

schiavi

PRESS BRAKE TOOLING



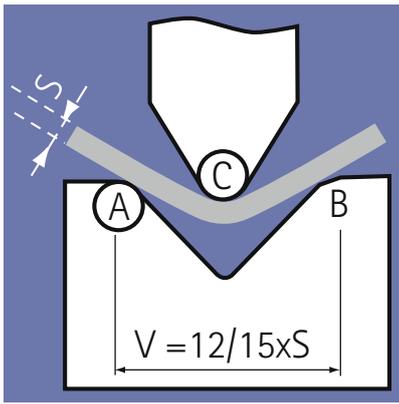
SCHIAVI **CUSTOMER SERVICE**

Being close to our customers means to us:

- . After-sale service
- . Local representatives
- . Prompt delivery of spare parts
- . Professional training

INFORMATION / SALES DEPARTMENT

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Bottoming _ In this bending method, the inner radius obtained is called "natural bending radius" and is equal to 1/6 of V – width approximately. A inner radius equal to thickness can be obtained by using a die with a V-width of 6 times sheet thickness.

In case of 90° bendings, 88° dies can be used to compensate material elasticity. The required pressure is indicated in pressure table. This bending method is generally used for sheets up to 2-3 mm thickness.

Main bending techniques

Air bending _ It is the most common bending method requiring a relatively low pressure, but the angle precision is affected by material elasticity once the bending is completed.

Air bending can be divided in:

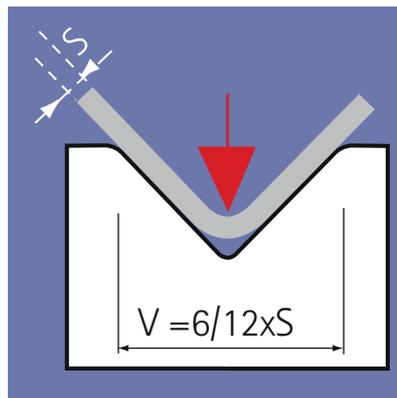
Partial bending _ This is a method in which the bending stops before sheet comes to the die bottom. The sheet contacts the tool in A – B – C points (as indicated in the picture) and the bending angle is determined by the position of such points. This bending method preferably requires a V – width of 12 or 15 times sheet thickness.

Pressure values indicated in the pressure table are indicative, as in this method the pressure varies according to many factors, such as material features, tool type and profile, etc.

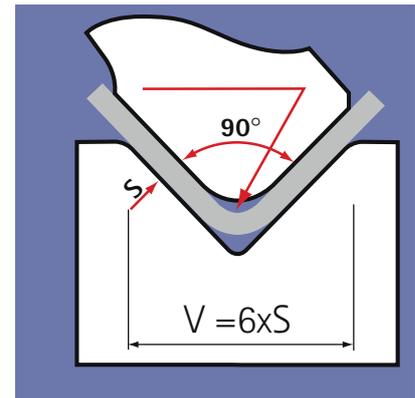
Coining – This is a bottom pressing bending method requiring a very high pressure, 4/5 times higher than the ones required in bottoming. The bending precision is very good, as the inner radius coining cancels the material springback.

This happens as a consequence of penetration of the punch tip into the die bottom in natural bending radius of sheet metal.

Die has a V – width of 6 times sheet thickness and is at 90° as well as punch.



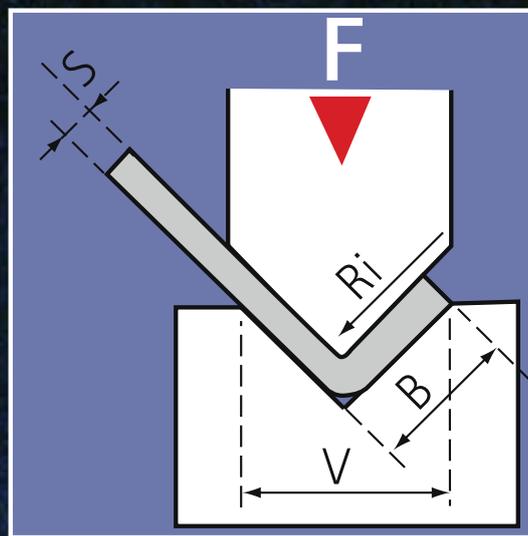
Through this bending method, it is possible to obtain bending inner radius lower than sheet thickness and the elimination of remaining elasticity.



Coining is generally used on sheets up to 2 mm thickness and, in some cases, up to 3 mm thickness.

Punch angle is very important only in case of coining.

S	Spessore lamiera - mm Thickness of the sheet - mm
V	Larghezza del V V-opening
F	Forza in T/m Force in T/m
B	Bordo minimo Shortest edge
Ri	Raggio interno Inside radius
R	alluminio 20-25 Kg/mm ² aluminium 20-25 Kg/mm ²
R	acciaio dolce 40-45 Kg/mm ² mild steel 40-45 Kg/mm ²
R	inox 65-70 Kg/mm ² stainless steel 65-70 Kg/mm ²



Relazione tra spessore lamiera e larghezza V
Sheet thickness/V-shape width ratio

S	Spessore lamiera - mm Sheet thicknes - mm	0,5-2,5	3-8	9-10	12 o più
V	Larghezza del V "V" width	6 S	8 S	10 S	12 S

R	alluminio 20-25 kg/mm ² aluminium 20-25 kg/sq. mm
R	acciaio dolce 40-45 kg/mm ² mild steel 40-45 kg/sq. mm
R	inox 65-70 kg/mm ² stainless steel 65-70 kg/sq. mm

$$F = \frac{S^2 \times 2 \times R}{1.4 \times V} = \dots \text{ ton/m}$$

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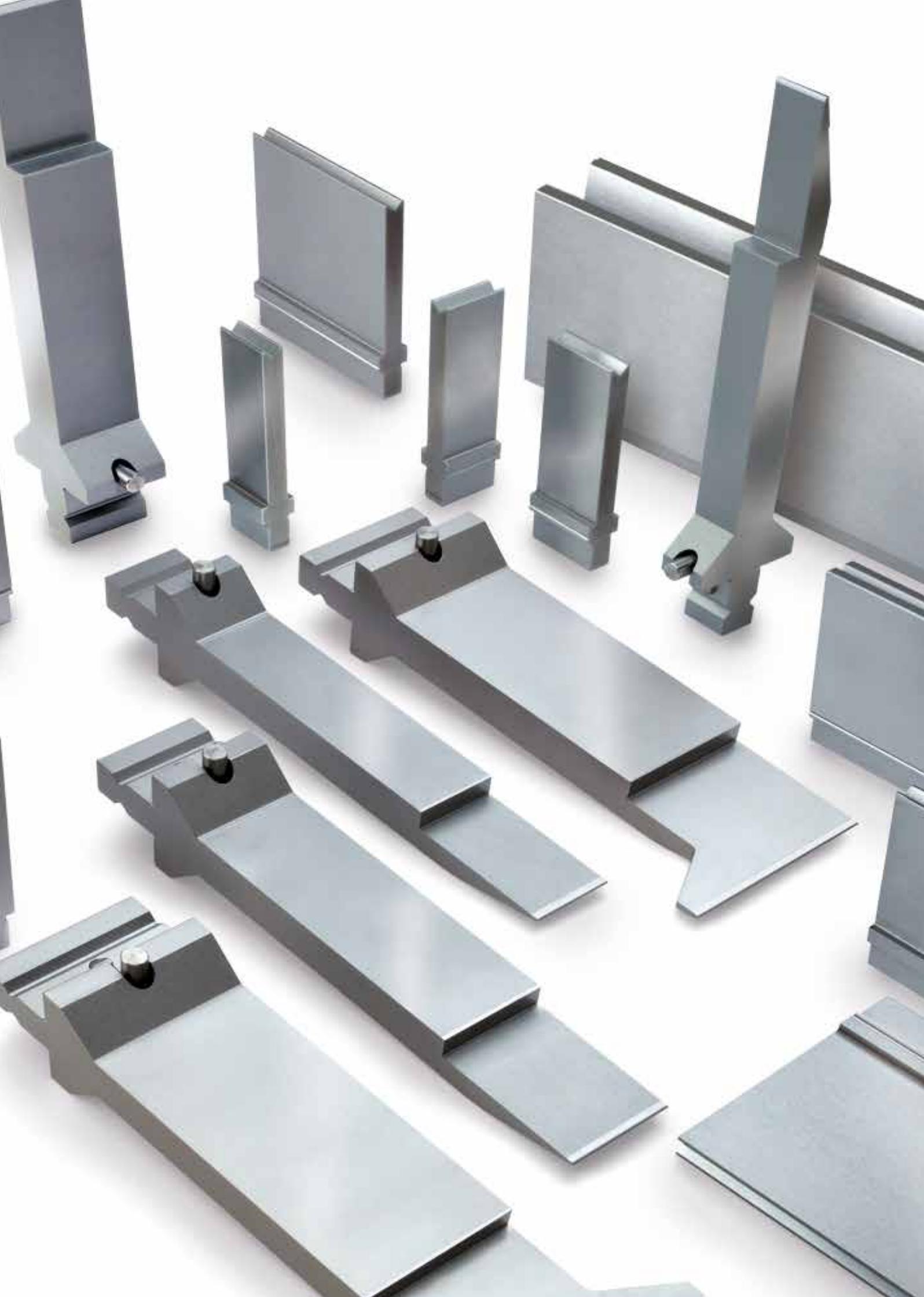
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PRESS BRAKE TOOLING
TRUMPF STYLE



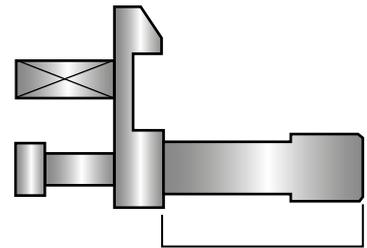
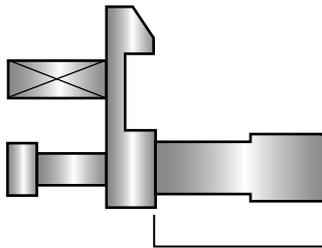
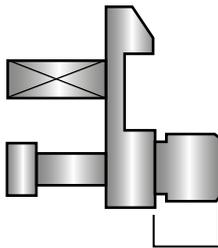
TRUMPF STYLE

CLICK AND LOCK



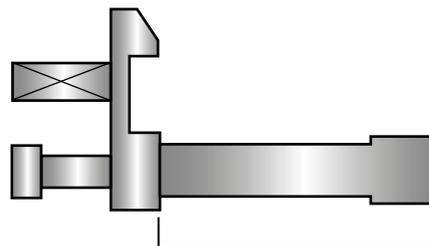
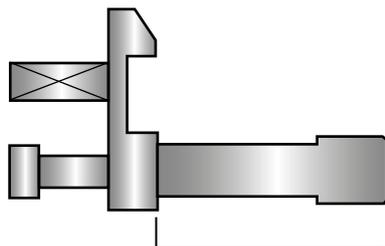
Buttons can be put in all punches with a weight below 12.7 kg

Description	Description	Description
Punch Button Assembly - 10mm	Punch Button Assembly - 24mm	Punch Button Assembly - 30mm

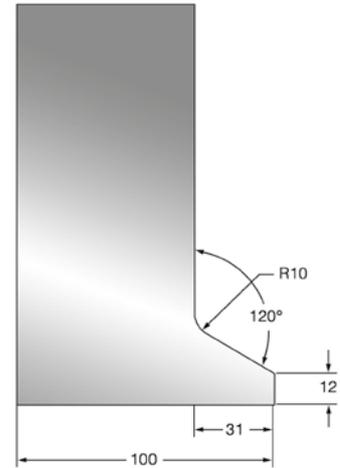
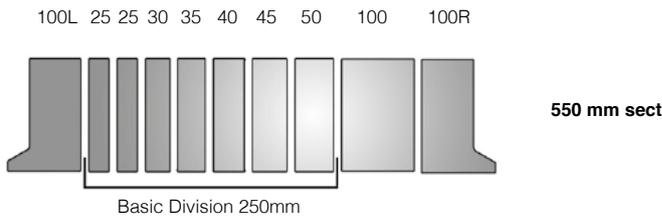
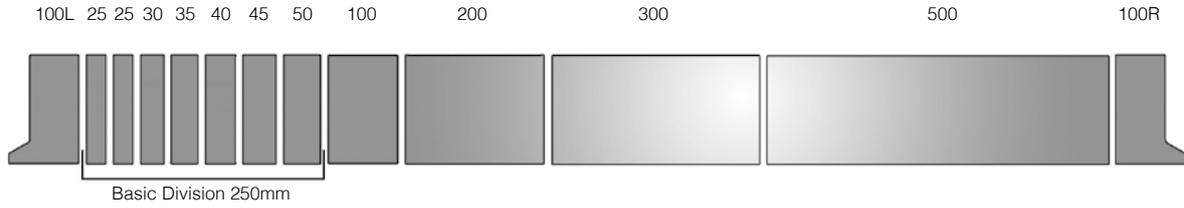


Description
Punch Button Assembly - 35mm

Description
Punch Button Assembly - 45mm



SYSTEM DIVISION PUNCHES



Version B							
Set	100L	250X	100	200	300	500	100R
1050	1	1	1	1	1	0	1
1250	1	1	1	2	1	0	1
2050	1	1	1	1	1	2	1
2550	1	1	1	1	1	3	1
3050	1	1	1	1	1	4	1
4050	1	1	1	1	1	6	1

Division version for tool sets with a weight of up to 50kg/m

Set	100L	250X	100	200	300	500	100R
1050	1	1	1	1	1	0	1
1250	1	1	1	2	1	0	1
2050	1	1	1	3	3	0	1
2550	1	1	1	4	4	0	1
3050	1	1	1	5	5	0	1
4050	1	1	1	7	7	0	1

Division version for tool sets with a weight of more than 50kg/m

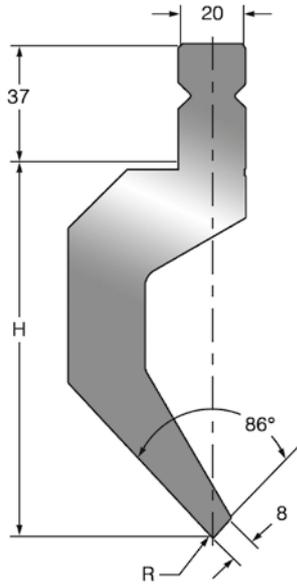
Version A			
Set	100L	250X	100R
1050A	1	1	6
1250A	1	1	8
2050A	1	1	16

Benefit version B		
-High flexSBility	-Fewer tool change-overs	
-Short tool set-up time	-Version most often selected and recommended	-Low purchase cost

Benefit version A	
-Maximum flexSBility	-Weight of the individual part pieces very low
-Maximum tool set-up time	-All tools can be loaded vertically and horizontally

SYSTEM DIVISION VERSION B/A
The combination of a punch block A-division and a die block in B-division will not cause any problems

PUNCHES SWAN NECK

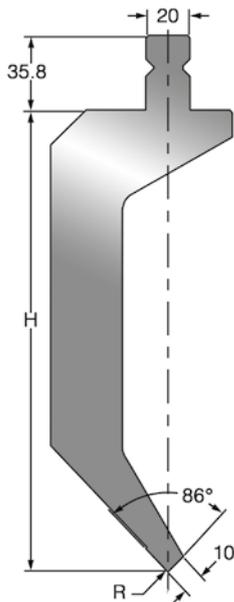


Schiavi Profile	SOW200
Trumf Profile	OW200/K
Radius	R1
Angle	86°
Height	120
Maximum Loading:	800 kN/m
Weight:	29.1 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

Dimensions in mm

Modified Punch Tip Radii				
R0.5	R1.6	R2	R2.3	Radius
86°	86°	86°	86°	Angle
119.8	119.2	119.2	119	Height



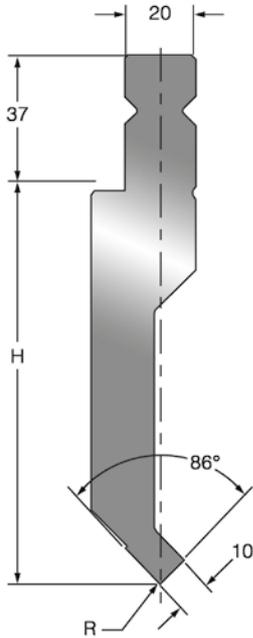
Schiavi Profile	SOW200S
Trumf Profile	OW200/S
Radius	R1
Angle	86°
Height	220
Maximum Loading:	800 kN/m
Weight:	66,3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	300
	200
Version A	Horn right
Description	Horn Left
Length 2050	100
Length 1250	50
Length 1050	45
	40
	35
	30
	25

Dimensions in mm

Modified Punch Tip Radii				
R0.5	R1.6	R2	R2.3	Radius
86°	86°	86°	86°	Angle
219.8	219.2	219.2	219	Height

PUNCHES GOOSE NECK

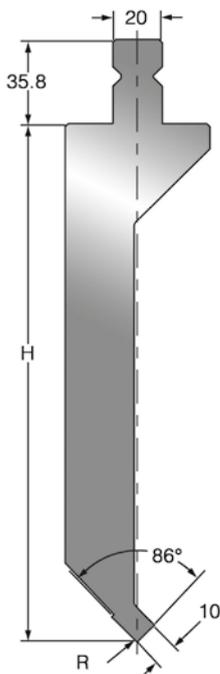


Schiavi Profile	SOW201
Trumpf Profile	OW201/K
Radius	R1
Angle	86°
Height	120
Maximum Loading:	800 kN/m
Weight:	24.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

Dimensions in mm

Modified Punch Tip Radii				
R0.5	R1.6	R2	R2.3	Radius
86°	86°	86°	86°	Angle
119.8	119.4	119.2	119	Height



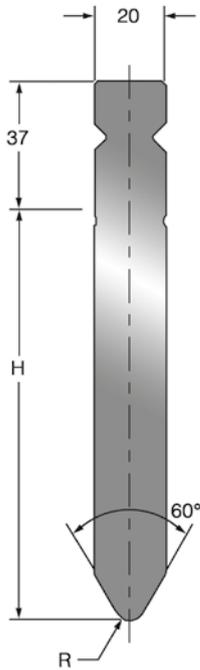
Schiavi Profile	SOW201S
Trumpf Profile	OW201/S
Radius	R1
Angle	86°
Height	220
Maximum Loading:	800 kN/m
Weight:	57.0 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	300
	200
Version A	Horn right
Description	Horn Left
Length 2050	100
Length 1250	50
Length 1050	45
	40
	35
	30
	25

Dimensions in mm

Modified Punch Tip Radii				
R0.5	R1.6	R2	R2.3	Radius
86°	86°	86°	86°	Angle
219.8	219.4	219.2	219	Height

PUNCHES POINTED BOTTOMING

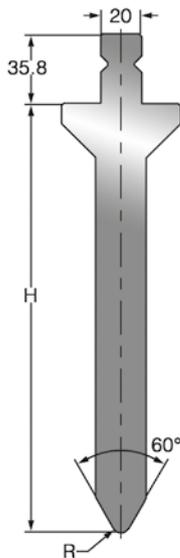


Schiavi Profile	SOW203
Trumpf Profile	OW203/K
Radius	R4
Angle	60°
Height	120
Maximum Loading:	1300 kN/m
Weight:	23.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

Dimensions in mm

Modified Punch Tip Radii				
R2	R2.5	R3	R4.7	Radius
60°	60°	60°	60°	Angle
119.8	119.8	119.8	119.1	Height



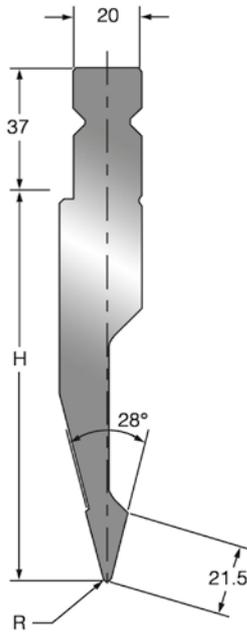
Schiavi Profile	SOW203S
Trumpf Profile	OW203/S
Radius	R4
Angle	60°
Height	220
Maximum Loading:	1300 kN/m
Weight:	52.1 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	300
	200
Version A	Horn right
Description	Horn Left
Length 2050	100
Length 1250	50
Length 1050	45
	40
	35
	30
	25

Dimensions in mm

Modified Punch Tip Radii				
R2	R2.5	R3	R4.7	Radius
60°	60°	60°	60°	Angle
219.8	219.8	219.8	219	Height

PUNCHES POINTED WITH RECESS

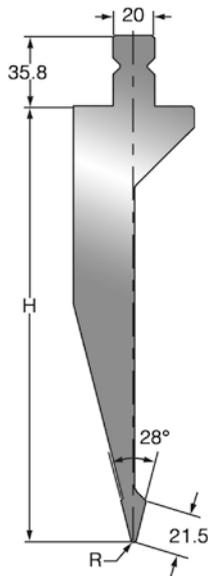


Schiavi Profile	SOW202
Trumpf Profile	OW202/K
Radius	R1
Angle	28°
Height	120
Max. Loading (Bending):	600 kN/m
Max. Loading (Flattening):	800 kN/m
Weight:	19.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

Dimensions in mm

Modified Punch Tip Radii				
R0.5	R1.6	R2	R2.3	Radius
28°	28°	28°	28°	Angle
119.8	117.2	116	115.1	Height



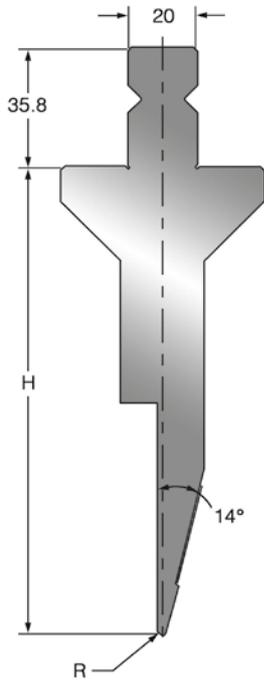
Schiavi Profile	SOW202S
Trumpf Profile	OW202/S
Radius	R1
Angle	28°
Height	220
Max. Loading (Bending):	600 kN/m
Max. Loading (Flattening):	800 kN/m
Weight:	49.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

Dimensions in mm

Modified Punch Tip Radii				
R0.5	R1.6	R2	R2.3	Radius
28°	28°	28°	28°	Angle
219.8	217.8	216	215.6	Height

PUNCHES POINTED WITH FLATTENED SPOT



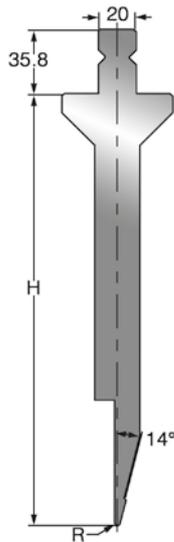
Schiavi Profile	SOW210
Trumpf Profile	OW210
Radius	R1
Angle	28°
Height	140
Max. Loading (Bending):	400 kN/m
Max. Loading (Flattening):	1300 kN/m
Weight:	28.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

Modified Punch Tip Radii	
R0.5	Radius
28°	Angle
139.8	Height

Dimensions in mm

PUNCHES POINTED WITH FLATTENING SPOT



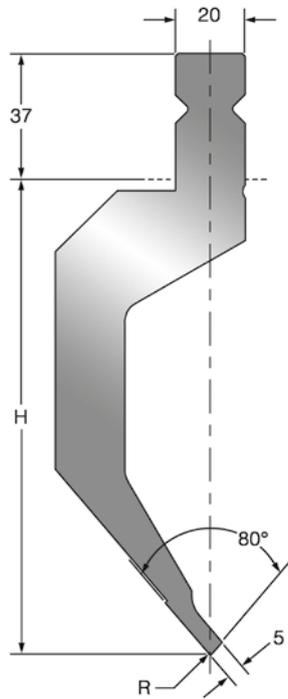
Schiavi Profile	SOW210S
Trumpf Profile	OW210/S
Radius	R1
Angle	28°
Height	240
Max. Loading (Bending):	400 kN/m
Max. Loading (Flattening):	1300 kN/m
Weight:	47.7 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

Modified Punch Tip Radii	
R0.5	Radius
28°	Angle
239.8	Height

Dimensions in mm

PUNCHES THIN TIP

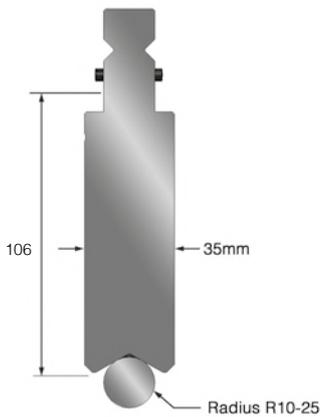


Schiavi Profile	SOW280
Trumpf Profile	OW280/K
Radius	R0.5
Angle	80°
Height	140
Maximum Loading:	400 kN/m
Weight:	30.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

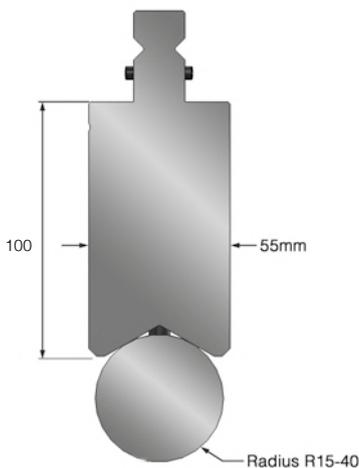
RADIUS PUNCHES

- Hardened Holders and Inserts
- Standard Radius Sizes up to 40mm
- Insert Holder made in 42CrMo4 hardened and ground
- Insert Radius made in C50 hardened and ground



Schiavi Profile	SOW308
Trumpf Profile	OW308/K
Radius	10-25
Height	106
Maximum Loading:	1300 kN/m
Weight:	33.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25



Schiavi Profile	SOW308S
Trumpf Profile	OW308/S
Radius	15-40
Height	100
Maximum Loading:	1500 kN/m
Weight:	46.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	250
Length 3050	550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	Horn right
Length 2050	Horn Left
Length 1250	100
Length 1050	50
	45
	40
	35
	30
	25

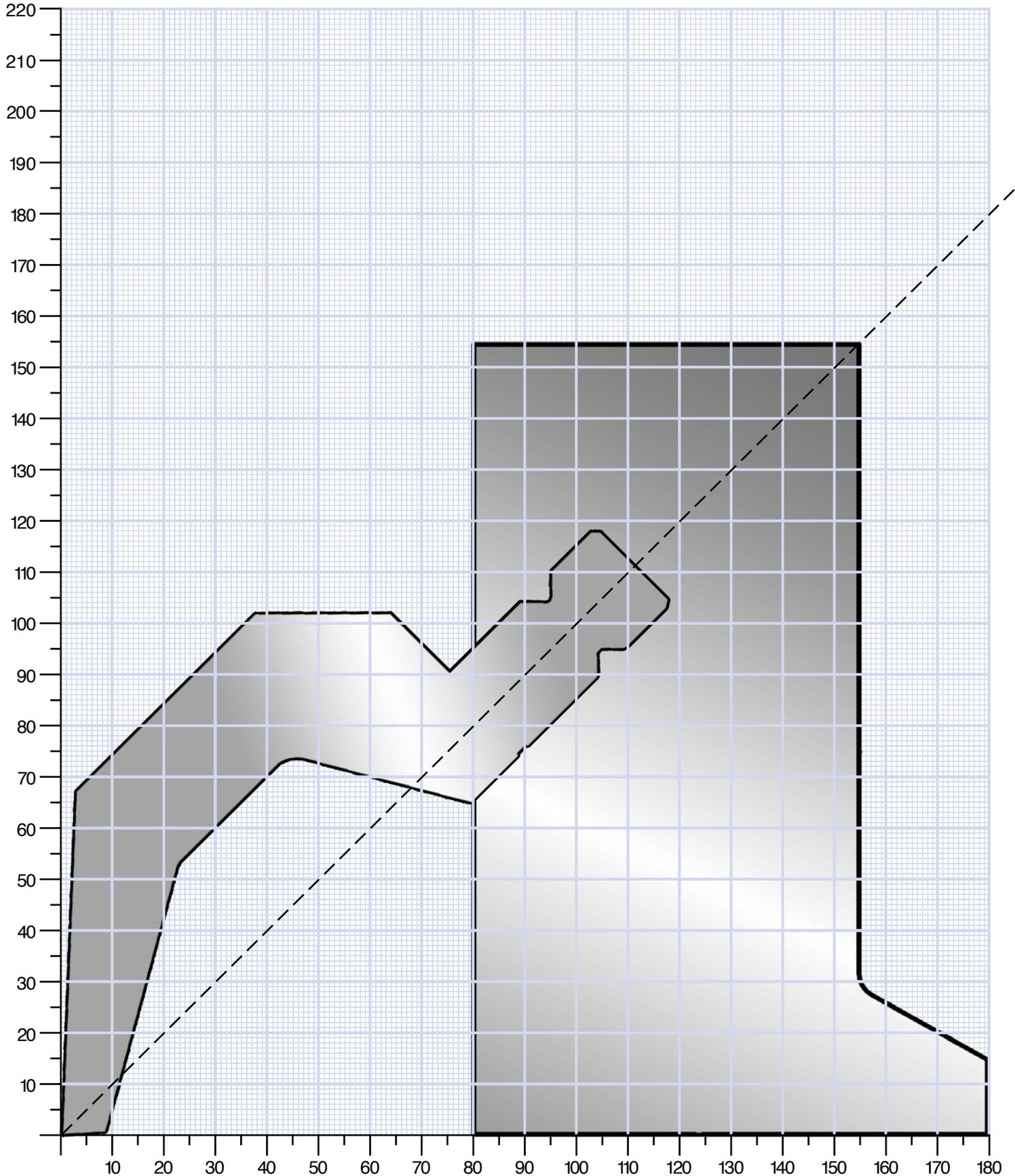
Standard Radius insert

10	15	20	25	30	35	40
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Other Radius inserts available on request

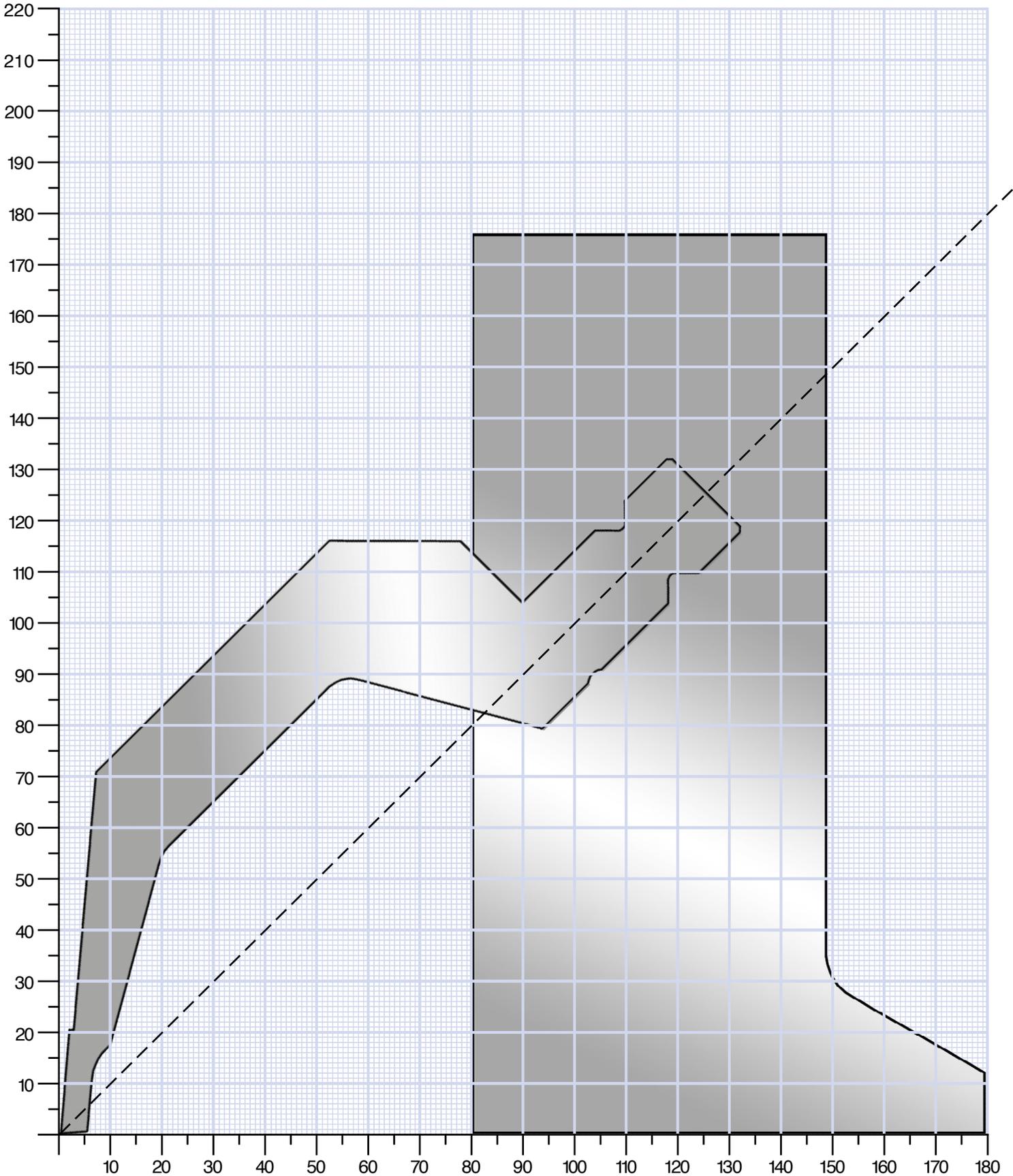
BEND LIMIT GRAPH

SOW200 Swan-Neck Punch



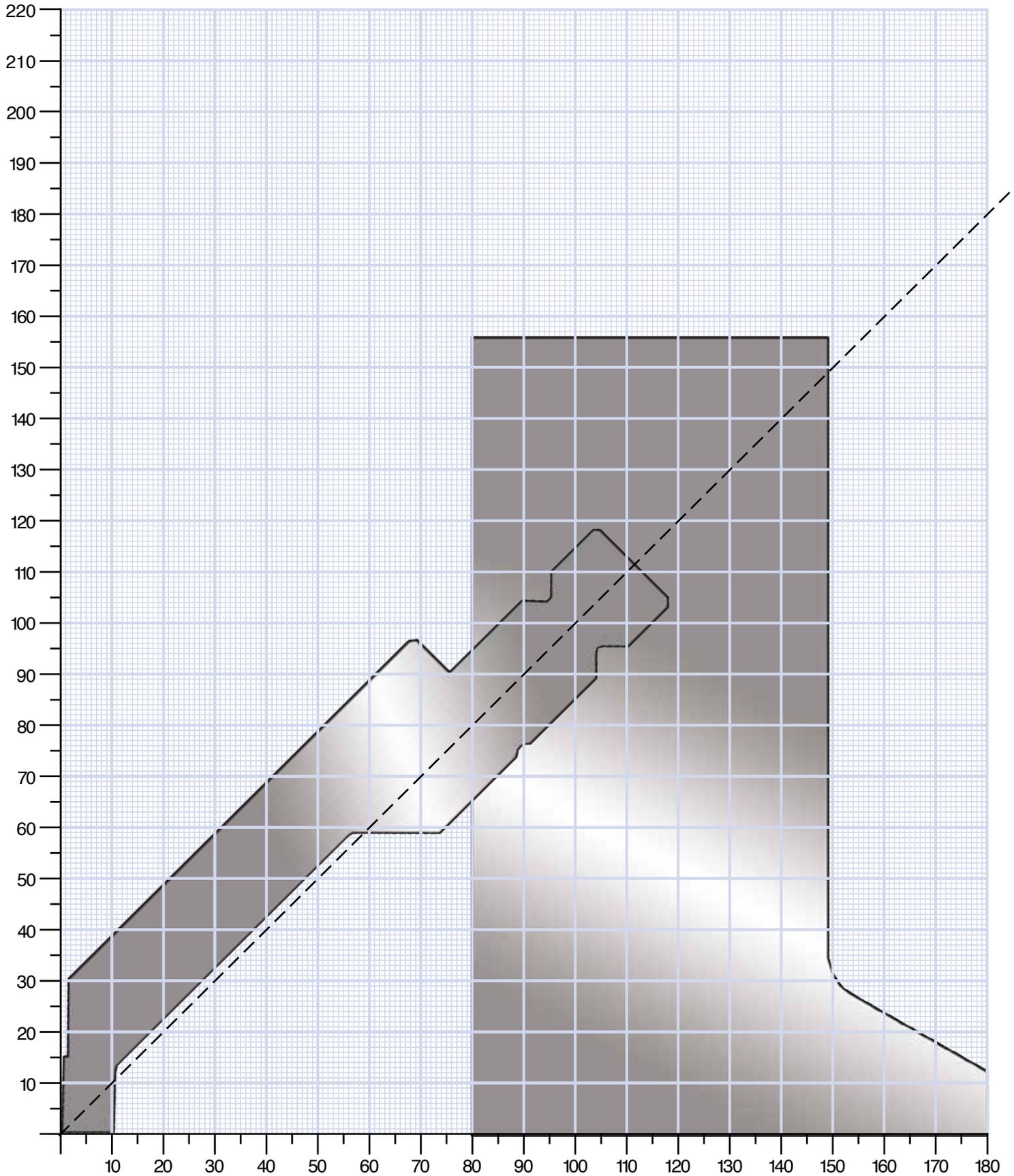
BEND LIMIT GRAPH

SOW280 Thin Tip Punch



BEND LIMIT GRAPH

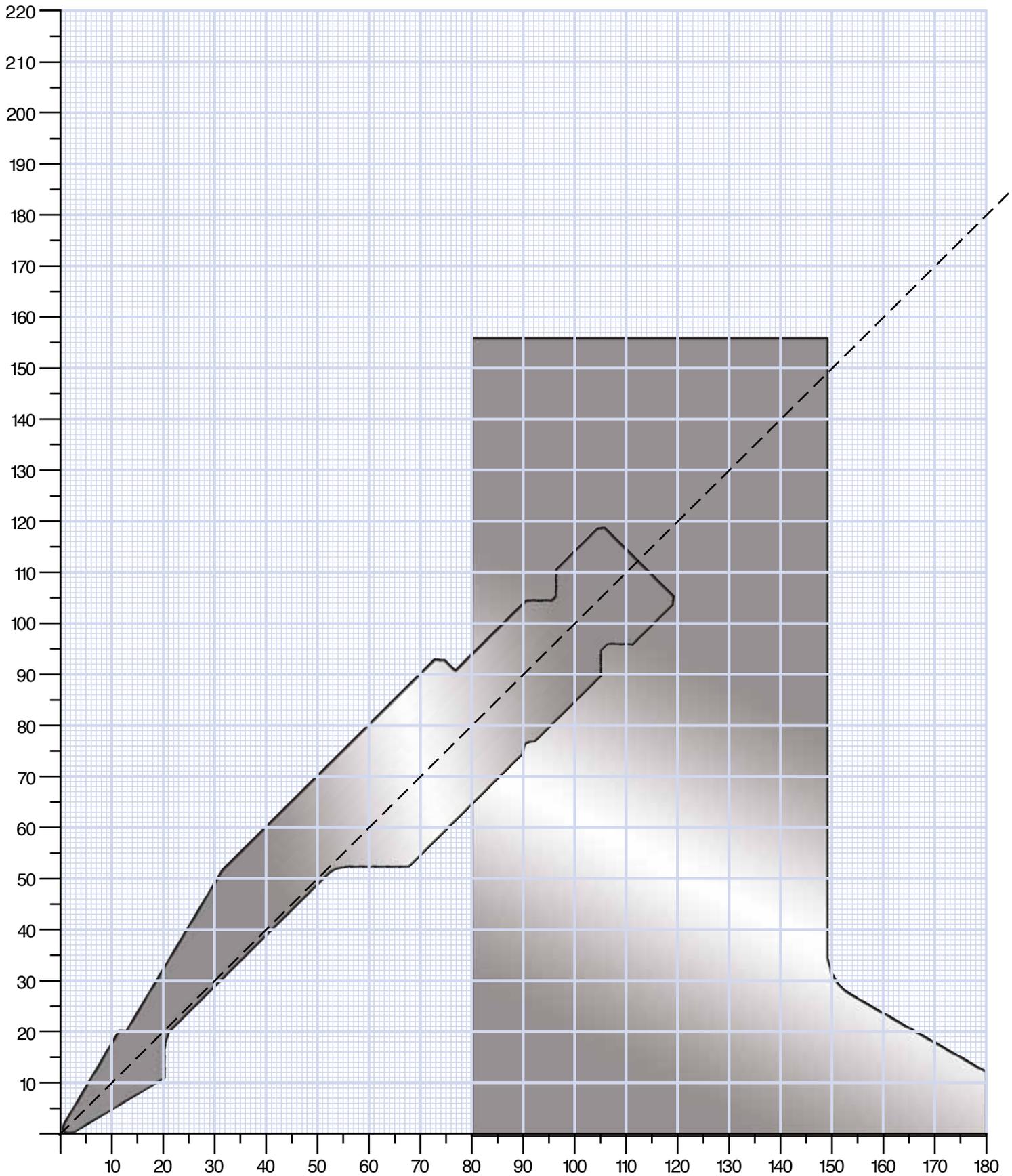
SOW201 Goose-Neck Punch



TRUMPF STYLE

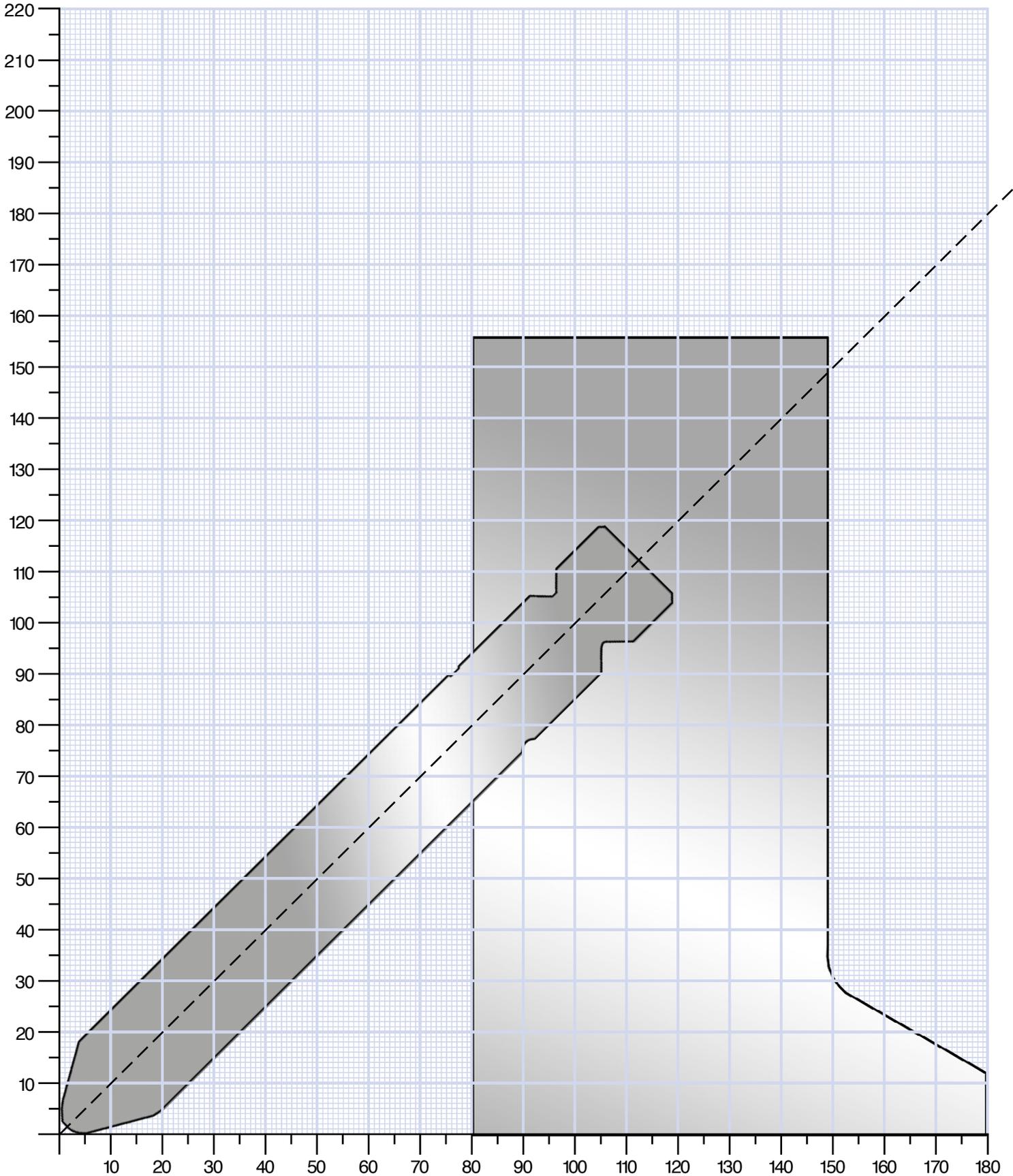
BEND LIMIT GRAPH

SOW202 Pointed with Recess Punch



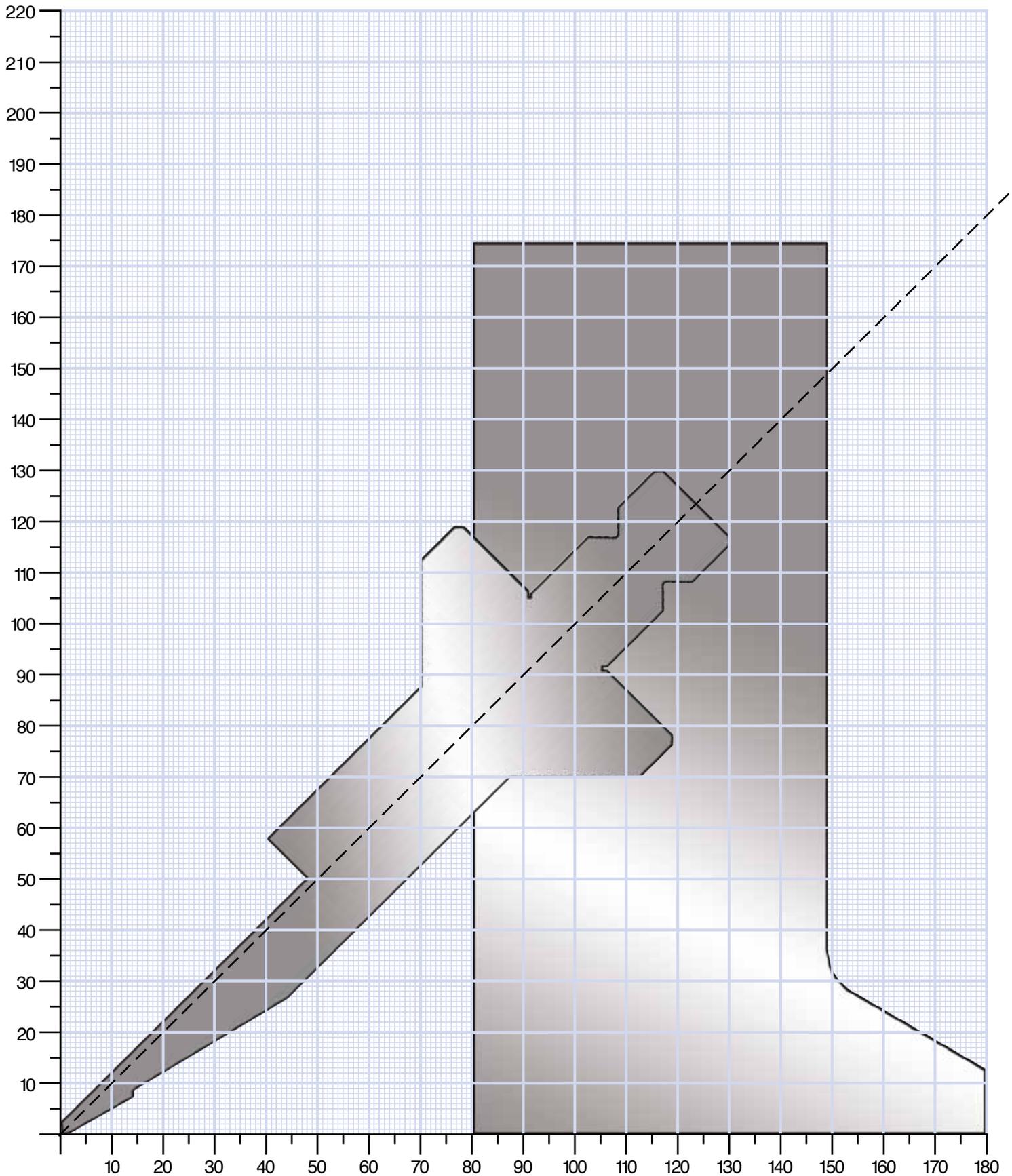
BEND LIMIT GRAPH

SOW203 Pointed/Bottoming Punch



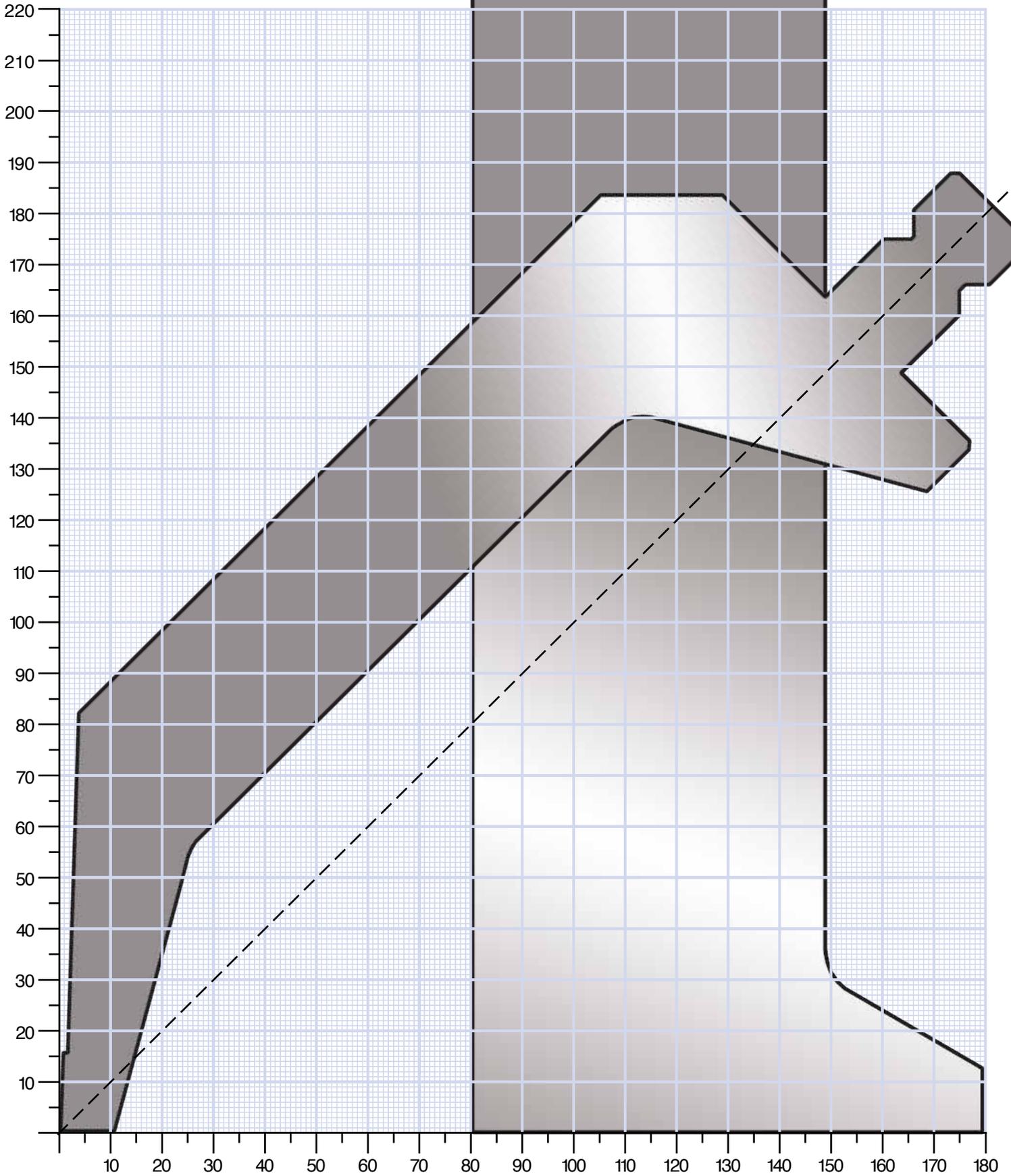
BEND LIMIT GRAPH

SOW210 Pointed with Flattened Spot Punch



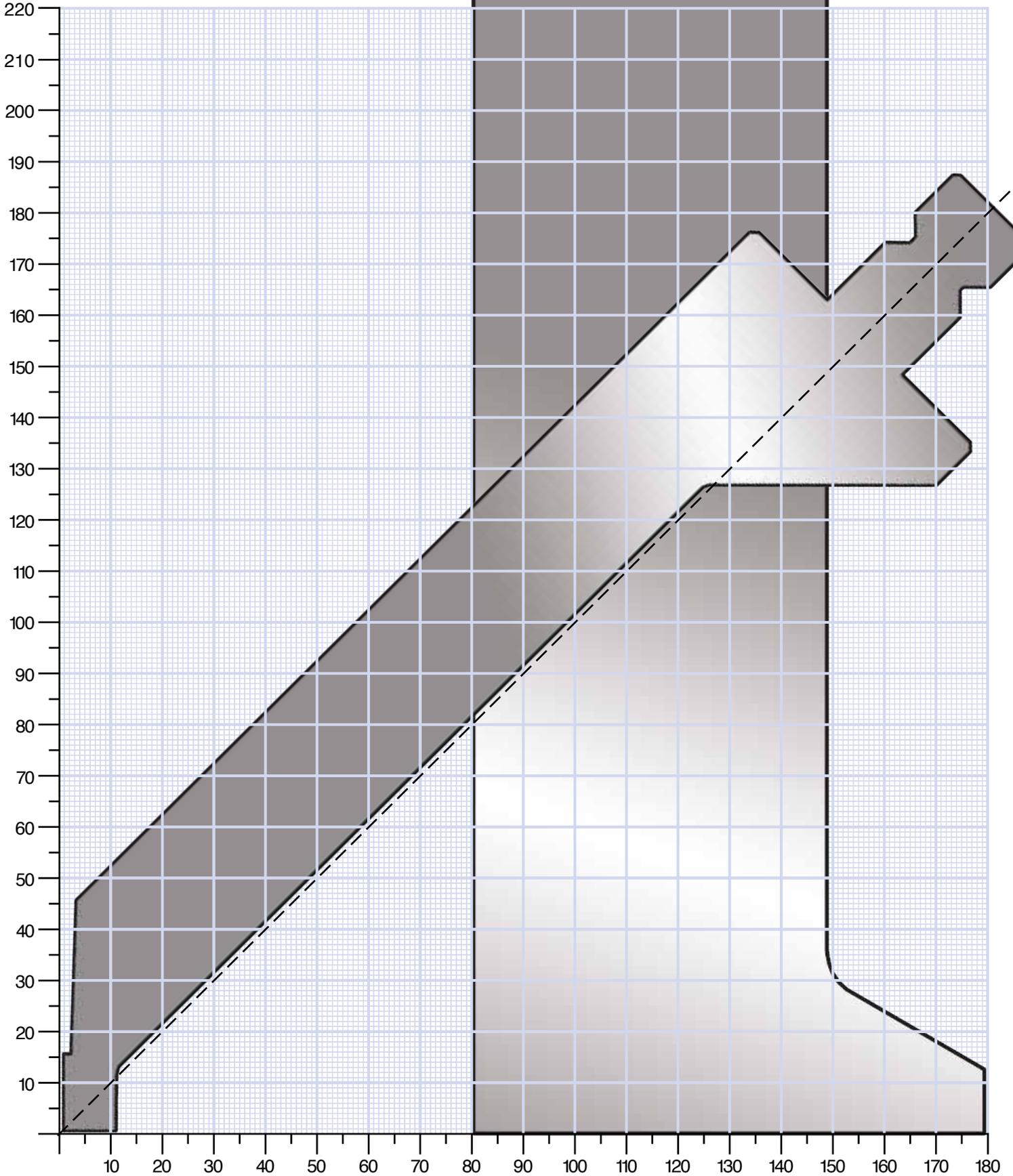
BEND LIMIT GRAPH

SOW200S Swan-Neck Punch



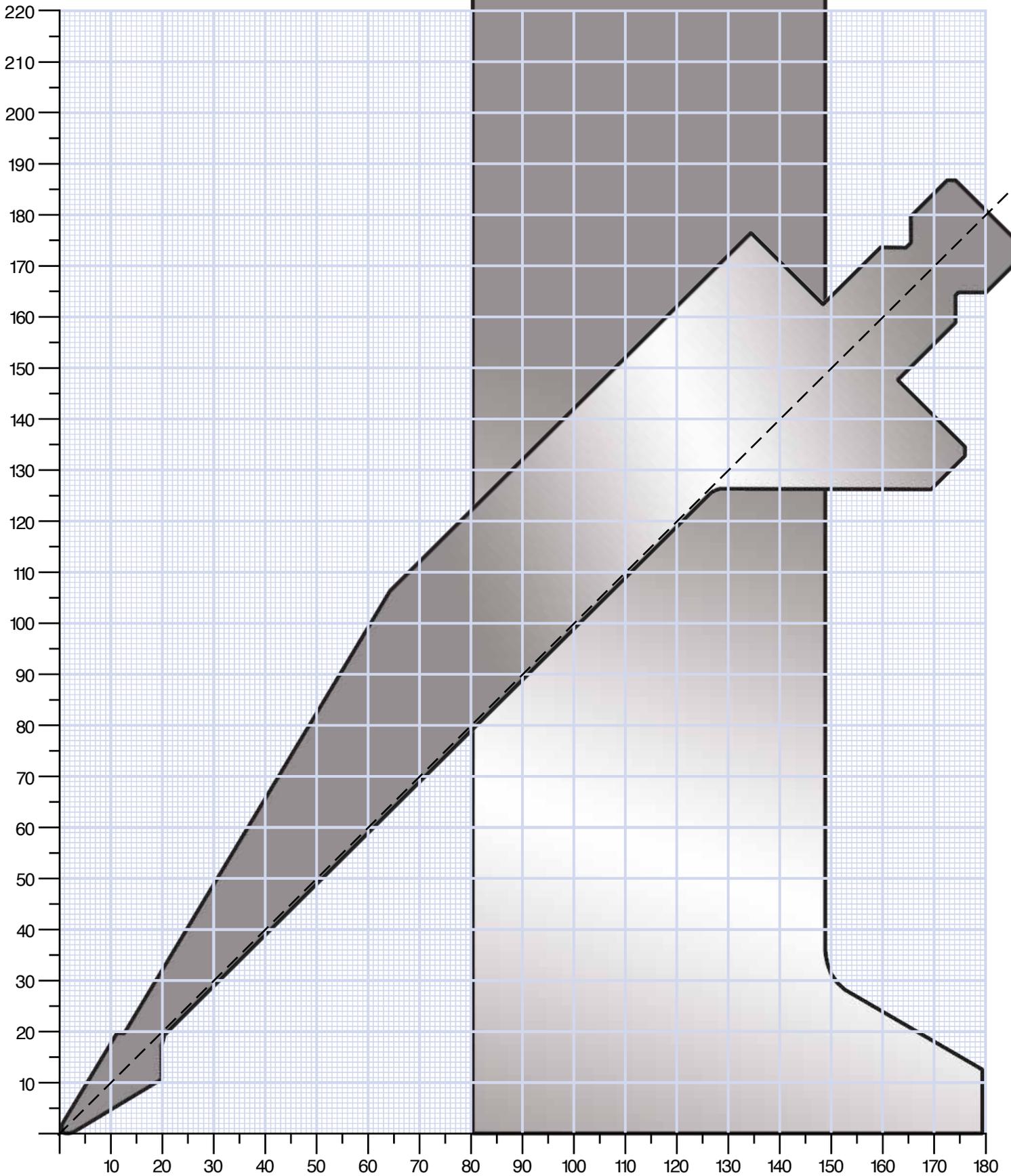
BEND LIMIT GRAPH

SOW201S Goose-Neck Punch



BEND LIMIT GRAPH

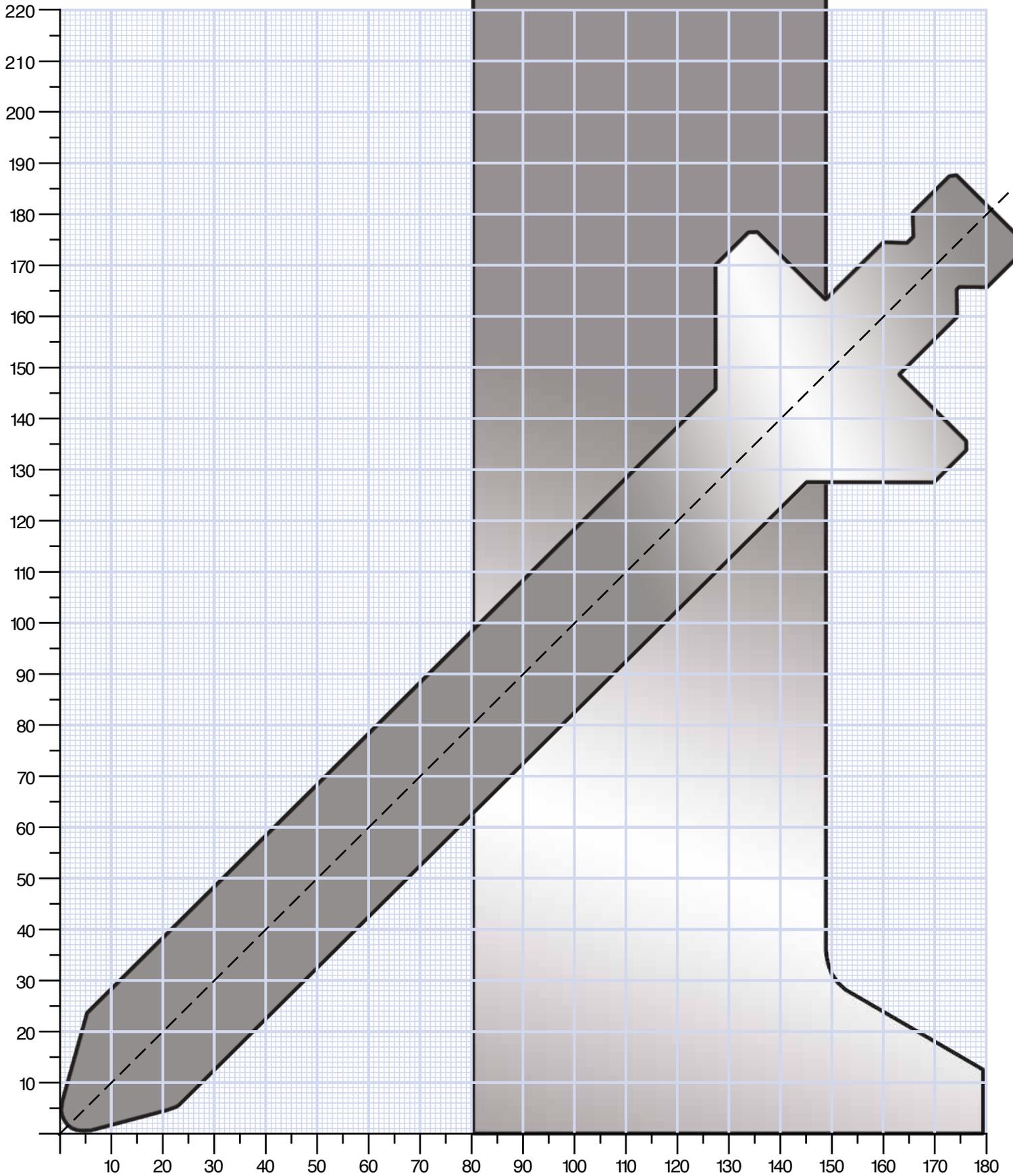
SOW202S Pointed with Recess Punch



TRUMPF STYLE

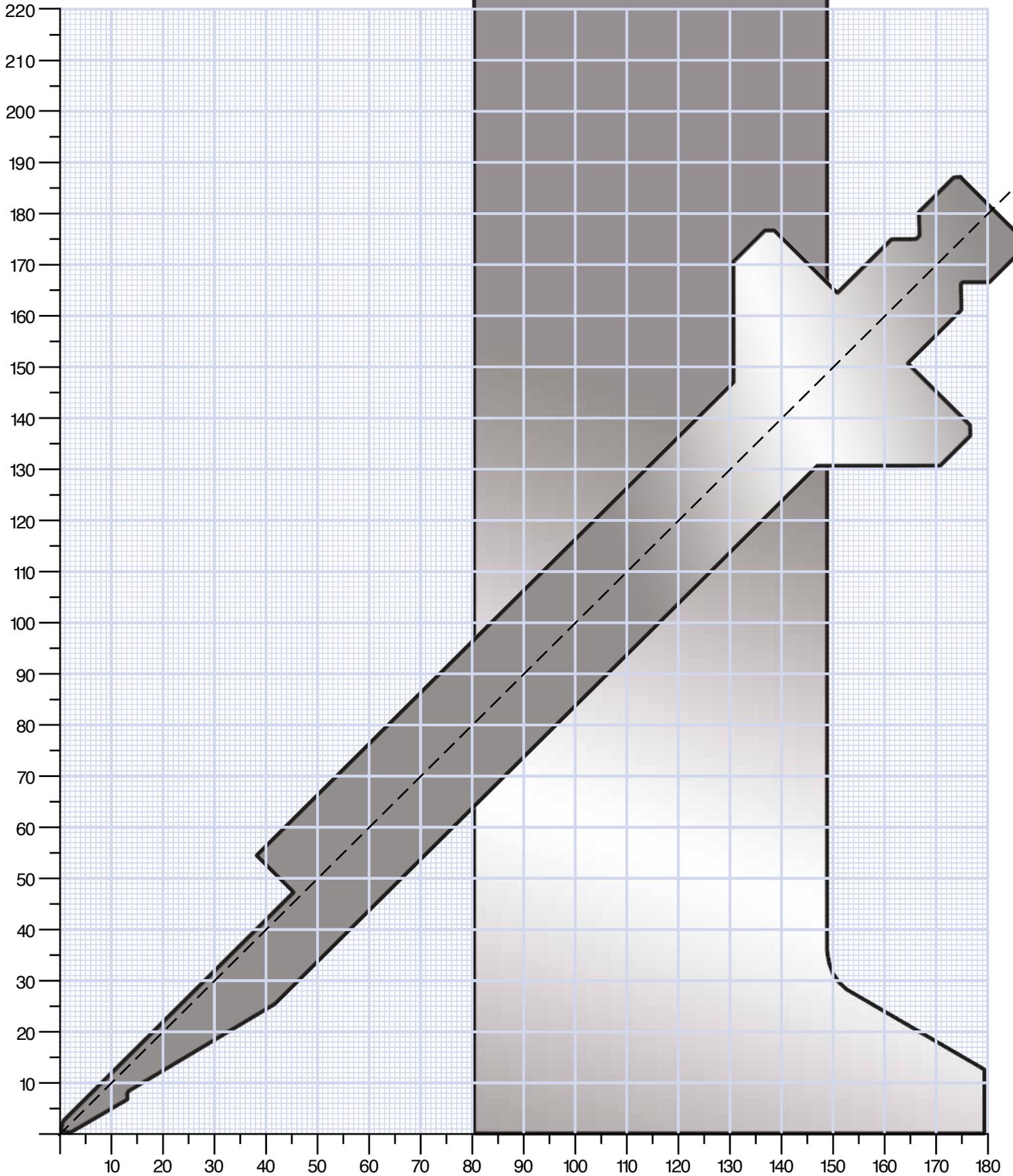
BEND LIMIT GRAPH

SOW203S Pointed/Bottoming Punch



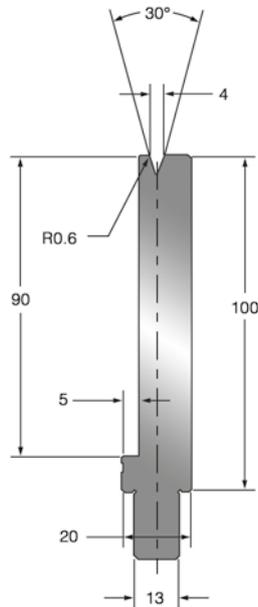
BEND LIMIT GRAPH

SOW210S Pointed with Flattened Spot Punch



TRUMPF STYLE

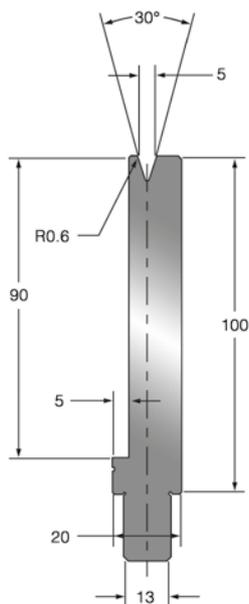
DIE V-OPENING 4MM&5MM



Bolt Holes Standard

Schiavi Profile	S04S.30°
Trumpf Cat. No.	EV/S-W4/30°
V-Opening	4
Angle	30°
Height	100
Maximum Loading:	150 kN/m
Weight:	14.0 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25



