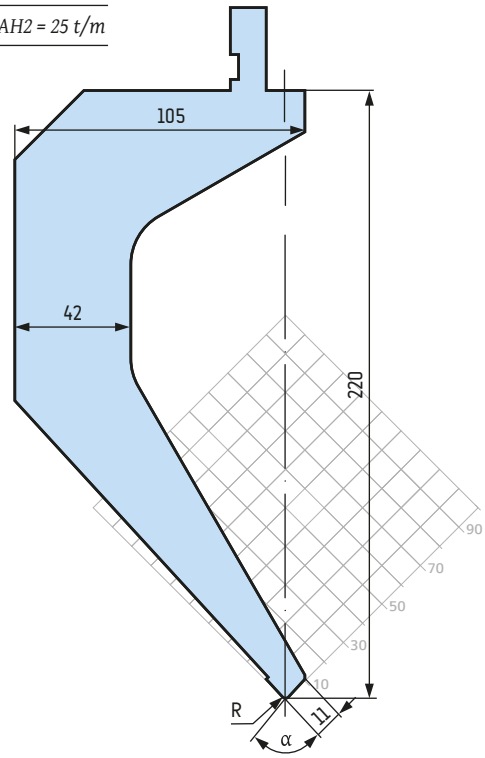
S 2040	30 t/m
α = 85⁰	
R = 0.8 mm	*AH2 = 10 t/m*

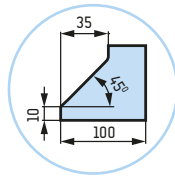




42CrMo4

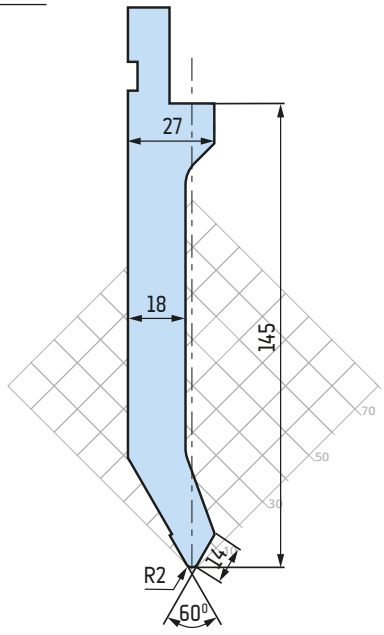
S 2041	80 t/m
α = 85⁰	
R = 1.5 mm	*AH2 = 25 t/m*

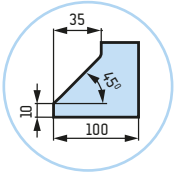




42CrMo4

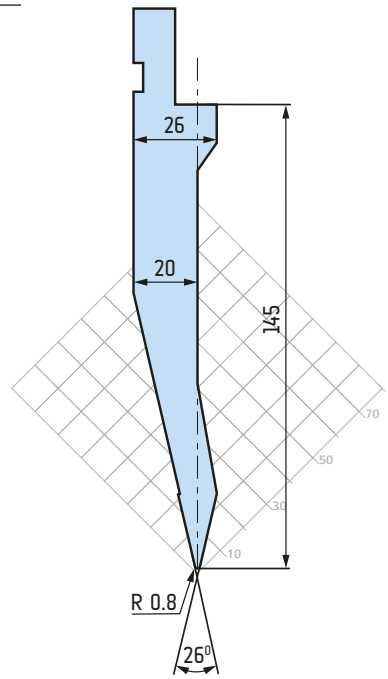
S 2042	70 t/m
α = 60⁰	
R = 2 mm	*AH2 = 25 t/m*

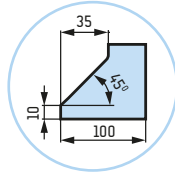




42CrMo4

S 2043	50 t/m
α = 26⁰	
R = 0.8 mm	*AH2 = 25 t/m*





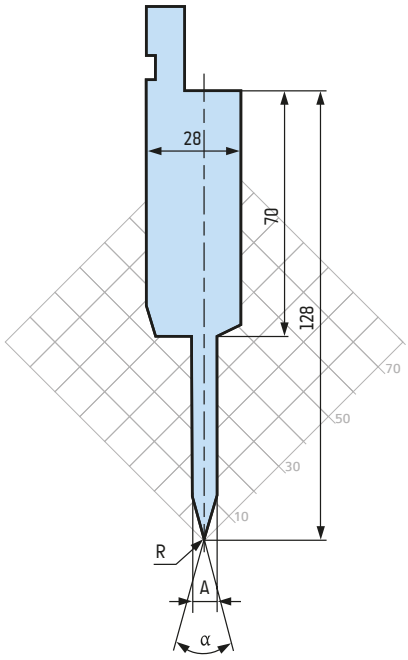
flattening tools | **nástroje na falcovanie**

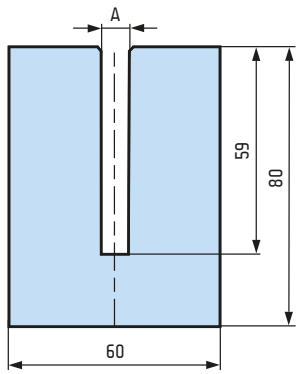
42CrMo4

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

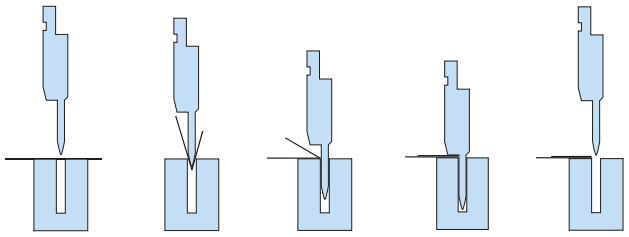
42CrMo4

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

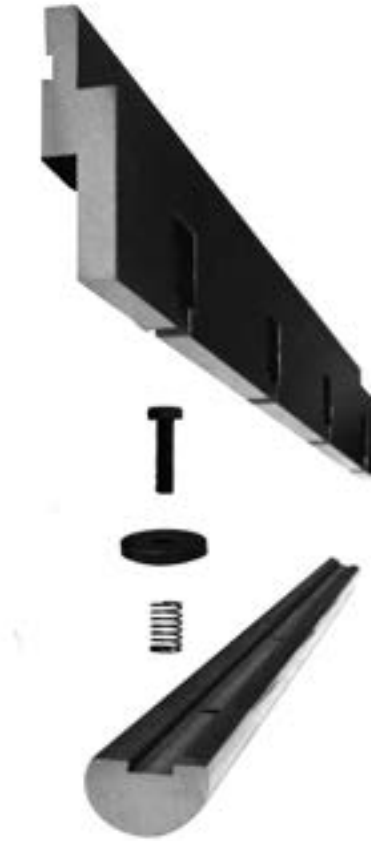


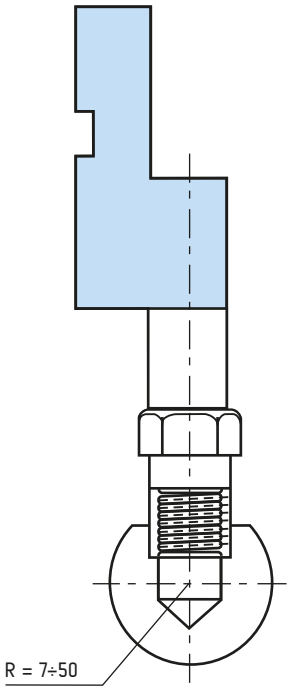


example of use S 2033 and M 3000
príklad aplikácie S 2033 a M 3000



assembly | **spôsob upevnenia**

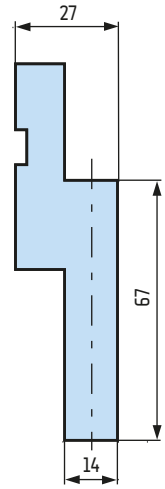




for inserts R 7 – R 50 | **pre vložky R 7 – R 50**

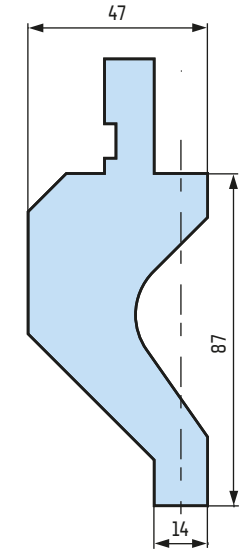
24h

PUNCH R | **RAZNÍK R** 80 t/m



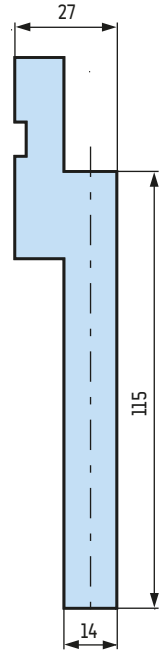
24h

PUNCH R 2 | **RAZNÍK R 2** 50 t/m



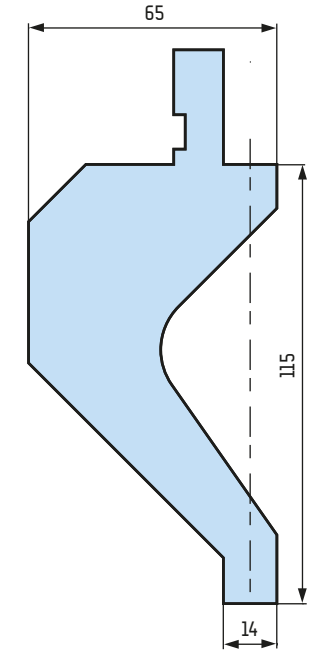
24h

PUNCH R/115 | **RAZNÍK R/115** 80 t/m



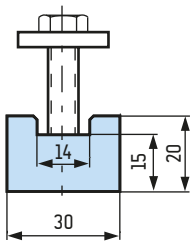
24h

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

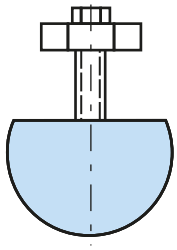


inserts R 7 – R 50 | **vložky R 7 – R 50**

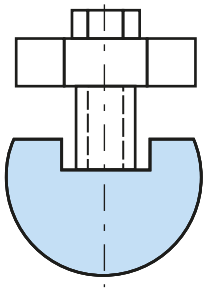
FLATTENING INSERT | **VLOŽKA PLOCHÁ**



VLOŽKA R 7 – R 12



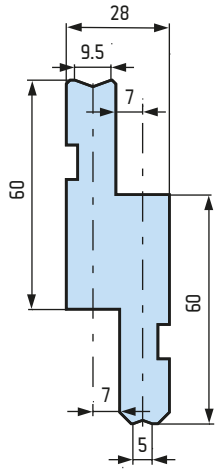
VLOŽKA R 12.5 – R 50



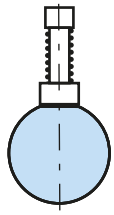
for inserts R 3 – R 6.5 | **pre vložky R 3 – R 6.5**

RAZNÍK R – R 80 t/m

Double radius punch.
Razník dvojitý rádiusový

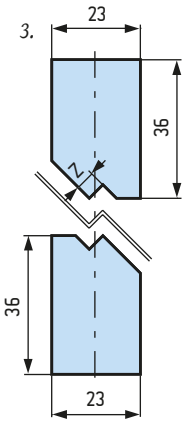


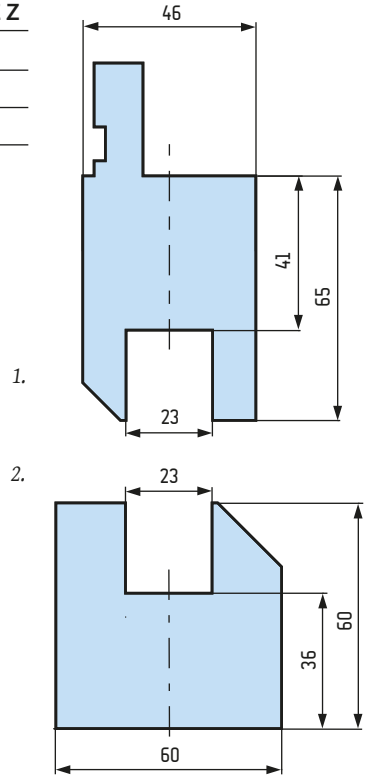
VLOŽKA R 3 – R 6.5



Z SHAPE TOOL | **ZOSTAVA PRE Z**

1. Z Punch / Razník Z
2. Z Die / Matrica Z
3. Z Insert (set) / Vložka Z (sada)





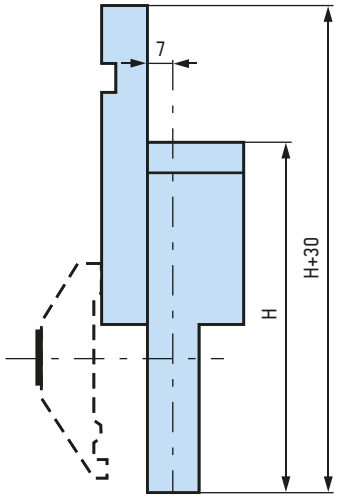
joiners | adaptéry

Note: The clamp is not included in the kit.
Pozor: Podložka nie je súčasťou sady.

24h

TYPE "A" | TYP „A"

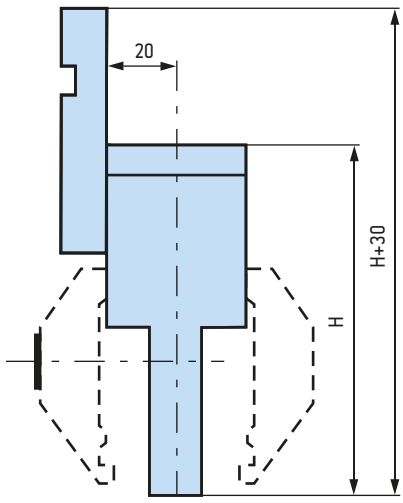
H = 100 mm, L = 150 mm
H = 120 mm, L = 150 mm
H = 140 mm, L = 150 mm
H = 150 mm, L = 150 mm



24h

TYPE "B" | TYP „B"

H = 120 mm, L = 150 mm
H = 170 mm, L = 150 mm

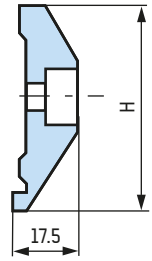


clamping washers | upevňovacie podložky

24h

TYPE "S" | TYP „S"

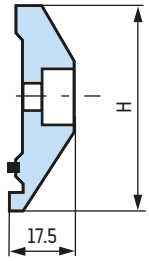
H = 58 mm, L = 150 mm



24h

TYPE "P" | TYP „P"

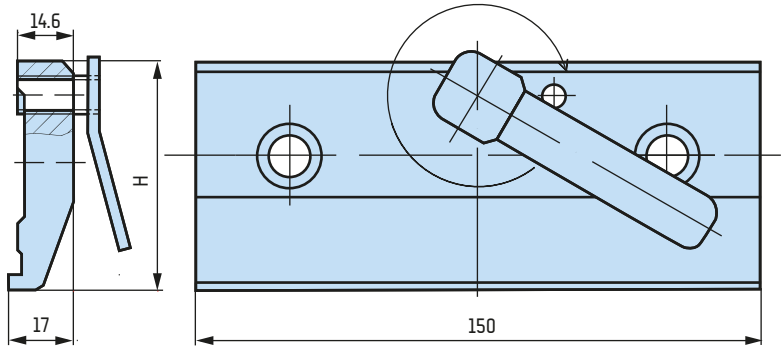
with plastic insert / s vložkou z plastu
H = 58 mm, L = 150 mm



24h

TYPE "QR" | TYP „QR"

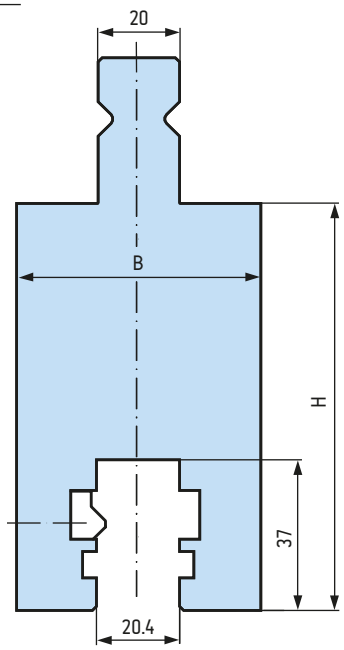
H = 60 mm, L = 150 mm



type "T" adaptor | upevňovacie adaptér typu „T"

24h 42CrMo4

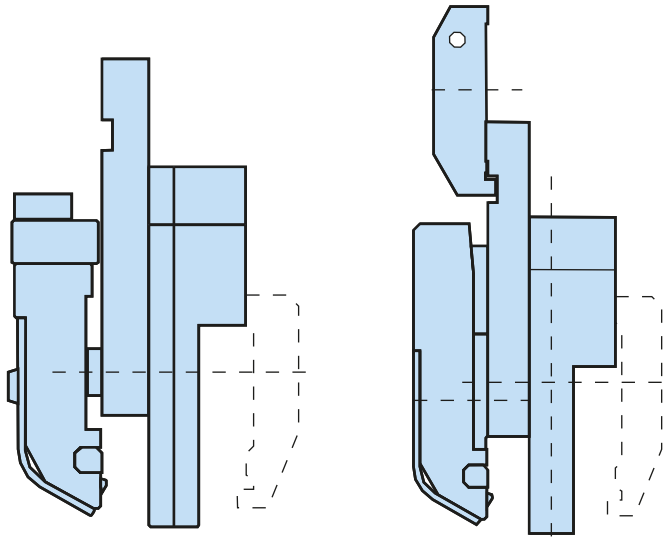
TYPE "T/T" | **TYP „T/T"**
H = 100 mm, L = 100 mm, B = 55 mm
H = 150 mm, L = 100 mm, B = 60 mm



TEDA adapters for quick installation of tools
adaptéry na rýchle upínanie nástrojov TEDA

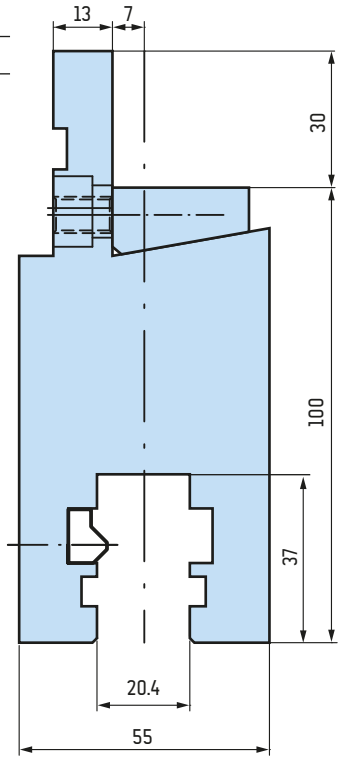
More information on p. 91
Viac informácií na str. 91

SPEED GRIP	**SPEED GRIP**
13000-M MANUAL | **RUČNÝ**	13000-ST PNEUMATIC | PNEUMATICKÝ



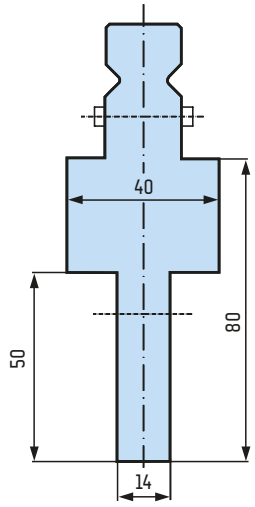
system changing adaptors
adaptéry medzisystémové

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

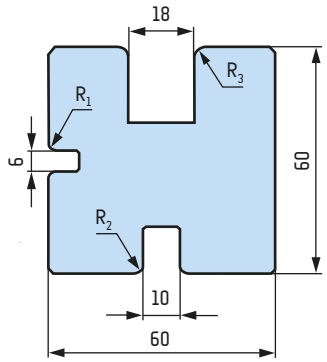


multiple vee dies | viacnásobné matrice

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

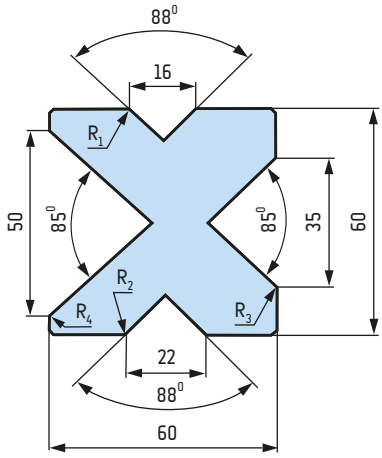
$\alpha = 85^0, 88^0$

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

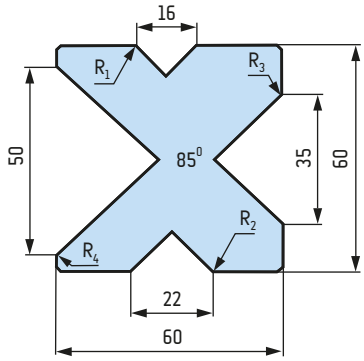


24h

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

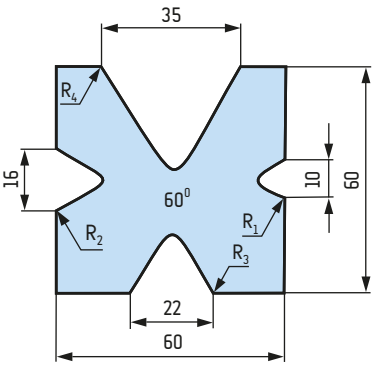


24h

M 4/60° 60 t/m

$\alpha = 60^0$

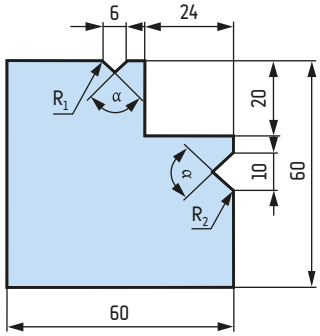
R_1 = 1 mm, R_2 = 2 mm, R_3 = 2 mm, R_4 = 3 mm



M 2/6 – 10 100 t/m

$\alpha = 90^0$

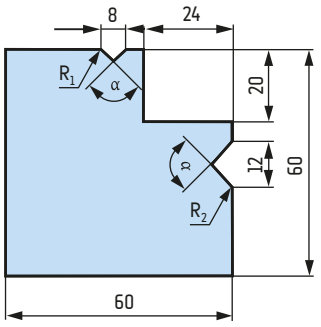
R_1 = 1 mm, R_2 = 1 mm



M 2/8 –12 80 t/m

$\alpha = 90^0$

R_1 = 1 mm, R_2 = 1 mm



with groove | matrice dvojdrážkové

M 6019 — 80 t/m

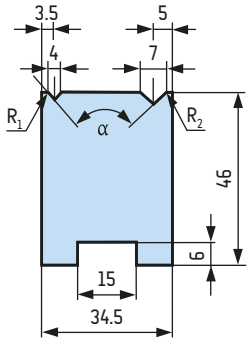
α = 90°

R_1 = 0.3 mm, R_2 = 0.5 mm

M 6119 — 80 t/m

α = 88°

R_1 = 0.3 mm, R_2 = 0.5 mm



M 6020 — 80 t/m

α = 90°

R_1 = 0.4 mm, R_2 = 0.6 mm

M 6220 — 35 t/m*

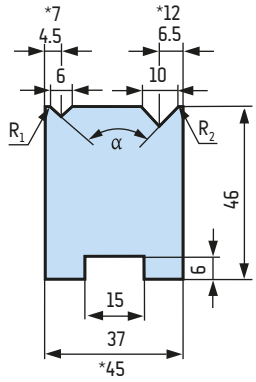
α = 30°

R_1 = 0.8 mm, R_2 = 2 mm

M 6120 — 80 t/m

α = 88°

R_1 = 0.4 mm, R_2 = 0.6 mm



M 6021 — 80 t/m

α = 90°

R_1 = 0.5 mm, R_2 = 0.8 mm

M 6221 — 40 t/m *

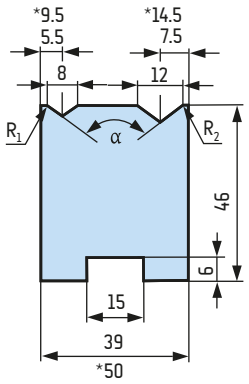
α = 30°

R_1 = 1 mm, R_2 = 1.5 mm

M 6121 — 80 t/m

α = 88°

R_1 = 0.5 mm, R_2 = 0.8 mm



M 6022 — 80 t/m

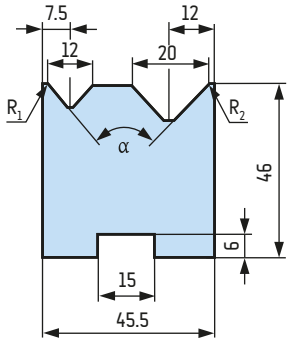
α = 90°

R_1 = 0.8 mm, R_2 = 2 mm

M 6122 — 80 t/m

α = 88°

R_1 = 1.6 mm, R_2 = 1.75 mm



M 6023 — 80 t/m

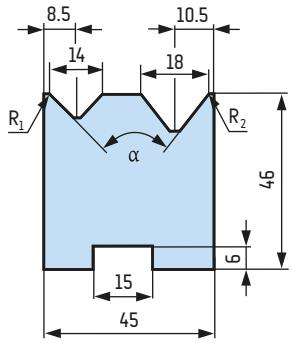
α = 90°

R_1 = 1.25 mm, R_2 = 1.5 mm

M 6123 — 80 t/m

α = 88°

R_1 = 1 mm, R_2 = 1.5 mm



M 6024 — 80 t/m

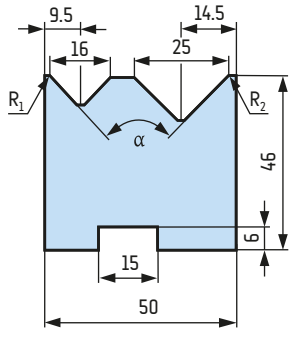
α = 90°

R_1 = 2.5 mm, R_2 = 3 mm

M 6124 — 80 t/m

α = 88°

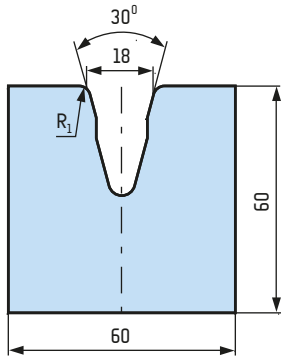
R_1 = 2.5 mm, R_2 = 3 mm



1V dies | matrice 1V

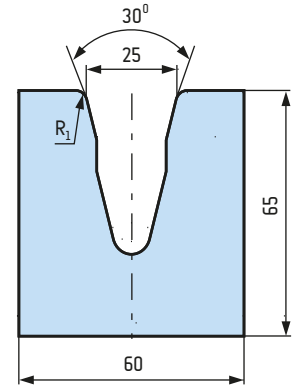
24h

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



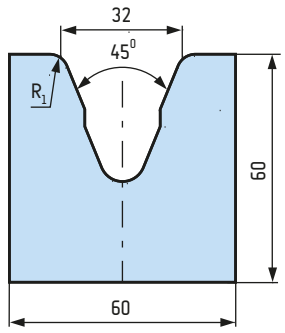
24h

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



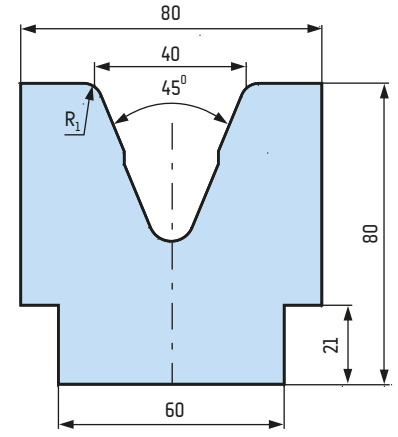
24h

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



24h

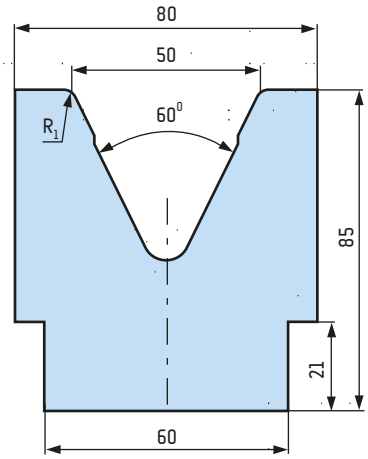
M 3345/40	100 t/m
$\alpha = 45^0$	
$V = 40\ mm$	
$R_1 = 5\ mm$	



