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Contents/Spis Treści

| | | |
|----------|--|----------------|
| | About the Company/O Firmie | Page/Strona 07 |
| A | Punches/Stemple | Page/Strona 09 |
| B | Punch Holders/Adaptory Stempli | Page/Strona 14 |
| C | Radius Punches/Stemple Promieniowe | Page/Strona 14 |
| D | Inserts for Radius Punches/Wkładki do Stempli Promieniowych | Page/Strona 14 |
| E | Punch Mounting Edge/Rodzaje Mocowania Stempli | Page/Strona 15 |
| F | Flattening Tools/Zestaw do Zagniatania | Page/Strona 16 |
| G | "Z" Set Tools/Zestaw do "Z" | Page/Strona 16 |
| H | Multiple Vee Dies/Matryce Wielopryzmowe | Page/Strona 17 |
| I | Single Wide Vee Dies/Matryce Jednopryzmowe Szerokie | Page/Strona 18 |
| J | Double Dies - Bolt Fastened/Matryce Dwupryzmowe - Mocowane Śrubami | Page/Strona 20 |
| K | Double Dies with Extract/Matryce Dwupryzmowe z Wybraniem | Page/Strona 21 |
| L | Double Dies - Quick Fasten/Matryce Dwupryzmowe - Szybkiego Mocowania | Page/Strona 22 |
| M | T-shaped Dies/Matryce Teowe | Page/Strona 23 |
| N | Single Narrow Dies/Matryce Jednopryzmowe Wąskie | Page/Strona 24 |
| O | Trumph Wila Dies Type/Matryce Typu Wila Trumph | Page/Strona 24 |
| P | Spring Dies/Matryce Sprężynowe | Page/Strona 26 |
| R | Die Holders/Mocowanie Matryc - Podkłady | Page/Strona 27 |
| S | Secionalized Tool/Schemat Segmentacji Narzędzi | Page/Strona 28 |



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TECHMET
Przedsiębiorstwo Wielobranżowe
S.R.E. Szotko spółka jawna

Entered into Enterprise Register In National Court Register, Economic Department XII under KRS No. 0000238840.

The Company was originally established in 1988 as P.W. TECHMET Stanisław Szotko and since 2000 has changed its name for TECHMET.

TECHMET is one of leading Polish manufacturers of specialized tools for press brakes. Apart from tools presented in our catalogue, we manufacture individually tailored tools, also in accordance with our customers' specifications. The majority of our products is sold on the West European markets. All technological operations i.e. mechanical and thermal processing undergo detailed control procedures. Therefore, the tools manufactured by our Company are of the best quality. The Company owns many specialized machines, such as surface grinders, milling machines, hydraulic presses, lathes, planing machines, annealing ovens and induction hardening equipment. The rotation of our employees during the first years of our business, allowed us to gather stable and unchanged workforce, which ensures the highest quality and precision of our products.



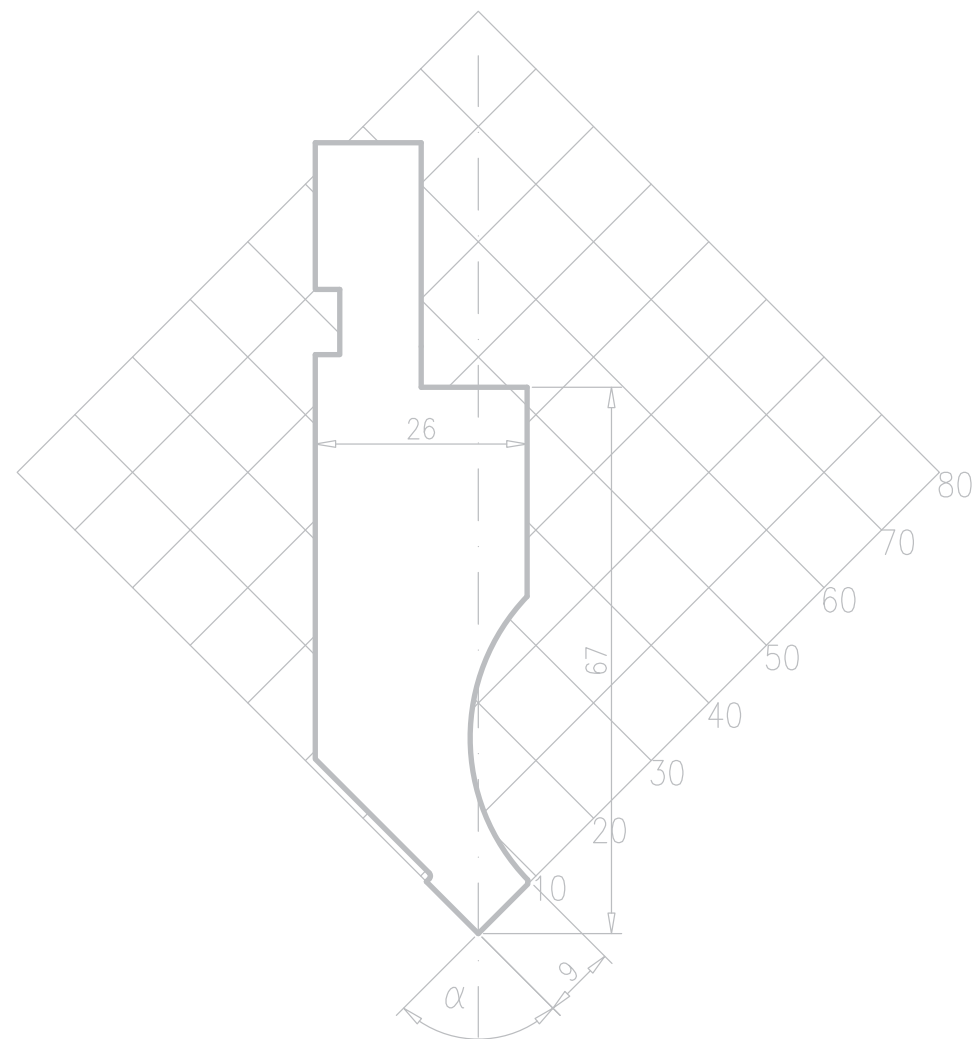
O Firmie

TECHMET
Przedsiębiorstwo Wielobranżowe
S.R.E. Szotko spółka jawna

Wpisana przez Sąd Rejonowy w Białymstoku XII Wydział Gospodarczy Krajowego Rejestru Sądowego do Rejestru Przedsiębiorców pod numerem KRS: 0000238840.

TECHMET jest spółką istniejącą od 2000 r. Wcześniej od 1988 r. przedsiębiorstwo działało jako P.W. TECHMET Stanisław Szotko.

TECHMET jest jednym z wiodących producentów specjalistycznych narzędzi do pras krawędziowych w Polsce. Oprócz narzędzi ujętych w katalogu, wykonujemy narzędzia według własnego projektu i specyfikacji klienta. Większość produktów trafia na rynek zachodni. Wszystkie operacje technologiczne tj. obróbka mechaniczna i termiczna poddawane są szczegółowej kontroli co powoduje, że narzędzia produkowane przez naszą firmę charakteryzują się najwyższą jakością. Firma dysponuje wieloma maszynami, wśród których możemy wymienić m.in. szlifierki do płaszczyzn, frezarki, prasy hydrauliczne, tokarki, strugarkę, piece hartownicze oraz urządzenia do hartowania indukcyjnego. Firma dzięki rotacji pracowników w pierwszych latach działalności, posiada obecnie niezmienny od lat skład personalny, co niewątpliwie wpływa na jakość i precyzję wykonywanych narzędzi.

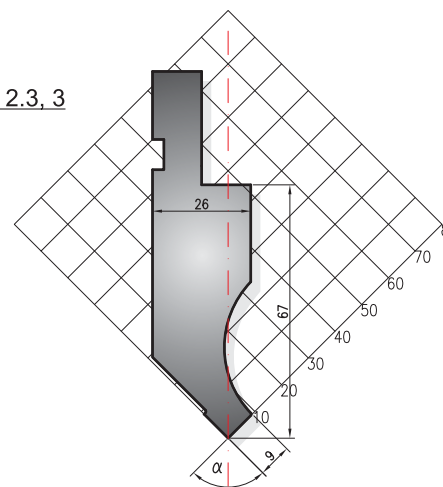


A

Punches/Stemple

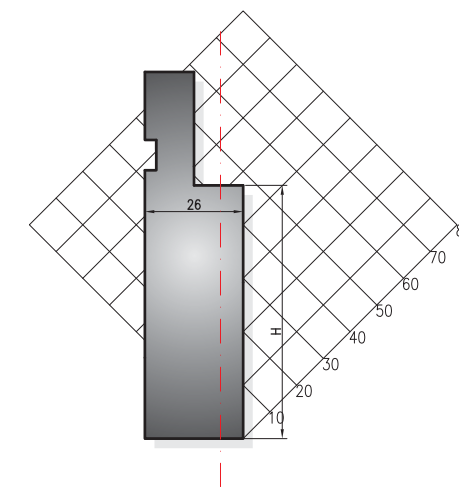
A 6010

100 T/m
 $\alpha=75^\circ, R=0.8$
 $\alpha=85^\circ, R=0.8, 3$
 $\alpha=88^\circ, R=0.2, 0.8, 1.5, 2.3, 3$
 $\alpha=90^\circ, R=0.2, 0.8$



A 6010Z

100 T/m
 $H=67$
 $H=105$

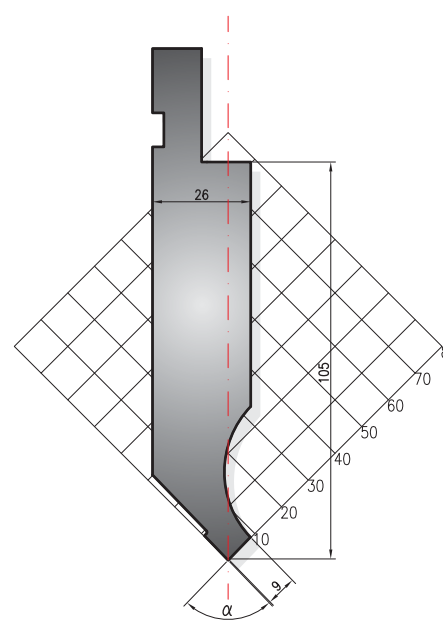


A 6010/F

100 T/m
 $\alpha=88^\circ, F=0.8, 3$
 $\alpha=90^\circ, F=0.8$

A 6010/H105

100 T/m
 $\alpha=75^\circ, 88^\circ, 90^\circ$
 $R=0.8$

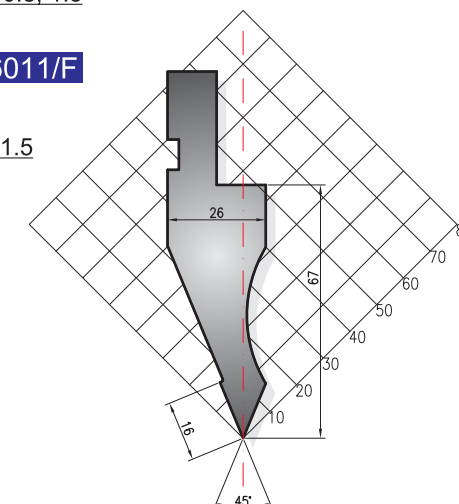


A 6011

70 T/m
 $\alpha=45^\circ, R=0.4, 0.8, 1.5$

A 6011/F

70 T/m
 $\alpha=45^\circ, F=0.8, 1.5$

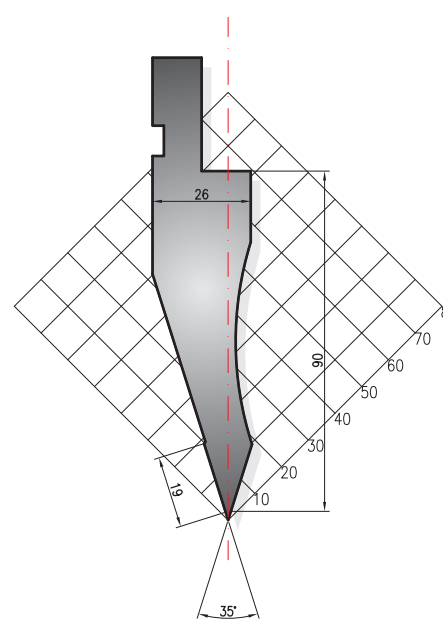


A 6012

50 T/m
 $\alpha=35^\circ, R=1$

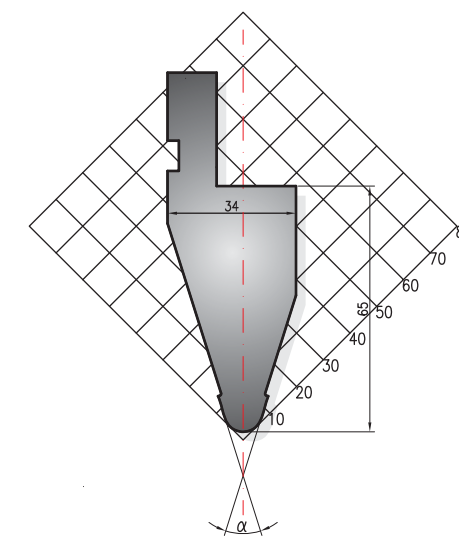
A 6012/F

50 T/m
 $\alpha=35^\circ, F=1$



A 6013

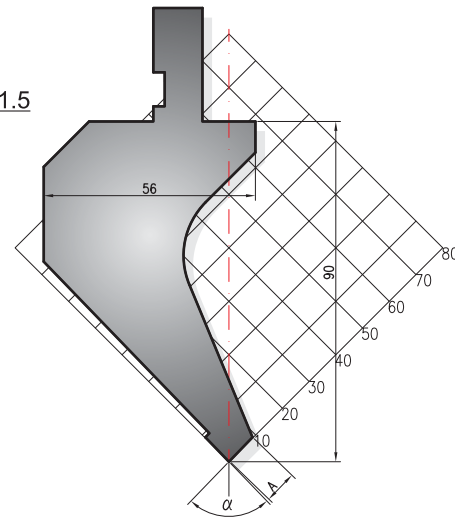
100 T/m
 $\alpha=35^\circ, R=5$
 $\alpha=60^\circ, R=6$
 $\alpha=80^\circ, R=6$