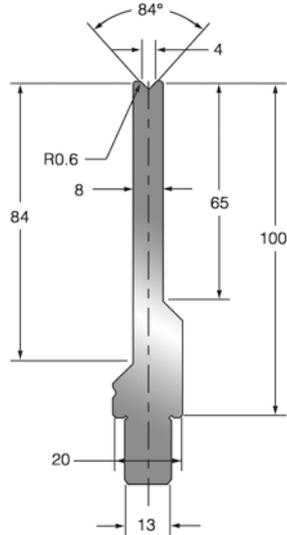
Bolt Holes Standard

Schiavi Profile	S05S.30°
Trumpf Cat. No.	EV/S-W5/30°
V-Opening	5
Angle	30°
Height	100
Maximum Loading:	150 kN/m
Weight:	13.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

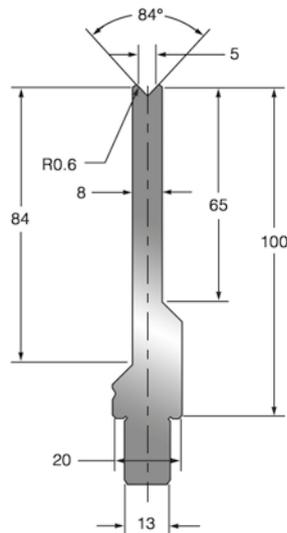
Dimensions in mm

DIE V-OPENING 4MM&5MM



Schiavi Profile	S04S.84°
Trumpf Cat. No.	EV/S-W4/84°
V-Opening	4
Angle	84°
Height	100
Maximum Loading:	250 kN/m
Weight:	10.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25



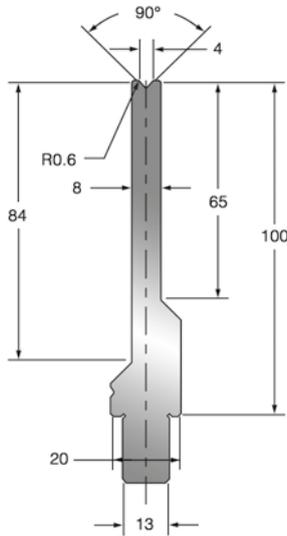
Schiavi Profile	S05S.84°
Trumpf Cat. No.	EV/S-W5/84°
V-Opening	5
Angle	84°
Height	100
Maximum Loading:	250 kN/m
Weight:	10.2 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Dimensions in mm

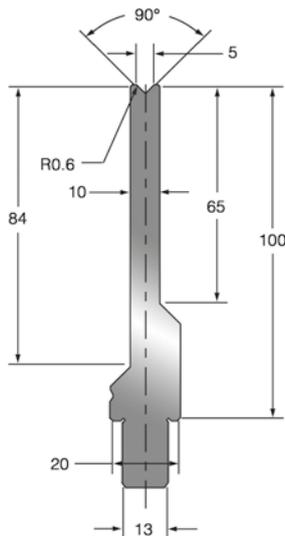
TRUMPF STYLE

DIE V-OPENING 4MM&5MM



Schiavi Profile	S04S.90°
Trumpf Cat. No.	EV/S-W4/90°
V-Opening	4
Angle	90°
Height	100
Maximum Loading:	250 kN/m
Weight:	10.8 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

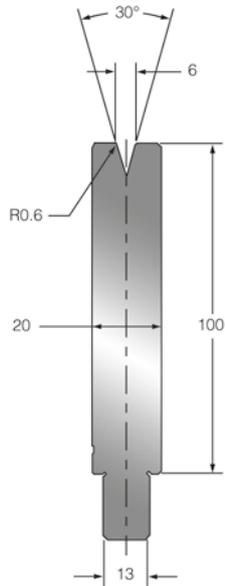


Schiavi Profile	S05S.90°
Trumpf Cat. No.	EV/S-W5/90°
V-Opening	5
Angle	90°
Height	100
Maximum Loading:	390 kN/m
Weight:	11.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Dimensions in mm

DIE V-OPENING 6MM

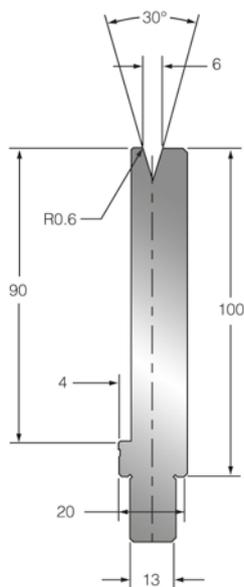


Schiavi Profile	S06.30°
Trumpf Cat. No.	EV001 30°
V-Opening	6
Angle	30°
Height	100
Maximum Loading:	400 kN/m
Weight:	17.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S06.30° also available with H=150

Bolt Holes Standard



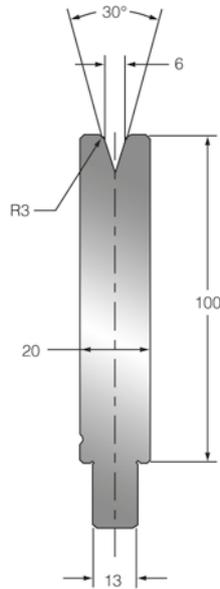
Schiavi Profile	S06S.30°
Trumpf Cat. No.	EV001/S 30°
V-Opening	6
Angle	30°
Height	100
Maximum Loading:	170 kN/m
Weight:	14.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Bolt Holes Standard

Dimensions in mm

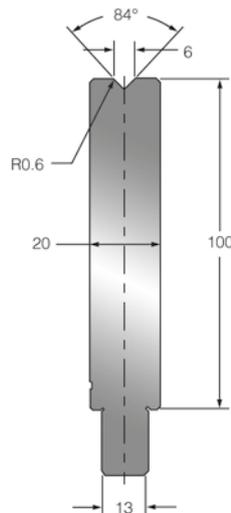
DIE V-OPENING 6MM



Schiavi Profile	S06.30° R3
Trumpf Cat. No.	EV001 R3 30°
V-Opening	6
Angle	30°
Height	100
Maximum Loading:	400 kN/m
Weight:	17.2 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Bolt Holes Standard



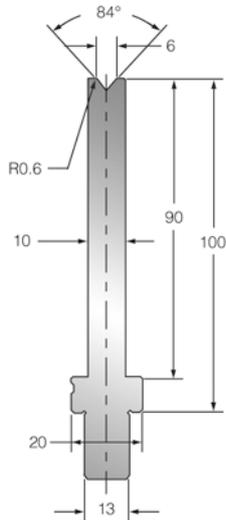
Schiavi Profile	S06.84°
Trumpf Cat. No.	EV W6 84°
V-Opening	6
Angle	84°
Height	100
Maximum Loading:	400 kN/m
Weight:	17.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S06.84° also available with H=150

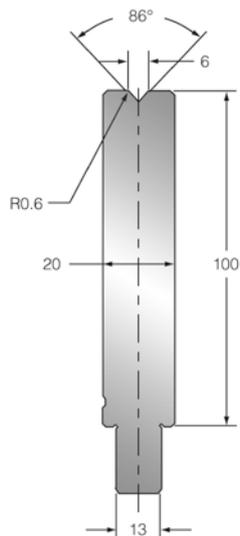
Dimensions in mm

DIE V-OPENING 6MM



Schiavi Profile	S06S.84°
Trumpf Cat. No.	EV/S W6 84°
V-Opening	6
Angle	84°
Height	100
Maximum Loading:	250 kN/m
Weight:	10.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

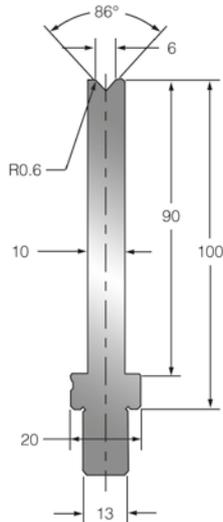


Schiavi Profile	S06.86°
Trumpf Cat. No.	EV020 86°
V-Opening	6
Angle	86°
Height	100
Maximum Loading:	400 kN/m
Weight:	17.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

DIE V-OPENING 6MM

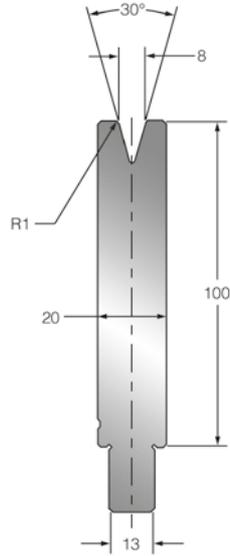


Schiavi Profile	S06S.86°
Trumpf Cat. No.	EV020/S 86°
V-Opening	6
Angle	86°
Height	100
Maximum Loading:	240 kN/m
Weight:	10.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

DIE V-OPENING 8MM

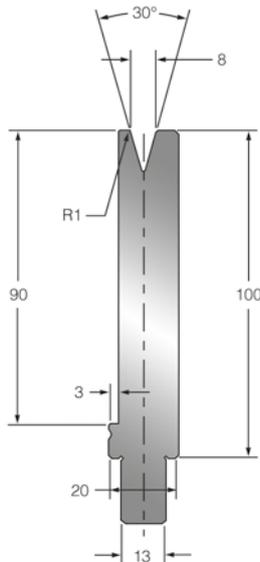


Schiavi Profile	S08.30°
Trumpf Cat. No.	EV002 30°
V-Opening	8
Angle	30°
Height	100
Maximum Loading:	400 kN/m
Weight:	17.1 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S08.30° also available with H=150

Bolt Holes Standard



Schiavi Profile	T08S.30°
Trumpf Cat. No.	EV002/S 30°
V-Opening	8
Angle	30°
Height	100
Maximum Loading:	200 kN/m
Weight:	15.1 kg/m

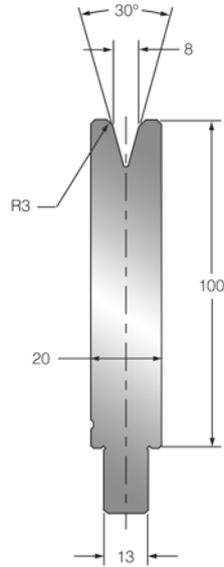
Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Bolt Holes Standard

Dimensions in mm

TRUMPF STYLE

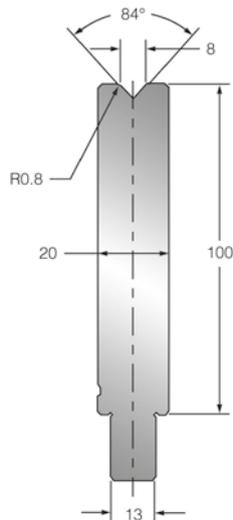
DIE V-OPENING 8MM



Schiavi Profile	S08.30° R3
Trumpf Cat. No.	EV002 R3 30°
V-Opening	8
Angle	30°
Height	100
Maximum Loading:	400 kN/m
Weight:	17.0 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Bolt Holes Standard



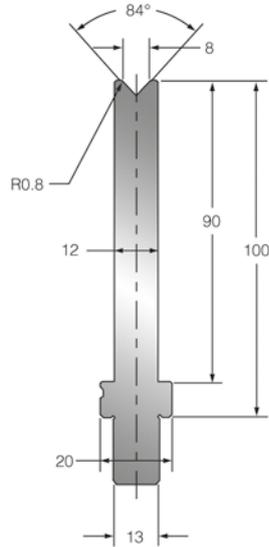
Schiavi Profile	S08.84°
Trumpf Cat. No.	EV W8/84°
V-Opening	8
Angle	84°
Height	100
Maximum Loading:	400 kN/m
Weight:	17.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S08.84° also available with H=150

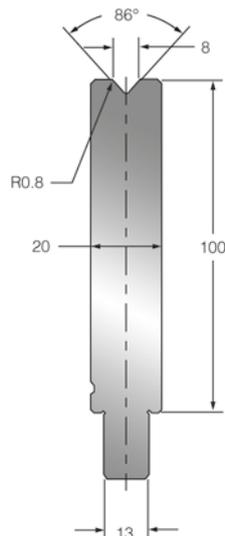
Dimensions in mm

DIE V-OPENING 8MM



Schiavi Profile	S08S.84°
Trumpf Cat. No.	EV/S W8/84°
V-Opening	8
Angle	84°
Height	100
Maximum Loading:	350 kN/m
Weight:	11.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

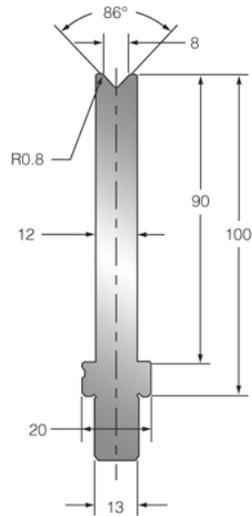


Schiavi Profile	S08.86°
Trumpf Cat. No.	EV021 86°
V-Opening	8
Angle	86°
Height	100
Maximum Loading:	400 kN/m
Weight:	17.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

DIE V-OPENING 8MM

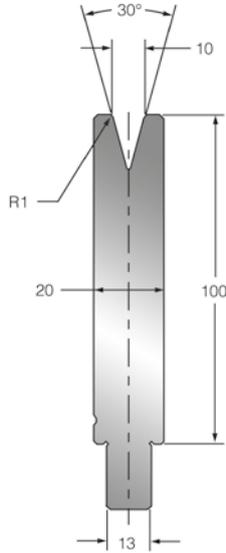


Schiavi Profile	S08S.86°
Trumpf Cat. No.	EV021/S 86°
V-Opening	8
Angle	86°
Height	100
Maximum Loading:	310 kN/m
Weight:	11.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

DIE V-OPENING 10MM

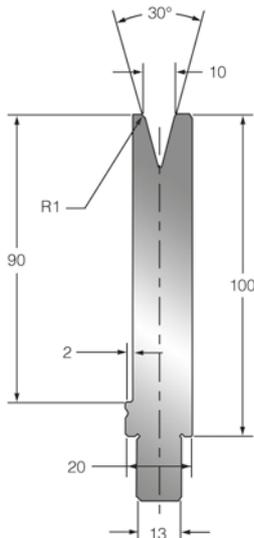


Schiavi Profile	S10.30°
Trumpf Cat. No.	EV003 30°
V-Opening	10
Angle	30°
Height	100
Maximum Loading:	400 kN/m
Weight:	16.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. T10.30° also available with H=150

Bolt Holes Standard



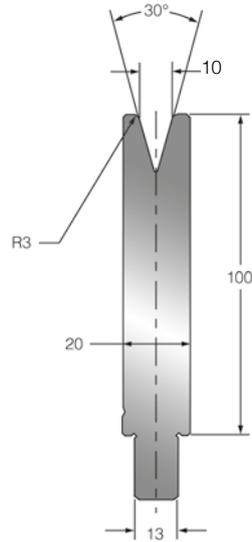
Schiavi Profile	S10S.30°
Trumpf Cat. No.	EV003/S 30°
V-Opening	10
Angle	30°
Height	100
Maximum Loading:	200 kN/m
Weight:	15.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Bolt Holes Standard

Dimensions in mm

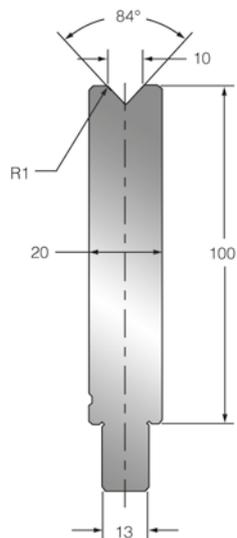
DIE V-OPENING 10MM



Bolt Holes Standard

Schiavi Profile	S10.30° R3
Trumpf Cat. No.	EV003 R3 30°
V-Opening	10
Angle	30°
Height	100
Maximum Loading:	400 kN/m
Weight:	16.7 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25



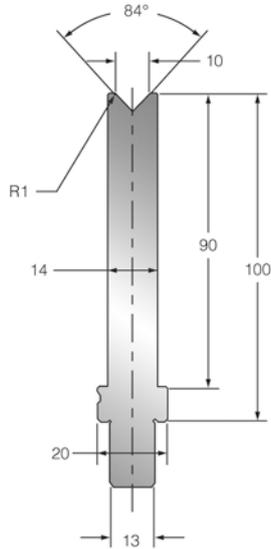
Schiavi Profile	S10.84°
Trumpf Cat. No.	EV W10/84°
V-Opening	10
Angle	84°
Height	100
Maximum Loading:	500 kN/m
Weight:	17.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S10.84° also available with H=150

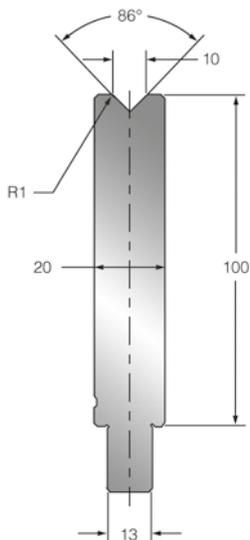
Dimensions in mm

DIE V-OPENING 10MM



Schiavi Profile	S10S.84°
Trumpf Cat. No.	EV/S W10/84°
V-Opening	10
Angle	84°
Height	100
Maximum Loading:	400 kN/m
Weight:	13.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25



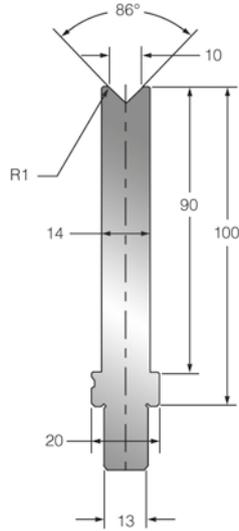
Schiavi Profile	S10.86°
Trumpf Cat. No.	EV022 86°
V-Opening	10
Angle	86°
Height	100
Maximum Loading:	500 kN/m
Weight:	17.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Mod. S10.86° also available with H=150

Dimensions in mm

DIE V-OPENING 10MM

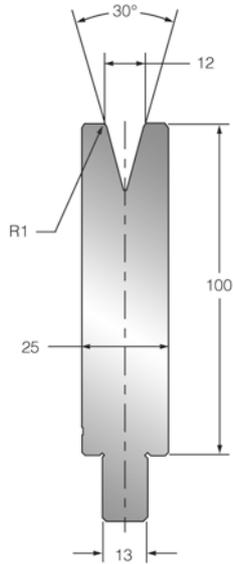


Schiavi Profile	S10S.86°
Trumpf Cat. No.	EV022/S 86°
V-Opening	10
Angle	86°
Height	100
Maximum Loading:	380 kN/m
Weight:	13.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

DIE V-OPENING 12MM

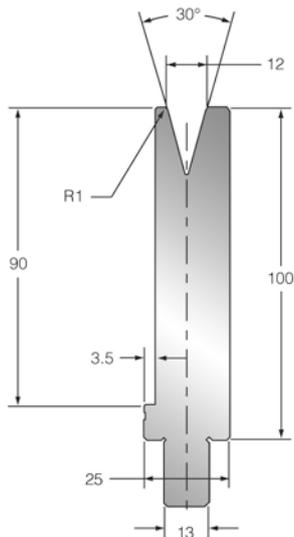


Schiavi Profile	S12.30°
Trumpf Cat. No.	EV004 30°
V-Opening	12
Angle	30°
Height	100
Maximum Loading:	400 kN/m
Weight:	20.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. T12.30° also available with H=150

Bolt Holes Standard



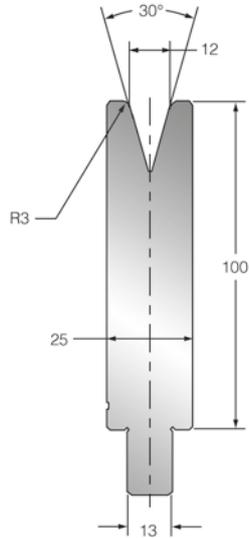
Schiavi Profile	S12S.30°
Trumpf Cat. No.	EV004/S 30°
V-Opening	12
Angle	30°
Height	100
Maximum Loading:	250 kN/m
Weight:	18.0 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Bolt Holes Standard

Dimensions in mm

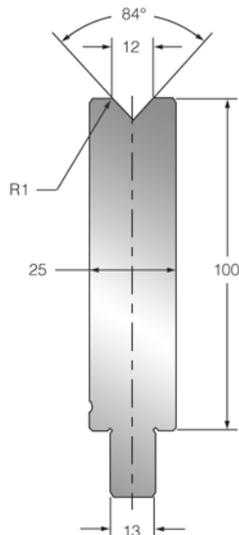
DIE V-OPENING 12MM



Schiavi Profile	S12.30° R3
Trumpf Cat. No.	EV004 R3 30°
V-Opening	12
Angle	30°
Height	100
Maximum Loading:	400 kN/m
Weight:	20.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Bolt Holes Standard



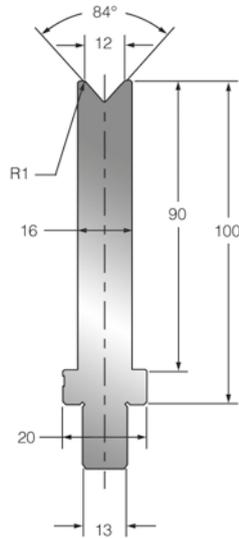
Schiavi Profile	S12.84°
Trumpf Cat. No.	EV W12/84°
V-Opening	12
Angle	84°
Height	100
Maximum Loading:	500 kN/m
Weight:	21.4 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S12.84° also available with H=150

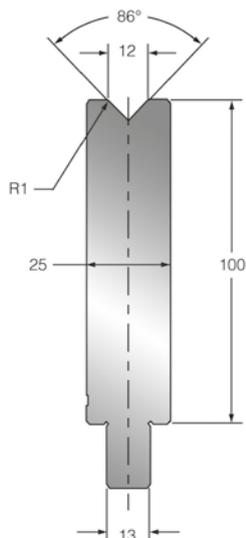
Dimensions in mm

DIE V-OPENING 12MM



Schiavi Profile	S12S.84°
Trumpf Cat. No.	EV/S W12/84°
V-Opening	12
Angle	84°
Height	100
Maximum Loading:	400 kN/m
Weight:	14.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

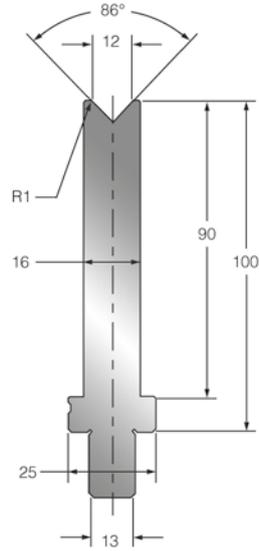


Schiavi Profile	S12.86°
Trumpf Cat. No.	EV023 86°
V-Opening	12
Angle	86°
Height	100
Maximum Loading:	500 kN/m
Weight:	21.4 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

DIE V-OPENING 12MM

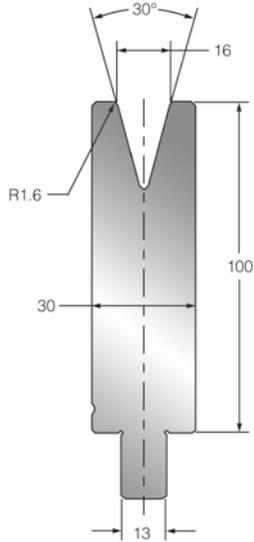


Schiavi Profile	S12S.86°
Trumpf Cat. No.	EV023/S 86°
V-Opening	12
Angle	86°
Height	100
Maximum Loading:	400 kN/m
Weight:	14.9 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

DIE V-OPENING 16MM

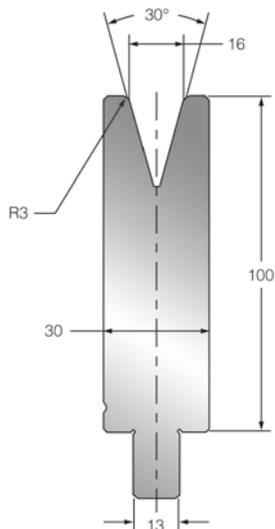


Schiavi Profile	S16.30°
Trumpf Cat. No.	EV005 30°
V-Opening	16
Angle	30°
Height	100
Maximum Loading:	500 kN/m
Weight:	23.4 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S16.30° also available with H=150

Bolt Holes Standard



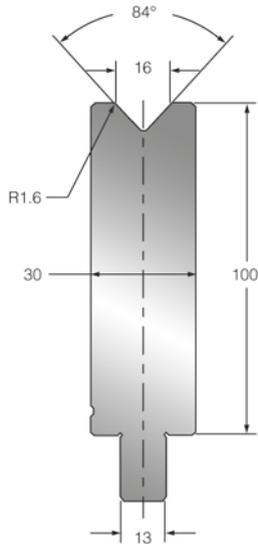
Schiavi Profile	S16.30° R3
Trumpf Cat. No.	EV005 R3 30°
V-Opening	16
Angle	30°
Height	100
Maximum Loading:	500 kN/m
Weight:	23.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Bolt Holes Standard

Dimensions in mm

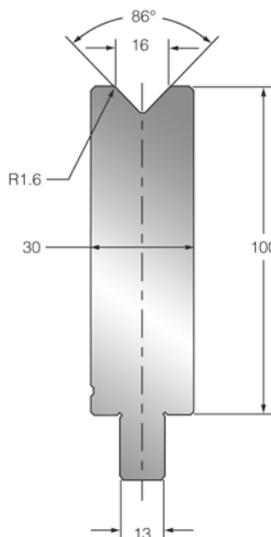
DIE V-OPENING 16MM



Schiavi Profile	S16.84°
Trumpf Cat. No.	EV W16/84°
V-Opening	16
Angle	84°
Height	100
Maximum Loading:	700 kN/m
Weight:	25.0 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S16.84° also available with H=150

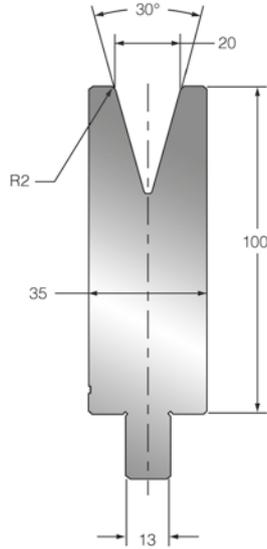


Schiavi Profile	S16.86°
Trumpf Cat. No.	EV024 86°
V-Opening	16
Angle	86°
Height	100
Maximum Loading:	700 kN/m
Weight:	25.0 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

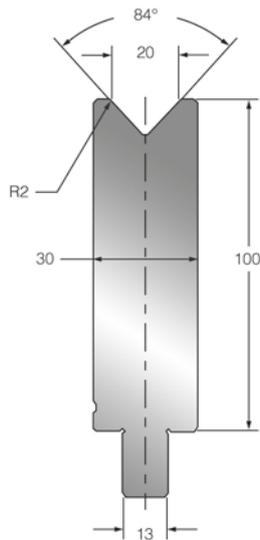
DIE V-OPENING 20MM



Schiavi Profile	S20.30°
Trumpf Cat. No.	EV006 30°
V-Opening	20
Angle	30°
Height	100
Maximum Loading:	600 kN/m
Weight:	26.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S20.30° also available with H=150



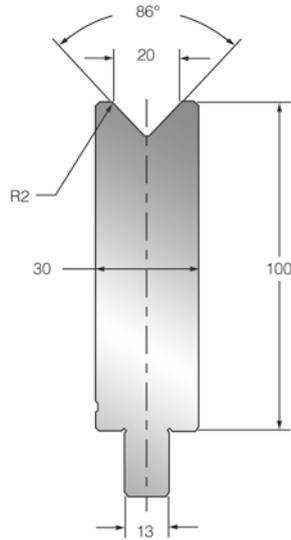
Schiavi Profile	S20.84°
Trumpf Cat. No.	EV W20/84°
V-Opening	20
Angle	84°
Height	100
Maximum Loading:	700 kN/m
Weight:	24.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	500
	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S20.84° also available with H=150

Dimensions in mm

DIE V-OPENING 20MM



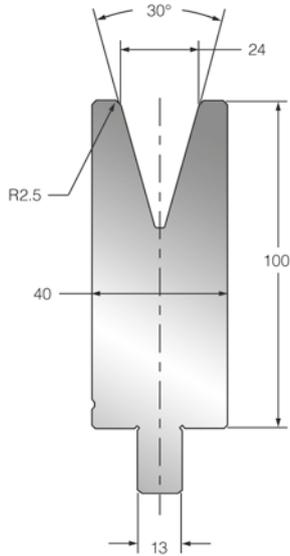
Schiavi Profile	S20.86°
Trumpf Cat. No.	EV025 86°
V-Opening	20
Angle	86°
Height	100
Maximum Loading:	700 kN/m
Weight:	24.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S20.86° also available with H=150

Dimensions in mm

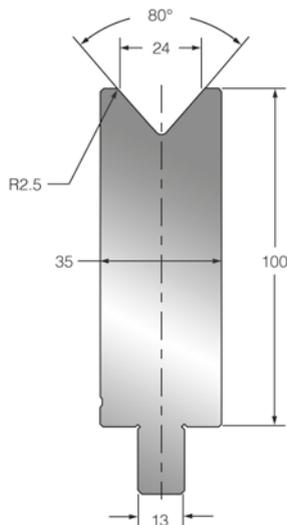
DIE V-OPENING 24MM



Schiavi Profile	S24.30°
Trumpf Cat. No.	EV007 30°
V-Opening	24
Angle	30°
Height	100
Maximum Loading:	650 kN/m
Weight:	29.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S24.30° also available with H=150



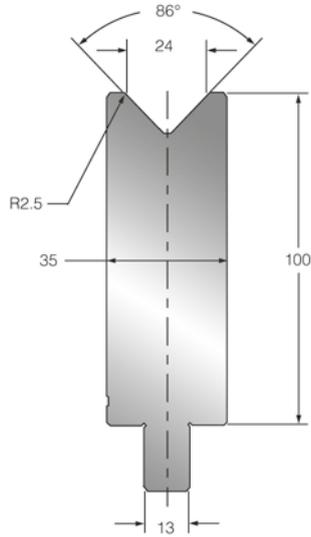
Schiavi Profile	S24.80°
Trumpf Cat. No.	EV W24/80°
V-Opening	24
Angle	80°
Height	100
Maximum Loading:	700 kN/m
Weight:	28.1 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S24.80° also available with H=150

Dimensions in mm

DIE V-OPENING 24MM

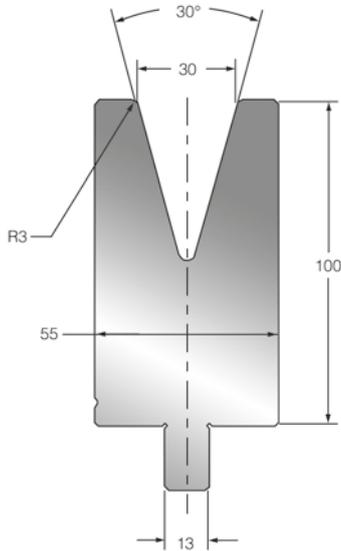


Schiavi Profile	S24.86°
Trumpf Cat. No.	EV026 86°
V-Opening	24
Angle	86°
Height	100
Maximum Loading:	700 kN/m
Weight:	28.2 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

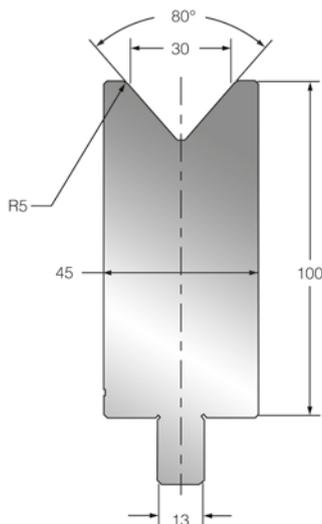
Dimensions in mm

DIE V-OPENING 30MM



Schiavi Profile	S30.30°
Trumpf Cat. No.	EV W30/30°
V-Opening	30
Angle	30°
Height	100
Maximum Loading:	900 kN/m
Weight:	37.8 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25



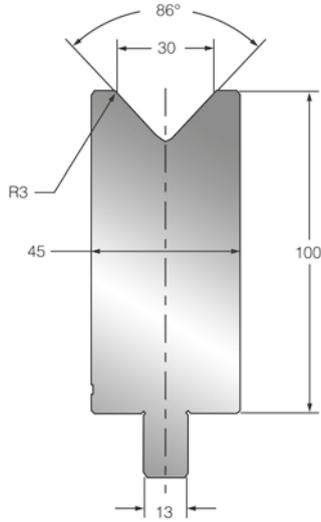
Schiavi Profile	S30.80°
Trumpf Cat. No.	EV W30/80°
V-Opening	30
Angle	80°
Height	100
Maximum Loading:	900 kN/m
Weight:	34.8 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S30.80° also available with H=150

Dimensions in mm

DIE V-OPENING 30MM

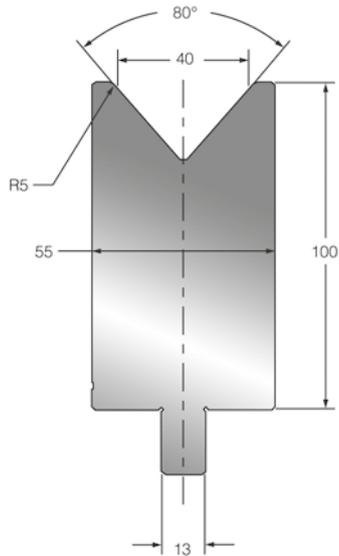


Schiavi Profile	S30.86°
Trumpf Cat. No.	EV027 86°
V-Opening	30
Angle	86°
Height	100
Maximum Loading:	750 kN/m
Weight:	34.7 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Dimensions in mm

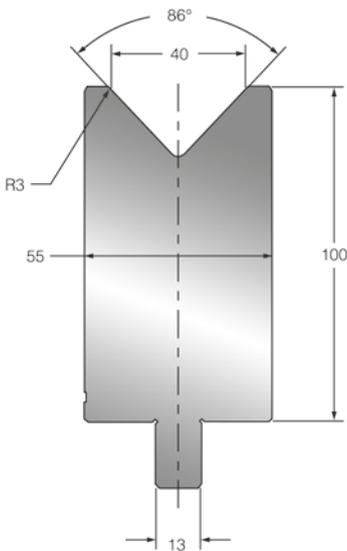
DIE V-OPENING 40MM



Schiavi Profile	S40.80°
Trumpf Cat. No.	EV W40/80°
V-Opening	40
Angle	80°
Height	100
Maximum Loading:	1200 kN/m
Weight:	40.8 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S40.80° also available with H=150



Schiavi Profile	S40.86°
Trumpf Cat. No.	EV028 86°
V-Opening	40
Angle	86°
Height	100
Maximum Loading:	1200 kN/m
Weight:	41.6 kg/m

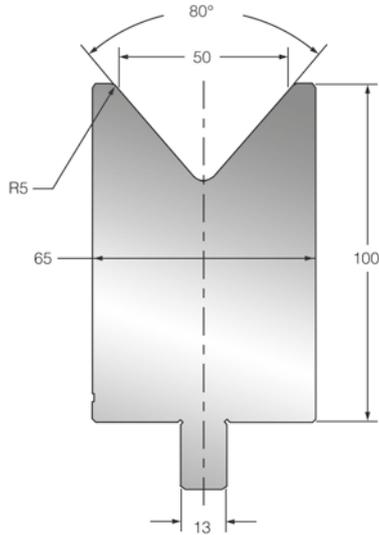
Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

Mod. S30.80° also available with H=150

Dimensions in mm

TRUMPF STYLE

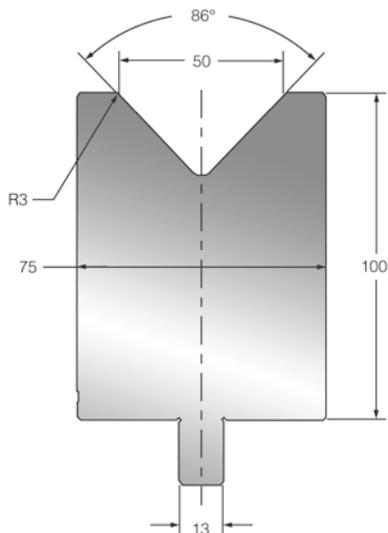
DIE V-OPENING 50MM



Schiavi Profile	S50.80°
Trumpf Cat. No.	EV W50/80°
V-Opening	50
Angle	80°
Height	100
Maximum Loading:	1500 kN/m
Weight:	46.4 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Mod. S50.80° also available with H=150

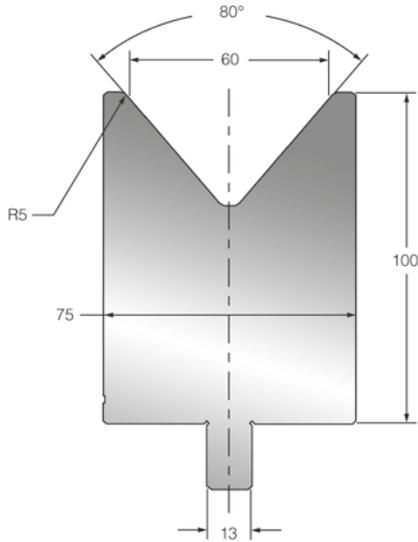


Schiavi Profile	S50.86°
Trumpf Cat. No.	EV029 86°
V-Opening	50
Angle	86°
Height	100
Maximum Loading:	1500 kN/m
Weight:	55.4 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
	40
	35
	30
	25

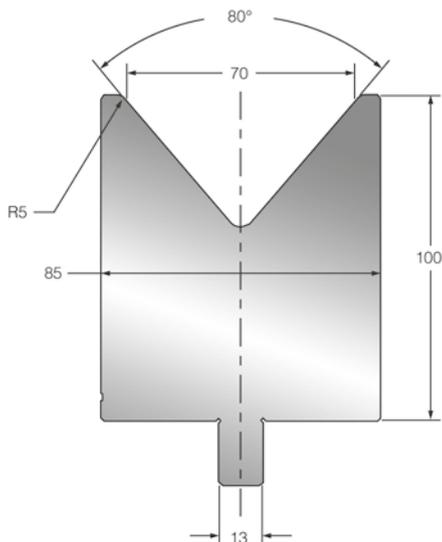
Dimensions in mm

DIE V-OPENING 60&70MM



Schiavi Profile	S60.80°
Trumpf Cat. No.	EV W60/80°
V-Opening	60
Angle	80°
Height	100
Maximum Loading:	1500 kN/m
Weight:	51.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	300
Length 1050	200
Version A	100
Description	50
Length 2050	45
Length 1250	40
Length 1050	35
	30
	25



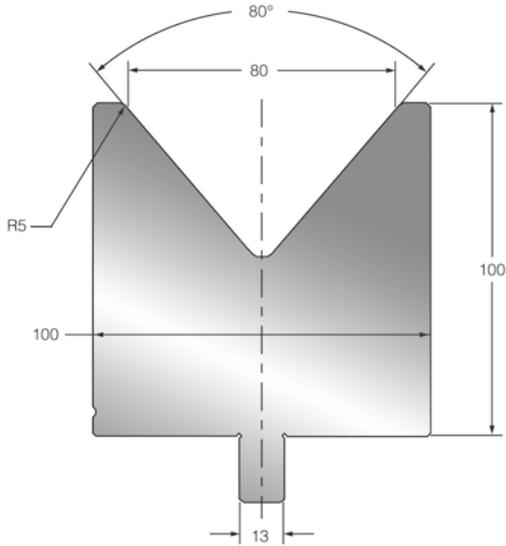
Schiavi Profile	S70.80°
Trumpf Cat. No.	EV W70/80°
V-Opening	70
Angle	80°
Height	100
Maximum Loading:	1500 kN/m
Weight:	56.2 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	300
Length 1050	200
Version A	100
Description	50
Length 2050	45
Length 1250	40
Length 1050	35
	30
	25

Dimensions in mm

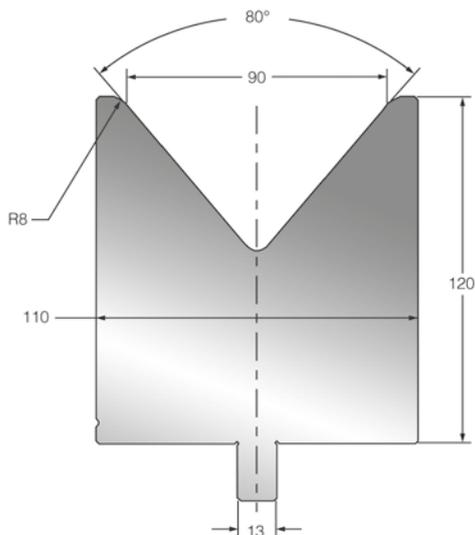
TRUMPF STYLE

DIE V-OPENING 80&90MM



Schiavi Profile	S80.80°
Trumpf Cat. No.	EV W80/80°
V-Opening	80
Angle	80°
Height	100
Maximum Loading:	1500 kN/m
Weight:	64.3 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	300
	200
Version A	100
Description	50
Length 2050	45
Length 1250	40
Length 1050	35
	30
	25

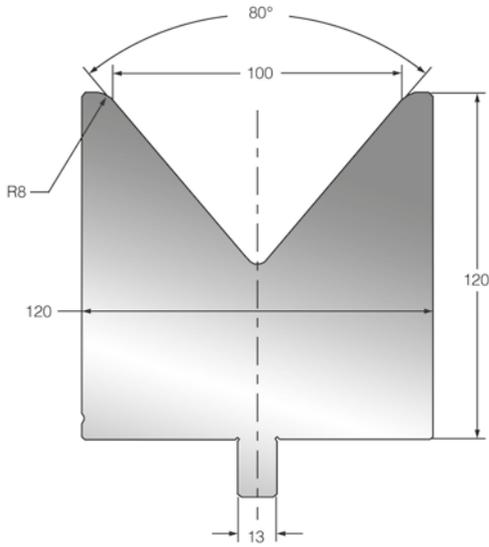


Schiavi Profile	S90.80°
Trumpf Cat. No.	EV W90/80°
V-Opening	90
Angle	80°
Height	120
Maximum Loading:	1500 kN/m
Weight:	84.5 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	200
	100
Version A	50
Description	45
Length 2050	40
Length 1250	35
Length 1050	30
	25

Dimensions in mm

DIE V-OPENING 100MM

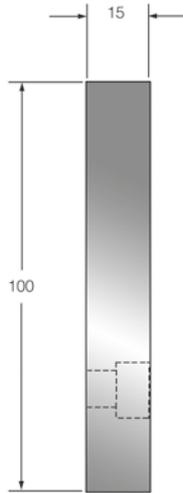


Schiavi Profile	S100.80°
Trumpf Cat. No.	EV W100/80°
V-Opening	100
Angle	80°
Height	120
Maximum Loading:	1500 kN/m
Weight:	89.2 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	
Length 2050	Single
Length 1250	Description
Length 1050	200
	100
Version A	50
Description	45
Length 2050	40
Length 1250	35
Length 1050	30
	25

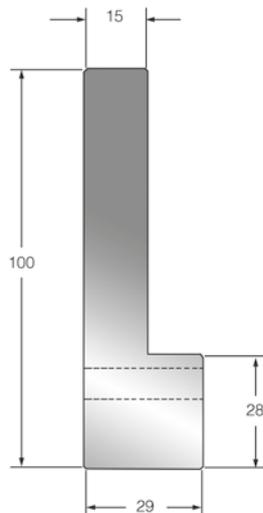
Dimensions in mm

HEMMING



Schiavi Profile	ZDL 100
Trumpf Cat. No.	ZDL
Height	100
Maximum Loading:	1300 kN/m
Weight:	11.6 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

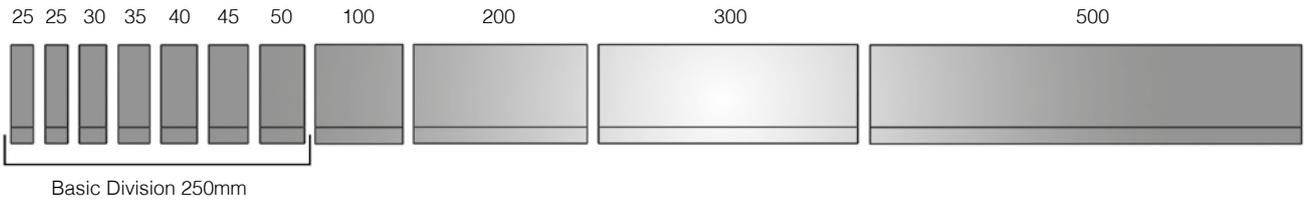


Schiavi Profile	FWZ 100
Trumpf Cat. No.	FWZ
V-Opening	100
Maximum Loading:	1200 kN/m
Weight:	14.8 kg/m

Version B	Sectionalised
Description	Description
Length 4050	Length 250
Length 3050	Length 550
Length 2550	Single
Length 2050	Description
Length 1250	500
Length 1050	300
Version A	200
Description	100
Length 2050	50
Length 1250	45
Length 1050	40
	35
	30
	25

Dimensions in mm

SYSTEM DIVISION



Division version for tool sets with a weight up to 50 kg/m System Division Version B

Set	250X	100	200	300	500
550	1	3	0	0	0
1050B	1	3	1	1	0
1250B	1	3	2	1	0
2050B	1	3	1	1	2
2550B	1	3	1	1	3
3050B	1	3	1	1	4
4050B	1	3	1	1	6

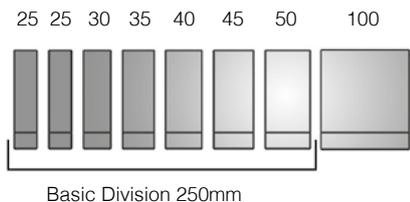
Division version for tool sets with weights starting from 50 kg/m For Dies: T60.80°, T70.80° & T80.80° ONLY

Set	250X	100	200	300
550	1	3	0	0
1050	1	3	1	1
1250B	1	3	2	1
2050B	1	3	3	3
2550B	1	3	4	4
3050B	1	3	5	5
4050B	1	3	7	7

Division version for tool sets with weights of more than 83 kg/m For Dies: T90.80° & T100.80° ONLY

Set	250X	100	200
550	1	3	0
1050	1	2	3
1250B	1	4	3
2050B	1	6	6
2550B	1	7	8
3050B	1	8	10
4050B	1	10	14

- | | |
|---|--|
| <ul style="list-style-type: none"> • High flexSbility • Short tool set-up time • Low purchase cost | <ul style="list-style-type: none"> • Fewer tool change-overs • Version most often selected and recommended |
|---|--|



System Division Version A

Set	250X	100
550	1	3
1050A	1	8
1250A	1	10
2050A	1	18

- Maximum flexSbility
- Minimum tool set-up time
- Weight of the individual part pieces very low

System Division Version B/A

The combination of a punch block A-division and a die in B-division will not cause any problems.



PRESS BRAKE TOOLING
WILA STYLE



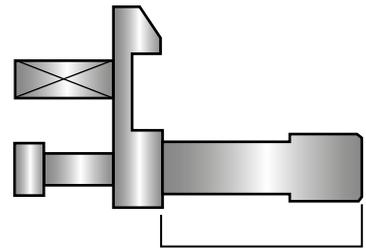
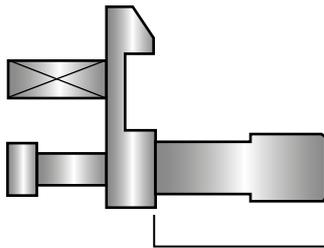
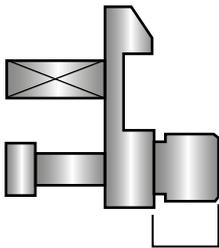
WILA STYLE

CLICK AND LOCK

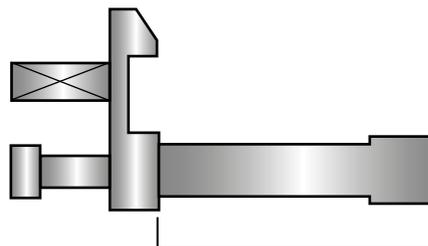
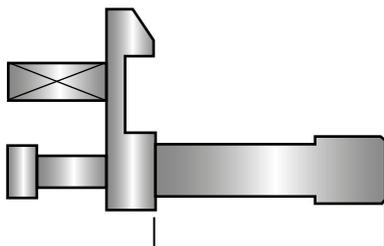


Buttons can be put in all punches with a weight below 12.7 kg

Description	Description	Description
Punch Button Assembly - 10mm	Punch Button Assembly - 24mm	Punch Button Assembly - 30mm

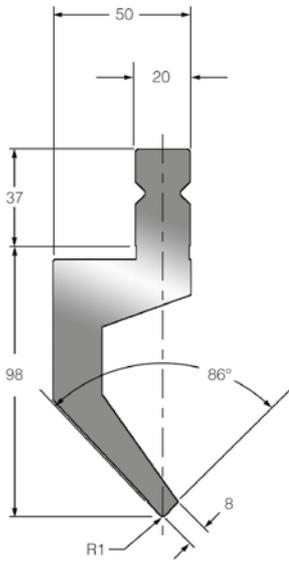


Description	Description
Punch Button Assembly - 35mm	Punch Button Assembly - 45mm

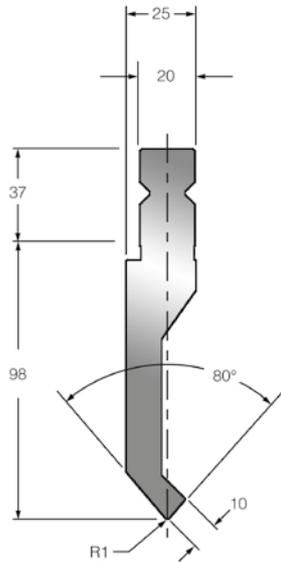


WILA STYLE

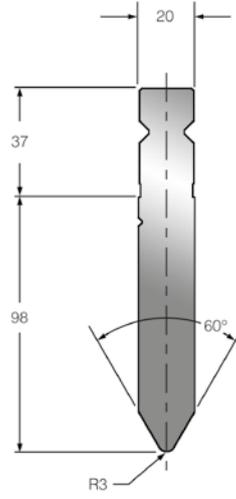
PUNCHES HEIGHT 135&157MM



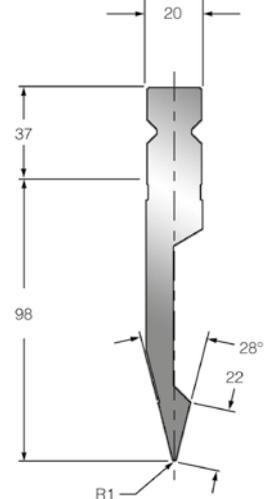
SP003



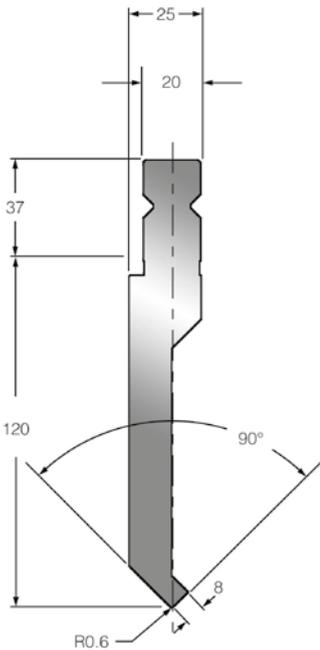
SP002



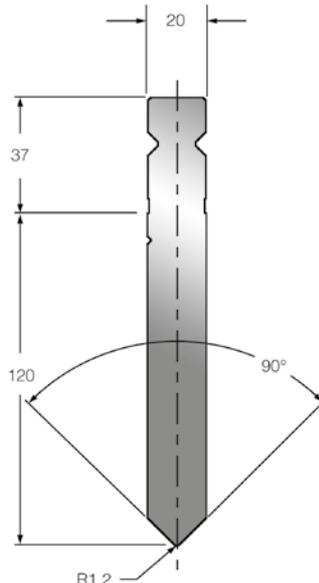
SP004



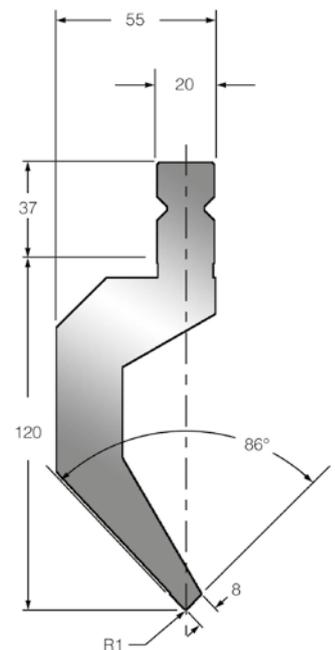
SP001



SP015



SP016

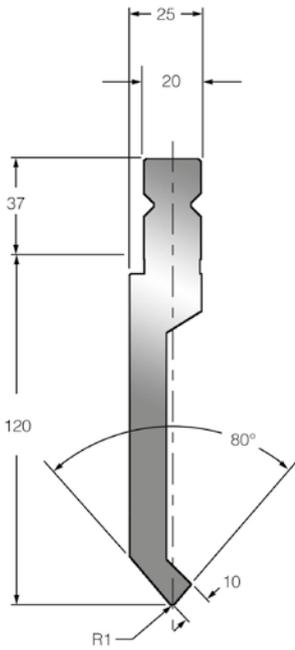


SP013

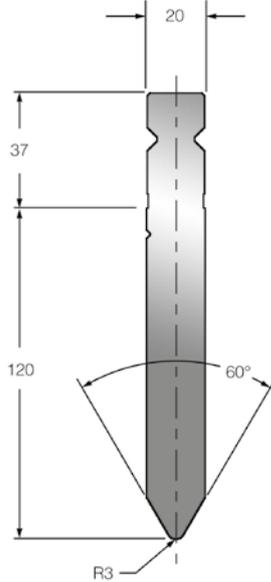
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	PossSble lenghts
SP003	BIU-003	65	24	86°	135	515 / 200 / 550 sect / 200sect
SP002	BIU-002	100	18	80°	135	515 / 200 / 550 sect / 200sect
SP004	BIU-004	160	20,5	60°	135	515 / 200 / 550 sect / 200sect
SP001	BIU-001	100	14,5	28°	135	515 / 200 / 550 sect / 200sect
SP015	BIU-015	60	21	90°	157	515 / 200 / 550 sect / 200sect
SP016	BIU-016	100	24	90°	157	515 / 200 / 550 sect / 200sect
SP013	BIU-013	65	30	86°	157	515 / 200 / 550 sect / 200sect

WILA STYLE

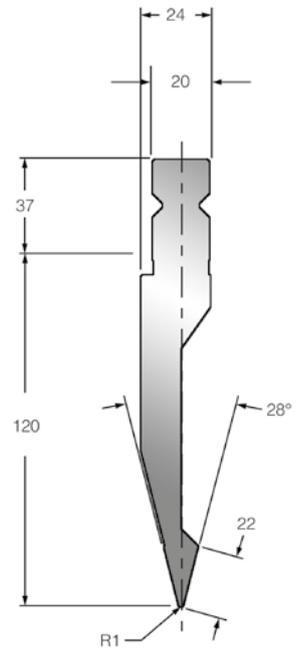
PUNCHES HEIGHT 157MM



SP012



SP014

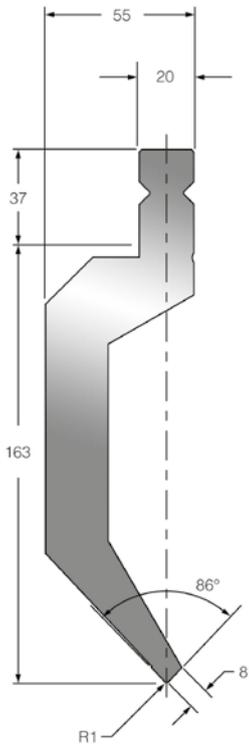


SP011

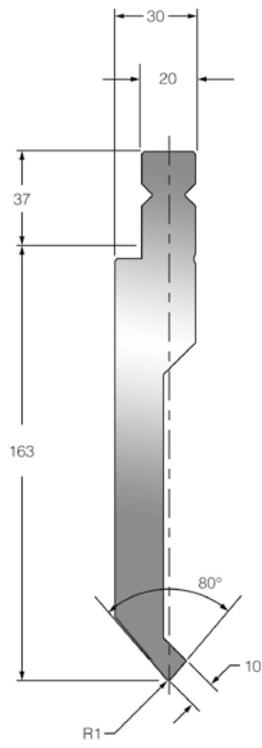
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	PossSble lenghts
SP012	BIU-012	100	21	80°	157	515 / 200 / 550 sect / 200sect
SP014	BIU-014	160	24	60°	157	515 / 200 / 550 sect / 200sect
SP011	BIU-011	100	18,5	28°	157	515 / 200 / 550 sect / 200sect

WILA STYLE

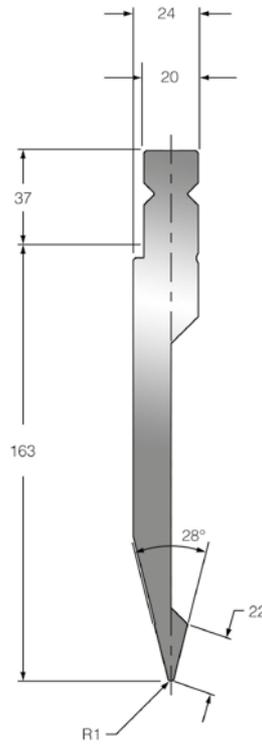
PUNCHES HEIGHT 200MM



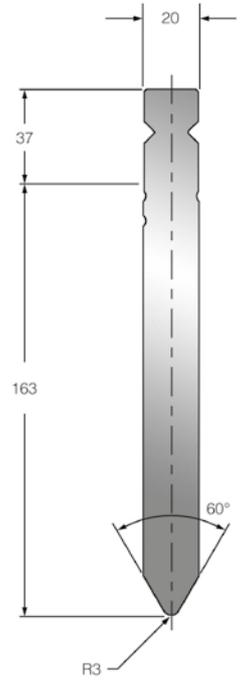
SP023



SP022



SP021

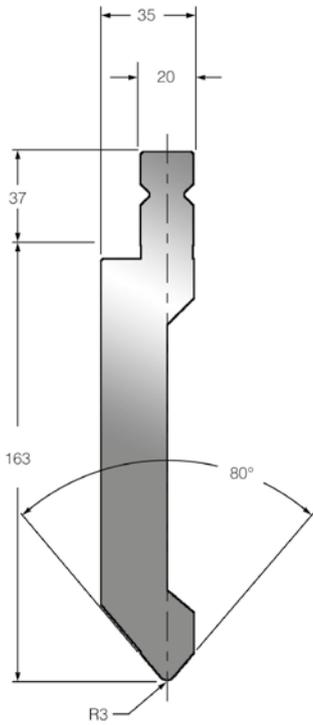


SP024

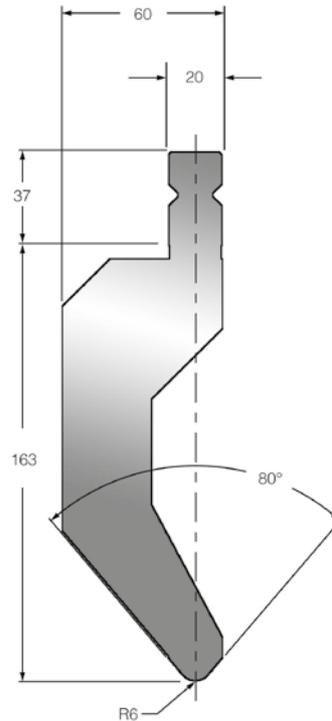
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	PossSble lenghts
SP023	BIU-023	65	38	86°	200	515 / 200 / 550 sect / 200sect
SP022	BIU-022	80	31,5	80°	200	515 / 200 / 550 sect / 200sect
SP021	BIU-021	70	24	28°	200	515 / 200 / 550 sect / 200sect
SP024	BIU-024	160	31	60°	200	515 / 200 / 550 sect / 200sect

WILA STYLE

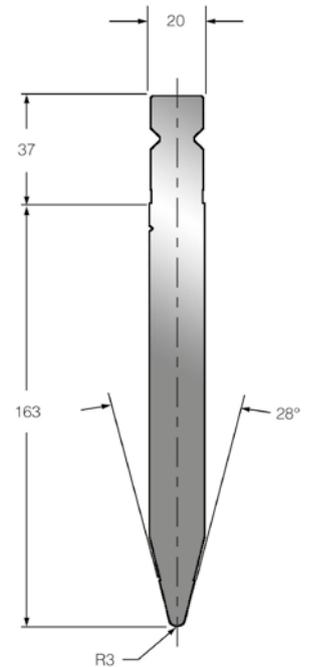
PUNCHES HEIGHT 200MM



SP026



SP025

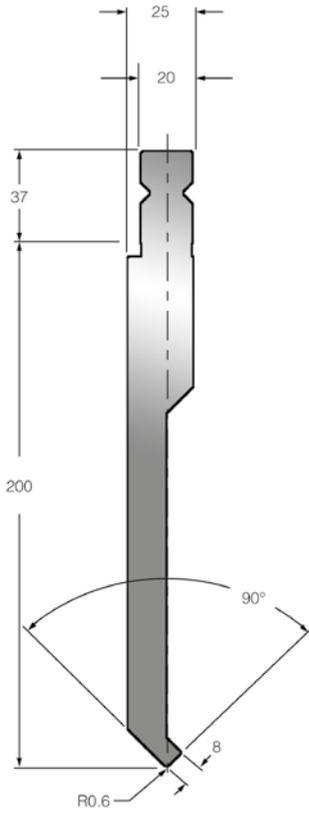


SP029

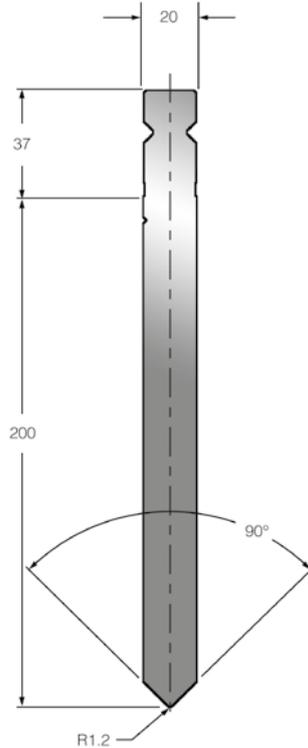
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
SP026	BIU-026	140	38	80°	200	515 / 200 / 550 sect / 200sect
SP025	BIU-025	130	53	80°	200	515 / 200 / 550 sect / 200sect
SP029	BIU-029	160	30,3	28°	200	515 / 200 / 550 sect / 200sect