1V dies | matrice 1V

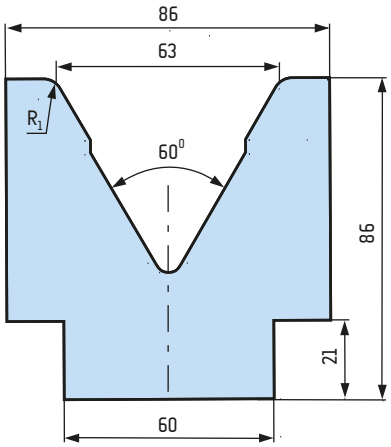
24h

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



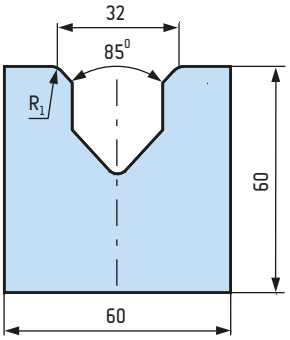
24h

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



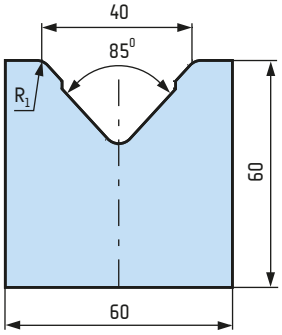
24h

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



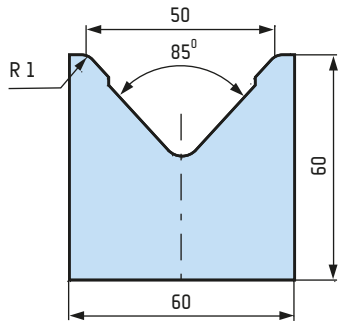
24h

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

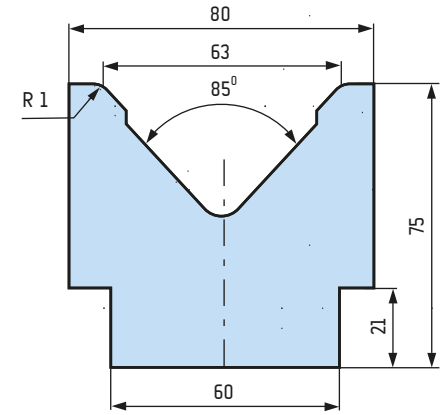


1V dies | matrice 1V

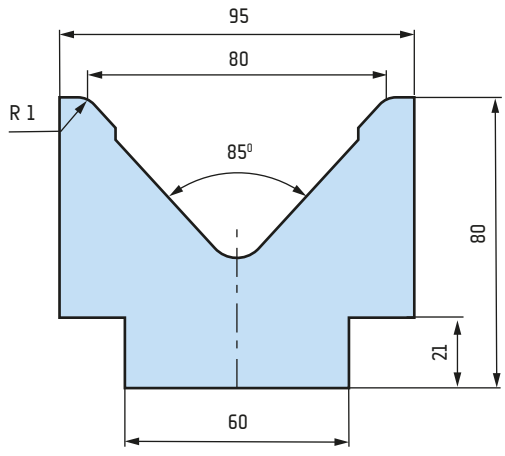
M 3385/50	100 t/m
$\alpha = 85^0$	
$V = 50$ mm	
$R_1 = 4$ mm	



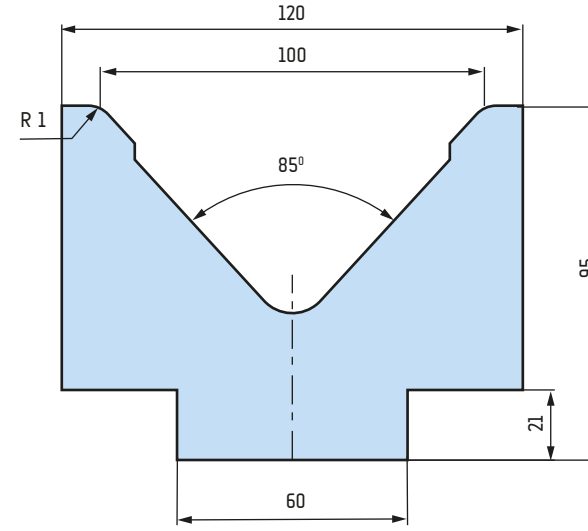
M 3385/63	100 t/m
$\alpha = 85^0$	
$V = 63$ mm	
$R_1 = 5$ mm	



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

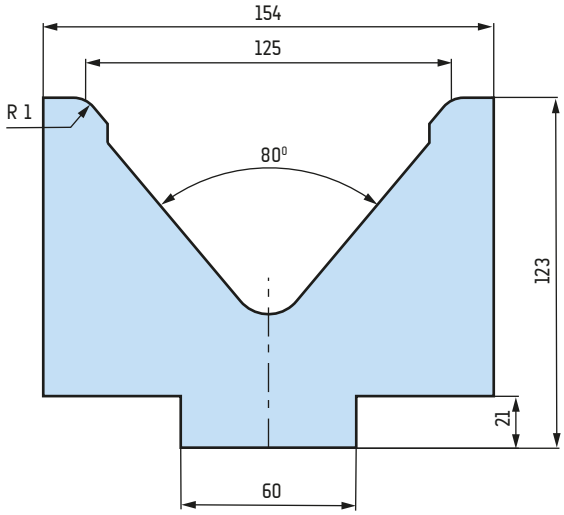


M 3385/100	100 t/m
$\alpha = 85^0$	
$V = 100$ mm	
$H = 95$ mm	
na objednávku $H = 110$ mm	
$R_1 = 7$ mm	

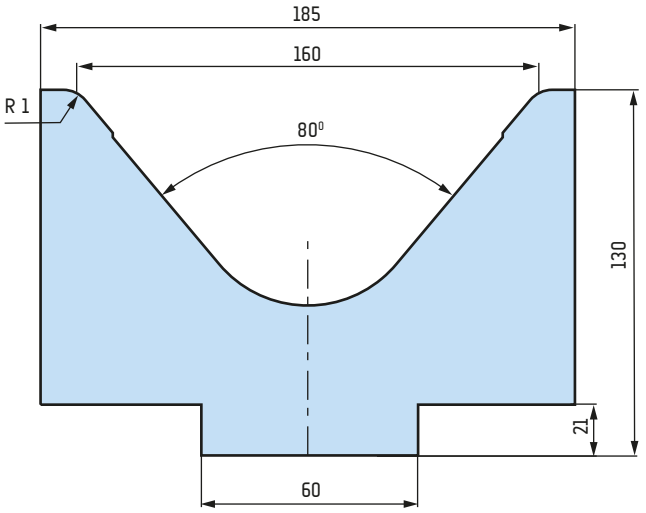


1V dies | matrice 1V

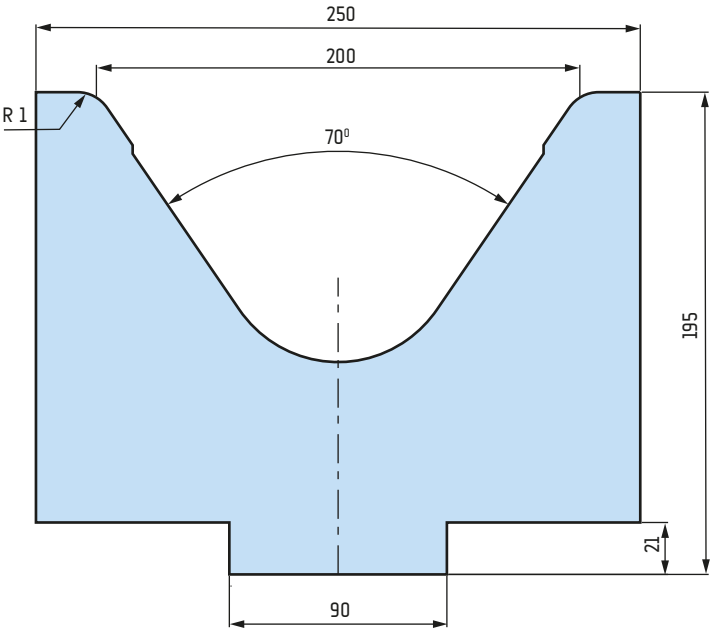
M3380/125	100 t/m
$\alpha = 80^0$	
$V = 125$ mm	
$H = 123$ mm	
$R_1 = 9$ mm	



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



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
Matrice upínané pomocou podpôr A 34, A 39, A 55 alebo A 75 –> str. 83

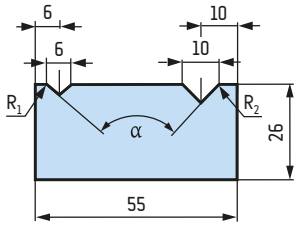
bolt fastened | upínané skrutkami

24h

M 6112 100 t/m

α = 90°

R_1 = 0.4 mm, R_2 = 0.8 mm



24h

M 6212 60 t/m

α = 60°

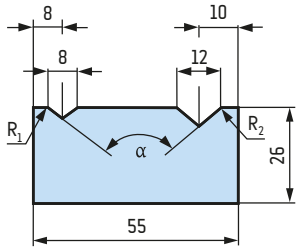
R_1 = 0.7 mm, R_2 = 1 mm

24h

M 6113 100 t/m

α = 90°

R_1 = 0.5 mm, R_2 = 0.8 mm



24h

M 6213 80 t/m

α = 60°

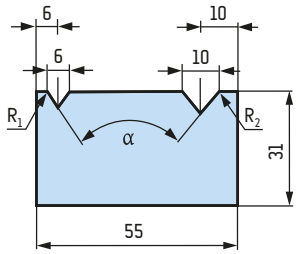
R_1 = 0.7 mm, R_2 = 1 mm

24h

M 6312 30 t/m

α = 35°

R_1 = 0.7 mm, R_2 = 1 mm

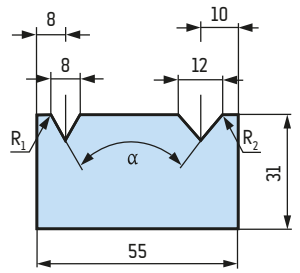


24h

M 6313 30 t/m

α = 35°

R_1 = 1.5 mm, R_2 = 2 mm

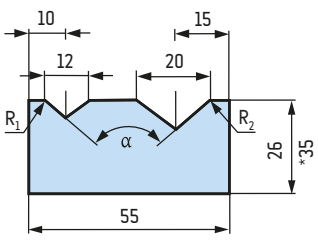


24h

M 6114 100 t/m

α = 88°

R_1 = 2.5 mm, R_2 = 3 mm



24h

M 6214 80 t/m *

α = 60°

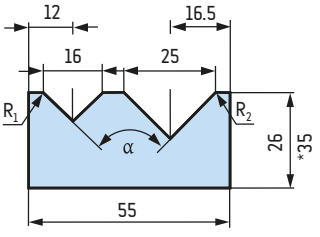
R_1 = 2.5 mm, R_2 = 3 mm

24h

M 6115 100 t/m

α = 88°

R_1 = 2.5 mm, R_2 = 3 mm



24h

M 6215 80 t/m *

α = 60°

R_1 = 2.5 mm, R_2 = 3 mm

TYPE ”A“ DIES | MATRICE TYPU „A“

dies with base H = 80 mm | matrice so základňou H = 80 mm

M 6130	30 t/m
A = 8 mm, B = 16 mm	
R_1 = 1 mm, R_2 = 1 mm	

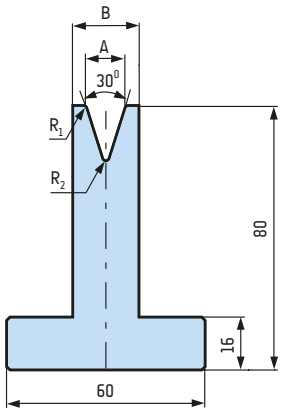
M 6230	35 t/m
A = 10 mm, B = 20 mm	
R_1 = 1 mm, R_2 = 1 mm	

M 6330	35 t/m
A = 12 mm, B = 22 mm	
R_1 = 1 mm, R_2 = 1 mm	

M 6430	45 t/m
A = 16 mm, B = 30 mm	
R_1 = 2 mm, R_2 = 2 mm	

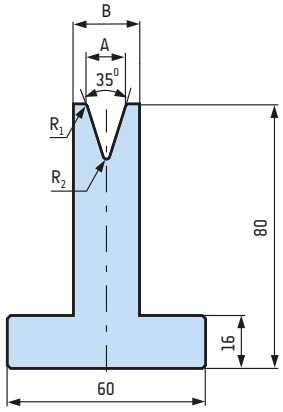
M 6530	30 t/m
A = 6 mm, B = 14 mm	
R_1 = 0.8 mm, R_2 = 0.8 mm	

M 6630	50 t/m
A = 20 mm, B = 35 mm	
R_1 = 4 mm, R_2 = 4 mm	



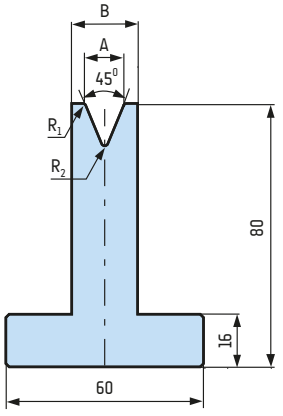
M 6135	35 t/m
A = 8 mm, B = 14 mm	
R_1 = 1.5 mm, R_2 = 0.8 mm	

M 6235	40 t/m
A = 12 mm, B = 18 mm	
R_1 = 2 mm, R_2 = 1 mm	



M 6145	50 t/m
A = 10 mm, B = 16 mm	
R_1 = 2 mm, R_2 = 1 mm	

M 6245	50 t/m
A = 12 mm, B = 18 mm	
R_1 = 2.5 mm, R_2 = 1 mm	



TYPE "A" DIES | MATRICE TYPU „A"

dies with base H = 80 mm | matrice so základňou H = 80 mm

24h

M 6160 60 t/m

A = 8 mm, B = 14 mm

R_1 = 1.5 mm, R_2 = 0.8 mm

24h

M 6260 60 t/m

A = 10 mm, B = 16 mm

R_1 = 2 mm, R_2 = 1 mm

24h

M 6360 60 t/m

A = 12 mm, B = 18 mm

R_1 = 2.5 mm, R_2 = 1 mm

24h

M 6460 60 t/m

A = 16 mm, B = 24 mm

R_1 = 1.5 mm, R_2 = 1.5 mm

24h

M 6560 60 t/m

A = 20 mm, B = 30 mm

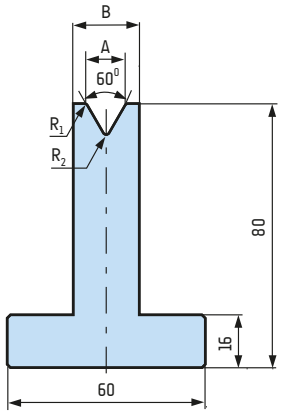
R_1 = 2 mm, R_2 = 2 mm

24h

M 6660 60 t/m

A = 25 mm, B = 40 mm

R_1 = 3 mm, R_2 = 3 mm



24h

M 6085 100 t/m

A = 8 mm, B = 14 mm

R_1 = 1 mm, R_2 = 0.5 mm

24h

M 6185 100 t/m

A = 12 mm, B = 18 mm

R_1 = 2.5 mm, R_2 = 1 mm

24h

M 6285 100 t/m

A = 16 mm, B = 24 mm

R_1 = 2.5 mm, R_2 = 1 mm

24h

M 6385 100 t/m

A = 20 mm, B = 30 mm

R_1 = 3 mm, R_2 = 1.5 mm

24h

M 6485 100 t/m

A = 25 mm, B = 40 mm

R_1 = 3 mm, R_2 = 3 mm

24h

M 6585 100 t/m

A = 10 mm, B = 18 mm

R_1 = 1 mm, R_2 = 1 mm

24h

M 6685 100 t/m

A = 14 mm, B = 18 mm

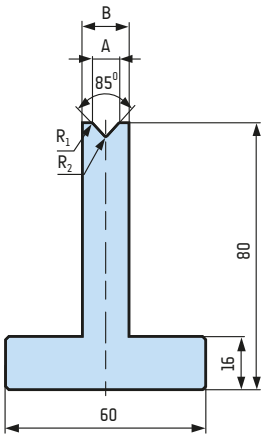
R_1 = 2.6 mm, R_2 = 0.4 mm

24h

M 6785 100 t/m

A = 6 mm, B = 14 mm

R_1 = 0.5 mm, R_2 = 0.5 mm



24h

M 6088 100 t/m

A = 8 mm, B = 14 mm

R_1 = 1 mm, R_2 = 0.5 mm

24h

M 6188 100 t/m

A = 12 mm, B = 18 mm

R_1 = 2.5 mm, R_2 = 1 mm

24h

M 6288 100 t/m

A = 16 mm, B = 24 mm

R_1 = 2.5 mm, R_2 = 1 mm

24h

M 6388 100 t/m

A = 20 mm, B = 30 mm

R_1 = 3 mm, R_2 = 1.5 mm

24h

M 6488 100 t/m

A = 25 mm, B = 40 mm

R_1 = 3 mm, R_2 = 3 mm

24h

M 6588 100 t/m

A = 10 mm, B = 18 mm

R_1 = 1 mm, R_2 = 1 mm

24h

M 6688 100 t/m

A = 14 mm, B = 18 mm

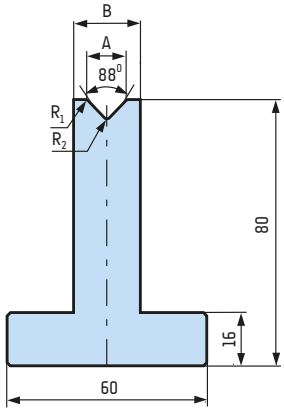
R_1 = 2.6 mm, R_2 = 0.4 mm

24h

M 6788 100 t/m

A = 6 mm, B = 14 mm

R_1 = 0.5 mm, R_2 = 0.5 mm



TYPE "A" DIES | MATRICE TYPU „A"

dies with base H = 80 mm | matrice so základňou H = 80 mm

24h

M 6190 100 t/m

A = 6 mm, B = 12 mm

R_1 = 1.5 mm, R_2 = 0.5 mm

24h

M 6290 100 t/m

A = 8 mm, B = 14 mm

R_1 = 1.5 mm, R_2 = 0.8 mm

24h

M 6390 100 t/m

A = 10 mm, B = 16 mm

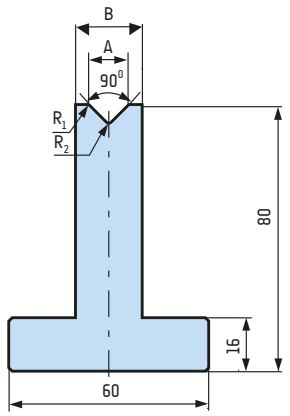
R_1 = 2 mm, R_2 = 1 mm

24h

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 | matrice so základňou H = 120 mm

24h

M 9130 30 t/m

A = 8 mm, B = 18 mm

R_1 = 1 mm, R_2 = 1 mm

24h

M 9230 35 t/m

A = 10 mm, B = 24 mm

R_1 = 1 mm, R = 1 mm

24h

M 9330 35 t/m

A = 12 mm, B = 24 mm

R_1 = 1 mm, R_2 = 1 mm

24h

M 9430 45 t/m

A = 16 mm, B = 30 mm

R_1 = 2 mm, R_2 = 2 mm

24h

M 9530 30 t/m

A = 6 mm, B = 14 mm

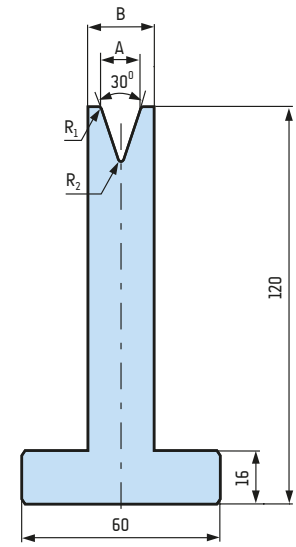
R_1 = 0.8 mm, R = 0.8 mm

24h

M 9630 50 t/m

A = 20 mm, B = 35 mm

R_1 = 4 mm, R_2 = 4 mm



24h

M 9135 35 t/m

A = 8 mm, B = 18 mm

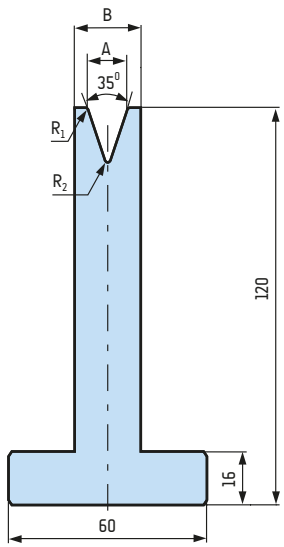
R_1 = 1.5 mm, R_2 = 0.8 mm

24h

M 9235 40 t/m

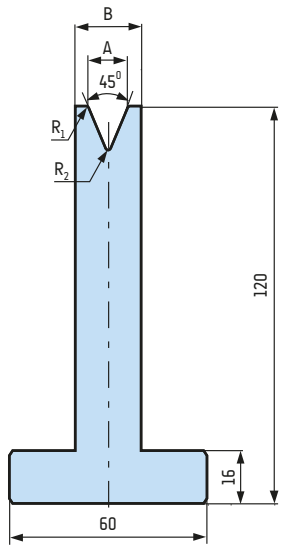
A = 12 mm, B = 18 mm

R_1 = 2 mm, R_2 = 1 mm



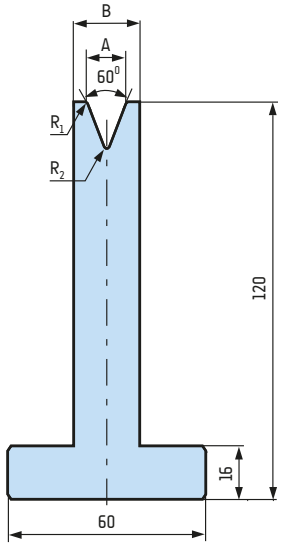
TYPE "A" DIES | MATRICE TYPU „A"

dies with base H = 120 mm | matrice so základňou 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	

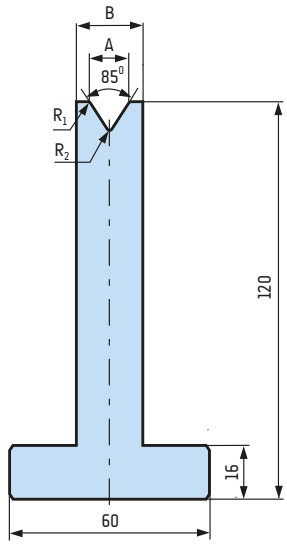
M 9260	60 t/m
A = 10 mm, B = 18 mm	
R_1 = 2 mm, R_2 = 1 mm	

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 | MATRICE TYPU „A"

dies with base H = 120 mm | matrice so základňou 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	

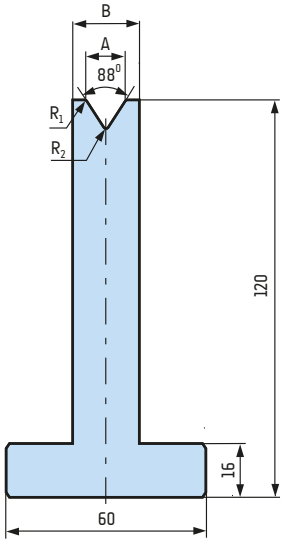
M 9388	100 t/m
A = 20 mm, B = 30 mm	
R_1 = 3 mm, R_2 = 1.5 mm	

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	

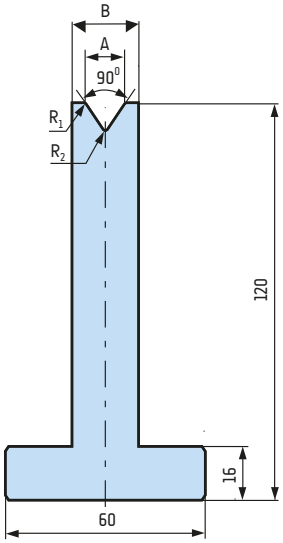


M 9190	100 t/m
A = 6 mm, B = 14 mm	
R_1 = 1.5 mm, R_2 = 0.5 mm	

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 | MATRICE TYPU „A"

Dies fixed using die supports A 31 or A 61 –> p. 84
Matrice upínané pomocou podpôr A 31 alebo A 61 –> str. 84

insert dies | matrice vložkové

42CrMo4

M 8130	35 t/m
$\alpha = 30^0$	
A = 6 mm, B = 16 mm	
R_1 = 1 mm	

42CrMo4

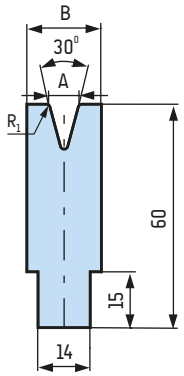
M 8230	35 t/m
$\alpha = 30^0$	
A = 8 mm, B = 19 mm	
R_1 = 1.5 mm	