A Punches/Stemple

A 6014

50 T/m
 $\alpha=75^\circ, A=9, R=0.8$
 $\alpha=88^\circ, A=6, R=0.2, 0.8$
 $\alpha=88^\circ, A=9, R=0.2, 0.8, 1.5$
 $\alpha=90^\circ, A=9, R=0.8$

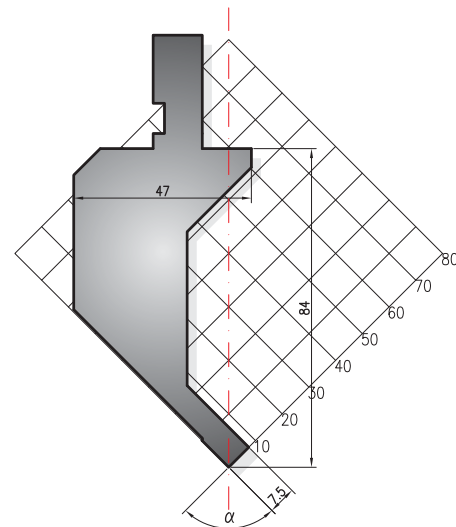


A 6014/F

50 T/m
 $\alpha=88^\circ, A=6, F=0.8$
 $\alpha=90^\circ, A=9, F=0.8$

A 6016

15 T/m
 $\alpha=88^\circ, R=0.6$
 $\alpha=90^\circ, R=0.6$



A 6016/F

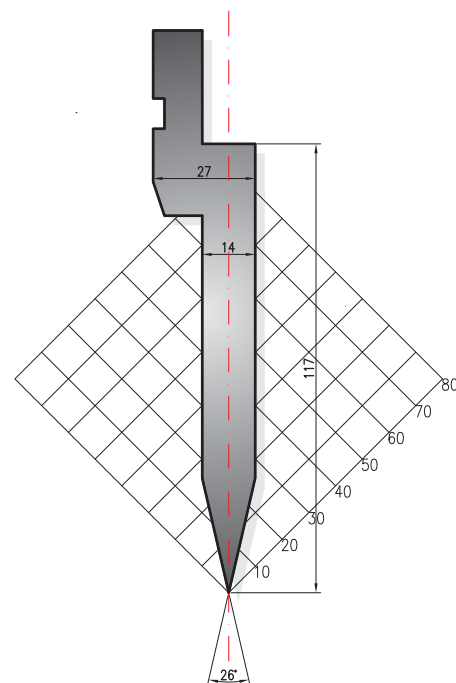
15 T/m
 $\alpha=88^\circ, F=0.6$
 $\alpha=90^\circ, F=0.6$