WILA STYLE

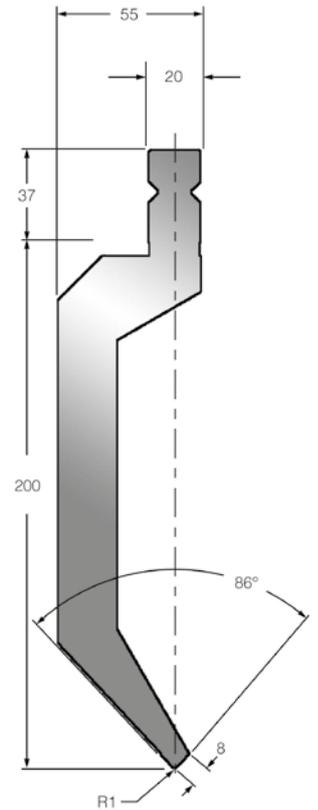
PUNCHES HEIGHT 237MM



SP035



SP036

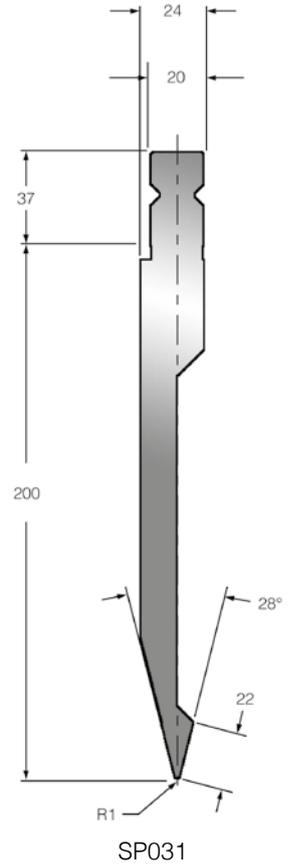
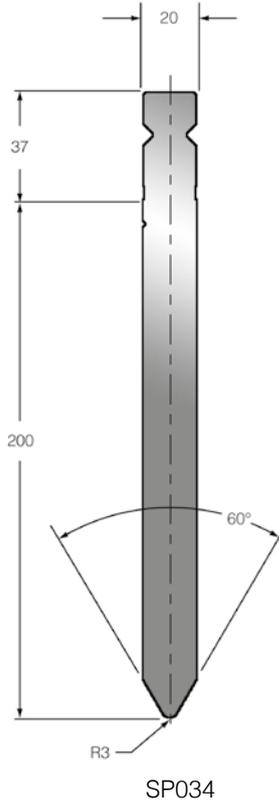
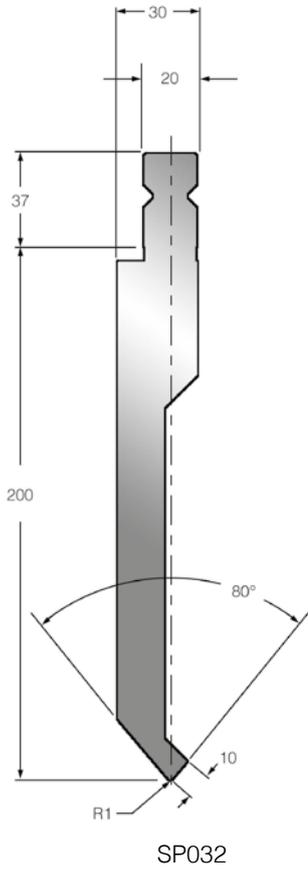


SP033

Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	PossSble lenghts
SP035	BIU-035	60	34	90°	237	515 / 200 / 550 sect / 200sect
SP036	BIU-036	100	37	90°	237	515 / 200 / 550 sect / 200sect
SP033	BIU-033	50	45	86°	237	515 / 200 / 550 sect / 200sect

WILA STYLE

PUNCHES HEIGHT 237MM



Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
SP032	BIU-032	70	38,4	80°	237	515 / 200 / 550 sect / 200sect
SP034	BIU-034	160	36,6	60°	237	515 / 200 / 550 sect / 200sect
SP031	BIU-031	60	29	28°	237	515 / 200 / 550 sect / 200sect

PUNCHES HEMMING PUNCHES



SP061



SP051



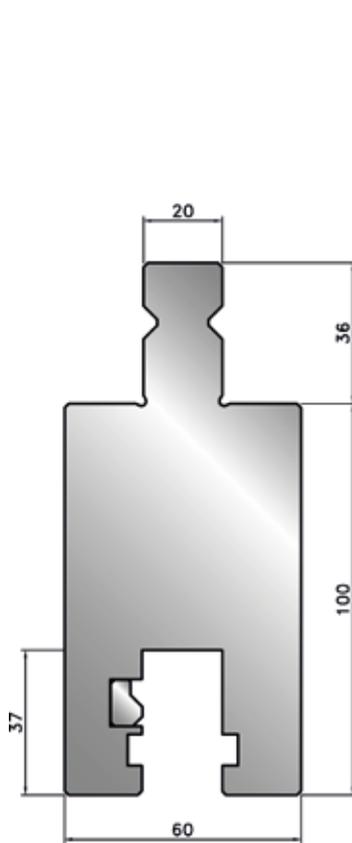
SP063



SP053

Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
SP061	BIU-061	50	20,2	28°	157	515 / 200 / 550 sect / 200sect
SP051	BIU-051	100	22	28°	157	515 / 200 / 550 sect / 200sect
SP063	BIU-063	50	37,9	28°	237	515 / 200 / 550 sect / 200sect
SP053	BIU-053	100	37,9	28°	237	515 / 200 / 550 sect / 200sect

PUNCHES ADAPTOR



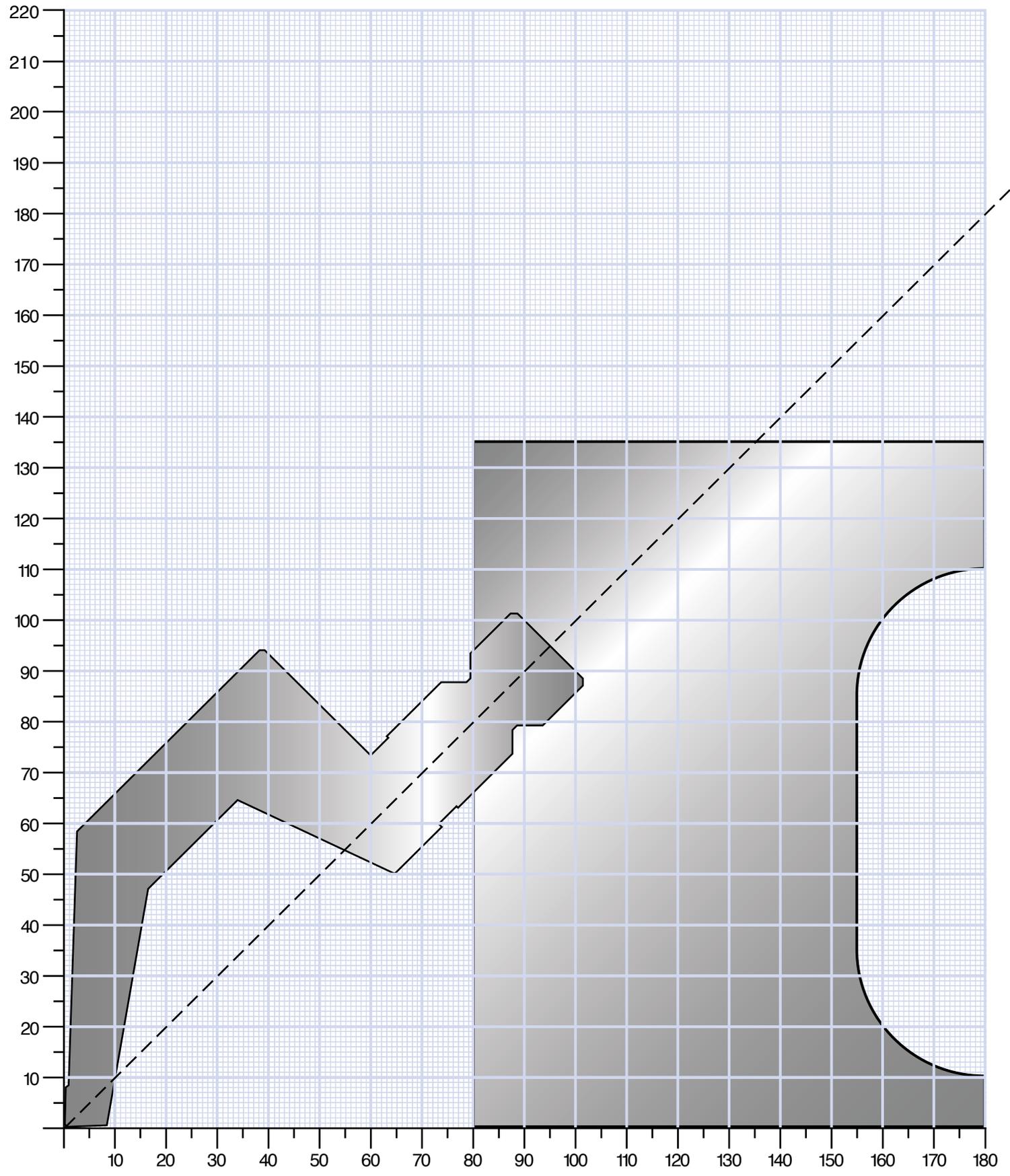
MODUFIX H=100



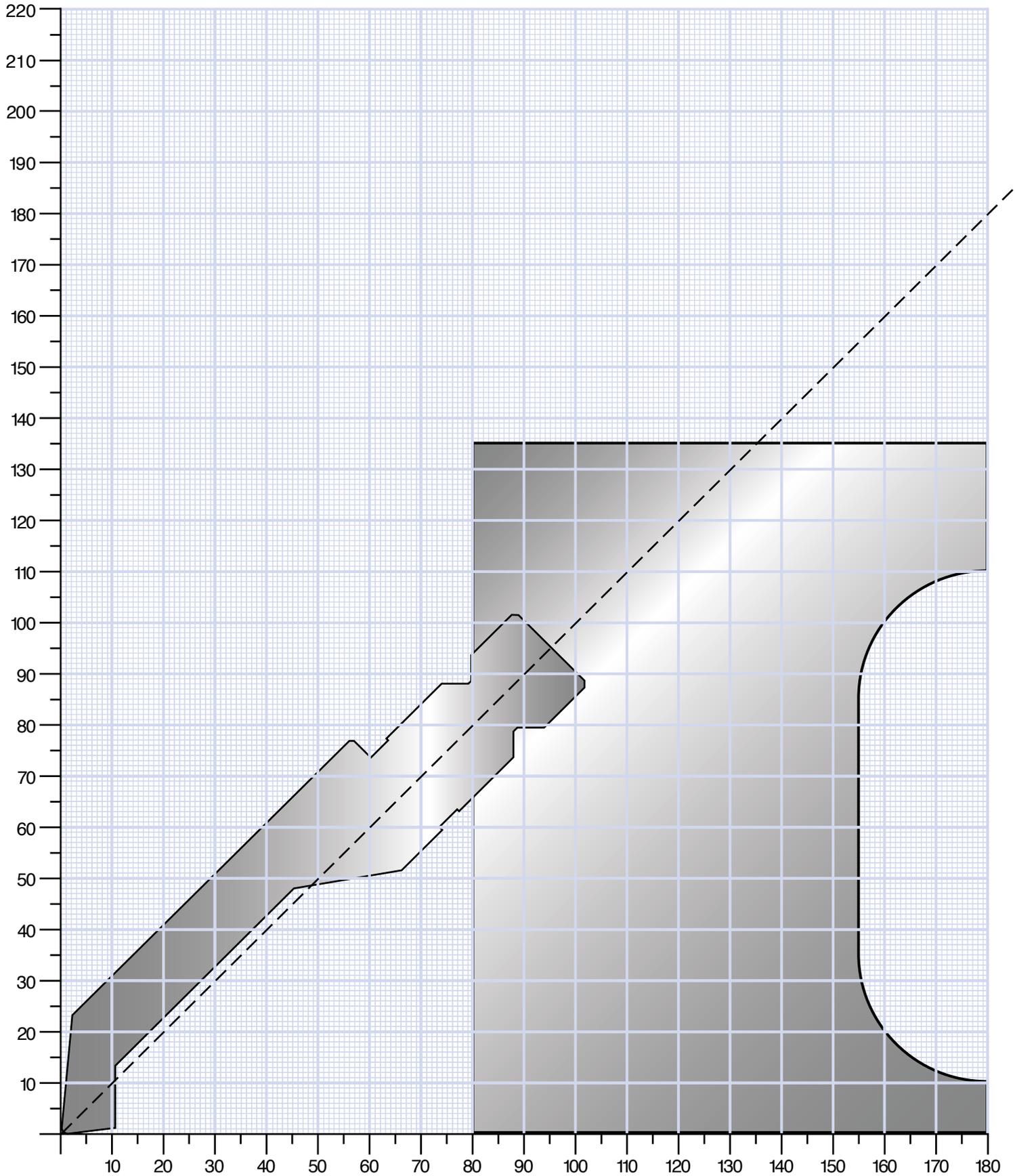
MODUFIX H=150

Schiavi Cat. No.	Max Loading T/m	Weight Kg/m	Height	Possible lengths
Modufix H=100	150	45,3	100	100 / 550 S
Modufix H=150	150	68,6	150	100 / 550 S