42CrMo4

M 8330	50 t/m
$\alpha = 30^0$	
A = 10 mm, B = 24 mm	
R_1 =2 mm	

42CrMo4

M 8430	40 t/m
$\alpha = 30^0$	
A = 12 mm, B = 25 mm	
R_1 = 2.5 mm	



42CrMo4

M 8160	60 t/m
$\alpha = 60^0$	
A = 6 mm, B = 14 mm	
R_1 = 0.6 mm	

42CrMo4

M 8260	60 t/m
$\alpha = 60^0$	
A = 8 mm, B = 15 mm	
R_1 = 0.8 mm	

42CrMo4

M 8360	60 t/m
$\alpha = 60^0$	
A = 10 mm, B = 18 mm	
R_1 = 1 mm	

42CrMo4

M 8460	60 t/m
$\alpha = 60^0$	
A = 12 mm, B = 18 mm	
R_1 = 1.2 mm	

42CrMo4

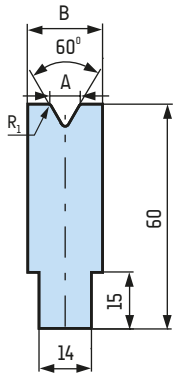
M 8560	60 t/m
$\alpha = 60^0$	
A = 16 mm, B = 24 mm	
R_1 = 1.6 mm	

42CrMo4

M 8660	60 t/m
$\alpha = 60^0$	
A = 20 mm, B = 30 mm	
R_1 = 2 mm	

42CrMo4

M 8760	60 t/m
$\alpha = 60^0$	
A = 25 mm, B = 33 mm	
R_1 = 2.5 mm	



TYPE "A" DIES | MATRICE TYPU „A"

Dies fixed using die supports A 31 or A 61 –> p. 84
Matrice upínané pomocou podpôr A 31 alebo A 61 –> str. 84

insert dies | matrice vložkové

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		

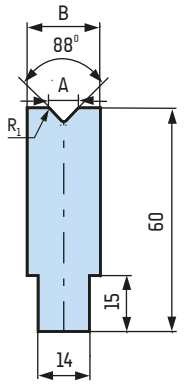
42CrMo4		
M 8588	100 t/m	
$\alpha = 88^0$		
$A = 14$ mm, $B = 18$ mm		
$R_1 = 2.5$ mm		

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		



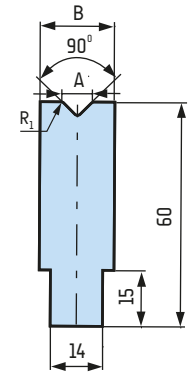
42CrMo4		
M 8190	100 t/m	
$\alpha = 90^0$		
$A = 6$ mm, $B = 14$ mm		
$R_1 = 1.5$ mm		

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		



Bending and folding die, upper part moves on springs.
Matrice s dvoma funkciami : ohýbanie aj falcovanie horná časť sa hýbe na pružinách.

flattening dies | matrice pre falcovanie

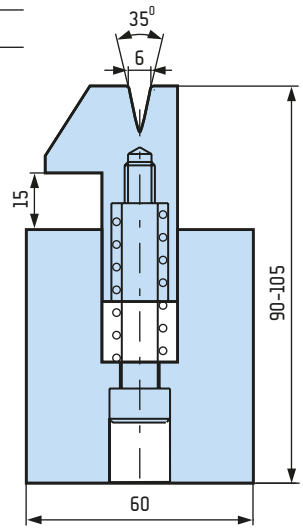
24h

M 3033/6 60 t/m

$\alpha = 35^0$

$V = 6$ mm

$R_1 = 1$ mm



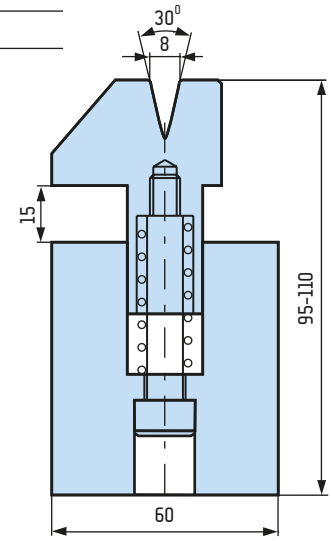
24h

M 3033/8 80 t/m

$\alpha = 30^0$

$V = 8$ mm

$R_1 = 1$ mm



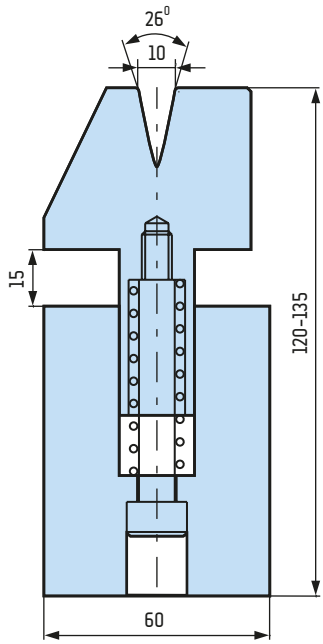
24h

M 3033/10 100 t/m

$\alpha = 26^0$

$V = 10$ mm

$R_1 = 1$ mm



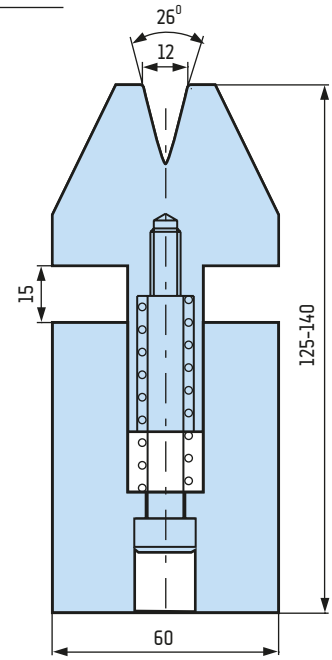
24h

M 3033/12 100 t/m

$\alpha = 26^0$

$V = 12$ mm

$R_1 = 1$ mm



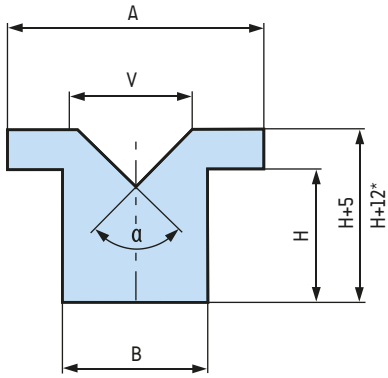
dies with plastic inserts | matrice s plastovými vložkami

INSERT W 24 | **VLOŽKA 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	

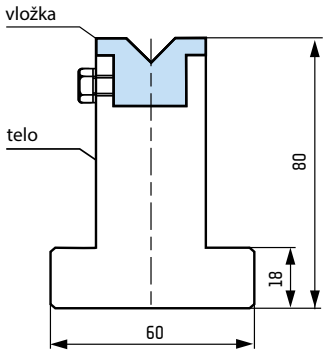
INSERT W 35 | **VLOŽKA W 35**	20 t/m
B = 20 mm, H = 19 mm, A = 35 mm	
α = 35°, V = 6 mm / 8 mm / 10 mm	
α = 45°, V = 6 mm / 8 mm / 10 mm / 12 mm	
α = 60°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm	
α = 88°, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm / 25 mm	

INSERT W 35 | **VLOŽKA 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	

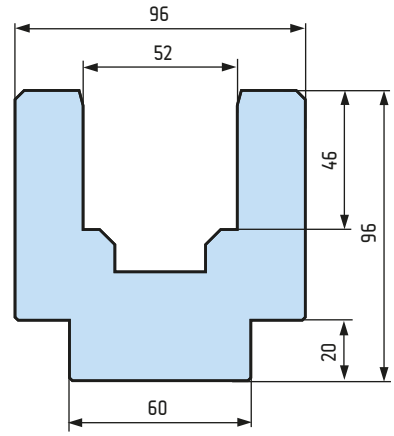
** for W 38 / pre W 38*



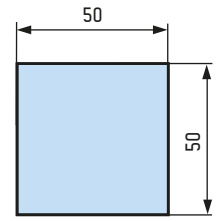
BODY | **ZÁKLADNÉ TELO W 24 / W 35 / W 38**



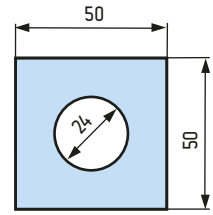
BODY W 50 | **ZÁKLADNÉ TELO W 50**



INSERT 50 FULL | **VLOŽKA 50 PLNÁ**



INSERT 50 WITH HOLE | **VLOŽKA 50 S OTVOROM**

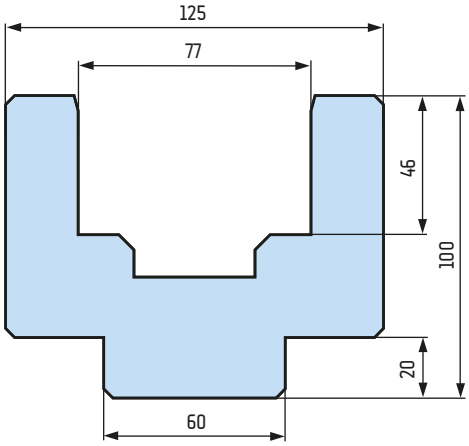


Polyamid inserts allow to minimize bending marks on coated or stainless steel.

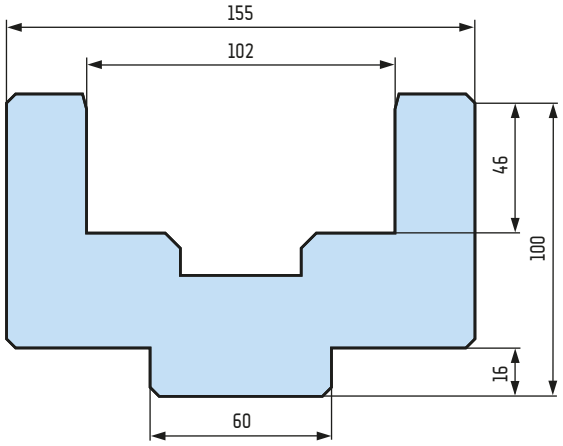
Polyamidové vožky pomáhajú minimalizovať stopy ohybu na tenkých plechoch, alebo plechoch z nehrdzavejúcej ocele.

dies with plastic inserts | matrice s plastovými vložkami

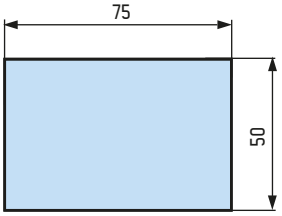
BODY W 75 | **ZÁKLADNÉ TELO W 75**



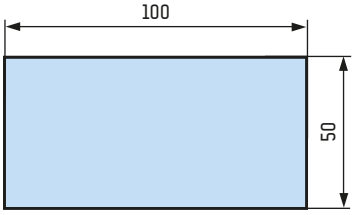
BODY W 100 | **ZÁKLADNÉ TELO W 100**



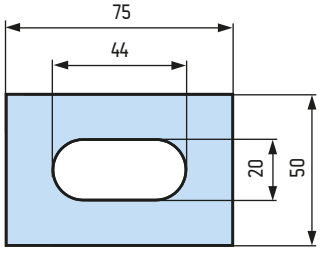
INSERT 75 FULL | **VLOŽKA 75 PLNÁ**



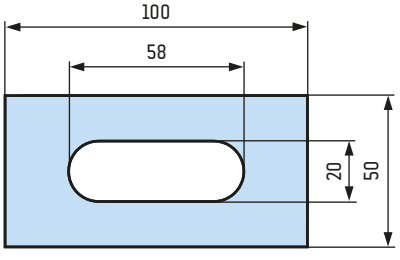
INSERT 100 FULL | **VLOŽKA 100 PLNÁ**



INSERT 75 WITH HOLE | **VLOŽKA 75 S OTVOROM**



INSERT 100 WITH HOLE | **VLOŽKA 100 S OTVOROM**



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

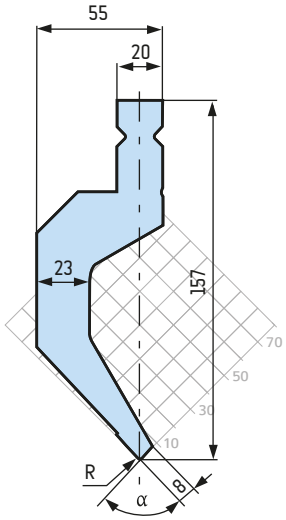
Gumové vložky umožňujú ohýbanie bez poškodenia plechu. Odporúča sa najmä s razníkmi "R".

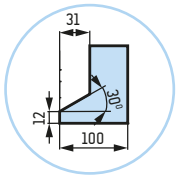
42CrMo4

S 2200 80 t/m

$\alpha = 86^0$

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



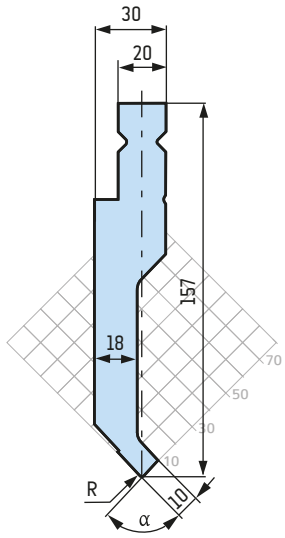


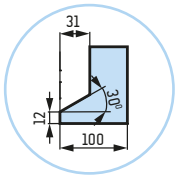
42CrMo4

S 2201 80 t/m

$\alpha = 86^0$

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



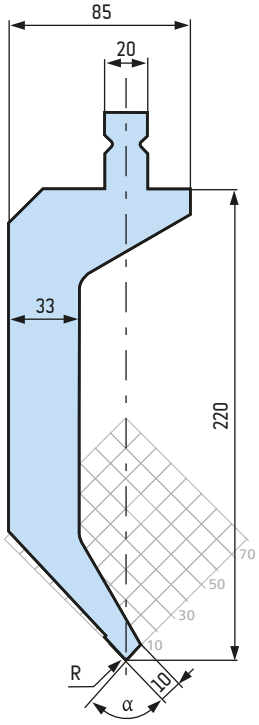


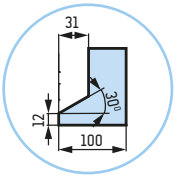
42CrMo4

S 2200 W 80 t/m

$\alpha = 86^0$

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



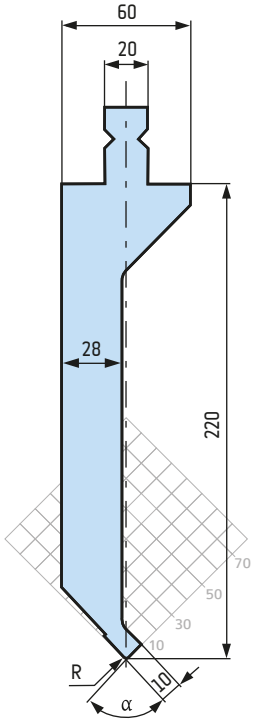


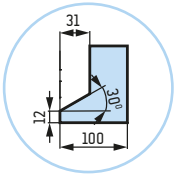
42CrMo4

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*

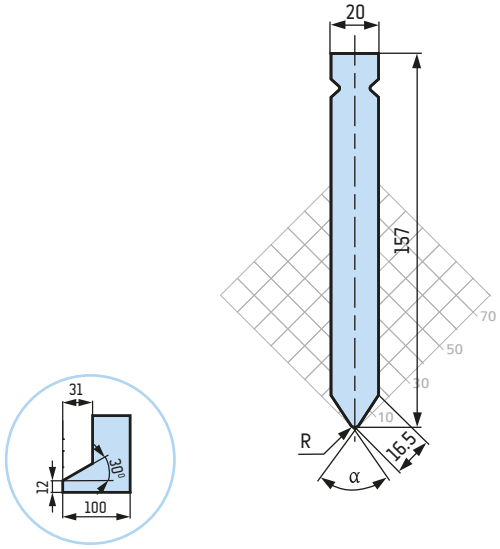


42CrMo4

S 2203 130 t/m

$\alpha = 60^0$

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

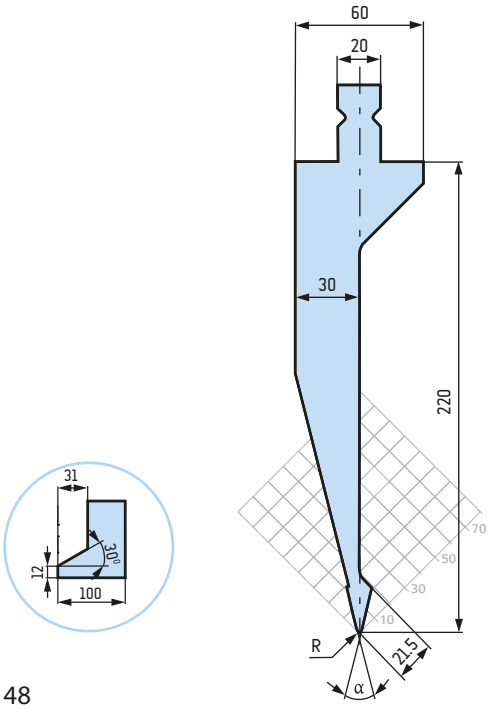


42CrMo4

S 2202 W 60 t/m

$\alpha = 28^0$

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

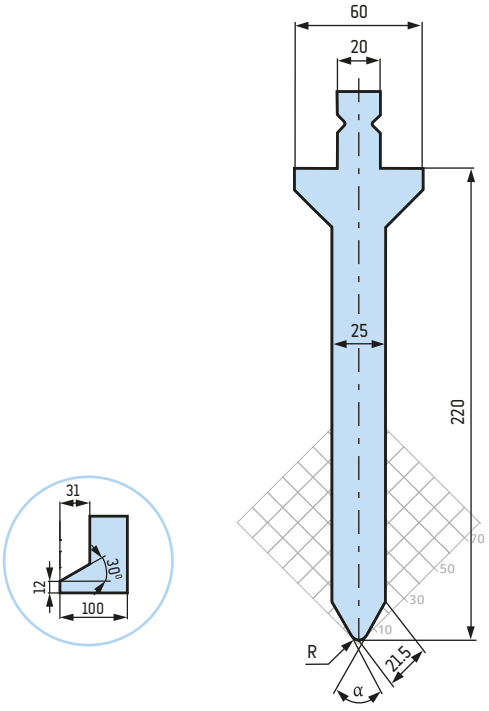


42CrMo4

S 2203 W 130 t/m

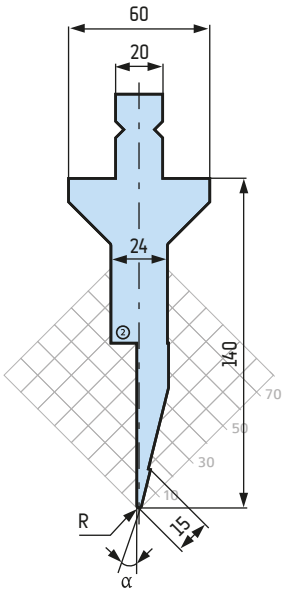
$\alpha = 60^0$

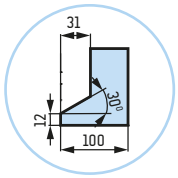
R = 4 mm *TH = 85 t/m*



42CrMo4

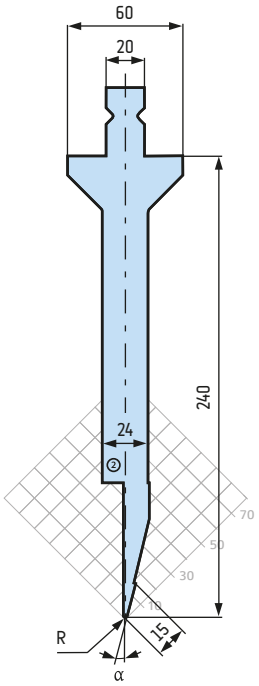
S 2204	40 t/m
② 130 t/m	
$\alpha = 14^0$	
$R = 1$ mm	$TH = 22$ t/m

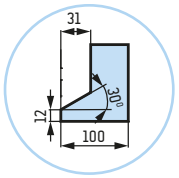




42CrMo4

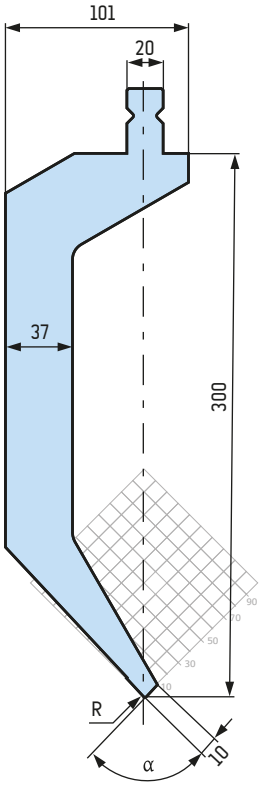
S 2204 W	40 t/m
② 130 t/m	
$\alpha = 14^0$	
$R = 1$ mm	$TH = 30$ t/m

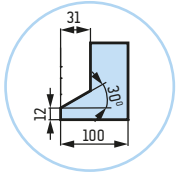




42CrMo4

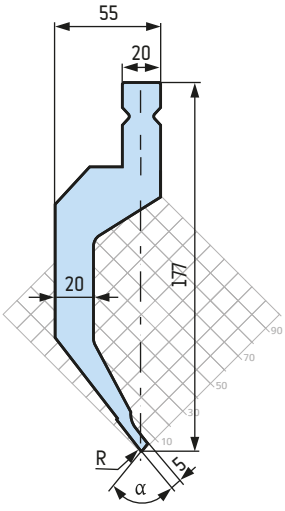
S 2300 W	80 t/m
$\alpha = 86^0$	
$R = 1$ mm	$TH = 22$ t/m

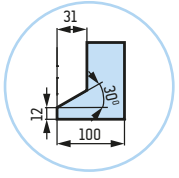




42CrMo4

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

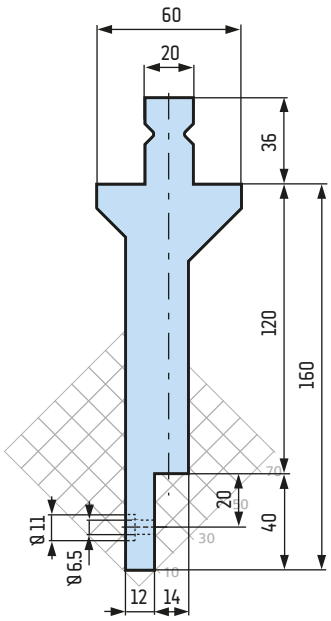




insert punch | razník s vložkou

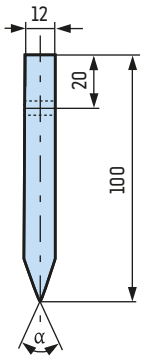
24h 42CrMo4

S 2206 100 t/m



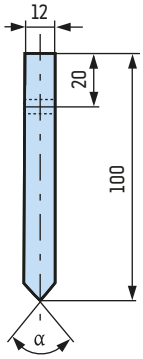
VLOŽKA R 0.3 – R 6

α = 28⁰



VLOŽKA R 0.2 – R 1.5

α = 84⁰, 86⁰, 90⁰

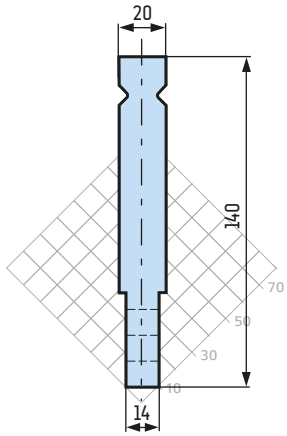


radius punch | razník rádiusový

24h 42CrMo4

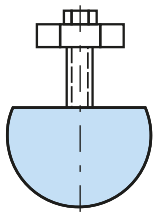
S 2207 80 t/m

L = 415 mm, 835 mm



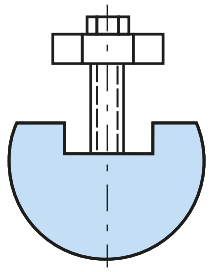
VLOŽKA R 7 – R 12

L = 415 mm, 835 mm



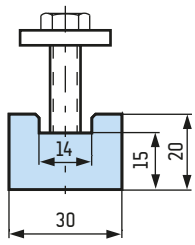
VLOŽKA R 12.5 – R 50

L = 415 mm, 835 mm



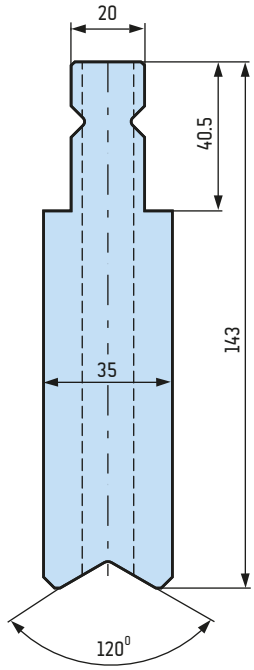
FLATTENING INSERT | **VLOŽKA PLOCHÁ**

L = 415 mm, 835 mm



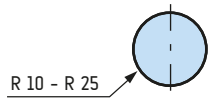
42CrMo4

S 2208 R 10 – R 25 100 t/m



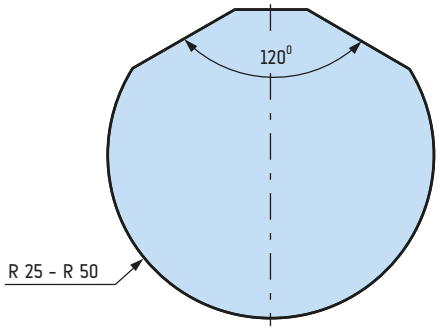
R 10 – R 25

** for punch / pre razníky S 2208*



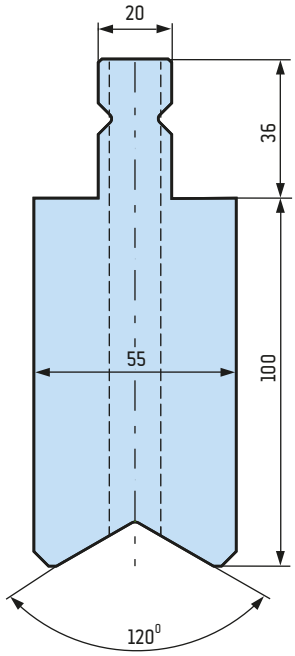
R 25 – R 50

** for punch / pre razníky S 2208*



42CrMo4

S 2208 W R 25 – R 50 100 t/m



flattening tools | nástroje na falcovanie

42CrMo4

S 2205 70 t/m

α = 26°

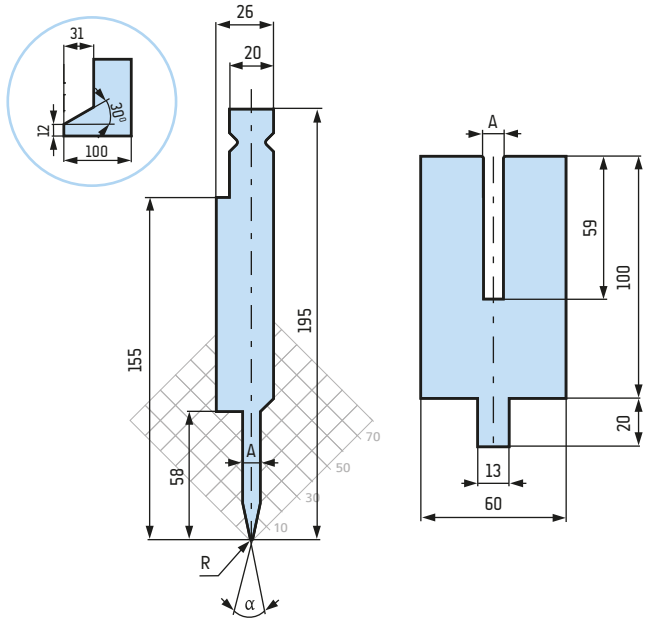
A = 8 mm, 10 mm, 12 mm

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 | MATRICE 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