A 6017/H117

100 T/m
 $\alpha=26^\circ, R=0.8$

A 6017/H117/F

100 T/m
 $\alpha=26^\circ, F=0.8$

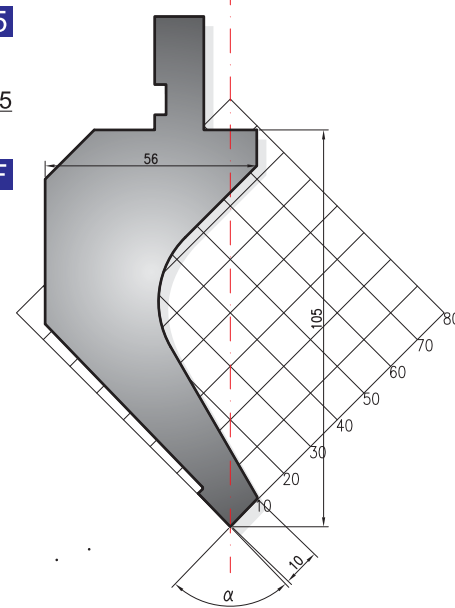


A 6015

50 T/m
 $\alpha=88^\circ, R=0.2, 0.8, 1.5$

A 6015/F

50 T/m
 $\alpha=88^\circ, F=1, 3$
 $\alpha=90^\circ, F=1$

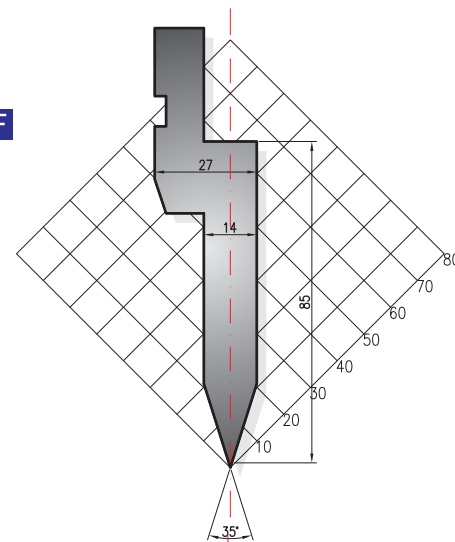


A 6017/H85

100 T/m
 $\alpha=35^\circ, R=0.8$

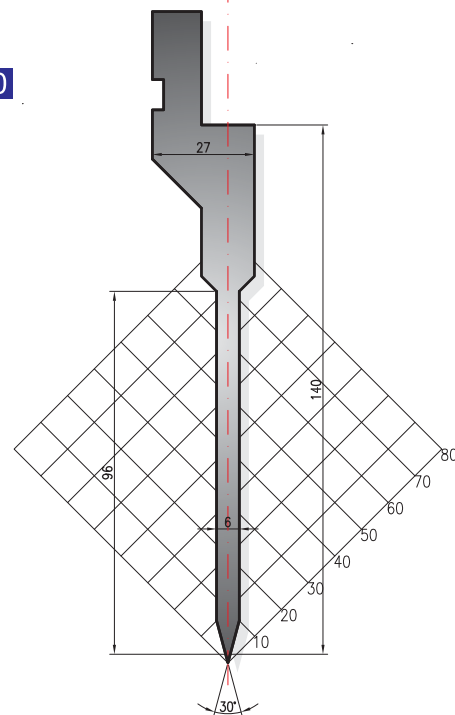
A 6017/H85/F

100 T/m
 $\alpha=35^\circ, F=0.8$



A 6017/H140

40 T/m
 $\alpha=30^\circ, R=0.8$



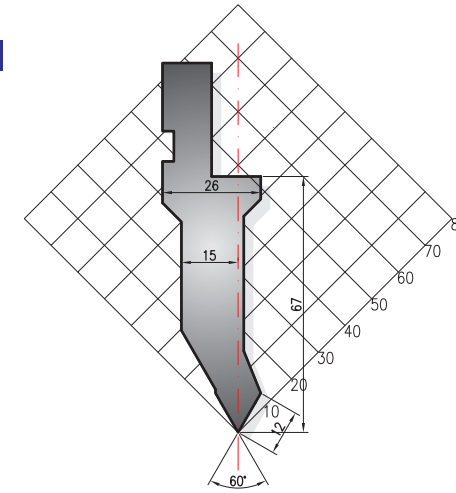
A Punches/Stemple

A 6018

50 T/m
 $\alpha=60^\circ, R=0.8$

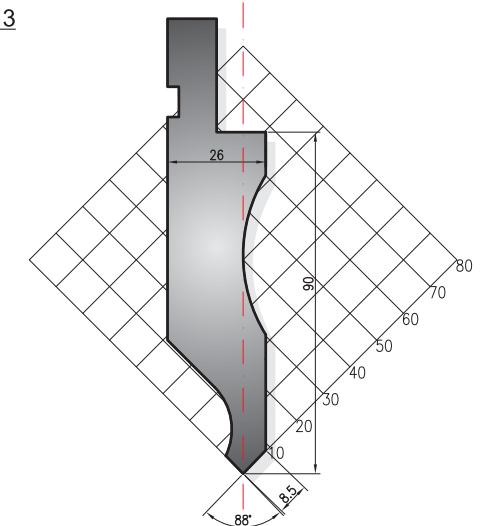
A 6018/F

50 T/m
 $\alpha=60^\circ, F=0.8$



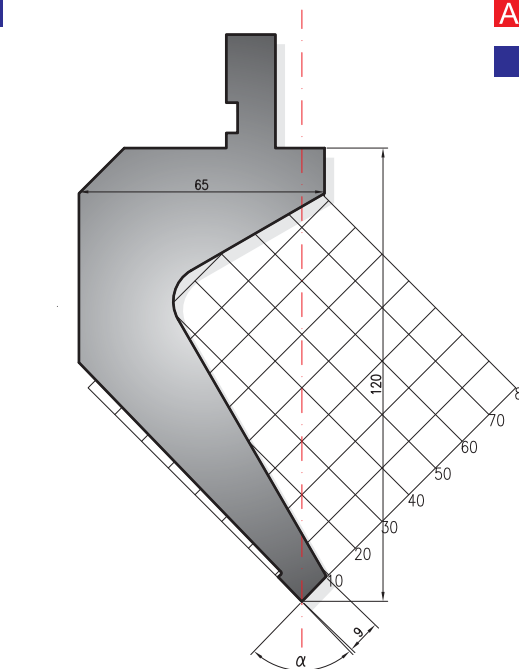
A 6019

50 T/m
 $\alpha=88^\circ, R=0.8, 3$



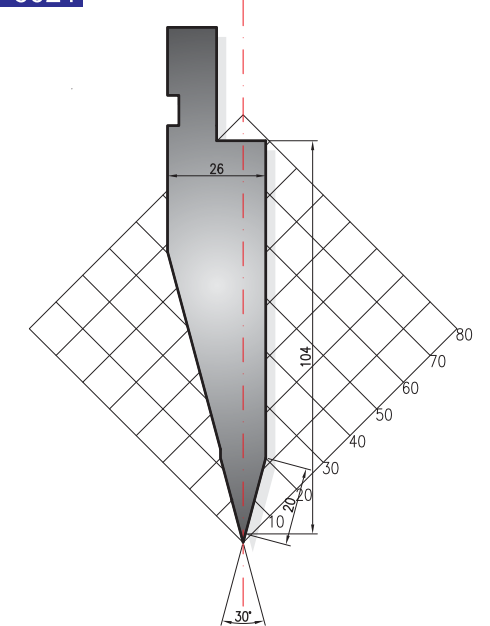
A 6020

50 T/m
 $\alpha=75^\circ, R=0.8$
 $\alpha=88^\circ, R=0.2, 0.8$



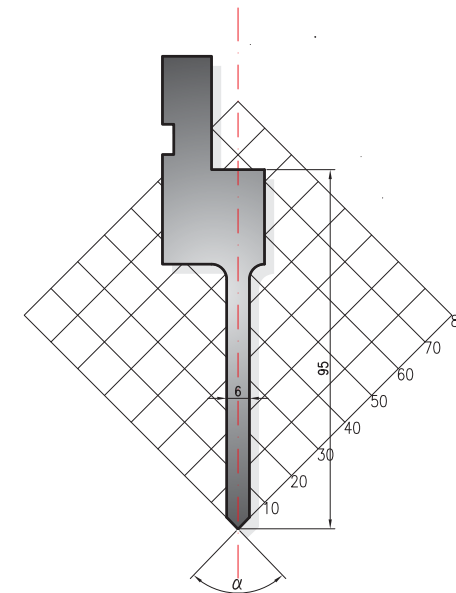
A 6021

100 T/m
 $\alpha=30^\circ, R=0.8$



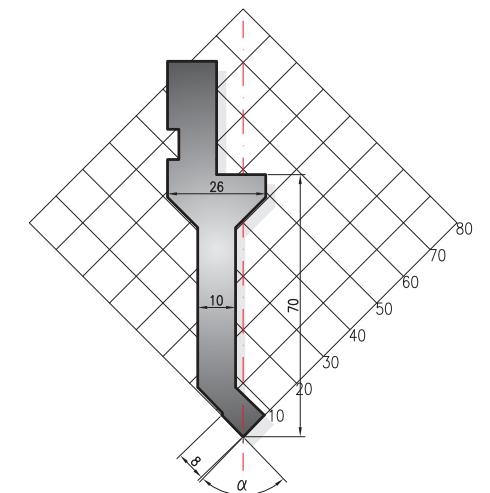
A 6022

50 T/m
 $\alpha=75^\circ, R=0.8$
 $\alpha=88^\circ, R=0.2$
 $\alpha=90^\circ, R=0.2$



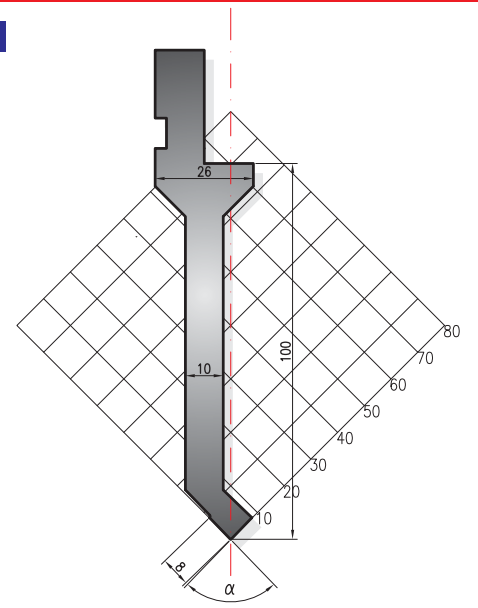
A 6023

30 T/m
 $\alpha=88^\circ, R=0.2$
 $\alpha=90^\circ, R=0.2$



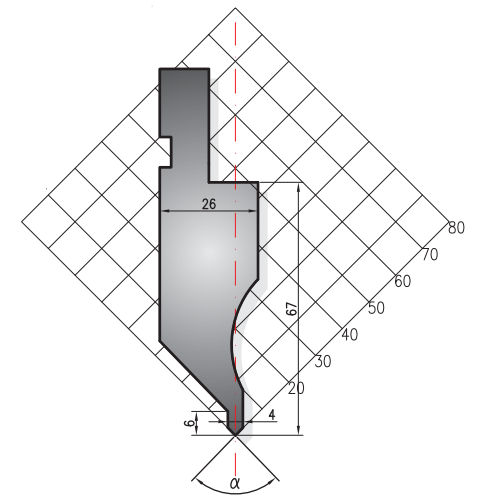
A 6024

30 T/m
 $\alpha=88^\circ, R=0.2$
 $\alpha=90^\circ, R=0.2$



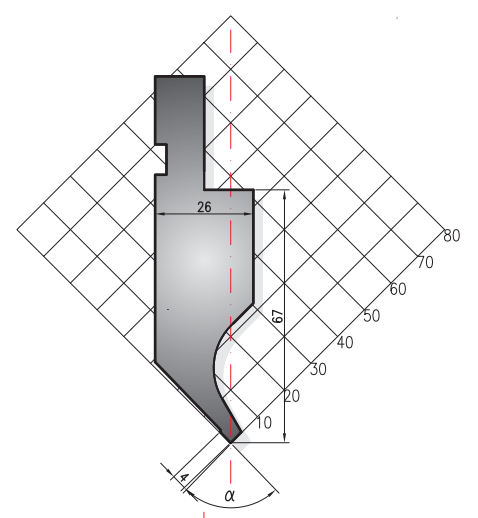
A 6025

40 T/m
 $\alpha=88^\circ, R=0.2$
 $\alpha=90^\circ, R=0.2$



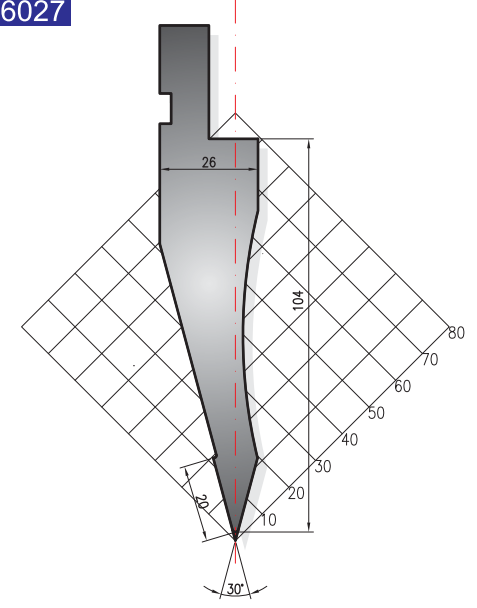
A 6026

20 T/m
 $\alpha=88^\circ, R=0.2$
 $\alpha=90^\circ, R=0.2$



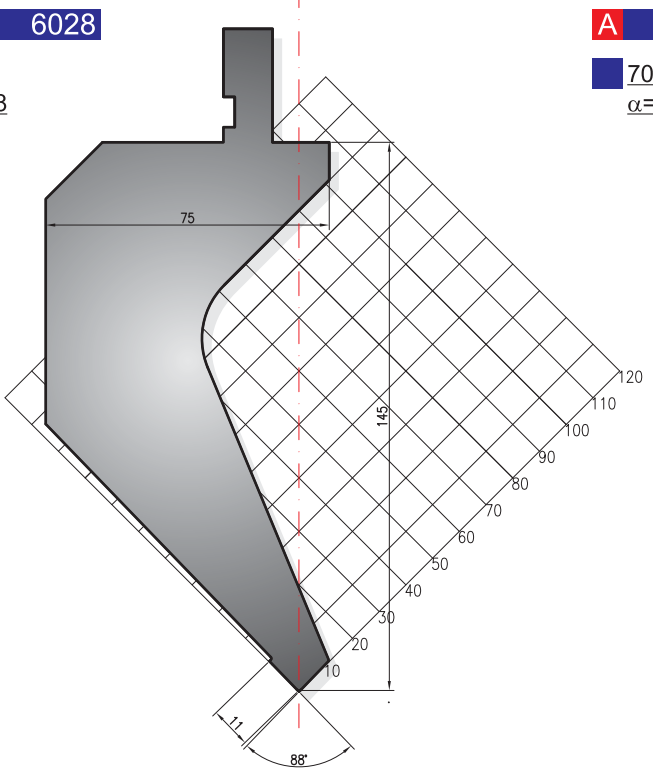
A 6027

50 T/m
 $\alpha=30^\circ, R=0.8$



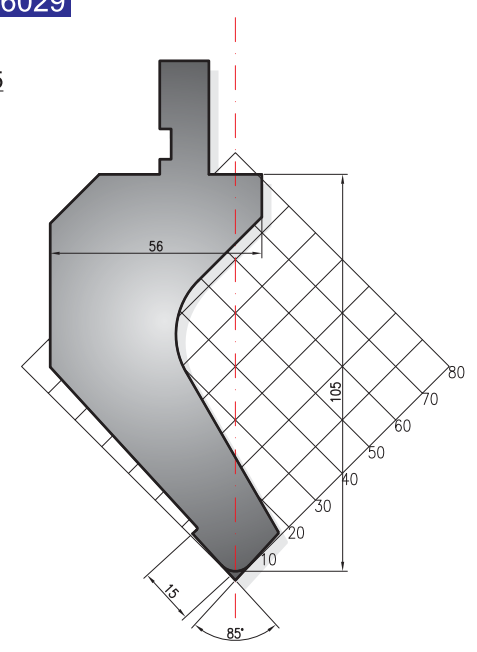
A 6028

80 T/m
 $\alpha=88^\circ, R=0.8$



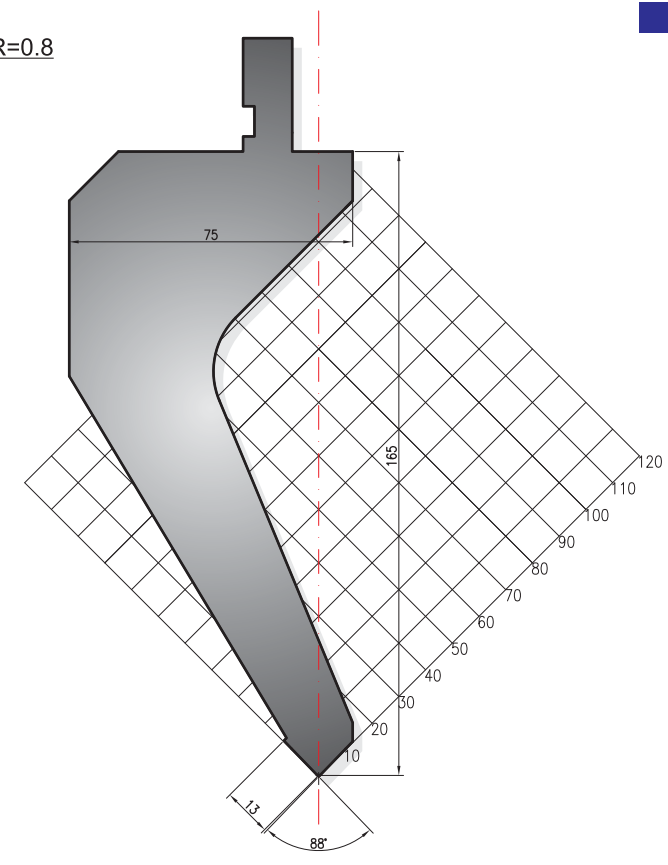
A 6029

70 T/m
 $\alpha=85^\circ, R=5, 6.5$



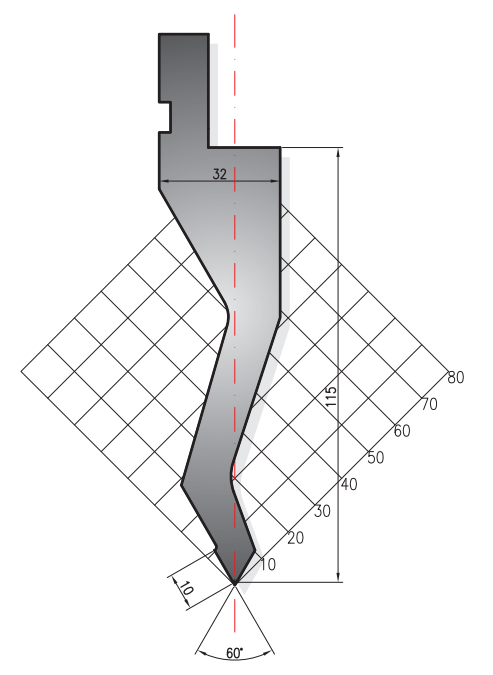
A 6030

60 T/m
 $\alpha=88^\circ, R=0.8$



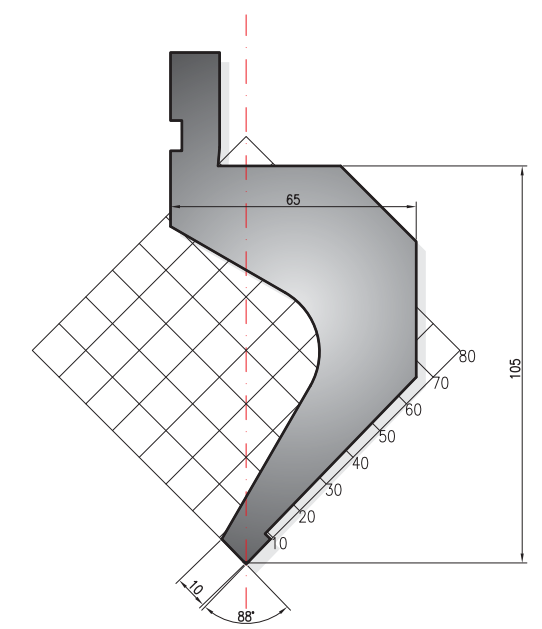
A 6031

60 T/m
 $\alpha=60^\circ, R=0.8$



A 6032

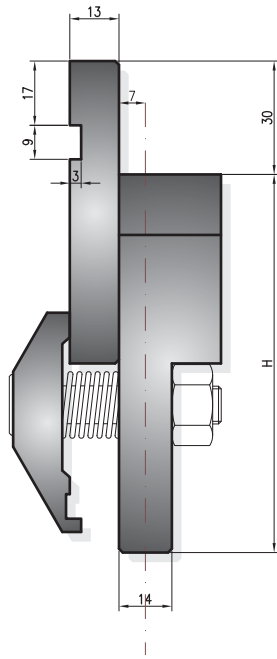
45 T/m
 $\alpha=88^\circ, R=0.8$



B Punch Holders/Adaptery Stempli

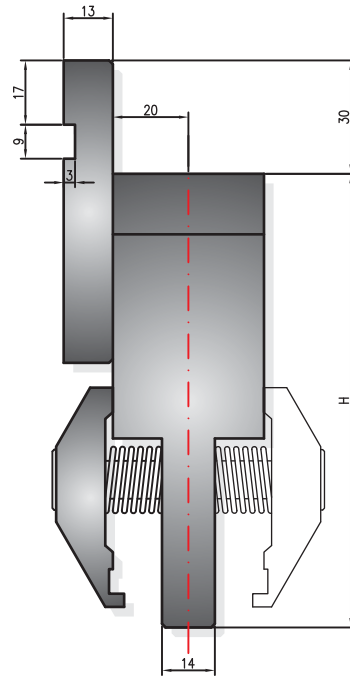
B Type 1 / Typ 1

H=100, L=150
H=120, L=150
H=150, L=150

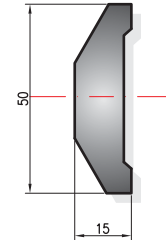
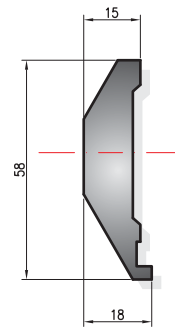


