

**Utillaje de plegadora
tipo BEYELER/AJIAL/LVD**



SUPRAFORM, S.L.

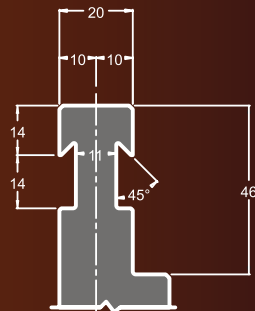
MAS QUE UTILES

Punzoni - Punches - Stempel (System Beyeler)



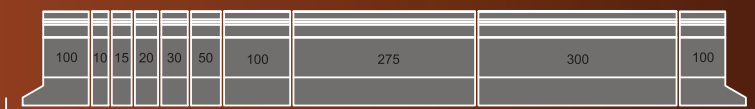
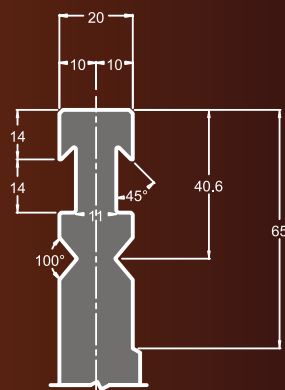
- Il nuovo processo di tempra profonda a CNC, è oggi disponibile con profondità minima di 4mm e durezza fino a 58HRC.
- The new CNC-Deeaphardening process, it is now able to consistently harden to Rockwell 58C at depth of 4mm.
- CNC-Deeaphardening ist ein Härtingsverfahren das neulich von Toolspress worden ist für Anwendung bei Abkantwerkzeugen.

Beyeler R

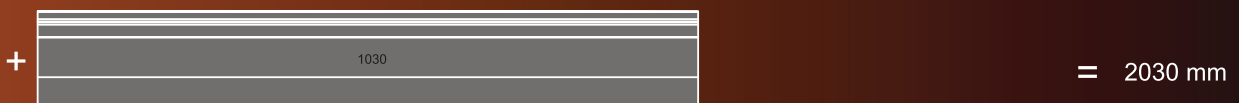


Acciaio 42CrMo4 bonificato a 23-28 Hrc
42CrMo4 Steel Hard. & Temp. to Hrc 23-28
42CrMo4 Stahl Vergutet auf Hrc 23-28

Beyeler RFA

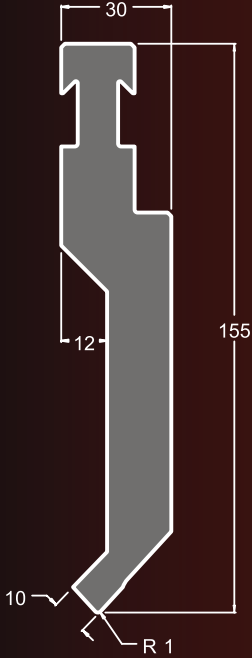


Basic segment 1000 mm

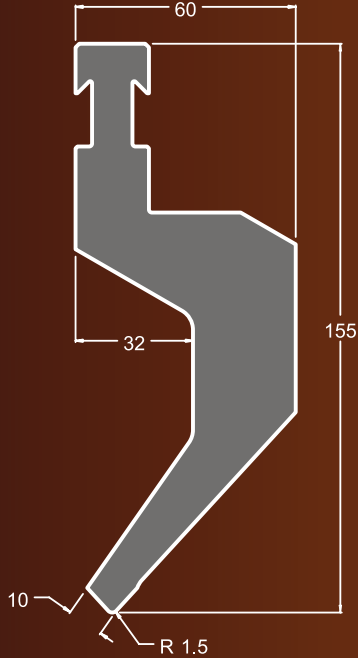


Punzoni - Punches - Stempel (System Beyeler)