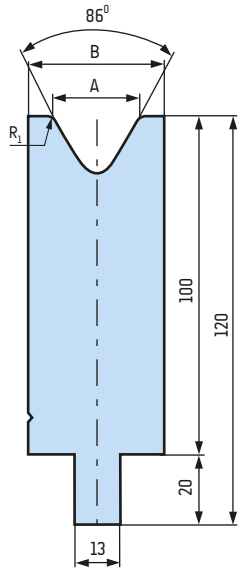
M 7130 100 t/m
A = 30 mm, B = 45 mm
R_1 = 3 mm

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

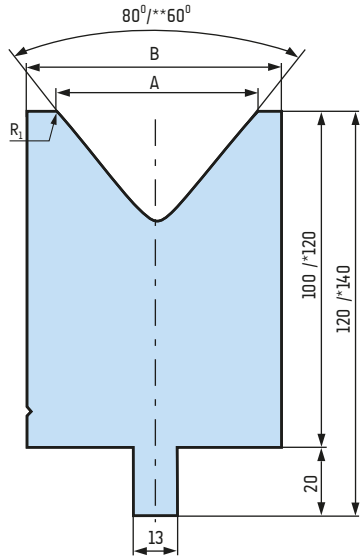
M 7290 100 t/m*
A = 90 mm, B = 110 mm
R_1 = 8 mm

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

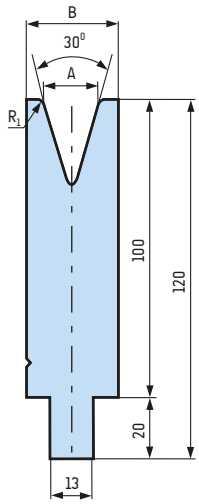
M 7320 50 t/m
A = 20 mm, B = 35 mm
R_1 = 2 mm

42CrMo4

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

42CrMo4

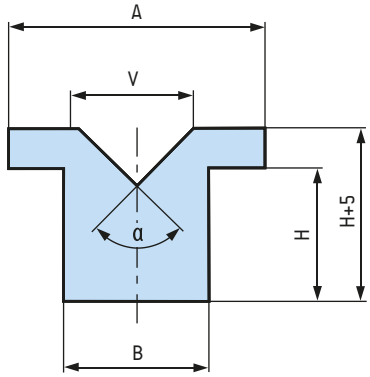
M 7330 70 t/m
A = 30 mm, B = 55 mm
R_1 = 3 mm



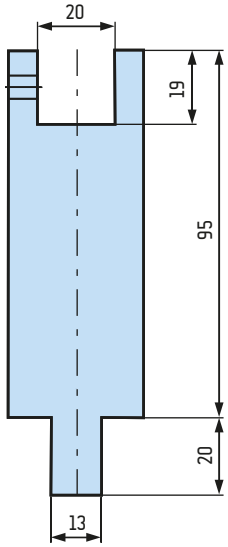
TYPE "T" DIES | MATRICE TYPU „T"

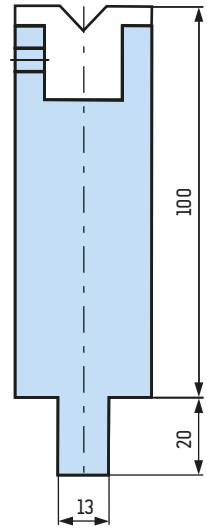
dies with plastic inserts
matrice s vložkami z polyamidu

INSERT W 35-T | **VLOŽKA 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	



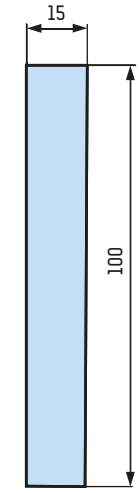
BODY | **ZÁKLADNÉ TELO W 35-T**



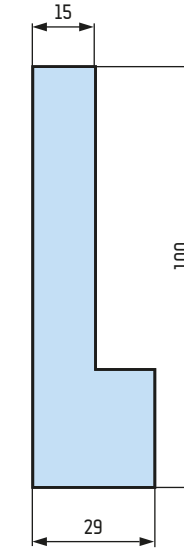


flattening inserts
vložky pre dotláčanie

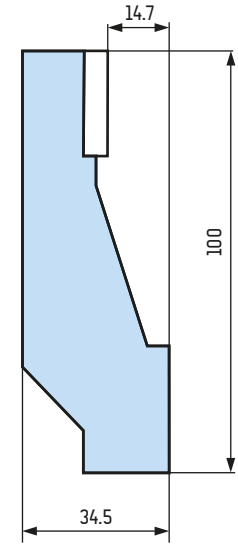
INSERT T 1 | **VLOŽKA T 1**



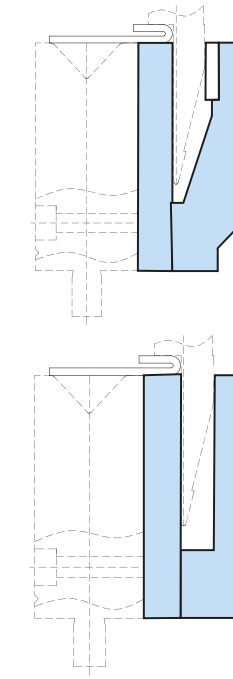
INSERT T 2 | **VLOŽKA T 2**



INSERT T 3 | **VLOŽKA T 3**



ASSAMBLE | **PRÍKLAD MONTAZU**

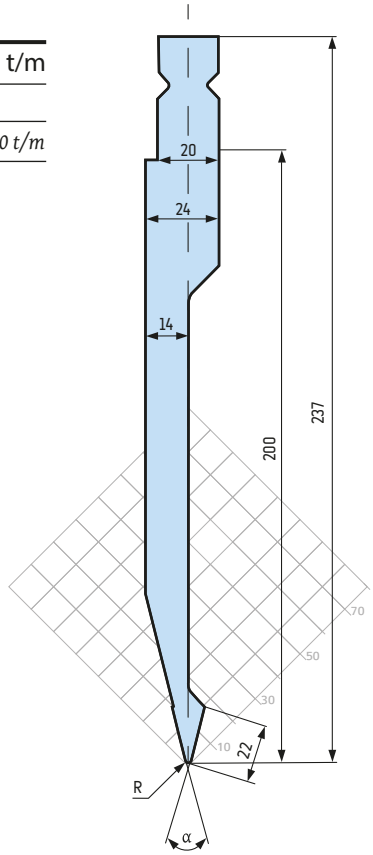


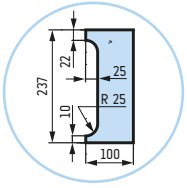
42CrMo4

S 2231 60 t/m

$\alpha = 28^0$

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



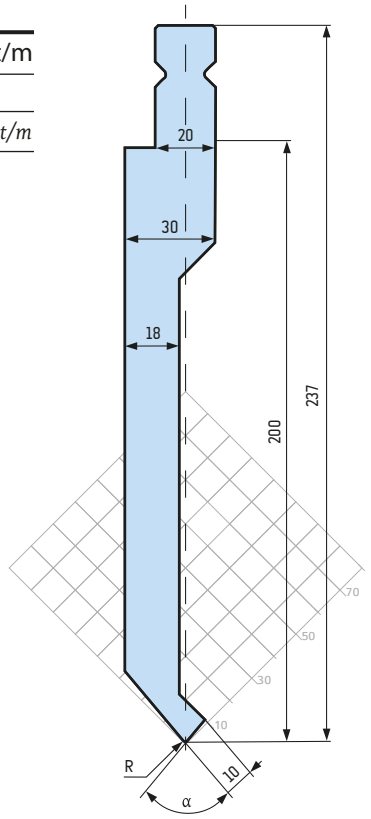


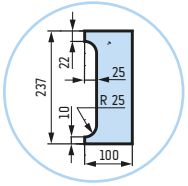
42CrMo4

S 2232 70 t/m

$\alpha = 80^0$

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



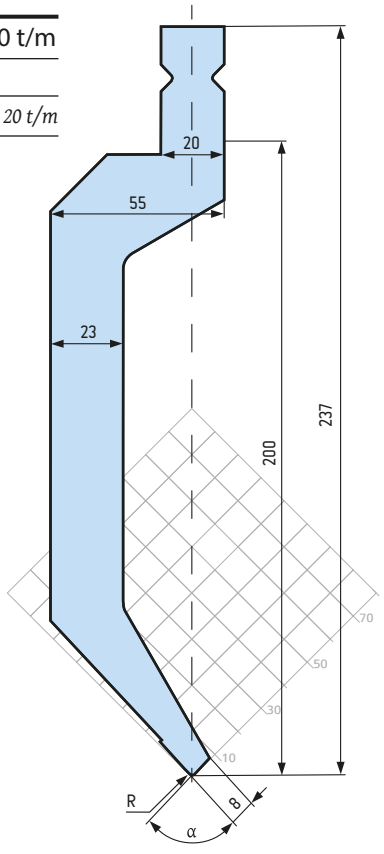


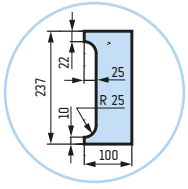
42CrMo4

S 2233 50 t/m

$\alpha = 86^0$

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



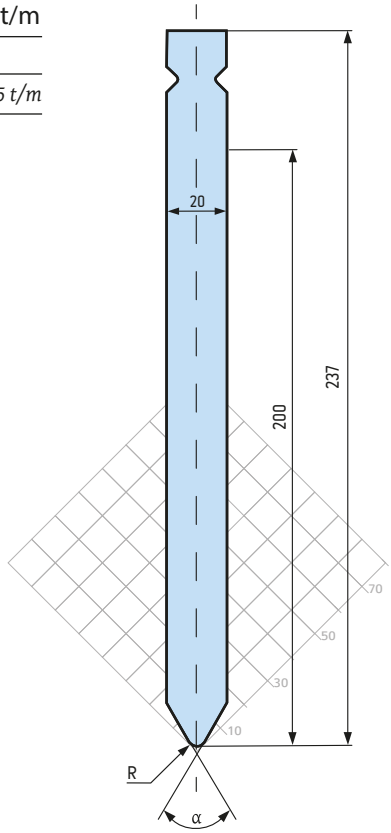


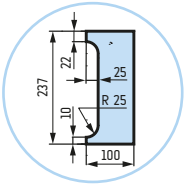
42CrMo4

S 2234 160 t/m

$\alpha = 60^0$

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





TYPE ”W“ DIES 55 MM | MATRICE 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

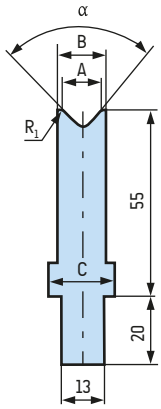
M 7424	100 t/m
$\alpha = 88^0$	
A = 24 mm, B = 40 mm, C = 40 mm	
R_1 = 2 mm	

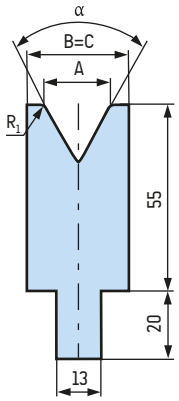
42CrMo4

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	



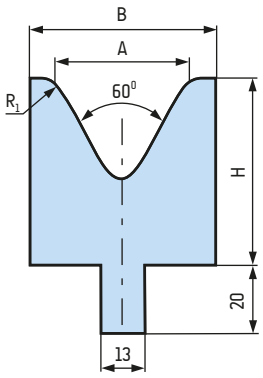


42CrMo4

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 | MATRICE 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

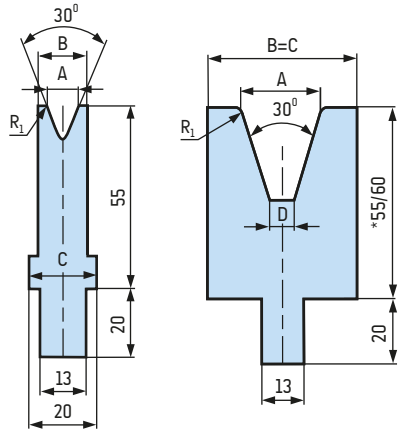
42CrMo4

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 = 86⁰

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

R_1 = 1 mm

42CrMo4

M 7708 100 t/m

α = 86⁰

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

R_1 = 1 mm

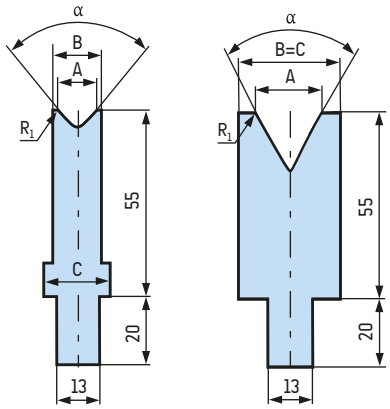
42CrMo4

M 7710 100 t/m

α = 86⁰

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

R_1 = 1 mm



42CrMo4

M 7712 100 t/m

α = 86⁰

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

R_1 = 1 mm

42CrMo4

M 7716 100 t/m

α = 86⁰

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

R_1 = 1.5 mm

42CrMo4

M 7720 100 t/m

α = 86⁰

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

R_1 = 2 mm

42CrMo4

M 7824 100 t/m

α = 80⁰

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

R_1 = 2.5 mm

42CrMo4

M 7830 100 t/m

α = 80⁰

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

R_1 = 3 mm

42CrMo4

M 7840 100 t/m

α = 80⁰

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

R_1 = 4 mm

42CrMo4

M 7850 100 t/m

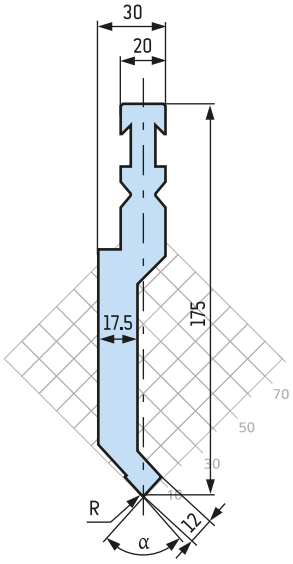
α = 80⁰

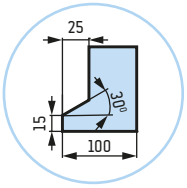
A = 50 mm, B = 75 mm, C = 75 mm

R_1 = 5 mm

42CrMo4

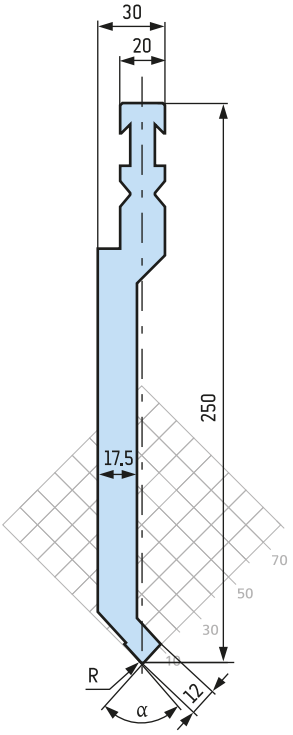
S 2403	80 t/m
$\alpha = 85^0$	
$R = 1$ mm	$BH = 27$ t/m

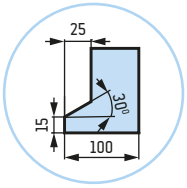




42CrMo4

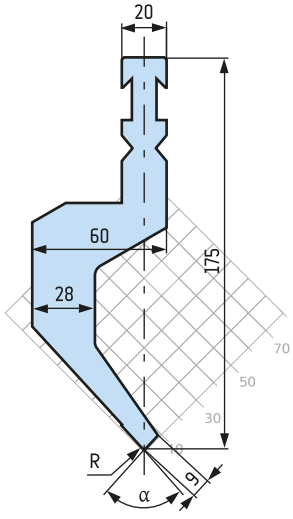
S 2403 W	70 t/m
$\alpha = 85^0$	
$R = 1$ mm	$BH = 30$ t/m

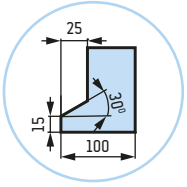




42CrMo4

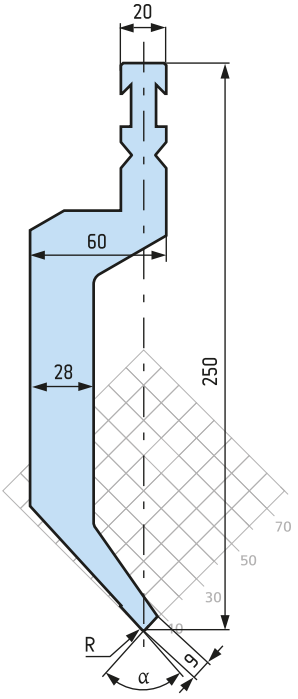
S 2404	40 t/m
$\alpha = 85^0$	
$R = 1$ mm	$BH = 15$ t/m