B Type 2 / Typ 2

H=120, L=150
H=150, L=150

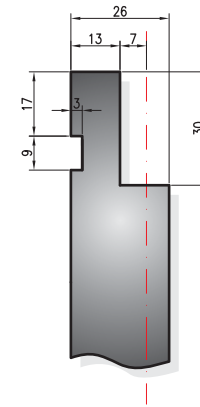


B Security Clamps / Klamry Mocujące

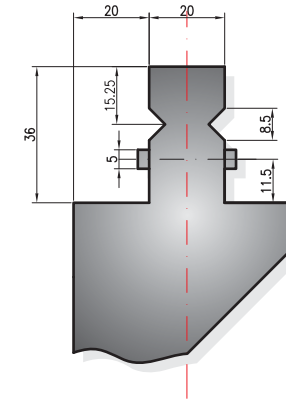


E Punch Mounting Edge/Rodzaje Mocowania Stempli

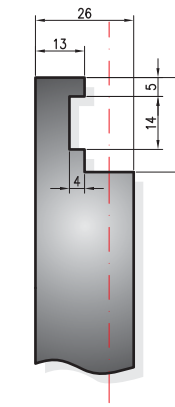
E System 1



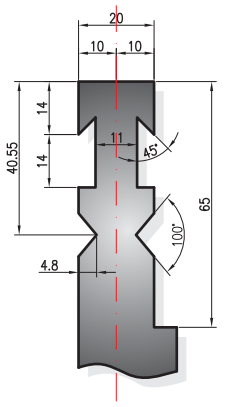
E System 2



E System 3



E System 4



E System 5

E System 6

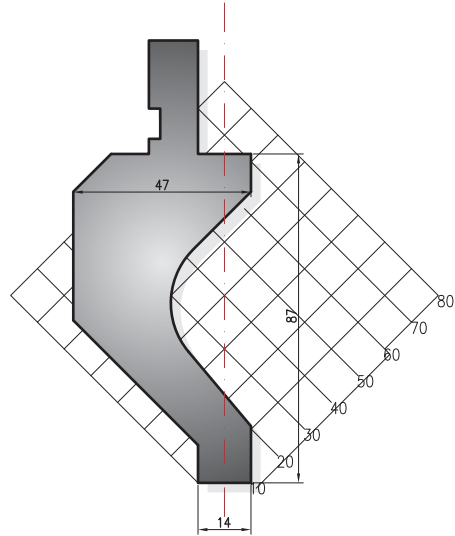
E System 7

E System 8

C Radius Punches/Stemple Promieniowe

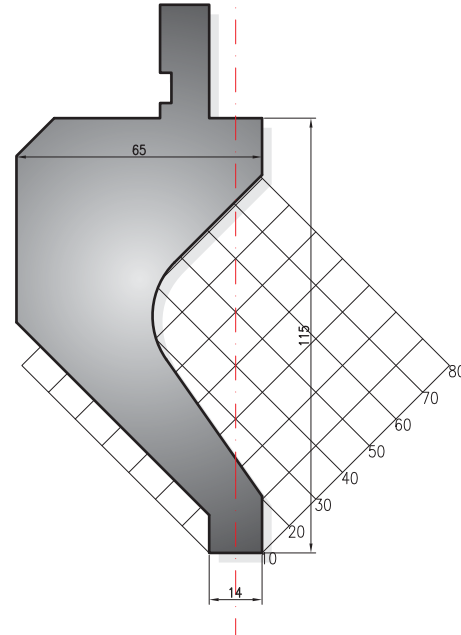
C 6003

50 T/m



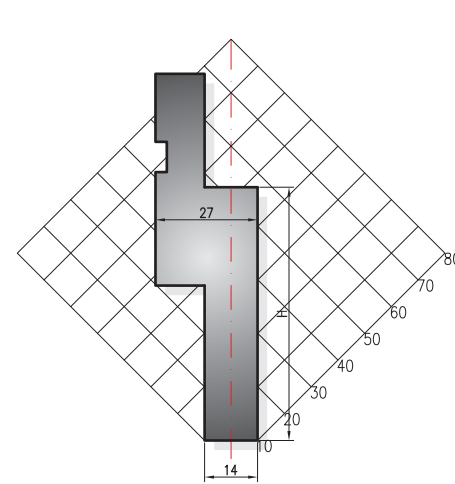
C 6004

50 T/m

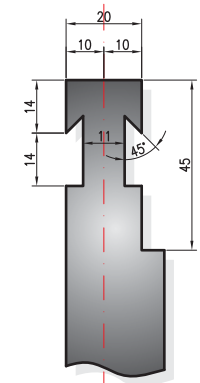


C 6005

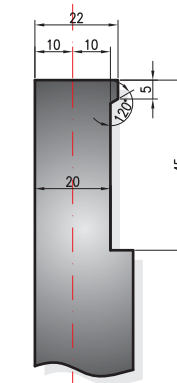
100 T/m



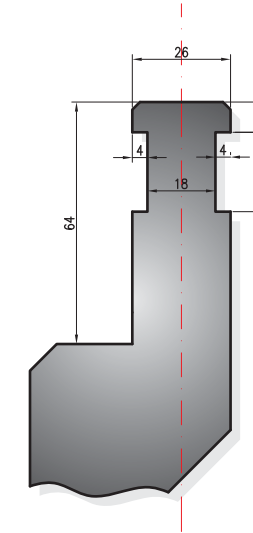
E System 9



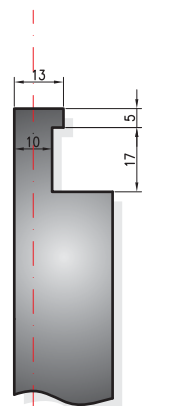
E System 10



E System 11



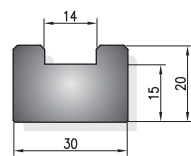
E System 12



D Inserts for Radius Punches/Wkładki do Stempli Promieniowych

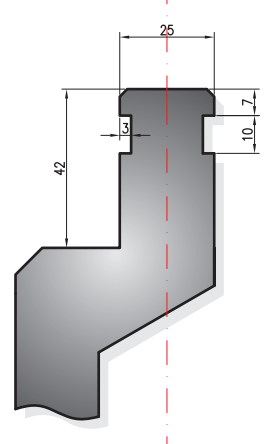
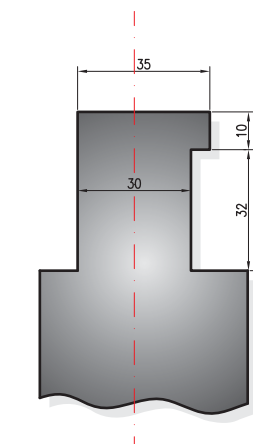
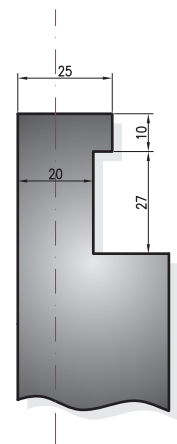
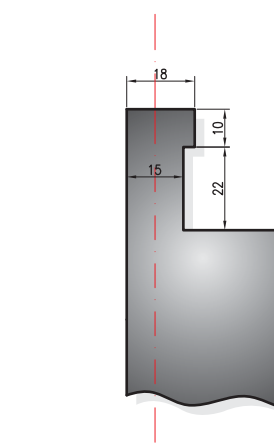
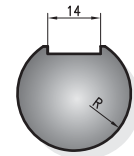
D 8002

100 T/m



D 8002/R

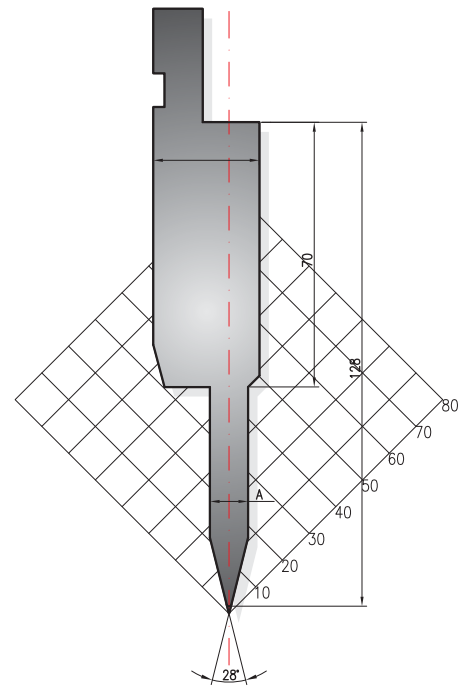
100 T/m
R=7.5 R=10,
R=12.5 R=15
R=17.5 R=20
R=25 R=30
R=40 R=50



F Flattening Tools/Zestaw do Zagniatania

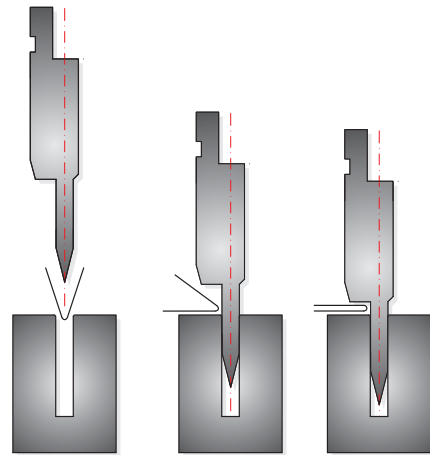
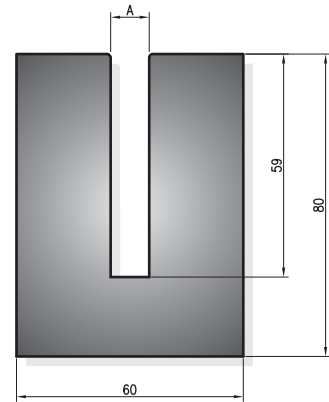
F 6300

70 T/m
 $\alpha=28^\circ$, R=0.6, A=8, 10, 12



F 4300

70 T/m
 A=8, 10, 12

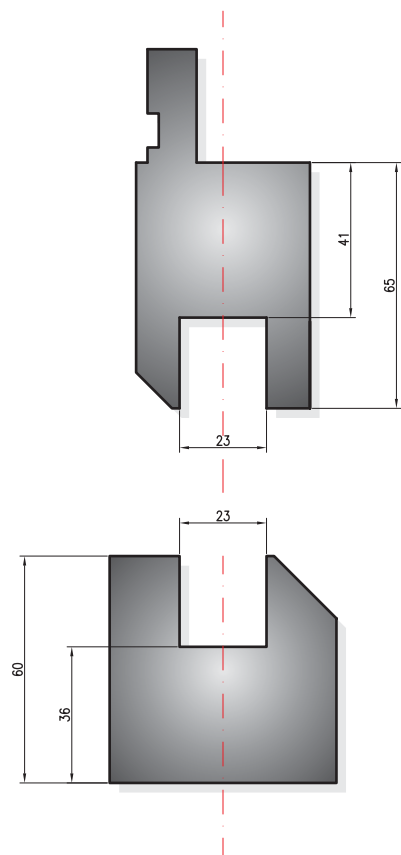


i Example of use / Przykład zastosowania

G "Z" Set Tools/Zestaw do "Z"

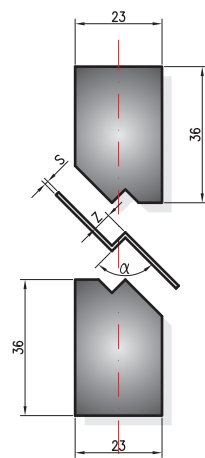
G 6306

100 T/m



G 4307

100 T/m

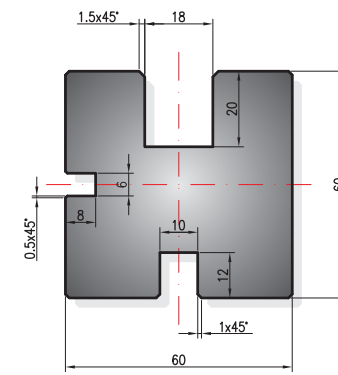


| Z mm | α° | S mm | t/m |
|------|----------------|------|-----|
| 1 | 160° | 0.5 | 100 |
| 1.5 | 160° | 0.6 | 100 |
| 2 | 150° | 0.8 | 100 |
| 2.5 | 140° | 1 | 100 |
| 3 | 90° | 1 | 100 |
| 3.5 | 90° | 1.2 | 100 |
| 4 | 90° | 1.2 | 100 |
| 4.5 | 90° | 1.5 | 100 |
| 5 | 90° | 1.5 | 100 |
| 5.5 | 90° | 1.5 | 100 |
| 6 | 90° | 1.5 | 100 |
| 6.5 | 90° | 1.5 | 100 |
| 7 | 90° | 2 | 100 |
| 7.5 | 90° | 2 | 100 |
| 8 | 90° | 2.5 | 100 |