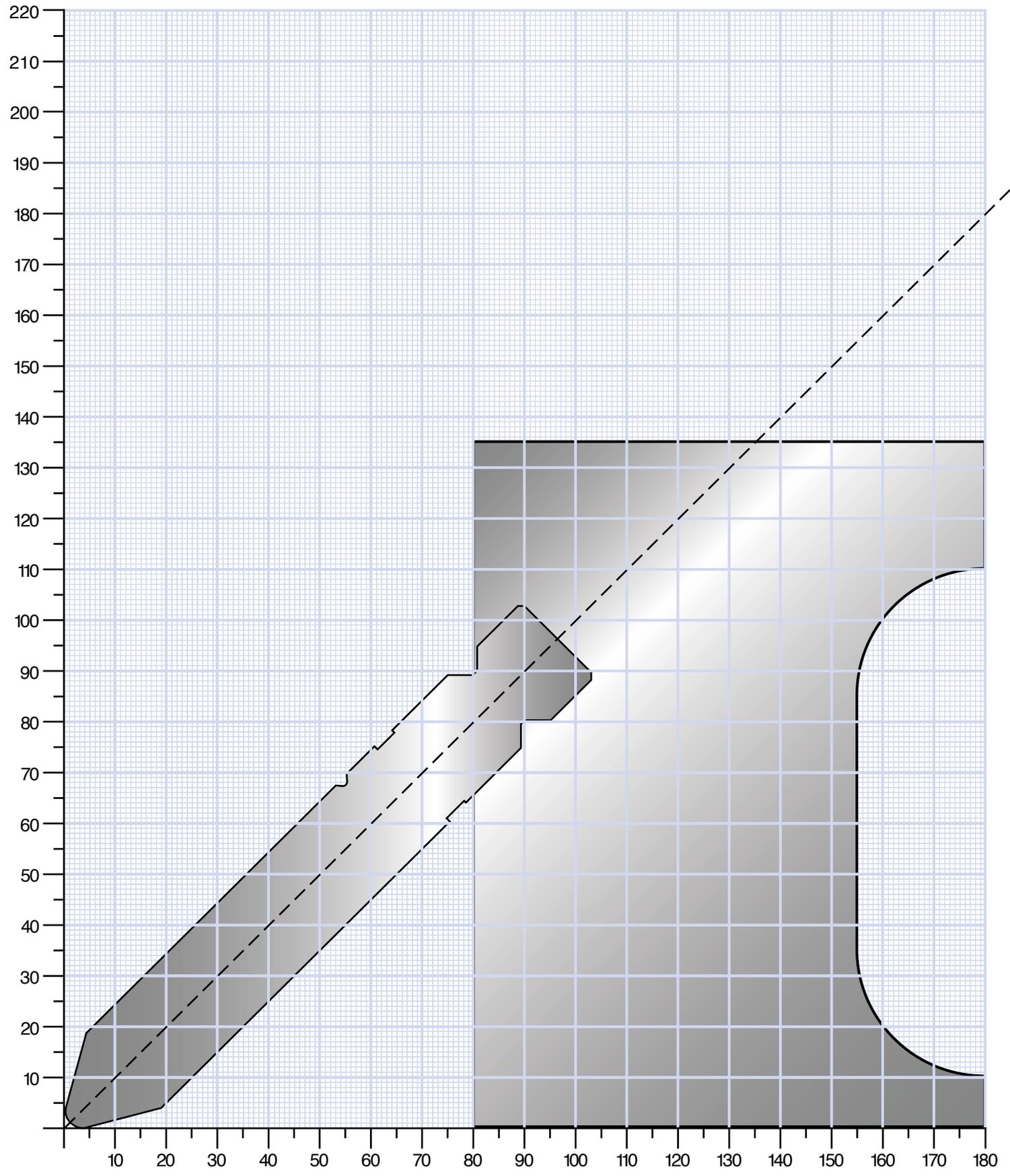
SP003 BEND LIMIT GRAPH



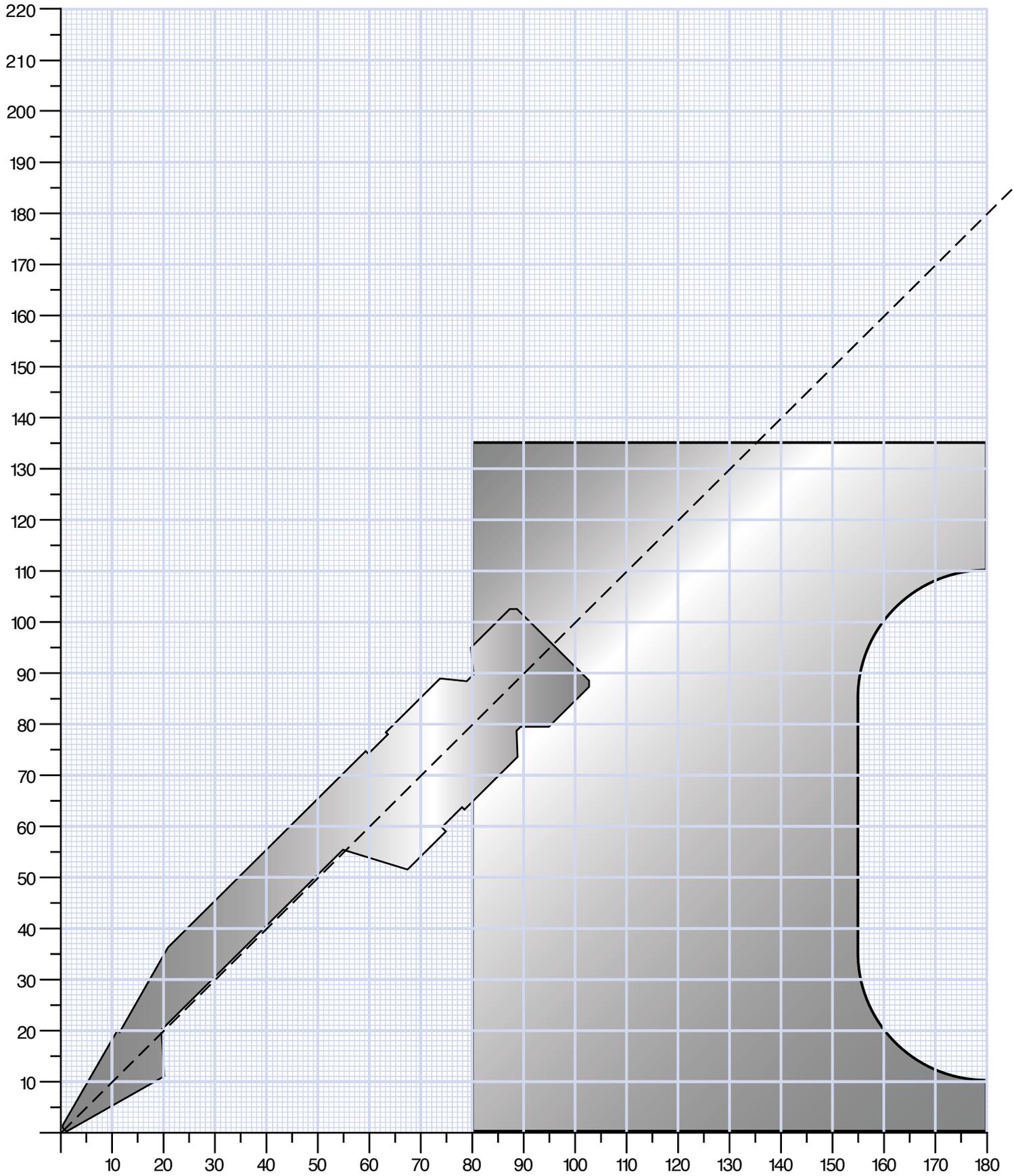
SP002 BEND LIMIT GRAPH



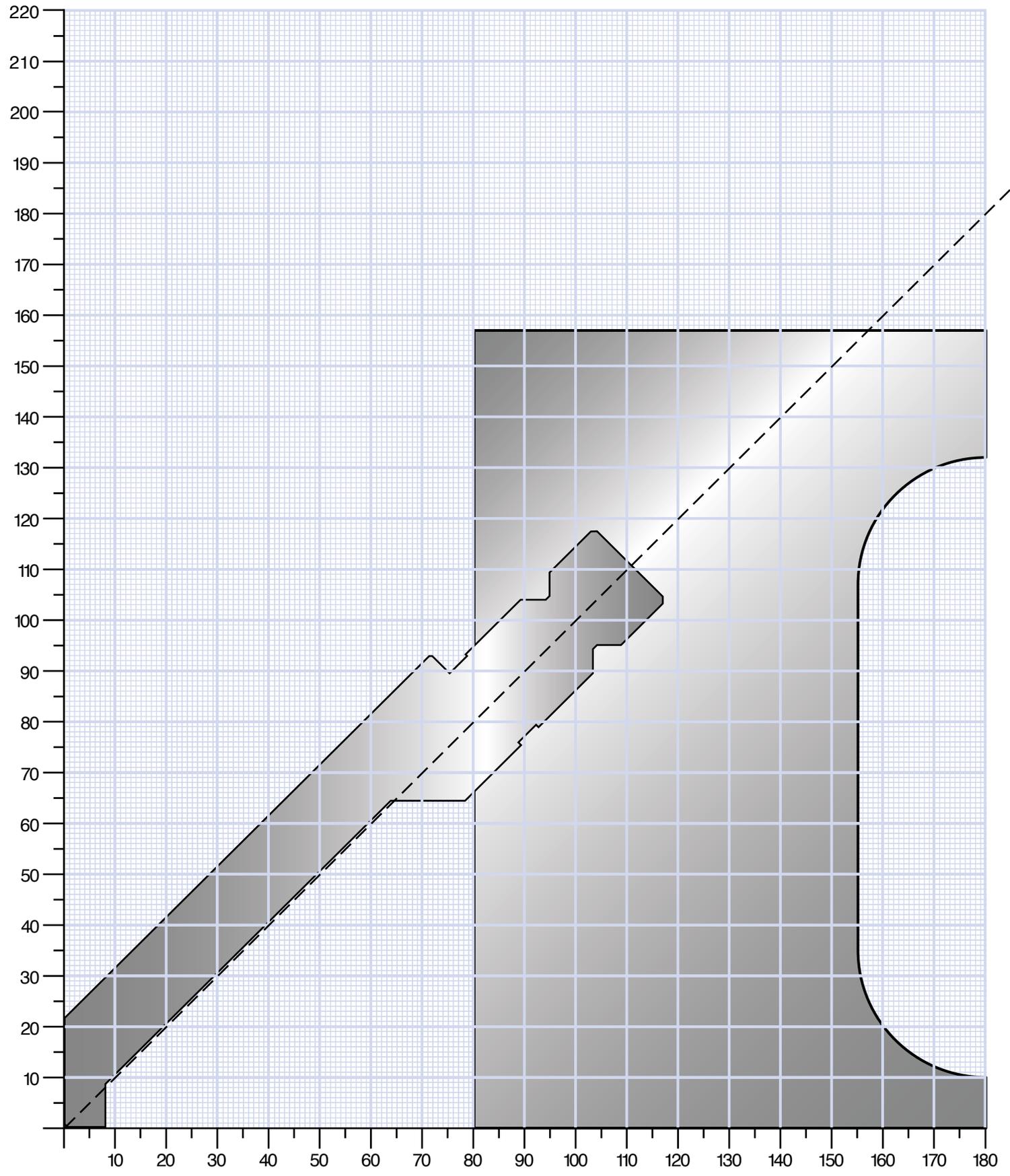
SP004 BEND LIMIT GRAPH



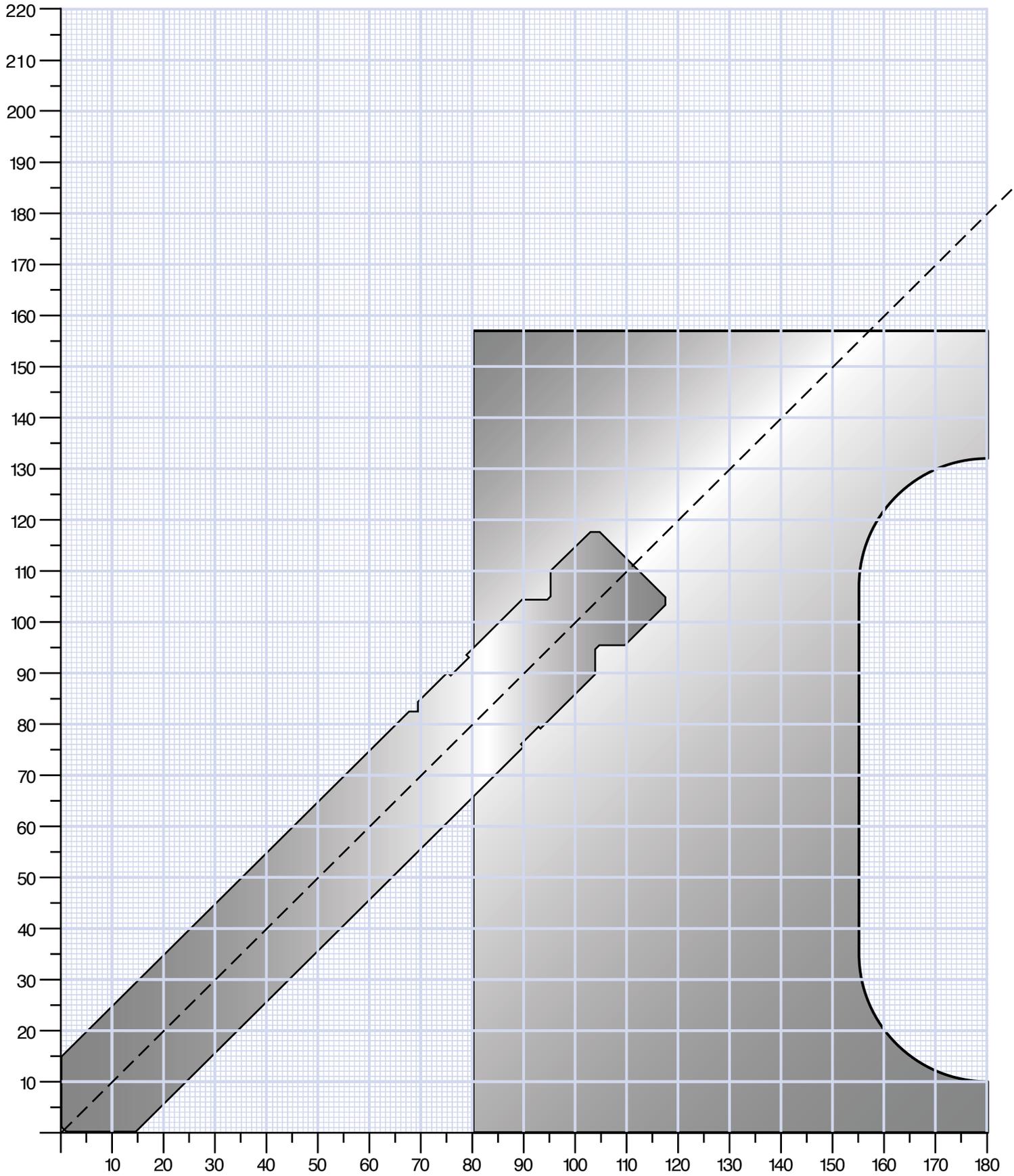
SP001 BEND LIMIT GRAPH



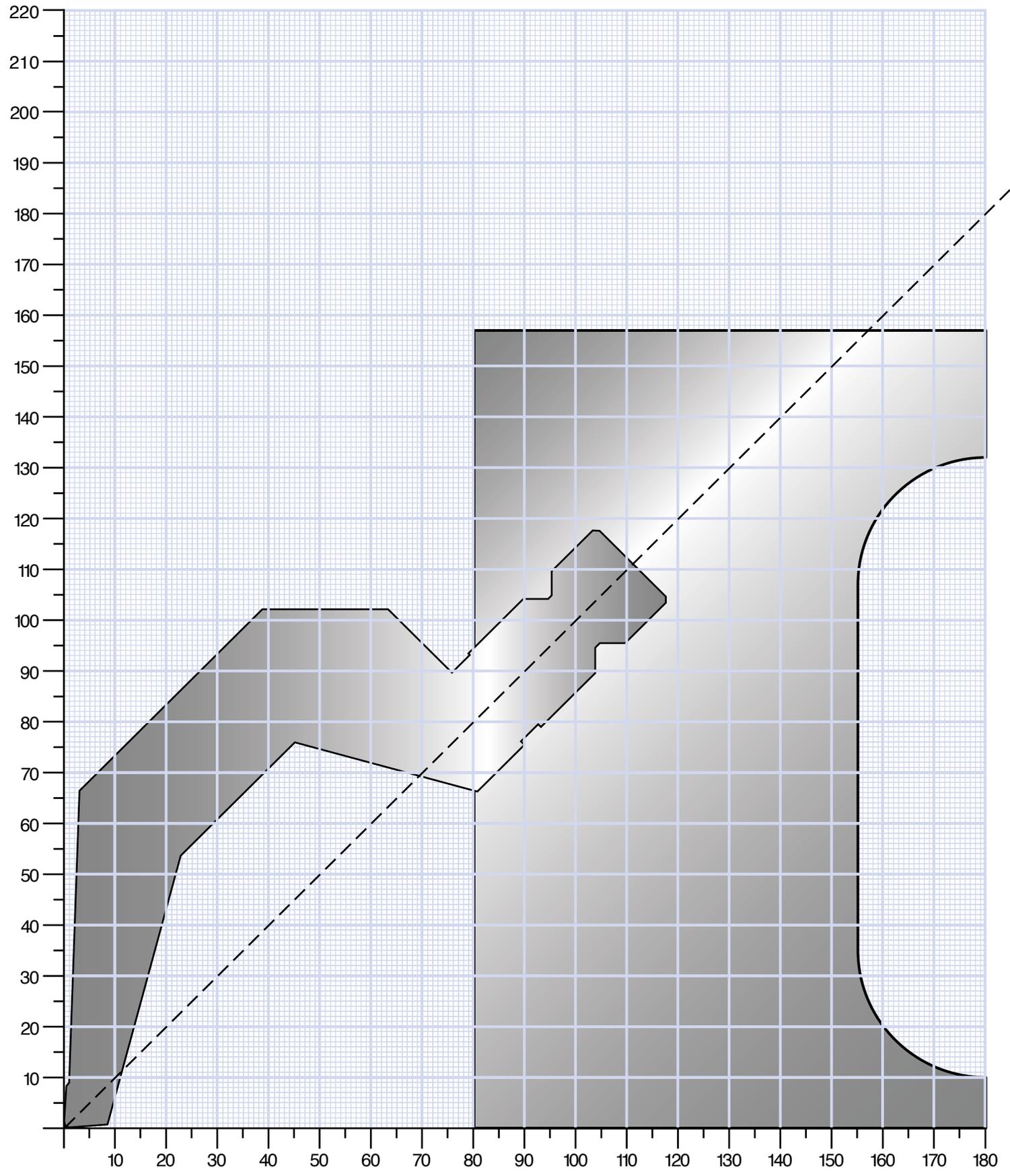
SP015 BEND LIMIT GRAPH



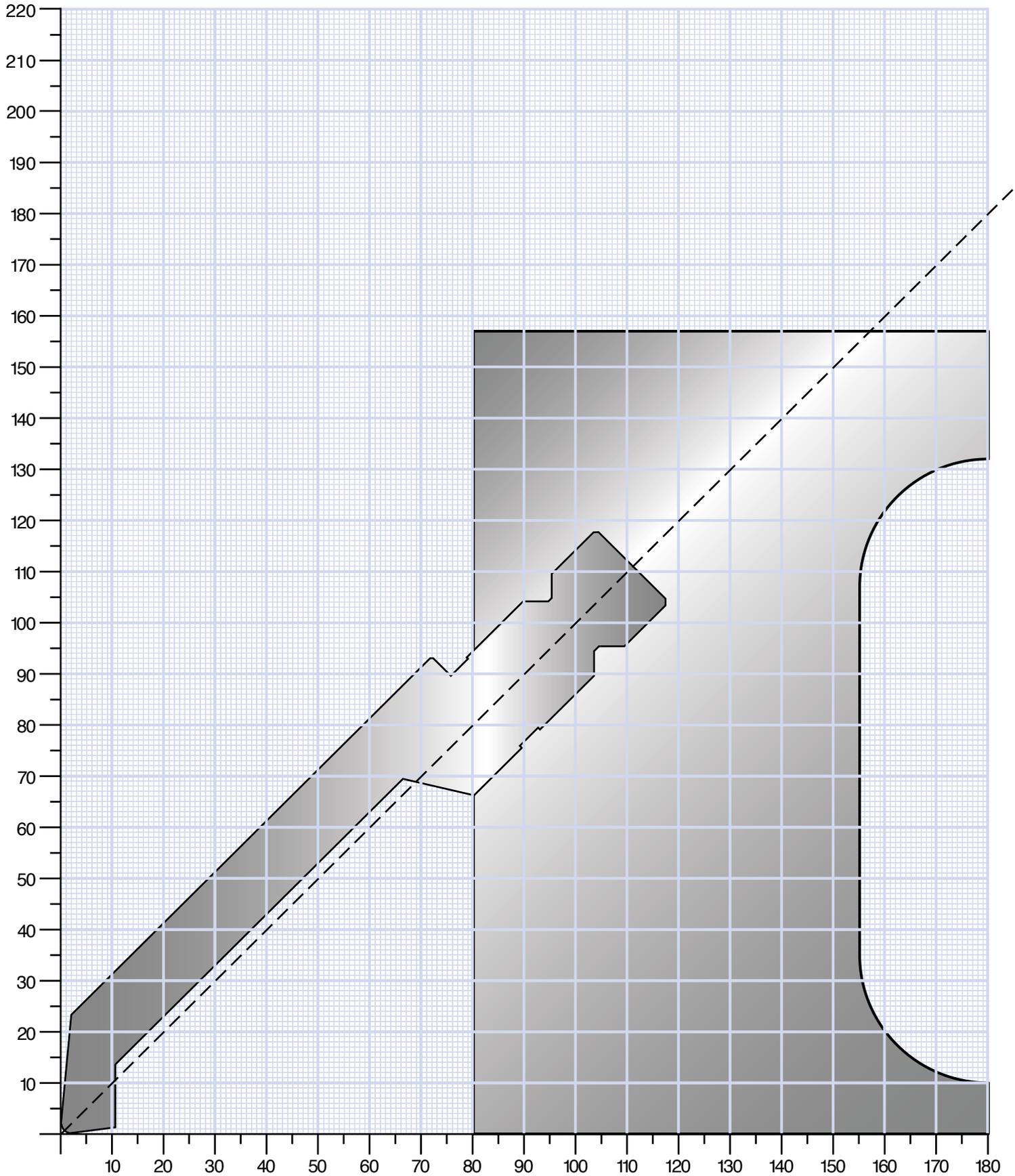
SP016 BEND LIMIT GRAPH



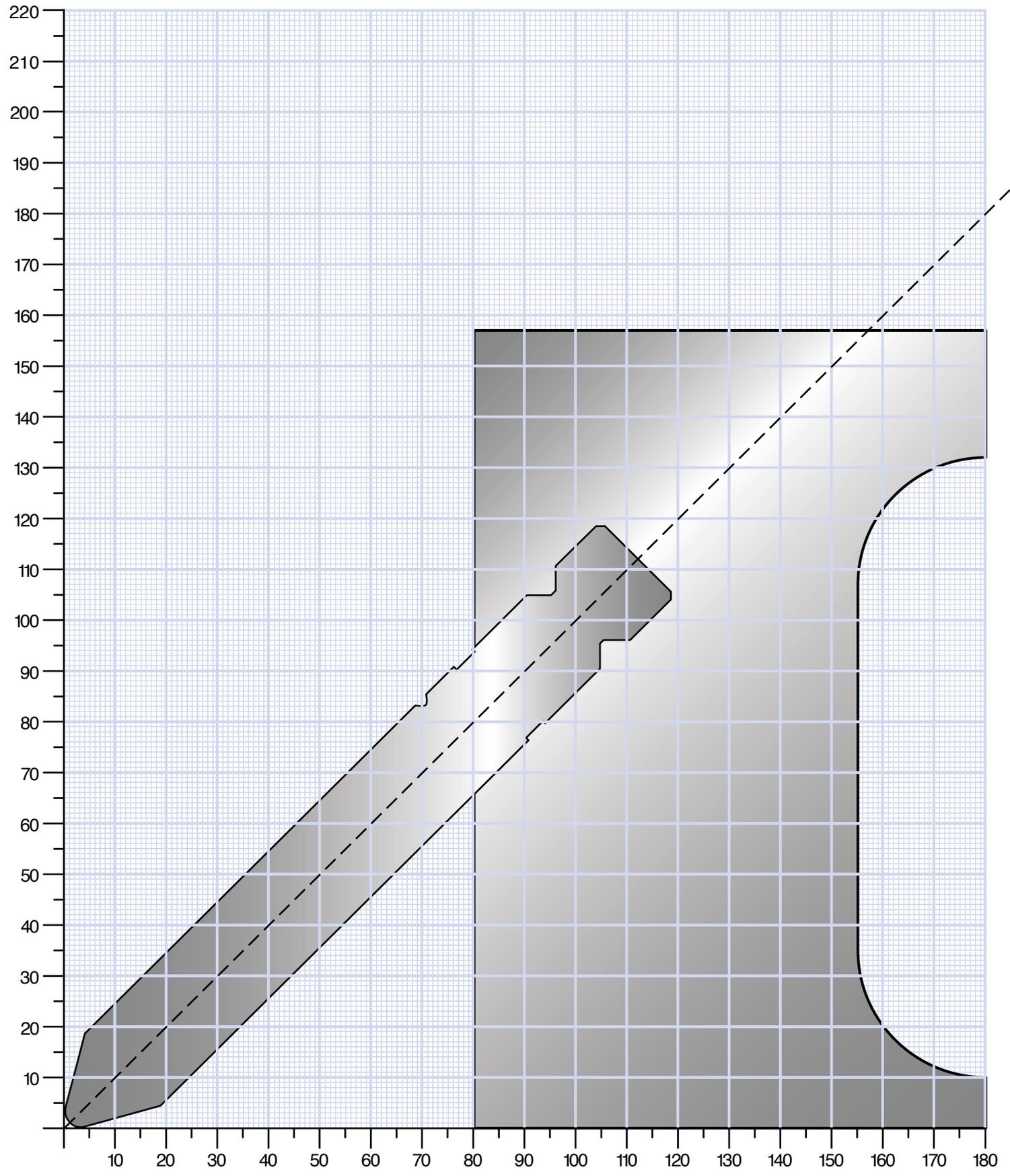
SP013 BEND LIMIT GRAPH



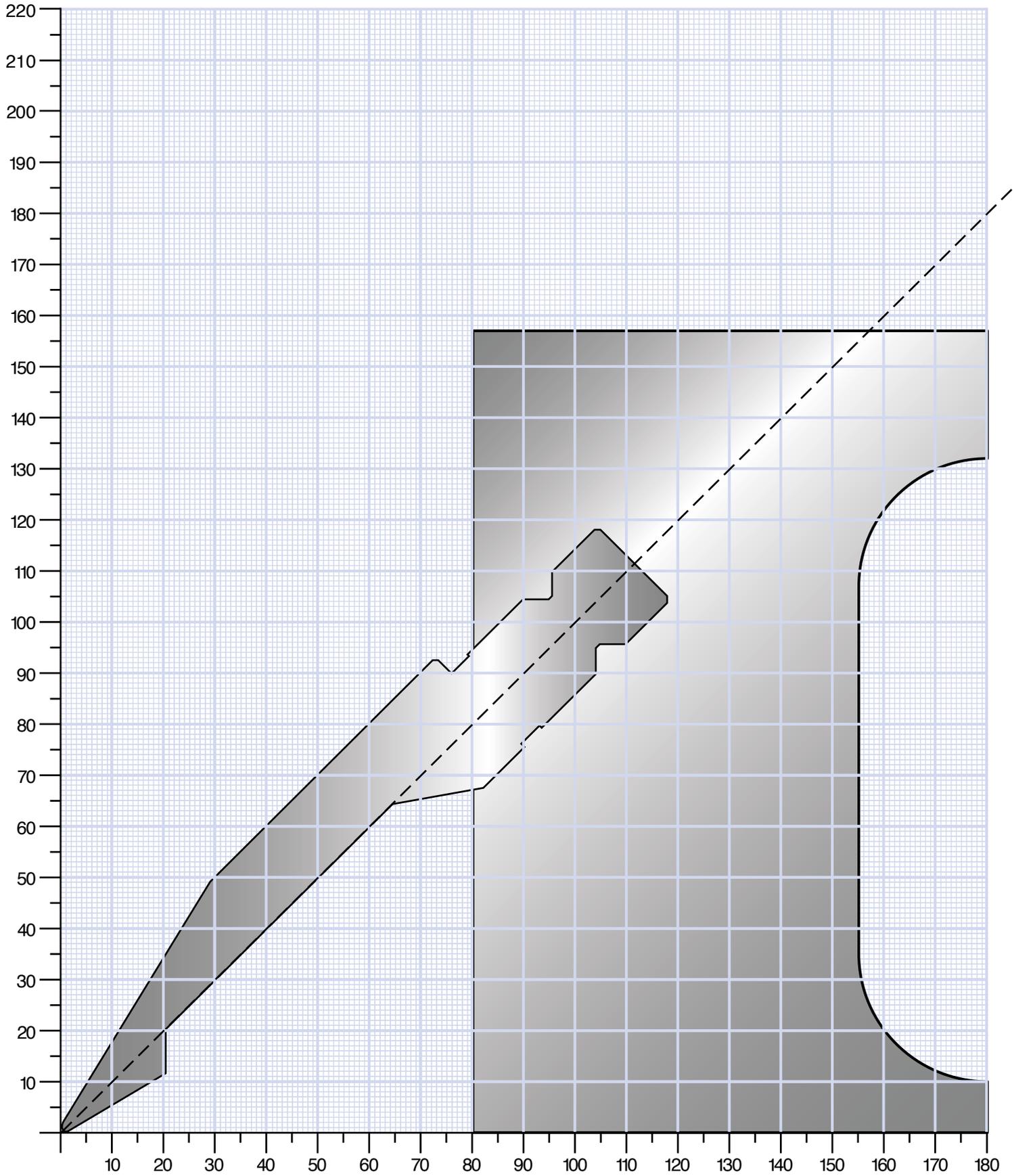
SP012 BEND LIMIT GRAPH



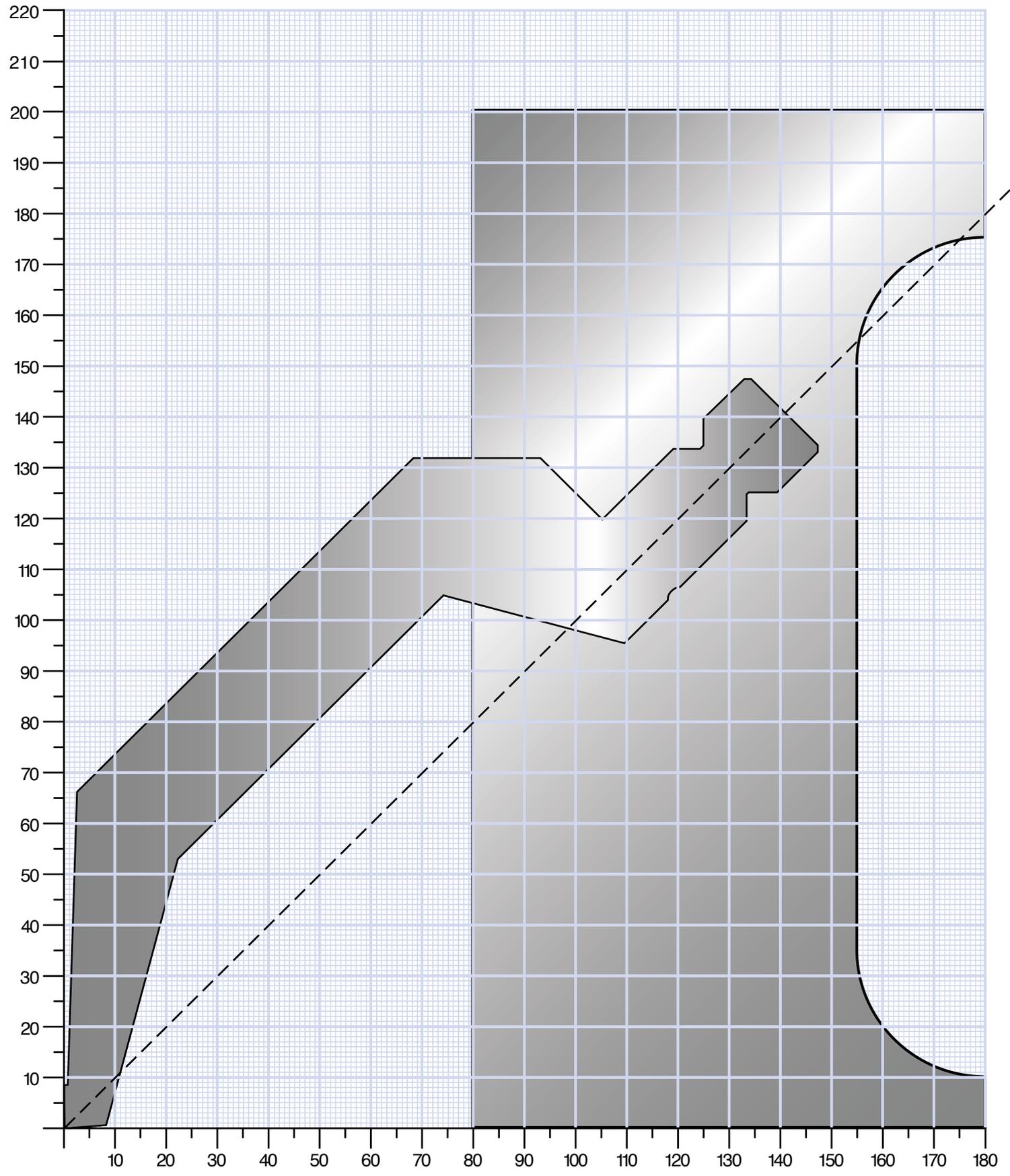
SP014 BEND LIMIT GRAPH



SP011 BEND LIMIT GRAPH

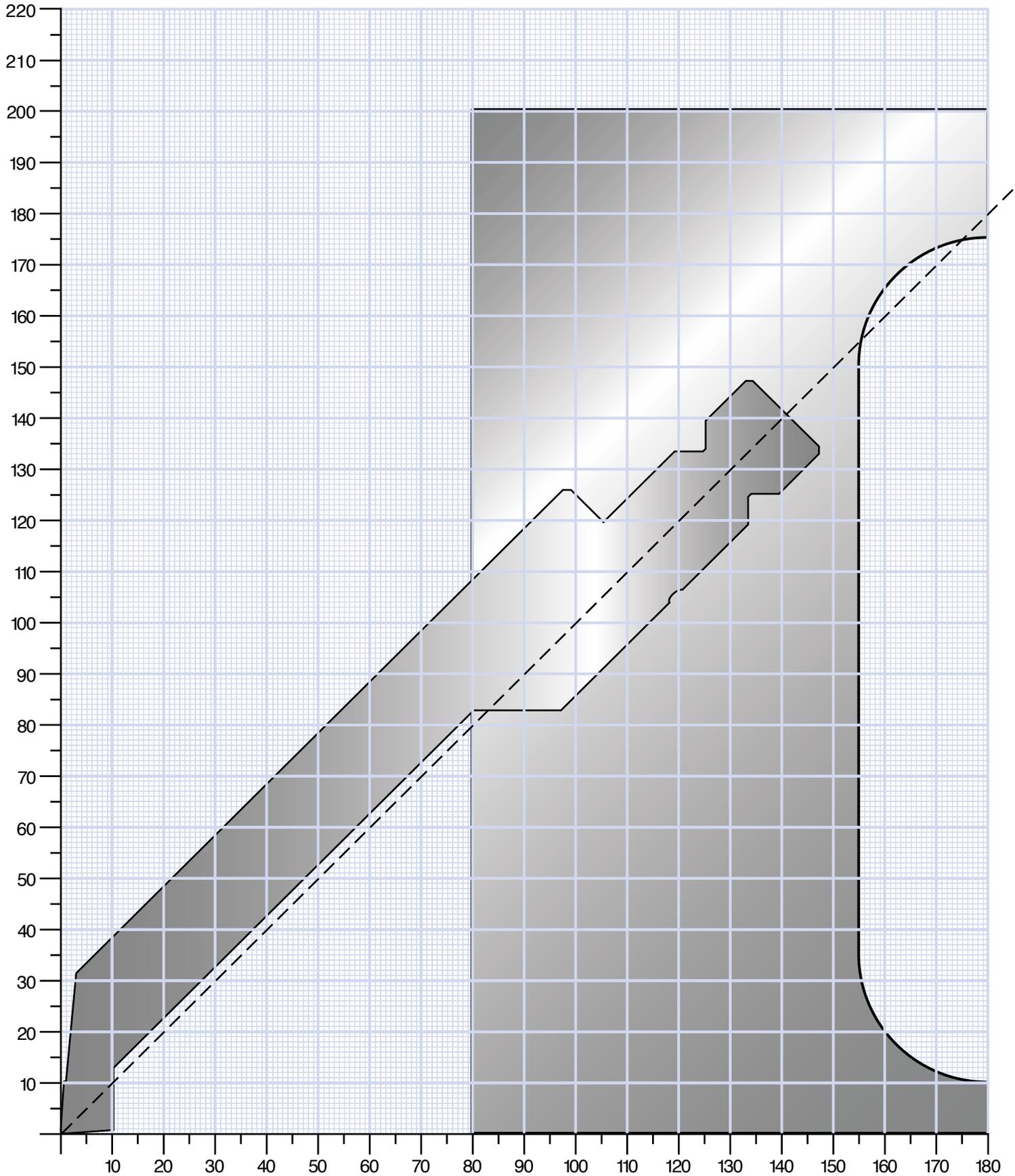


SP023 BEND LIMIT GRAPH

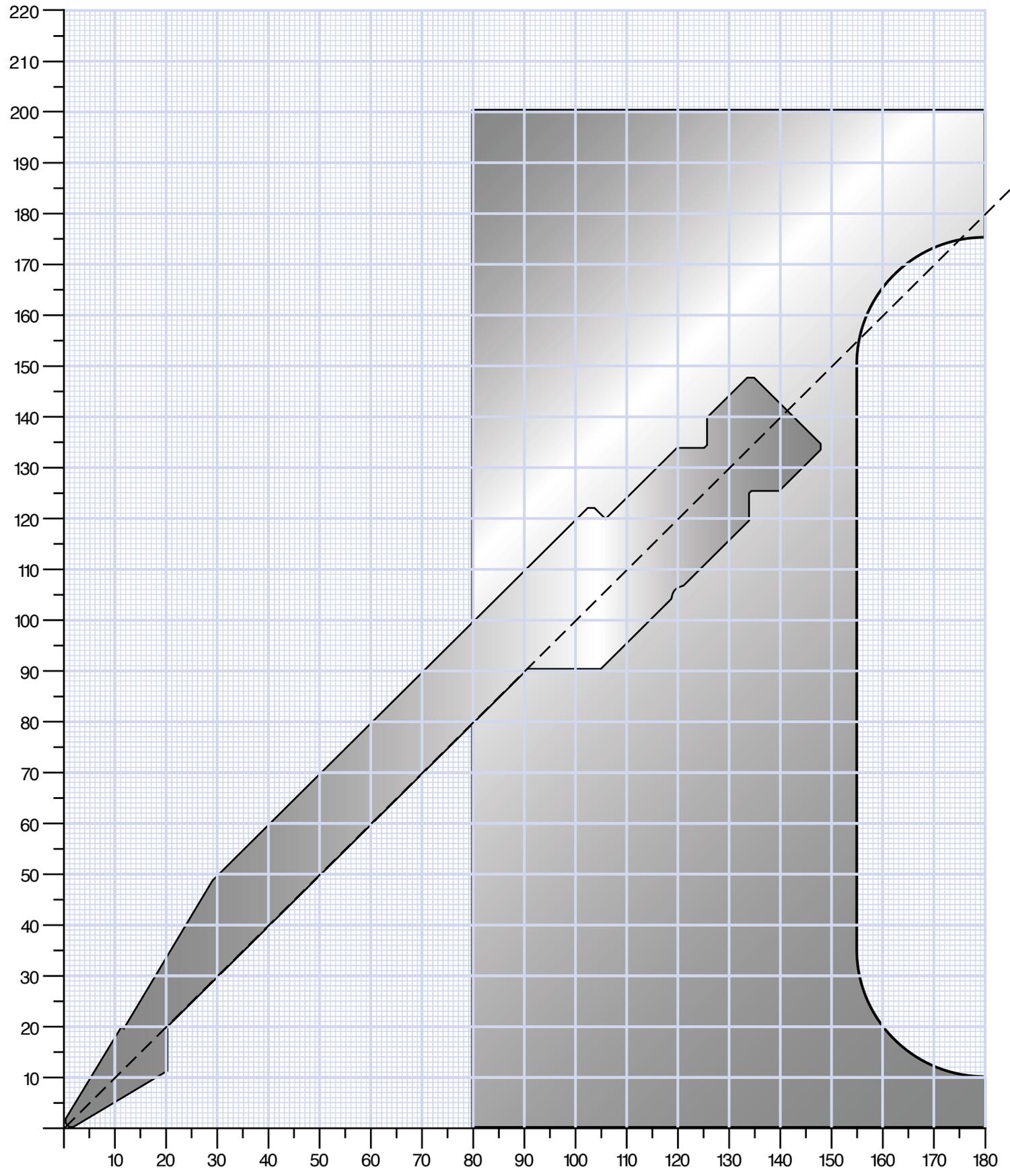


WILA STYLE

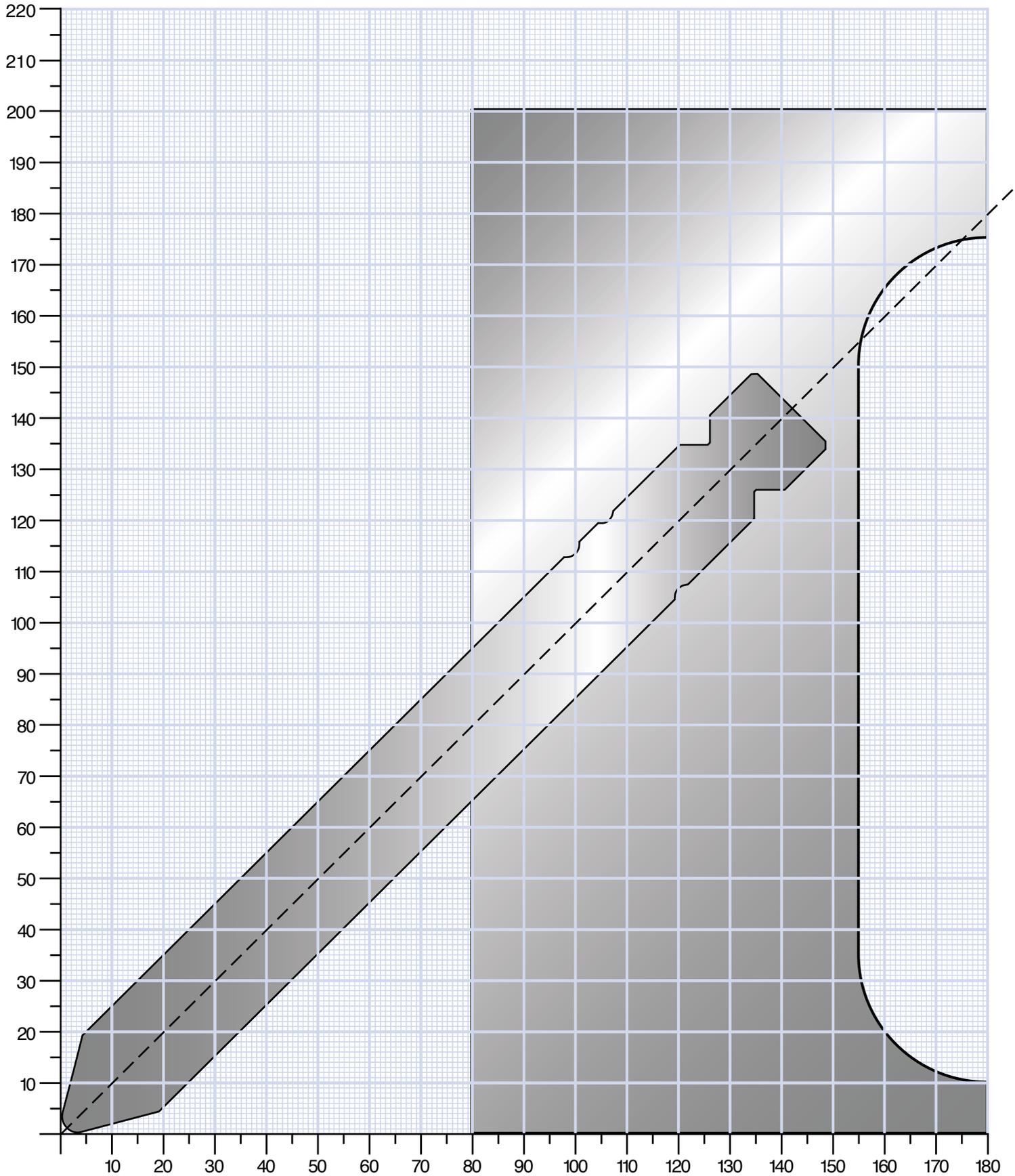
SP022 BEND LIMIT GRAPH



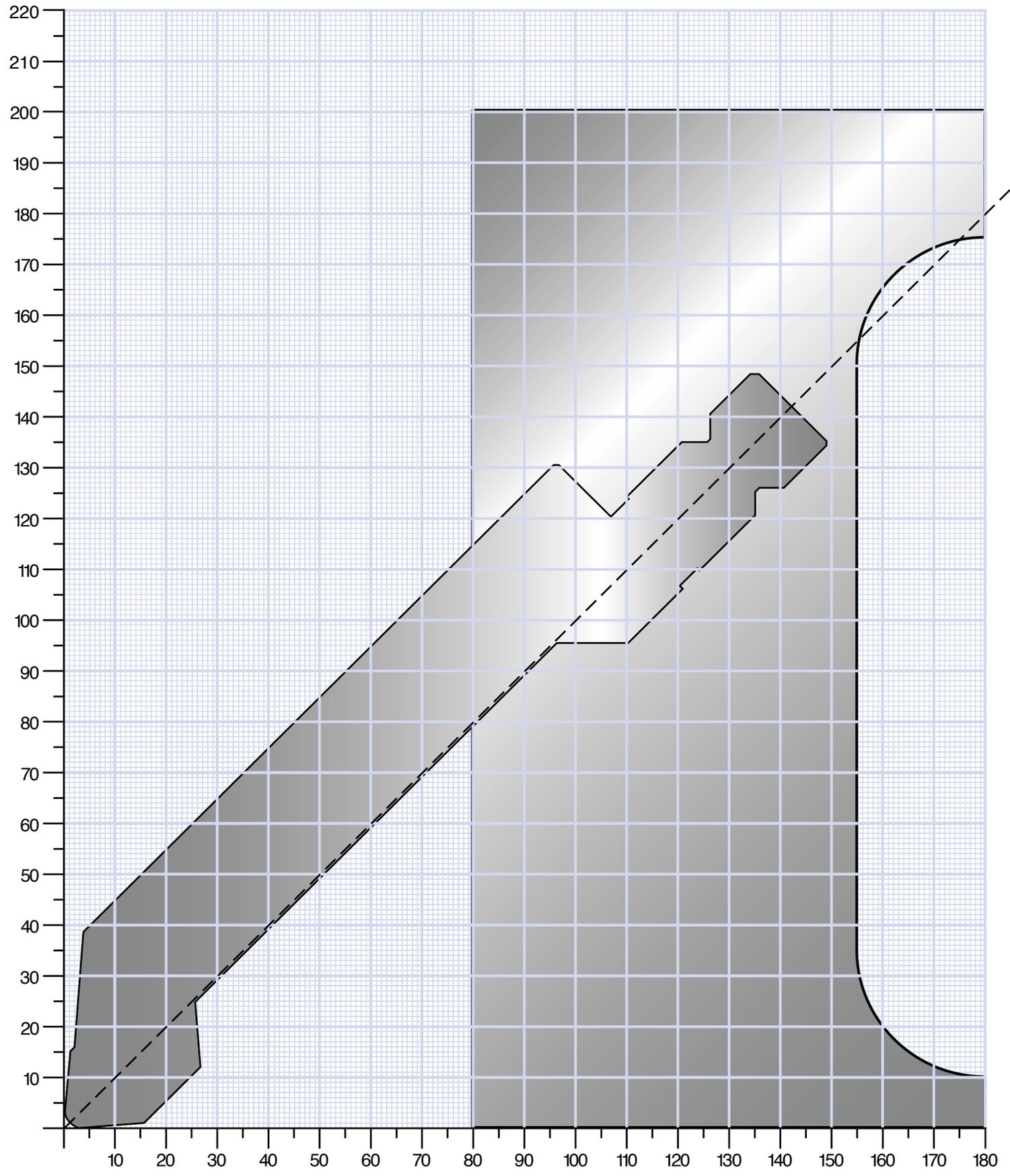
SP021 BEND LIMIT GRAPH



SP024 BEND LIMIT GRAPH

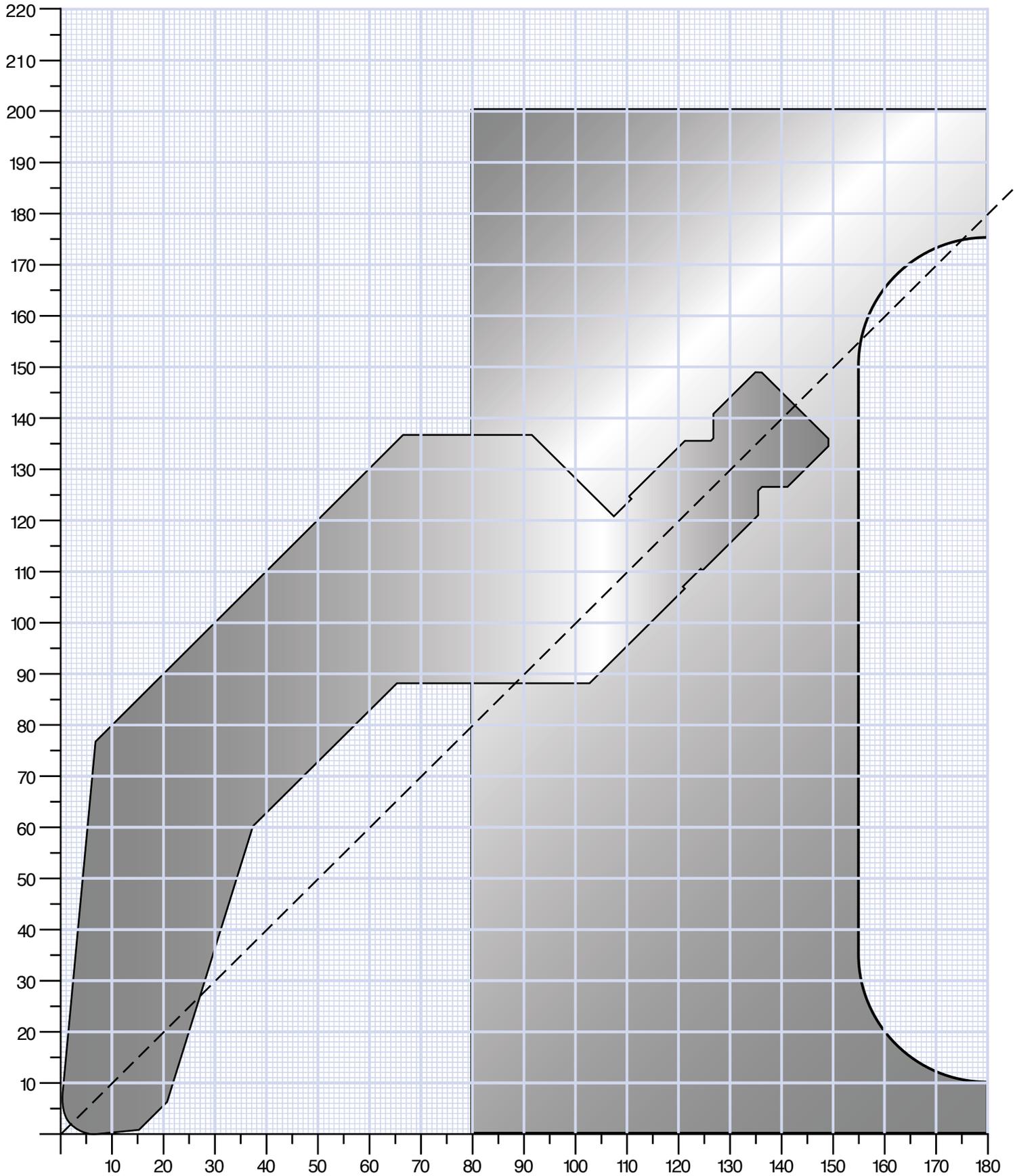


SP026 BEND LIMIT GRAPH

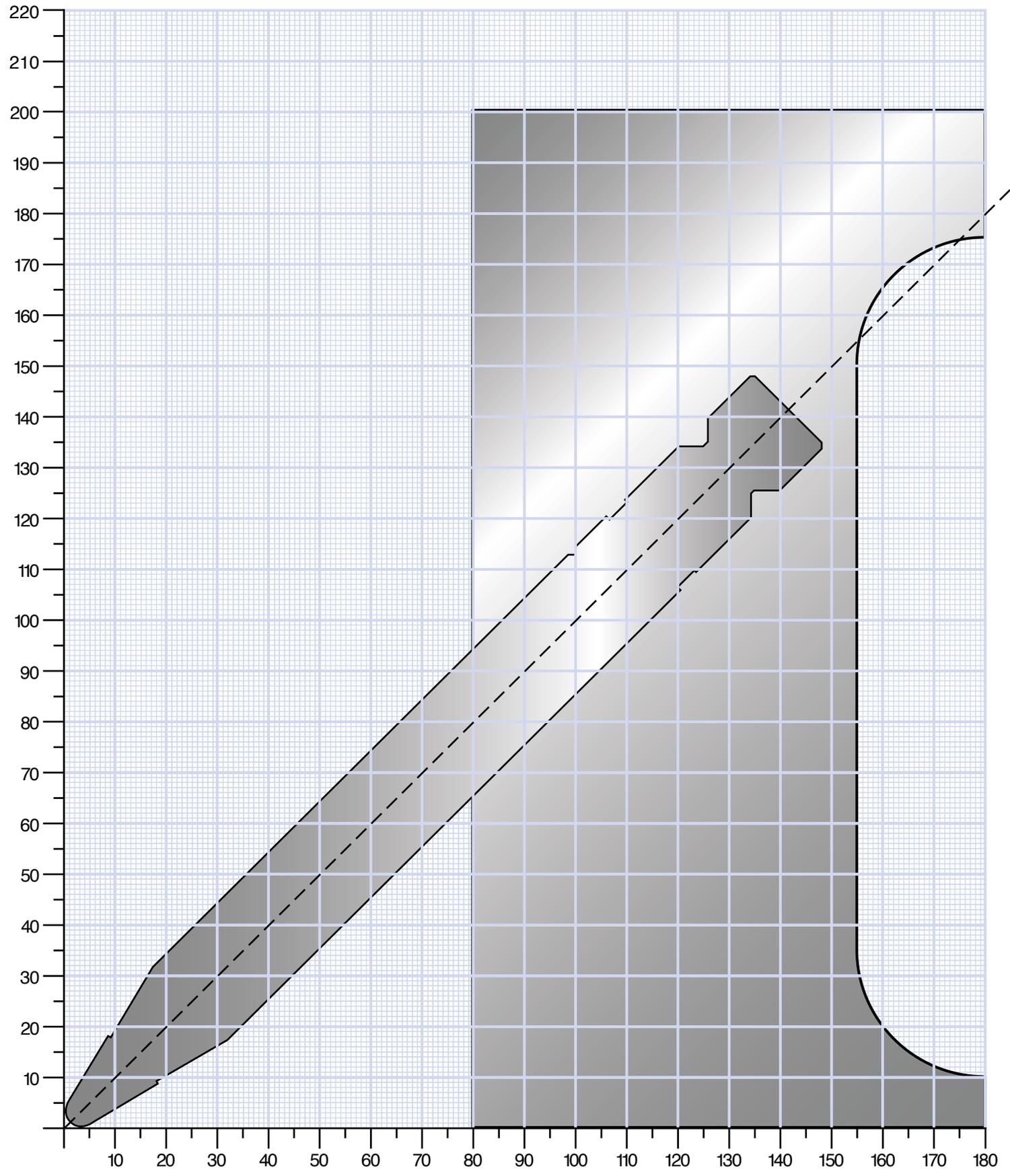


WILA STYLE

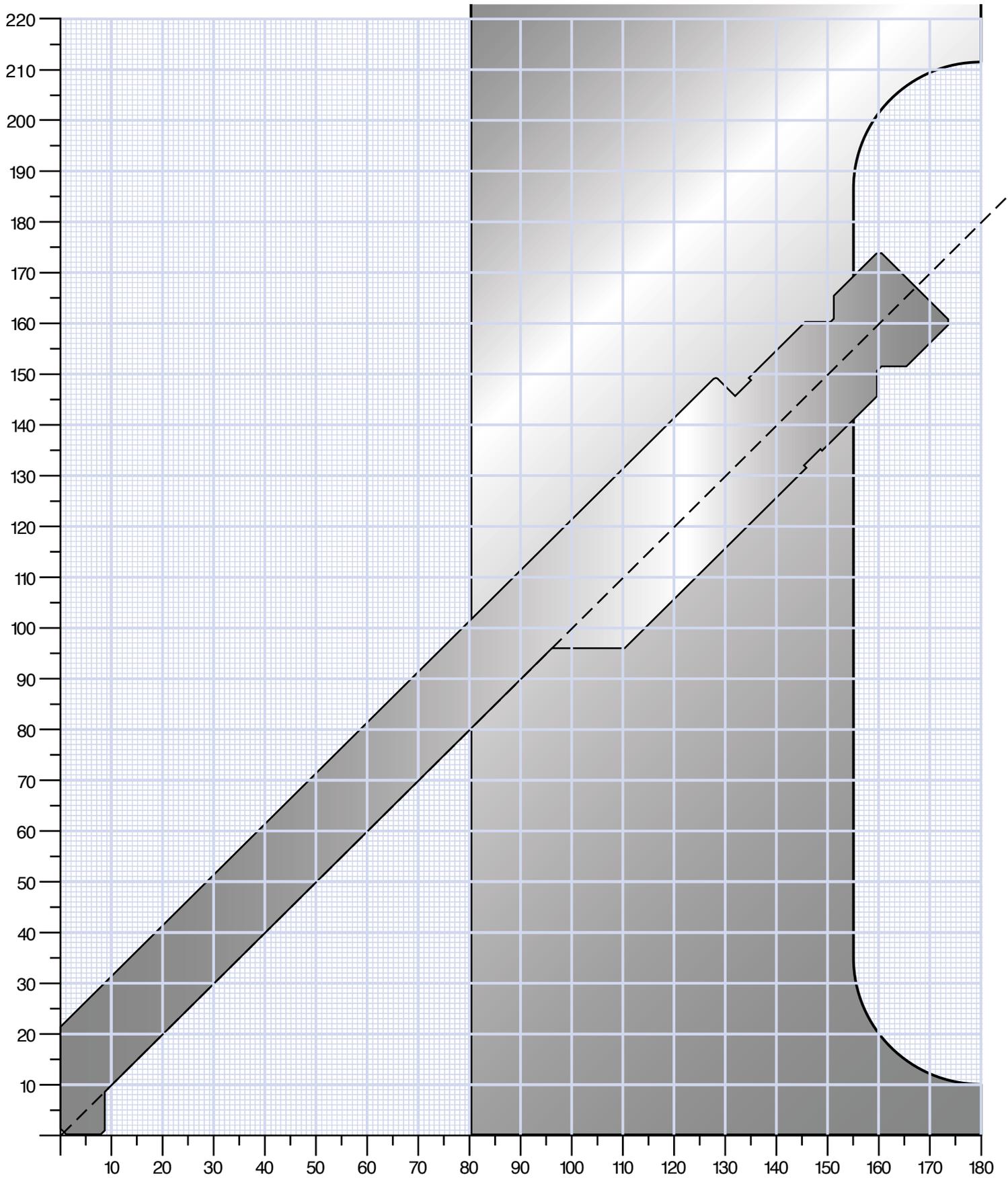
SP025 BEND LIMIT GRAPH



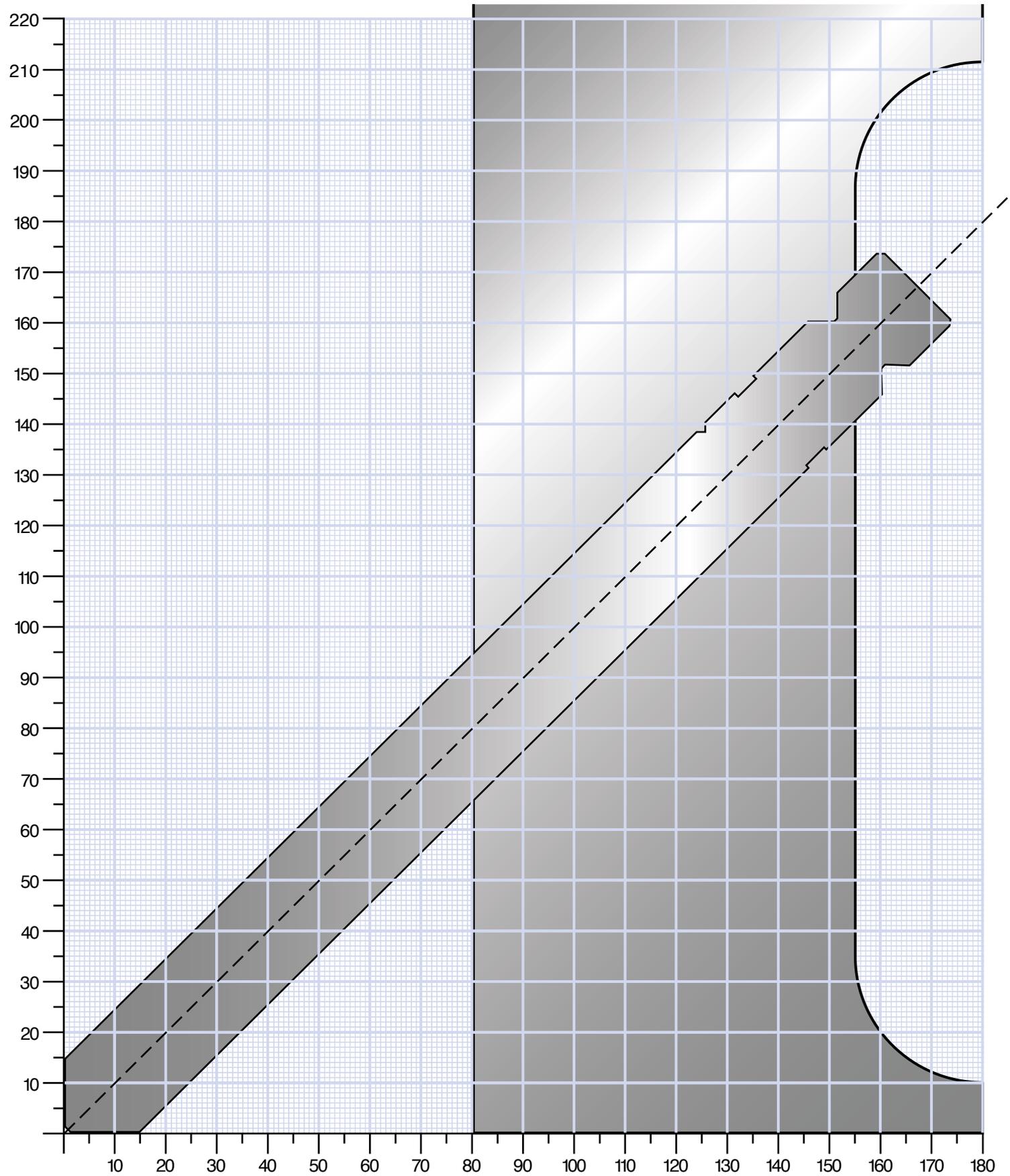
SP029 BEND LIMIT GRAPH



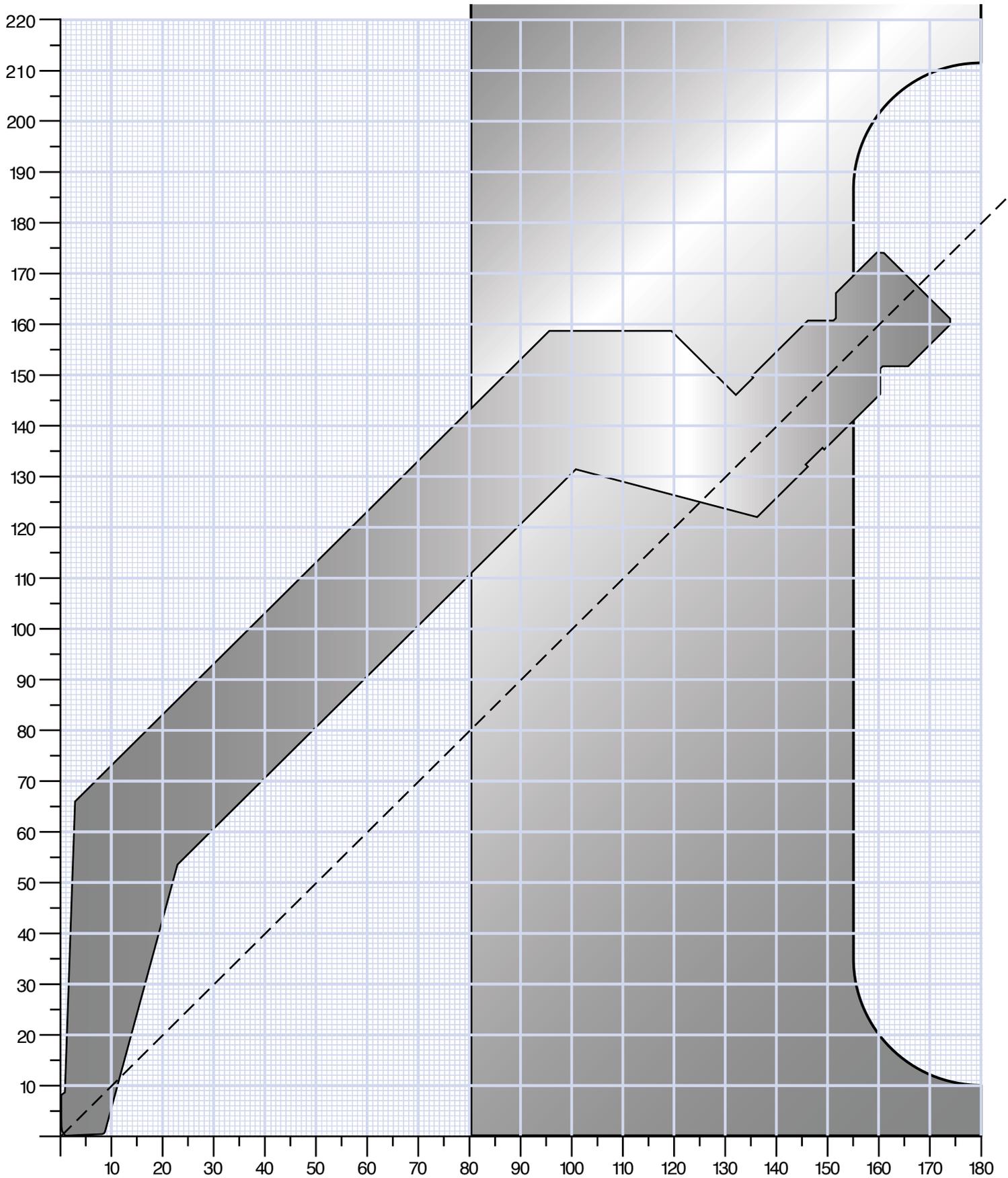
SP035 BEND LIMIT GRAPH



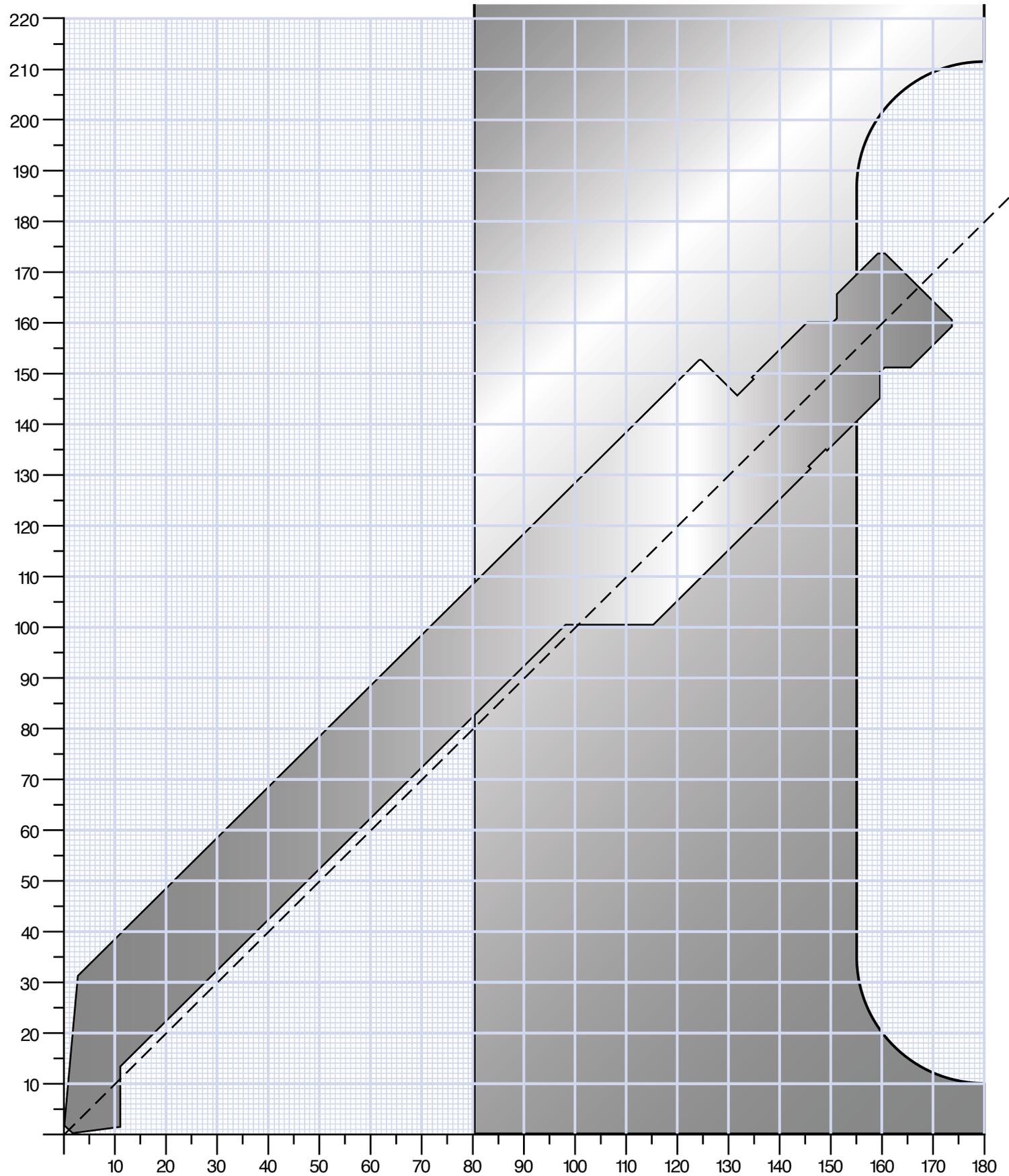
SP036 BEND LIMIT GRAPH



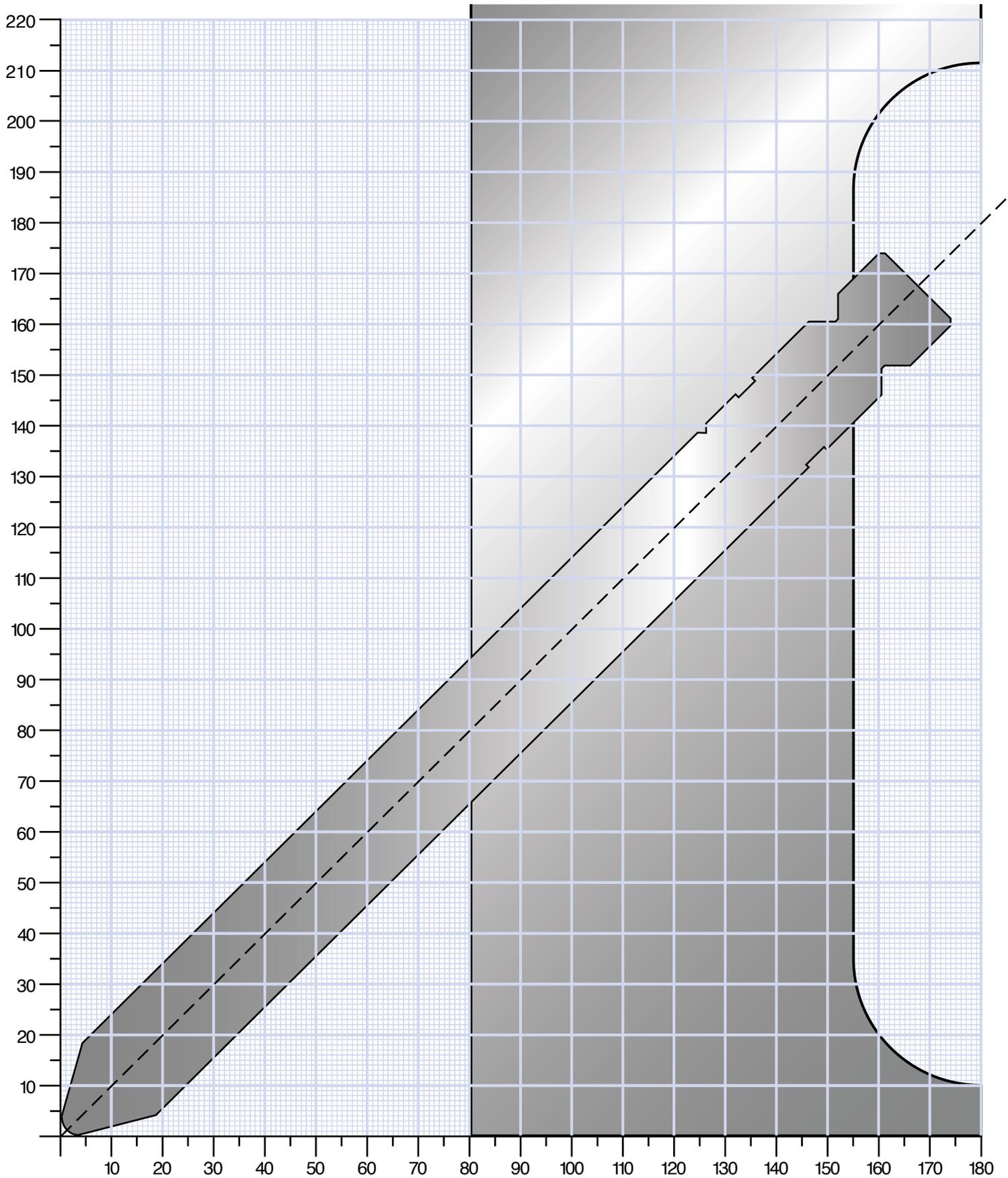
SP033 BEND LIMIT GRAPH



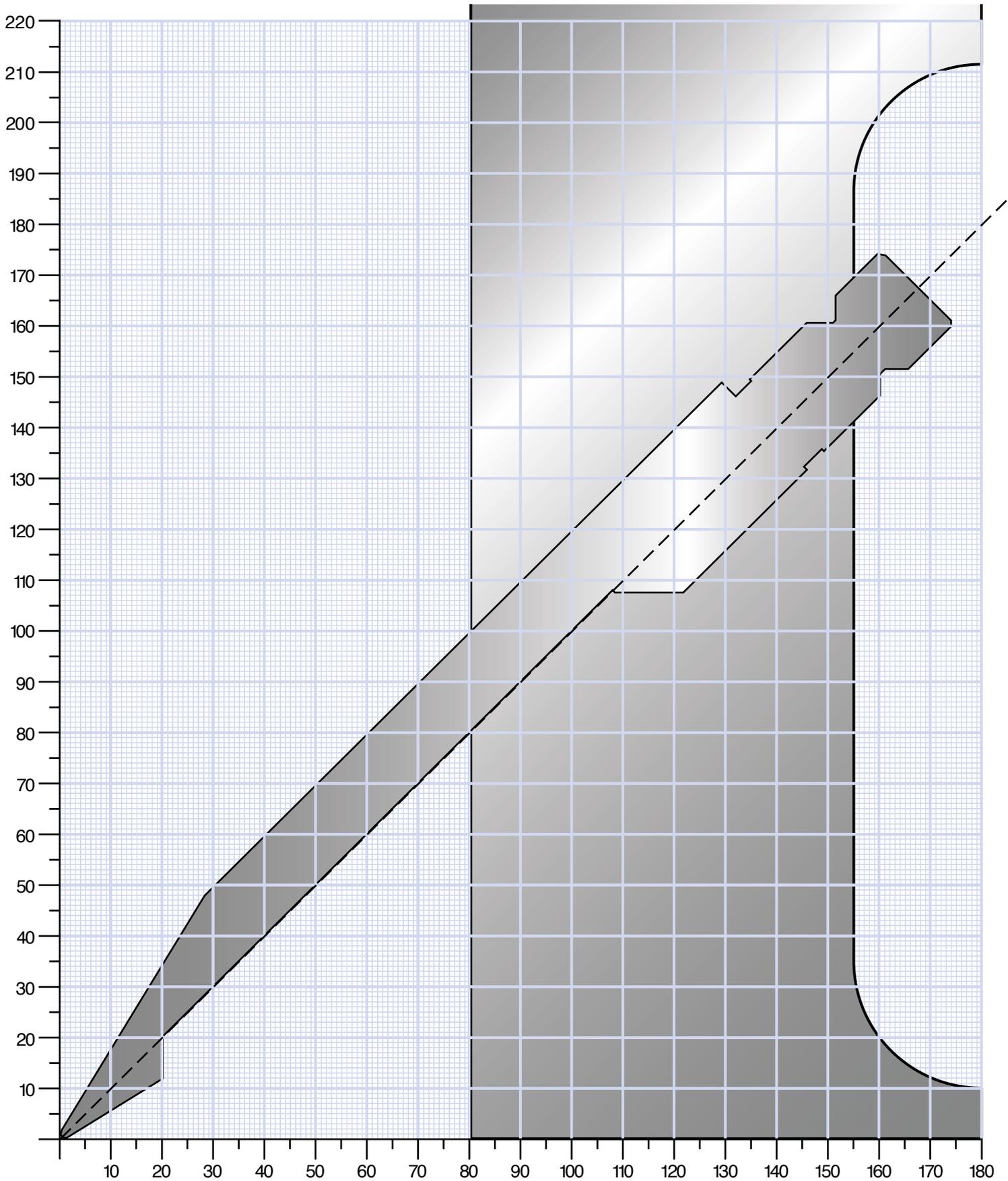
SP032 BEND LIMIT GRAPH



SP034 BEND LIMIT GRAPH

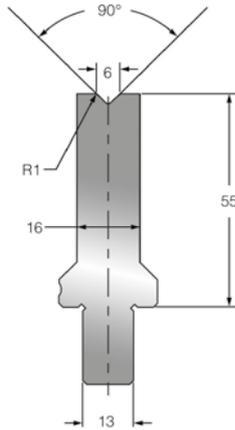


SP031 BEND LIMIT GRAPH

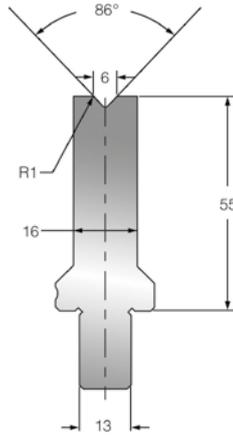


WILA STYLE

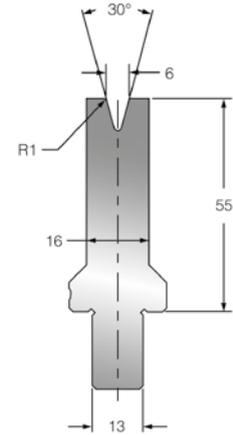
DIE V-OPENING 6MM



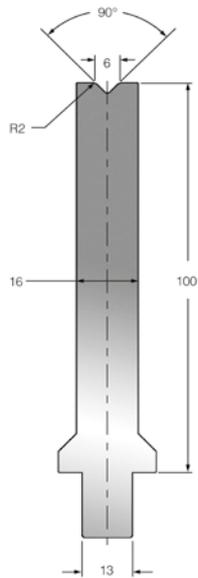
SM041



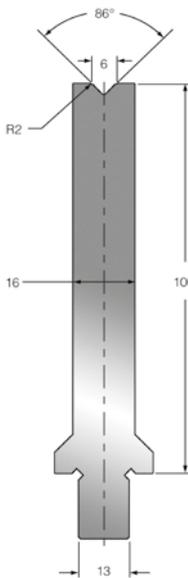
SM021



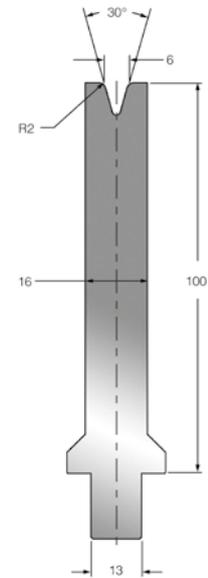
SM061



SM341



SM321

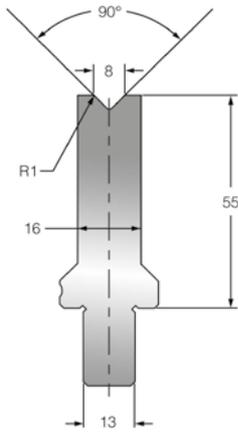


SM361

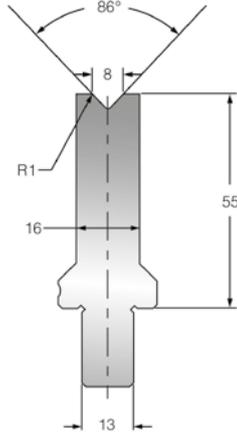
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	PossSble lenghts
SM041	OZU-041	120	9,5	6	90°	55	515 / 200 / 550 sect / 200sect
SM021	OZU-021	120	9,5	6	86°	55	515 / 200 / 550 sect / 200sect
SM061	OZU-061	80	9,5	6	30°	55	515 / 200 / 550 sect / 200sect
SM341	OZU-341	120	15,1	6	90°	100	515 / 200 / 550 sect / 200sect
SM321	OZU-321	120	15,1	6	86°	100	515 / 200 / 550 sect / 200sect
SM361	OZU-361	80	15,2	6	30°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

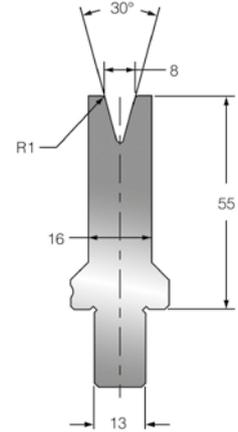
DIE V-OPENING 8MM



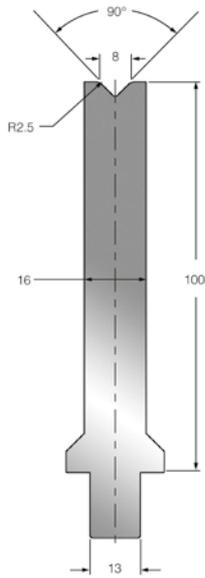
SM042



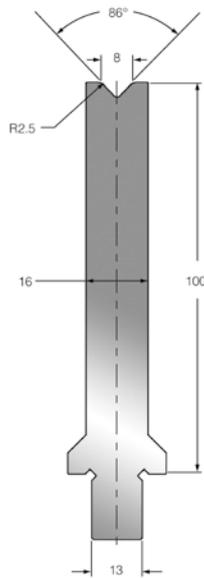
SM010



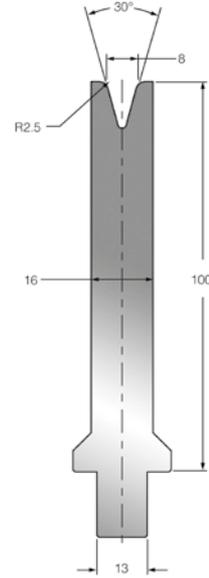
SM051



SM342



SM310

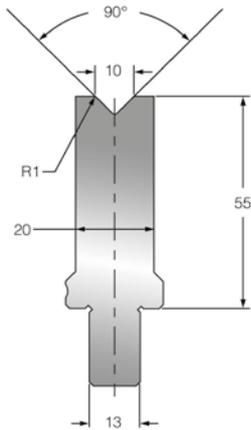


SM351

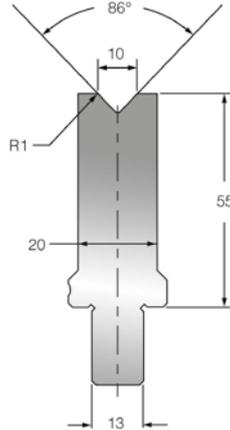
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	PossSble lengths
SM042	OZU-042	120	9,5	8	90°	55	515 / 200 / 550 sect / 200sect
SM010	OZU-010	120	9,5	8	86°	55	515 / 200 / 550 sect / 200sect
SM051	OZU-051	80	9,5	8	30°	55	515 / 200 / 550 sect / 200sect
SM342	OZU-342	120	15,1	8	90°	100	515 / 200 / 550 sect / 200sect
SM310	OZU-310	120	15,1	8	86°	100	515 / 200 / 550 sect / 200sect
SM351	OZU-351	80	15	8	30°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

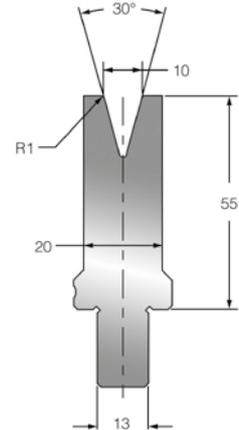
DIE V-OPENING 10MM



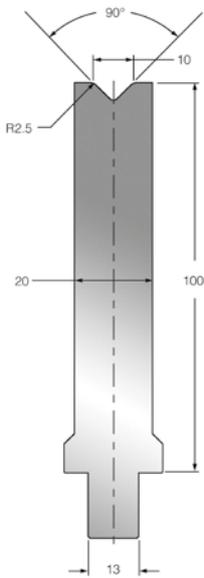
SM043



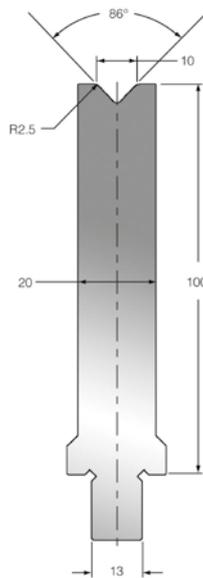
SM022



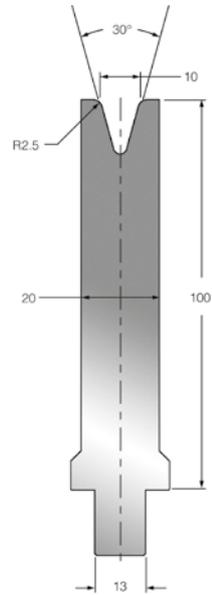
SM062



SM343



SM322

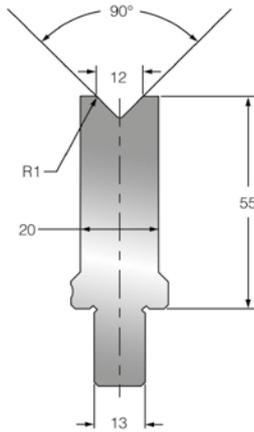


SM362

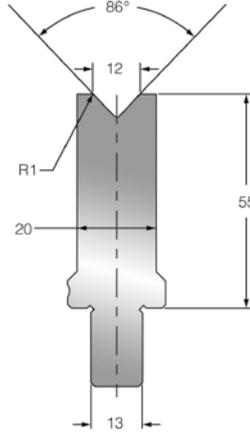
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	PossSble lenghts
SM043	OZU-043	120	11	10	90°	55	515 / 200 / 550 sect / 200sect
SM022	OZU-022	120	11	10	86°	55	515 / 200 / 550 sect / 200sect
SM062	OZU-062	80	10,5	10	30°	55	515 / 200 / 550 sect / 200sect
SM343	OZU-343	120	17,9	10	90°	100	515 / 200 / 550 sect / 200sect
SM322	OZU-322	120	17,9	10	86°	100	515 / 200 / 550 sect / 200sect
SM362	OZU-362	80	17,7	10	30°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

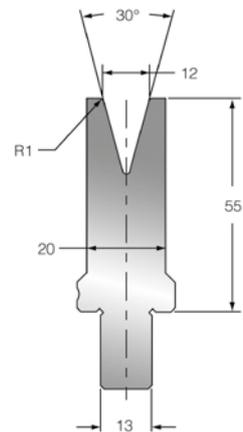
DIE V-OPENING 12MM



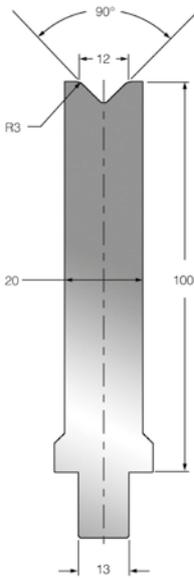
SM044



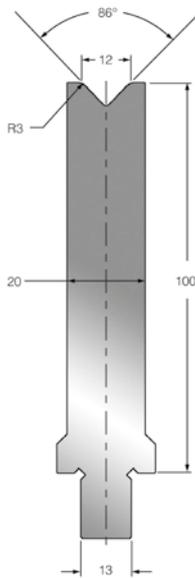
SM011



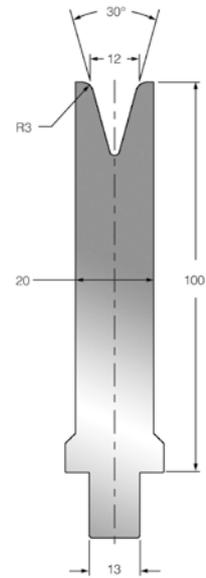
SM052



SM344



SM311

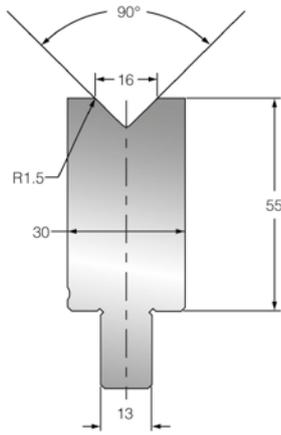


SM352

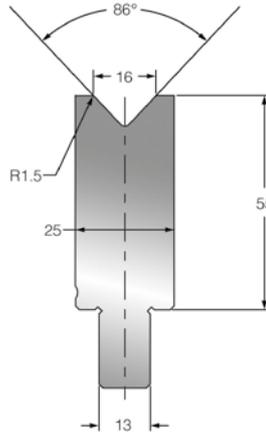
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	PossSble lengths
SM044	OZU-044	120	11	12	90°	55	515 / 200 / 550 sect / 200sect
SM011	OZU-011	120	11	12	86°	55	515 / 200 / 550 sect / 200sect
SM052	OZU-052	80	10	12	30°	55	515 / 200 / 550 sect / 200sect
SM344	OZU-344	120	17,8	12	90°	100	515 / 200 / 550 sect / 200sect
SM311	OZU-311	120	17,8	12	86°	100	515 / 200 / 550 sect / 200sect
SM352	OZU-352	80	17,4	12	30°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

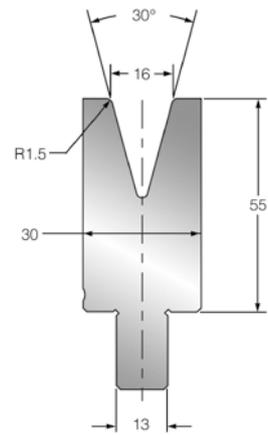
DIE V-OPENING 16MM



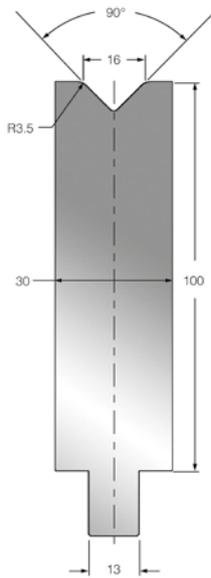
SM045



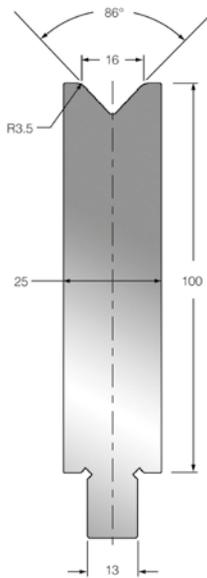
SM012



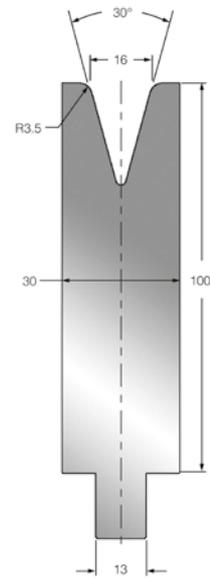
SM053



SM345



SM312

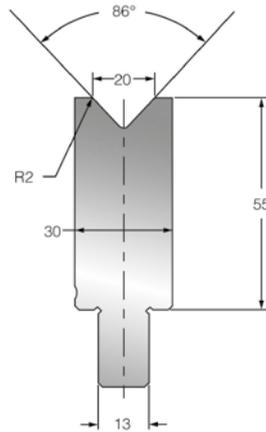


SM353

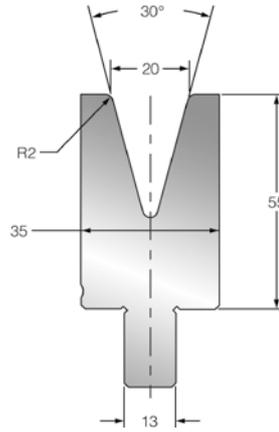
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
SM045	OZU-045	120	15	16	90°	55	515 / 200 / 550 sect / 200sect
SM012	OZU-012	120	13	16	86°	55	515 / 200 / 550 sect / 200sect
SM053	OZU-053	80	13,5	16	30°	55	515 / 200 / 550 sect / 200sect
SM345	OZU-345	120	25,8	16	90°	100	515 / 200 / 550 sect / 200sect
SM312	OZU-312	120	19,3	16	86°	100	515 / 200 / 550 sect / 200sect
SM353	OZU-353	80	24,2	16	30°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

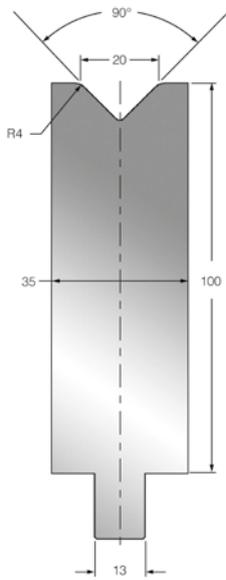
DIE V-OPENING 20MM



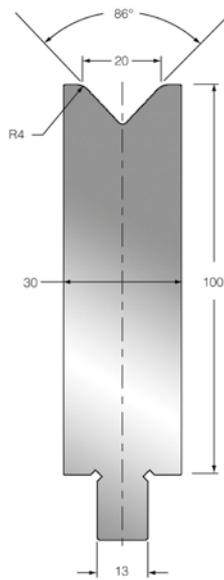
SM023



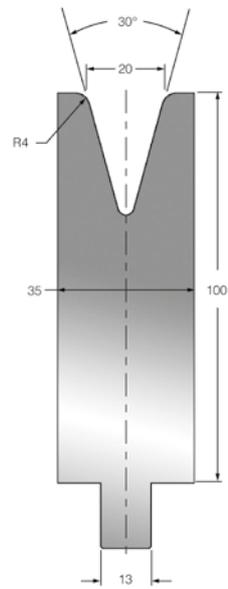
SM063



SM346



SM323

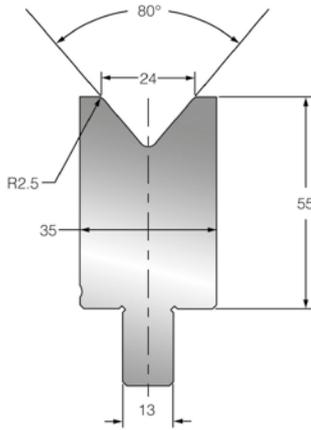


SM363

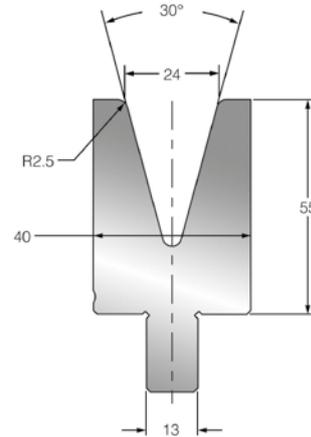
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	PossSBle lenghts
SM023	OZU-023	120	15	20	86°	55	515 / 200 / 550 sect / 200sect
SM063	OZU-063	80	15	20	30°	55	515 / 200 / 550 sect / 200sect
SM346	OZU-346	120	28,7	20	90°	100	515 / 200 / 550 sect / 200sect
SM323	OZU-323	120	24,9	20	86°	100	515 / 200 / 550 sect / 200sect
SM363	OZU-363	80	27,2	20	30°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

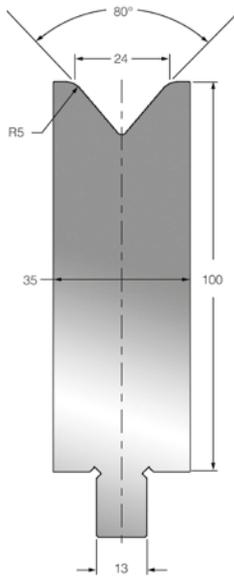
DIE V-OPENING 24MM



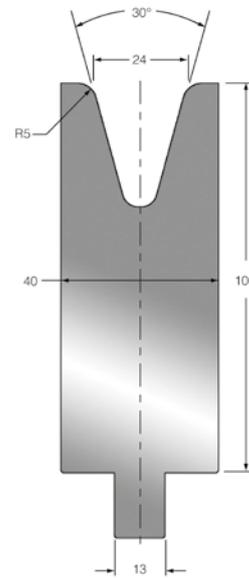
SM013



SM054



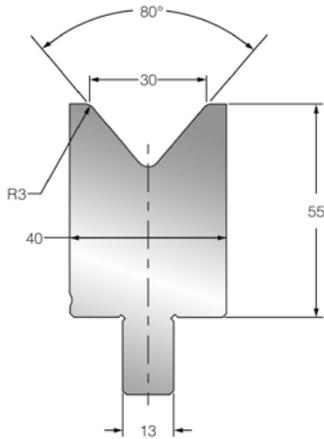
SM313



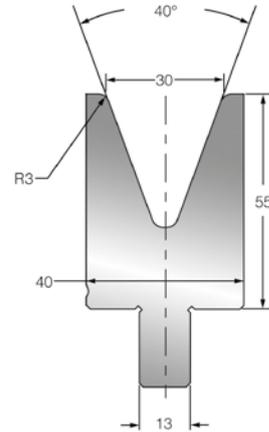
SM354

Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	PossSBle lengths
SM013	OZU-013	125	16	24	80°	55	515 / 200 / 550 sect / 200sect
SM054	OZU-054	80	16	24	30°	55	515 / 200 / 550 sect / 200sect
SM313	OZU-313	125	26,5	24	80°	100	515 / 200 / 550 sect / 200sect
SM354	OZU-354	80	30,1	24	30°	100	515 / 200 / 550 sect / 200sect

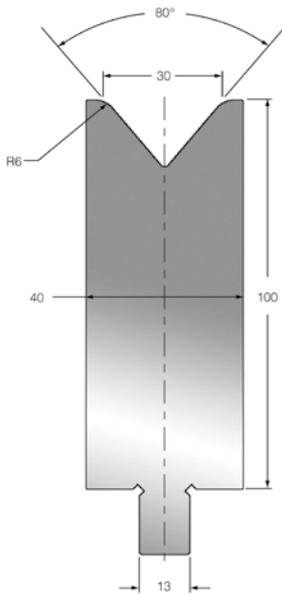
DIE V-OPENING 30MM



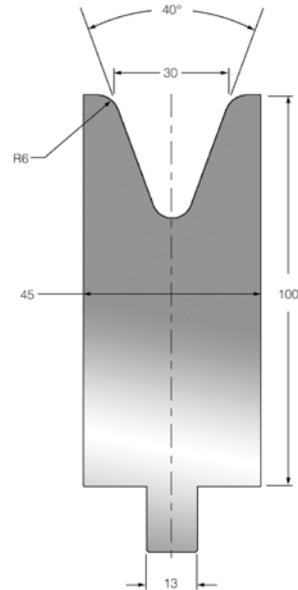
SM014



SM031



SM324

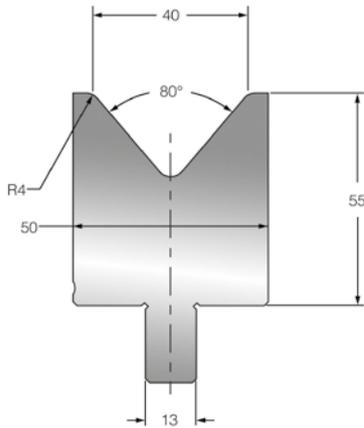


SM328

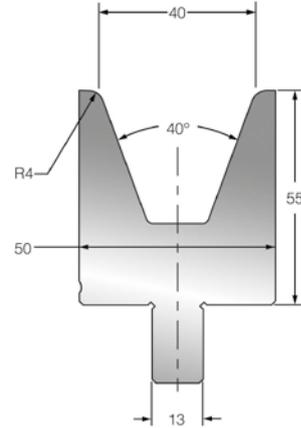
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
SM014	OZU-014	125	17	30	80°	55	515 / 200 / 550 sect / 200sect
SM031	OZU-031	70	15	30	40°	55	515 / 200 / 550 sect / 200sect
SM324	OZU-324	125	32,1	30	80°	100	515 / 200 / 550 sect / 200sect
SM328	OZU-328	100	33,1	30	40°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

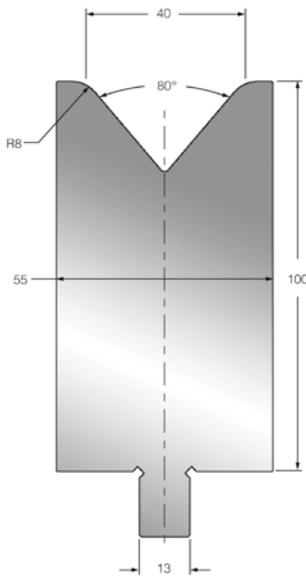
DIE V-OPENING 40MM



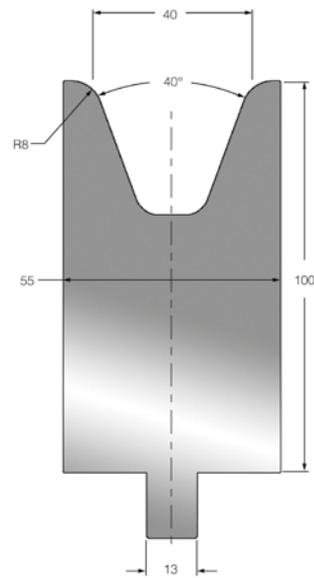
SM015



SM032



SM325

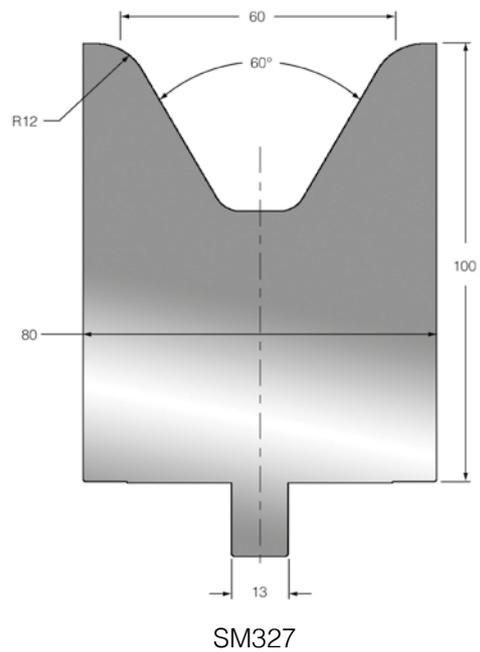
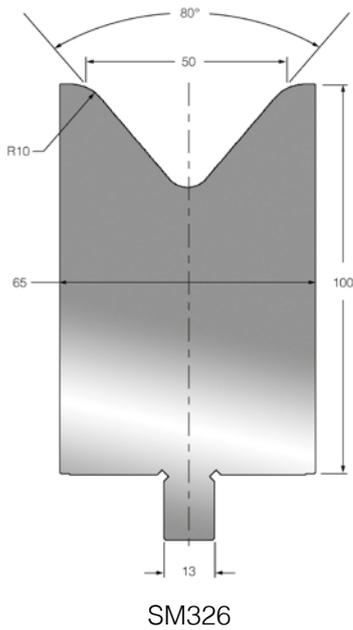
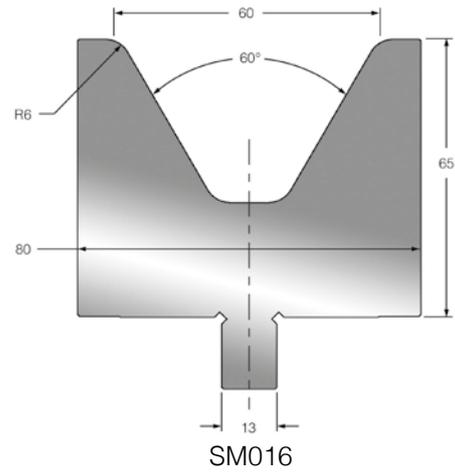
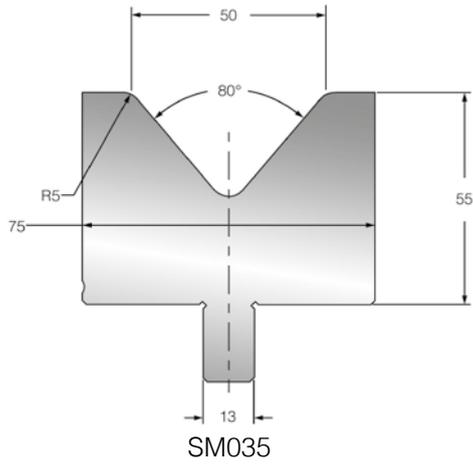


SM329

Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
SM015	OZU-015	125	21	40	80°	55	515 / 200 / 550 sect / 200sect
SM032	OZU-032	80	17	40	40°	55	515 / 200 / 550 sect / 200sect
SM325	OZU-325	125	41,9	40	80°	100	515 / 200 / 550 sect / 200sect
SM329	OZU-329	125	54,1	40	40°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

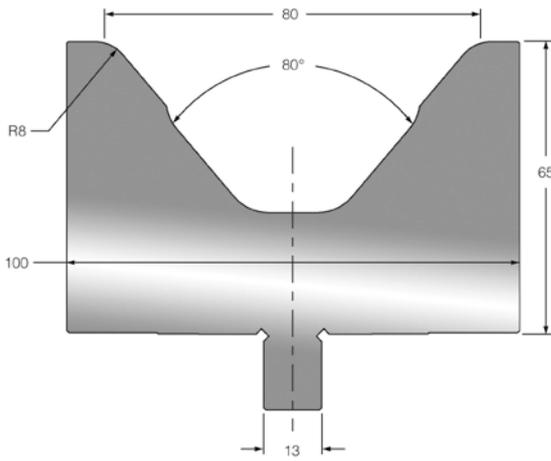
DIE V-OPENING 50&60MM



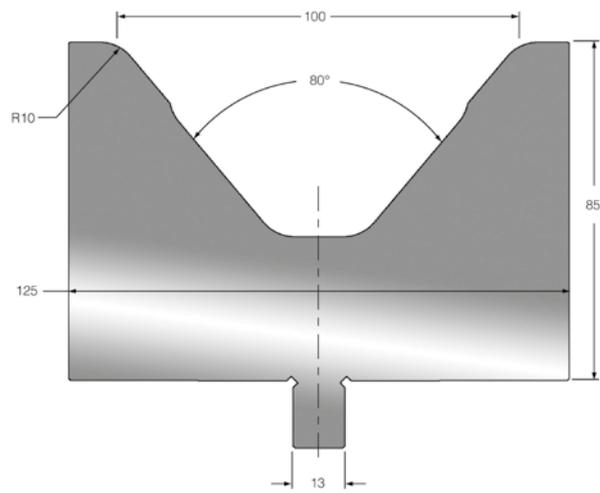
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	PossSble lengths
SM035	OZU-035	150	29	50	80°	55	515 / 200 / 550 sect / 200sect
SM326	OZU-326	150	47,8	50	80°	100	515 / 200 / 550 sect / 200sect
SM016	OZU-016	125	32	60	60°	65	515 / 200 / 550 sect / 200sect
SM327	OZU-327	125	54,1	60	60°	100	515 / 200 / 550 sect / 200sect

WILA STYLE

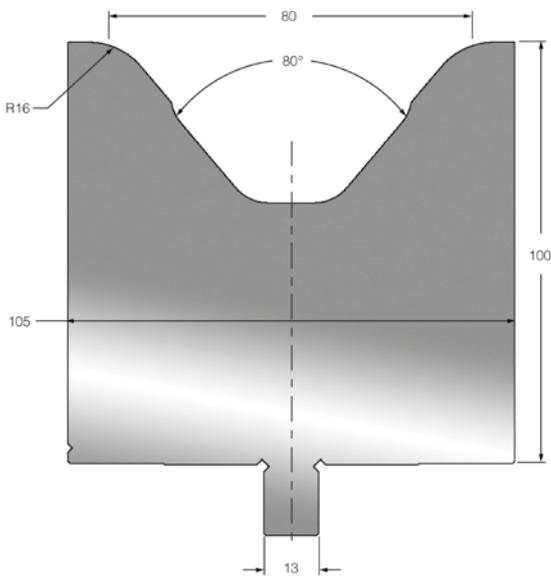
DIE V-OPENING 80&100MM



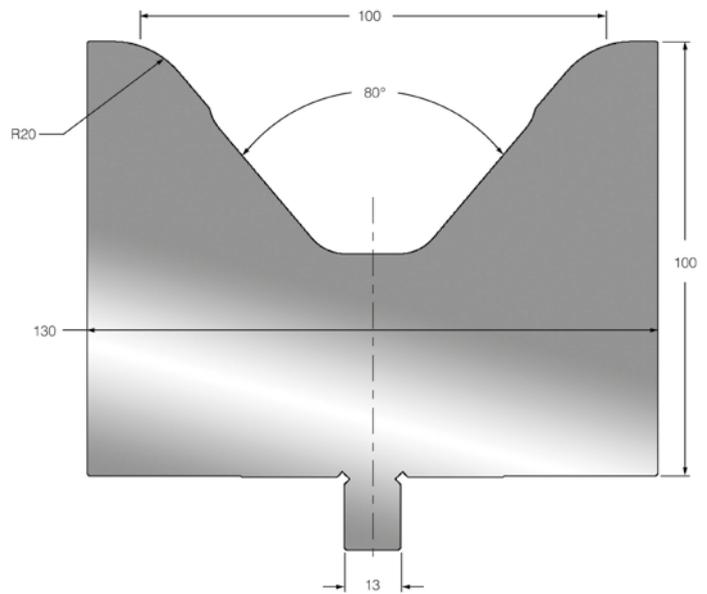
SM017



SM018



SM317

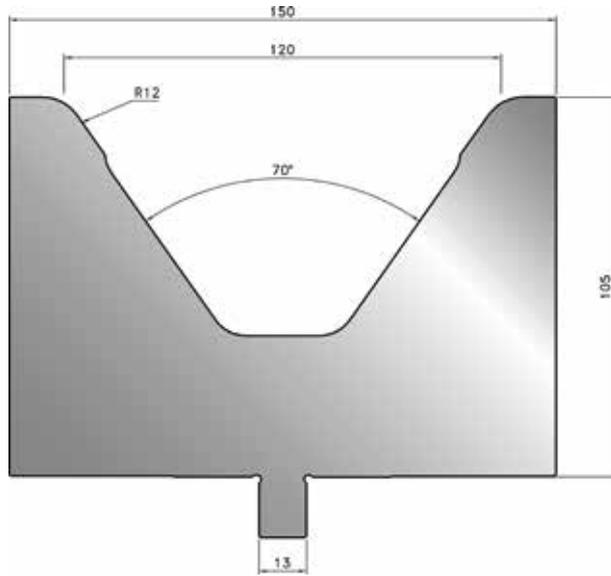


SM318

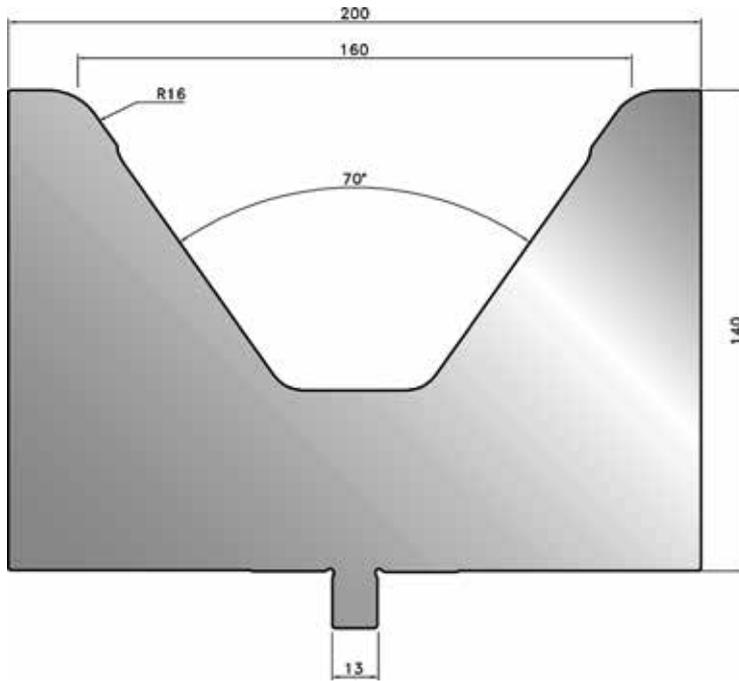
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	PossSBle lenghts
SM017	OZU-017	150	38,5	80	80°	65	515 / 200
SM317	OZU-317	150	70,6	80	80°	100	515 / 200
SM018	OZU-018	150	62,5	100	80°	65	515 / 200
SM318	OZU-318	150	81,5	100	80°	100	515 / 200

WILA STYLE

DIE V-OPENING 120&160MM



SM0070

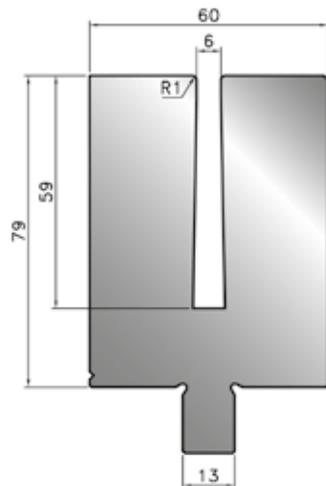


SM071

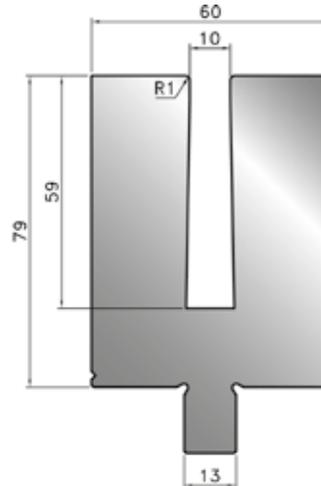
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
SM070	OZU-070	250	88,4	120	70°	105	515 / 200
SM071	OZU-071	250	153,8	160	70°	140	515 / 200