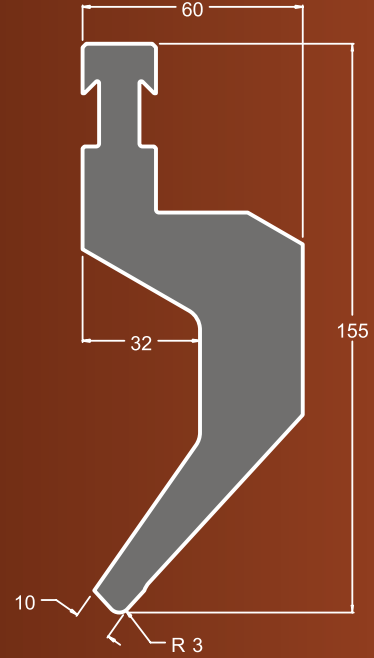
P2R. 88°
P2R. 85° max F kN/m
1300



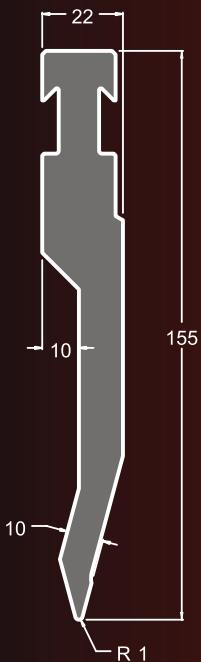
P4R. 88°
P4R. 85° max F kN/m
900



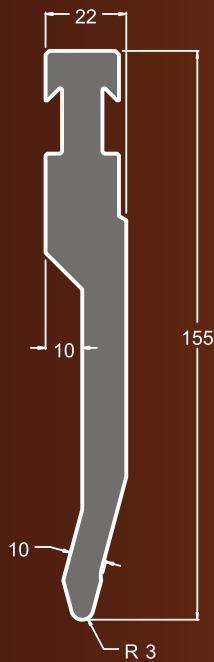
P4R. 88°
P4R. 85° max F kN/m
900



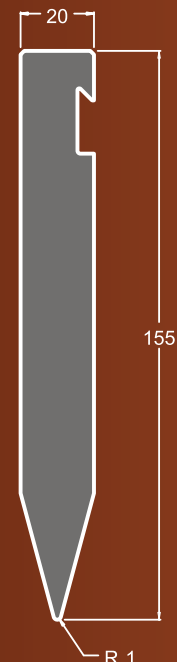
P5R. 30° max F kN/m
1000



P5R. 30° max F kN/m
1000

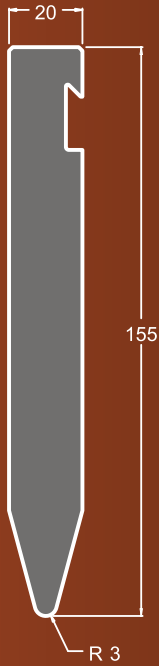


P6R. 30° max F kN/m
1600

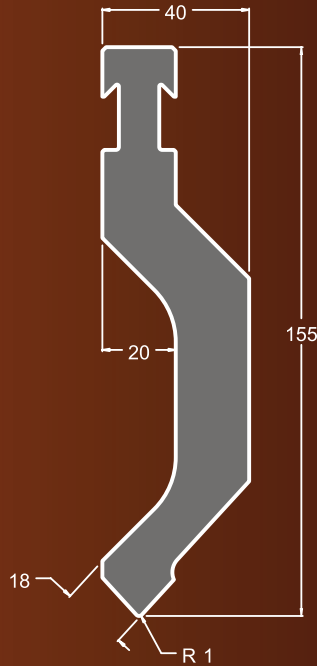


Punzoni - Punches - Stempel (System Beyeler)