H Multiple Vee Dies/Matryce Wielopryzmowe

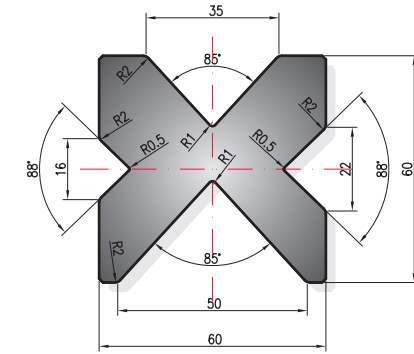
H 4008

100 T/m



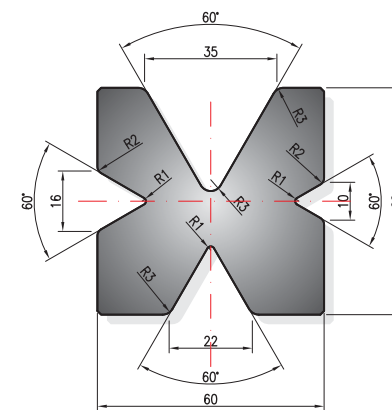
H 4009

100 T/m



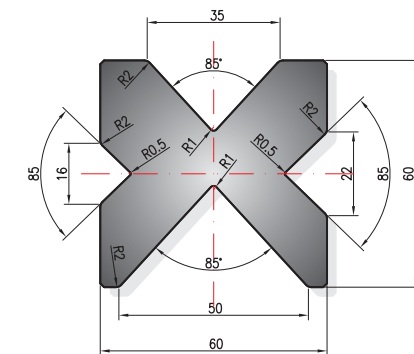
H 4009/60

80 T/m



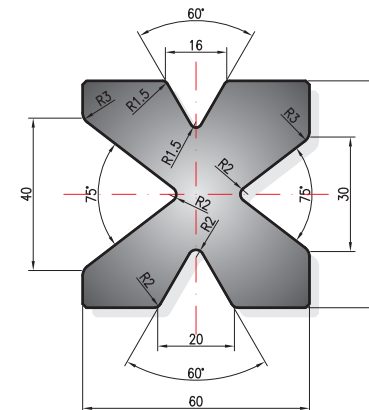
H 4009/85

100 T/m



H 4009/SPEC

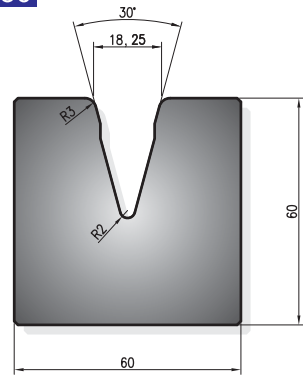
30 T/m



4011/18/30

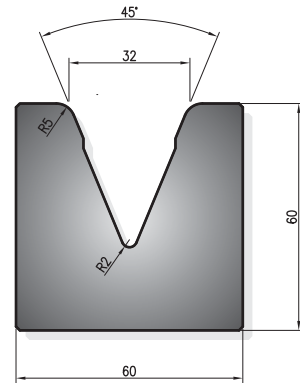
4011/25/30

80 T/m



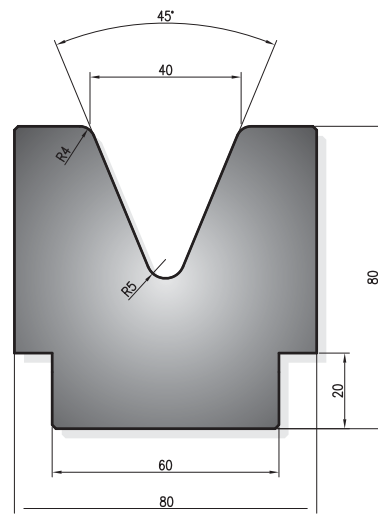
4011/32/45

40 T/m



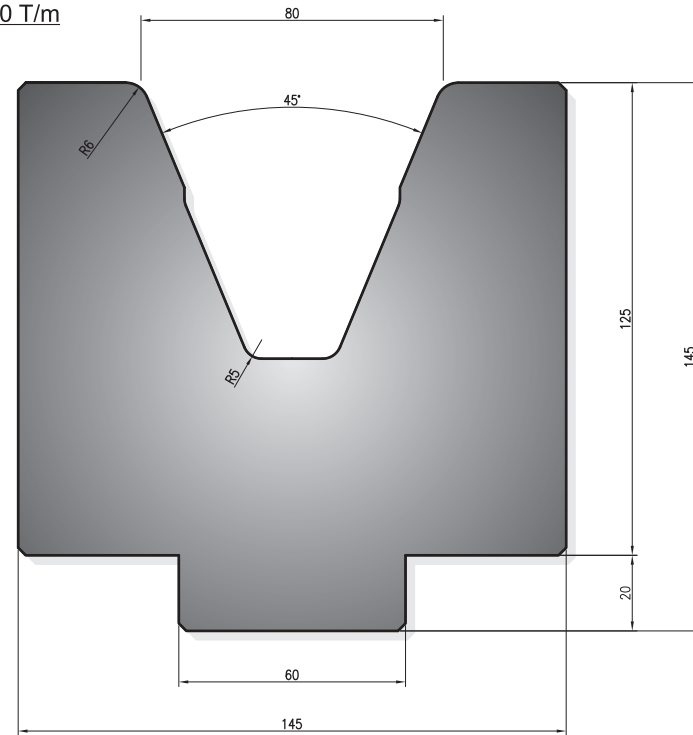
4011/40/45

100 T/m



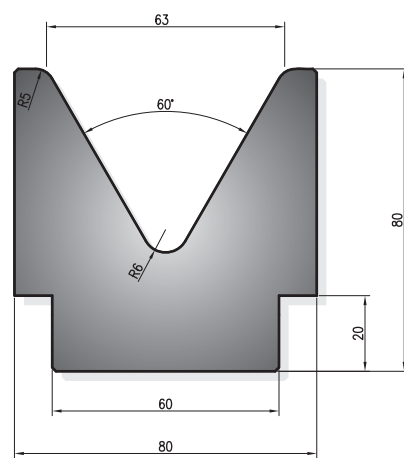
4011/80/45

100 T/m



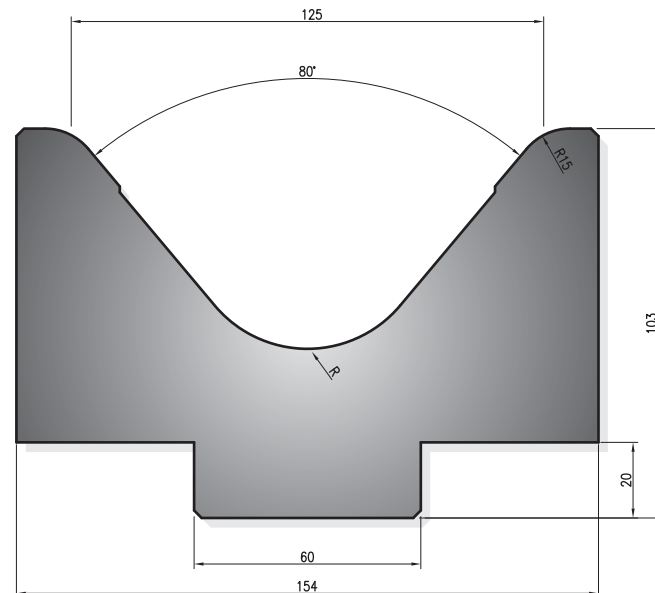
4011/63/60

100 T/m



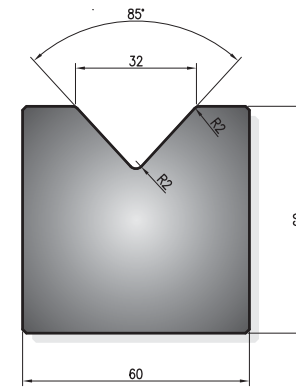
4011/125/80

100 T/m



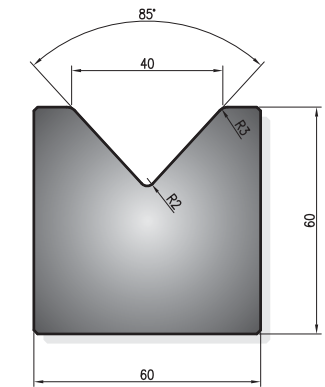
4011/32/85

100 T/m



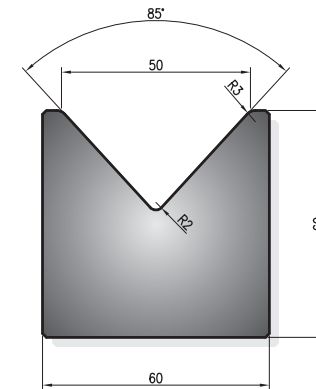
4011/40/85

100 T/m



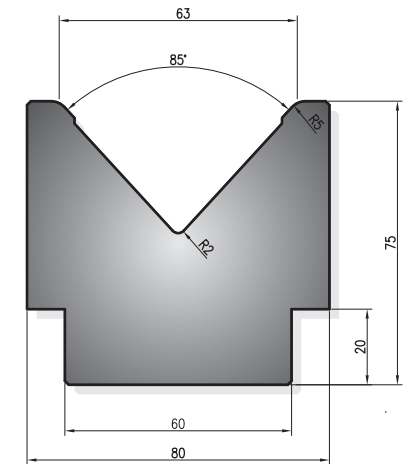
4011/50/85

100 T/m



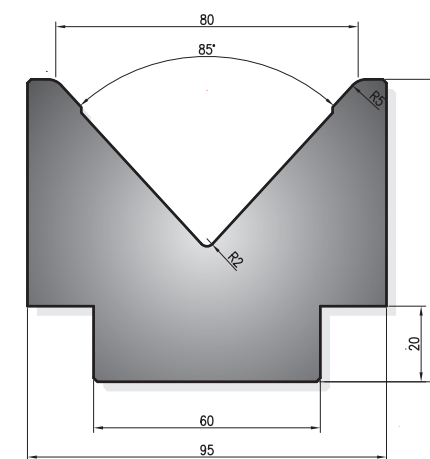
4011/63/85

100 T/m



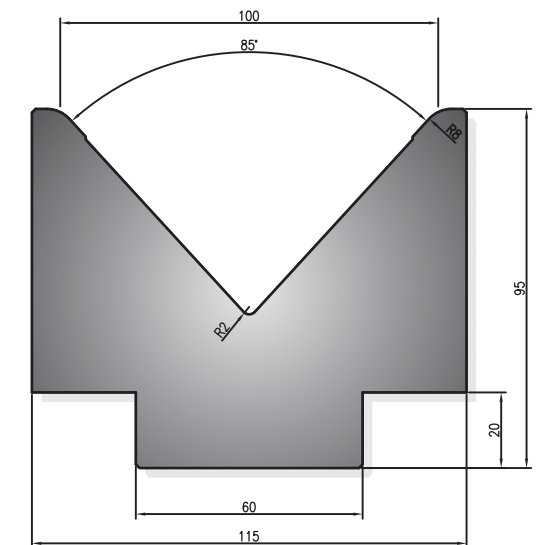
4011/80/85

100 T/m



4011/100/85

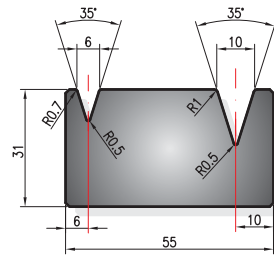
100 T/m



J Double Dies - Bolt Fastened/Matryce Dwupryzmowe - Mocowane Śrubami

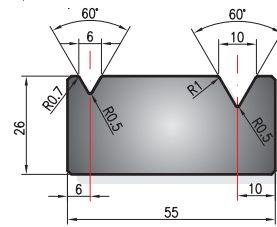
J 4012/35

30 T/m



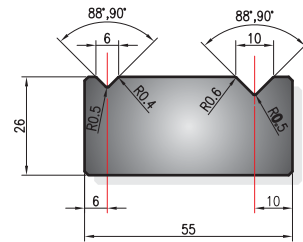
J 4012/60

80 T/m



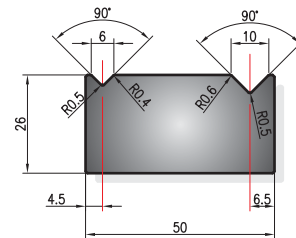
J 4012/88,90

100 T/m



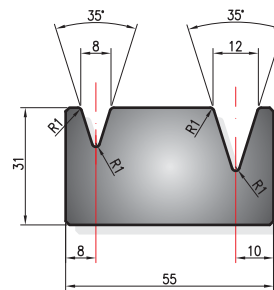
J 4012/A/90

80 T/m



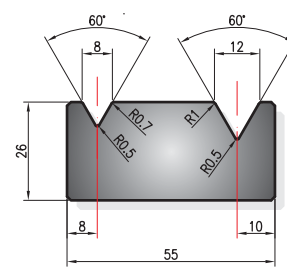
J 4013/35

30 T/m



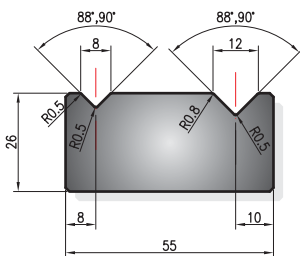
J 4013/60

80 T/m



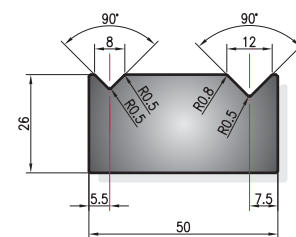
J 4013/88,90

100 T/m



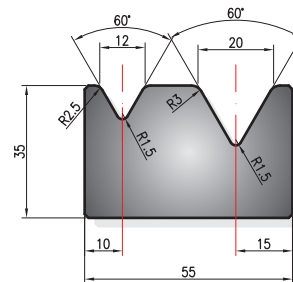
J 4013/A/90

80 T/m



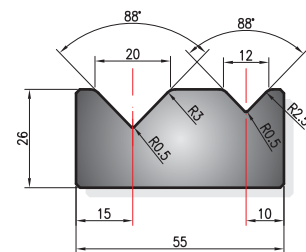
J 4014/60

80 T/m



J 4014/88

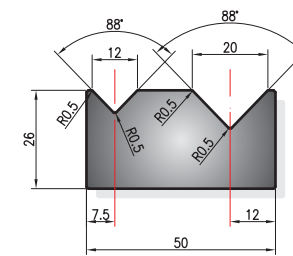
100 T/m



J Double Dies - Bolt Fastened/Matryce Dwupryzmowe - Mocowane Śrubami

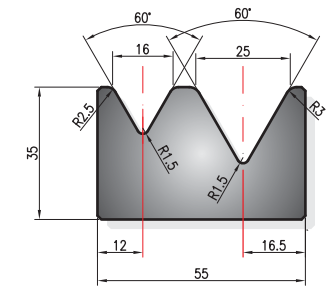
J 4014/A/88

80 T/m



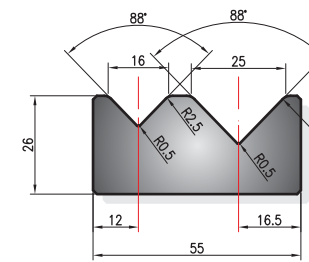
J 4015/60

80 T/m



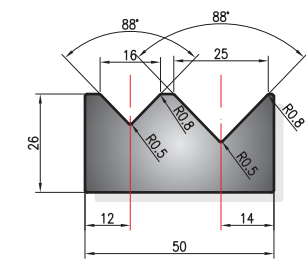
J 4015/88

100 T/m



J 4015/A/88

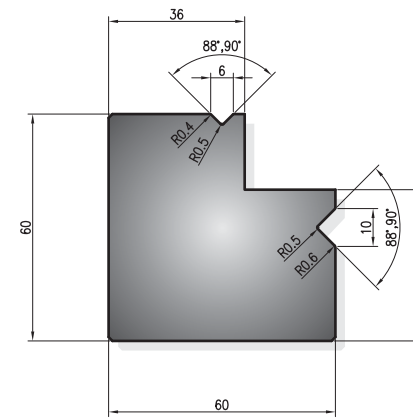
80 T/m



K Double Dies with Extract/Matryce Dwupryzmowe z Wybraniem

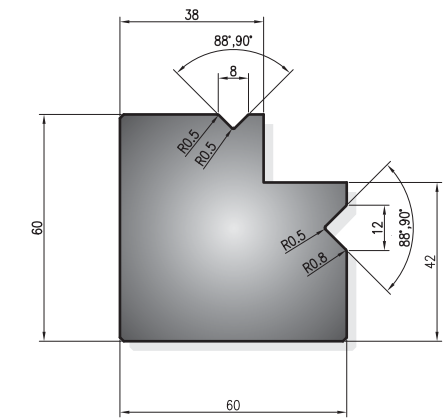
K 4016/88,90

70 T/m



K 4017/88,90

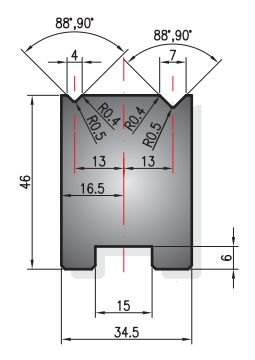
70 T/m



L Double Dies - Quick Fasten/Matryce Dwuprzyszowe - Szybkiego Mocowania

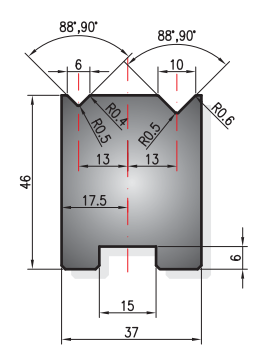
L 4019/88,90

60 T/m



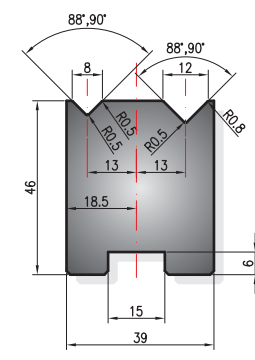
L 4020/88,90

70 T/m



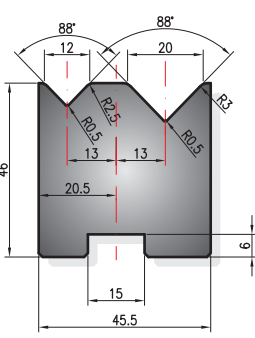
L 4021/88,90

75 T/m



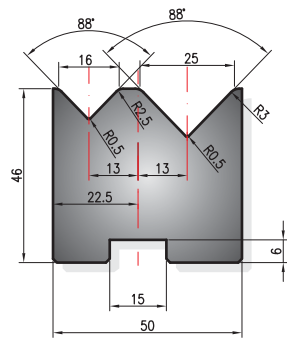
L 4022

100 T/m



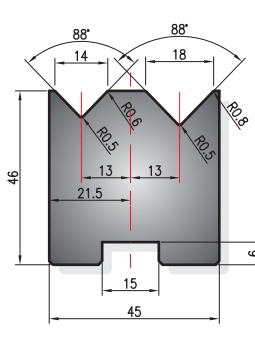
L 4023

100 T/m



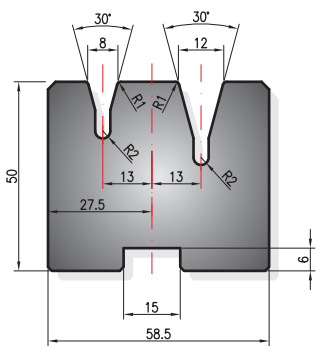
L 4024

100 T/m



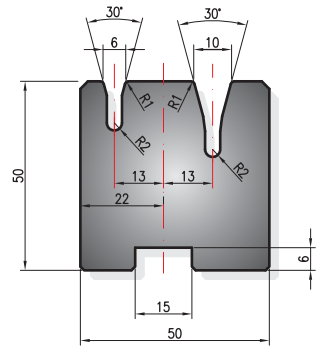
L 4025

30 T/m



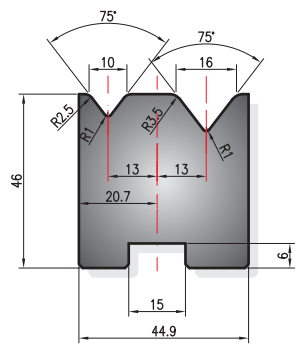
L 4026

30 T/m



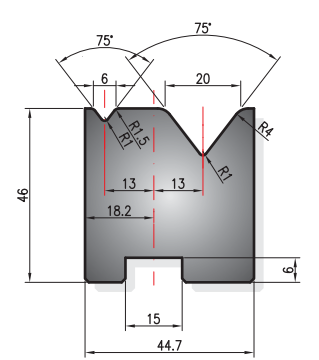
L 4027

30 T/m



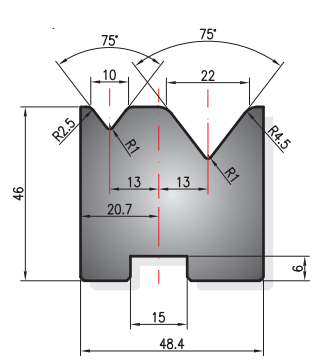
L 4028

30 T/m



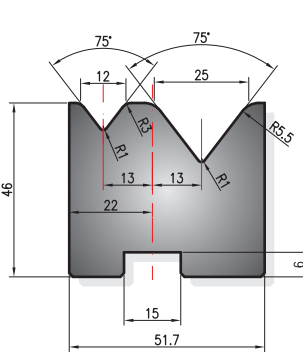
L 4029

30 T/m



L 4030/QC

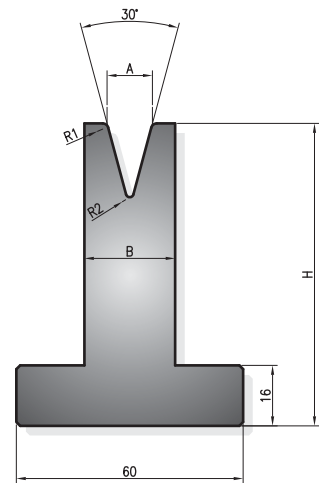
30 T/m



M T-shaped Dies/Matryce Teowe