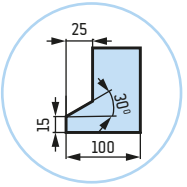




42CrMo4

S 2404 W	40 t/m
$\alpha = 85^0$	
$R = 1$ mm	$BH = 15$ t/m



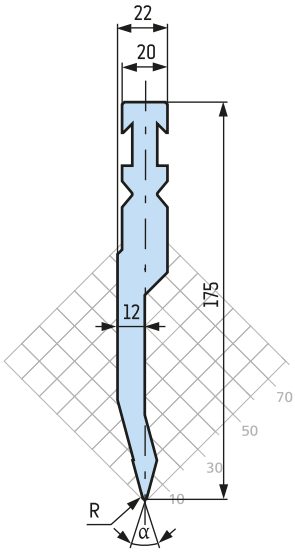


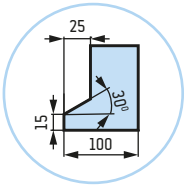
42CrMo4

S 2405 100 t/m

$\alpha = 30^0$

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



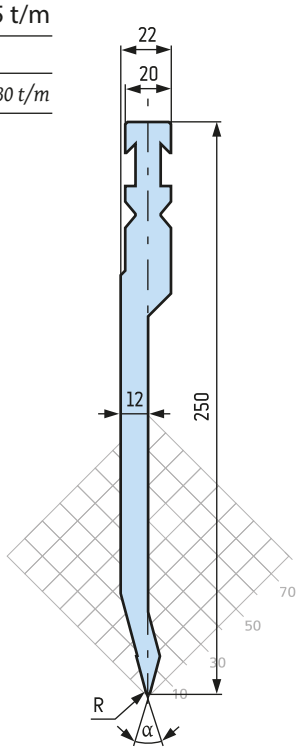


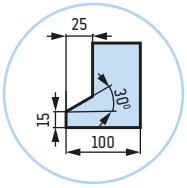
42CrMo4

S 2405 W 75 t/m

$\alpha = 30^0$

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



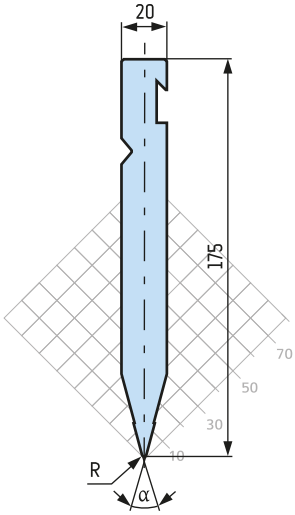


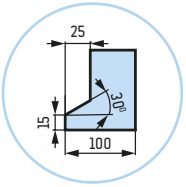
42CrMo4

S 2406 160 t/m

$\alpha = 30^0$

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



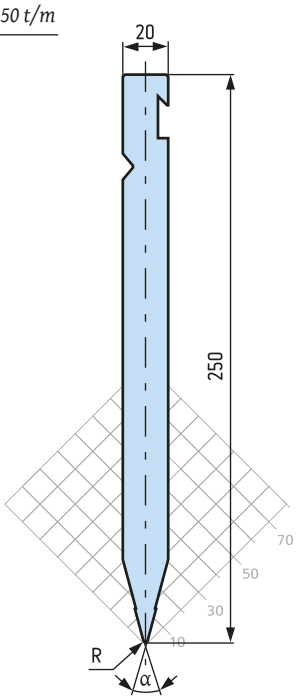


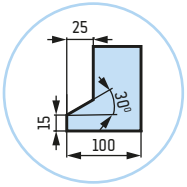
42CrMo4

S 2406 W 140 t/m

$\alpha = 30^0$

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



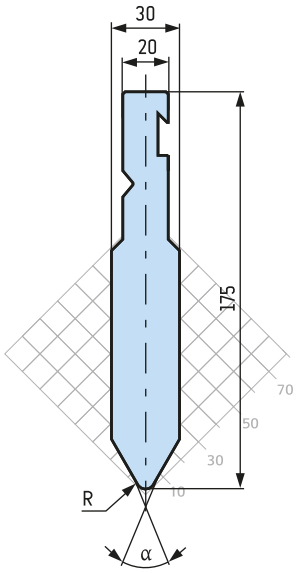


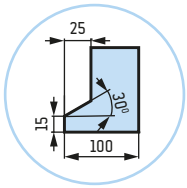
42CrMo4

S 2409 160 t/m

α = 60°

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



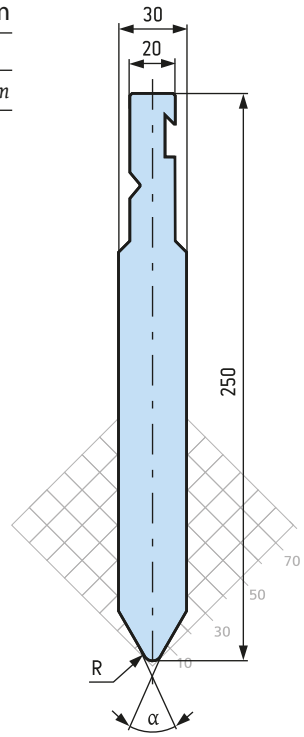


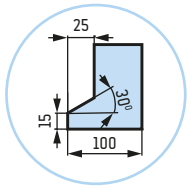
42CrMo4

S 2409 W 160 t/m

α = 60°

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





42CrMo4

S 2433 70 t/m

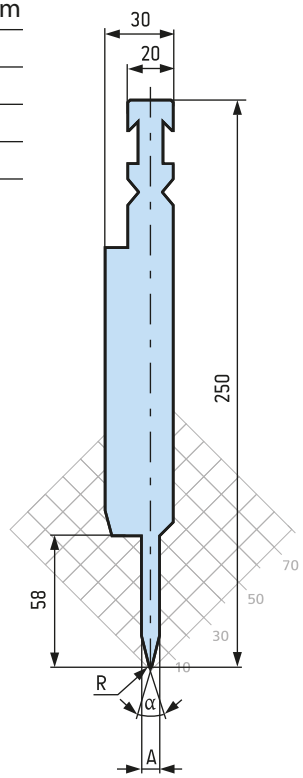
α = 28°

A = 8 mm, 10 mm, 12 mm

R = 0.6 mm

L = 500 mm

* *Na použitie v zostave s matricou M 2000*

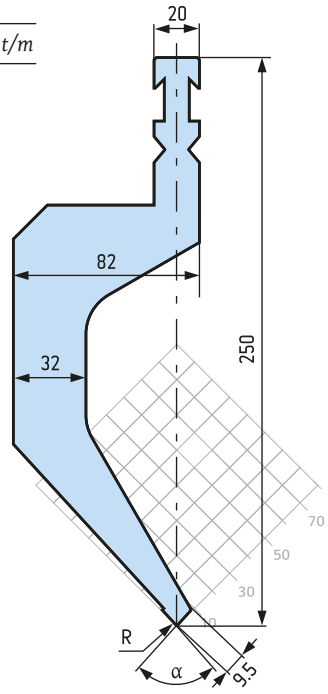


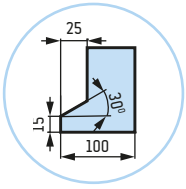
42CrMo4

S 2437 70 t/m

α = 85°

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



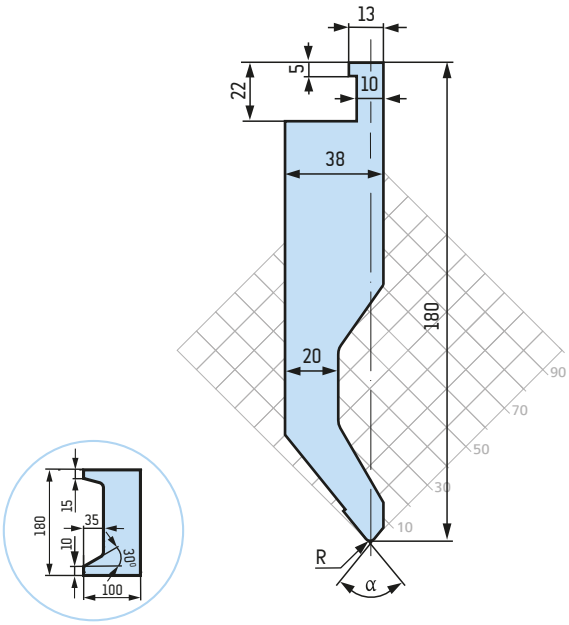


42CrMo4

S 2510 C 70 t/m

$\alpha = 78^0$

$R = 2$ mm $LH1 = 18$ t/m

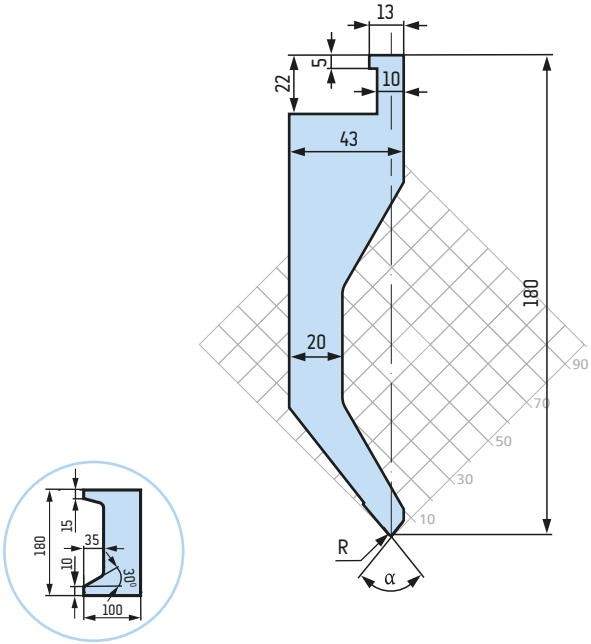


42CrMo4

S 2510 D 40 t/m

$\alpha = 78^0$

$R = 1$ mm $LH1 = 15$ t/m

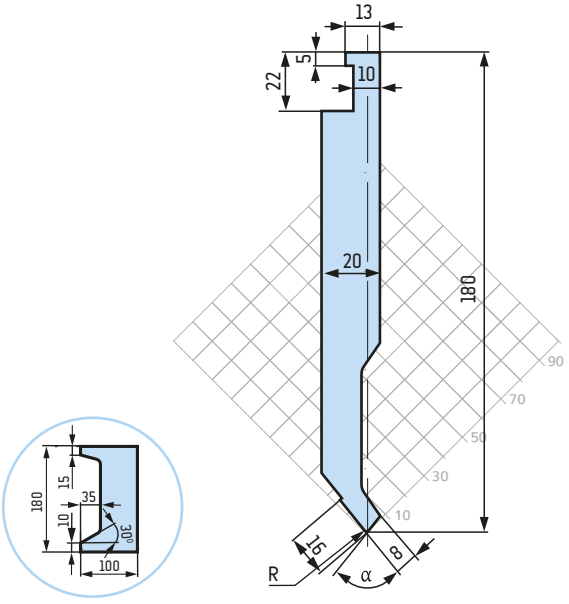


42CrMo4

S 2510 E 40 t/m

$\alpha = 78^0$

$R = 1$ mm $LH1 = 13$ t/m

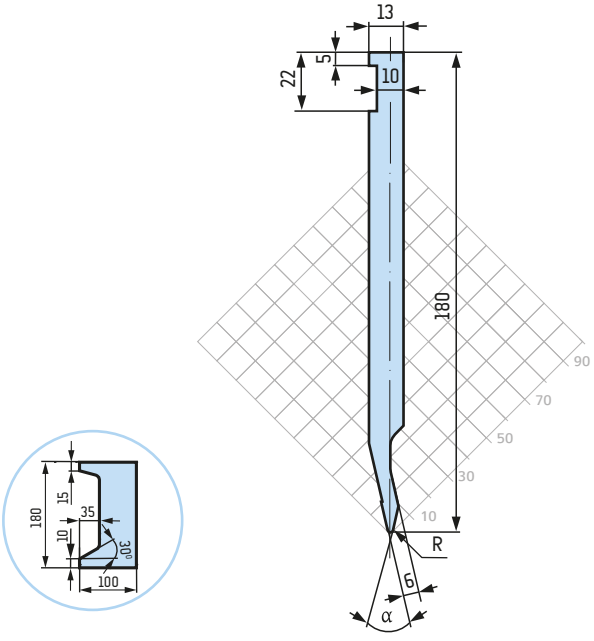


42CrMo4

S 2510 F 40 t/m

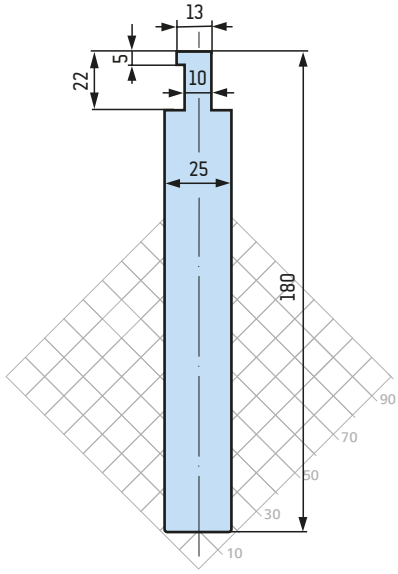
$\alpha = 26^0$

$R = 1$ mm $LH1 = 10$ t/m



42CrMo4

S 2510 H 150 t/m

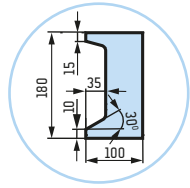


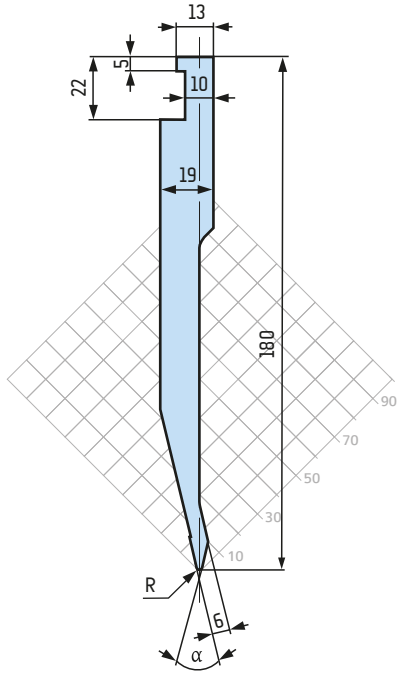
42CrMo4

S 2510 J 40 t/m

α = 26°

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





42CrMo4

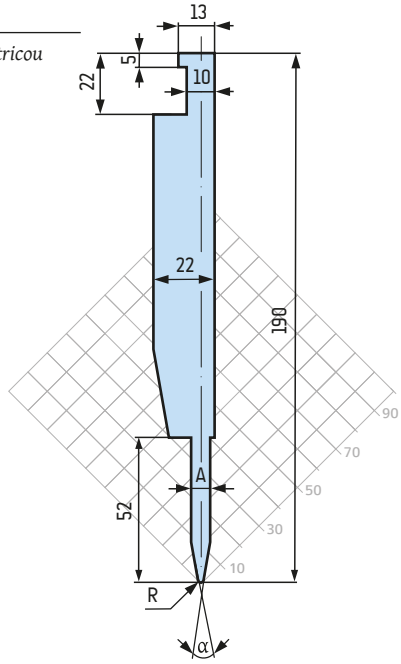
S 2510 P 40 t/m

α = 20°

R = 1 mm

A = 8 mm, 10 mm, 12 mm

* *Na použitie v zostave s matricou M 5000*

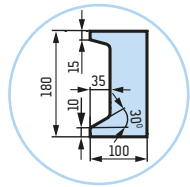


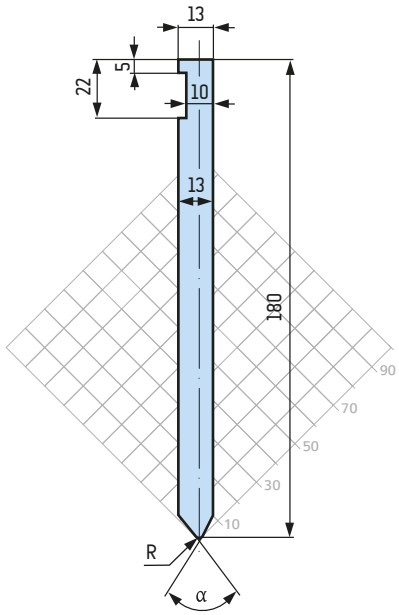
42CrMo4

S 2510 R 80 t/m

α = 78°

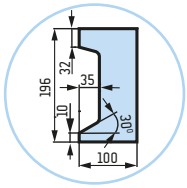
R = 2 mm *LH1 = 30 t/m*

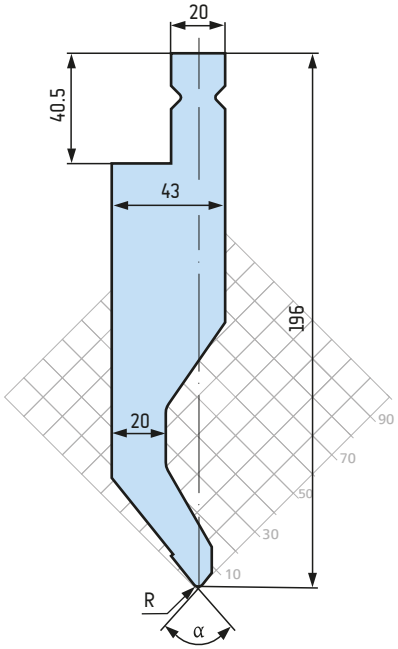




42CrMo4

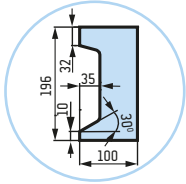
S 2610 C	70 t/m
$\alpha = 78^0$	
$R = 2\ mm$	$LH2 = 20\ t/m$

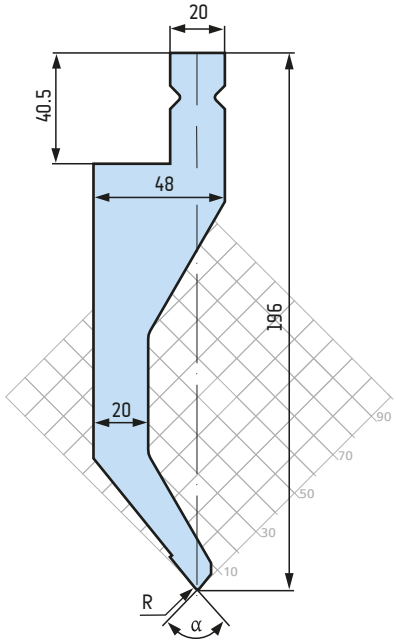




42CrMo4

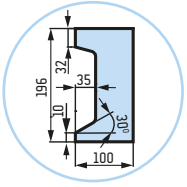
S 2610 D	50 t/m
$\alpha = 78^0$	
$R = 1\ mm$	$LH2 = 15\ t/m$

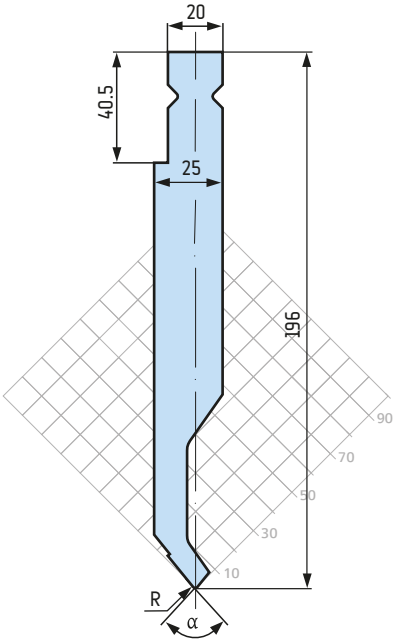




42CrMo4

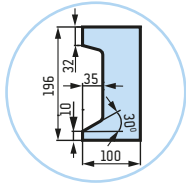
S 2610 E	40 t/m
$\alpha = 78^0$	
$R = 1\ mm$	$LH2 = 13\ t/m$

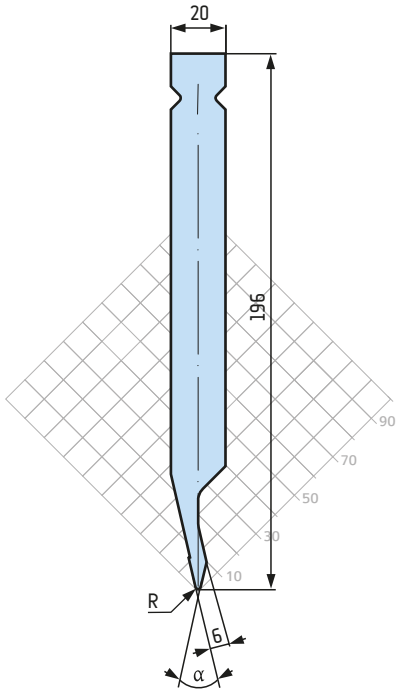




42CrMo4

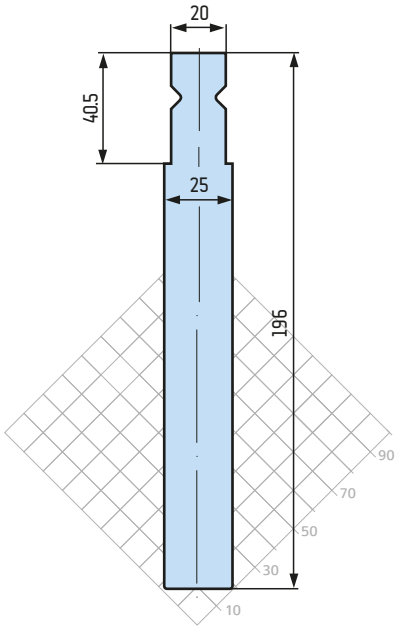
S 2610 F	40 t/m
$\alpha = 26^0$	
$R = 1\ mm$	$LH2 = 10\ t/m$