WILA STYLE

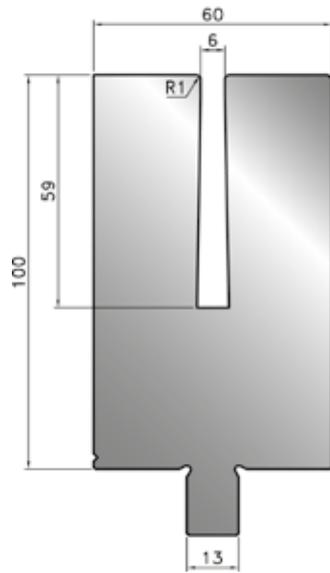
HEMMING DIES



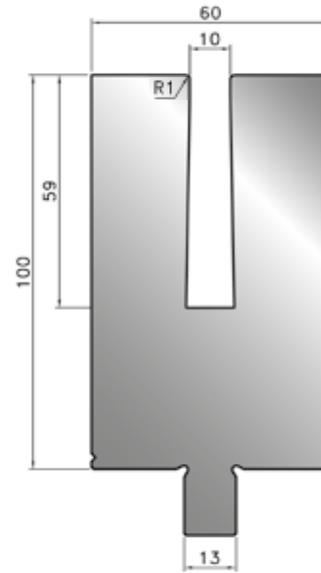
SM082



SM083



SM382

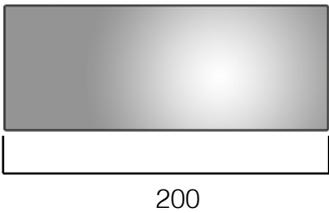
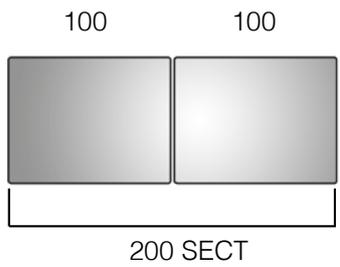
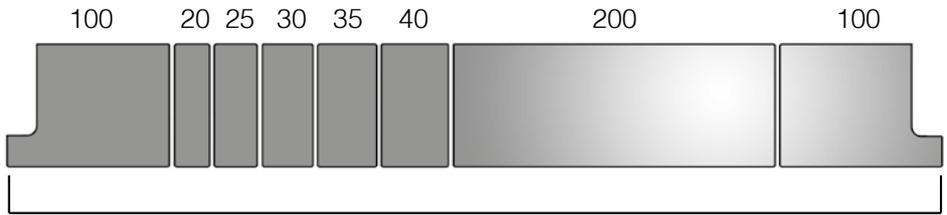


SM381

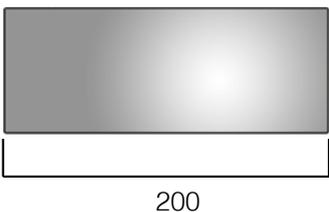
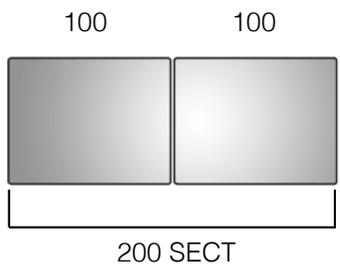
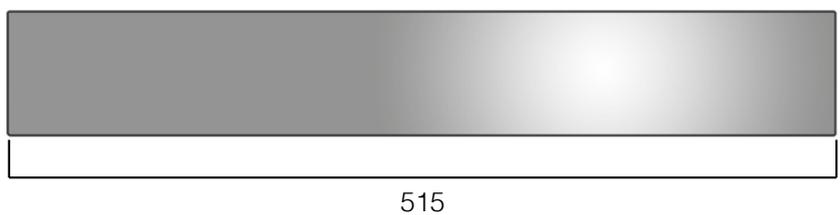
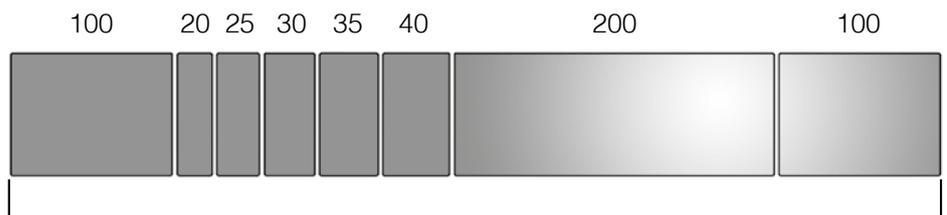
Schiavi Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Max Loading T/m flattening	Weight Kg/m	U Opening	Height	Possible lengths
SM082	OZU-082	50	100	36	6	79	515 / 200
SM083	OZU-083	50	100	35	10	79	515 / 200
SM381	OZU-381	50	100	44,7	10	100	515 / 200
SM382	OZU-382	50	100	45	6	100	515 / 200

SYSTEM DIVISION WITH TOOLS

PUNCHES



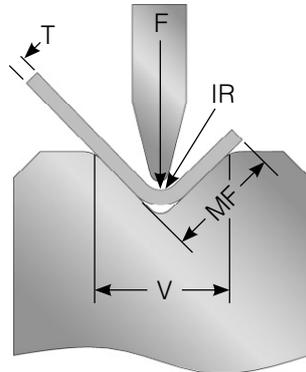
DIES



WILA STYLE

PRESS FORCE TABLE

T = Material Thickness
 F = Press Force (kN/m)
 IR = Inside Radius
 MF = Minimum Flange
 V = Die V Opening



Notes	
* Optimum Die	
• F in kN	
• T, MF, V, IR in mm	

Material 400 N / mm ² Mild Steel																		
		6	8	10	12	16	20	24	30	40	50	60	70	80	90	100	120	V
		4.5	6	7.5	9	12	15	18	22.5	30	37.5	45	52.5	60	67.5	75	90	MF
		1	1.3	1.6	1.9	2.6	3.2	3.8	4.8	6.4	8	9.6	11	13	14	16	19	IR
Material Thickness	0.75	52*	39	31	26													
	1	93	70*	56	47	35												
	1.25	145	109	87*	73	55	44											
	1.5	209	157	126	105*	79	63											
	1.75		214	171	143*	107	86	71										
	2			223	186	140*	112	93										
	2.5				291	218	175*	145	116									
	3					314	251	209*	168	126								
	3.5					428	342	285	228*	171	137							
	4						447	372	298*	223	179	149						
	4.5						566	471	377	283*	226	189	162					
	5								466	349*	279	233	200	175				
6								670	503	402*	335	287	251	223				
7									684	547*	456*	391	342	304	274			
8										715	596*	511*	447	397	358	298		
10												798*	698*	621	559	466		
12													1005	894*	804*	670		

Material 700 N / mm ² Stainless Steel																		
		6	8	10	12	16	20	24	30	40	50	60	70	80	90	100	120	V
		4.5	6	7.5	9	12	15	18	22.5	30	37.5	45	52.5	60	67.5	75	90	MF
		1	1.3	1.6	1.9	2.6	3.2	3.8	4.8	6.4	8	9.6	11	13	14	16	19	IR
Material Thickness	0.75	87*	65	52	44													
	1	155	116*	93	78	58												
	1.25	242	182	145*	121	91	73											
	1.5	349	262	209	175*	131	105											
	1.75		356	285	238*	178*	143	119										
	2			372	310	233*	186	155										
	2.5				485	364	291*	242	194									
	3					524	419	349*	279	209								
	3.5						570	475	380*	285	228							
	4							621	497*	372	298	248						
	4.5								628	471*	377	314	269					
	5									582*	466	388	333	291				
6									838	670*	559	479	419					
7										912*	760*	652	570	507				
8										1192	993*	851*	745	662	596			
10												1330*	1164*	1034	931	776		
12													1675	1490*	1340*	1118		

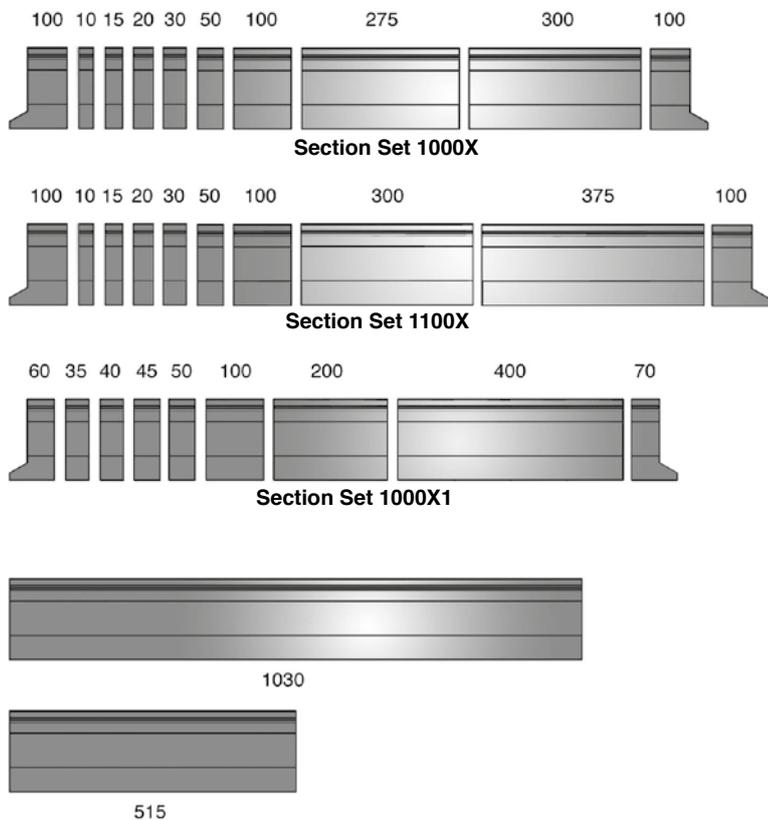




PRESS BRAKE TOOLING
BYSTRONIC STYLE

STANDARD PUNCH & DIE LENGTHS

Standard Punch Lengths



Features:

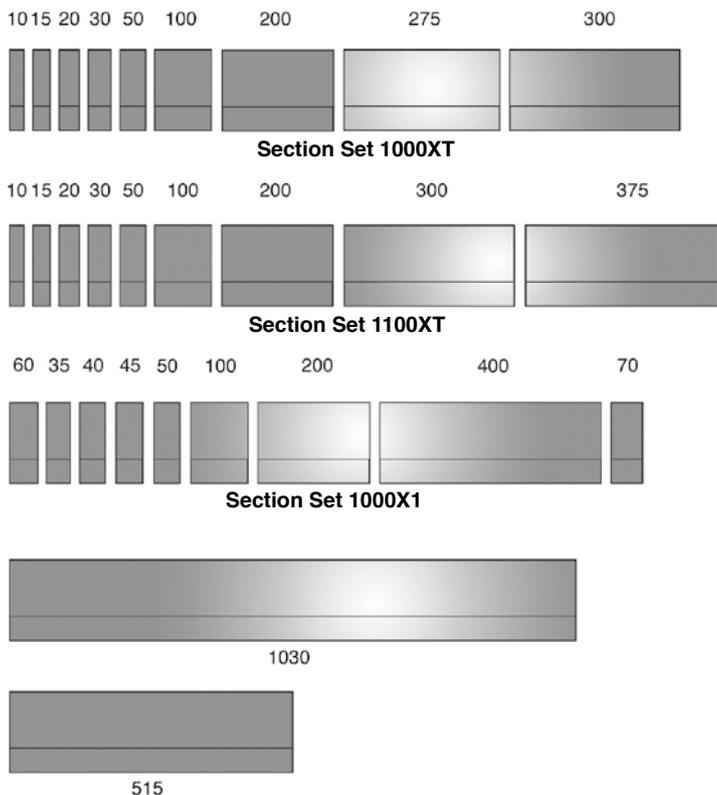
- All punches made from 42CrMo4
- Sectionalised set includes 2 ear pieces (horns)
- Punches are induction hardened to 58HRC
- Minimum hardness depth on punch tip = 4mm

To order put the required number after the part no.

XXXXXXXXXX - 1000X
 or - 1100X
 or - 1000X1

e.g SB0588010 - 1100X

Standard Die Lengths



Features:

- Dies induction hardened to 58HRC on working areas
- Minimum hardness depth = 4mm
- All dies made from 42CrMo4

To order put the required number after the part no.

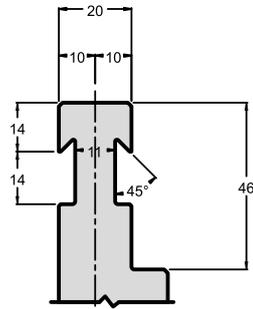
XXXXXXXXXX - 1000XT
 or - 1100XT
 or - 1000X1

e.g SB0588010 - 1100X

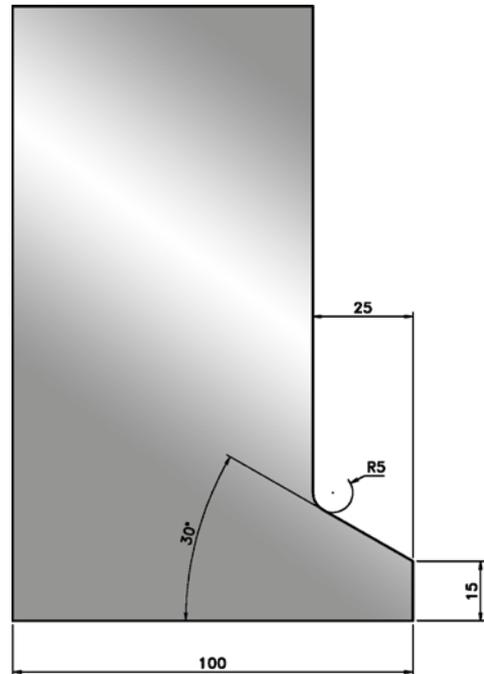
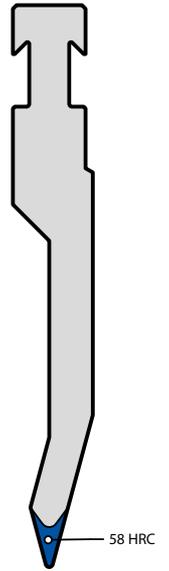
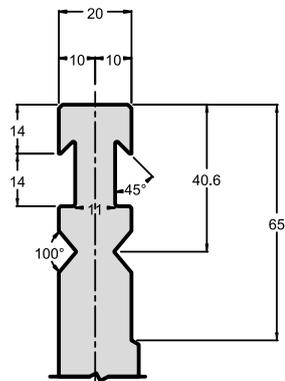
PUNCHES



Bystronic R

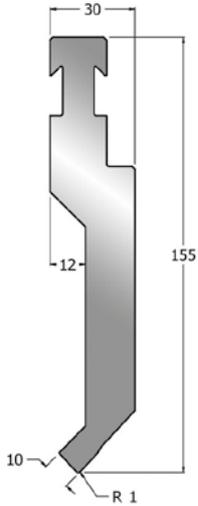


Bystronic RFA

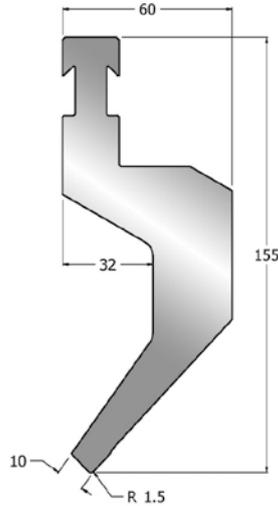


BYSTRONIC STYLE

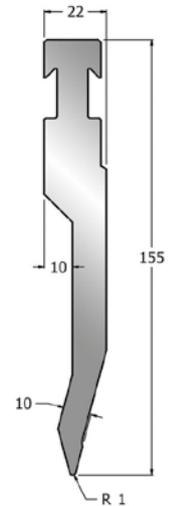
R-STYLE PUNCHES 155MM



85/88° Gooseneck
SB0185010
SB0188010
Max Force: 1000 kN/m
Bystronic Profile P2R

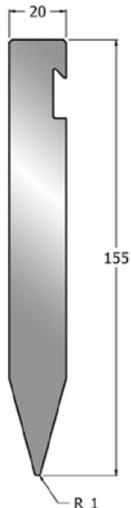


85/88° Swan Neck
SB0085015
SB0088015
Max Force: 700 kN/m
Bystronic Profile P4R



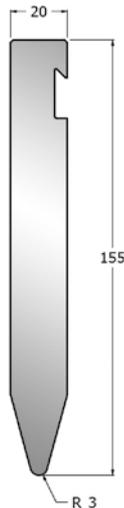
30° Acute Goose Neck
SB0230010

Max Force: 1000 kN/m
Bystronic Profile P5R



30° Pointed
SB0430010

Max Force: 1500 kN/m
Bystronic Profile P6R



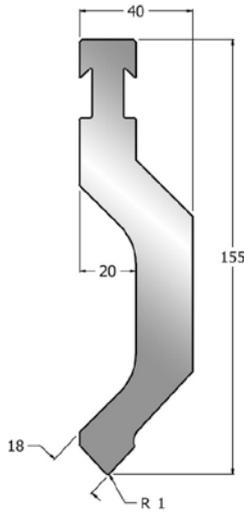
30° Pointed
SB0430030

Max Force: 1500 kN/m
Bystronic Profile P7R

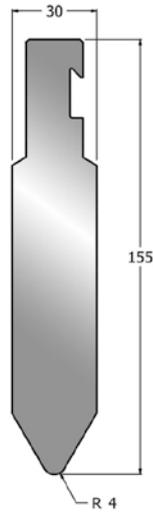
For different Radii & Relief consult Schiavi

BYSTRONIC STYLE

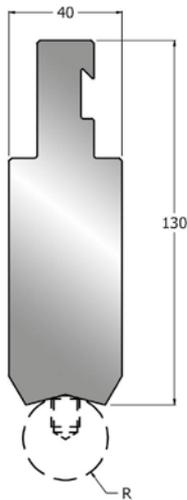
R-STYLE PUNCHES 155MM



85°/88° Shallow Swan Neck
 SB0585010
 SB0588010
 Max Force: 1000 kN/m
 Bystronic Profile P8R

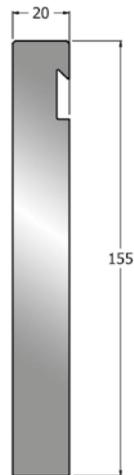


60° Pointed
 SB0460040
 Max Force: 2000 kN/m
 Bystronic Profile P9R

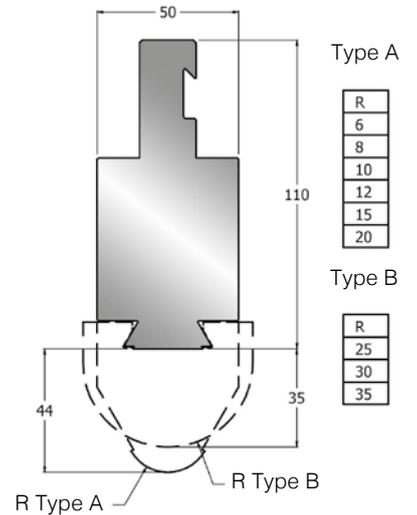


R
14
17.5
20
22.5
25
27.5
30
32.5
35
40

Radius Tools Available
 Consult Schiavi for more
 details

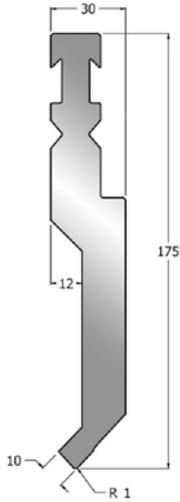


Flattening Tools Available
 Consult Schiavi for more
 details

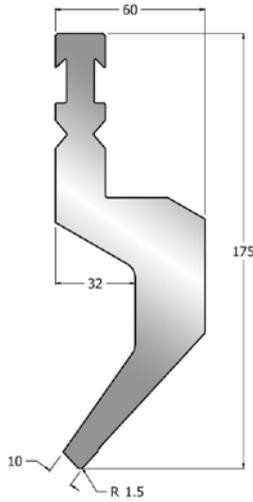


Keyed Radius Tools Available
 Consult Schiavi for more
 details

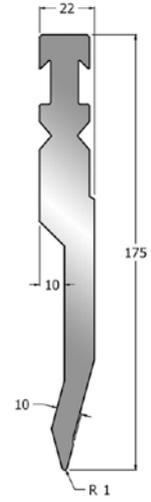
RFA-STYLE PUNCHES 175MM



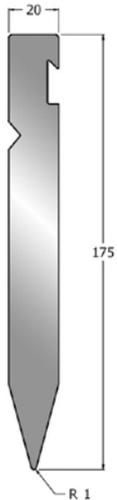
85°/88° Gooseneck
 SB1185010
 SB1188010
 Max Force: 1000 kN/m
 Bystronic Profile P2RFA



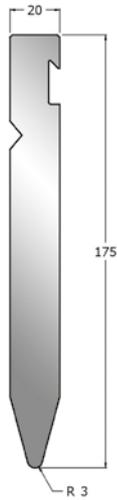
85°/88° Swan Neck
 SB1085015
 SB1088015
 Max Force: 700 kN/m
 Bystronic Profile P4RFA



30° Acute Goose Neck
 SB1230010
 Max Force: 1000 kN/m
 Bystronic Profile P5RFA



30° Pointed
 SB1430010
 Max Force: 1500 kN/m
 Bystronic Profile P6RFA

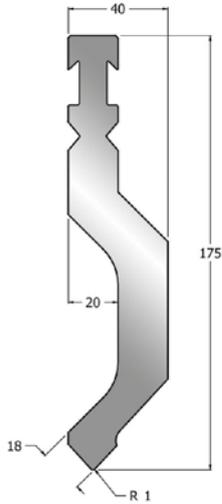


30° Pointed
 SB1430030
 Max Force: 1500 kN/m
 Bystronic Profile P7RFA

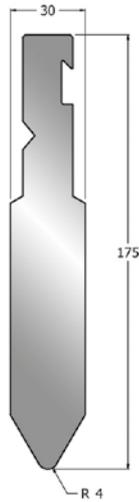
For different Radii & Relief consult Schiavi

BYSTRONIC STYLE

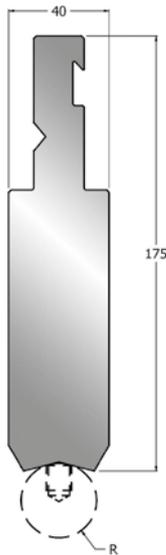
RFA-STYLE PUNCHES 175MM



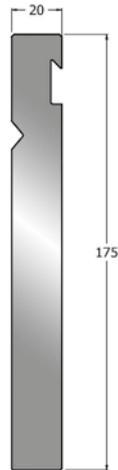
85°/88° Shallow Swan Neck
 SB1585010
 SB1588010
 Max Force: 1000 kN/m
 Bystronic Profile P8RFA



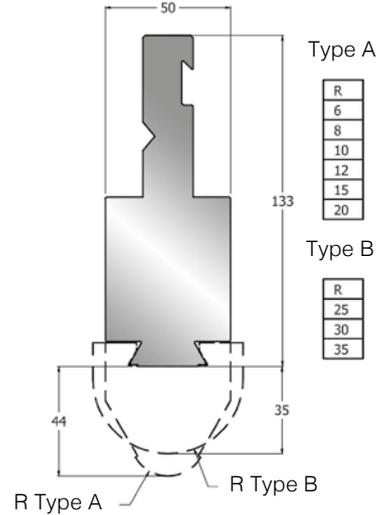
60° Pointed
 SB1460040
 Max Force: 1600 kN/m
 Bystronic Profile P9RFA



Radius Tools Available
 Consult Schiavi for more
 details



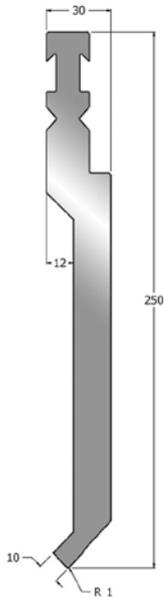
Flattening Tools Available
 Consult Schiavi for more
 details



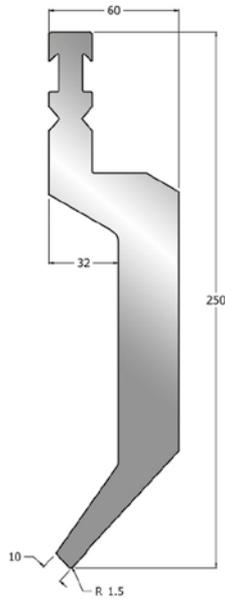
Keyed Radius Tools Available
 Consult Schiavi for more
 details

BYSTRONIC STYLE

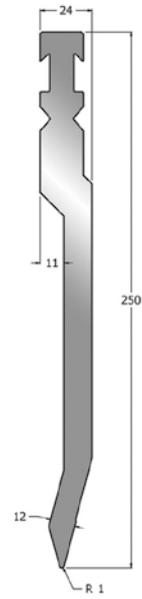
RFA-STYLE PUNCHES 250MM



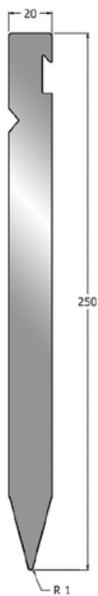
85°/88° Gooseneck
SB2185010
SB2188010
Max Force: 1000 kN/m
Bystronic Profile P2RFA



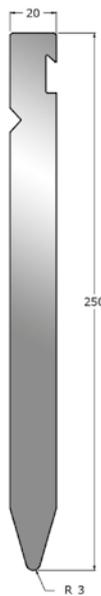
85°/88° Swan Neck
SB2085015
SB2088015
Max Force: 600 kN/m
Bystronic Profile P4RFA



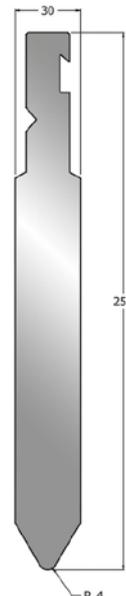
30° Acute Goose Neck
SB2230010
Max Force: 750 kN/m
Bystronic Profile P5RFA



30° Pointed
SB2430010
Max Force: 1400 kN/m
Bystronic Profile P6RFA



30° Pointed
SB2430030
Max Force: 1400 kN/m
Bystronic Profile P7RFA

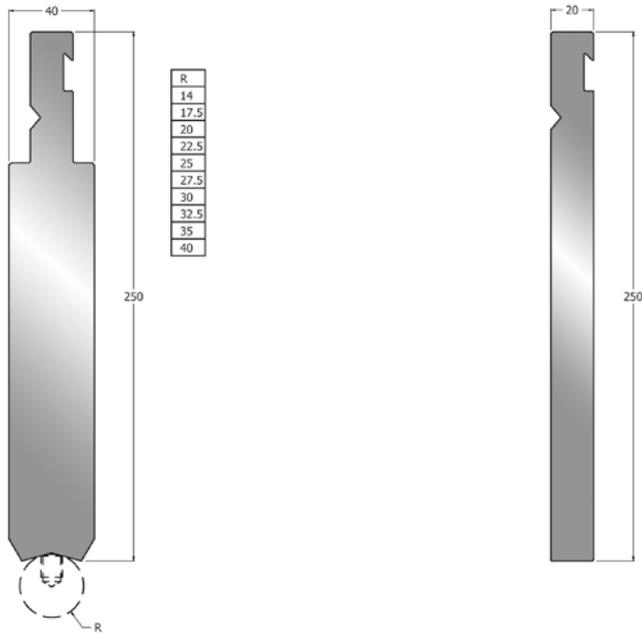


60° Pointed
SB2460040
Max Force: 1600 kN/m
Bystronic Profile P9RFA

For different Radii & Relief consult Schiavi

BYSTRONIC STYLE

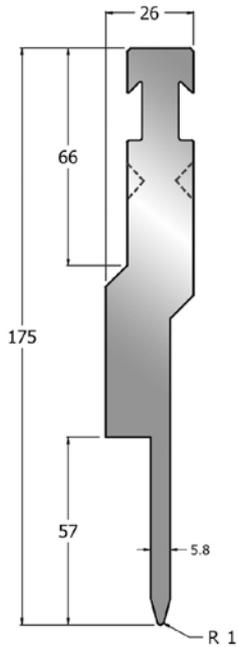
RFA-STYLE PUNCHES 250MM



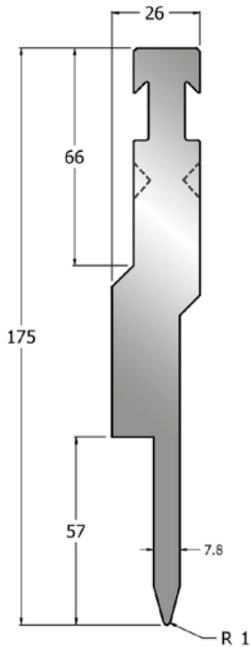
Radius Tools Available
Consult Schiavi for more
details

Flattening Tools Available
Consult Schiavi for more
details

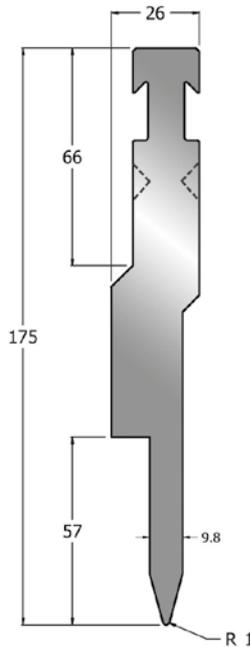
HEMMING



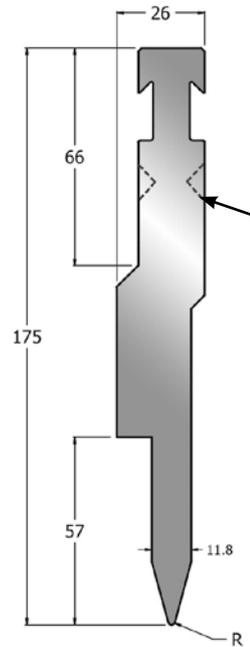
R= SB0330010 - 6
RFA= SB1330010 - 6
Max Force:
Bending 500 kN/m
Flattening 1000 kN/m



R= SB0330010 - 8
RFA= SB1330010 - 8
Max Force:
Bending 700 kN/m
Flattening 1000 kN/m

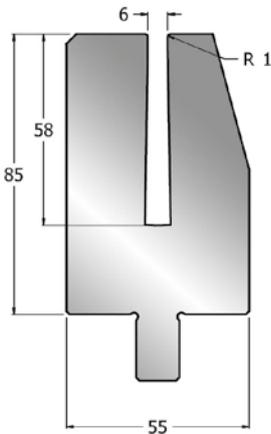


R= SB0330010 - 10
RFA= SB1330010 - 10
Max Force:
Bending 1000 kN/m
Flattening 1000 kN/m

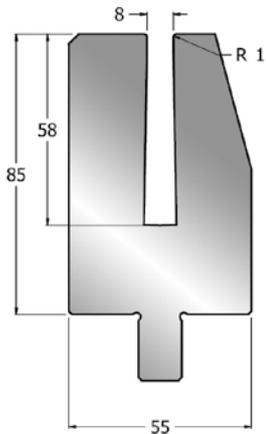


R= SB0330010 - 12
RFA= SB1330010 - 12
Max Force:
Bending 1000 kN/m
Flattening 1000 kN/m

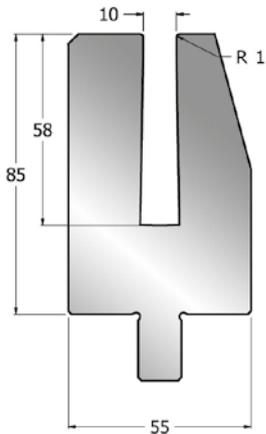
RFA Punches include 'V' grooves



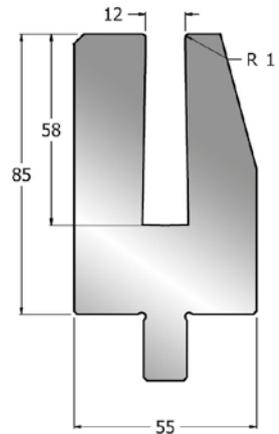
SB5330006
Max Force:
Bending 550 kN/m
Flattening 1000 kN/m



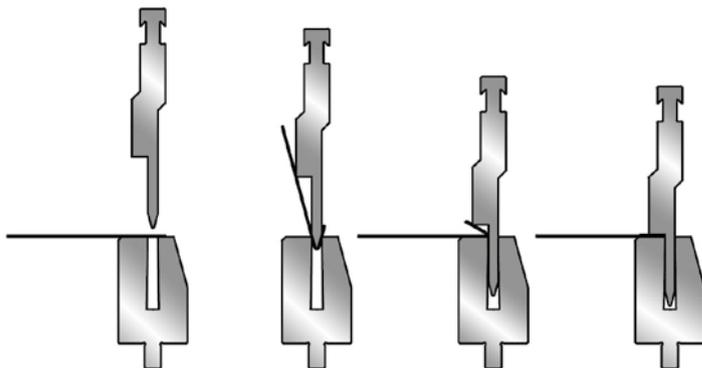
SB5330008
Max Force:
Bending 550 kN/m
Flattening 1000 kN/m



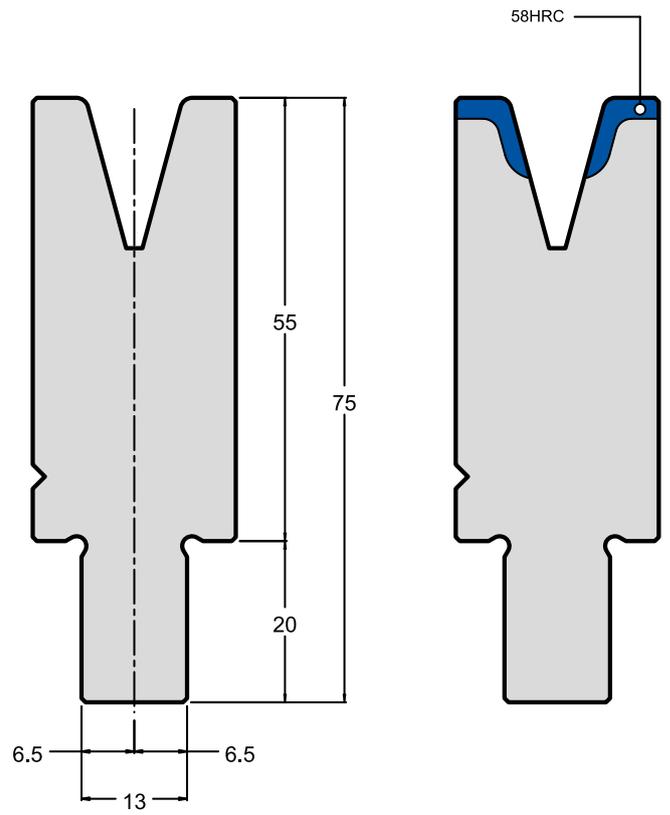
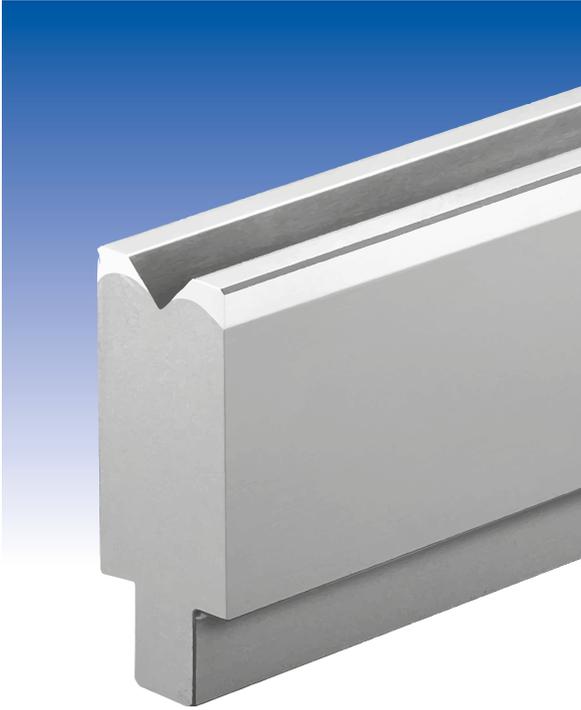
SB5330010
Max Force:
Bending 550 kN/m
Flattening 1000 kN/m



SB5330012
Max Force:
Bending 550 kN/m
Flattening 1000 kN/m

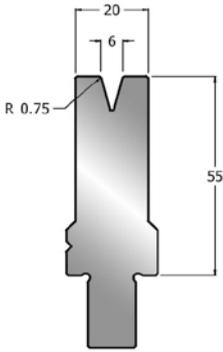


DIES

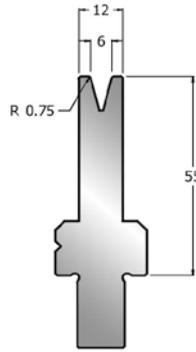


BYSTRONIC STYLE

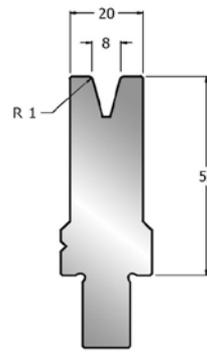
DIES ANGLE 30°



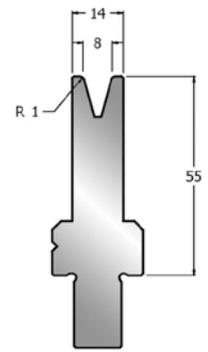
SB5030006
Max Force kN/m
Bend to 90° = 1000
30° = 400



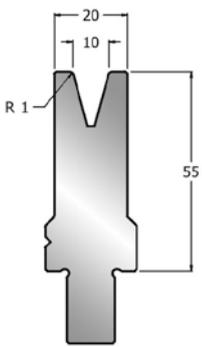
SB5130006
Max Force kN/m
Bend to 90° = 400
30° = 100



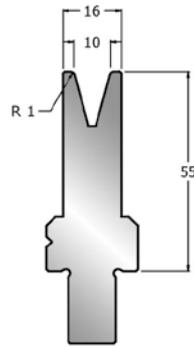
SB5030008
Max Force kN/m
Bend to 90° = 1000
30° = 300



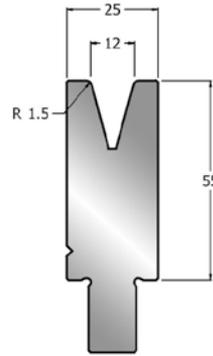
SB5130008
Max Force kN/m
Bend to 90° = 400
30° = 100



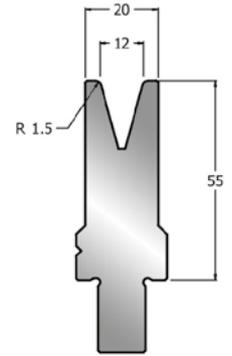
SB5030010
Max Force kN/m
Bend to 90° = 700
30° = 200



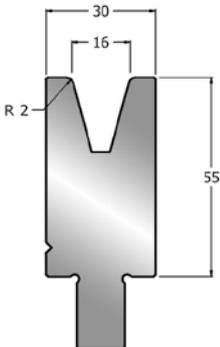
SB5130010
Max Force kN/m
Bend to 90° = 400
30° = 100



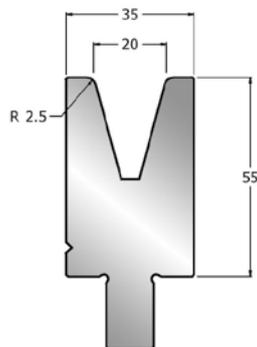
SB5030012
Max Force kN/m
Bend to 90° = 900
30° = 250



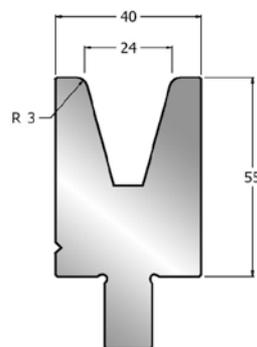
SB5130012
Max Force kN/m
Bend to 90° = 400
30° = 100



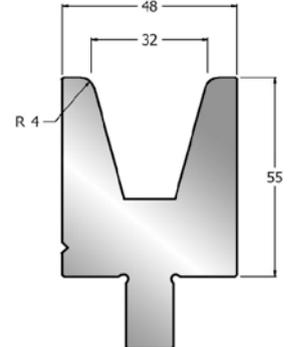
SB5030016
Max Force kN/m
Bend to 90° = 1000
30° = 250



SB5030020
Max Force kN/m
Bend to 90° = 600
30° = 150



SB5030024
Max Force kN/m
Bend to 90° = 1100
30° = 300

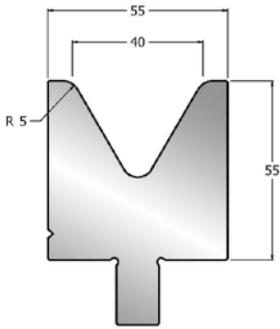


SB5030032
Max Force kN/m
Bend to 90° = 1100
30° = 300

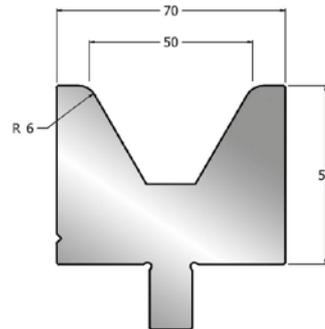
All dies induction hardened

BYSTRONIC STYLE

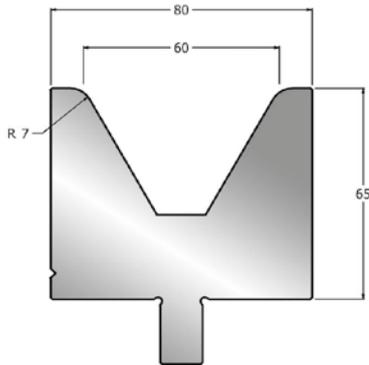
DIES ANGLE 60° & 80°



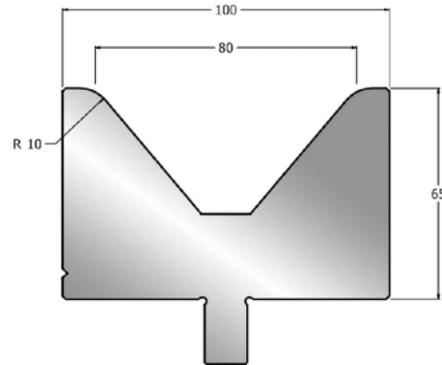
SB5060040
60°
Max Force kN/m
Bend to 90° = 1800
60° = 1000



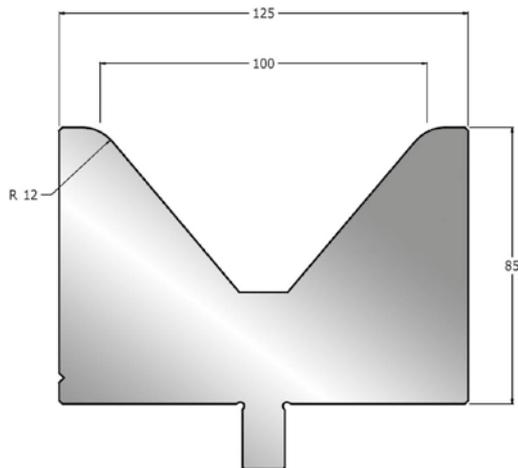
SB5060050
60°
Max Force kN/m
Bend to 90° = 1800
60° = 1000



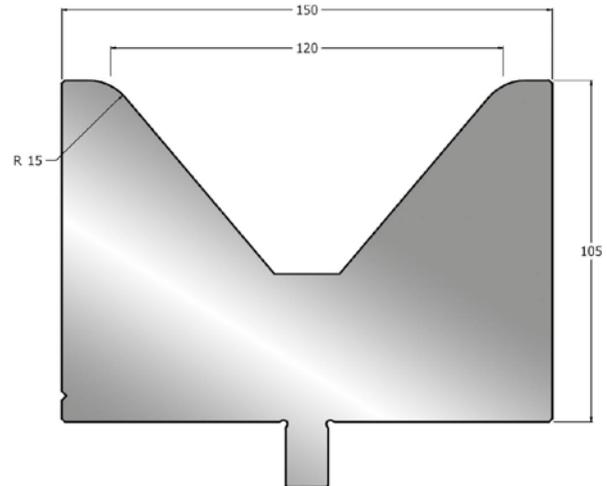
SB5060060
60°
Max Force kN/m
Bend to 90° = 1600
60° = 900



SB5080080
80°
Max Force kN/m
Bend to 90° = 1600
80° = 1400



SB5080100
80°
Max Force kN/m
Bend to 90° = 2000
80° = 1800

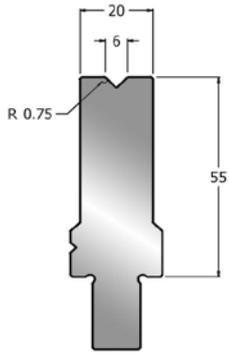


SB5080120
80°
Max Force kN/m
Bend to 90° = 2400
80° = 2000

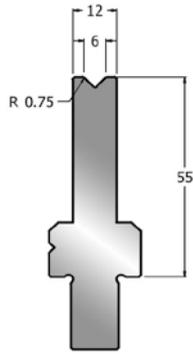
All dies induction hardened

BYSTRONIC STYLE

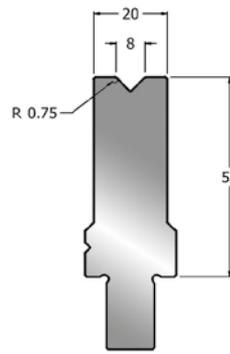
DIES ANGLE 85° & 88°



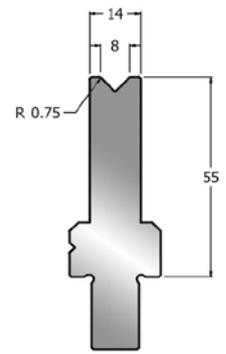
SB5085006
SB5088006
85°/88°
Max Force = 1000 kN/m



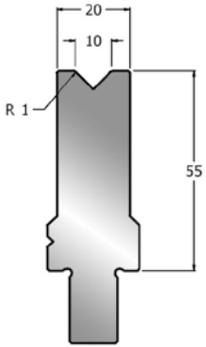
SB5185006
SB5188006
85°/88°
Max Force = 900 kN/m



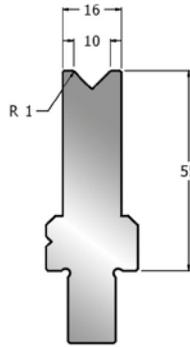
SB5085008
SB5088008
85°/88°
Max Force = 1000 kN/m



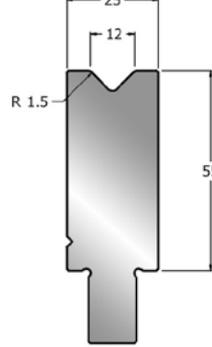
SB5185008
SB5188008
85°/88°
Max Force = 900 kN/m



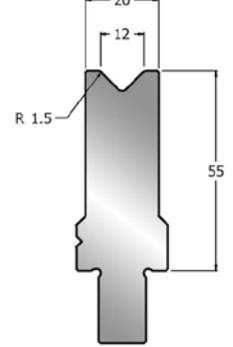
SB5085010
SB5088010
85°/88°
Max Force = 1000 kN/m



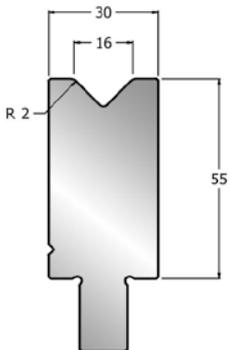
SB5185010
SB5188010
85°/88°
Max Force = 800 kN/m



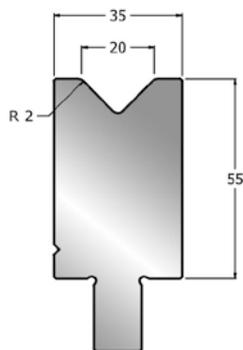
SB5085012
SB5088012
85°/88°
Max Force = 1000 kN/m



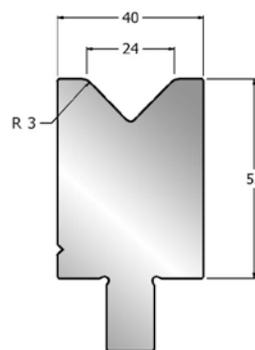
SB5185012
SB5188012
85°/88°
Max Force = 700 kN/m



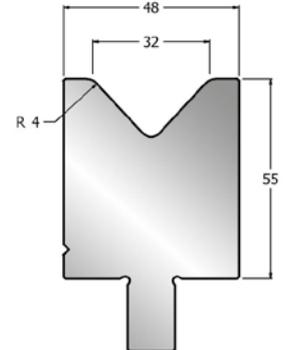
SB5085016
SB5088016
85°/88°
Max Force = 1000 kN/m