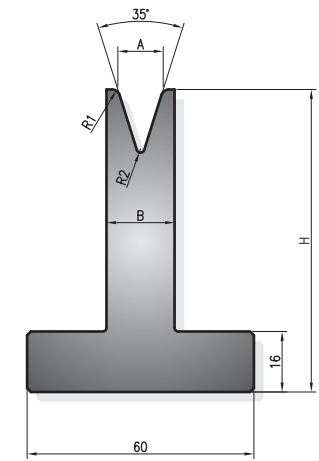
M 4030

30 T/m



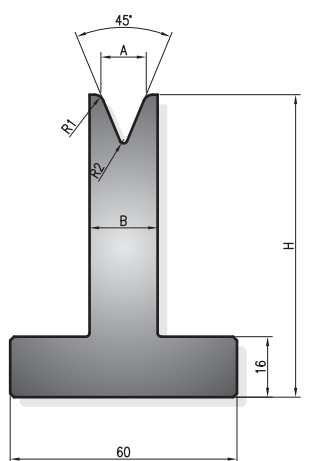
M 4035

30 T/m



M 4045

70 T/m



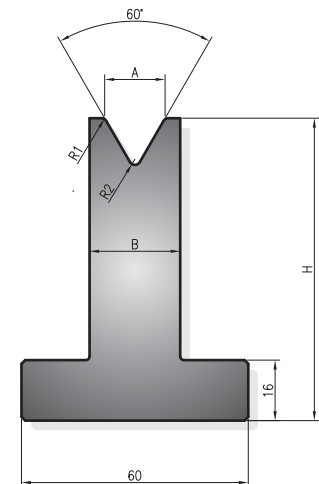
| 4030 | A mm | B mm | R1 mm | R2 mm | H mm |
|---------|------|------|-------|-------|--------|
| 4030/6 | 6 | 14 | 0.6 | 0.6 | 80/120 |
| 4030/8 | 8 | 18 | 0.8 | 0.8 | 80/120 |
| 4030/10 | 10 | 24 | 1 | 1 | 80/120 |
| 4030/12 | 12 | 24 | 1.5 | 1 | 80/120 |
| 4030/16 | 16 | 30 | 2 | 2 | 80/120 |
| 4030/20 | 20 | 35 | 2.5 | 3 | 80/120 |
| 4030/25 | 25 | 40 | 3 | 3 | 80/120 |

| 4035 | A mm | B mm | R1 mm | R2 mm | H mm |
|---------|------|------|-------|-------|--------|
| 4035/8 | 8 | 14 | 1.5 | 0.8 | 80/120 |
| 4035/10 | 10 | 16 | 2 | 1 | 80/120 |
| 4035/12 | 12 | 18 | 2 | 1 | 80/120 |

| 4045 | A mm | B mm | R1 mm | R2 mm | H mm |
|---------|------|------|-------|-------|--------|
| 4045/10 | 10 | 18 | 1 | 1 | 80/120 |
| 4045/12 | 12 | 24 | 1.5 | 1.5 | 80/120 |
| 4045/16 | 16 | 26 | 2 | 2 | 80/120 |
| 4045/20 | 20 | 30 | 2.5 | 2.5 | 80/120 |
| 4045/25 | 25 | 35 | 3 | 3 | 80/120 |

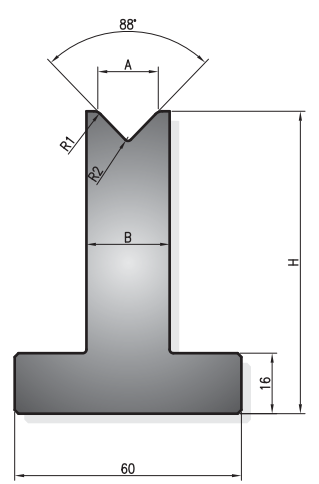
M 4060

70 T/m



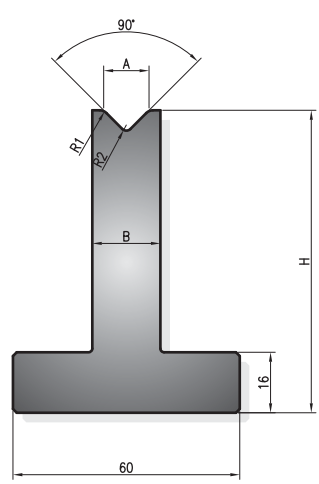
M 4088

100 T/m



M 4090

100 T/m



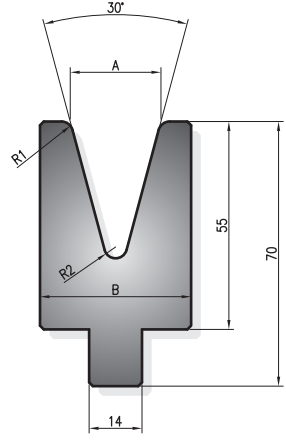
| 4060 | A mm | B mm | R1 mm | R2 mm | H mm |
|---------|------|------|-------|-------|--------|
| 4060/6 | 6 | 12 | 1.5 | 0.5 | 80/120 |
| 4060/8 | 8 | 14 | 1.5 | 0.8 | 80/120 |
| 4060/10 | 10 | 16 | 2 | 1 | 80/120 |
| 4060/12 | 12 | 18 | 2.5 | 1 | 80/120 |
| 4060/16 | 16 | 24 | 1.5 | 1.5 | 80/120 |
| 4060/20 | 20 | 30 | 2 | 2 | 80/120 |
| 4060/25 | 25 | 40 | 3 | 3 | 80/120 |

| 4088 | A mm | B mm | R1 mm | R2 mm | H mm |
|---------|------|------|-------|-------|--------|
| 4088/6 | 6 | 12 | 1.5 | 0.5 | 80/120 |
| 4088/8 | 8 | 14 | 1.5 | 0.8 | 80/120 |
| 4088/10 | 10 | 16 | 2 | 1 | 80/120 |
| 4088/12 | 12 | 18 | 2.5 | 1 | 80/120 |
| 4088/16 | 16 | 22 | 2.5 | 1 | 80/120 |
| 4088/20 | 20 | 30 | 3 | 3 | 80/120 |
| 4088/25 | 25 | 40 | 3 | 3 | 80/120 |
| 4088/30 | 30 | 45 | 3 | 3 | 80/120 |

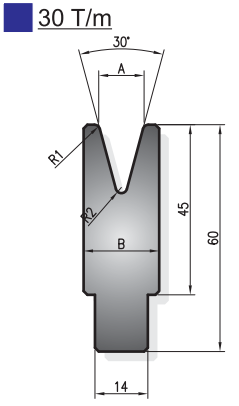
| 4090 | A mm | B mm | R1 mm | R2 mm | H mm |
|---------|------|------|-------|-------|--------|
| 4090/6 | 6 | 12 | 1.5 | 0.5 | 80/120 |
| 4090/8 | 8 | 14 | 1.5 | 0.8 | 80/120 |
| 4090/10 | 10 | 16 | 2 | 1 | 80/120 |
| 4090/12 | 12 | 18 | 2.5 | 1.5 | 80/120 |
| 4090/16 | 16 | 22 | 2.5 | 1 | 80/120 |

N Single Narrow Dies/Matryce Jednoprzymowe Wąskie

| 4130 | A mm | B mm | R1 mm | R2 mm |
|---------|------|------|-------|-------|
| 4130/20 | 20 | 30 | 2.5 | 2.5 |
| 4130/24 | 24 | 40 | 3 | 3 |



N 4130

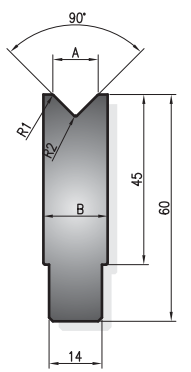


30 T/m

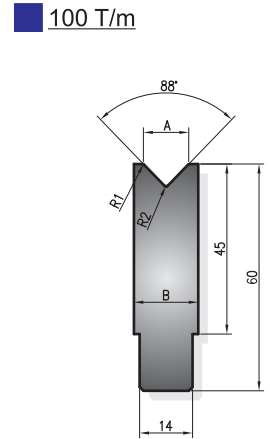
| 4130 | A mm | B mm | R1 mm | R2 mm |
|---------|------|------|-------|-------|
| 4130/6 | 6 | 20 | 1 | 1 |
| 4130/8 | 8 | 20 | 1 | 1 |
| 4130/10 | 10 | 20 | 1 | 1 |
| 4130/12 | 12 | 20 | 1.5 | 1.5 |
| 4130/16 | 16 | 30 | 2.5 | 2.5 |

N 4130
30 T/m

| 4190 | A mm | B mm | R1 mm | R2 mm |
|---------|------|------|-------|-------|
| 4190/6 | 6 | 14 | 0.5 | 0.5 |
| 4190/8 | 8 | 14 | 0.5 | 0.5 |
| 4190/10 | 10 | 15 | 0.5 | 0.5 |
| 4190/12 | 12 | 17 | 0.5 | 0.5 |