42CrMo4

S 2610 H 160 t/m

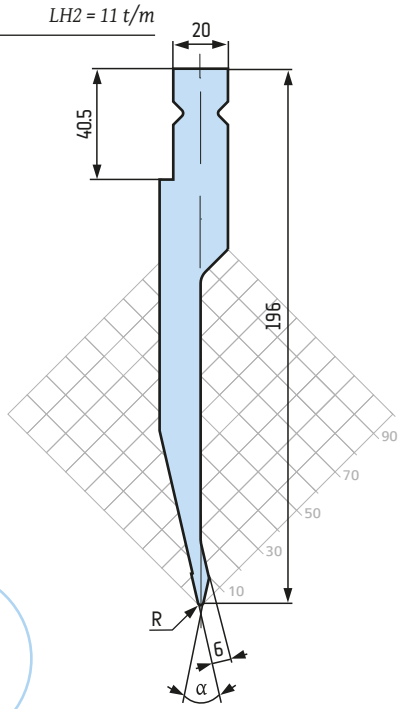


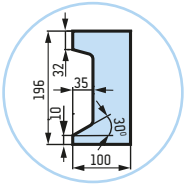
42CrMo4

S 2610 J 40 t/m

α = 26⁰

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





42CrMo4

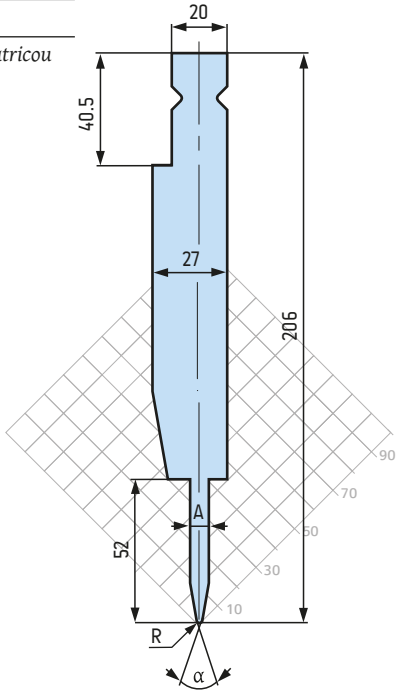
S 2610 P 40 t/m

α = 20⁰

R = 1 mm

A = 8 mm, 10 mm, 12 mm

* *Na použitie v zostave s matricou M 5000*

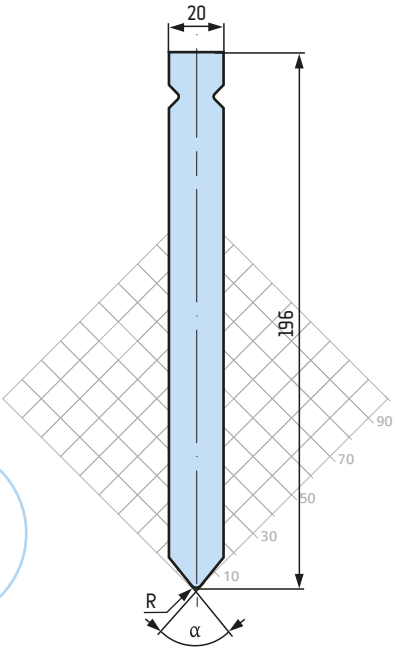


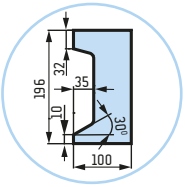
42CrMo4

S 2610 R 120 t/m

α = 78⁰

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



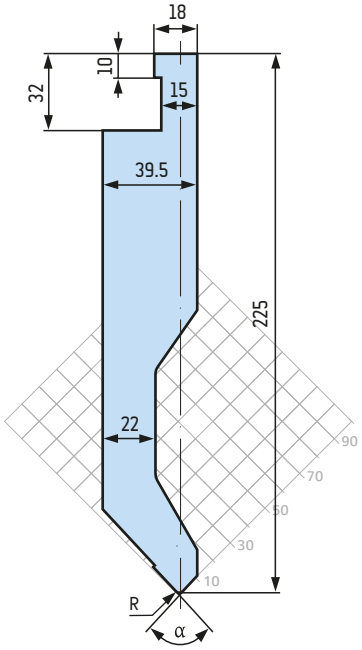


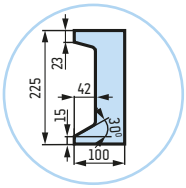
42CrMo4

S 2515 C 80 t/m

$\alpha = 78^0$

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



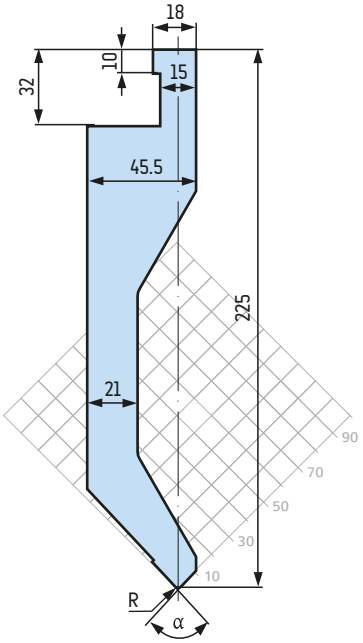


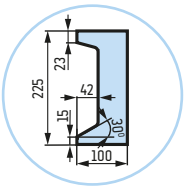
42CrMo4

S 2515 D 75 t/m

$\alpha = 78^0$

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



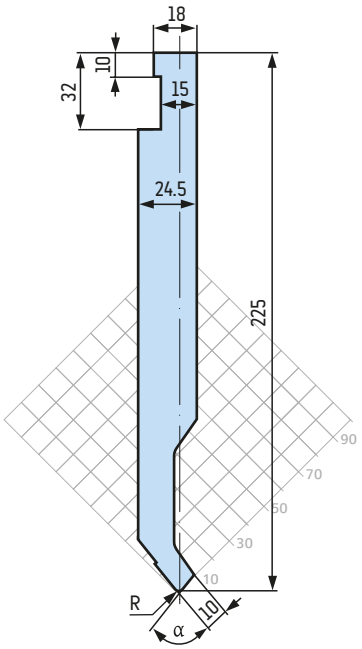


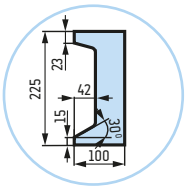
42CrMo4

S 2515 E 50 t/m

$\alpha = 78^0$

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



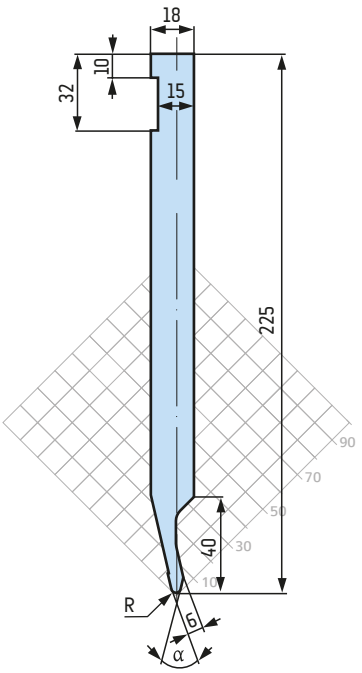


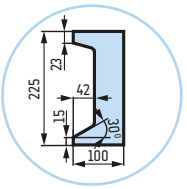
42CrMo4

S 2515 F 50 t/m

$\alpha = 26^0$

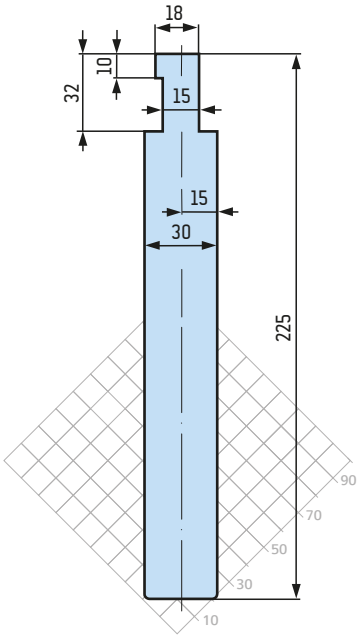
R = 2 mm *LH3 = 17 t/m*





42CrMo4

S 2515 H 150 t/m

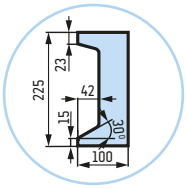


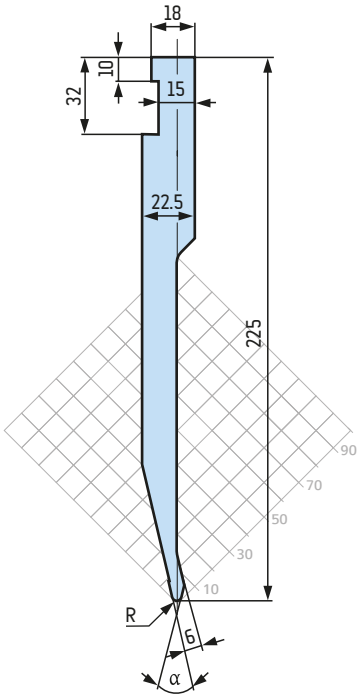
42CrMo4

S 2515 J 50 t/m

α = 26⁰

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





42CrMo4

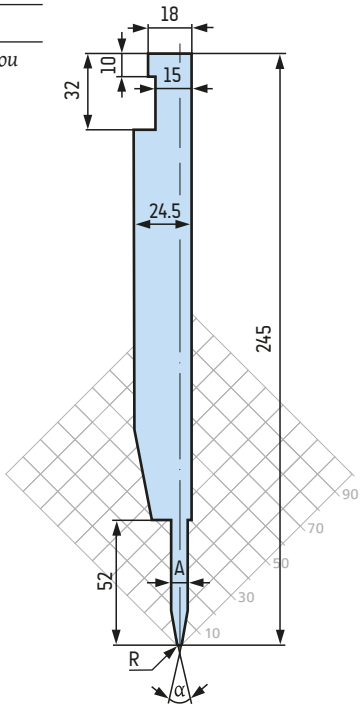
S 2515 P 40 t/m

α = 20⁰

A = 8 mm, 10 mm, 12 mm

R = 1 mm

* *Na použitie v zostave s matricou M 5000*

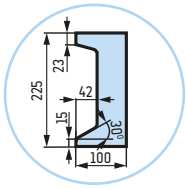


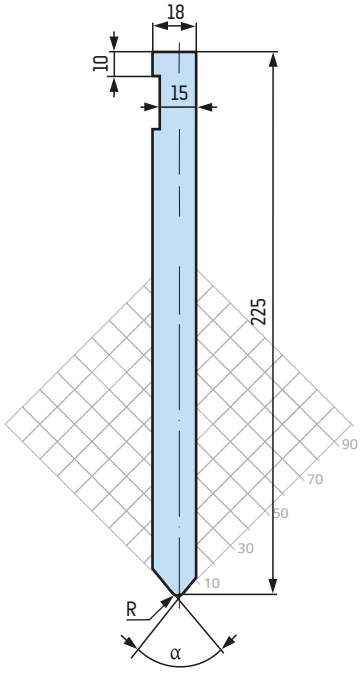
42CrMo4

S 2515 R 120 t/m

α = 78⁰

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



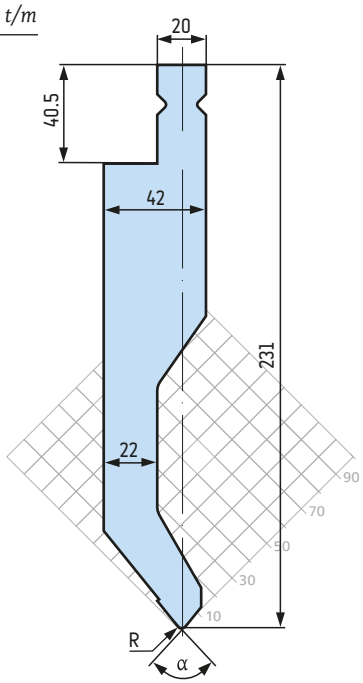


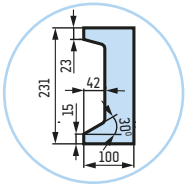
42CrMo4

S 2615 C 80 t/m

$\alpha = 78^0$

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



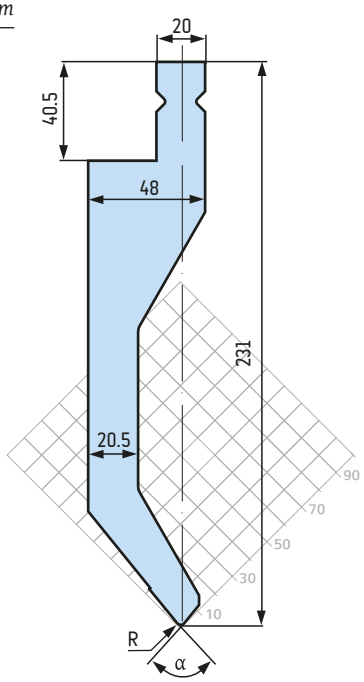


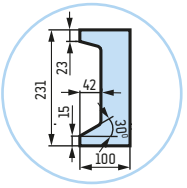
42CrMo4

S 2615 D 75 t/m

$\alpha = 78^0$

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



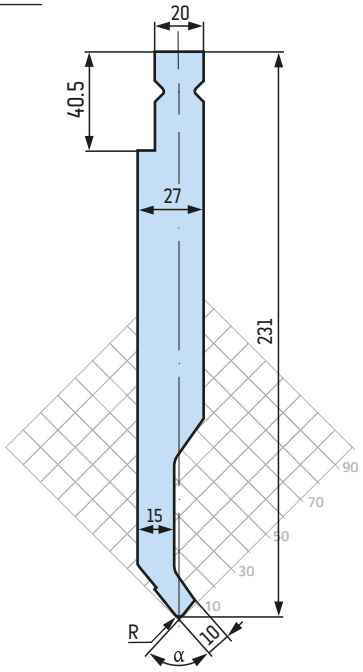


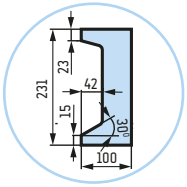
42CrMo4

S 2615 E 50 t/m

$\alpha = 26^0$

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



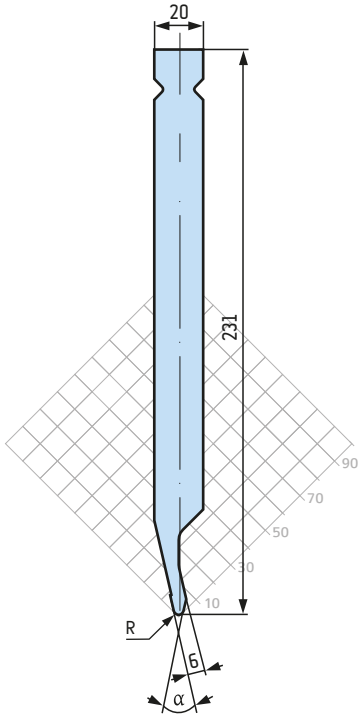


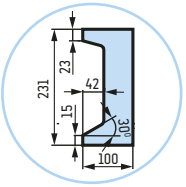
42CrMo4

S 2615 F 50 t/m

$\alpha = 26^0$

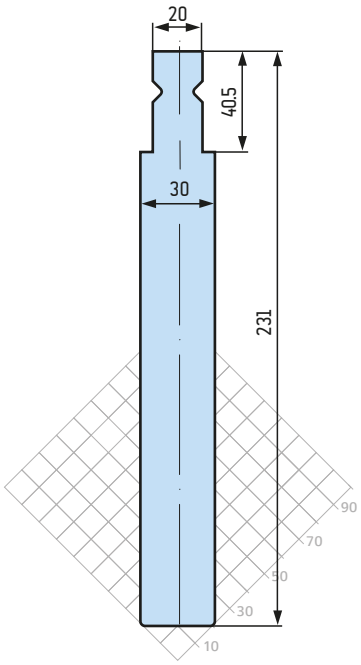
$R = 2$ mm $LH4 = 17$t/m





42CrMo4

S 2615 H 150 t/m

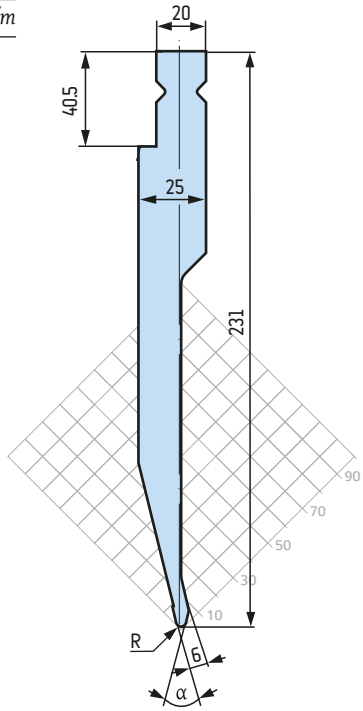


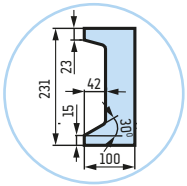
42CrMo4

S 2615 J 50 t/m

$\alpha = 26^0$

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





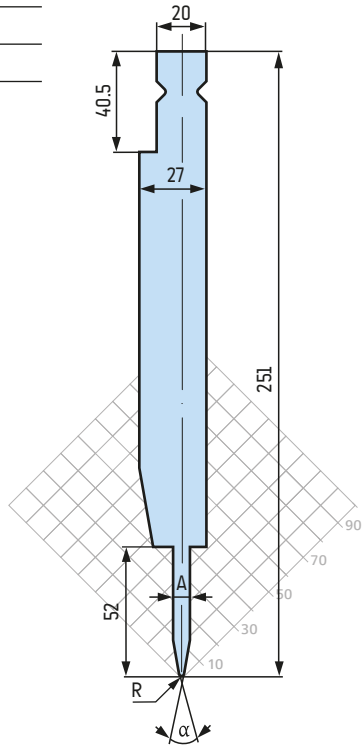
42CrMo4

S 2615 P 40 t/m

$\alpha = 20^0$

A = 8 mm, 10 mm, 12 mm

R = 1 mm

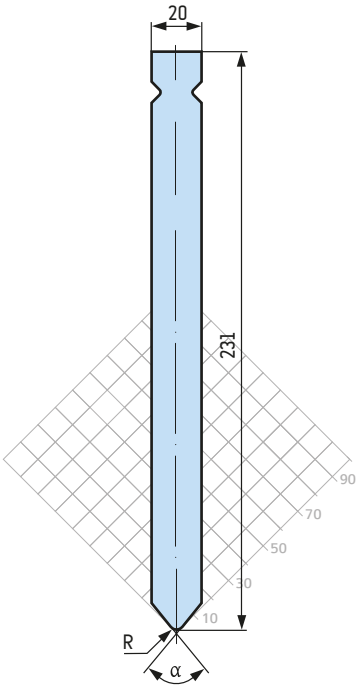


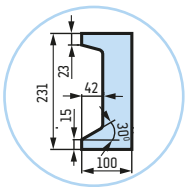
42CrMo4

S 2615 R 120 t/m

$\alpha = 78^0$

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





TYPE "L" DIES 90 MM | MATRICE 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 5112 35 t/m

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

R_1 = 1.5 mm

42CrMo4

M 5124 55 t/m

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

R_1 = 3 mm

42CrMo4

M 5150* 80 t/m

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

R_1 = 5 mm

42CrMo4

M 5108 20 t/m

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

R_1 = 1 mm

42CrMo4

M 5116 35 t/m

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

R_1 = 2 mm

42CrMo4

M 5130 60 t/m

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

R_1 = 3 mm

42CrMo4

M 5110 30 t/m

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

R_1 = 1 mm

42CrMo4

M 5120 35 t/m

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

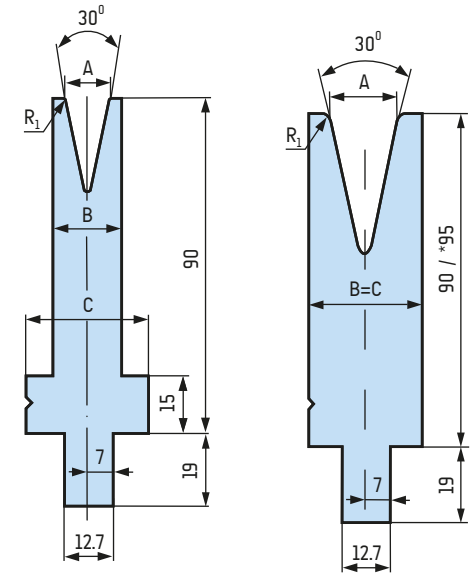
R_1 = 2 mm

42CrMo4

M 5140 60 t/m

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

R_1 = 4 mm



42CrMo4

M 5206 40 t/m

A = 6 mm, B = 12 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 5224 100 t/m

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

R_1 = 2.5 mm

42CrMo4

M 5250 150 t/m

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

R_1 = 4 mm

42CrMo4

M 5208 40 t/m

A = 8 mm, B = 12 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 5230 110 t/m

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

R_1 = 3 mm

42CrMo4

M 5260 150 t/m

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

R_1 = 4 mm

42CrMo4

M 5210 50 t/m

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

R_1 = 1 mm

42CrMo4

M 5220 100 t/m

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

R_1 = 2 mm

42CrMo4

M 5240 130 t/m

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

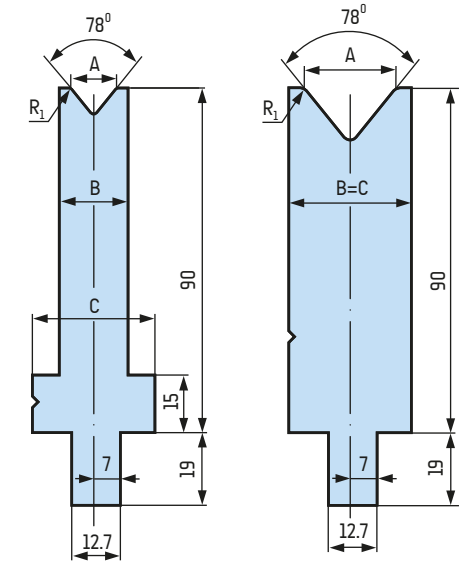
R_1 = 3 mm

42CrMo4

M 5280 150 t/m

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

R_1 = 6 mm



TYPE "L" DIES 130 MM | MATRICE 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

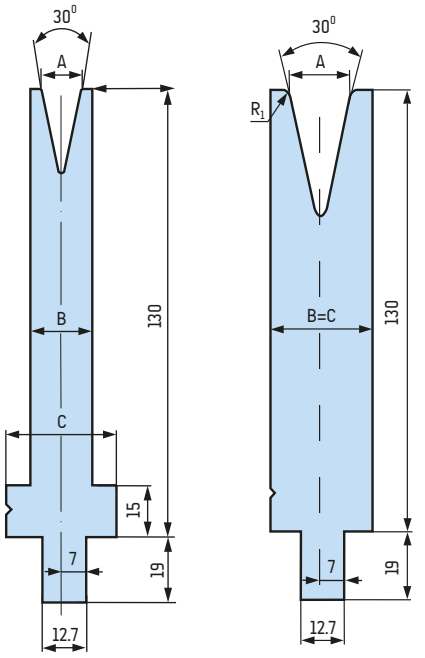
R_1 = 4 mm

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

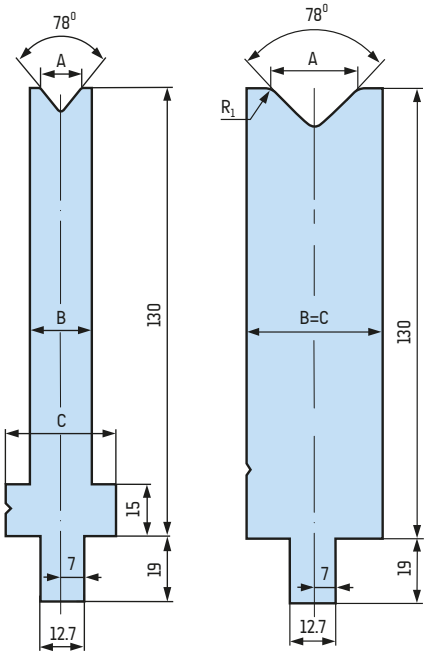
R_1 = 6 mm

42CrMo4

M 54120 150 t/m

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

R_1 = 12 mm

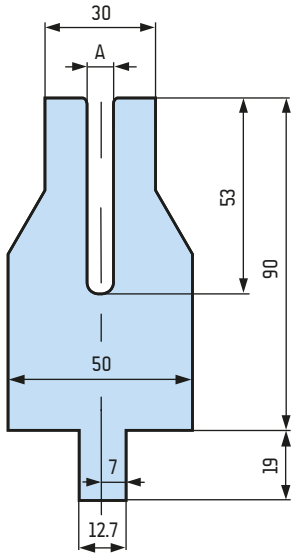


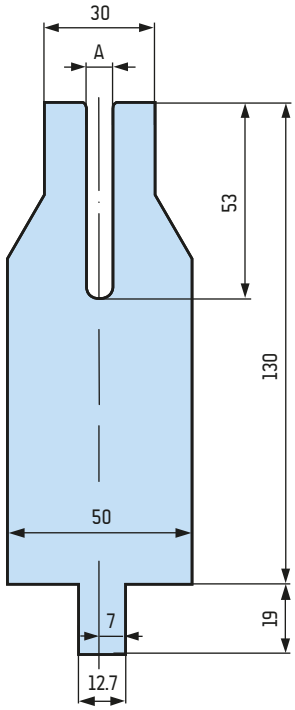
TYPE ”L“ DIES | MATRICE TYPU „L”

flattening dies | matrice pre falcovanie

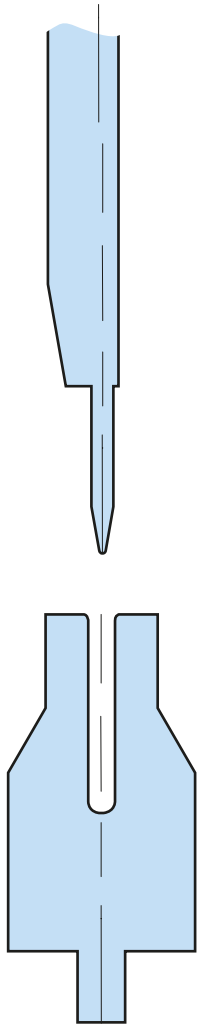
42CrMo4

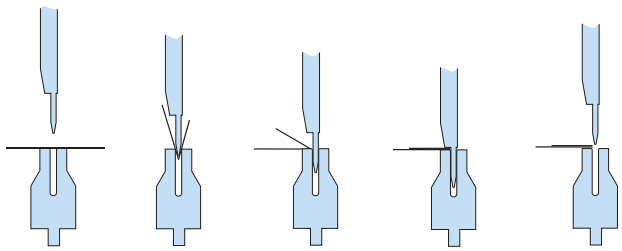
M 5000	50 t/m
A = 8 mm, 10 mm, 12 mm	
H = 90 mm, 130 mm	





example of use | príklad aplikácie





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

Pre matrice M5000 aplikujeme razníky S2510 P, S2610 P, S2515 P alebo S2615 P.

FLEXI BEND DIES | MATRICE FLEXI BEND

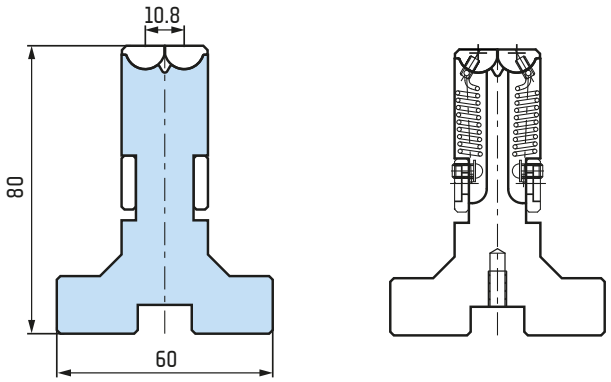
dies with movable inserts | matrice s pohyblivými vložkami

MODEL XT 1	**plechy 0.3 do 1.2 mm**	
FBXT 1	*matrica s drážkou 15x8 mm*	*AMADA*
MODEL XT 2	**plechy 0.5 do 2.0 mm**	
FBXT 2	*matrica s drážkou 15x8 mm*	*AMADA*
MODEL 1	**plechy 0.7 do 1.5 mm (max 2 mm)**	
FBP60-1	*matrica so základňou 60 mm*	*AMADA*
FBS80-1	*matrica so stopkou 14 mm*	*AMADA*
FBT55-1	*matrica so stopkou 13 mm*	*WILA*
FBT90-1	*matrica so stopkou 12.7 mm*	*LVD*
FBT100-1	*matrica so stopkou 13 mm*	*WILA*
MODEL 2	**plechy 2 do 3.2 mm (max 4 mm)**	
FBP65-2	*matrica so základňou 60 mm*	*AMADA*
FBS80-2	*matrica so stopkou 14 mm*	*AMADA*
FBT60-2	*matrica so stopkou 13 mm*	*WILA*
FBT90-2	*matrica so stopkou 12.7 mm*	*LVD*
FBT100-2	*matrica so stopkou 13 mm*	*WILA*
MODEL 2.5	**plechy 2 do 6 mm**	
FBM-2.5	*matrica so základňou 60 mm* *smožnosťou upínania stopkou pre WILA i LVD*	*AMADA*
MODEL 3	**plechy 2 do 6 mm**	
FBP100-3	*matrica so základňou 60 mm*	*AMADA*
FBT100-3	*matrica so stopkou 13 mm*	*WILA*
FBM70-3	*smožnosťou upínania stopkou AMADA, WILA i LVD*	
MODEL 3.5	**plechy 6 do 10 mm**	
FBM-3.5	*smožnosťou upínania stopkou AMADA, WILA i LVD*	
MODEL 4	**plechy 6 do12 mm**	
FBM90-4	*smožnosťou upínania stopkou AMADA, WILA i LVD*	
Matrice nastaviteľné		
FBHD2	*rozsah nastavenia: 16-30 mm*	
FBHD2.5	*rozsah nastavenia: 28-69 mm*	
FBHD3 Z	*rozsah nastavenia: 39-118 mm*	
FBHD4	*rozsah nastavenia: 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*	

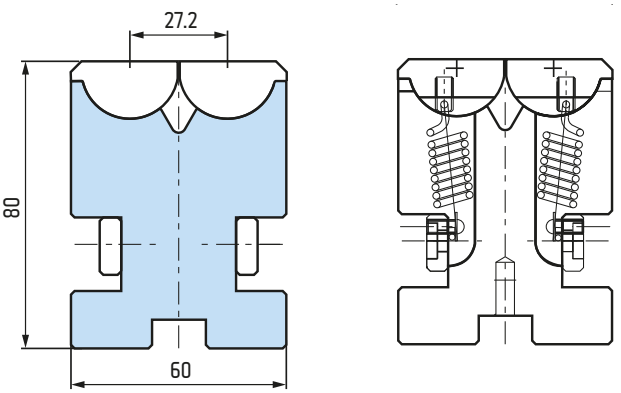
FLEXI 10.8 100 t/m

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.

Matrice Flexi Bend sú moderné matrice pre ohraňovacie lisy s nakláňacími vložkami, kompatibilné s každým typom lisu. Vďaka ich všetrannosti sú ideálnou voľbou v produkcii presných plechových komponentov.

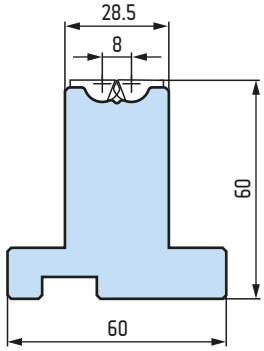
Výhody matríc Flexi Bend :

1. Kratšie ramená ohybu – Nakláňacie vložky umožňujú presné ohýbanie taktiež aj pri malých profiloch, eliminujúc deformáciu
2. Hrany sú bez otlačenia - Minimálne trenie zabraňuje ohybom a škrabancom, čím zaisťuje estetický vzhľad
3. Menšia deformácia - Znižuje riziko deformácie pri ohýbaní blízko otvorov v plechu pri zachovaní celistvosti línie plechu.
4. Minimálne následné spracovanie - Menej otlačení znamená, že nie je potrebné leštenie, čo znižuje náklady a šetrí čas výroby.

S Flexi Bend získavame produkty vysokej kvality pri nižších nákladoch a kratších výrobných cykloch.