SB5085020
SB5088020
85°/88°
Max Force = 1000 kN/m



SB5085024
SB5088024
85°/88°
Max Force = 1000 kN/m

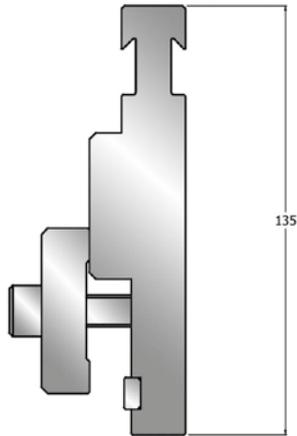


SB5085032
SB5088032
85°/88°
Max Force = 1000 kN/m

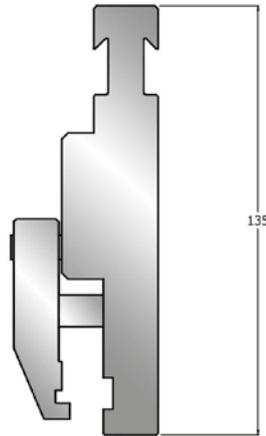
All dies induction hardened

ADAPTORS

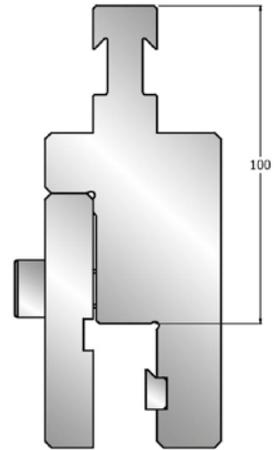
Adaptor R-EuroA



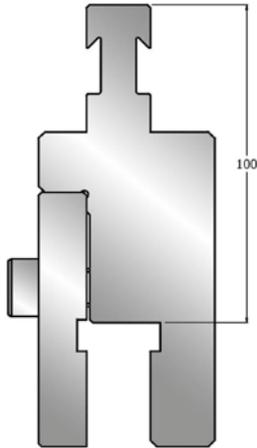
Adaptor R-EuroB



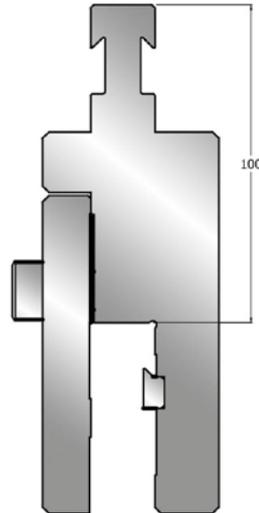
Adaptor R-R



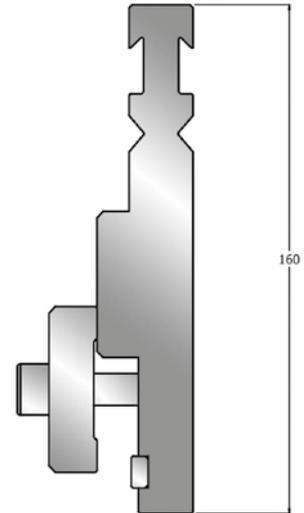
Adaptor R-S



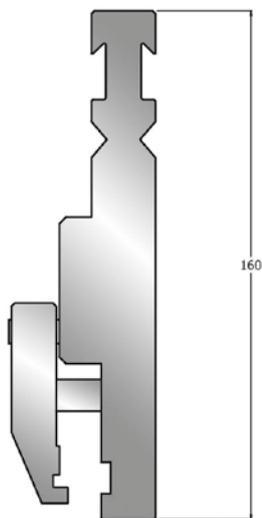
Adaptor R-RFA



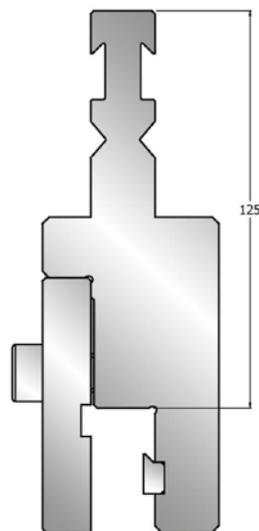
Adaptor RFA-EuroA



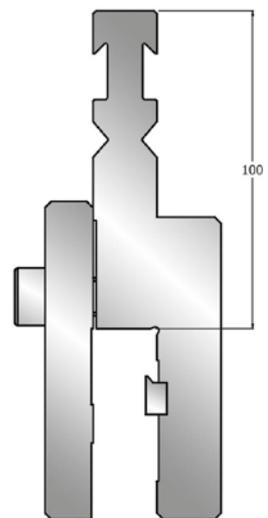
Adaptor RFA-EuroB



Adaptor RFA-R



Adaptor RFA-RFA

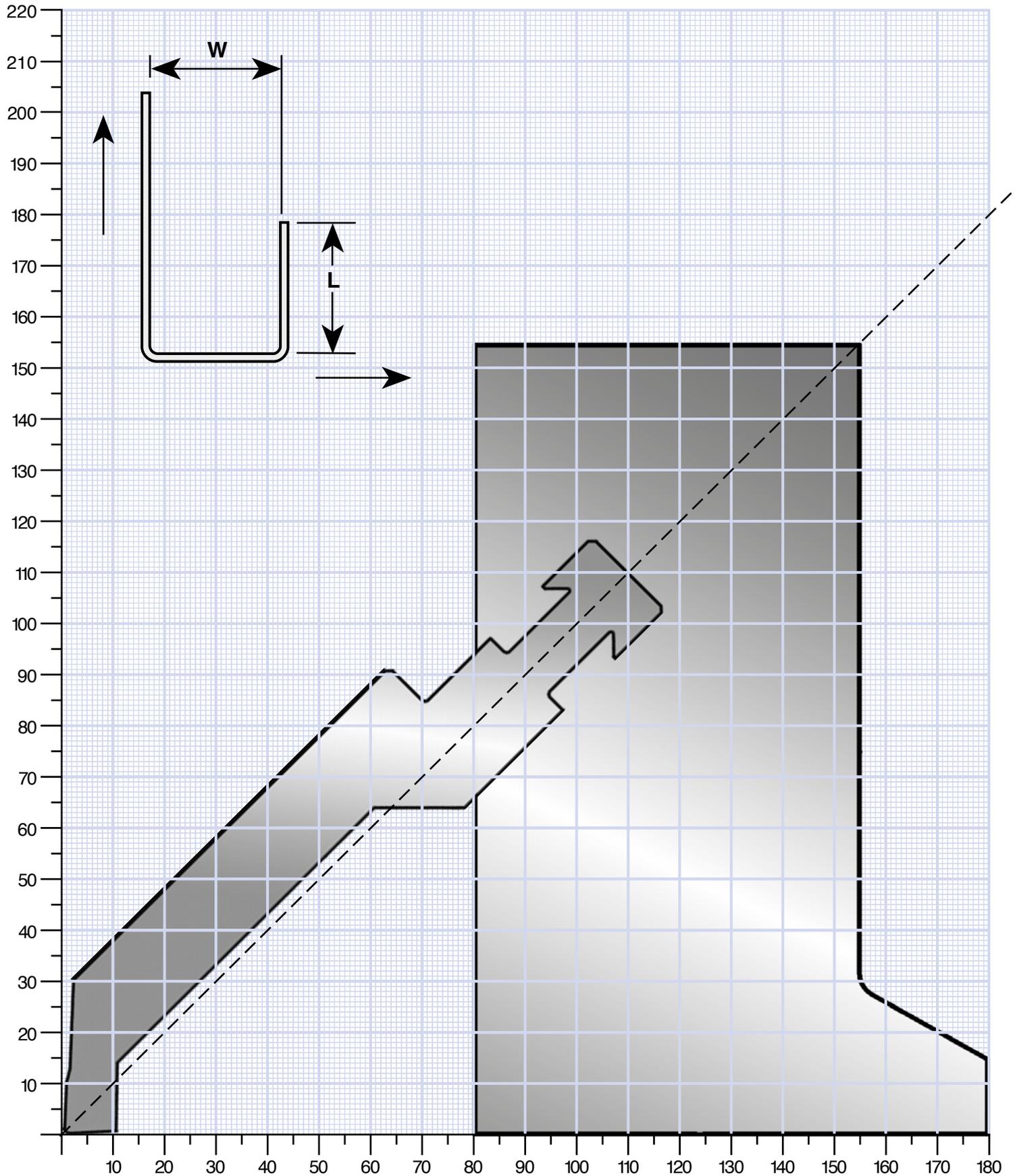


For adaptors consult Schiavi

BYSTRONIC STYLE

BEND LIMIT GRAPH

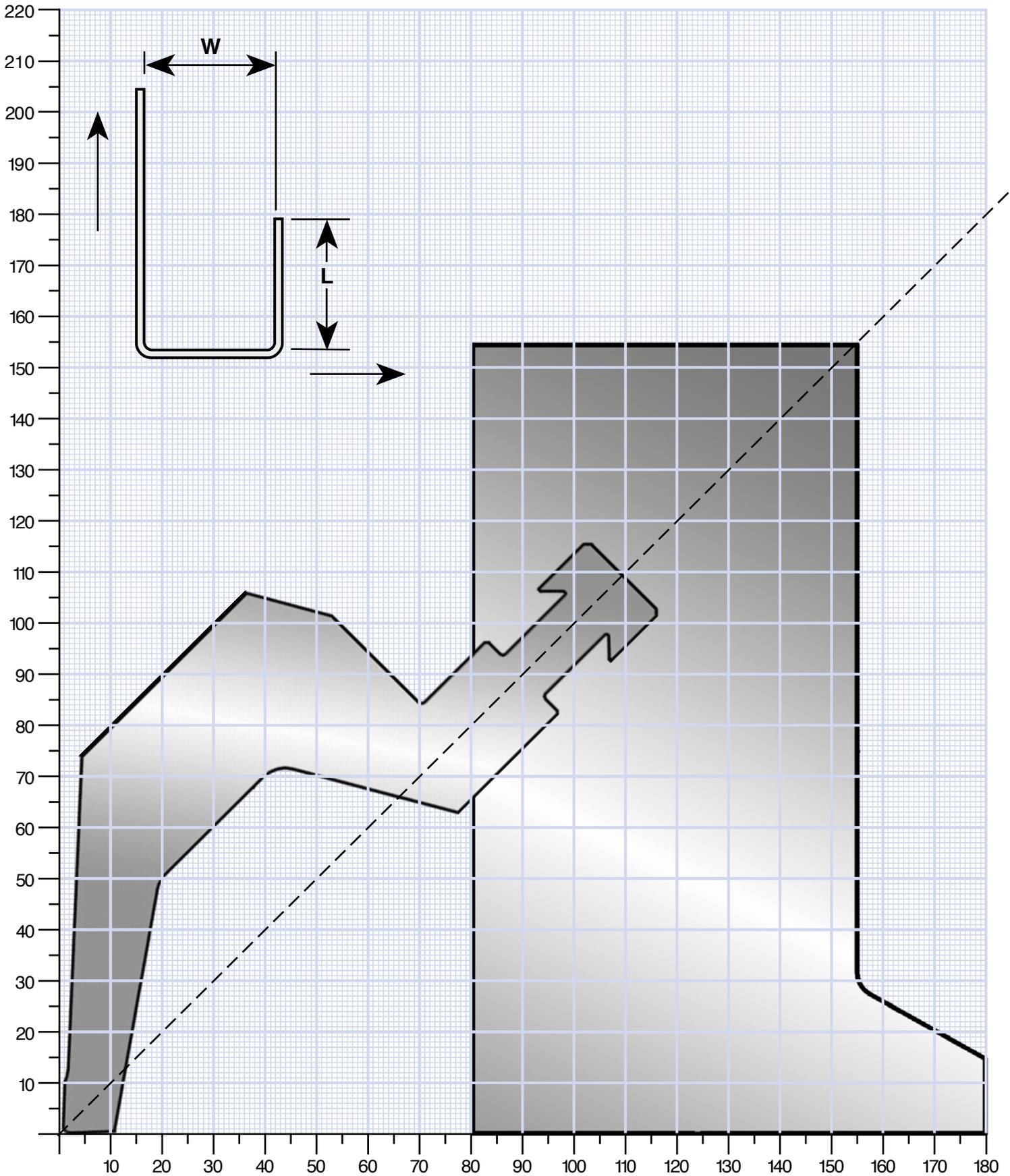
SB0188010, SB0185010



BYSTRONIC STYLE

BEND LIMIT GRAPH

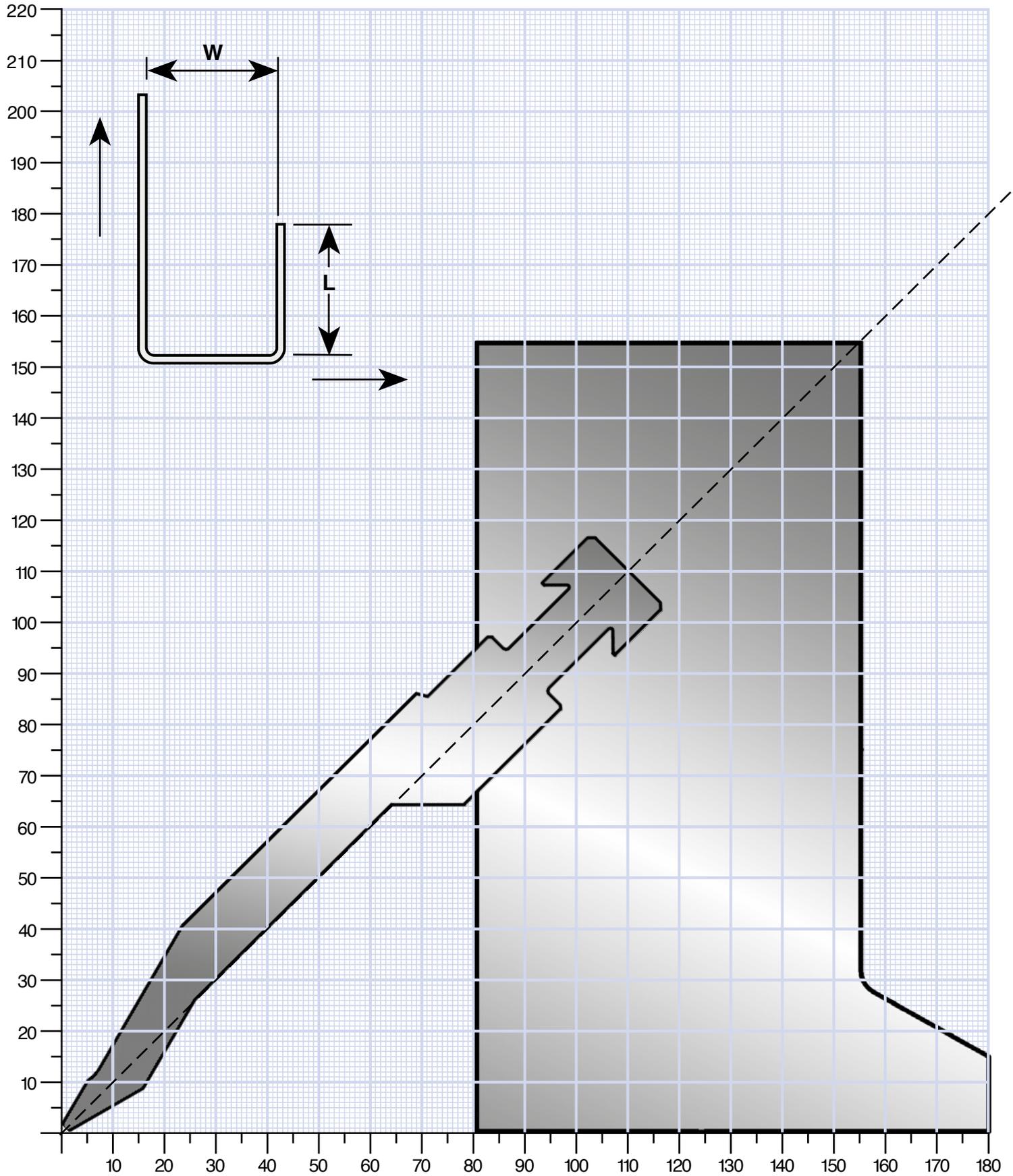
SB0088015, SB0085015



BYSTRONIC STYLE

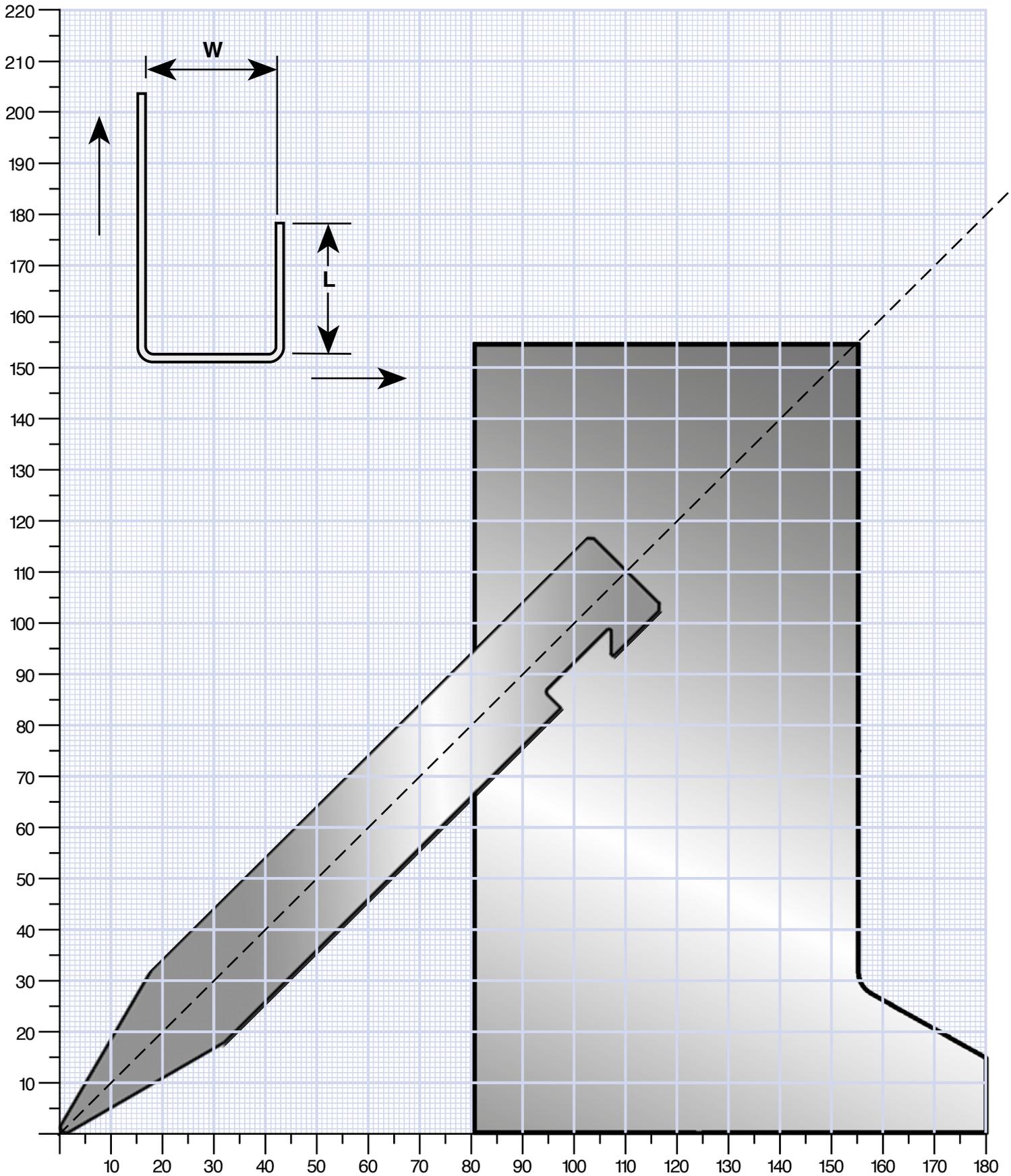
BEND LIMIT GRAPH

SB0230010



BEND LIMIT GRAPH

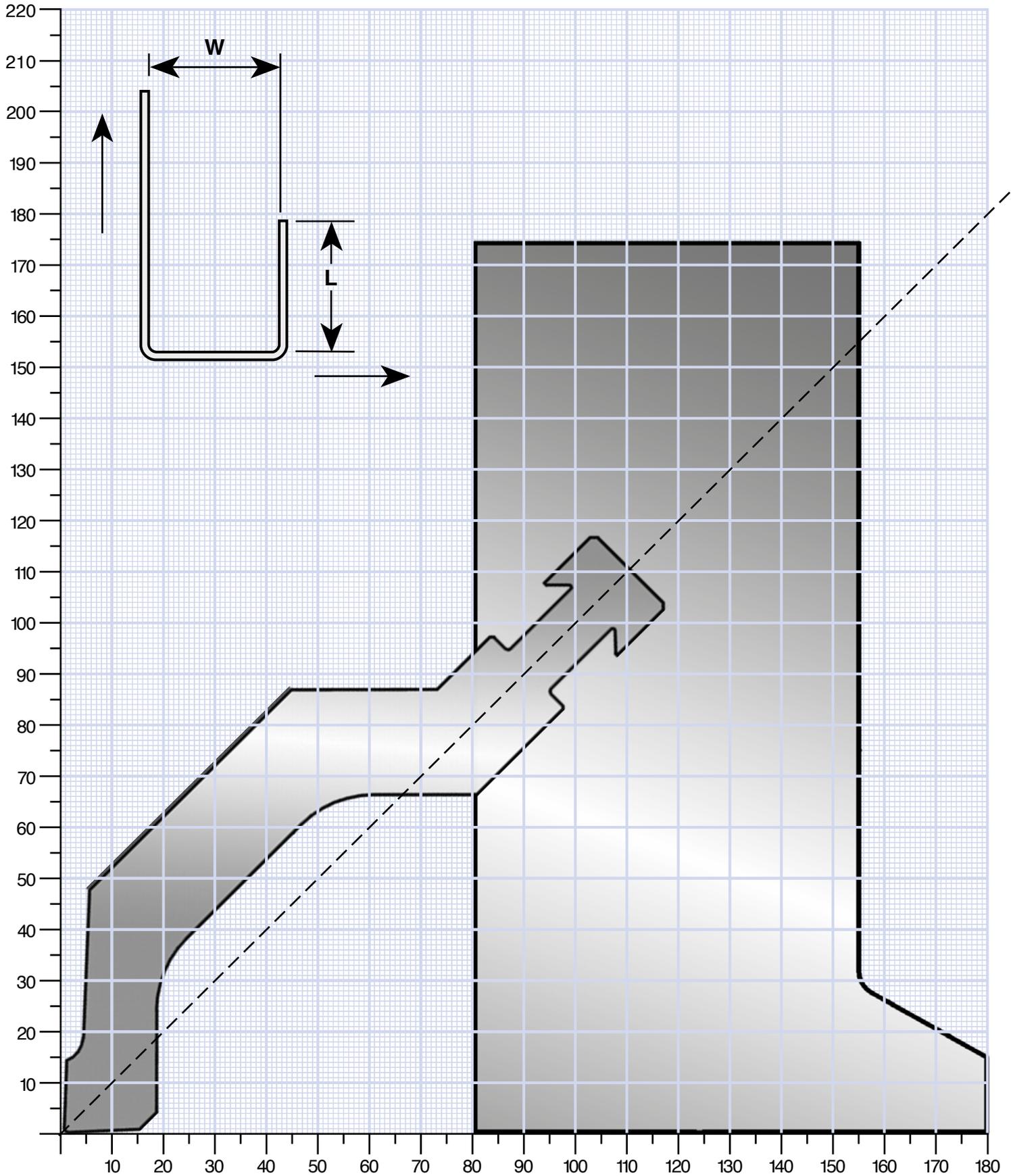
SB0430010



BYSTRONIC STYLE

BEND LIMIT GRAPH

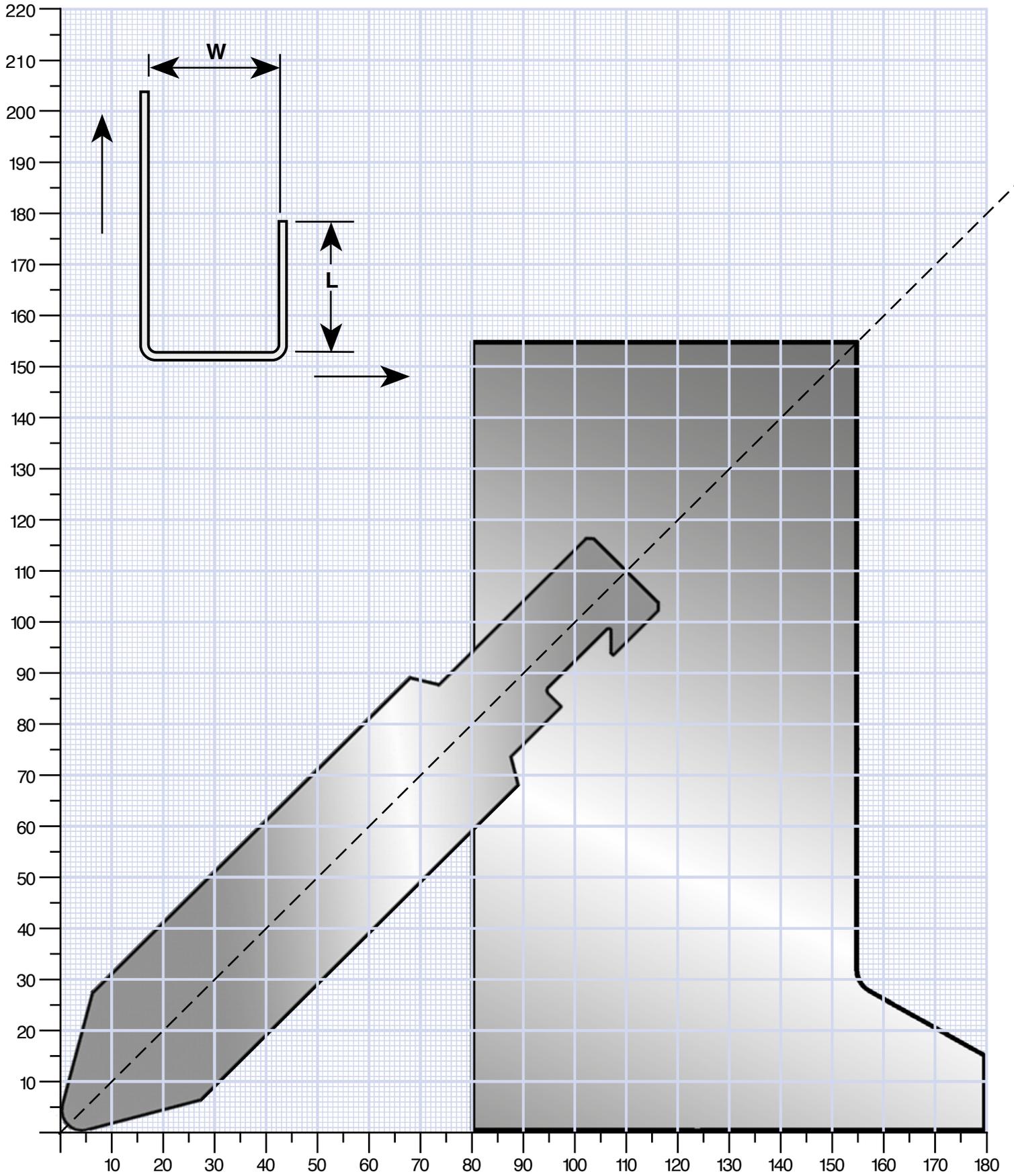
SB0588010, SB0585010



BYSTRONIC STYLE

BEND LIMIT GRAPH

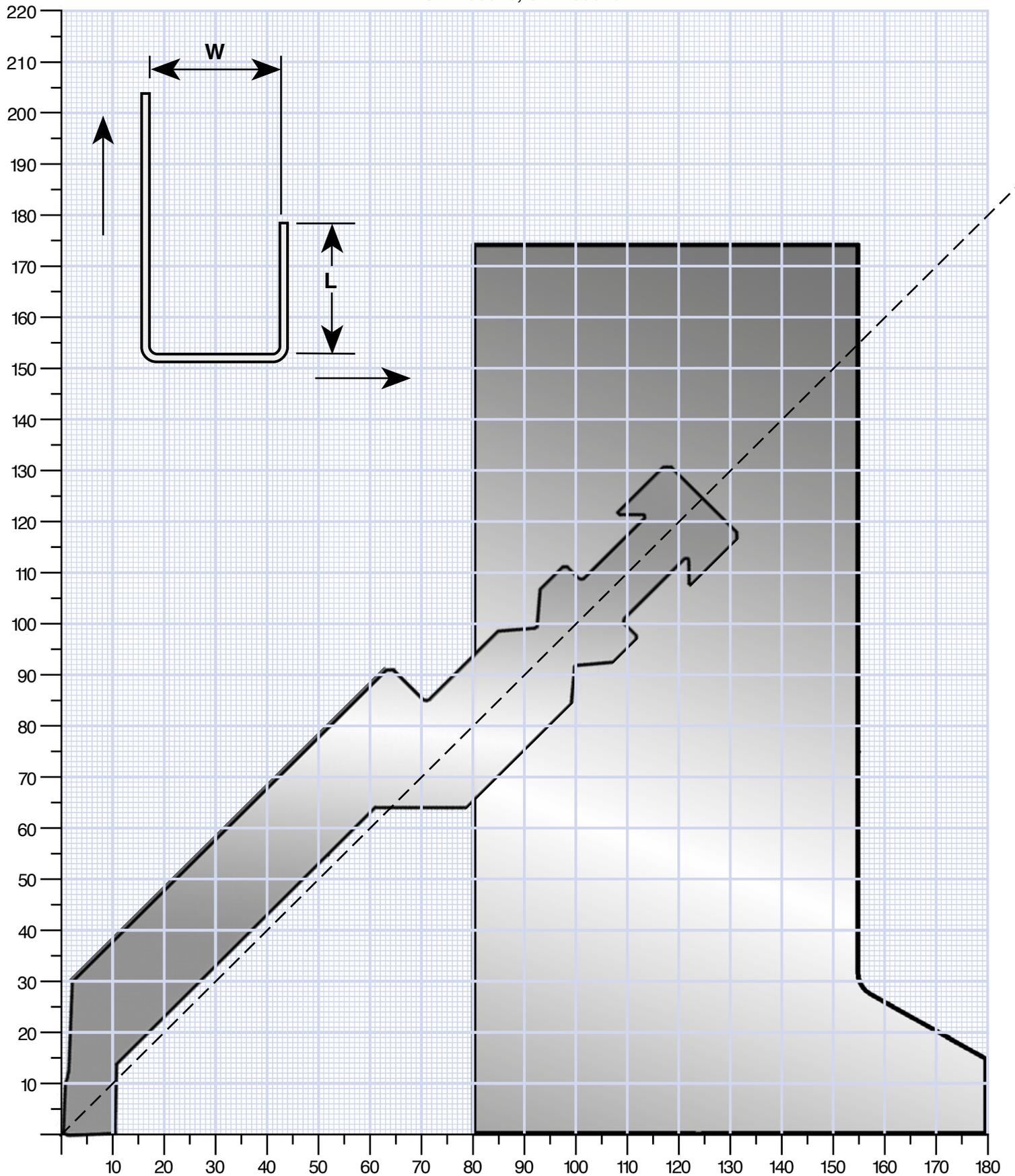
SB0460040



BYSTRONIC STYLE

BEND LIMIT GRAPH

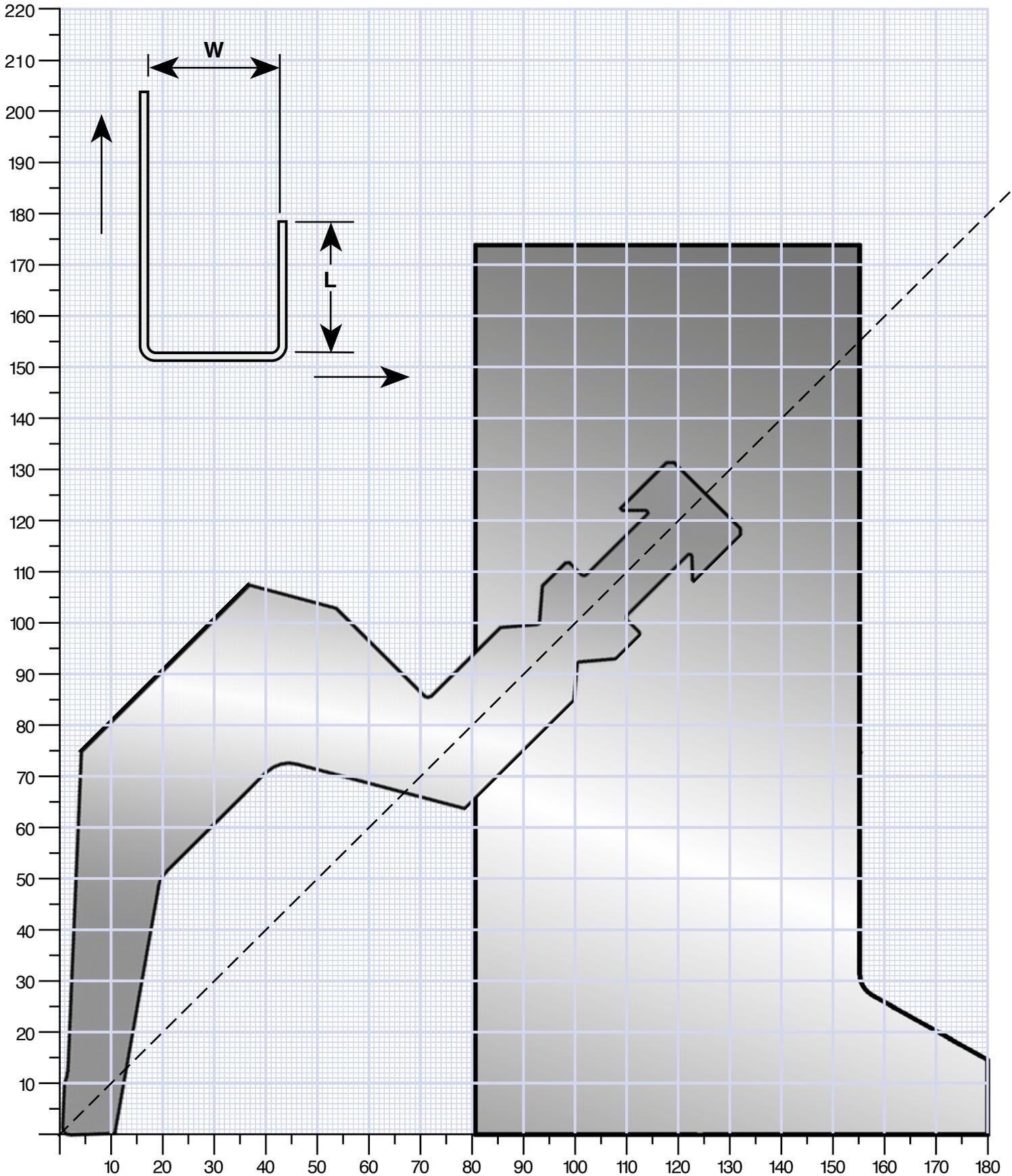
SB1188010, SB1185010



BYSTRONIC STYLE

BEND LIMIT GRAPH

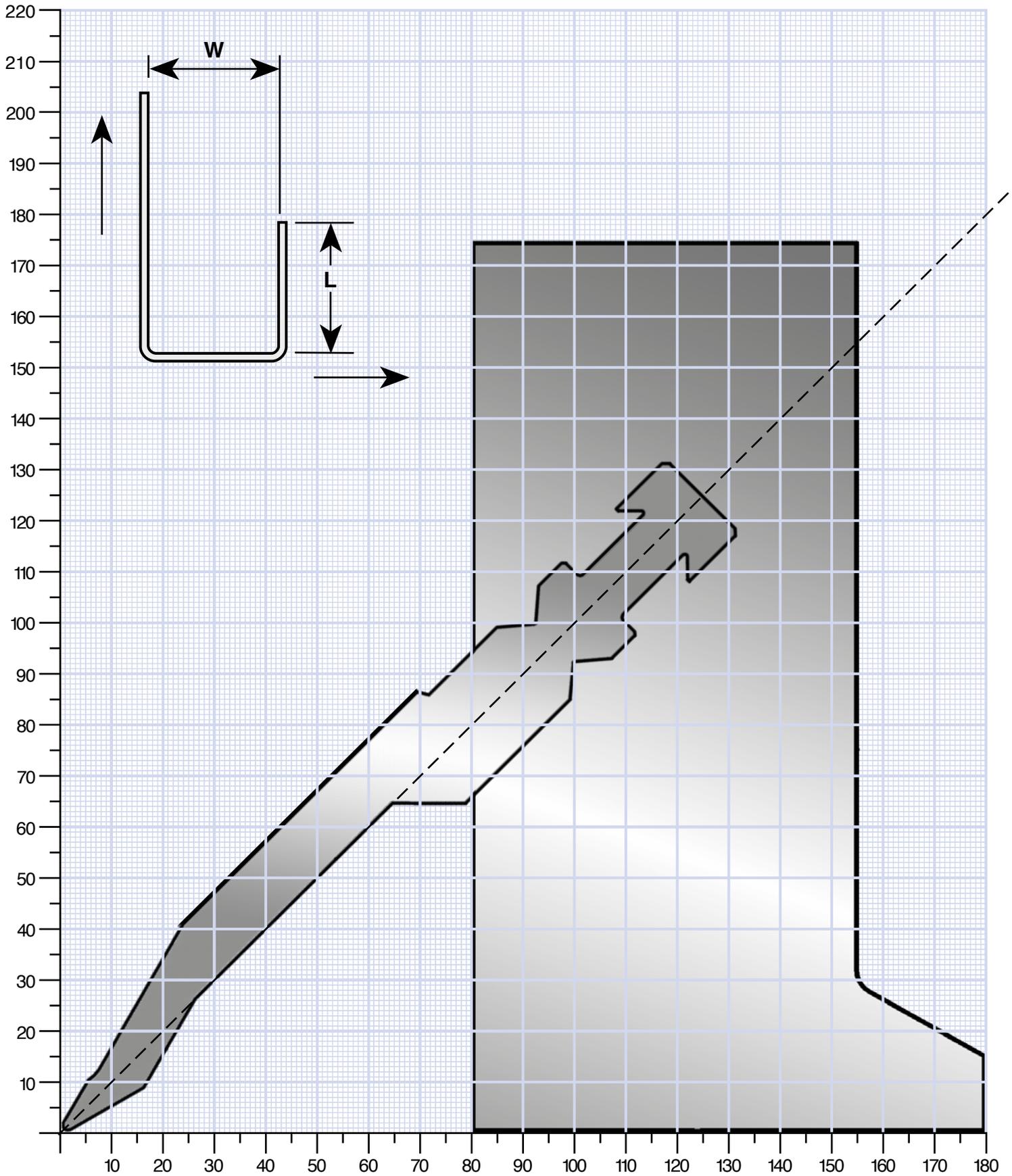
SB1088015, SB1085015



BYSTRONIC STYLE

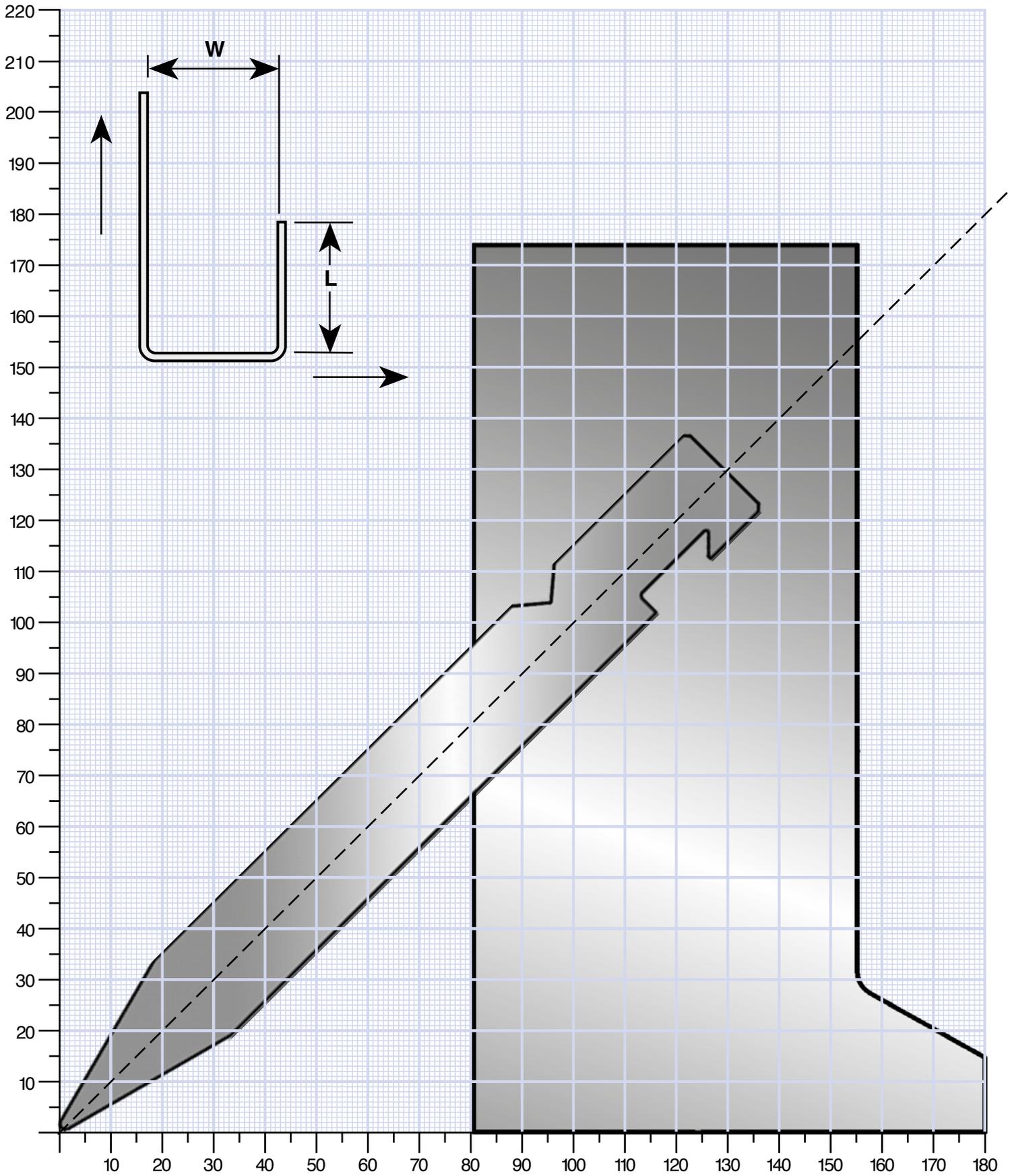
BEND LIMIT GRAPH

SB1230010



BEND LIMIT GRAPH

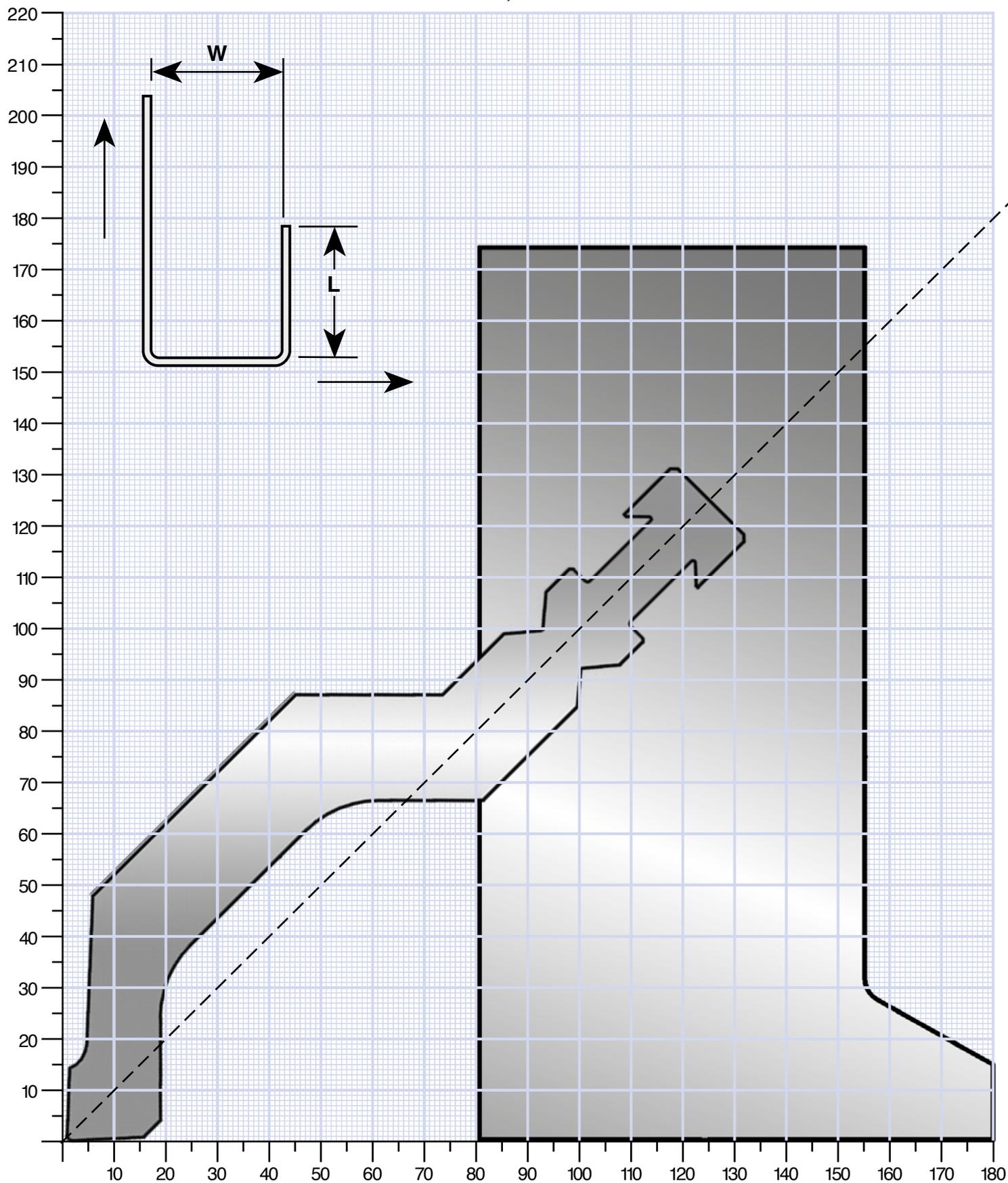
SB1430010



BYSTRONIC STYLE

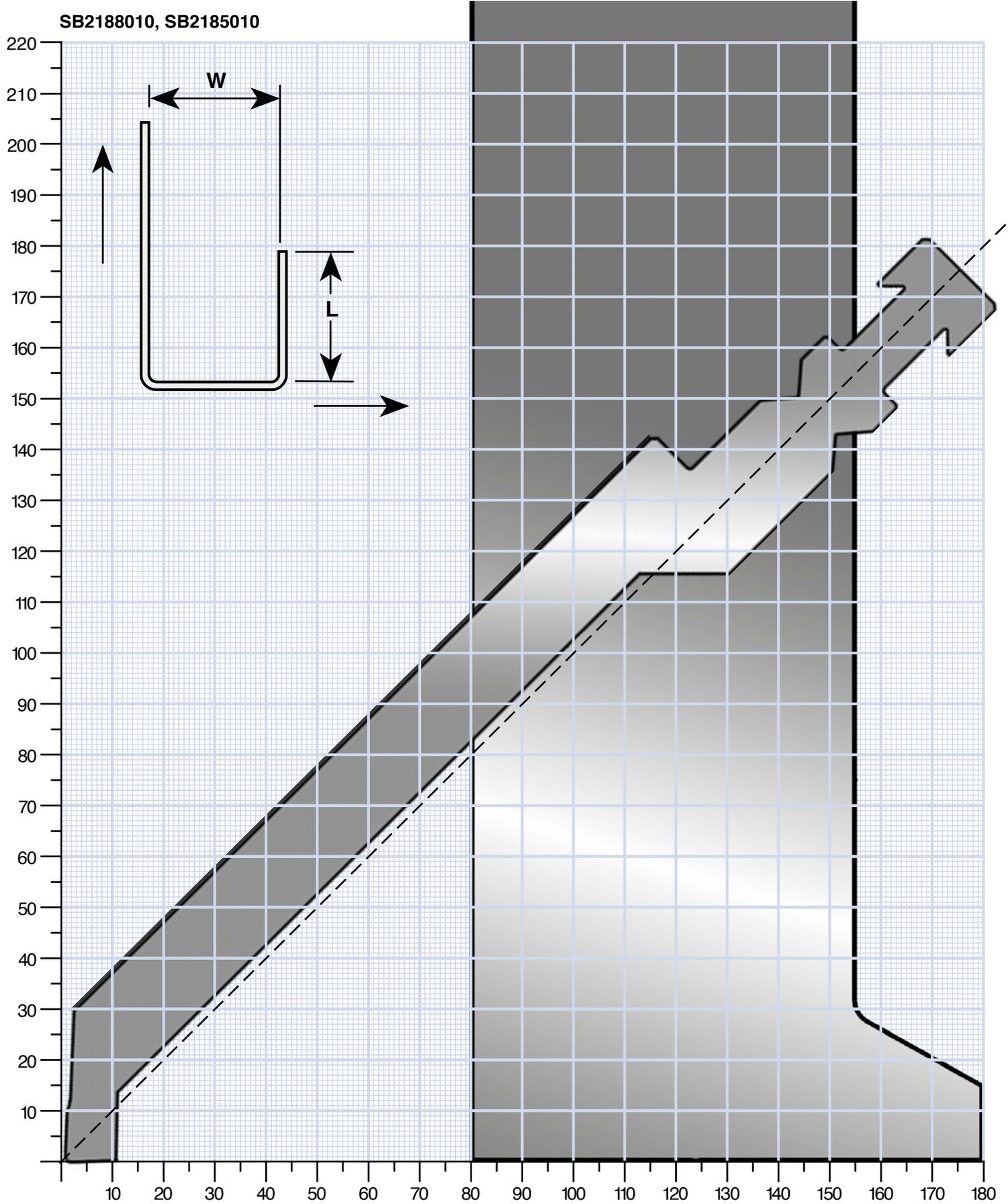
BEND LIMIT GRAPH

SB1588010, SB1585010



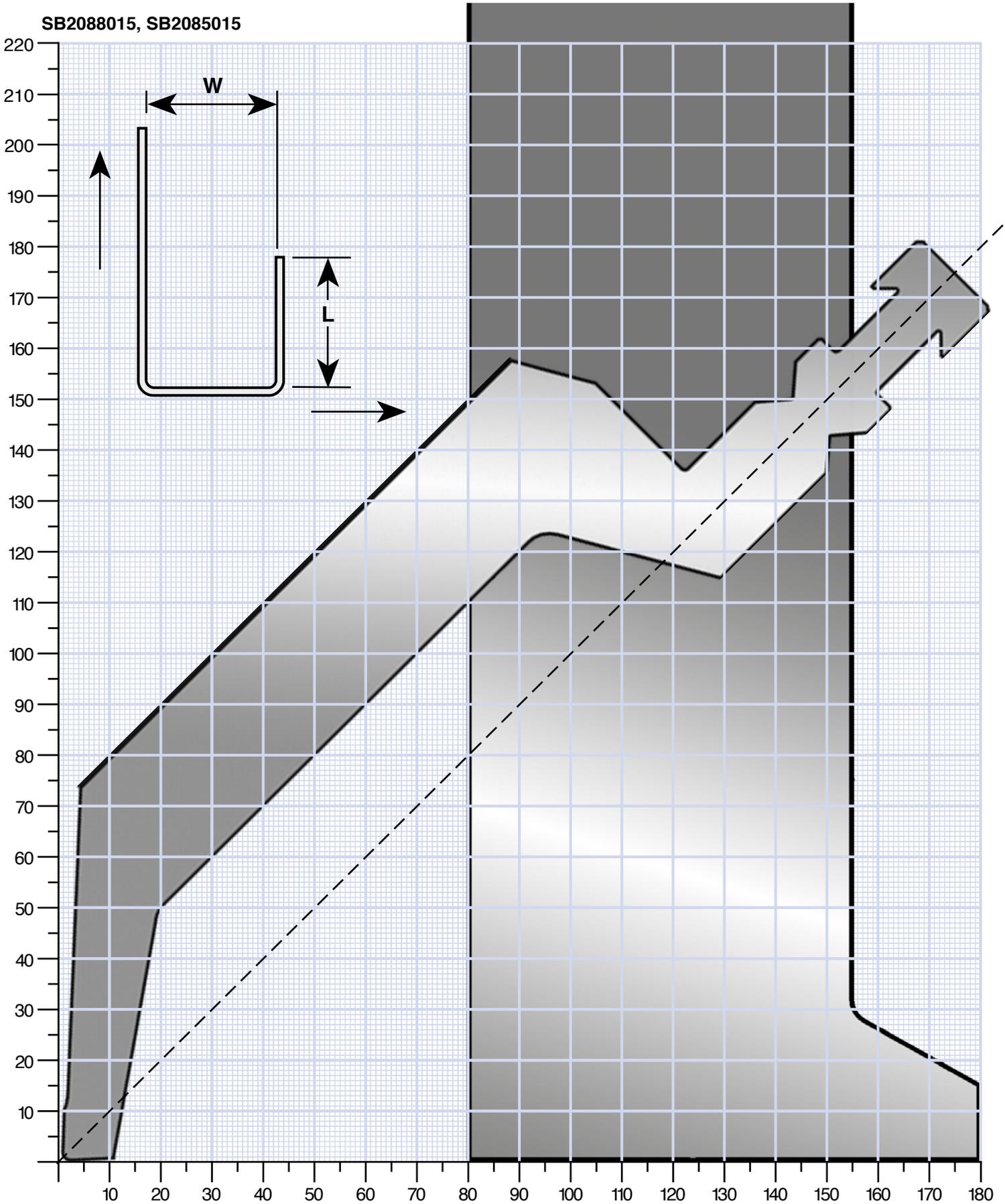
BYSTRONIC STYLE

BEND LIMIT GRAPH



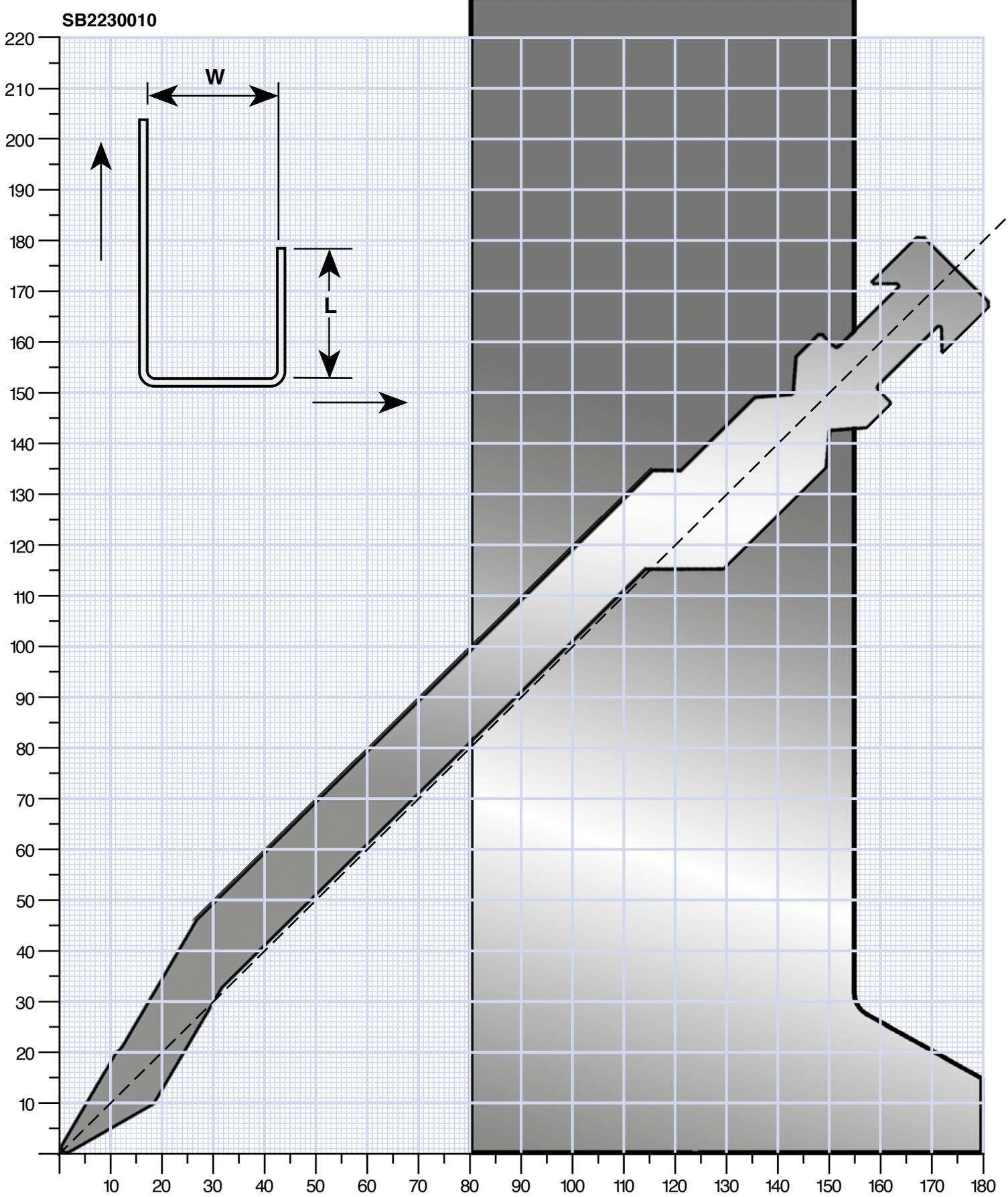
BYSTRONIC STYLE

BEND LIMIT GRAPH

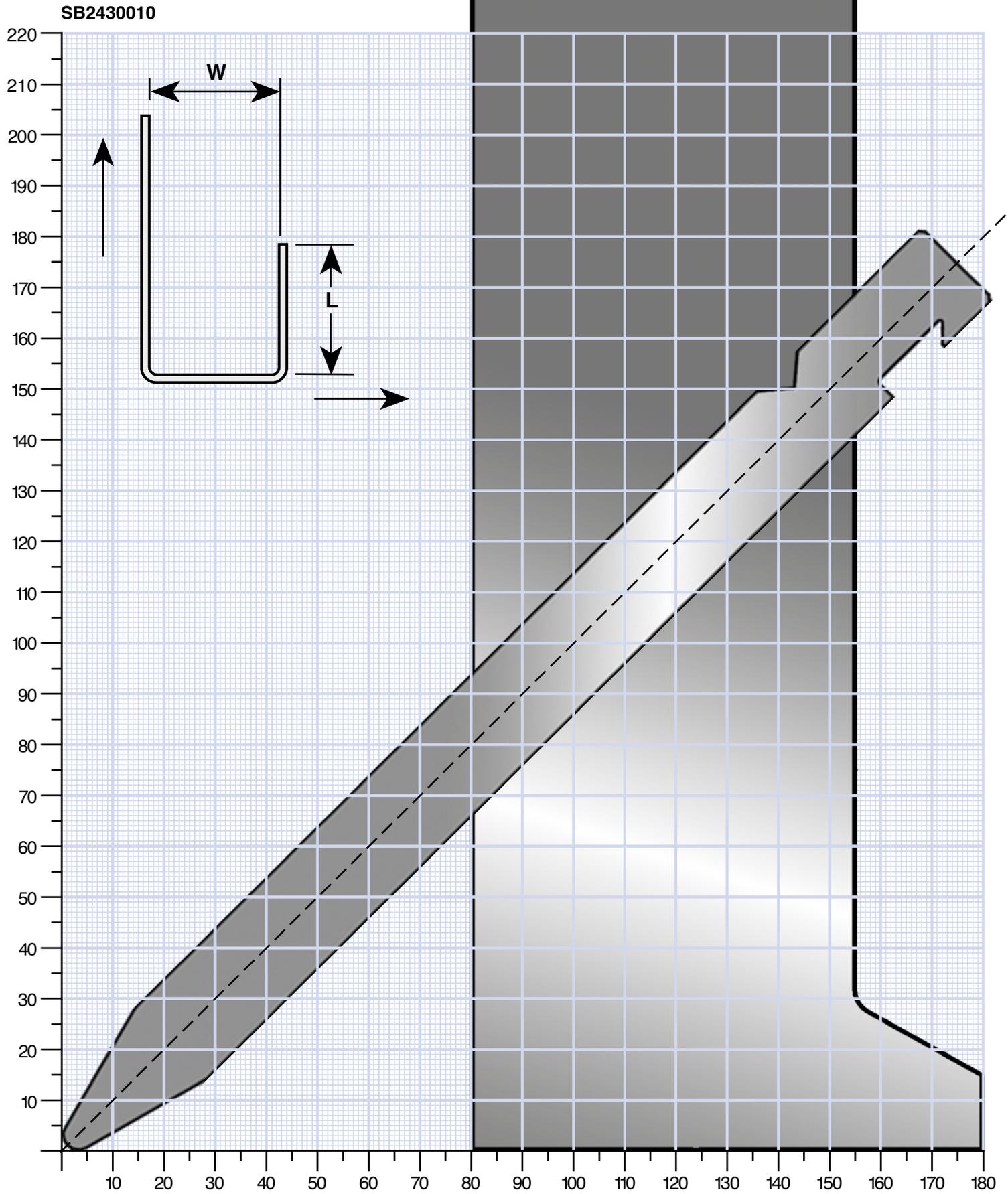


BYSTRONIC STYLE

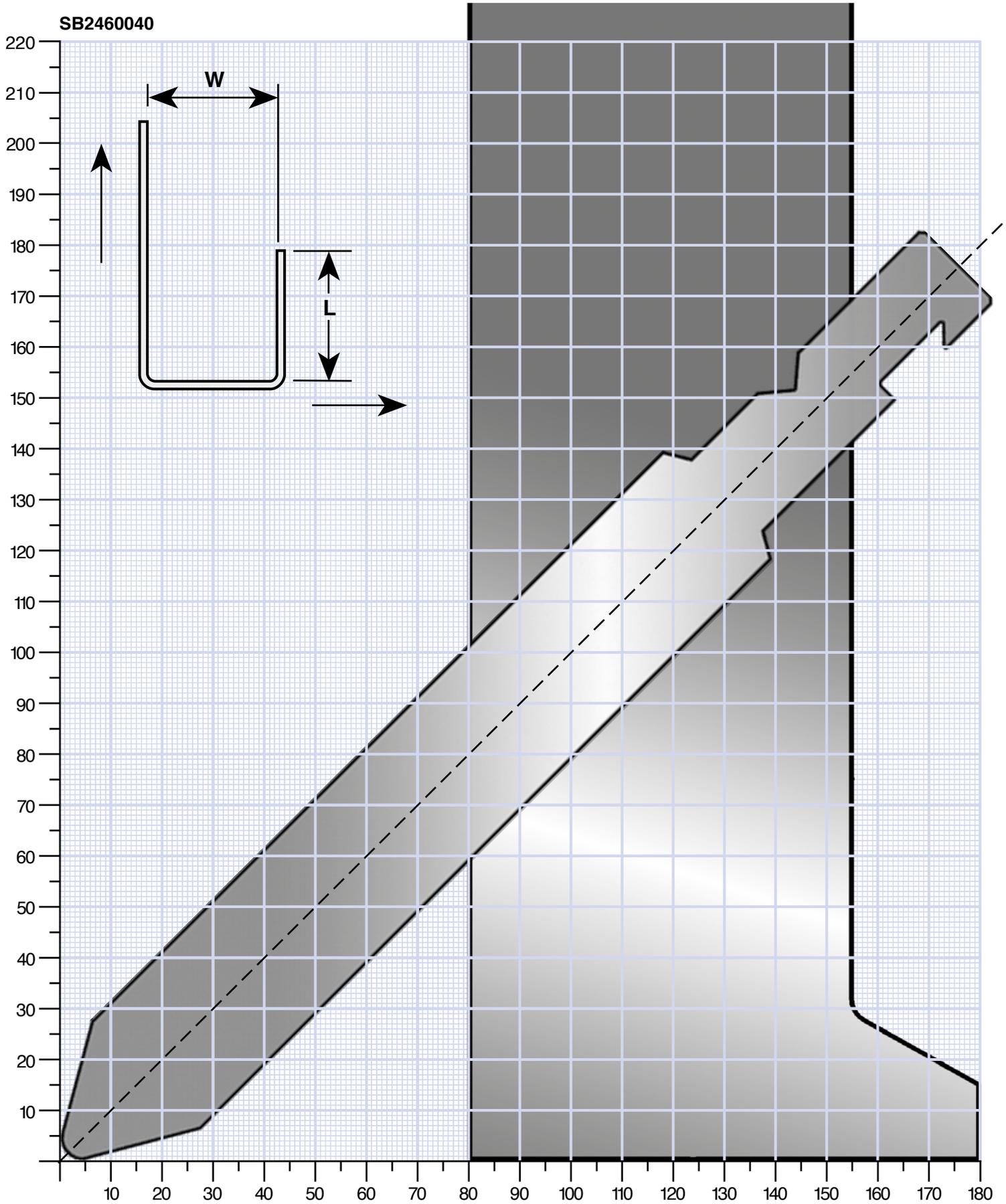
BEND LIMIT GRAPH



BEND LIMIT GRAPH



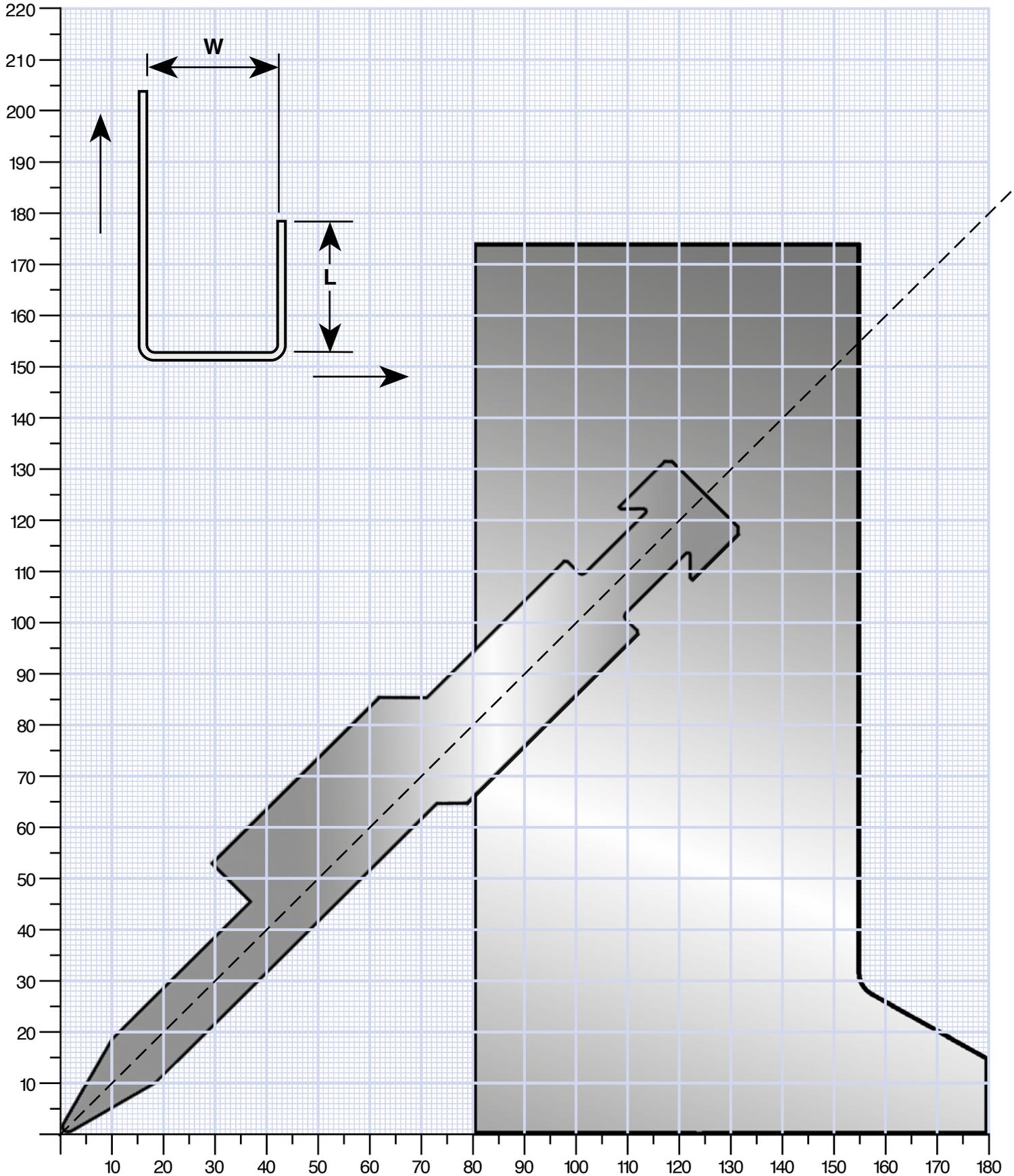
BEND LIMIT GRAPH



BYSTRONIC STYLE

BEND LIMIT GRAPH

SB0330010-6, SB0330010-8, SB0330010-10, SB0330010-12, SB1330010-6, SB1330010-8, SB1330010-10, SB1330010-12



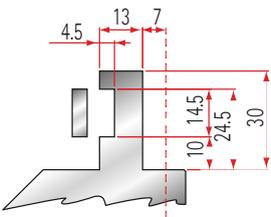


PRESS BRAKE TOOLING
EUROPEAN STYLE

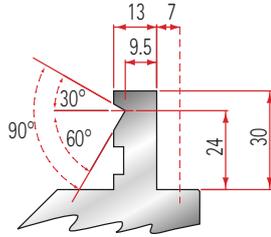
EUROPEAN STYLE

SAFETY GROOVES

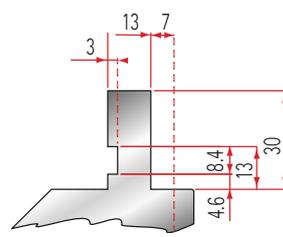
9001



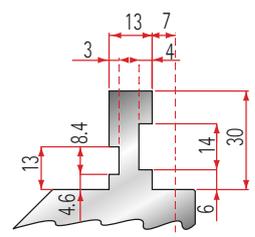
9002



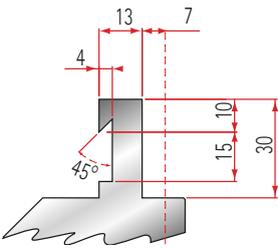
9003



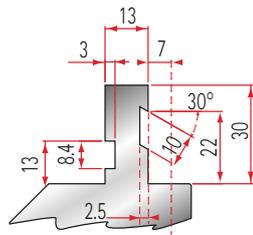
9004



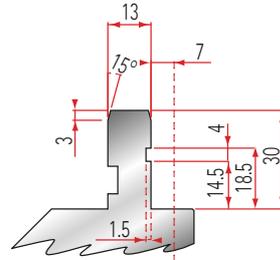
9005



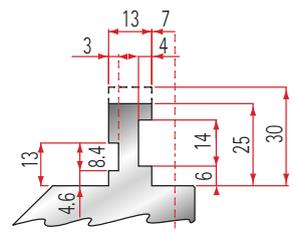
9006



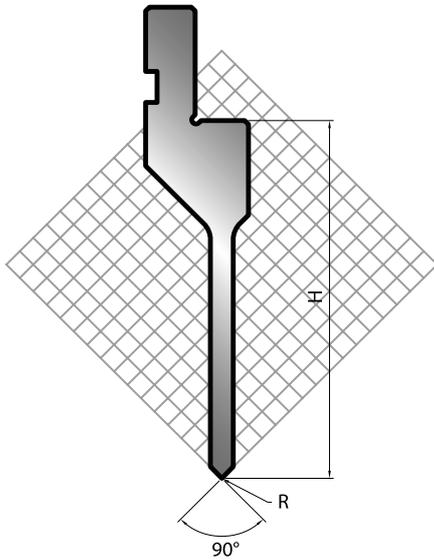
9007



9008



TECHNICAL INFORMATION

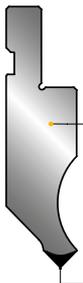


L'utensile non è sezionabile in modo standard.
The tool can't be sectioned in the standard way.



Contattateci per ulteriori chiarimenti.
Please contact us for any clarification.

SCHIAVI HR



42CRM04 Bonificato a 23-28 Hrc
42CRM04 Hardening and Tempering to Hrc 23-28
42CRM04 Vergutet auf HRc 23-28
Temprato a Induzione a 55-58 Hrc
Induction Hardened to Hrc 55-58
Induktive gehartet auf HRc 55-58

SCHIAVI TH

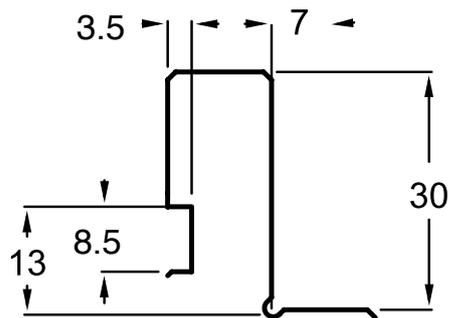


42CRM04 Temprato a Cuore 45-49 Hrc
42CRM04 Through Hardened to Hrc 45-49
42CRM04 Durchgehend vergutet auf HRc 45-49

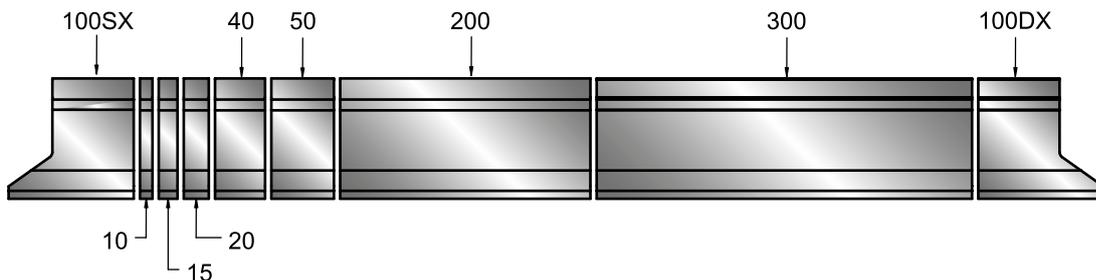
SCHIAVI IH



C45 Temprato a Induzione a 55-58 Hrc
C45 Induction Hardened to Hrc 55-58
C45 Induktive gehartet auf HRc 55-58

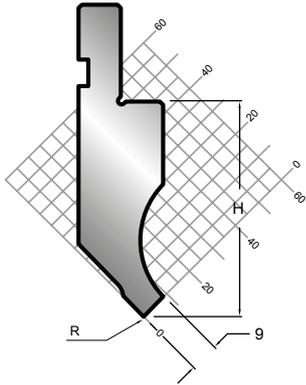


Lunghezza standard - Standard length - Standardlängen 835 mm - 415 mm - 835 mm sect.