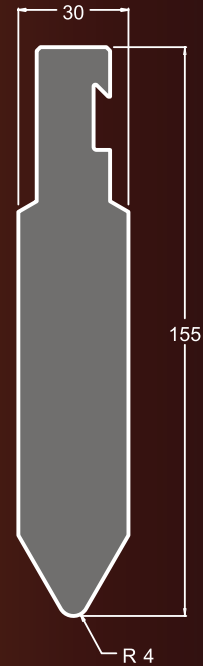
P7R. 30° max F kN/m
1600



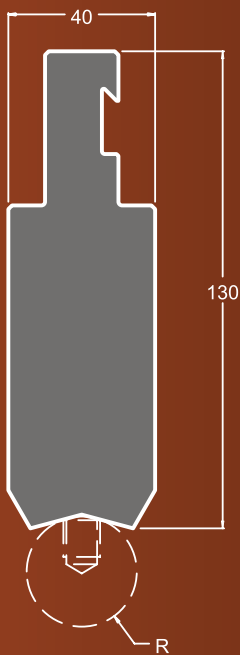
P8R. 88°
P8R. 85° max F kN/m
1000



P9R. 60° max F kN/m
1600

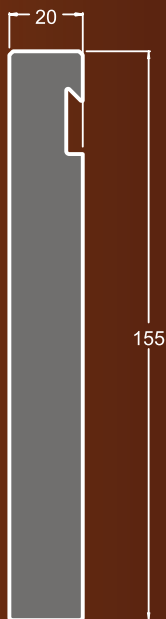


P10R max F kN/m
1000

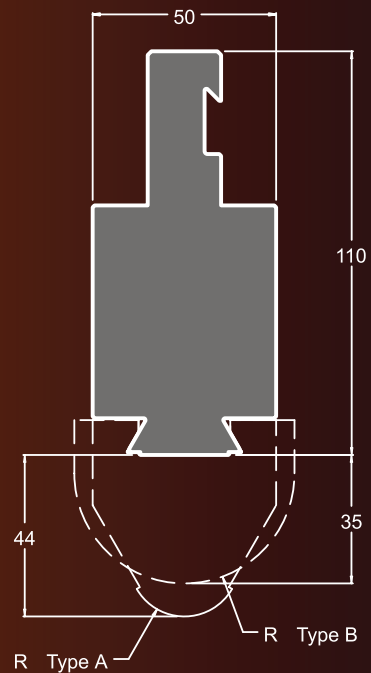


R
14
17.5
20
22.5
25
27.5
30
32.5
35
40

P11R max F kN/m
1600



P12R max F kN/m
1600



Type A

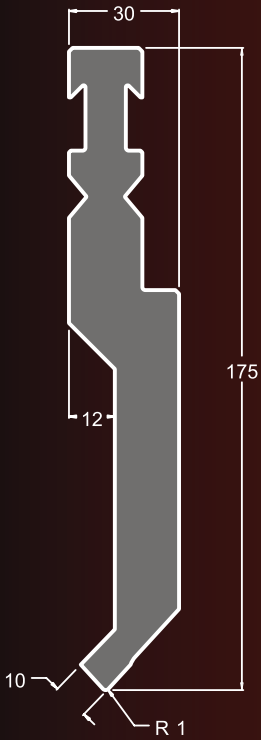
R
6
8
10
12
15
20

Type B

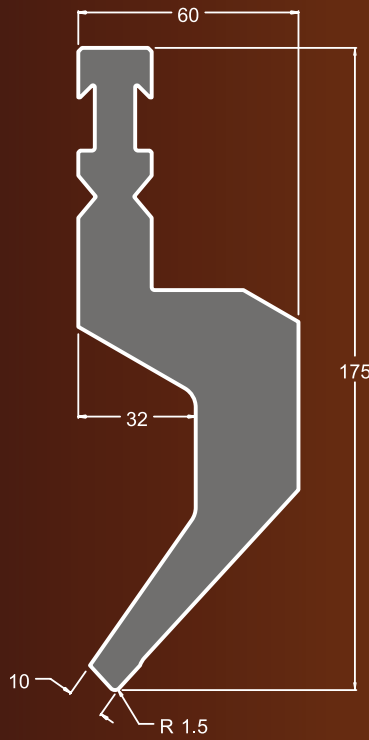
R
25
30
35

Punzoni - Punches - Stempel (System Beyeler)