N 4188



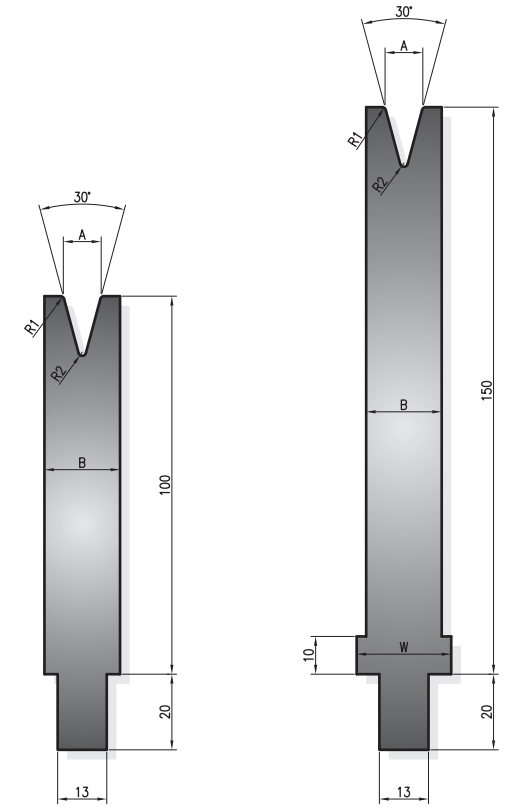
100 T/m

| 4188 | A mm | B mm | R1 mm | R2 mm |
|---------|------|------|-------|-------|
| 4188/6 | 6 | 14 | 0.5 | 0.5 |
| 4188/8 | 8 | 14 | 0.5 | 0.5 |
| 4188/10 | 10 | 15 | 0.5 | 0.5 |
| 4188/12 | 12 | 17 | 0.5 | 0.5 |
| 4188/14 | 14 | 20 | 0.5 | 0.5 |

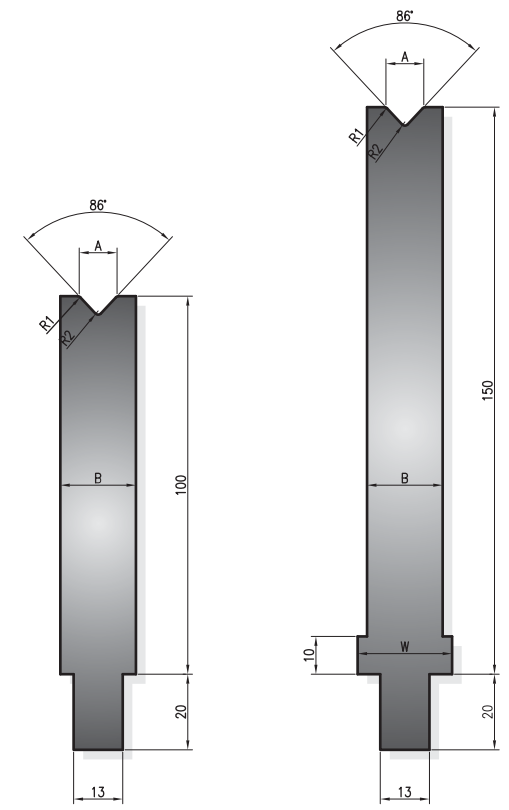
N 4190
100 T/m

O Trumph Wila Dies Types/Matryce Typu Wila Trumph

O 4330



O 4386

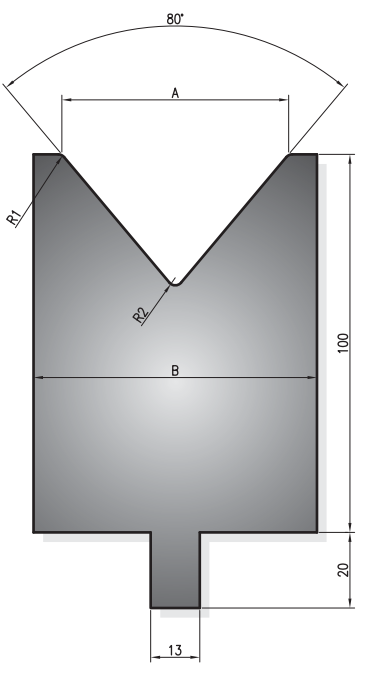


| 4330 | A mm | B mm | W mm | R1 mm | R2 mm | H mm | T/Mt |
|---------|------|------|------|-------|-------|------|------|
| 4330/6 | 6 | 12 | 20 | 0.6 | 0.6 | 100 | 17 |
| | | 20 | 20 | 0.6 | 0.6 | 100 | 40 |
| | | 20 | 25 | 0.6 | 0.6 | 150 | 40 |
| 4330/8 | 8 | 14 | 20 | 1 | 1 | 100 | 17 |
| | | 20 | 20 | 1 | 1 | 100 | 40 |
| | | 20 | 25 | 1 | 1 | 150 | 40 |
| 4330/10 | 10 | 16 | 20 | 1 | 1 | 100 | 20 |
| | | 20 | 20 | 1 | 1 | 100 | 40 |
| | | 20 | 25 | 1 | 1 | 150 | 40 |
| 4330/12 | 12 | 18 | 25 | 1 | 1 | 100 | 20 |
| | | 25 | 25 | 1 | 1 | 100 | 40 |
| | | 25 | 25 | 1 | 1 | 150 | 40 |
| 4330/16 | 16 | 30 | 30 | 1.5 | 1.5 | 100 | 50 |
| | | 30 | 30 | 1.5 | 1.5 | 100 | 50 |
| 4330/20 | 20 | 35 | 35 | 2 | 2 | 100 | 60 |
| | | 35 | 35 | 2 | 2 | 150 | 60 |
| 4330/24 | 24 | 40 | 40 | 2.5 | 2.5 | 100 | 65 |
| | | 40 | 40 | 2.5 | 2.5 | 150 | 65 |
| 4330/32 | 32 | 60 | 60 | 3 | 3 | 100 | 65 |
| | | 60 | 60 | 3 | 3 | 150 | 65 |

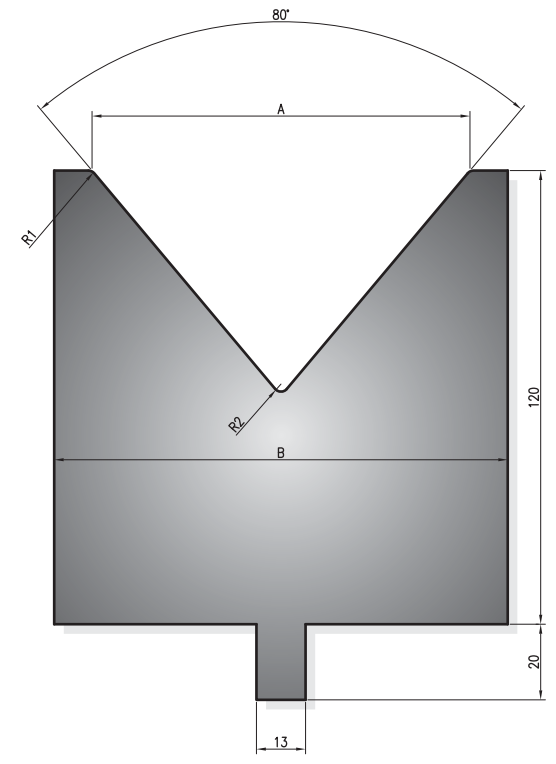
| 4386 | A mm | B mm | W mm | R1 mm | R2 mm | H mm | T/Mt |
|---------|------|------|------|-------|-------|------|------|
| 4386/6 | 6 | 10 | 20 | 0.6 | 0.6 | 100 | 24 |
| | | 20 | 20 | 0.6 | 0.6 | 100 | 40 |
| | | 20 | 25 | 0.6 | 0.6 | 150 | 40 |
| 4386/8 | 8 | 12 | 20 | 0.8 | 0.8 | 100 | 35 |
| | | 20 | 20 | 0.8 | 0.8 | 100 | 40 |
| | | 20 | 25 | 0.8 | 0.8 | 150 | 40 |
| 4386/10 | 10 | 14 | 20 | 1 | 1 | 100 | 38 |
| | | 20 | 20 | 1 | 1 | 100 | 50 |
| | | 20 | 25 | 1 | 1 | 150 | 50 |
| 4386/12 | 12 | 16 | 25 | 1 | 1 | 100 | 40 |
| | | 25 | 25 | 1 | 1 | 100 | 50 |
| | | 25 | 25 | 1 | 1 | 150 | 50 |
| 4386/16 | 16 | 30 | 30 | 1.5 | 1.5 | 100 | 70 |
| | | 30 | 30 | 1.5 | 1.5 | 150 | 70 |
| 4386/20 | 20 | 30 | 30 | 2 | 2 | 100 | 70 |
| | | 30 | 30 | 2 | 2 | 150 | 70 |
| 4386/24 | 24 | 35 | 35 | 2.5 | 2.5 | 100 | 70 |
| | | 35 | 35 | 2.5 | 2.5 | 150 | 70 |
| 4386/30 | 30 | 45 | 45 | 3 | 3 | 100 | 75 |
| | | 45 | 45 | 3 | 3 | 150 | 75 |
| 4386/40 | 40 | 55 | 55 | 3 | 3 | 100 | 120 |
| | | 55 | 55 | 3 | 3 | 150 | 120 |
| 4386/50 | 50 | 75 | 75 | 3 | 3 | 100 | 120 |
| | | 75 | 75 | 3 | 3 | 150 | 120 |

O Trumph Wila Dies Types/Matryce Typu Wila Trumph

O 4380



O 4380

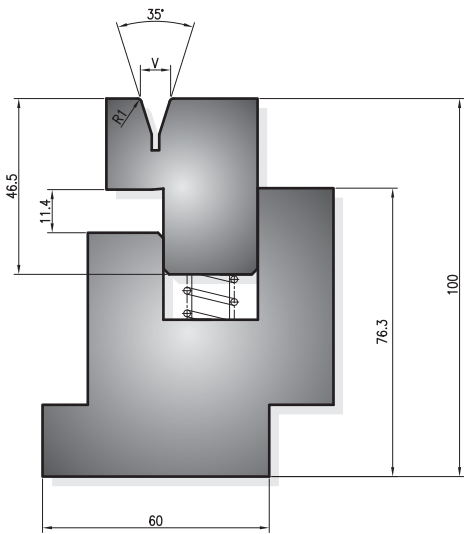


| 4380 | A mm | B mm | R1 mm | R2 mm | T/Mt |
|---------|------|------|-------|-------|------|
| 4380/60 | 60 | 75 | 5 | 5 | 150 |
| 4380/70 | 70 | 85 | 5 | 5 | 150 |
| 4380/80 | 80 | 100 | 5 | 5 | 150 |

| 4380 | A mm | B mm | R1 mm | R2 mm | T/Mt |
|----------|------|------|-------|-------|------|
| 4380/90 | 90 | 110 | 8 | 5 | 150 |
| 4380/100 | 100 | 120 | 8 | 5 | 150 |

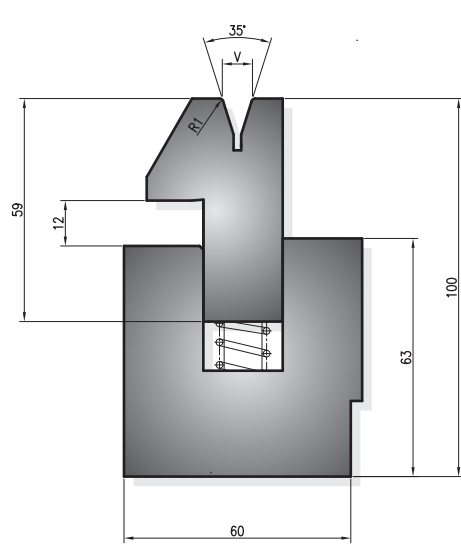
P 43100

60 T/m
V=6
V=8



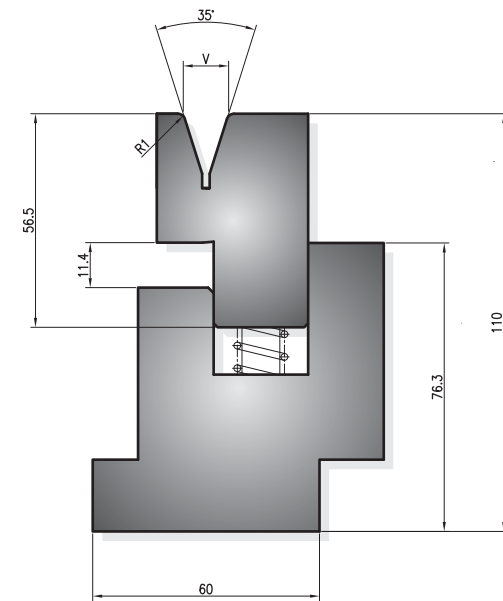
P 43100N

60 T/m
V=6
V=8



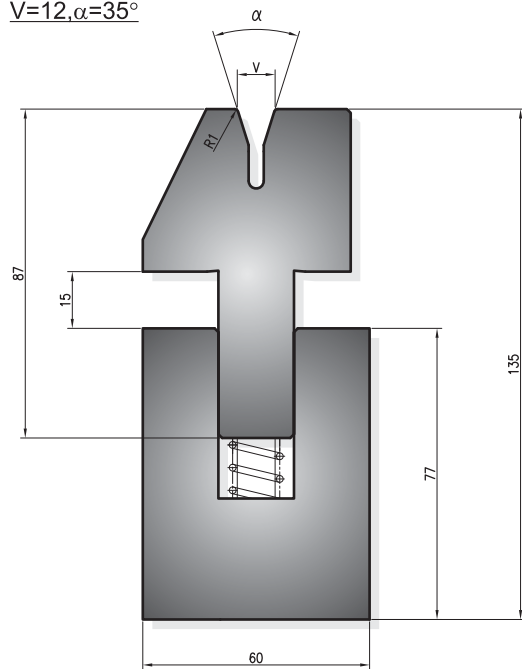
P 43110

60 T/m
V=12



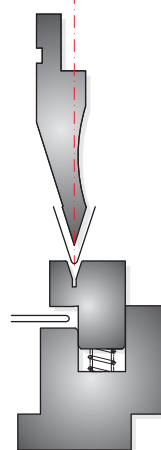
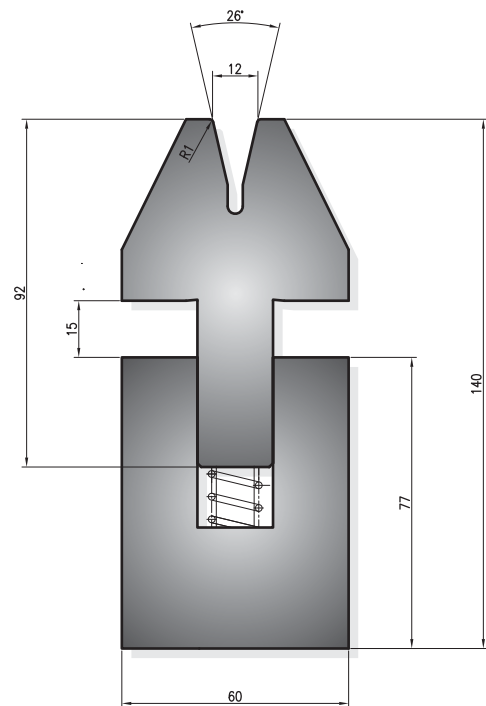
P 43135