EUROPEAN STYLE

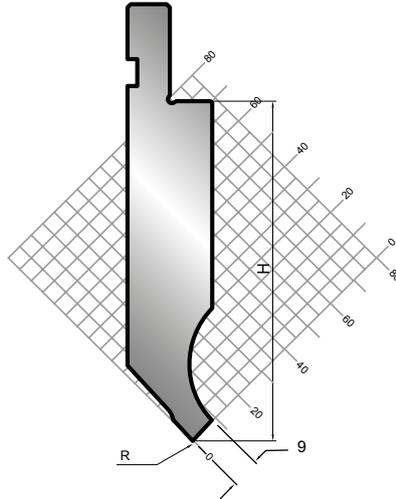
PUNCHES 90°



ton/m 100 L=835 - kg 11,20

HR TH 90°		
MOD.	R	H
S49011	0,2	66,92
S59011	0,6	66,4
S69011	0,8	66,65

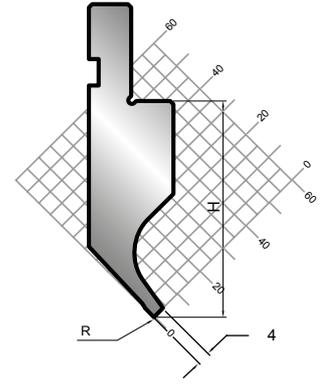
IH 90°		
MOD.	R	H
S39011	0,2	66,92
S29011	0,8	66,65



ton/m 100 L=835 - kg 18,50

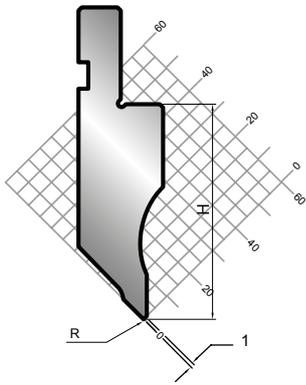
HR 90°		
MOD.	R	H
S68813	0,2	104,92
S78813	0,6	104,4
S88813	0,8	104,65

IH 90°		
MOD.	R	H
S58813	0,2	104,92
S48813	0,8	104,65



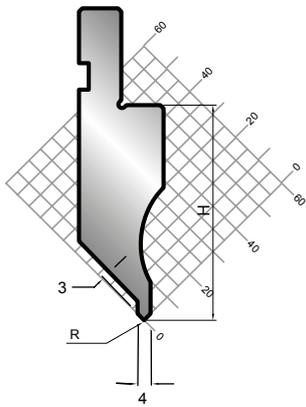
ton/m 20 L=835 - kg 10,60

HR TH 90°		
MOD.	R	H
S2010	0,2	66,92
S2008	0,6	66,4



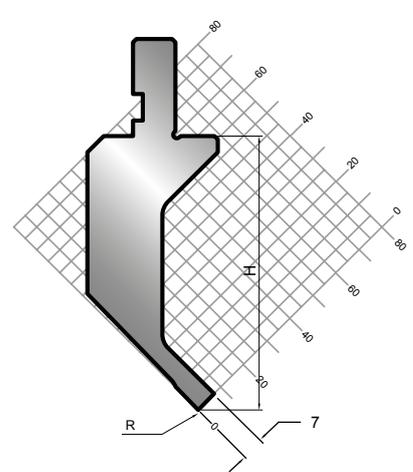
ton/m 80 L=835 - kg 10,80

HR TH 90°		
MOD.	R	H
S4901	0,2	66,92
S4902	0,6	66,4



ton/m 80 L=835 - kg 10,80

HR TH 90°		
MOD.	R	H
S48011	0,2	66,92
S48021	0,6	66,4

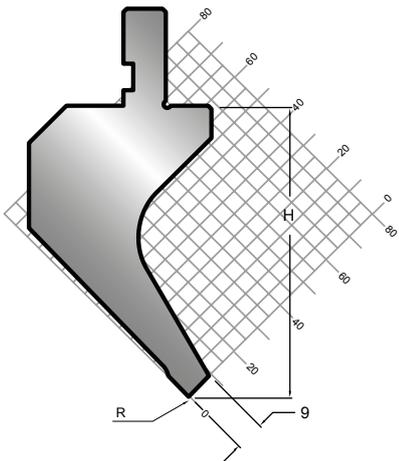


ton/m 20 L=835 - kg 14,10

TH 90°		
MOD.	R	H
S29032	0,2	84,31
S29031	0,6	84,15
S29033	0,8	84,05

EUROPEAN STYLE

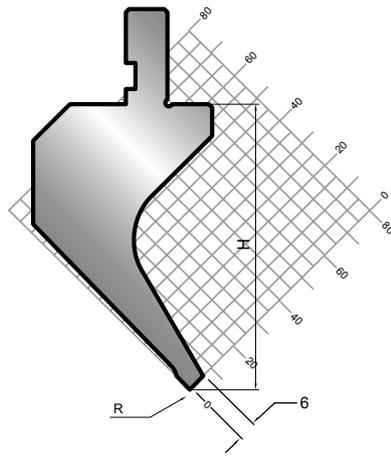
PUNCHES 90°



ton/m 70 L=835 - kg 19,50

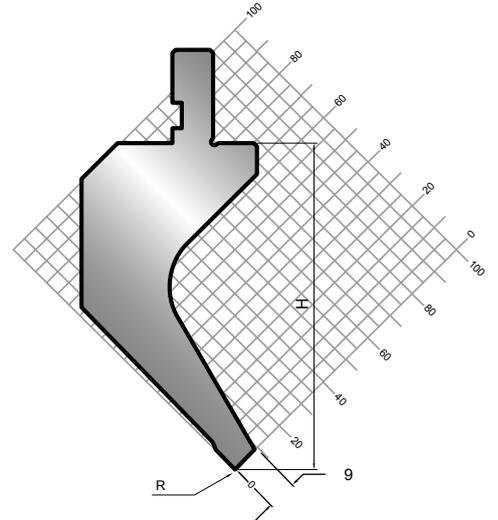
HR TH		90°	
MOD.	R	H	
S49021	0,2	89,92	
S59021	0,6	89,4	
S69021	0,8	89,65	

IH		90°	
MOD.	R	H	
S39021	0,2	89,92	
S29021	0,8	89,65	



ton/m 50 L=835 - kg 19,00

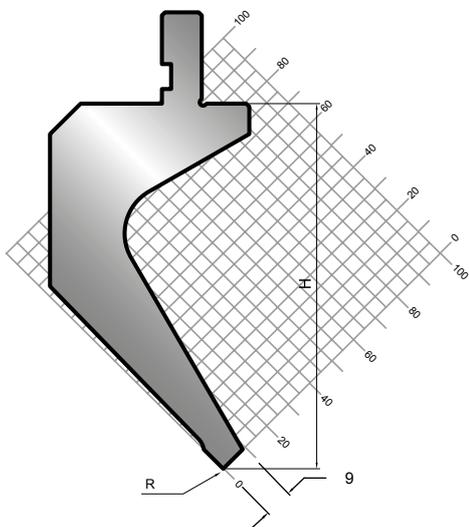
HR TH		90°	
MOD.	R	H	
S2315	0,2	89,92	
S3315	0,6	89,4	
S4315	0,8	89,65	



ton/m 50 L=835 - kg 22,20

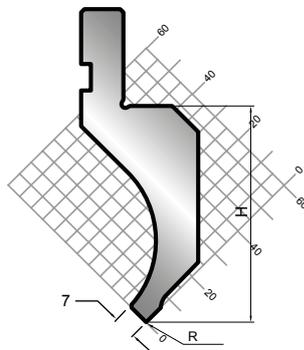
HR TH		90°	
MOD.	R	H	
S59041	0,2	104,92	
S69041	0,6	104,4	
S79041	0,8	104,65	

IH		90°	
MOD.	R	H	
S39041	0,2	104,92	
S29041	0,8	104,65	



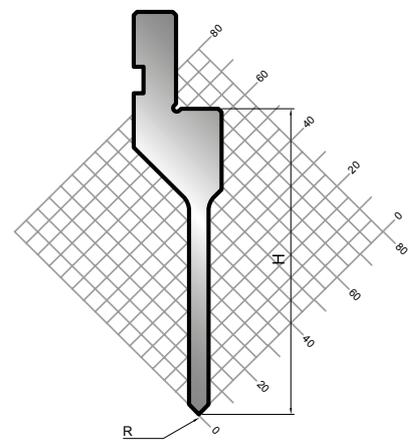
ton/m 50 L=835 - kg 25,70

HR TH		90°	
MOD.	R	H	
S2830	0,2	119,92	
S3830	0,6	119,4	
S1830	0,8	119,65	



ton/m 60 L=835 - kg 10,20

HR		90°	
MOD.	R	H	
S2105	0,8	66,65	

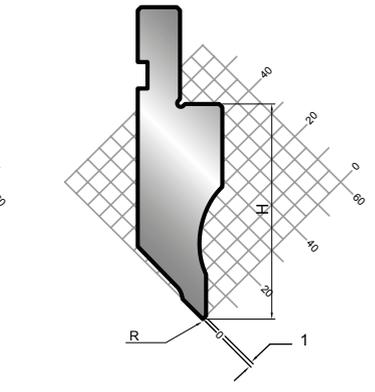
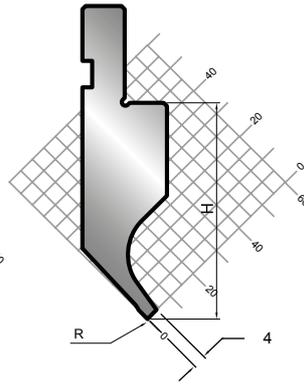
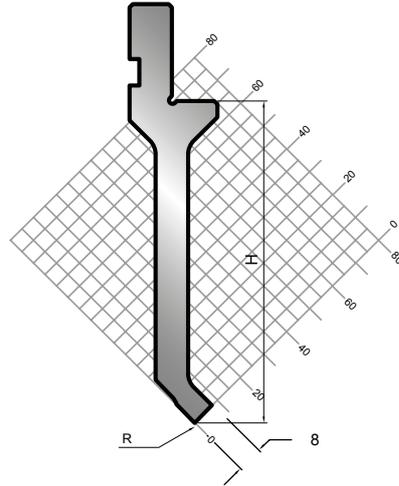
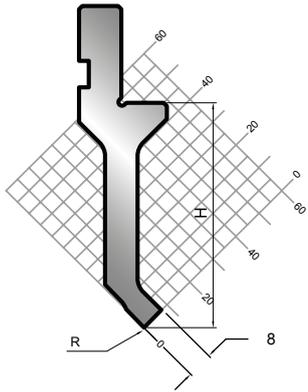


ton/m 50 L=835 - kg 9,00

HR TH		90°	
MOD.	R	H	
S2032	0,2	94,92	
S3032	0,6	94,4	
S4032	0,8	94,65	

EUROPEAN STYLE

PUNCHES 90° - 88°



ton/m 30 L=835 - kg 8,00

ton/m 30 L=835 - kg 10,10

ton/m 20 L=835 - kg 10,60

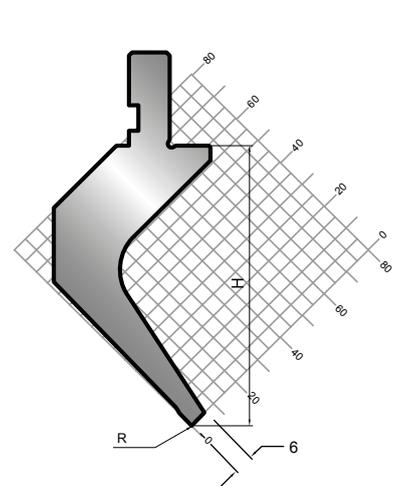
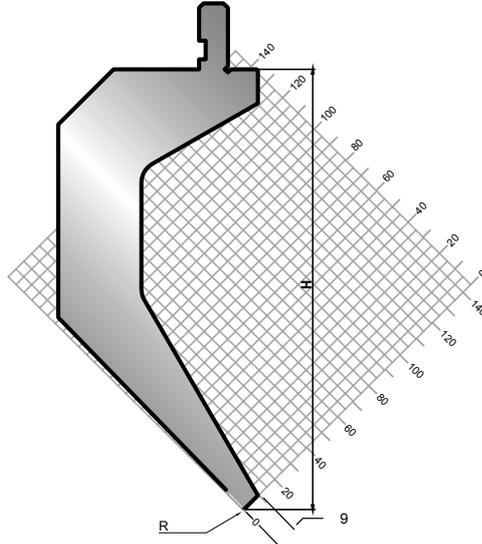
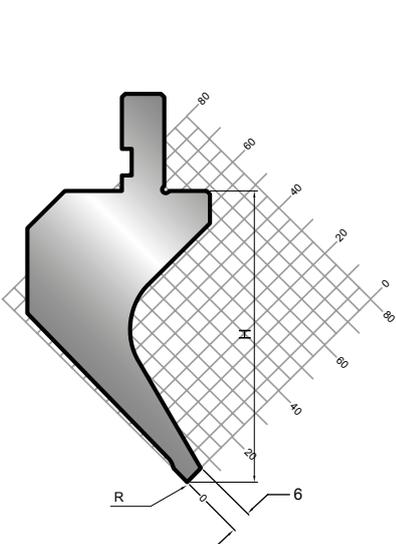
ton/m 80 L=835 - kg 10,80

HR TH	90°	
MOD.	R	H
S201	0,2	69,92
S202	0,6	69,4
S203	0,8	69,65

HR TH	90°	
MOD.	R	H
S3006	0,2	99,92
S2006	0,6	99,4
S4006	0,8	99,65

HR TH	88°	
MOD.	R	H
S2011	0,2	66,91
S2009	0,6	66,4
S3009	0,8	66,65

HR TH	88°	
MOD.	R	H
S4902	0,2	66,92
S4903	0,6	66,4
S4904	0,8	66,65



ton/m 50 L=835 - kg 19,00

ton/m 80 L=835 - kg 53,70

ton/m 30 L=835 - kg 14,00

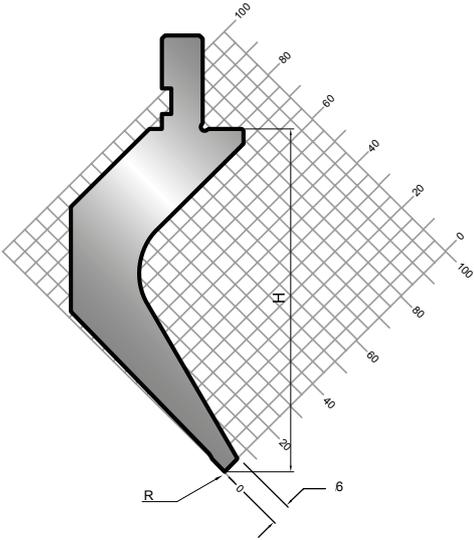
HR TH	88°	
MOD.	R	H
S4530288	0,2	89,91
S4530688	0,6	89,4
S2316	0,8	89,65
S4531588	1,5	89,34
S4533088	3	88,98

HR	88°	
MOD.	R	H
S2041	0,8	200

HR	88°	
MOD.	R	H
S2050	0,25	90

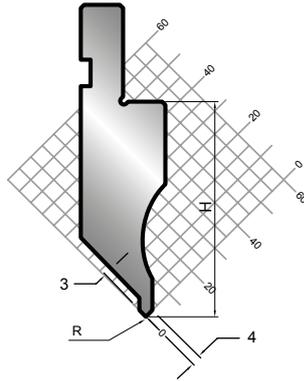
EUROPEAN STYLE

PUNCHES 88° - 85°



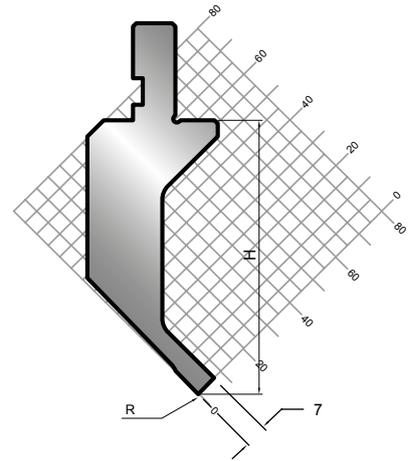
ton/m 30 L=835 - kg 18,70

HR		88°	
MOD.	R	H	
S2065	0,25	110	



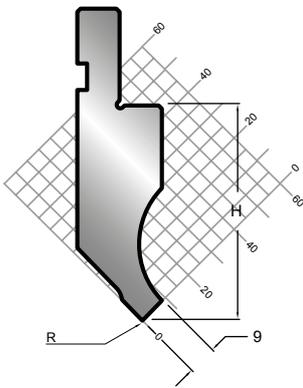
ton/m 80 L=835 - kg 10,80

HR TH		88°	
MOD.	R	H	
S4802	0,2	66,91	
S4803	0,6	66,4	
S4804	0,8	66,65	



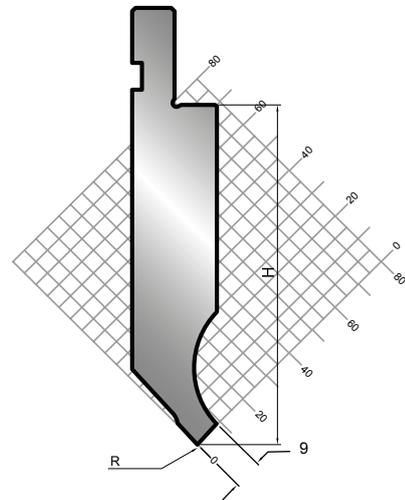
ton/m 20 L=835 - kg 14,10

TH		88°	
MOD.	R	H	
S2021	0,2	84,31	
S2022	0,6	84,15	
S2023	0,8	84,05	



ton/m 100 L=835 - kg 11,20

HR TH		88°		IH		88°	
MOD.	R	H		MOD.	R	H	
S0040288	0,2	66,91		S28814	0,2	66,91	
S0040688	0,6	66,4		S28815	0,6	66,40	
S0040888	0,8	66,65		S28849	0,8	66,65	
S0041588	1,5	66,34		S28816	1,5	66,34	
S0043088	3	65,68		S28811	3	65,68	



ton/m 100 L=835 - kg 17,50

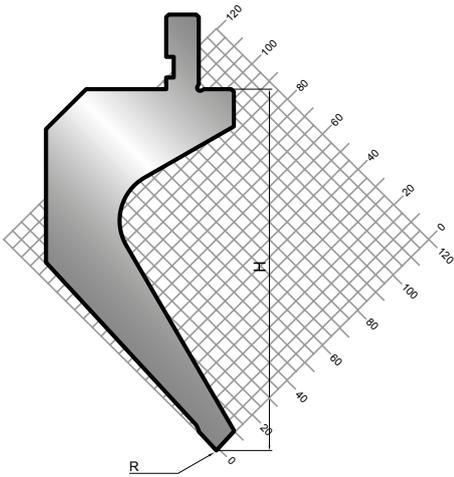
HR TH		88°		IH		88°	
MOD.	R	H		MOD.	R	H	
S0050288	0,2	104,91		S38815	0,2	104,91	
S0050688	0,6	104,4		S38816	0,6	104,40	
S0050888	0,8	104,65		S38813	0,8	104,65	
S0051588	1,5	104,34		S38817	1,5	104,34	
S0053088	3	103,68		S38818	3	103,68	

HR TH		85°		IH		85°	
MOD.	R	H		MOD.	R	H	
S0040285	0,2	66,91		S38819	0,2	66,91	
S0040685	0,6	66,4		S38820	0,6	66,40	
S0040885	0,8	66,65		S38812	0,8	66,65	
S0041585	1,5	66,34		S38821	1,5	66,34	
S0043085	3	65,68		S38811	3	65,68	

HR TH		85°		IH		85°	
MOD.	R	H		MOD.	R	H	
S0050285	0,2	104,91		S38821	0,2	104,91	
S0050685	0,6	104,4		S38822	0,6	104,40	
S0050885	0,8	104,65		S38814	0,8	104,65	
S0051585	1,5	104,34		S38823	1,5	104,34	
S0053085	3	103,68		S38824	3	103,68	

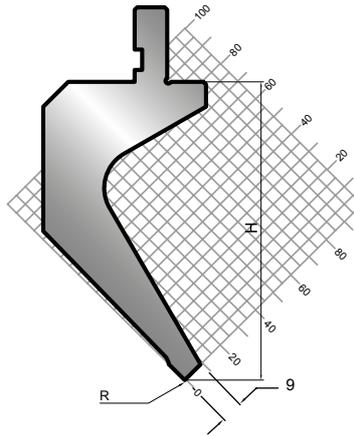
EUROPEAN STYLE

PUNCHES 88° - 85°



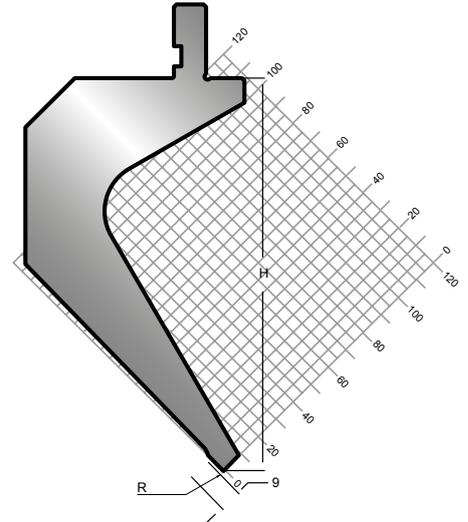
ton/m 50 L=835 - kg 35,00

HR		88°	
MOD.	R	H	
S47306	0,6	144,4	
S47308	0,8	145	



ton/m 50 L=835 - kg 25,70

HR TH		88°	
MOD.	R	H	
S1836	0,2	119,91	
S1837	0,6	119,4	
S1825	0,8	119,65	
S1838	1,5	119,34	
S1835	3	118,68	



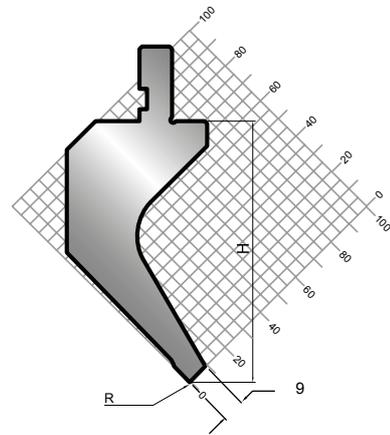
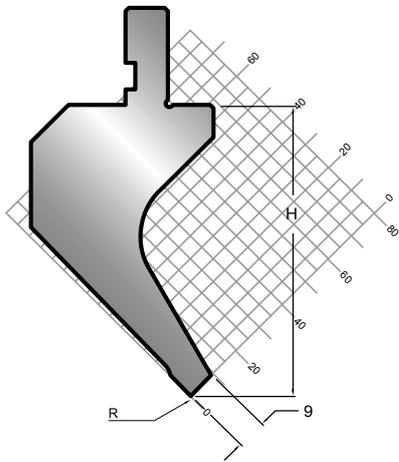
ton/m 50 L=835 - kg 40,70

HR		88°	
MOD.	R	H	
S47206	0,6	159,4	
S47208	0,8	159,65	

HR		85°	
MOD.	R	H	
S4730685	0,6	144,4	
S4730885	0,8	145	

HR TH		85°	
MOD.	R	H	
S2836	0,2	119,91	
S2837	0,6	119,4	
S2838	0,8	119,65	
S2839	1,5	119,34	
S2840	3	118,68	

HR		85°	
MOD.	R	H	
S4720685	0,6	159,4	
S4720885	0,8	159,65	



ton/m 70 L=835 - kg 19,50

HR TH		88°		IH		88°	
MOD.	R	H		MOD.	R	H	
S4620288	0,2	89,91		S28822	0,2	89,91	
S4620688	0,6	89,4		S28823	0,6	89,40	
S4620888	0,8	89,65		S28824	0,8	89,65	
S4621588	1,5	89,34		S28825	1,5	89,34	
S4623088	3	88,68		S28821	3	88,68	

ton/m 50 L=835 - kg 22,20

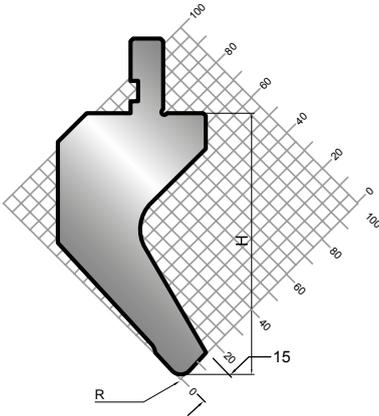
HR TH		88°		IH		88°	
MOD.	R	H		MOD.	R	H	
S0450288	0,2	104,91		S38844	0,2	104,91	
S0450688	0,6	104,4		S28843	0,6	104,40	
S0450888	0,8	104,65		S28844	0,8	104,65	
S0451588	1,5	104,34		S28845	1,5	104,34	
S0453088	3	103,68		S28841	3	103,68	

HR TH		85°		IH		85°	
MOD.	R	H		MOD.	R	H	
S4620285	0,2	89,91		S38822	0,2	89,91	
S4620685	0,6	89,4		S38823	0,6	89,40	
S4620885	0,8	89,65		S38824	0,8	89,65	
S4621585	1,5	89,34		S38825	1,5	89,34	
S4623085	3	88,68		S38821	3	88,68	

HR TH		85°		IH		85°	
MOD.	R	H		MOD.	R	H	
S0450285	0,2	104,91		S38841	0,2	104,91	
S0450685	0,6	104,4		S38842	0,6	104,40	
S0450885	0,8	104,65		S38840	0,8	104,65	
S0451585	1,5	104,34		S38843	1,5	104,34	
S0453085	3	103,68		S38845	3	103,68	

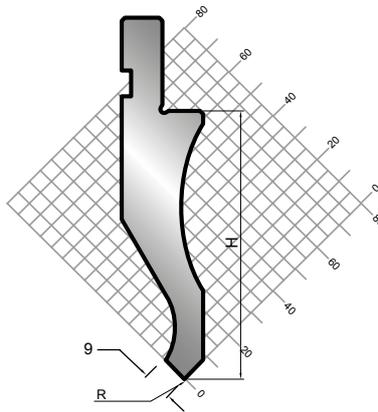
EUROPEAN STYLE

PUNCHES 88° - 85°



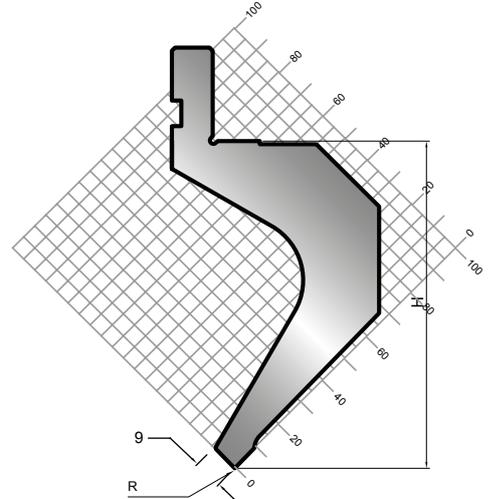
ton/m 100 L=835 - kg 26,00

HR 88°		
MOD.	R	H
S1848	4,8	105



ton/m 50 L=835 - kg 11,30

IH 88°		
MOD.	R	H
S2038	0,8	86



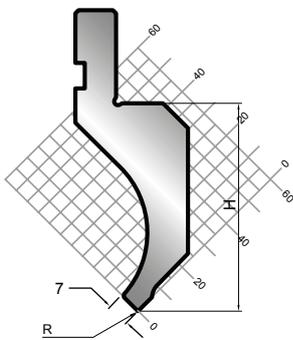
ton/m 30 L=835 - kg 26,00

HR 88°		
MOD.	R	H
S2101	0,8	104,65

HR 85°		
MOD.	R	H
S1864	6,4	104,33

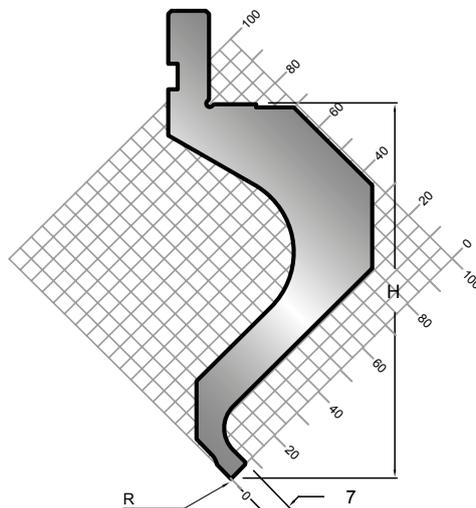
IH 85°		
MOD.	R	H
S20398	0,8	86

HR 85°		
MOD.	R	H
S2104	0,8	104,65



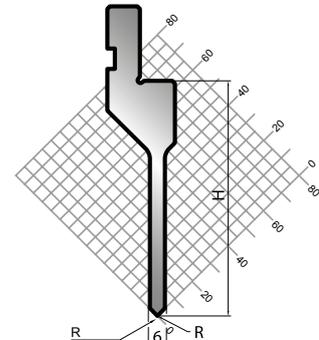
ton/m 60 L=835 - kg 10,20

HR 88°		
MOD.	R	H
S2100	0,8	66,65



ton/m 40 L=835 - kg 21,50

HR 88°		
MOD.	R	H
S2102	0,8	120



ton/m 50 L=835 - kg 9,00

HR TH 88°		
MOD.	R	H
S2033	0,2	94,92
S2030	0,6	94,4
S2034	0,8	94,65

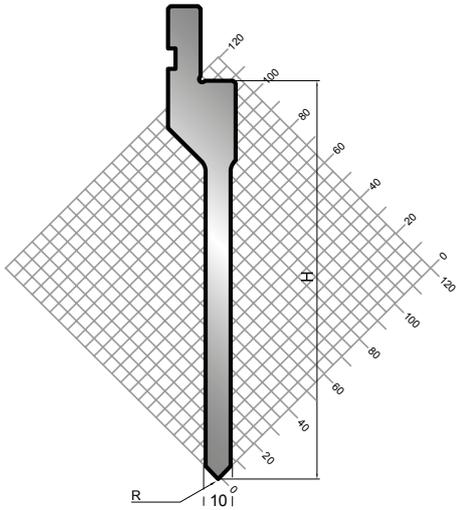
HR 85°		
MOD.	R	H
S2103	0,8	66,65

HR 85°		
MOD.	R	H
S2105	0,8	120

HR TH 85°		
MOD.	R	H
S2035	0,2	94,92
S2036	0,6	94,4
S2037	0,8	94,65

EUROPEAN STYLE

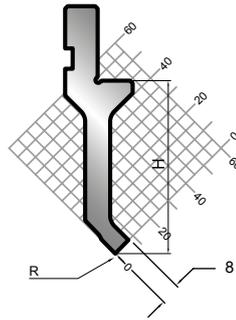
PUNCHES 88° - 85° - 75° - 60°



ton/m 50 L=835 - kg 15,65

HR 88°		
MOD.	R	H
S1130688	0,6	159,4
S1130888	0,8	159,65

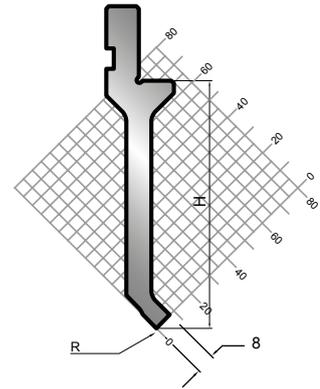
HR 85°		
MOD.	R	H
S1130685	0,6	159,4
S1130885	0,8	159,65



ton/m 30 L=835 - kg 8,00

HR TH 88°		
MOD.	R	H
S2000288	0,2	69,91
S2000688	0,6	69,4
S2000888	0,8	69,65

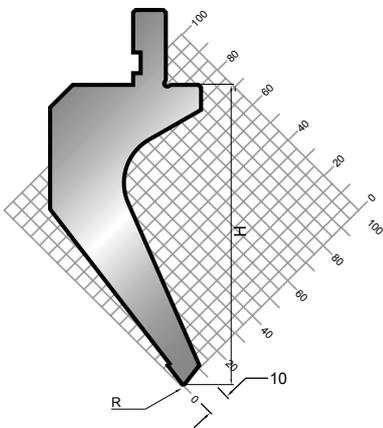
HR TH 85°		
MOD.	R	H
S2000285	0,2	69,91
S2000685	0,6	69,4
S2000885	0,8	69,65



ton/m 30 L=835 - kg 10,10

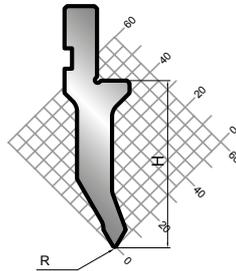
HR TH 88°		
MOD.	R	H
S3007	0,2	99,91
S2007	0,6	99,4
S4007	0,8	99,65

HR TH 85°		
MOD.	R	H
S5007	0,2	99,91
S6007	0,6	99,4
S7007	0,8	99,65



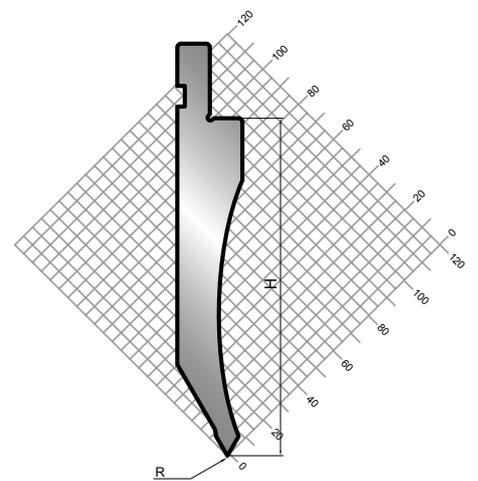
ton/m 50 L=835 - kg 25,70

HR 75°		
MOD.	R	H
S0471	0,8	120



ton/m 100 L=835 - kg 8,70

IH 60°		
MOD.	R	H
S2060	0,8	67
S2062	2	65,8

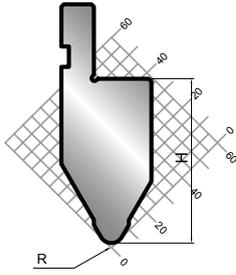


ton/m 100 L=835 - kg 17,70

HR 60°		
MOD.	R	H
S1997	0,8	135
S1998	2	133,8

EUROPEAN STYLE

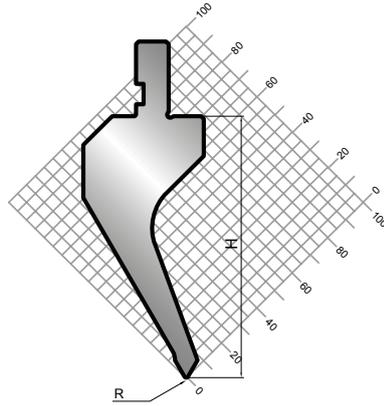
PUNCHES 60° - 50° - 45°



ton/m 100 L=835 - kg 15,30

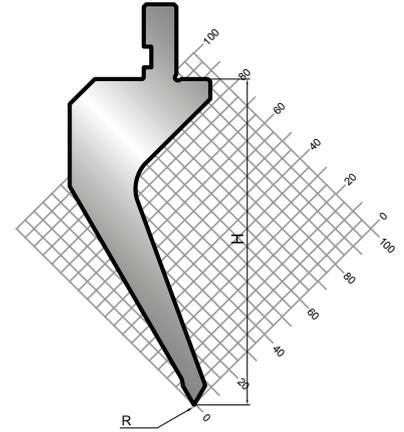
HR		60°	
MOD.	R	H	
S0031	4,8	66,2	
S0032	6	65	

IH		60°	
MOD.	R	H	
S26011	6	65	



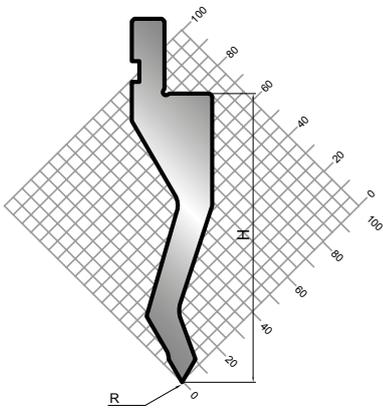
ton/m 60 L=835 - kg 18,50

HR		60°	
MOD.	R	H	
S2065	0,8	105	
S2069	2	103,8	



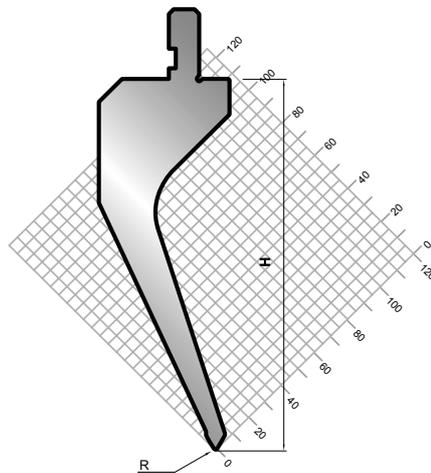
ton/m 60 L=835 - kg 22,80

HR		60°	
MOD.	R	H	
S2067	0,8	130	
S2070	2	128,8	



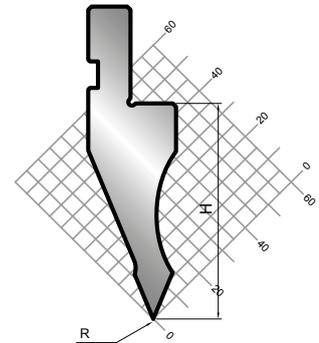
ton/m 60 L=835 - kg 18,50

HR		60°	
MOD.	R	H	
S2066	0,8	115	
S2071	2	113,8	



ton/m 50 L=835 - kg 27

HR		50°	
MOD.	R	H	
S2068	0,8	160	



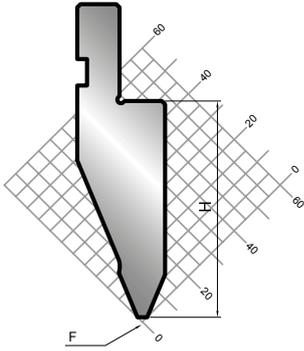
ton/m 100 L=835 - kg 9,10

HR TH		45°	
MOD.	R	H	
S0081	0,37	66,4	

IH		45°	
MOD.	R	H	
S20014	0,5	66,4	
S24511	1,5	65,2	

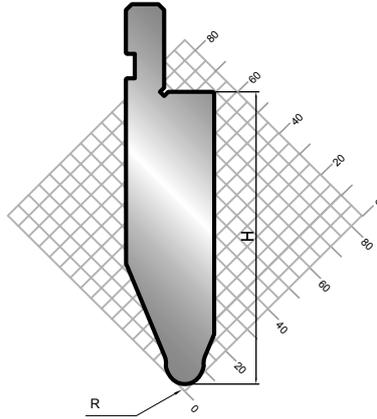
EUROPEAN STYLE

PUNCHES 45° - 35° - 30°



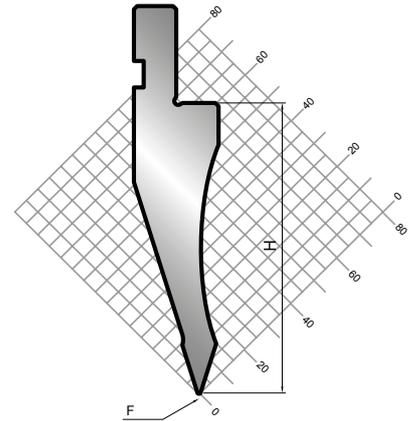
ton/m 100 L=835 - kg 10,00

HR		45°	
MOD.	F	H	
S215	3	67	



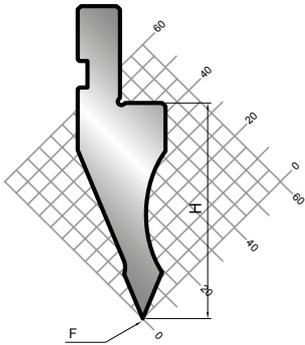
ton/m 100 L=835 - kg 19,40

IH		45°	
MOD.	R	H	
S1960	6	100	



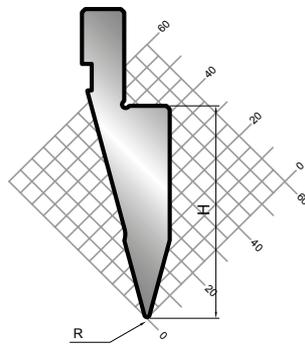
ton/m 100 L=835 - kg 11,80

HR IH		35°	
MOD.	F	H	
S1543	0,8	90	



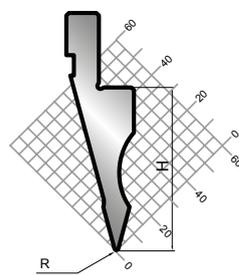
ton/m 100
L=835 - kg 9,80

IH		35°	
MOD.	F	H	
S1545	0,8	67	



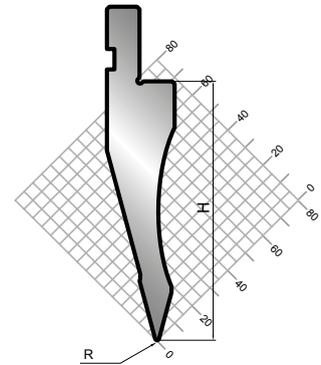
ton/m 100
L=835 - kg 8,50

HR TH		30°	
MOD.	R	H	
S1035	0,8	65,5	



ton/m 100
L=835 - kg 7,70

HR TH		30°	
MOD.	R	H	
S1380	0,8	65,5	

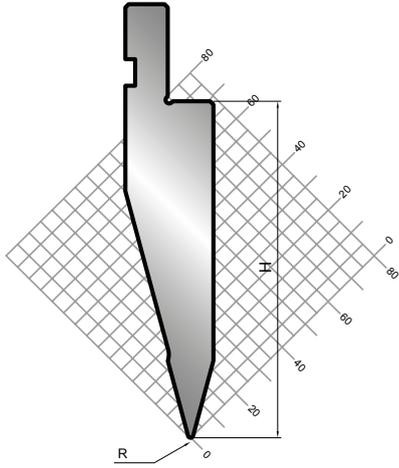


ton/m 100
L=835 - kg 14,00

HR TH		30°	
MOD.	R	H	
S1319	0,8	104	

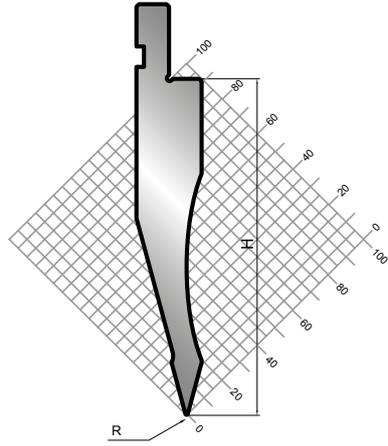
EUROPEAN STYLE

PUNCHES 30° - 26°



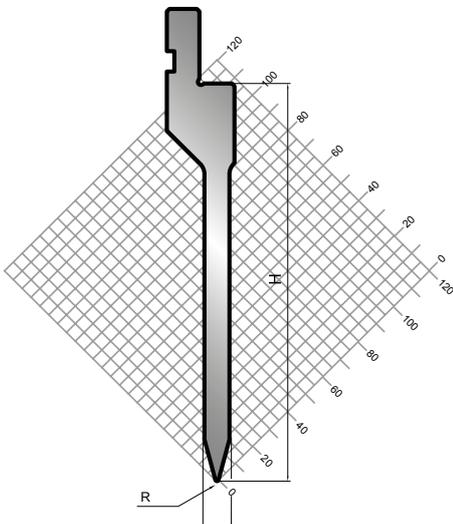
ton/m 100 L=835 - kg 15,00

HR TH		30°	
MOD.	R	H	
S1580	0,65	104	
S1589	0,8	104	
S1590	1,5	102	
S1591	3	97,7	



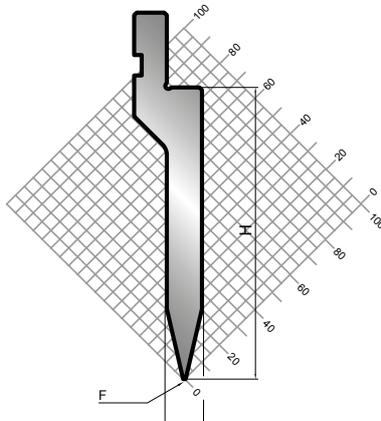
ton/m 100 L=835 - kg 17,70

HR		30°	
MOD.	R	H	
S1996	0,5	135	



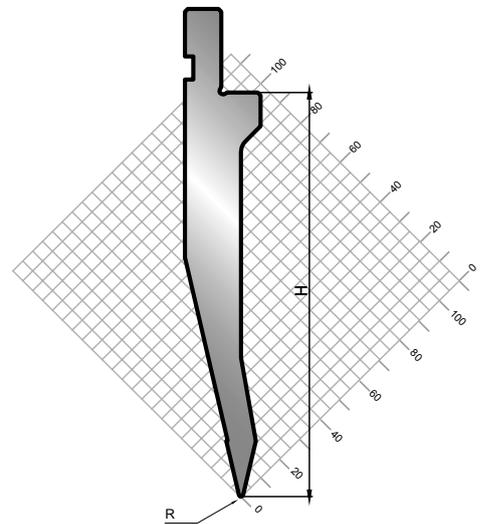
ton/m 50 L=835 - kg 15,60

HR		30°	
MOD.	R	H	
S1586	0,65	160	



ton/m 100 L=835 - kg 14,60

IH		26°	
MOD.	F	H	
S1754	1	117	

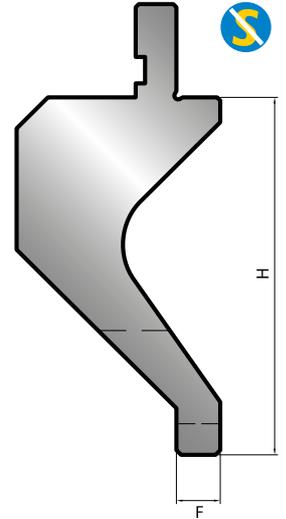
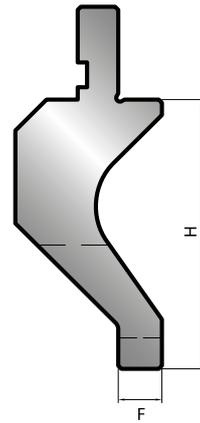
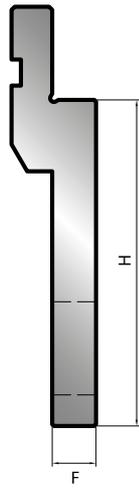
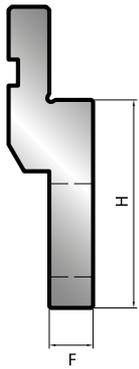


ton/m 90 L=835 - kg 17,50

HR		26°	
MOD.	R	H	
S1756	0,8	145	

EUROPEAN STYLE

PUNCH HOLDER



ton/m 100 L=830 - kg 12,80

ton/m 100 L=830 - kg 12,80

ton/m 50 L=830 - kg 9,00

ton/m 50 L=830 - kg 12,00

IH

MOD.	F	H
S3078	14	67

IH

MOD.	f	H
S1872	14	105

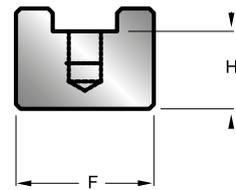
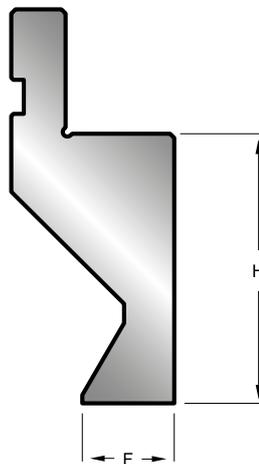
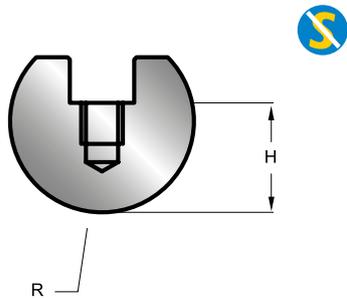
IH

MOD.	F	H
S1874	14	87

IH

MOD.	F	H
S1875	14	115

RADIUS RULERS AND FLATTENING PUNCHES



ton/m 100

ton/m 100 L=835 - kg 13,40

ton/m 100 L=835 - kg 3,90

IH

MOD.	R	H	L=835
S083079	8	13	kg 2
S103079	10	16	kg 2
S1253079	12,5	18	kg 2,80
S153079	15	20	kg 3,90
S1753079	17,5	22	kg 5,30
S203079	20	24	kg 6,60
S253079	25	29	kg 10
S303079	30	34	kg 13,60
S353079	35	45	kg 20,30
S403079	40	45	kg 13,60
S453079	45	60	kg 34
S503079	50	70	kg 43,50

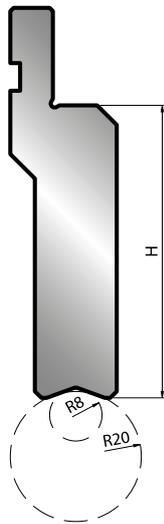
IH

MOD.	F	H
S1523	23	65

IH

MOD.	F	H
S3081	30	17

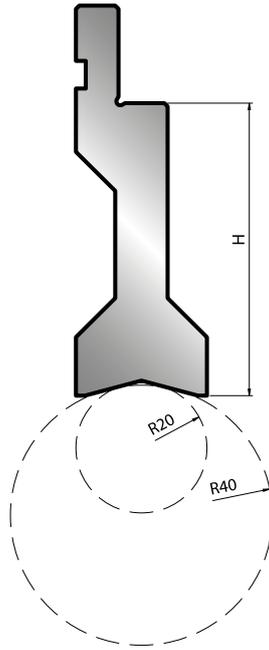
PUNCH HOLDER



L=834 - kg 17,60

IH

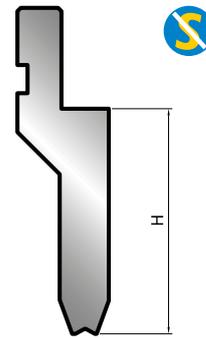
MOD.	H
S4045	90



L=834 - kg 16,80

IH

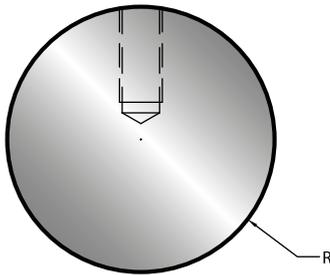
MOD.	H
S4055	90



L=830 - kg 9,60

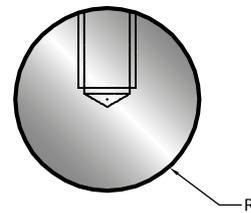
IH

MOD.	H
S4065	67



IH

MOD.	R	L=835
S084019	8	kg 0,80
S184019	10	kg 1,30
S1254019	12,5	kg 2
S154019	15	kg 3
S1754019	17,5	kg 4
S204019	20	kg 5,20
S254019	25	kg 8,10
S304019	30	kg 11,70
S354019	35	kg 16
S404019	40	kg 20,70

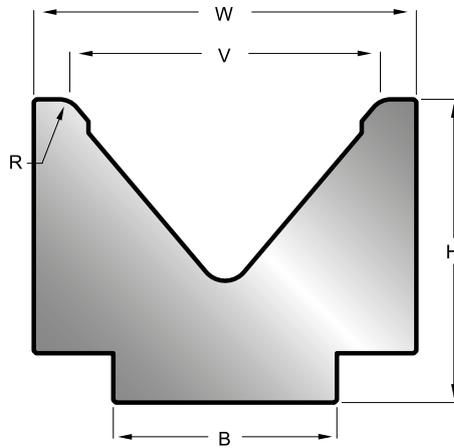


IH

MOD.	R	L=835
S034029	3	kg 0,20
S354029	3,5	kg 0,20
S044029	4	kg 0,35
S454029	4,5	kg 0,50
S054029	5	kg 0,60
S554029	5,5	kg 0,70
S064029	6	kg 0,80
S654029	6,5	kg 1
S074029	7	kg 1
S754029	7,5	kg 1



TECHNICAL INFORMATION



L'utensile non è sezionabile in modo standard.
The tool can't be sectioned in the standard way.

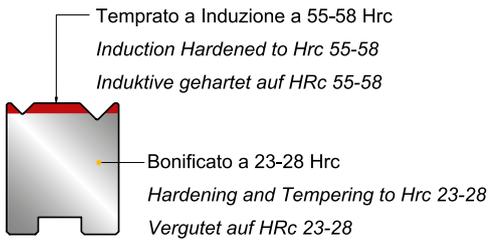


Contattateci per ulteriori chiarimenti.
Please contact us for any clarification.



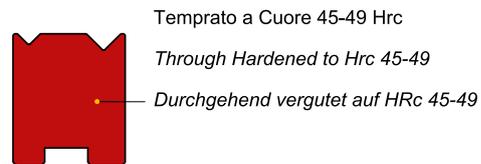
Trattamento ideale per piegare la lamiera zincata e l'acciaio inox.
Ideal treatment to bend the galvanized steel and the stainless steel.

SCHIAVI HR

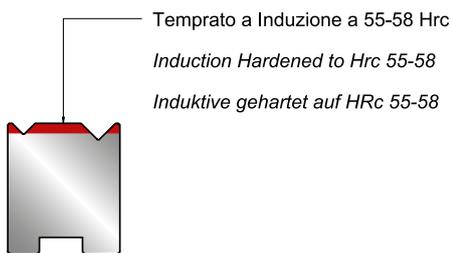


SCHIAVI TH

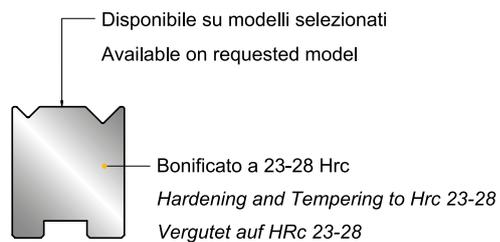
Su ordinazione anche nella variante GOLD
Available in GOLD style



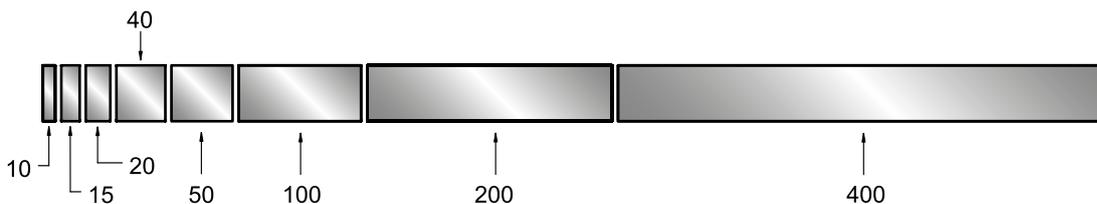
SCHIAVI IH



Su ordinazione anche nella variante GOLD
Available in GOLD style

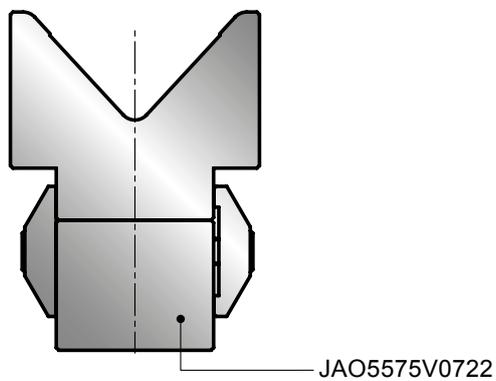
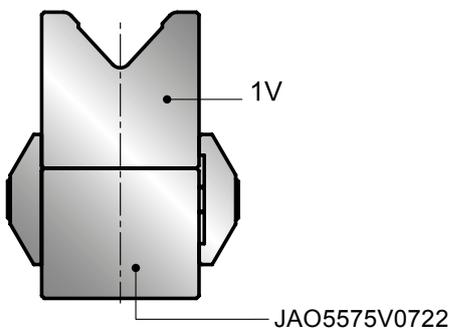
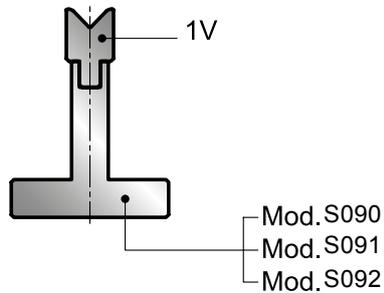
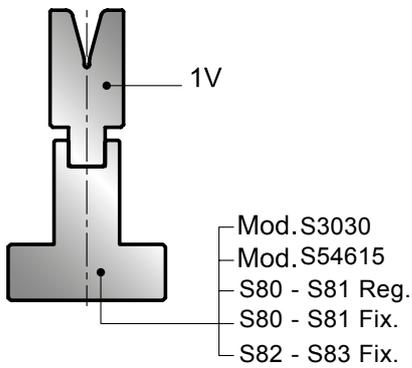
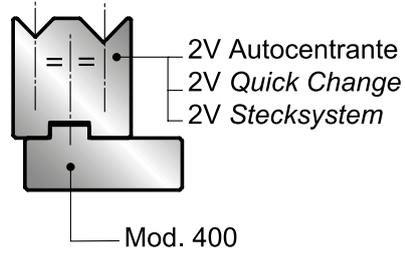
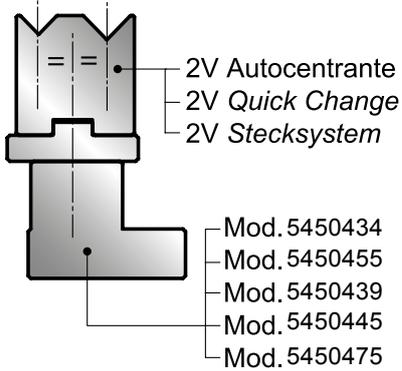
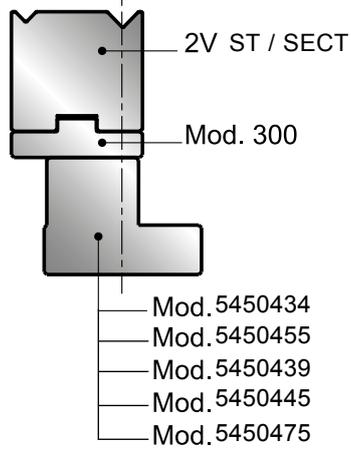
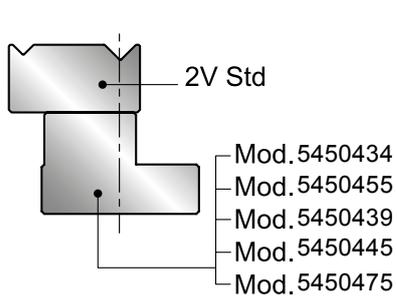


Lunghezza standard - Standard length - Standardlängen 835 mm - 415 mm - 835 mm sect.



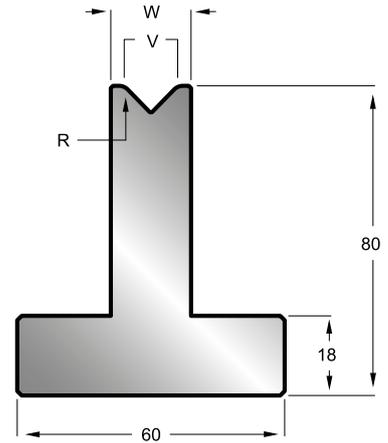
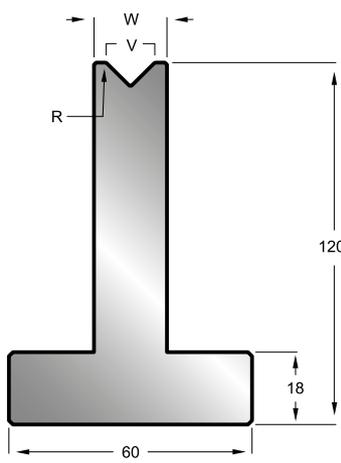
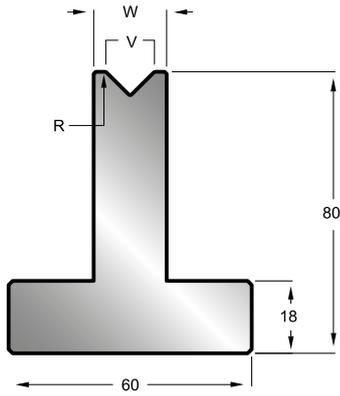
EUROPEAN STYLE

DIES SET UP SYSTEM



EUROPEAN STYLE

DIES T 90° - 88° - 85°



HR 90°

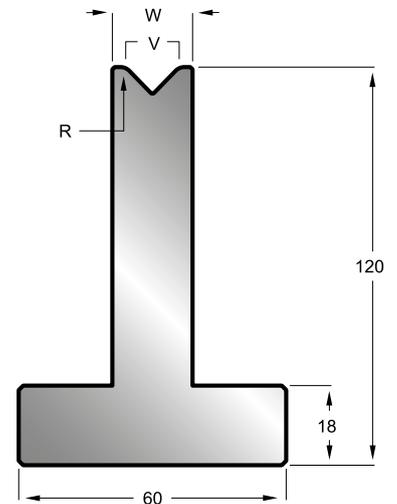
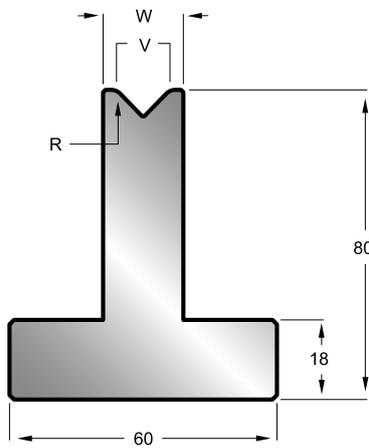
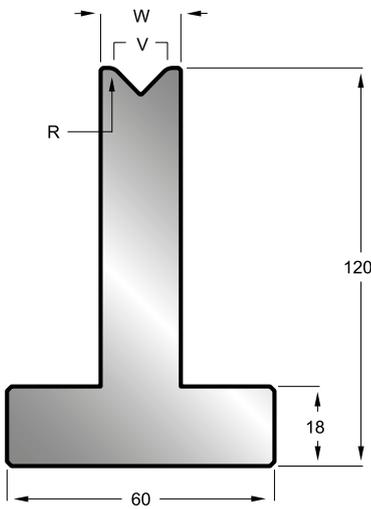
MOD.	V	R	W	ton/m	L=835
S0632T	6	0,4	14	100	kg 12,70
S0637T	8	0,5	14	80	kg 12,70
S0629T	10	0,6	18	100	kg 14,50
S0643T	12	0,8	18	80	kg 14,30
S0644T	16	1	24	100	kg 16,40

HR 90°

MOD.	V	R	W	ton/m	L=835
S1100T	6	0,4	14	100	kg 15,90
S1101T	8	0,5	14	80	kg 15,90
S1102T	10	0,6	18	100	kg 18
S1103T	12	0,8	18	80	kg 18
S1104T	16	1	24	100	kg 22,50

HR 88°

MOD.	V	R	W	ton/m	L=835
S0670T	6	0,4	14	100	kg 12,70
S0671T	8	0,5	14	80	kg 12,70
S0672T	10	0,6	18	100	kg 14,50
S0673T	12	2,75	18	80	kg 14,30
S0648T	16	2,75	24	100	kg 16,40
S0674T	20	3,0	30	100	kg 18,40
S0675T	25	3,0	35	100	kg 18,30



HR 88°

MOD.	V	R	W	ton/m	L=835
S1105T	6	0,4	14	100	kg 15,90
S1106T	8	0,5	14	80	kg 15,90
S1107T	10	0,6	18	100	kg 18
S1108T	12	2,75	18	80	kg 18,80
S1109T	16	2,75	24	100	kg 22,50
S1110T	20	3,0	30	100	kg 26
S1111T	25	3,0	35	100	kg 29,50

HR 85°

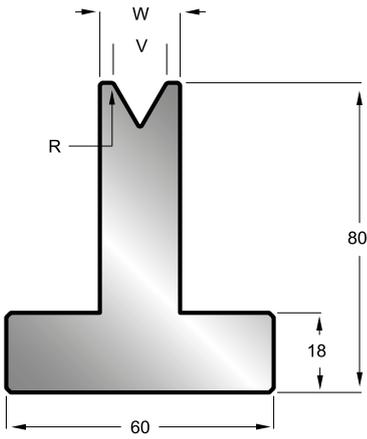
MOD.	V	R	W	ton/m	L=835
S0770T	6	1,5	14	100	kg 13
S0771T	8	1,5	14	80	kg 13
S0772T	10	2,0	18	100	kg 15
S0773T	12	2,75	18	80	kg 15
S0748T	16	2,75	24	100	kg 17,50
S0774T	20	3,0	30	100	kg 19
S0775T	25	3,0	35	100	kg 20

HR 85°

MOD.	V	R	W	ton/m	L=835
S1205T	6	1,5	14	100	kg 16,50
S1206T	8	1,5	14	80	kg 19
S1207T	10	2,0	18	100	kg 19
S1208T	12	2,75	18	80	kg 17
S1209T	16	2,75	24	100	kg 22
S1210T	20	3,0	30	100	kg 27
S1211T	25	3,0	35	100	kg 30

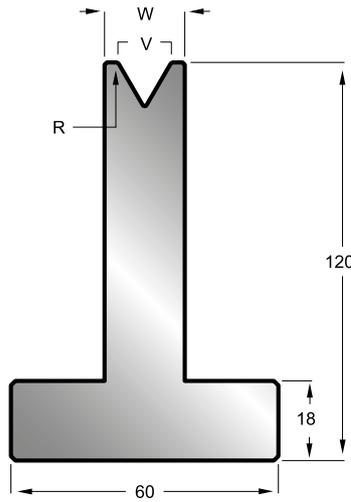
EUROPEAN STYLE

DIES T 60° - 45° - 35°



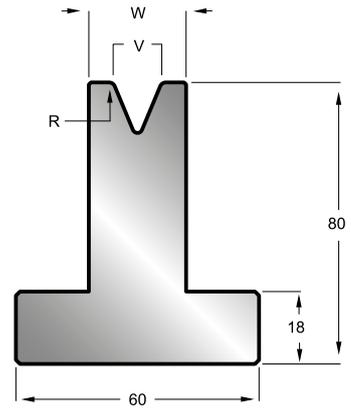
ton/m 60

HR	60°				
MOD.	V	R	W	L=835	
S0650T	6	0,4	14	kg 12,70	
S0651T	8	0,5	14	kg 12,70	
S0652T	10	0,6	18	kg 14,50	
S0653T	12	0,8	18	kg 14,20	
S0647T	16	3,0	24	kg 16,30	
S0654T	20	3,0	30	kg 18,30	
S0655T	25	3,0	35	kg 19,20	



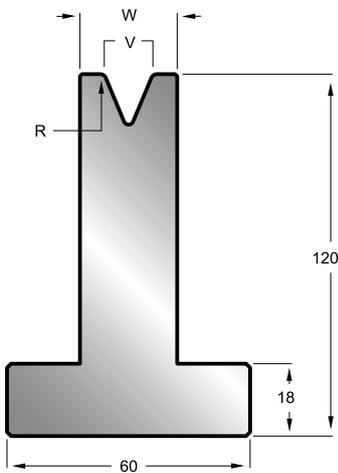
ton/m 60

HR	60°				
MOD.	V	R	W	L=835	
S1113T	6	0,4	14	kg 15,80	
S1114T	8	0,5	14	kg 15,90	
S1115T	10	0,6	18	kg 18	
S1116T	12	0,8	18	kg 18,40	
S1117T	16	3,0	24	kg 22,30	
S1118T	20	3,0	30	kg 25,80	
S1119T	25	3,0	35	kg 28	



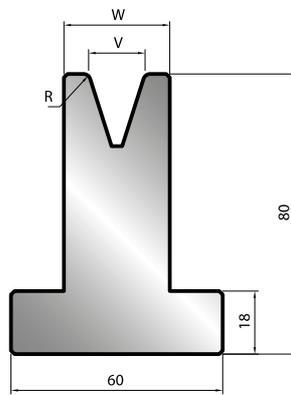
ton/m 50

HR	45°				
MOD.	V	R	W	L=835	
S1070T	6	0,6	14	kg 12,52	
S1071T	8	0,8	18	kg 14	
S1072T	10	1,0	18	kg 14	
S1073T	12	1,5	24	kg 16,20	
S1074T	16	2,0	24	kg 16	
S1075T	20	2,5	30	kg 17,56	
S1076T	25	3,0	35	kg 18,80	

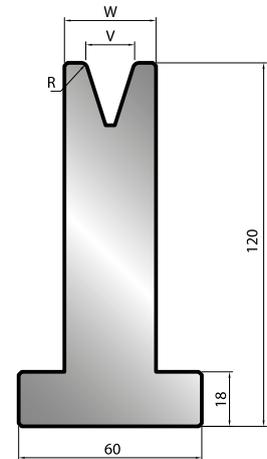


ton/m 50

HR	45°				
MOD.	V	R	W	L=835	
S1121T	6	0,6	14	kg 17	
S1122T	8	0,8	18	kg 19	
S1123T	10	1,0	18	kg 20	
S1124T	12	1,5	24	kg 22	
S1125T	16	2,0	24	kg 23	
S1126T	20	2,5	30	kg 25	
S1127T	25	3,0	35	kg 26,50	

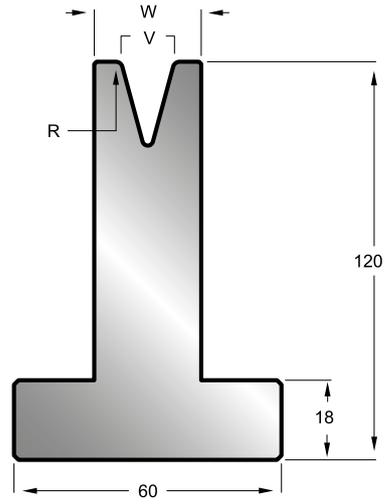
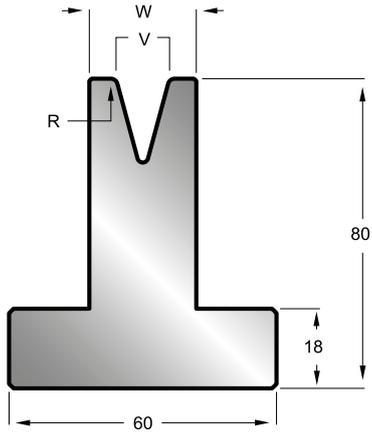


HR	35°				
MOD.	V	R	W	ton/m	L=835
S0727T	6	0,6	14	35	kg 12,52
S0728T	8	0,8	14	35	kg 13,98
S0729T	10	1,0	18	40	kg 16,19
S0730T	12	1,5	18	40	kg 15,92
S0731T	16	2,0	30	45	kg 17
S0732T	20	2,5	35	50	kg 18
S0733T	25	3,0	40	50	kg 20



HR	35°				
MOD.	V	R	W	ton/m	L=835
S1727T	6	0,6	14	35	kg 16
S1728T	8	0,8	14	35	kg 18
S1729T	10	1,0	18	40	kg 19
S1730T	12	1,5	18	40	kg 21
S1731T	16	2,0	30	45	kg 25,50
S1732T	20	2,5	35	50	kg 28
S1733T	25	3,0	40	50	kg 26

DIES T 30°

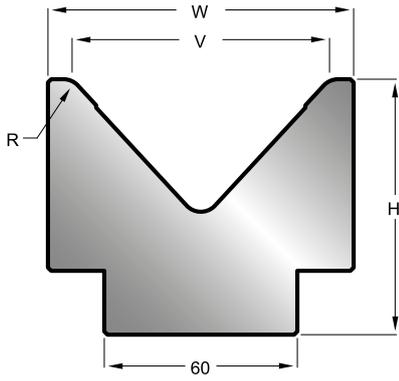


HR	30°				
MOD.	V	R	W	ton/m	L=835
S1080T	6	0,6	14	35	kg 12,52
S1081T	8	0,8	18	35	kg 13,98
S1082T	10	1,0	24	50	kg 16,19
S1083T	12	1,5	24	40	kg 15,92
S1084T	16	2,0	30	45	kg 17,79
S1085T	20	2,5	35	50	kg 18,94
S1086T	25	3,0	40	50	kg 19,59

HR	30°				
MOD.	V	R	W	ton/m	L=835
S1129T	6	0,6	14	35	kg 16,20
S1130T	8	0,8	18	35	kg 18
S1131T	10	1,0	24	50	kg 21,80
S1132T	12	1,5	24	40	kg 22,20
S1133T	16	2,0	30	45	kg 25
S1134T	20	2,5	35	50	kg 28
S1135T	25	3,0	40	50	kg 30

EUROPEAN STYLE

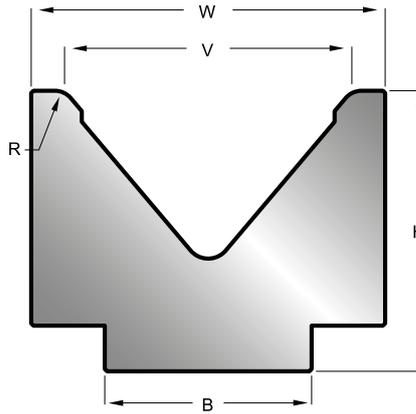
DIES 1V



ton/m 100

IH

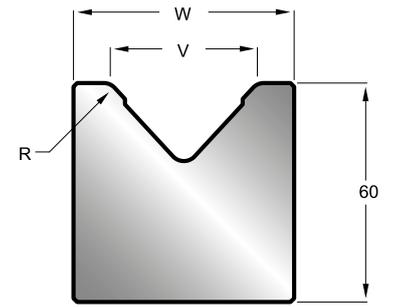
MOD.	A	V	R	W	H	L=835
S006300M	85°	63	5	80	75	kg 29,20
S008000M	85°	80	6	95	95	kg 43
S80060M	60°	80	6	115	115	kg 53



ton/m 100

IH

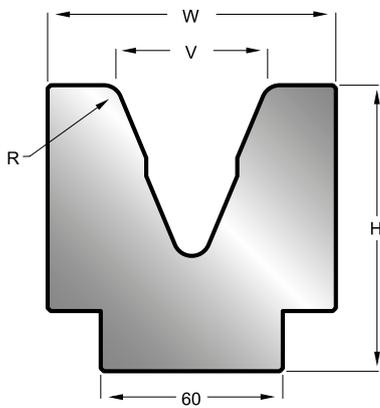
MOD.	V	B	R	W	H	L=835
S010000M	100	60	7	120	110	kg 58,50
S012500M	125	90	9	153	123	kg 82
S016000M	160	90	11	185	130	kg 100



ton/m 100

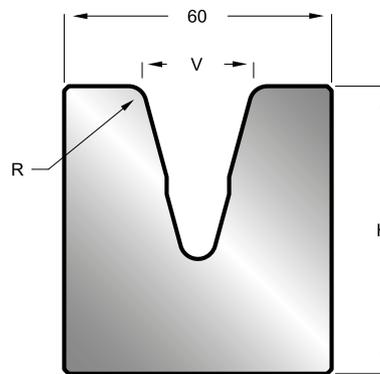
IH

MOD.	V	R	L=835
S003200M	32	4	kg 21,60
S004000M	40	4	kg 20,50
S005000M	50	4	kg 18,80