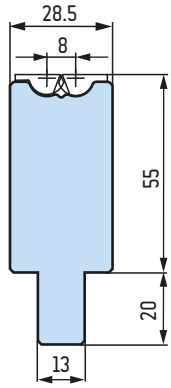
FBP60-1 50 t/m

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



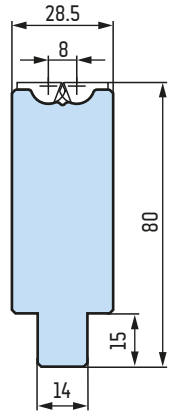
FBT55-1 50 t/m

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



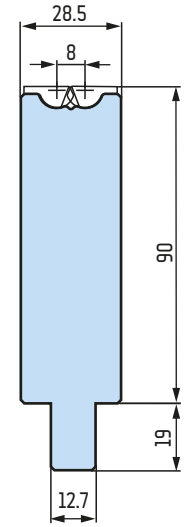
FBS80-1 50 t/m

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



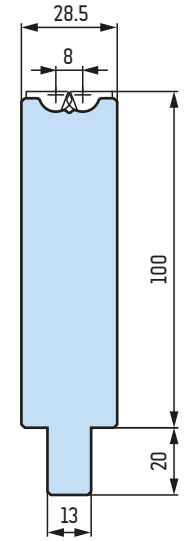
FBT90-1 50 t/m

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



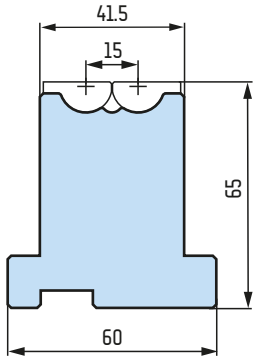
FBT100-1 50 t/m

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



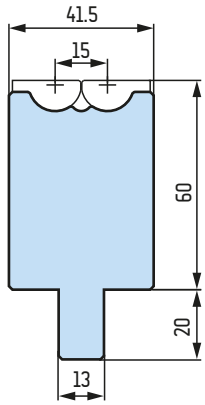
FBP65-2 150 t/m

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



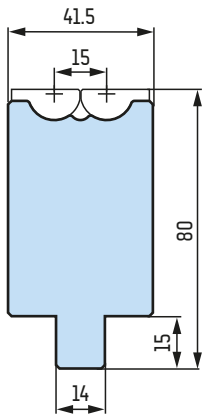
FBT60-2 150 t/m

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



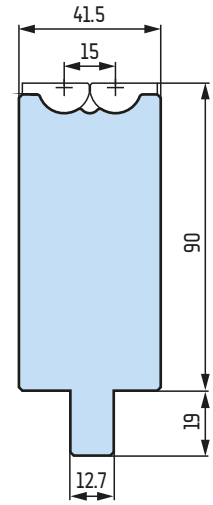
FBS80-2 150 t/m

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



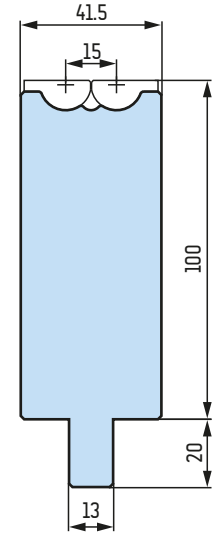
FBT90-2 150 t/m

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



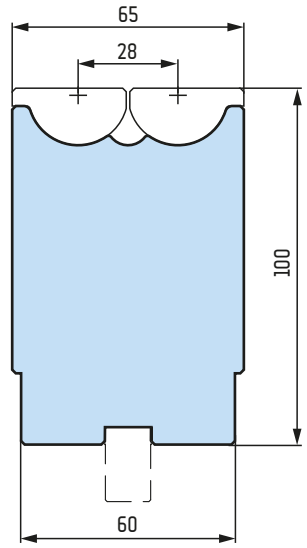
FBT100-2 150 t/m

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



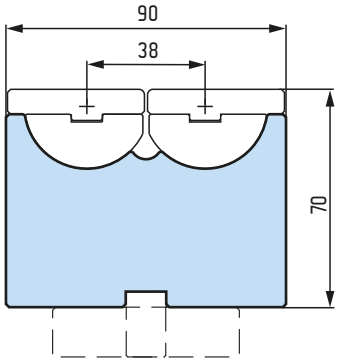
FBM2.5 250 t/m

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



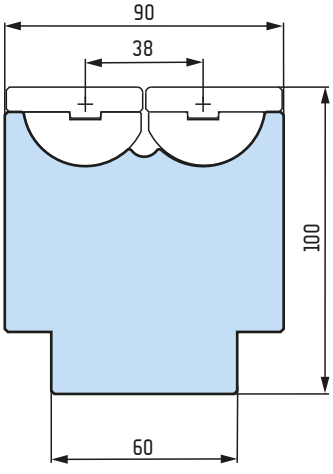
FBP70-3 250 t/m

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



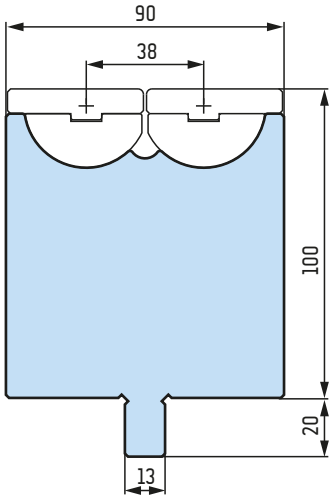
FBP100-3 250 t/m

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



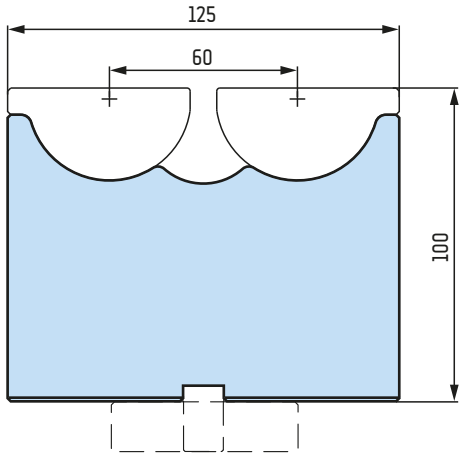
FBT100-3 250 t/m

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



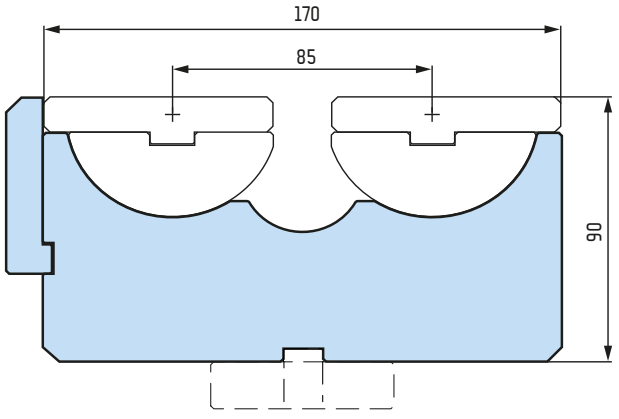
FBM3.5 250 t/m

L = 250 mm, 500 mm



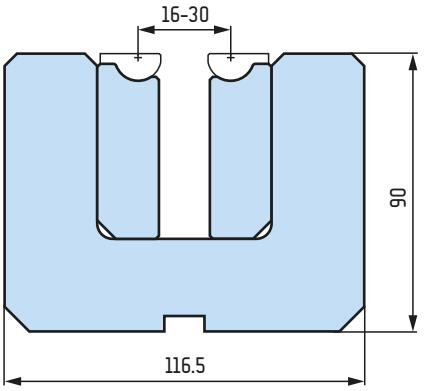
FBM90-4 300 t/m

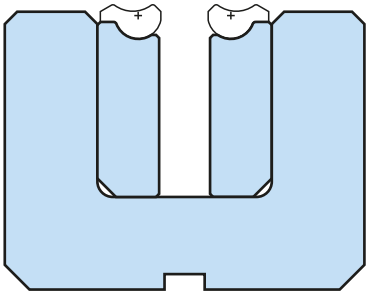
L = 250 mm, 500 mm

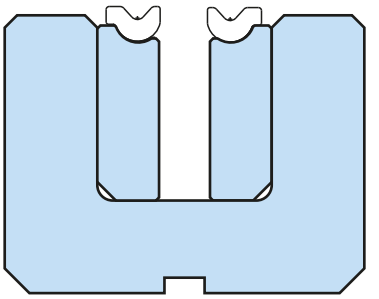


FBHD2 200 t/m

L = 250 mm, 500 mm

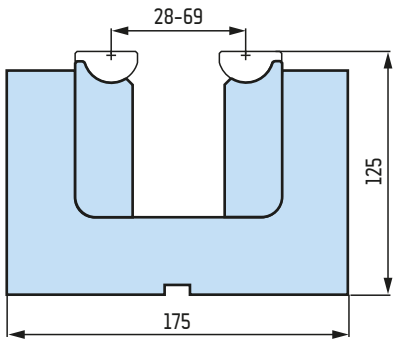


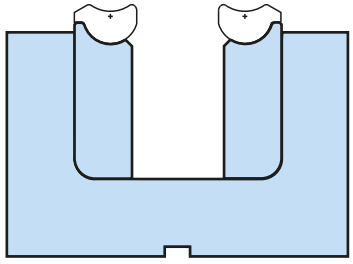


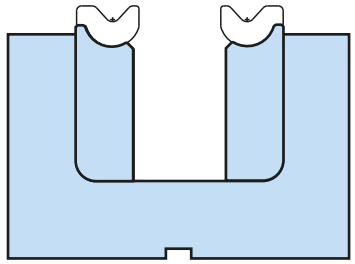


FBHD2.5 250 t/m

L = 250 mm, 500 mm

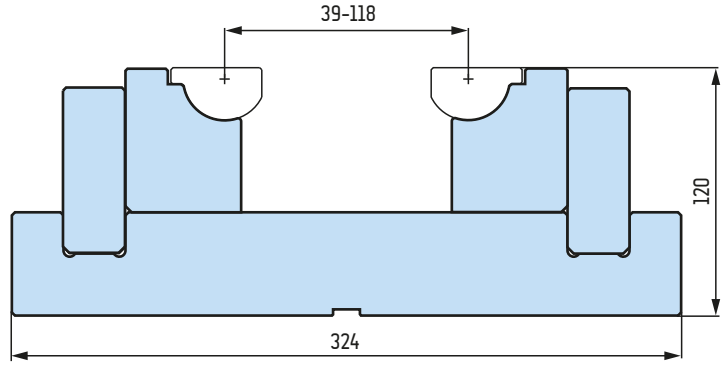


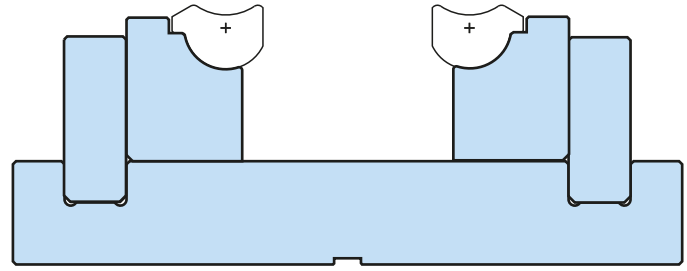


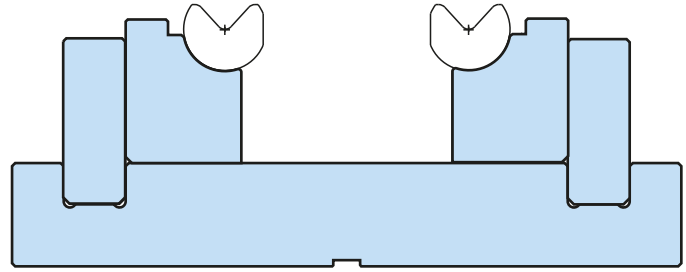


FBHD3 350 t/m

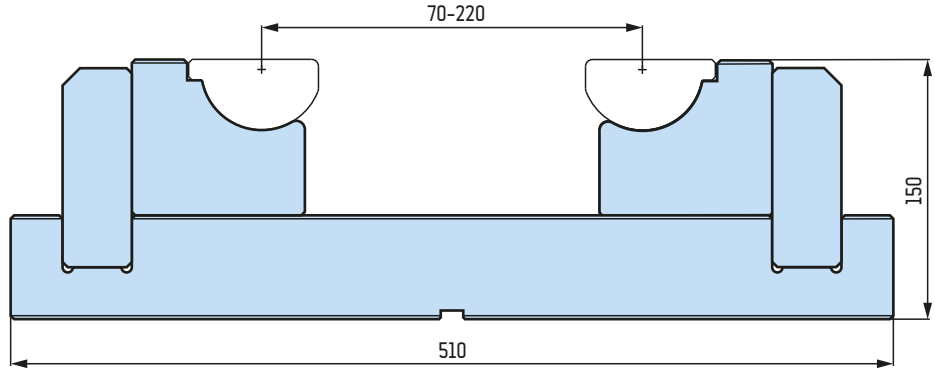
L = 250 mm, 500 mm

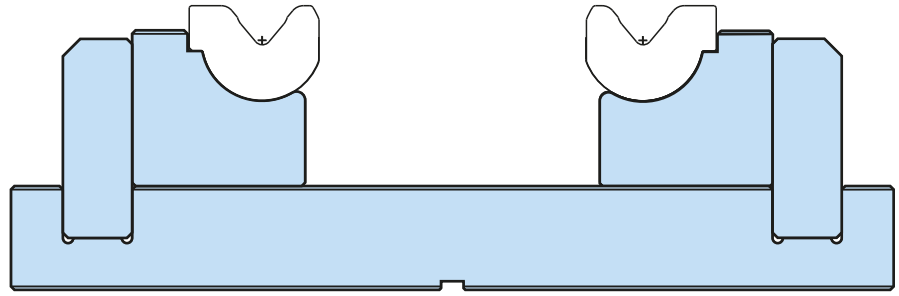


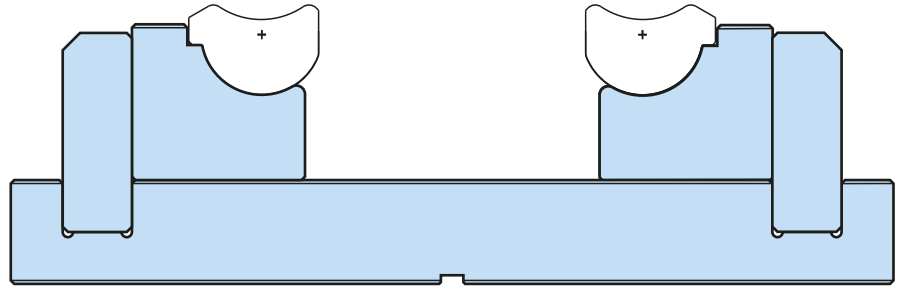




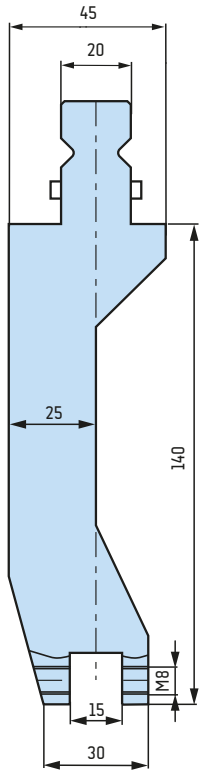
FBHD4	350 t/m
L = 250 mm, 500 mm	







S22140/FR



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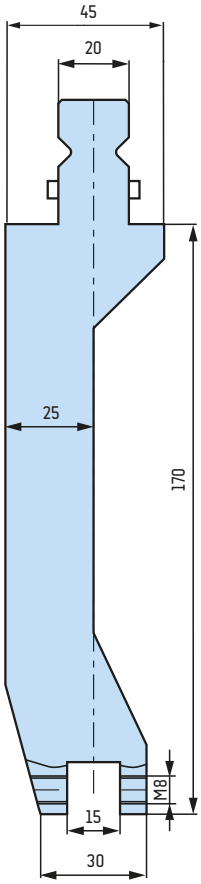
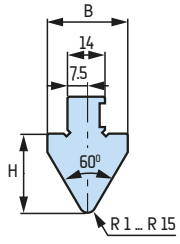
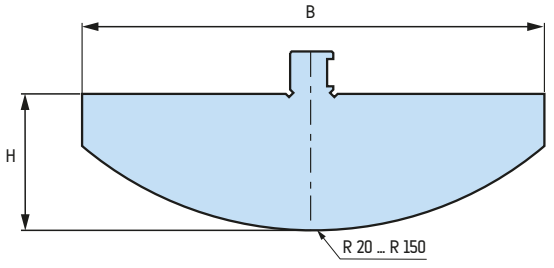


SYMBOL	B	H	R	α
IK H30 R1	*30*	*30*	*1*	*60°*
IK H30 R2	*30*	*30*	*2*	*60°*
IK H30 R3	*30*	*30*	*3*	*60°*
IK H30 R4	*30*	*30*	*4*	*60°*
IK H30 R5	*30*	*30*	*5*	*60°*
IK H30 R6	*30*	*30*	*6*	*60°*
IK H30 R8	*30*	*30*	*8*	*60°*
IK H30 R10	*30*	*30*	*10*	*60°*
IK H30 R12	*30*	*30*	*12*	*60°*
IK H30 R15	*30*	*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*	

VLOŽKY IK R1-R15

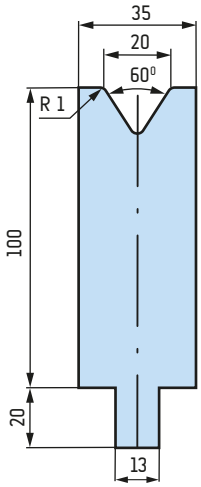


VLOŽKY IK R20 - R150



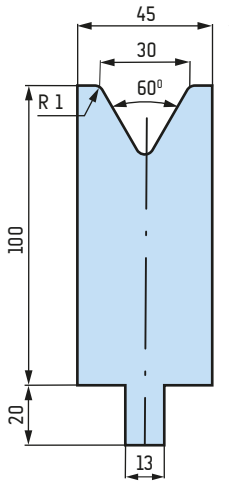
42CrMo4

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



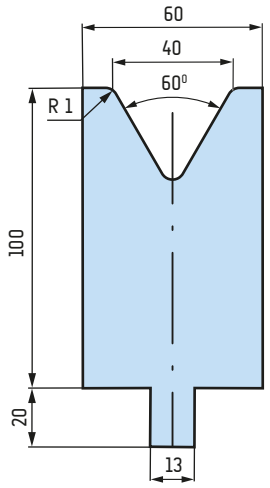
42CrMo4

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



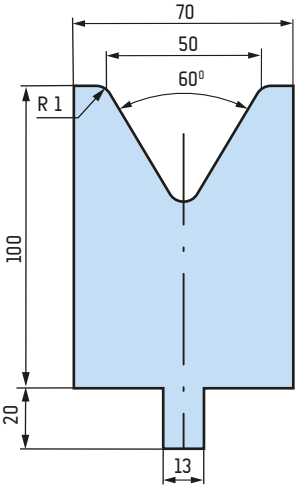
42CrMo4

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



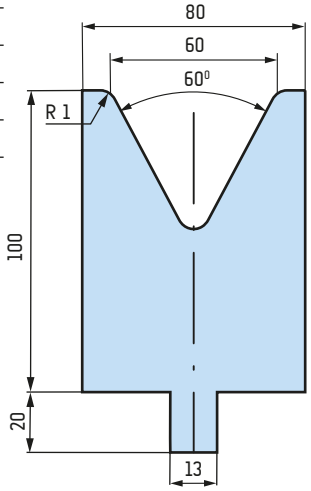
42CrMo4

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



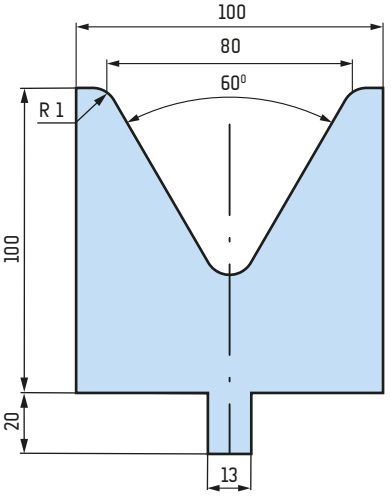
42CrMo4

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 | ALIKO CNC NASTAVITEĽNÉ MATRICE

FAST V-OPENINGS ADJUSTMENT STRAIGHT FROM CNC-CONTROL

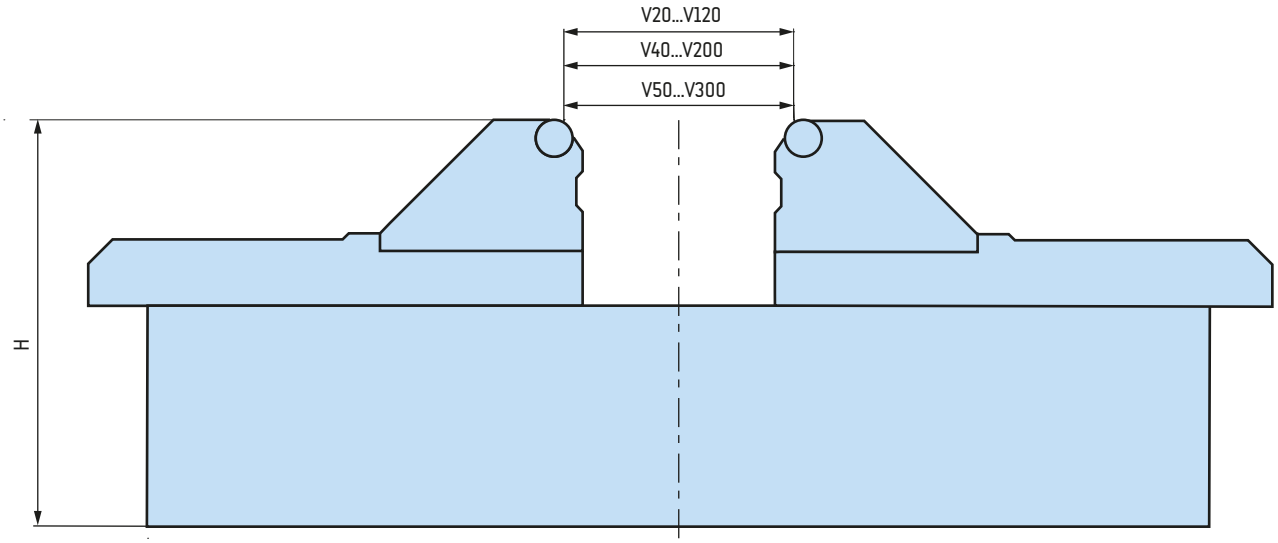
The design of the tool pays special attention to durability and precision control. V-opening adjustment range and tool length can be customized according to customer needs.

- *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*

RÝCHLE NASTAVENIE V- ROZMERU MATRICE PRIAMO Z OVLÁDANIA CNC

Konštrukcia cnc matrice je zameraná s osobitným dôrazom na odolnosť a presnosť ovládania. Rozsah nastavenia šírky matrice v a dĺžky nástroja je možné prispôsobiť potrebám zákazníka.

- *Automaticky nastaviteľná šírka v, presné polohovanie každých 10 mm*
- *Rýchle nastavenie veľkosti v rozmeru matrice priamo z cnc riadenia*
- *Silná a odolná konštrukcia*
- *Vynikajúca odolnosť voči zaťaženiu*
- *Valčeky na tvarovacích hranách matrice na zníženie sily potrebnej na ohýbanie a zvýšenie životnosti nástroja*
- *Vhodné pre väčšinu ohraňovacích lisov*
- *Prakticky bezúdržbové*



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	šírka V, mm	Výška, mm	Max. zaťaženie α 80°, t/m
MATRICA ALIKO CNC-VARIO 120	V20-120	200	250
MATRICA ALIKO CNC-VARIO 200	V40-200	330	400
MATRICA ALIKO CNC-VARIO 300	V50-300	400	400

ALIKO UPPER TOOL CLAMPING SYSTEMS | ALIKO UPÍNACIE SYSTÉMY RAZNÍKA

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*

HYDRAULICKÝ SYSTÉM UPÍNANIA RAZNÍKOV

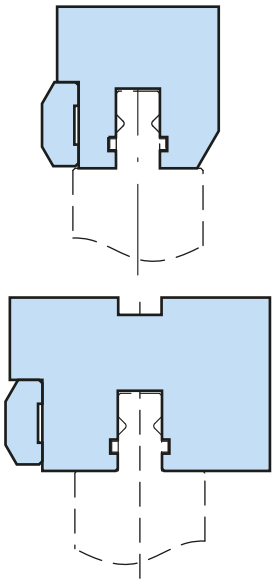
- *Rýchle upínanie, polohovanie a vybratie nástrojov*
- *Robustný prierez upínania profilu*
- *Zaťaženie upínania na úrovni 250 t/m alebo 400 t/m*
- *Vhodné pre všetky typy lisov*

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*

MECHANICKÝ UPÍNACÍ SYSTEM RAZNÍKOV PRE STROJE ŠTANDARTNÉ, AJ VYSOKO - TONÁŽNE STROJE

- *Kompatibilné s nástrojmi s upínaním WILA*
- *Maximálne zaťaženie 400 t/m, alebo 600 t/m*
- *Rýchle upínanie, polohovanie aj výmena razníkov*



ALIKO LOWER TOOL CLAMPING SYSTEMS | ALIKO UPÍNACIE SYSTÉMY MATRICE

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

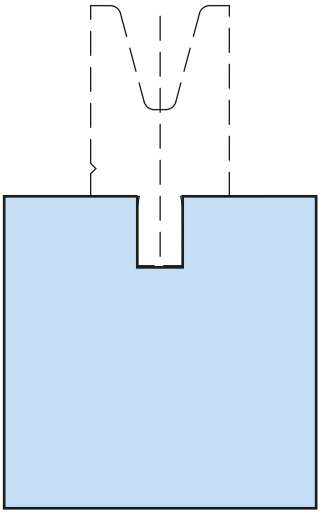
- *Mechanical lower tool clamping*
- *Pneumatic lower tool clamping*
- *Pneumatic lower tool clamping with V-loading bridge*
- *Hydraulic lower tool clamping*
- *Lower tool adapters*

UPÍNANIE MATRÍC

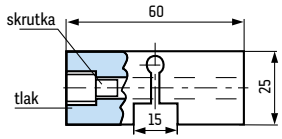
- *Rýchla výmena matríc, automatické zastredenie*
- *Jednoduchá manipulácia s matricami*
- *Možnosť použitia delených matríc*
- *Zaťaženie do 600 t/m*
- *Možnosť transportného systému matrice*

TYPY ALIKO SYSTÉMOV UPÍNANIA MATRÍC

- *Mechanické upínanie matríc*
- *Pneumatické upínanie matríc*
- *Pneumatické upínanie matríc so systémom transportu nástrojov*
- *Hydraulické upínanie matríc*



2 V

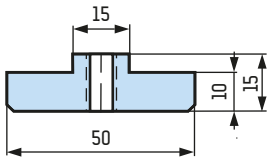


ASSEMBLY | **PRÍKLAD MONTÁŽE**



A

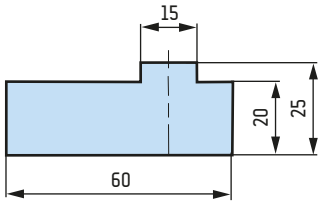
L = 415 mm, 835 mm





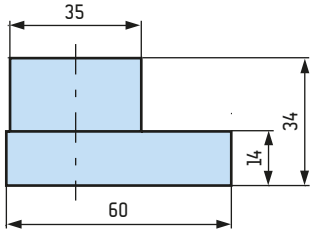
A 20

L = 415 mm, 835 mm



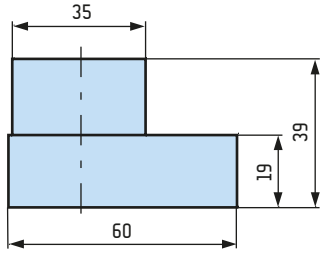
A 34

L = 412 mm, 830 mm



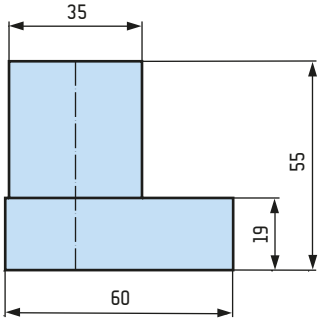
A 39

L = 412 mm, 830 mm



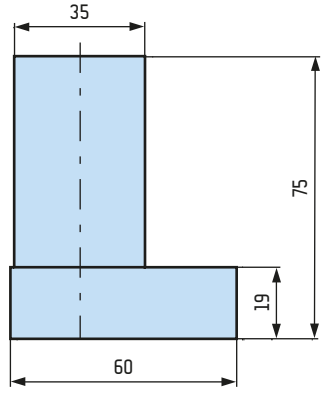
A 55

L = 412 mm, 830 mm



A 75

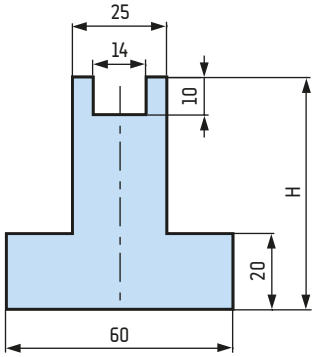
L = 412 mm, 830 mm



A 31

L = 415 mm, 835 mm

H = 31 mm



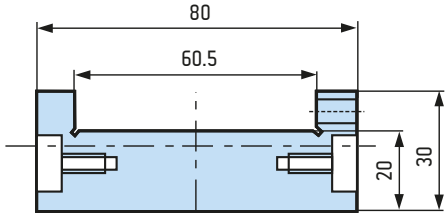
A 61

L = 415 mm, 835 mm

H = 61.5 mm

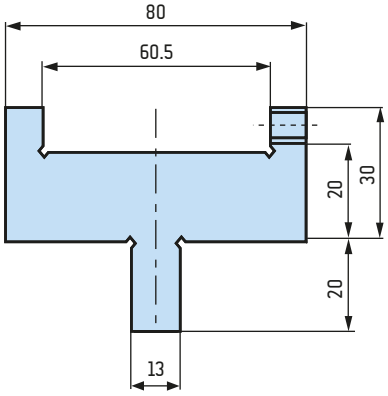
B 60

L = 1050 mm



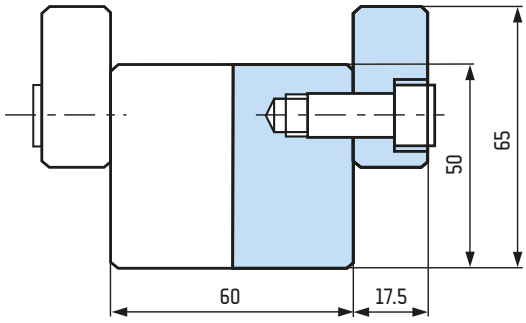
B 60 / T-A

L = 1050 mm



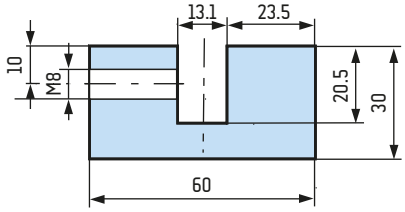
C 60

L = 835 mm



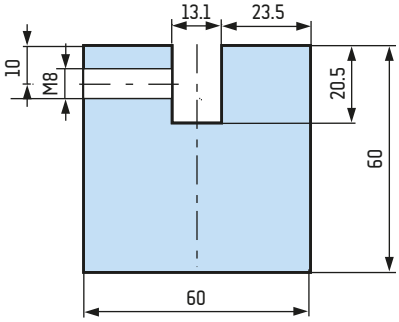
D 30

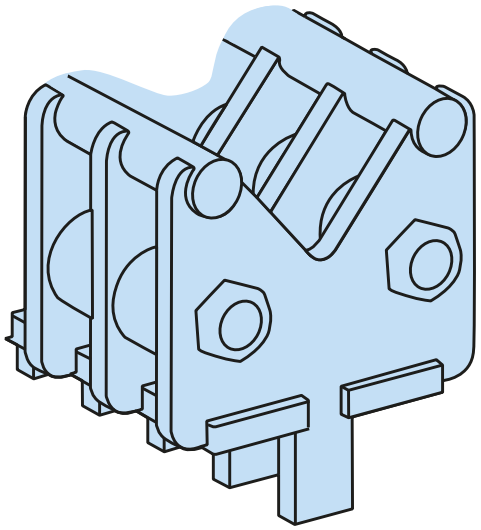
L = 1000 mm



D 60

L = 1000 mm





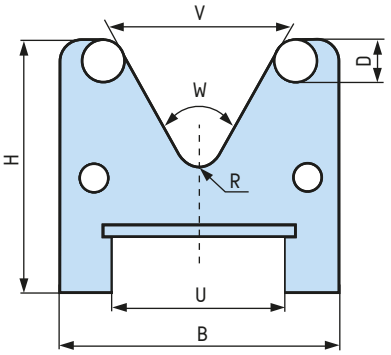
Compound dies meet the high demands of customers who need continual product improvement. By using new production techniques a new tooling product has been developed offering great value for money. It can be used for almost any application and will be a major advantage for use in the midrange and heavy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

Skladané matrice z legovanej ocele, s vložkami s tvrdosťou 60 HRc sú lacnejšou alternatívou plných matríc. Vďaka vysokej pevnosti môžu byť použité pre väčšinu požiadaviek na ohýbanie stredne hrubých aj hrubých plechov. Je možné meniť dĺžku matríc, vymieňať vložky a zhotovovať ich pre požadovaný system upínania matrice.