100 T/m
V=10, α=26°
V=10, α=35°
V=12, α=35°



P 43140

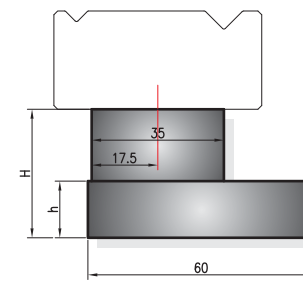
100 T/m
V=12



i Example of use / Przykład zastosowania

R 5006

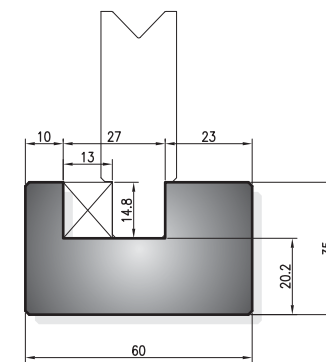
100 T/m



| 5006 | H mm | h mm |
|---------|------|------|
| 5006/34 | 34 | 15 |
| 5006/39 | 39 | 15 |
| 5006/45 | 45 | 19 |
| 5006/55 | 55 | 19 |
| 5006/75 | 75 | 19 |

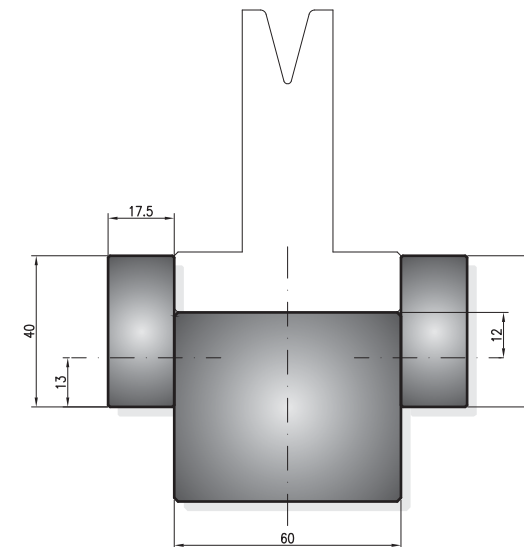
R 5015

100 T/m



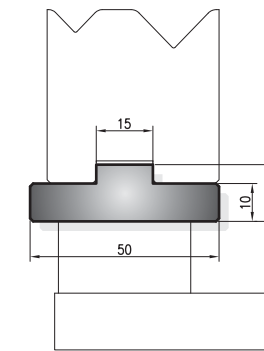
R 5018

100 T/m



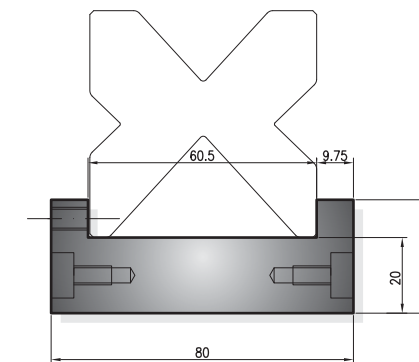
R 5010

100 T/m



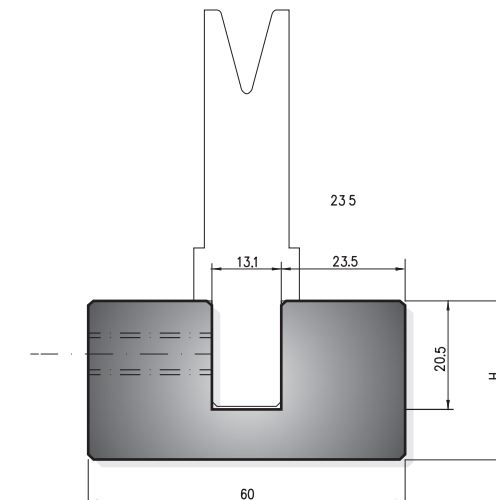
R 5016/L1050

100 T/m



R 5019

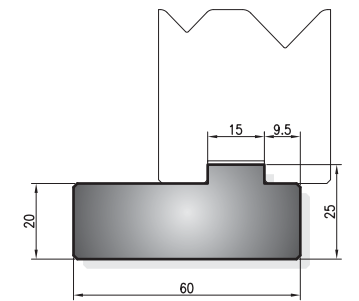
100 T/m



| 5019 | H mm |
|---------|------|
| 5019/30 | 30 |
| 5019/60 | 60 |

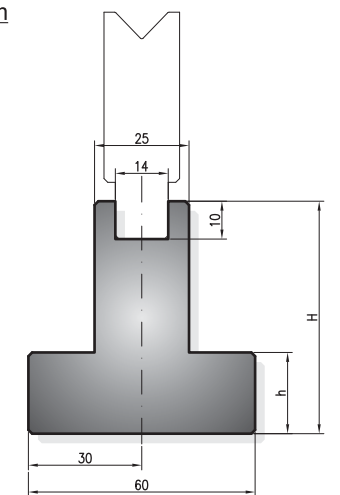
R 5011

100 T/m

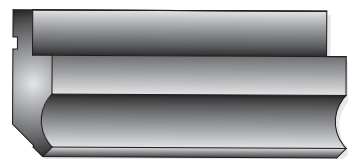


R 5017

100 T/m



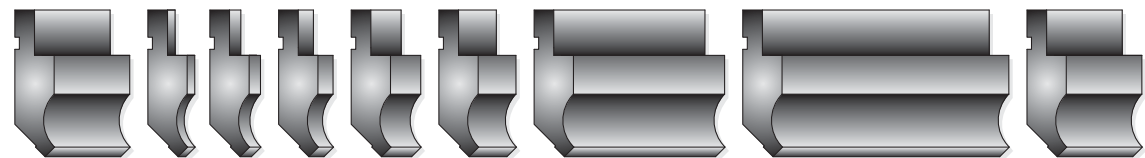
| 5017 | H mm | h mm |
|-----------|------|------|
| 5017/31 | 31 | 10 |
| 5017/61.5 | 61.5 | 21.5 |



415



835



100 10 15 20 40 50 200 300 100



415



835



100 10 15 20 40 50 400 200

STANDARD TOOLS

Material

C45, C55, 41Cr4 or 42CrMo4

Working edge hardened

54 - 56 HRC

Standard Lengths

835 and 415 mm

Segment Length

As shown on above drawing

NARZĘDZIA STANDARDOWE

Material

C45, C55, 40H lub 40HM

Część robocza hartowana

54 - 56 HRC

Długość Standardowa

835 i 415 mm

Narzędzia segmentowe

Jak na powyższym rysunku

| S _{mm} | 42 kg / mm ² | | | | | | | | | | | | | | | | 30° B x 1.6 R = 20 kg/mm ² r x 0.8 | 60° B x 1.1 R = 42 kg/mm ² r x 1 | 120° B x 0.9 R = 70 kg/mm ² r x 1.4 | | | | |
|-----------------|-------------------------|-----|-----|----|-----|-----|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|---|--|-------|-----|-----|---|
| | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | 32 | 40 | 50 | 63 | 80 | 100 | 125 | | | | 160 | 200 | 250 | V |
| | 0.5 | 0.7 | 0.8 | 1 | 1.3 | 1.5 | 2 | 2.5 | 3.2 | 4.4 | 5 | 6.5 | 8 | 10 | 12 | 15 | | | | 20 | 25 | 37 | B |
| 0.6 | 6 | 5 | 3 | 2 | | | | | | | | | | | | | | | | | | | |
| 0.8 | 12 | 9 | 7 | 5 | 4 | | | | | | | | | | | | | | | | | | |
| 1 | | 15 | 11 | 8 | 6 | 5 | | | | | | | | | | | | | | | | | |
| 1.2 | | | 18 | 12 | 9 | 7 | 5 | | | | | | | | | | | | | | | | |
| 1.5 | | | | 21 | 15 | 12 | 8 | 6 | | | | | | | | | | | | | | | |
| 2 | | | | | 30 | 23 | 16 | 12 | 9 | | | | | | | | | | | | | | |
| 2.5 | | | | | | 39 | 27 | 20 | 14 | 11 | | | | | | | | | | | | | |
| 3 | | | | | | | 43 | 31 | 23 | 16 | 12 | | | | | | | | | | | | |
| 4 | | | | | | | | 60 | 44 | 32 | 23 | 18 | | | | | | | | | | | |
| 5 | | | | | | | | | 76 | 54 | 39 | 29 | 22 | | | | | | | | | | |
| 6 | | | | | | | | | | 85 | 62 | 45 | 33 | 25 | | | | | | | | | |
| 8 | | | | | | | | | | | 121 | 88 | 70 | 46 | 35 | | | | | | | | |
| 10 | | | | | | | | | | | | 151 | 109 | 79 | 58 | 44 | | | | | | | |
| 12 | | | | | | | | | | | | | 173 | 124 | 91 | 66 | 50 | | | | | | |
| 15 | | | | | | | | | | | | | | 213 | 155 | 113 | 81 | 62 | | | | | |
| 20 | | | | | | | | | | | | | | | 302 | 220 | 158 | 115 | 89 | | | | |
| 25 | | | | | | | | | | | | | | | | 378 | 269 | 197 | 144 | F T/m | | | |

| S _{mm} | 70 kg / mm ² | | | | | | | | | | | | | | | | 30° B x 1.6 R = 20 kg/mm ² r x 0.8 | 60° B x 1.1 R = 42 kg/mm ² r x 1 | 120° B x 0.9 R = 70 kg/mm ² r x 1.4 | | | | |
|-----------------|-------------------------|-----|-----|----|-----|-----|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|---|--|-------|-----|-----|---|
| | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | 32 | 40 | 50 | 63 | 80 | 100 | 125 | | | | 160 | 200 | 250 | V |
| | 0.5 | 0.7 | 0.8 | 1 | 1.3 | 1.5 | 2 | 2.5 | 3.2 | 4.4 | 5 | 6.5 | 8 | 10 | 12 | 15 | | | | 20 | 25 | 37 | B |
| 0.6 | 10 | 8 | 6 | 4 | | | | | | | | | | | | | | | | | | | |
| 0.8 | 20 | 15 | 12 | 8 | 6 | | | | | | | | | | | | | | | | | | |
| 1 | | 25 | 19 | 13 | 10 | 8 | | | | | | | | | | | | | | | | | |
| 1.2 | | | 30 | 21 | 15 | 12 | 8 | | | | | | | | | | | | | | | | |
| 1.5 | | | | 35 | 26 | 20 | 13 | 10 | | | | | | | | | | | | | | | |
| 2 | | | | | 50 | 38 | 26 | 19 | 15 | | | | | | | | | | | | | | |
| 2.5 | | | | | | 66 | 45 | 33 | 24 | 18 | | | | | | | | | | | | | |
| 3 | | | | | | | 71 | 52 | 38 | 27 | 21 | | | | | | | | | | | | |
| 4 | | | | | | | | 101 | 73 | 53 | 38 | 30 | | | | | | | | | | | |
| 5 | | | | | | | | | 126 | 90 | 66 | 48 | 37 | | | | | | | | | | |
| 6 | | | | | | | | | | 142 | 103 | 76 | 55 | 42 | | | | | | | | | |
| 8 | | | | | | | | | | | 202 | 147 | 117 | 77 | 59 | | | | | | | | |
| 10 | | | | | | | | | | | | 252 | 182 | 131 | 96 | 74 | | | | | | | |
| 12 | | | | | | | | | | | | | 288 | 207 | 151 | 110 | 83 | | | | | | |
| 15 | | | | | | | | | | | | | | 354 | 258 | 189 | 135 | 104 | | | | | |
| 20 | | | | | | | | | | | | | | | 504 | 367 | 263 | 192 | 148 | | | | |
| 25 | | | | | | | | | | | | | | | | 603 | 448 | 328 | 240 | F T/m | | | |

SALE

Delivery term:

2 to 4 weeks from the date of order placing. Delivery date can be changed due to lack of materials on stock.

Ordering:

[S] PUNCH:

S - tool description / angle / radius or phase / length

example: S6010 / 88° / R 0,8 / 835

[M] DIE:

M - tool description / angle / length

example: M4009 / 85° / 835

[MM] DIE HOLDER:

MM - tool description / length

example: MM5011 / 835

SPRZEDAŻ

Termin wykonania :

Od 2 do 4 tygodni od daty złożenia zamówienia. Termin może ulec wydłużeniu w przypadku braku materiałów w magazynie.

Sposób zamawiania:

[S] STEMPEL:

S - oznaczenie narzędzi / kąt / promień lub faza / długość

przykładowa kombinacja: S6010 / 88° / R 0,8 / 835

[M] MATRYCA:

M - oznaczenie narzędzi / kąt / długość

przykładowa kombinacja: M4009 / 85° / 835

[MM] MOCOWANIE MATRYCY:

MM - oznaczenie narzędzi / długość

przykładowa kombinacja: MM5011 / 835

BRAKE
PRESS
DRESS
DRESS
NARZĘDZIA
PRAS
KRAWĘDZIOWYCH

TOOLING
DRESSING
DRESSING