IH

MOD.	V	R	W	H	ton/m	L=835
S32045M	32	5	60	60	40	kg 19,20
S40045M	40	5	80	80	70	kg 32,10
S50045M	50	6	95	95	70	kg 43,70
S63045M	63	8	105	105	90	kg 51,16

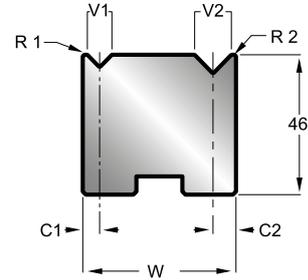
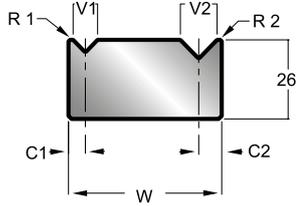


ton/m 60

HR

MOD.	V	R	H	ton/m	L=835
S340030	18	3,0	60	80	kg 21,50
S341030	25	4,0	65	60	kg 21,60

DIES 2V - 90°



HRTH 90°

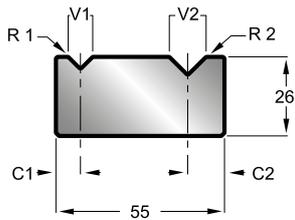
MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S12190	4	7	0,4	0,4	3,5	5,0	50	60	kg 8,40
S12390	6	10	0,4	0,6	4,5	6,5	50	70	kg 8,30
S12490	8	12	0,5	0,8	5,5	7,5	50	80	kg 8,20
S12590	14	18	0,5	0,5	8,5	10,5	50	100	kg 7,70
S31190	6	10	1,5	2,5	6,0	10,0	50	80	kg 9,20

Supporti - Die Holder - Halter
Mod 4006/4007 - 931/932/933

HRTH 90°

MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S3014090	4	7	0,4	0,4	3,5	5,0	50	60	kg 14,40
S3024090	6	10	0,4	0,6	4,5	6,5	50	70	kg 14,30
S3034090	8	12	0,5	0,8	5,5	7,5	50	80	kg 14,20
S3044090	14	18	0,5	0,5	8,5	10,5	50	100	kg 13,60
S3114690	6	10	1,5	2,5	6,0	10,0	50	80	kg 15

Supporti - Die Holder - Halter Mod. 931000
Guida - Die Rail - Matrizen Halter - Mod. 300000

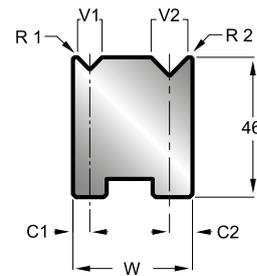


ton/m 100

IH 90°

MOD.	V1	V2	R1	R2	C1	C2	L=835
S040790M	6	10	0,4	0,6	6,0	10	kg 9,10
S081290M	8	12	0,5	0,8	8,0	10	kg 9

Supporti - Die Holder - Halter
Mod 4006/4007 - 931/932/933



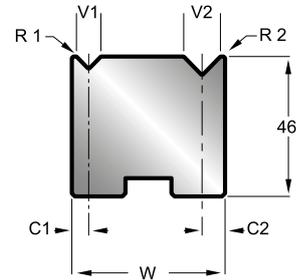
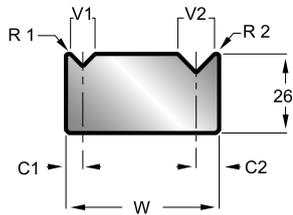
HRTH 90°

MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S501900M	4	7	0,4	0,4	3,5	5,0	34,5	60	kg 9,60
S502900M	6	10	0,4	0,6	4,5	6,5	37	70	kg 10,20
S503900M	8	12	0,5	0,8	5,5	7,5	39	80	kg 10,70
S504900M	14	18	0,5	0,5	8,5	10,5	45	100	kg 12
S511900M	6	10	1,5	2,5	6,0	10,0	40	80	kg 11,20

Supporti - Die Holder - Halter
Mod 4006/4007 - 931/932/933

EUROPEAN STYLE

DIES 2V - 88°



HRTH 88°

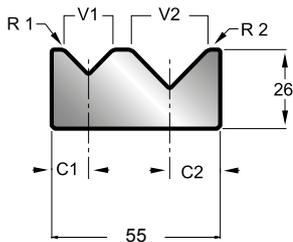
MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S12188	4	7	0,4	0,4	3,5	5,0	50	60	kg 8,40
S12388	6	10	0,4	0,6	4,5	6,5	50	70	kg 8,30
S12488	8	12	0,5	0,8	5,5	7,5	50	80	kg 8,20
S12588	14	18	0,5	0,5	8,5	10,5	50	100	kg 7,70
S12688	12	20	0,5	0,5	7,5	12,0	50	100	kg 7,60
S12788	16	25	0,8	0,8	9,5	14,5	50	100	kg 7
S31188	6	10	1,5	2,5	6,0	10,0	55	80	kg 9,20
S31488	12	20	3,0	4,0	10,0	15,0	55	100	kg 8,50

Supporti - Die Holder - Halter
Mod 4006/4007 - 931/932/933

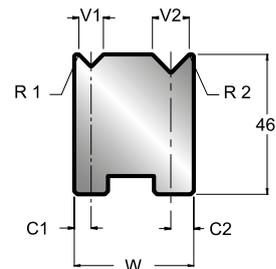
HRTH 88°

MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S3014088	4	7	0,4	0,4	3,5	5,0	50	60	kg 14,40
S3024088	6	10	0,4	0,6	4,5	6,5	50	70	kg 14,30
S3034088	8	12	0,5	0,8	5,5	7,5	50	80	kg 14,20
S3044088	14	18	0,5	0,5	8,5	10,5	50	100	kg 13,60
S3054088	12	20	0,5	0,5	7,5	12,0	50	100	kg 13,60
S3064088	16	25	0,8	0,8	9,5	14,5	50	100	kg 13
S3114688	6	10	1,5	2,5	6,0	10,0	55	80	kg 15
S3144088	12	20	3,0	4,0	10,0	15,0	55	100	kg 14,85

Supporti - Die Holder - Halter - Mod 931000
Guida - Die Rail - Matricen Halter - Mod. 300000



ton/m 100



IH 88°

MOD.	V1	V2	R1	R2	C1	C2	L=835
S122088M	12	20	2,75	3,0	10,0	15	kg 8,30
S162588M	16	25	2,75	3,0	12,0	16,5	kg 7,80

Supporti - Die Holder - Halter
Mod 4006/4007 - 931/932/933

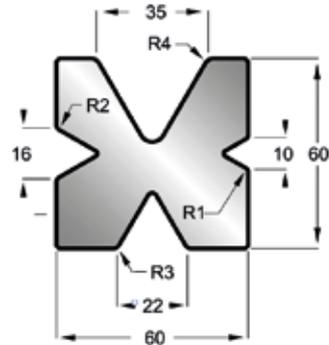
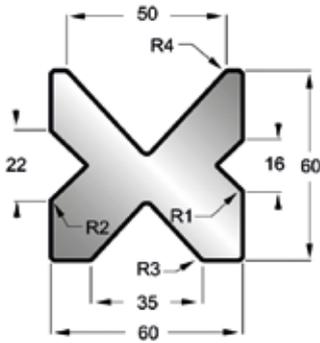
HRTH 88°

MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S501880M	4	7	0,4	0,4	3,5	5,0	34,5	60	kg 9,60
S502880M	6	10	0,4	0,6	4,5	6,5	37	70	kg 10,20
S503880M	8	12	0,5	0,8	5,5	7,5	39	80	kg 10,70
S504880M	14	18	0,5	0,5	8,5	10,5	45	100	kg 12
S505880M	12	20	0,5	0,5	7,5	12,0	45,5	100	kg 12,10
S506880M	16	25	0,8	0,8	9,5	14,5	50	100	kg 13
S507880M	6	10	1,5	2,5	6,0	10,0	40	80	kg 11,10
S508880M	12	20	3,0	4,0	10,0	15,0	50	100	kg 13,45

Supporti - Die Holder - Halter Mod 4006/4007 - 931/932/933
Guida - Die Rail - Matricen Halter - Mod. 300000

EUROPEAN STYLE

DIES 2V - 88° - 85° - 60°

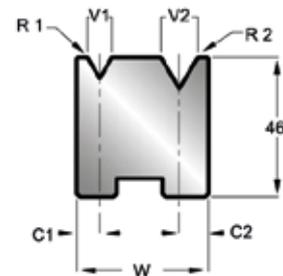
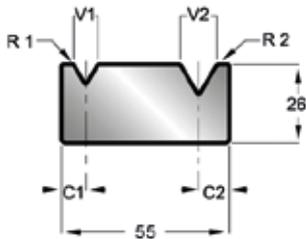


IH 88° - 85°

MOD.	A	R1	R2	R3	R4	ton/m	L=835
S4V8588M	88-85	0,5	0,5	2,0	2,0	100	kg 15,70
S4V850M	85	2,0	2,0	2,0	3,0	100	kg 15,70

IH 60°

MOD.	A	R1	R2	R3	R4	ton/m	L=835
S4V600M	60	1,5	2,0	2,5	3,0	100	kg 17,75



HRTH 60°

MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S061060M	6	10	0,4	0,6	6,0	10,0	55	100	kg 8,40
S081260M	8	12	0,4	0,8	8,0	10,0	55	100	kg 8,30
S062060M	16	20	1,6	2,0	12,0	15,0	55	100	kg 8,20

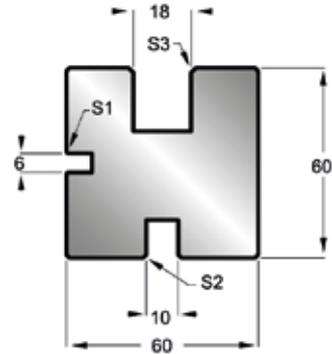
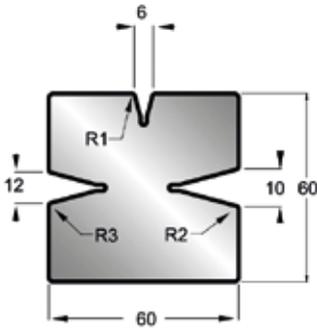
HRTH 60°

MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S502600M	6	10	0,6	1,0	6,0	8,5	41	60	kg 10,20
S503600M	8	12	0,8	1,2	7,5	9,5	43	60	kg 10,70
S50460M	16	25	1,6	2,5	12,0	17,0	55	60	kg 12,95

Supporti - Die Holder - Halter
Mod 4006/4007 - 931/932/933

Supporti - Die Holder - Halter - Mod 931000
Guida - Die Rail - Matrizen Halter - Mod. 300000

DIES 2V - 30°

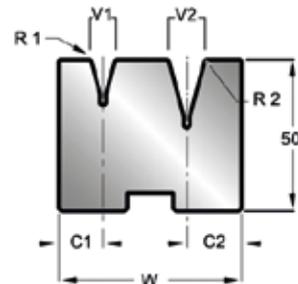
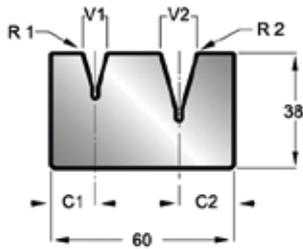


IH 30°

MOD.	A	R1	R2	R3	ton/m	L=835
S3V2410M	30	1,0	1,0	1,5	80	kg 21,90

IH

MOD.	A	R1	R2	R3	ton/m	L=835
S000110M	90	0,5	1,0	1,5	100	kg 20,00



IH 30°

MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S337300M	8	12	1	1	14,5	18,0	60	30	kg 8,30

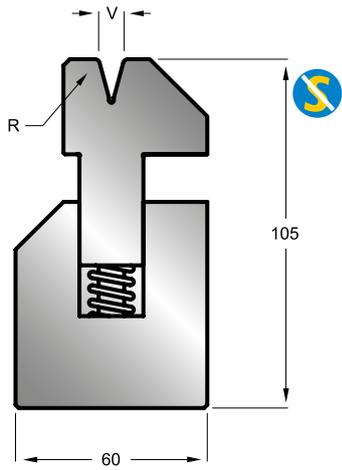
HRTH 30°

MOD.	V1	V2	R1	R2	C1	C2	W	ton/m	L=835
S337560M	6	10	1	1	9,0	15	50	30	kg 15
S337580M	8	12	1	1	14,5	18	58,5	30	kg 17,20

Supporti - Die Holder - Halter
Mod 4006/4007 - 931/932/933

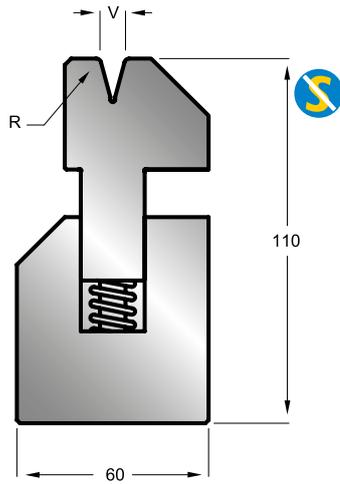
Supporti - Die Holder - Halter Mod 4006/4007 - 931/932/933
Guida - Die Rail - Matricen Halter - Mod. 300000

HEMMING DIES



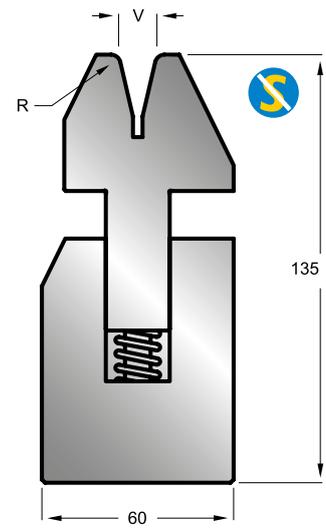
ton/m 60 L=835 - kg 30,70

HR	35°		
MOD.	V	R	
S105100S	6	1	
S105400S	8	2	



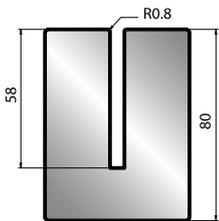
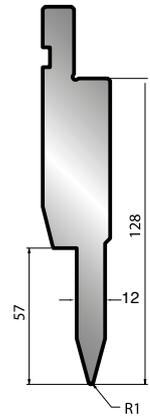
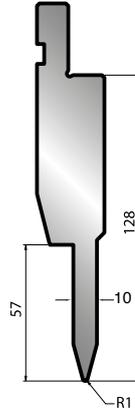
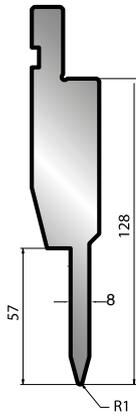
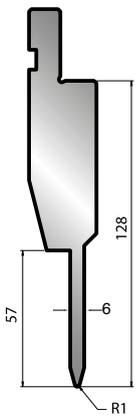
ton/m 80 L=835 - kg 30,00

HR	30°		
MOD.	V	R	
S105000S	8	1,5	



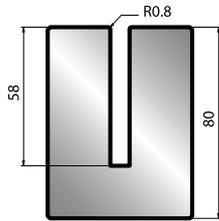
ton/m 100 L=835 - kg 41,70

HR	26°		
MOD.	V	R	
S104800S	10	1,5	
S104900S	12	3,0	



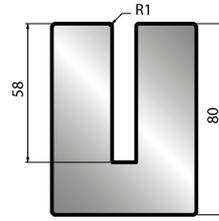
L=835 - kg 46

HR	30°	
MOD.	V	
SPV9061	6	



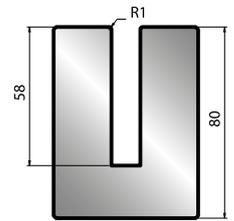
L=835 - kg 46

HR	30°	
MOD.	V	
SPV9081	8	



L=835 - kg 46

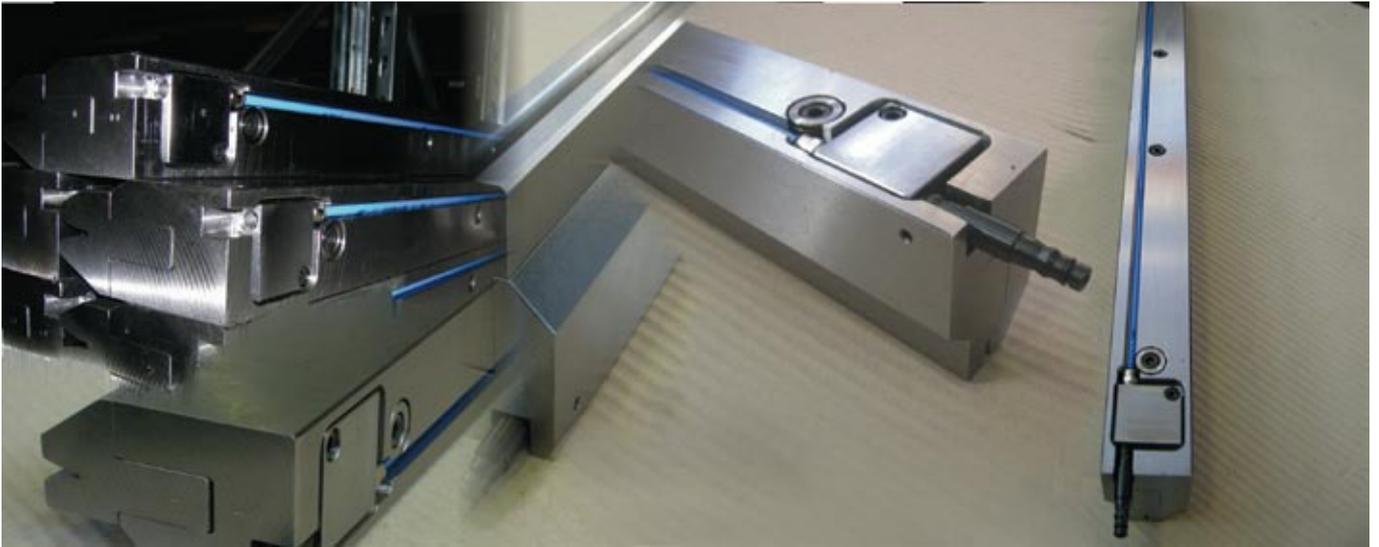
HR	30°	
MOD.	V	
SPV9101	10	



L=835 - kg 46

HR	30°	
MOD.	V	
SPV9121	12	

HEMMING TOOLS PNEUMATIC



T0152500008



	V	A	R	H aperto/open	Max T/M
S0993	10	26°	1,5	135	100
S0996	6	35°	1	105	80
S0975	12	26°	3	135	100
S1164	8	30°	1,5	110	80



Tabella di piegatura - Bending scheme

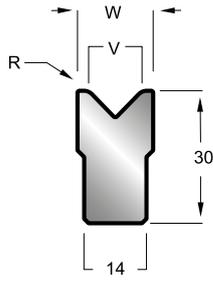
Acc. R.45 Kg/mm²

S mm	A mm	Ton /M	2xS	Ton /M
0,6	3	9	1,2	23
0,8	3	12	1,6	32
1	3,5	15	2	40
1,25	3,5	17	2,5	50
1,5	4,6	22	3	63
2	5,5	30	4	80
2,5	6,5	55	5	90
3	8	70	6	100

Acc. R.70 Kg/mm²

S mm	A mm	Ton /M	2xS	Ton /M
0,6	3	15	1,2	35
0,8	3	20	1,6	50
1	3,5	25	2	60
1,25	3,5	26	2,5	80
1,5	4,6	38	3	95
2	5,5	50	4	130

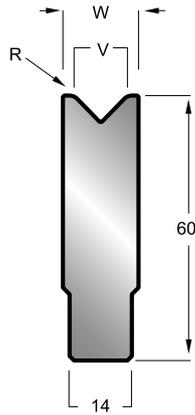
DIES 1V



ton/m 95

HR TH		90°			
MOD.	V	R	W	L=835	
S211090	6	1,5	14	kg 2,60	
S211190	8	1,5	14	kg 2,60	
S211290	10	2,0	14	kg 2,60	
S211390	12	2,5	18	kg 3,10	

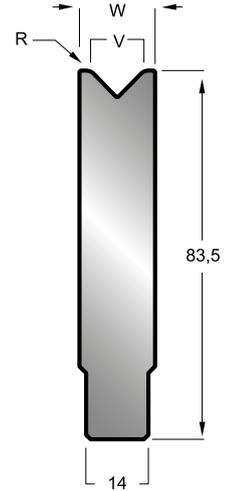
Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150 - 3030



ton/m 95

HR TH		90°			
MOD.	V	R	W	L=835	
S1V0690	6	1,5	14	kg 5,40	
S1V0890	8	1,5	14	kg 5,30	
S1V1090	10	2,0	15	kg 5,60	
S1V1290	12	2,5	17	kg 6,10	

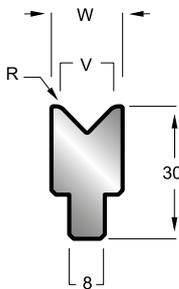
Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150 - 3030



ton/m 95

HR TH		90°			
MOD.	V	R	W	L=835	
S210090	6	1,5	14	kg 7,60	
S210190	8	1,5	14	kg 7,60	
S210290	10	2,0	14	kg 7,60	
S210390	12	2,5	17	kg 8,80	

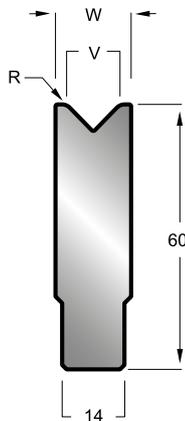
Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150 - 3030



ton/m 95

HR TH		90°			
MOD.	V	R	W	L=835	
S042090	6	1,5	14	kg 2,20	
S042190	8	1,5	14	kg 2,20	
S042290	10	2,0	16	kg 2,20	
S042390	12	2,5	16	kg 2,20	

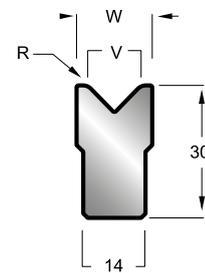
Supporti - Die Holder - Halter
Mod 90 - 91 - 92



ton/m 95

HR TH		88°			
MOD.	V	R	W	L=835	
S1V0688	6	1,5	14	kg 5,40	
S1V0888	8	1,5	14	kg 5,30	
S1V1088	10	2,0	15	kg 5,60	
S1V1288	12	2,5	17	kg 6,10	
S1V1488	14	2,5	18	kg 6,30	
S1V1688	16	2,5	21	kg 7	
S1V1888	18	3,0	23	kg 7,40	
S1V2088	20	3,0	25	kg 7,80	
S1V2588	25	3,0	30	kg 8,70	

Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150 - 3030



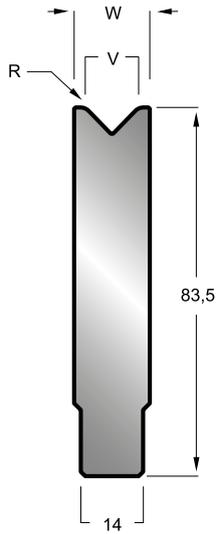
ton/m 95

HR TH		88°			
MOD.	V	R	W	L=835	
S211488	10	2,0	14	kg 3,10	
S211588	12	2,5	17	kg 3,10	
S211688	14	2,5	18	kg 3,10	

Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150 - 3030

EUROPEAN STYLE

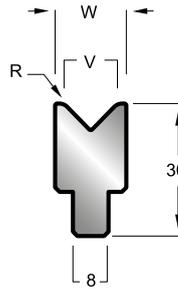
DIES 1V



ton/m 95

HR TH		88°			L=835
MOD.	V	R	W		
S210488	12	2,5	17	kg 8,80	
S210588	14	2,5	18	kg 9,10	

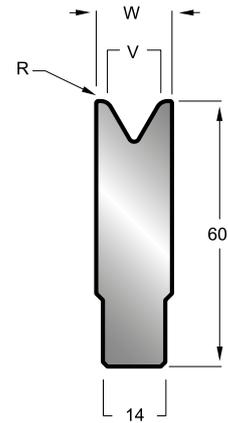
Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150



ton/m 95

HR TH		88°			L=835
MOD.	V	R	W		
S042088	6	1,5	14	kg 2,20	
S042188	8	1,5	14	kg 2,20	
S042288	10	2,0	16	kg 2,30	
S042388	12	2,5	16	kg 2,30	
S042488	14	2,5	18	kg 2,50	

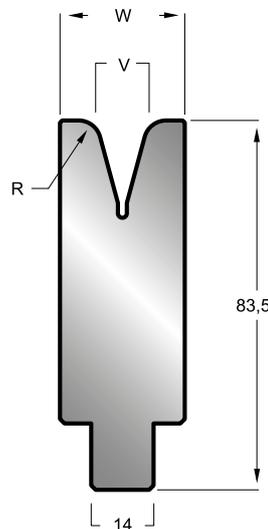
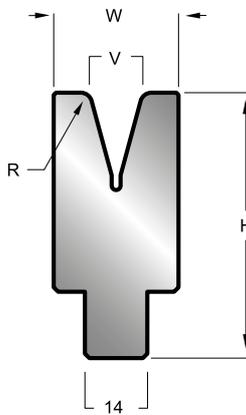
Supporti - Die Holder - Halter
Mod 90 - 91 - 92



ton/m 60

HR TH		60°			L=835
MOD.	V	R	W		
S1V0660	6	1,5	14	kg 5,40	
S1V0860	8	1,5	14	kg 5,30	
S1V1060	10	2,0	15	kg 5,60	
S1V1260	12	2,5	17	kg 6,10	
S1V1460	14	2,5	18	kg 6,30	
S1V1660	16	2,5	24	kg 7	
S1V2060	20	3,0	30	kg 7,80	
S1V2560	25	3,0	33	kg 8,70	

Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150 - 3030



HR TH		30°			ton/m	L=835
MOD.	V	R	W	H		
S1V0630	6	1,0	16	60	35	kg 5,40
S1V0830	8	1,0	19	60	35	kg 5,30
S1V1030	10	2,0	24	60	60	kg 5,60
S1V1230	12	2,5	28	60	60	kg 6,10
S1V1630	16	3	33	60	60	kg 9,50
S1V2030	20	4	40	80	60	kg 15,80
S1V2530	25	4	42	80	60	kg 12,70

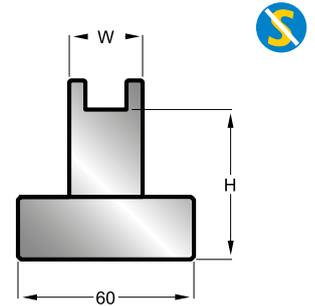
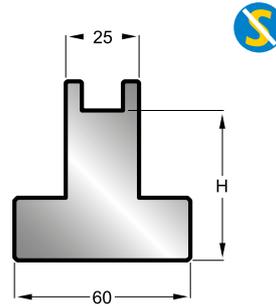
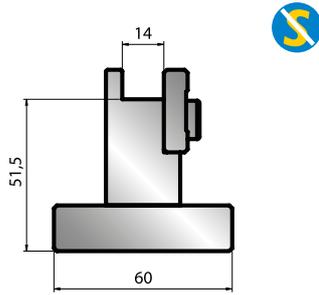
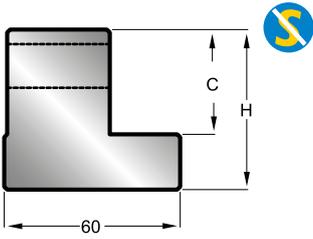
Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150

HR TH		30°			ton/m	L=835
MOD.	V	R	W			
S220030	6	3,0	16	35	kg 8,30	
S220130	8	3,0	19	35	kg 9,50	
S220230	10	3,0	24	50	kg 11,50	
S220330	12	5,0	28	50	kg 13	
S220430	14	5,0	32	50	kg 14,40	
S220530	16	5,0	36	50	kg 15,90	

Supporti - Die Holder - Halter
Mod 80 Reg./81 Reg. - 82/83 - 8150

EUROPEAN STYLE

DIES HOLDERS



ton/m 100 L=830/412mm

ton/m 100 L=840/420mm

ton/m 100

ton/m 100 L=1050/1260

IH

MOD.	H	C	L=830
S450434	34	19	kg 9,10
S450455	55	34	kg 14,50
S450439	39	20	kg 11,10
S450445	45	26	kg 12,41
S459475	75	56	kg 19,50

HR

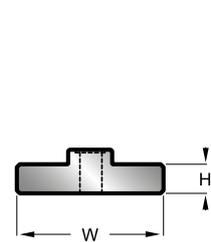
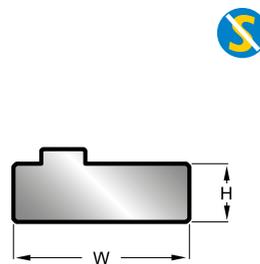
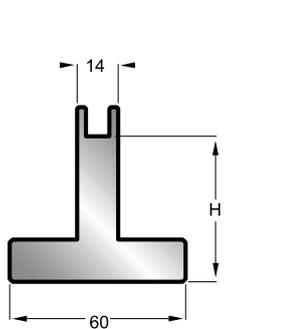
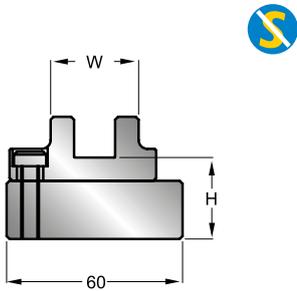
MOD.	H	W	L=840
S4615	51,5	25	kg 13,20

IH

MOD.	H	L	L=835
S80 FIX	51,5	1050	kg 17,10
S81 FIX	51,5	1260	kg 8,50
S82 FIX	21	1050	kg 20,50
S83 FIX	21	1260	kg 10,25

IH

MOD.	H	W	L	L=1050 1260
S80 REG	51,5	25	1050	kg 8,50
S81 REG	51,5	25	1260	kg 17,10



ton/m 100
L=525mm - kg 10,25

kg/m 100
L=835/1050mm

ton/m 100
L=835/415mm

ton/m 100
L=835/415mm

IH

MOD.	H	W
S3030	28	30

IH

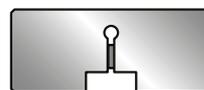
MOD.	H	L=835
S090	30	kg 5,60
S091	50	kg 7,60
S092	75	kg 8,20

IH

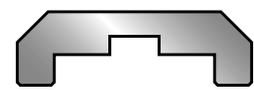
MOD.	H	W	L=835
S400	20	60	kg 8,30

TH

MOD.	H	W	L=835
S300	10	50	kg 3,71



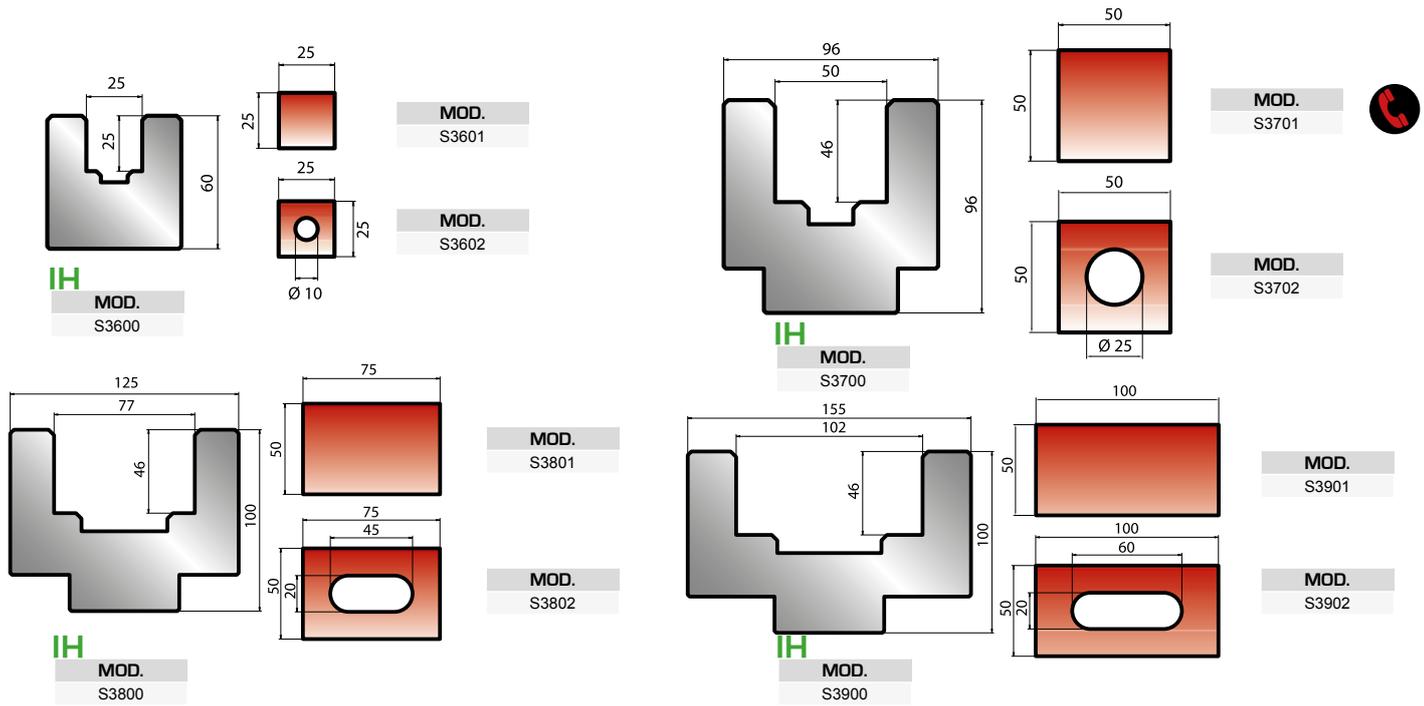
morsetto
rail clamping S500



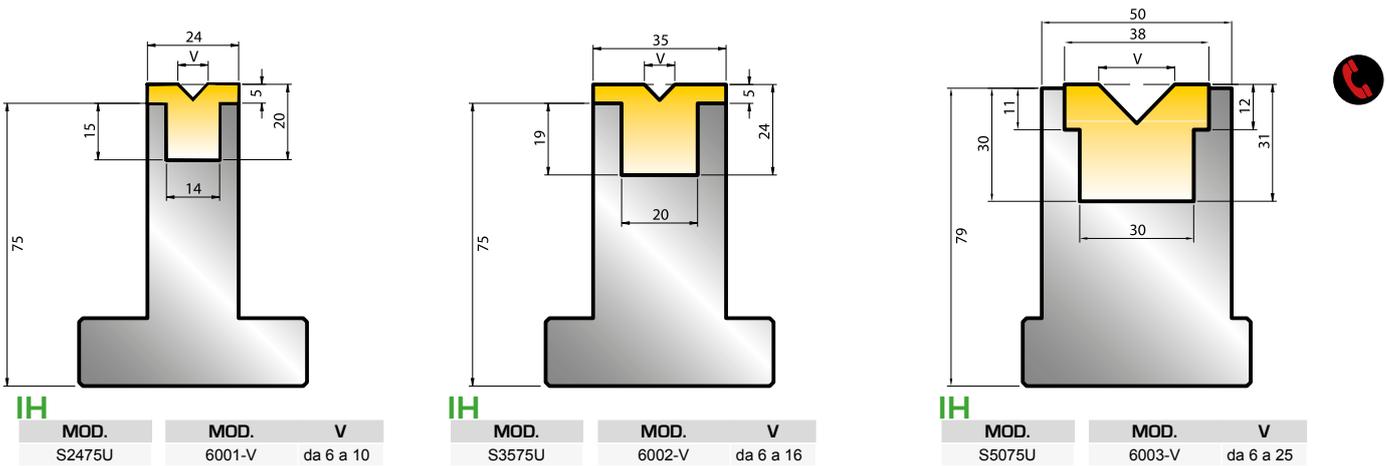
morsetto
rail clamping S600

EUROPEAN STYLE

INSERT AND POLYURETHANE HOLDERS



INSERT AND NYLON HOLDERS



MOD.	MOD.	V
S2475U	6001-V	da 6 a 10

MOD.	MOD.	V
S3575U	6002-V	da 6 a 16

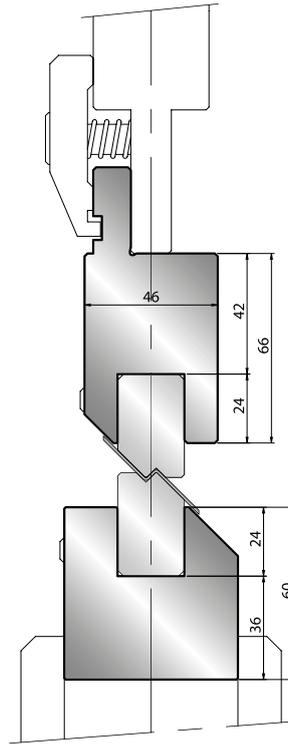
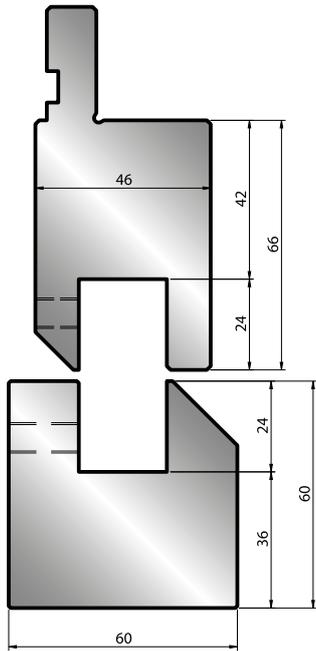
MOD.	MOD.	V
S5075U	6003-V	da 6 a 25

V	88°	60°	45°	30°
6	S0688020	S0660020	S0645020	S0630020
8	S0888020	S0860020	S0845020	S0830020
10	S1088020	S1060020	S1045020	S1030020

V	88°	60°	45°	30°
6	S0688031	S0660031	S0645031	S0630031
8	S0888031	S0860031	S0845031	S0830031
10	S1088031	S1060031	S1045031	S1030031
12	S1288031	S1260031	S1245031	S1230031
16	S1688031	S1660031	S1645031	S1630031
20	S2088031	S2060031	S2045031	
25	S2588031			

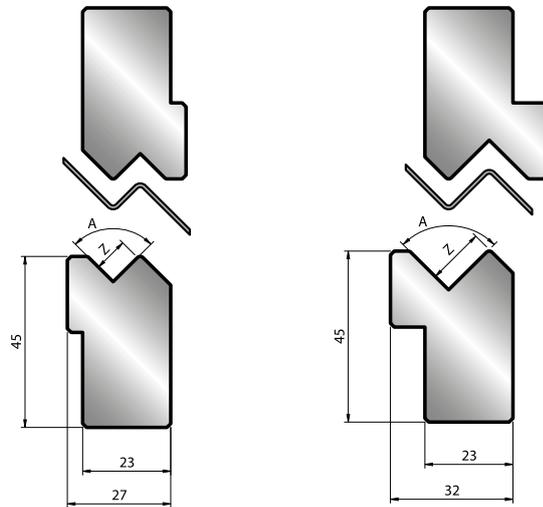
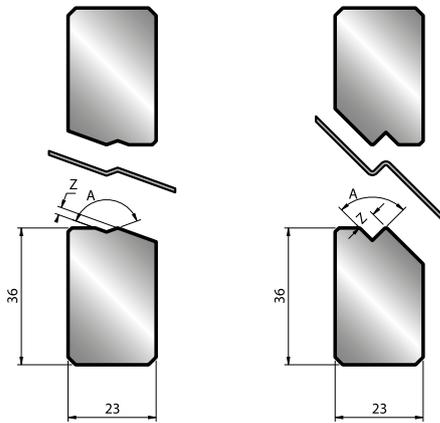
V	88°	60°	45°	30°
6	S0688024	S0660024	S0645024	S0630024
8	S0888024	S0860024	S0845024	S0830024
10	S1088024	S1060024	S1045024	S1030024
12	S1288024	S1260024	S1245024	
16	S1688024	S1660024		

Z BENDS 90°



L=835 - kg 37,50

IH
MOD.
S0680



IH

MOD.	Z (mm)	A	L=835
S1385	1,0	160°	kg 11
S1386	1,5	160°	kg 11
S1387	2,0	150°	kg 11
S1388	2,5	140°	kg 11
S1400	1,0	90°	kg 10
S1401	1,5	90°	kg 10
S1402	2,0	90°	kg 10
S1403	2,5	90°	kg 10
S1389	3,0	90°	kg 10
S1390	3,5	90°	kg 10
S1391	4,0	90°	kg 10
S1392	4,5	90°	kg 10
S1393	5,0	90°	kg 10

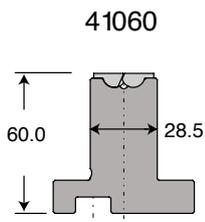
IH

MOD.	Z (mm)	A	L=835
S1394	5,5	90°	kg 10
S1395	6,0	90°	kg 10
S1396	6,5	90°	kg 10
S1397	7,0	90°	kg 10
S1398	7,5	90°	kg 10
S1399	8,0	90°	kg 10
S1404	9,0	90°	kg 13,50
S1405	10,0	90°	kg 13,50
S1406	11,0	90°	kg 13,50
S1407	12,0	90°	kg 13,50
S1408	13,0	90°	kg 13,50
S1409	14,0	90°	kg 13,50
S1410	15,0	90°	kg 13,50

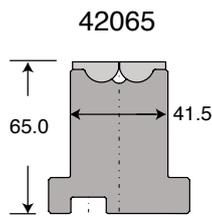


MODELLO EUROPEO

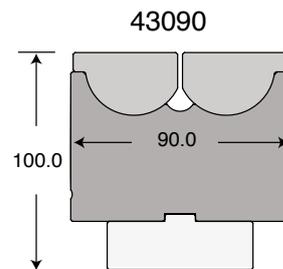
MODELLO 1



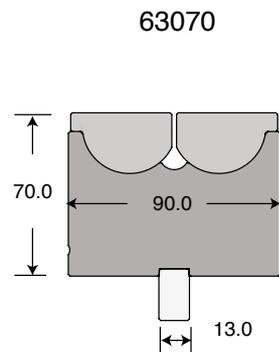
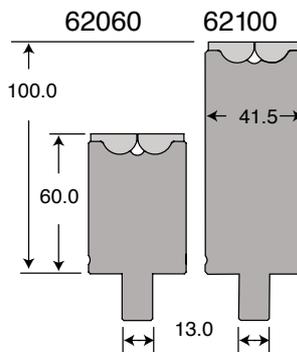
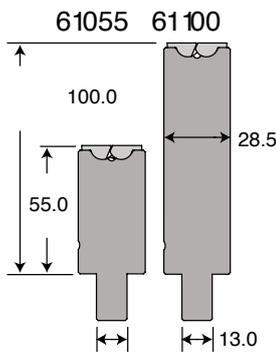
MODELLO 2



MODELLO 3



MODELLO WT



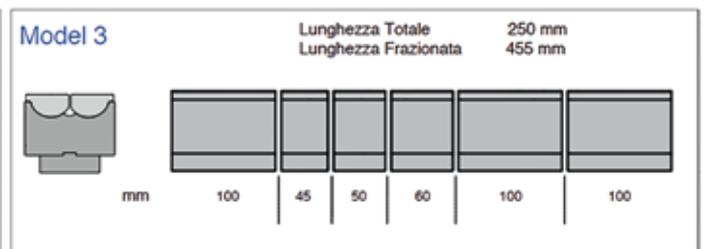
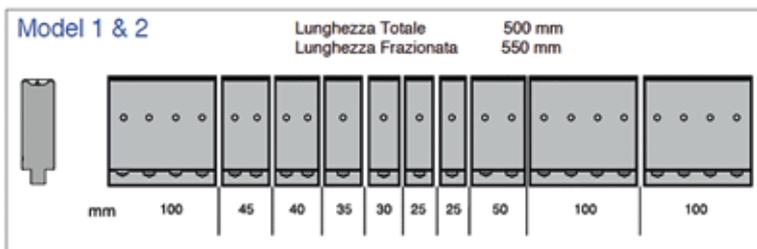
EUROPEAN STYLE

DIES

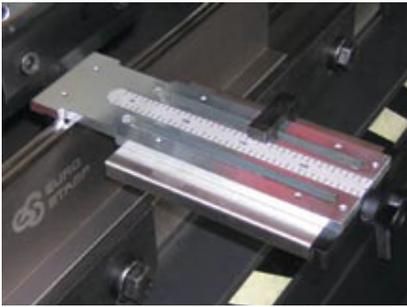
	Material Thickness	Min. Outside Flange	Ton/ FT	IR to Archieve Min Angle	Min. Angle	Effective V@Min. Angle	Max OR Radius @Min. Angle	Effective V@90°	Max OR Radius@ 90°	Shoulder Radius All Angles	Max Tons/ FT	Max Tons/ M	Max kN/ M
MODEL 1 MAX. 0.059" [1.5 mm]	0.45mm 0.018"	3.0mm 0.118"	1.8	1.4	34°	6.5mm 2.56"	3.17mm 0.125"	7.2mm 0.283"	4.45mm 0.175"	1.0mm 0.039"	34	112	1100
	0.50mm 0.020"		1.8	1.3									
	0.60mm 0.024"		2.0	1.2									
	0.80mm 0.030"		2.5	1.1									
	0.90mm 0.036"		3.3	1									
	1.0mm 0.040"	3.9mm 0.153"	4.0	0.8									
	1.2mm 0.048"		5.8										
	1.5mm 0.059"		9										
MODEL 2 MAX. 0.135" [3.43 mm]	1.9mm 0.074"	8.5mm 0.335"	7	3	42°	13.3mm 0.524"	5.5mm 0.216"	13.9mm 547"	9.0mm 0.354"	1.3mm 0.051"	50	168	1650
	2.9mm 0.105"	8.8mm 0.347"	13	2.8									
	3.0mm 0.118"	9.3mm 0.366"	15	2.5									
	3.2mm 0.126"		20	2.3									
	3.4mm 0.135"		22	2.1	55°	13.48mm 0.531"	7.9mm 0.276"						
MODEL 3 MAX. 0.250" [6.35 mm]	4.0mm 0.157"	22.5mm 0.886"	9	2	65°	31.4mm 1.236"	11.5mm 0.453"	33mm 1.299"	20.2mm 0.797"	6mm 0.236"	60*	204	2000
	4.75mm 0.187"		26	2.4									
	6.35mm 0.250"		28	3.2									

Consume 60% of the insert when bending to prevent insert damage.

*Make sure the tonnage produced is safe with the application and machine.
VERY high tonnage could damage the lower beam.



ACCESSORIES



JA05535v0279

squadre di riferimento / reference squares



JA05535v0278

squadre di riferimento orientabile / reference squares adjustable



JAV099000000

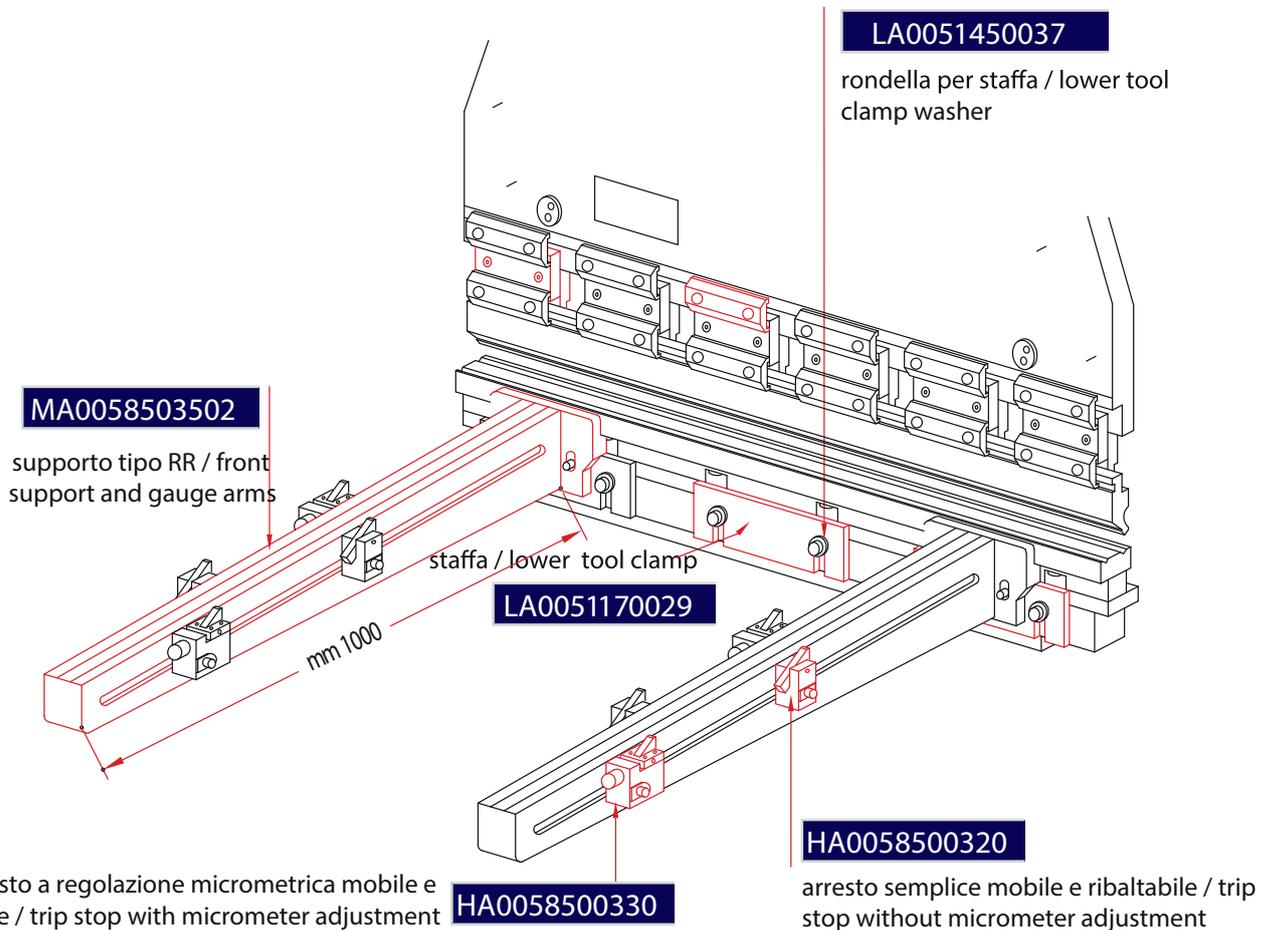
tenditori / tighteners

JAV100000000

pellicola di poliuretano antigraffio
152x0,4mm di spessore/
anti scratch film 152x0,4mm thickness 30mt

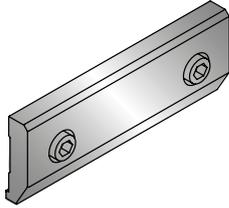
JAV100000001

pellicola di poliuretano antigraffio
152x0,8mm di spessore/
anti scratch film 152x0,8mm thickness 30mt



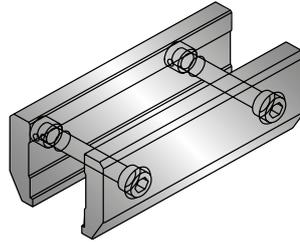
EUROPEAN STYLE

ACCESSORIES



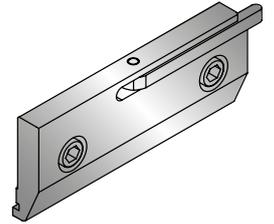
kg 0,86

MOD.	L
JAV076400150	150



kg 1,80

MOD.	L
JAV05575U0731	150



kg 0,88

MOD.	L
LA05573V0726	150

EXPRESS CLAMP



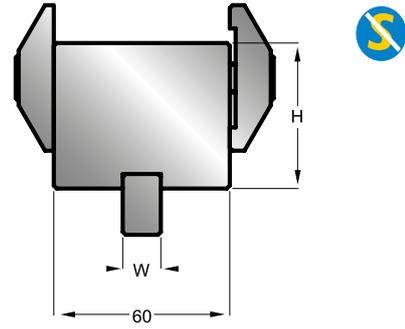
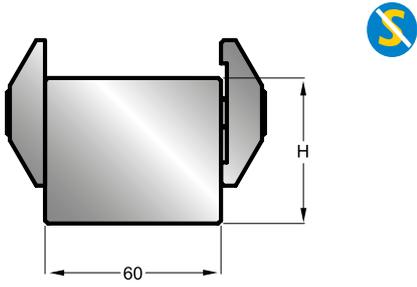
MOD.	H
8171-2	100
817100	100

MOD.	H
8181-2	120
818100	120

MOD.	H
8191-2	150
819100	150

EUROPEAN STYLE

CLAMP INTERMEDIATES



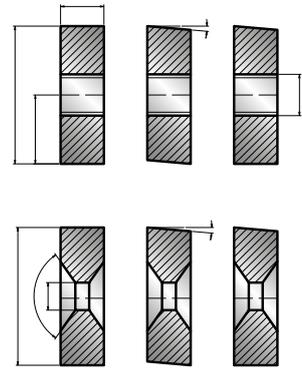
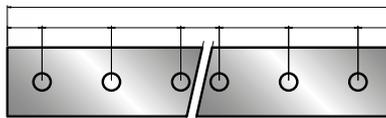
IH

MOD.	H	L=835
JA05575V0722	55	kg 30,70

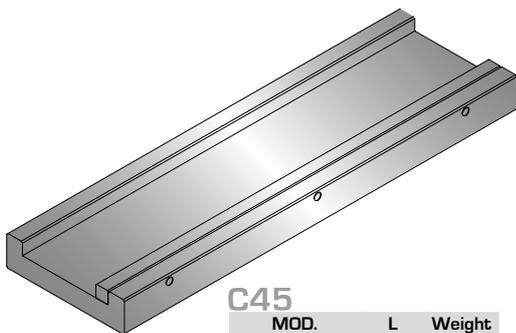
IH

MOD.	H	W	L=835
S3045	50	12,7	kg 30,20

SHEAR BLADES

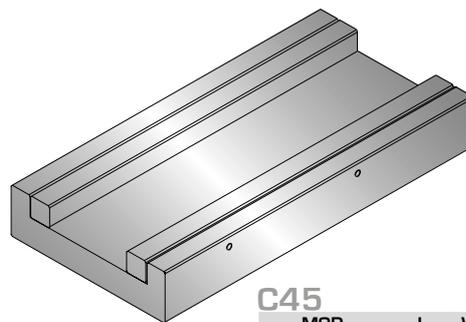


DIE RAIL



C45

MOD.	L	Weight
S60 1	2100	kg 27
S60 2	2600	kg 34
S60 3	3100	kg 40
S60 4	4100	kg 53

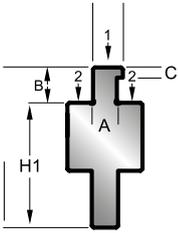


C45

MOD.	L	Weight
S60-90 1	520	kg 13,50
S60-90 2	1050	kg 27,20

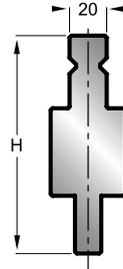
EUROPEAN STYLE

PUNCH ADAPTOR



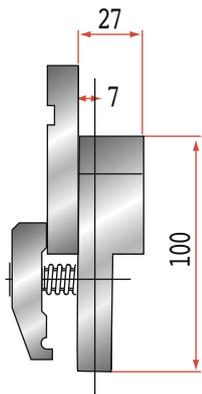
IH

MOD.	L
S20067S	150

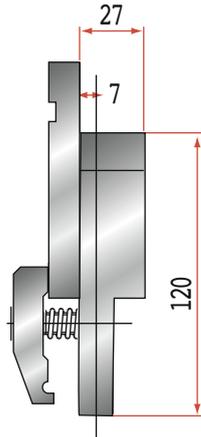


IH

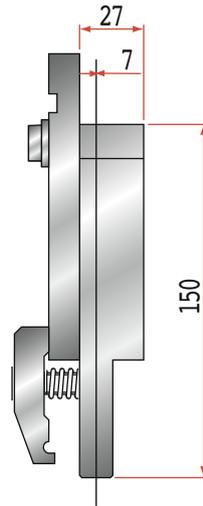
MOD.	H	L	Weight
SU2000	117	150	kg 3



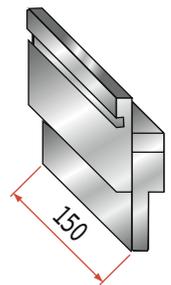
MOD.	L
JAV076900150	150



MOD.	L
JA05575V0704	150

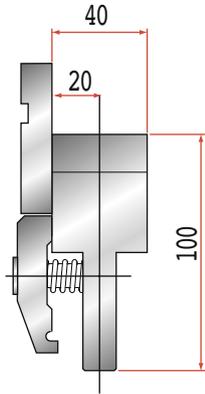


MOD.	L
JA05575V0385	150

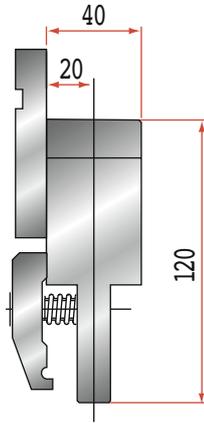


EUROPEAN STYLE

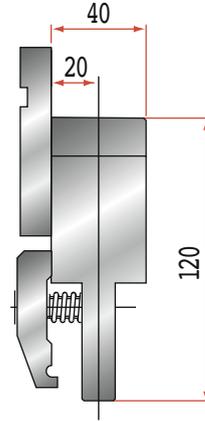
PUNCH ADAPTOR



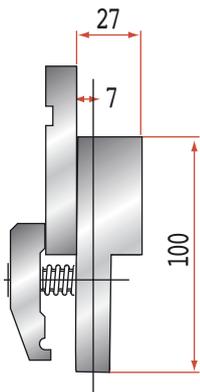
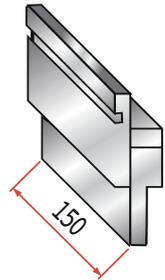
MOD.	L
JA05575V0709	150



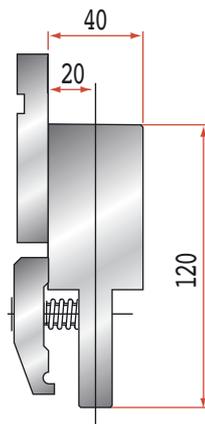
MOD.	L
JA05575V0220	150



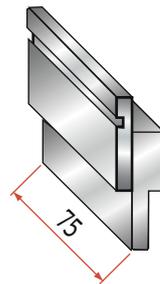
MOD.	L
JA05575V0388	150



MOD.	L
JAV081900075	75



MOD.	L
JAV102800075	75



Armadi per utensili tipo con 4/5 cassetti

4-5 drawer tooling cabinet

Dotazione standard cassetto

- n. 2 ripiani fissi
- n. 1 ripiano continuo per utensili frazionati
- n. 4 ripiani a mensole per utensili interi (835)

Opzioni

- n. 3 ripiani, continui o mensole, per ogni cassetto scorrevole



Drawer standard feature

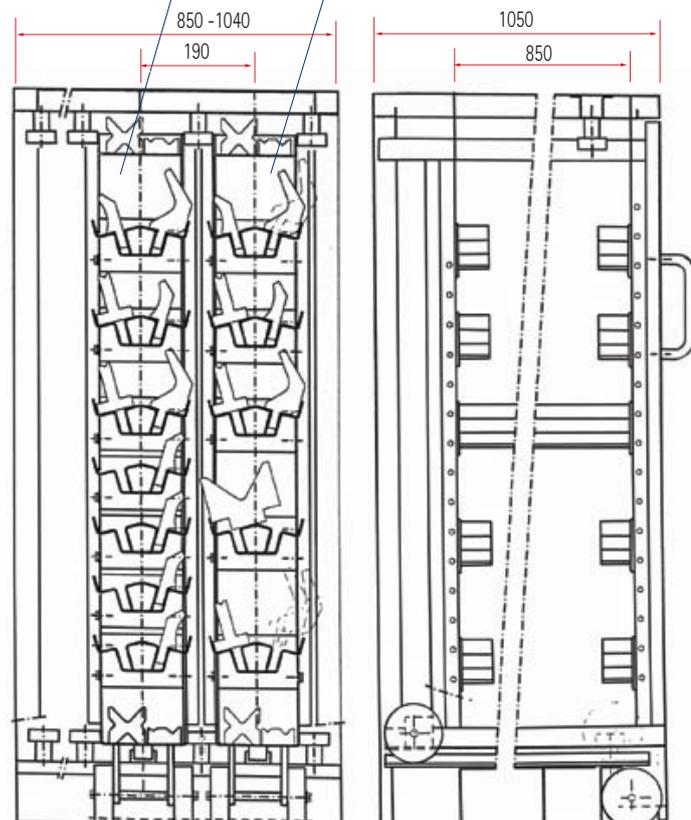
- n. 2 fixed shelves
- n. 1 full-length shelf for sectioned tools
- n. 4 shelf sections for full-length tools (835)

Options

- n. 3 full-length shelves or shelf partitions for each sliding drawer

Esempio con aggiunta piani
Example with added shelves

Configurazione standard
Standard configuration



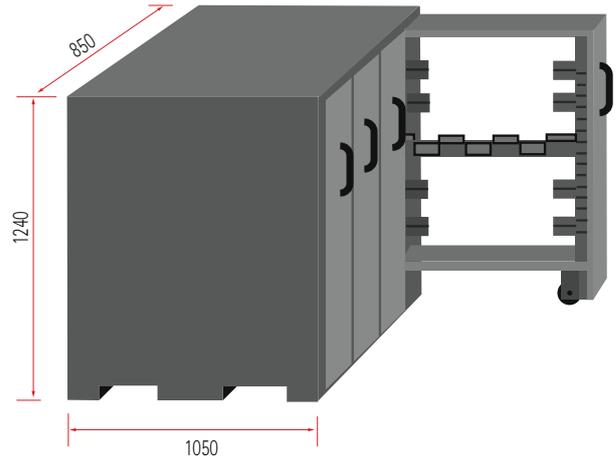
- **Cassetti verticali scorrevoli**
- **Vertical sliding drawers**
- **Supporti utensili posizionabili in altezza secondo necessità**
- **Height adjustable drawers for specific needs**
- **Supporti per utensili interi e frazionati**
- **Supports for full-length or sectioned tools**
- **Estrema praticità d'uso**
- **Extremely easy to use**

EUROPEAN STYLE

TOOLING CABINETS

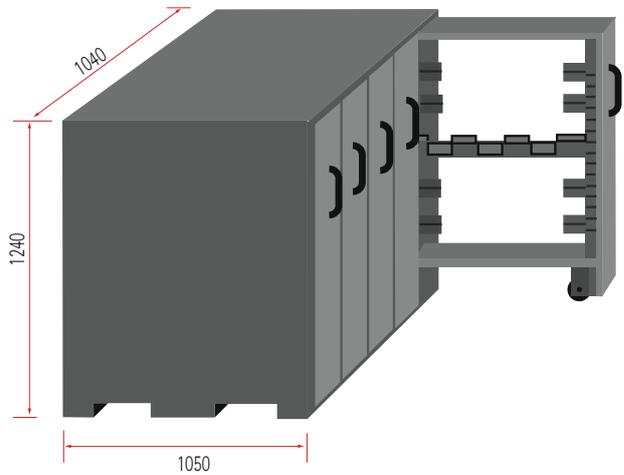
Modello quattro cassetti
per minimo 56 utensili
**4 drawer cabinet for at least
56 tools**

54004

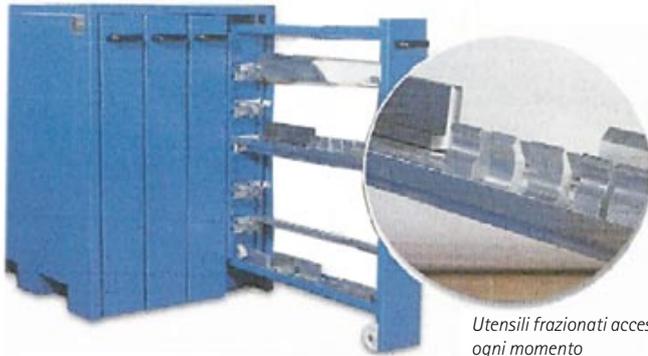


Modello cinque cassetti
per minimo 70 utensili
**5 drawer cabinet for at least
70 tools**

54005



*Cassetti verticali
scorrevoli: estrazione
sicura e pratica degli
utensili
Sliding upright drawers:
safe and practical tools
manipulation*



*Utensili frazionati accessibili in
ogni momento
Accessibility of sectioned tools in
any moment*



*Innovativo sistema
ad incastro: supporti
riposizionabili con un
semplice gesto.
Nessuna vite da
allentare*

*Innovating joint system:
the supports can be
repositioned with
a simple action. No
screws to be loosen*



*Supporti configurabili per ogni
tipologia di utensili in commercio
Adaptability of the supports for all
type of tools*



NOTES

NOTES