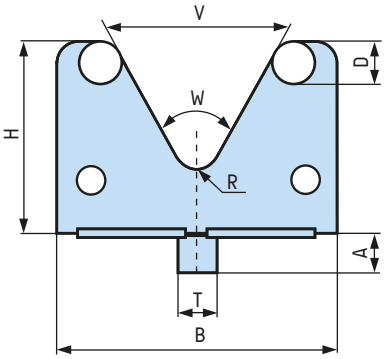
V	D	W°	B	H	R	t/m
16	6	**28**	30	**55**	2	**30**
20	6	**28**	34	**55**	2	**35**
24	8	**28**	40	**55**	3	**40**
32	10	**28**	53	**55**	5	**45**
32	10	**85**	53	**55**	5	**60**
40	10	**85**	62	**55**	5	**60**
48	10	**85**	70	**55**	5	**60**
mm	mm	°	mm	**mm**	mm	

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	

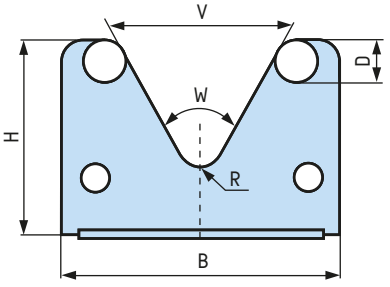
S



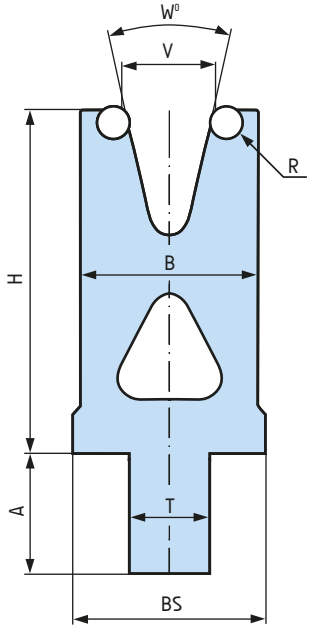
T



U



COMPOUND DIES | MATRICE SKLADANÉ



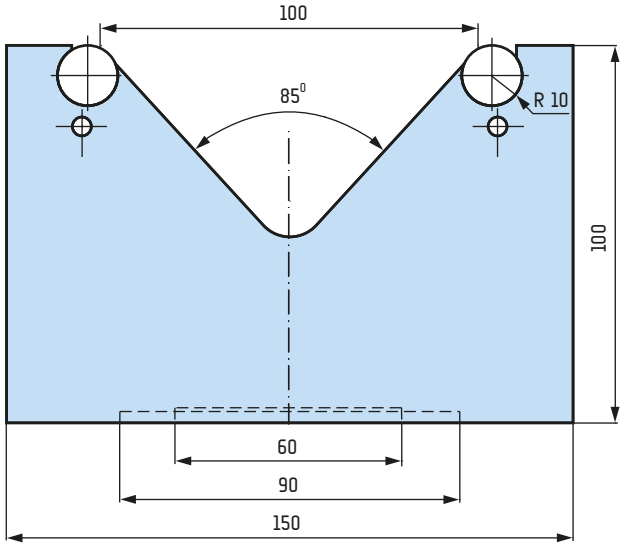
Compound dies are press brake dies for "airbending" only. The high precision, high quality, hardened and anodised, aluminium die body, contains the two hardened and ground die bars. The die bars are interchangeble in case of wear.

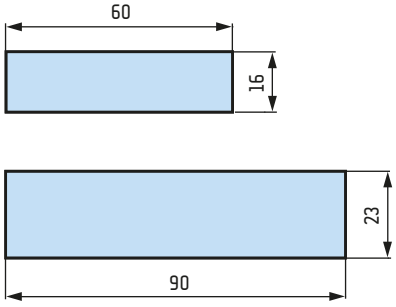
Kompozitné matrices sú vyrobené z odolných tvrdených hliníkových zliatin.Sú vhodné iba pre ohýbanie "vo vzduchu". Obsahujú dve tvrdené a brúsené oporné tyče, ktoré sú pri opotrebení vymeniteľné.

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 | MATRICE S VALČEKMI

example | **príklad**





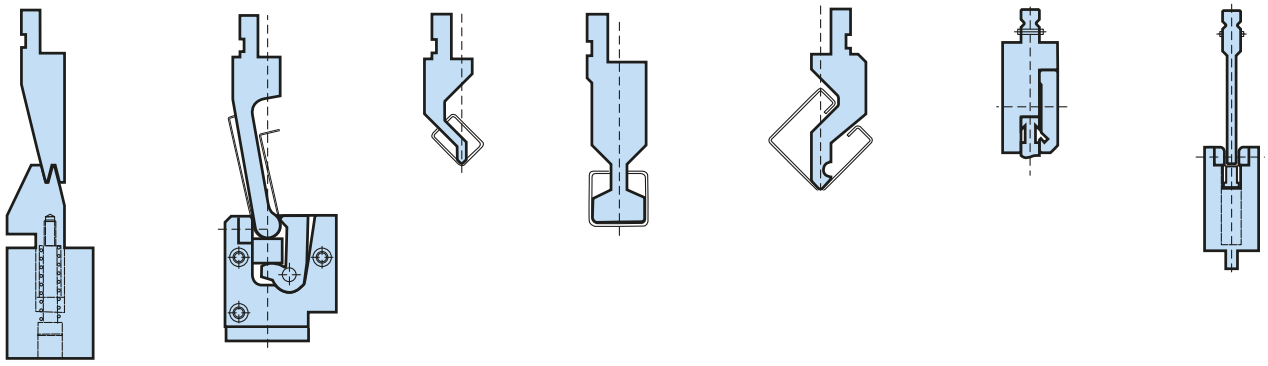
Round inserts hardened up to 60 HRc.
Rectandular inserts 60 mm or 90 mm wide allow the die to be fixed on smaller machine beams.

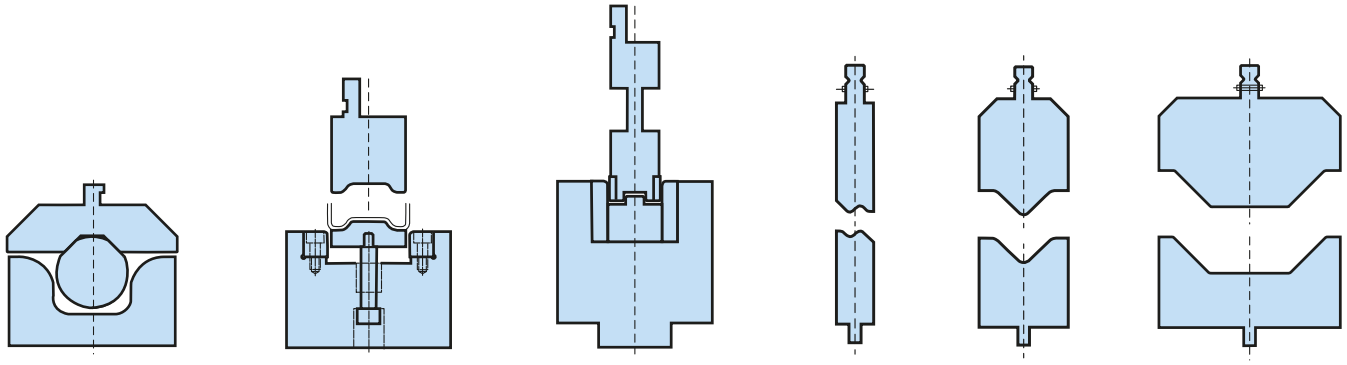
Matrice sú s valčekmi s tvrdosťou do 60 HRc.
Na užší stôl možno použiť vložky so šírkou 60 mm alebo 90 mm..

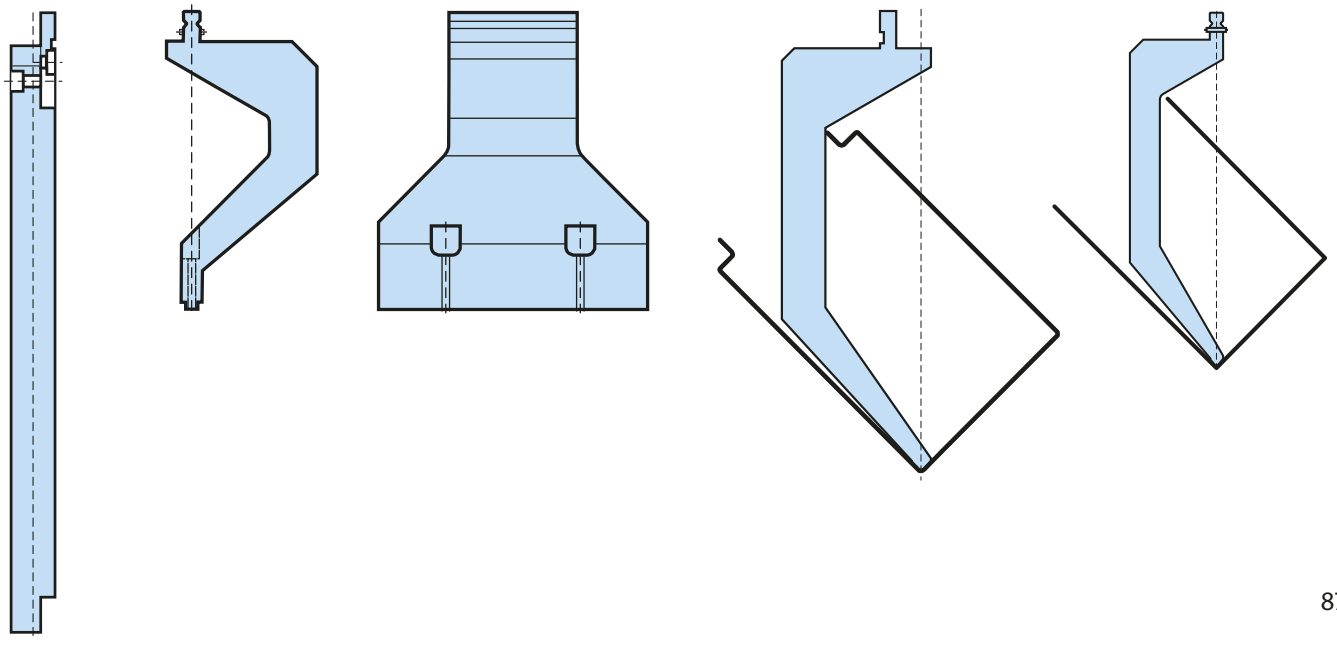
special tooling examples | príklady špeciálnych nástrojov

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

Ponúkame mnoho typov nástrojov na ohýbanie špeciálnych profilov, ako aj neštandardné upínanie nástrojov.

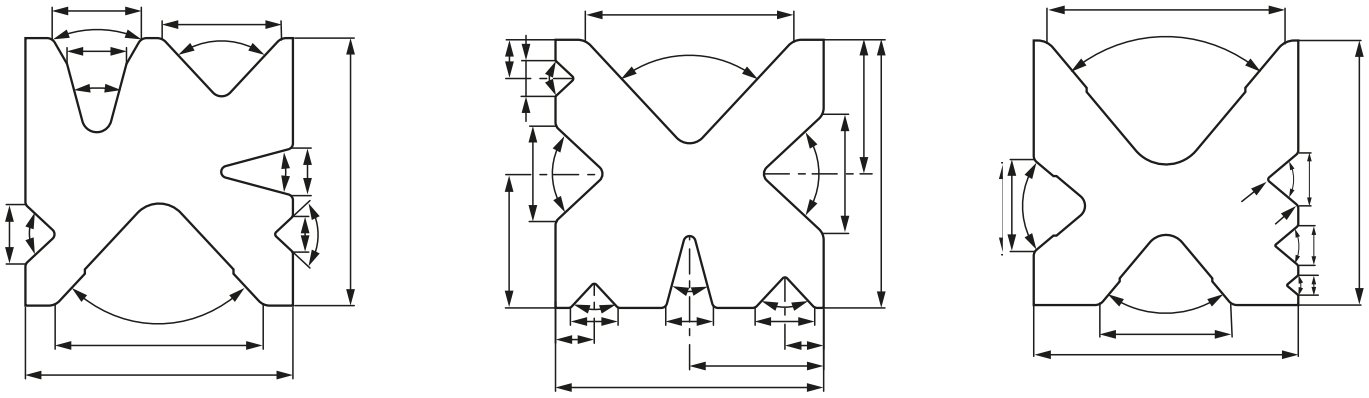






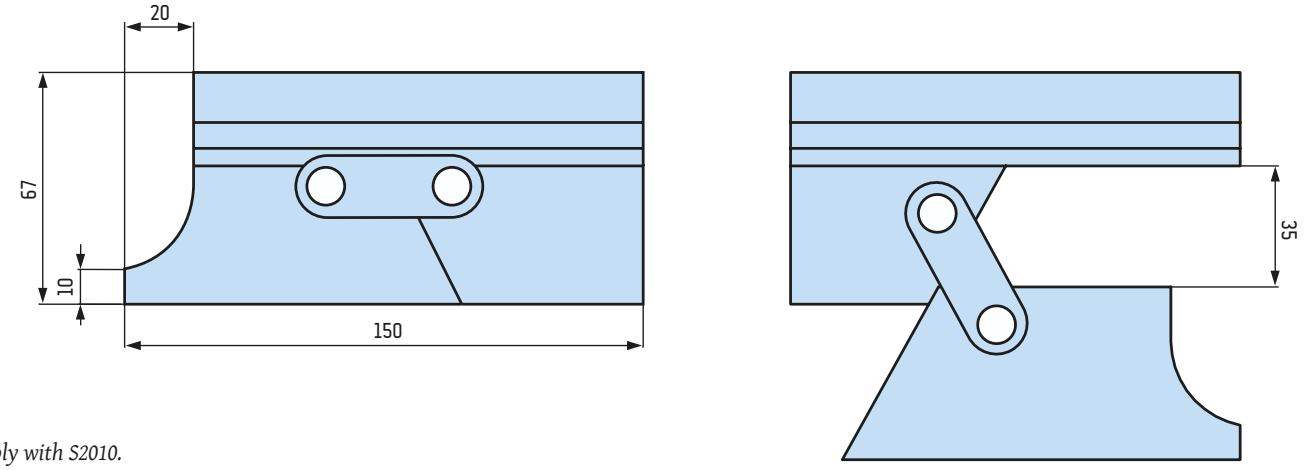
multi-v dies | matrice multi-v

Insert dimensions.
Pri objednávke uveďte rozmery.

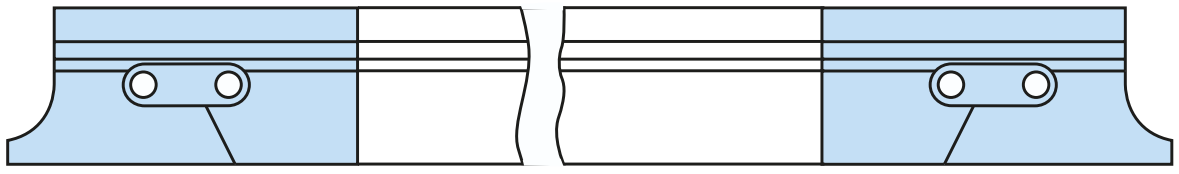


BOX-CLOSING PUNCH | RAZNÍK PRE UZATVÁRANIE KRABÍC

Punch with dimensions as S2010/88/R0.8 used for closing boxes.
Razník s geometriou ako S2010/88/R0.8 používaný na uzatváranie škatúľ.



Assembly with S2010.
Zostavenie s S2010.



protective tape | ochranná fólia

24h

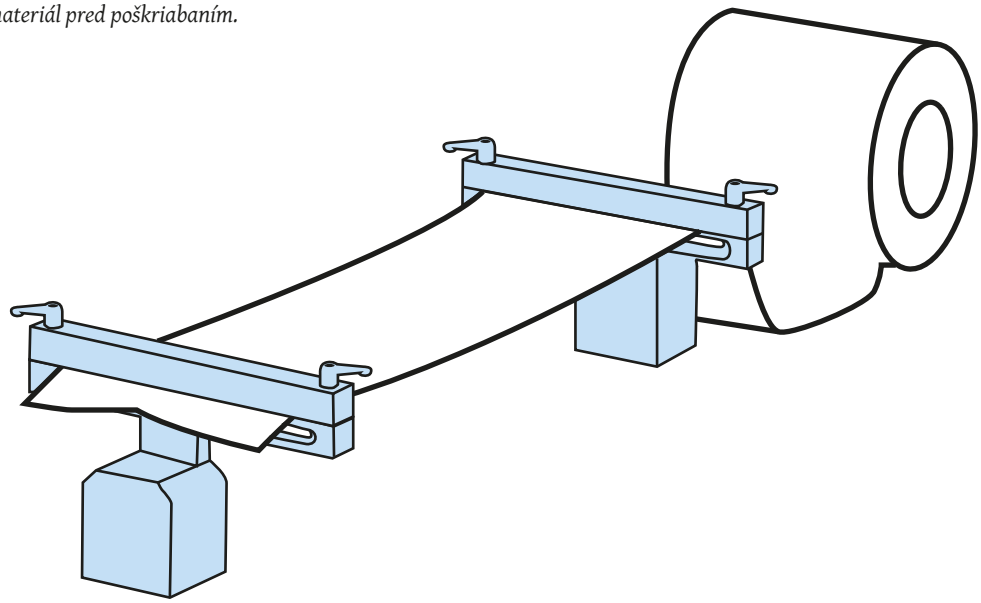
Tape size
thicknes = 0.4 mm, width = 100 mm
thicknes = 0.5 mm, width = 100 mm
thicknes = 0.8 mm, width = 100 mm

Rozmery fólie
hrúbka= 0.4 mm, szerokość = 100 mm
hrúbka= 0.5 mm, szerokość = 100 mm
hrúbka= 0.8 mm, szerokość = 100 mm

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

Držiak ochrannej fólie
upínanie pre matrice od 13 mm do 60 mm

Plastic tape protecting sheet metal from damage.
Ochranná plastová fólia chráni ohýbaný materiál pred poškriabaním.



magnetic squaring arm | magnetický nastavovač uhla polohy pri ohybe



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

Magnetický nastavovač uhla polohy pri ohybe sa dodáva v l'avom a pravom prevedení.



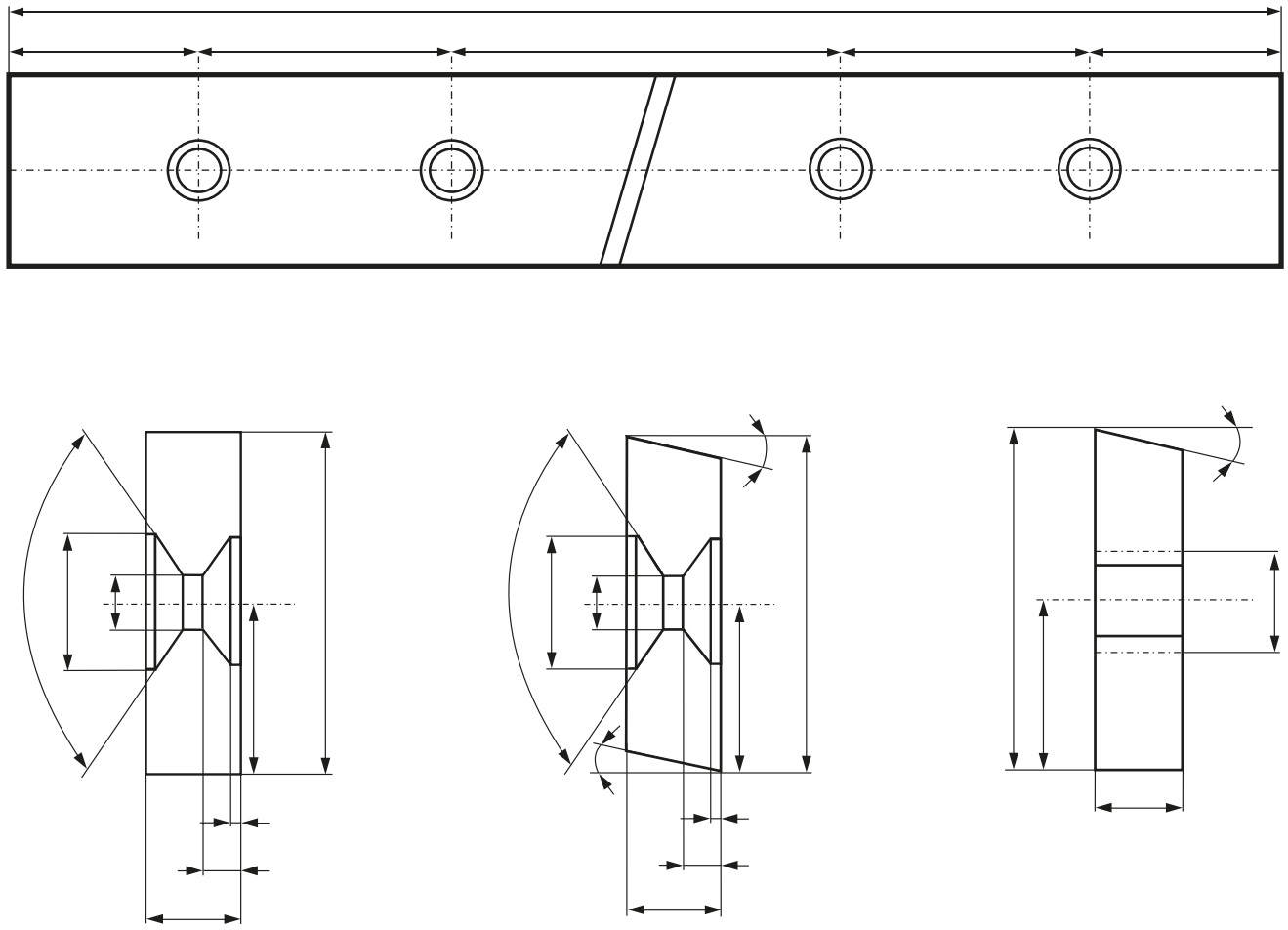
Verzia l'avá.
Left squaring arm.



Verzia pravá.
Right squaring arm.

shear blades | noże pre nožnice

Insert dimensions.
Pri objednávke uveďte rozmery.



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 6100 mm. We can regrind and repair used blades of up to 6100 mm in length.

Vyrábame nože pre gilotínové nožnice brúsené a kalené na 55 ±2 HRc. V stálom predaji máme nožnicové nože NG 3-13, NTE, CNTA 6.3-25. Dokážeme vyrobiť mnoho ďalších typov nožov podľa zákazníckych výkresov a špecifikácií s dĺžkou noža až 6100 mm. Ponúkame aj brúsenie gilotínových nožov do dĺžky 6100 mm.

TEDA adapters – main models | adaptéry TEDA – základné modely

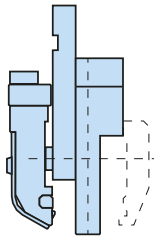
Main benefits:
– standard type "A" tool
– no tool modification
– tool frontal insertion / removal
– easy assembly on any press brake (new or already in use)
– no modification of press necessary

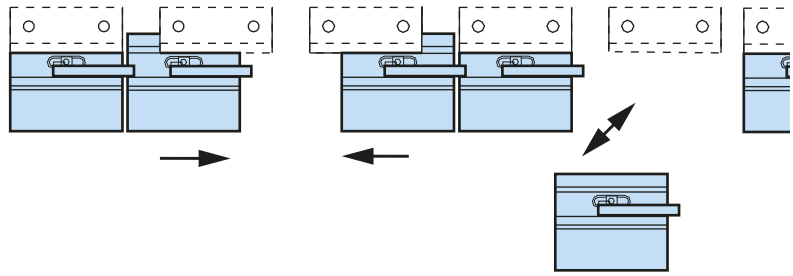
Hlavné výhody:
– štandartné nástroje typu „A"
– nie sú potrebné žiadne úpravy nástrojov
– nástroje sú upínané aj odopínané spredu
– jednoduchá montáž na akýkoľvek ohraňovací lis (nový, alebo už používaný)
– nie sú potrebné žiadne úpravy ohraňovacieho lisu

SPEED GRIP 13000-M MANUAL | MANUÁLNY / RUČNÝ

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

Ergonomická páka (jedna pre každý adaptér) zamyká / odomyká nástroje.





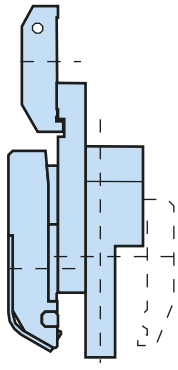
SPEED GRIP 13000-ST PNEUMATIC | PNEUMATICKÝ

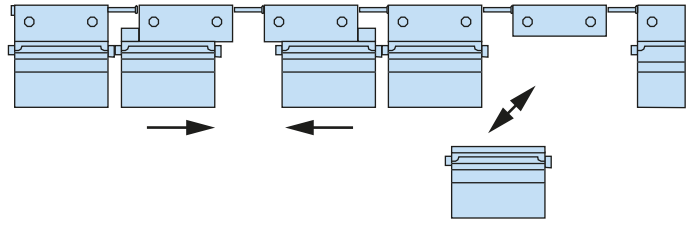
One selector only for the whole line. Air transmission by TEDA patented "STAR SYSTEM".

Len jeden prepínač pre celú líniu. Prenos vzduchu cez chránené ocelové rúrky (Patent TEDA "STAR SYSTEM").

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.

Upozornenie: v závislosti od konfigurácie nosníka ohraňovacieho lisu (os ohybu 7 mm alebo 20 mm) rozdielna výška adaptérov - 100 / 120 / 150 mm – s alebo bez klinu atď.). Pre každý model SPEED GRIP je k dispozícii celý rad rôznych riešení.

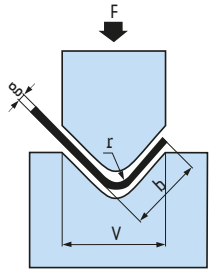




We also offer pneumatic die holders and special punch holders and adapters.
Compared to traditional manual clampings with screws SPEED GRIP grants about 80% timesaving.

Ponúkame aj pneumatické upínanie matríc, ako aj adaptéry a špeciálne držiaky.
Oproti tradičným ručným skrutkovacím adaptérom SPEED GRIP ušetria asi 80% času pri upínaní a zmene nástrojov.

PRESSURE TABLE | TABUĽKA SÍL A ROZMEROV



The table shows bending pressure for sheets with air bending.
Parametre vol'ného ohýbania plechov pri ohýbaní vo vzduchu.

F [t] – pressure on 1 m / sila na 1 m
V – vee size / šírka drážky
b – minimum lenght of bending arm / minimálna dĺžka ohýbacieho ramena
r – inner radius on steel / vnútorný polomer ohýbaného plechu

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 / odporúčané šírky drážky