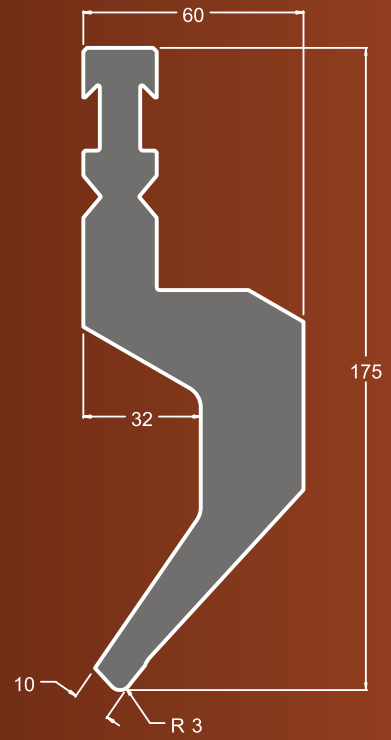
P2RFA. 88
P2RFA. 85 max F kN/m
1300



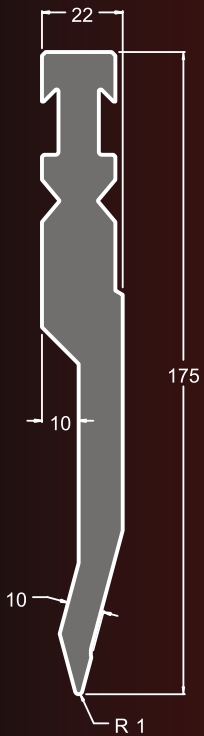
P4RFA. 85°
P4RFA. 85° max F kN/m
900



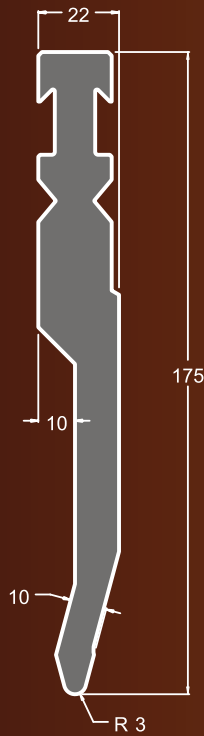
P4RFA. 85°
P4RFA. 85° max F kN/m
900



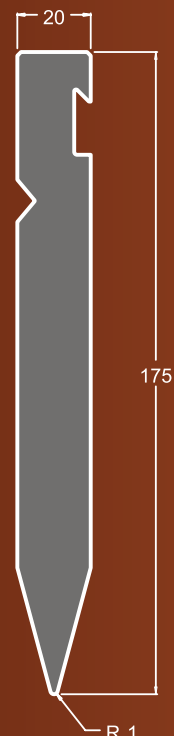
P5RFA. 30° max F kN/m
1000



P5RFA. 30° max F kN/m
1000

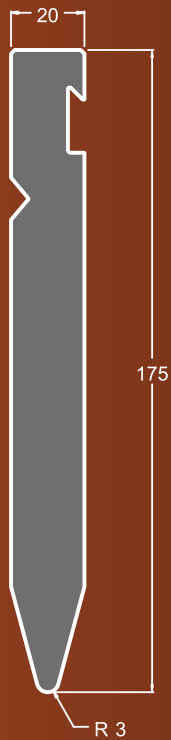


P6RFA. 30° max F kN/m
1600

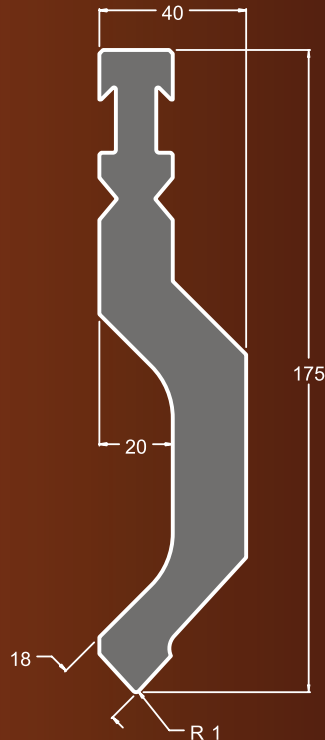


Punzoni - Punches - Stempel (System Beyeler)

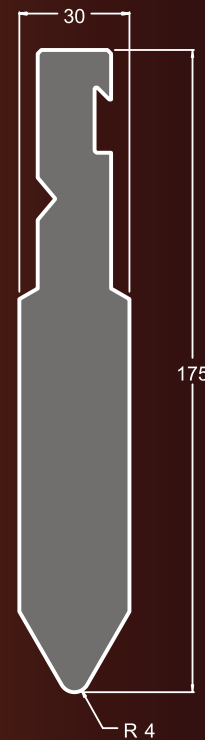
P7RFA. 30° max F kN/m
1600



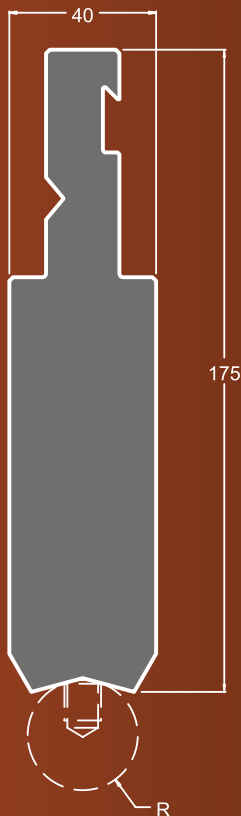
P8RFA. 88°
P8RFA. 85° max F kN/m
1000



P9RFA. 60° max F kN/m
1600

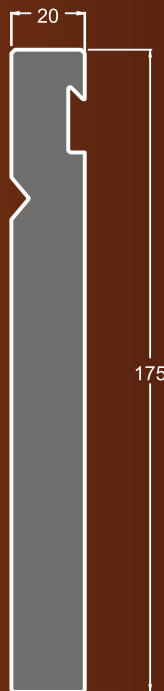


P10RFA max F kN/m
1000

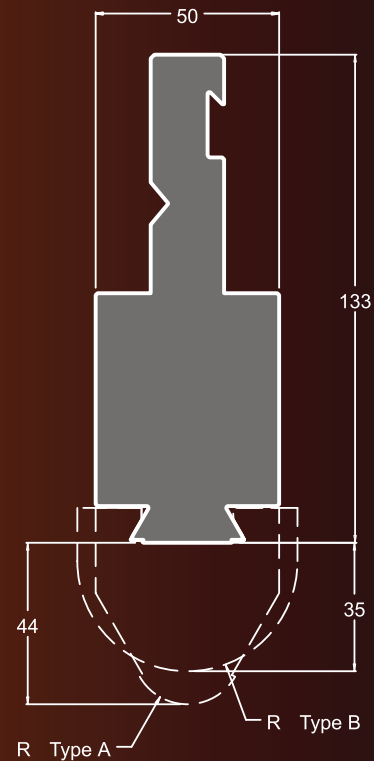


R
14
17.5
20
22.5
25
27.5
30
32.5
35
40

P11RFA max F kN/m
1600



P12RFA max F kN/m
1600



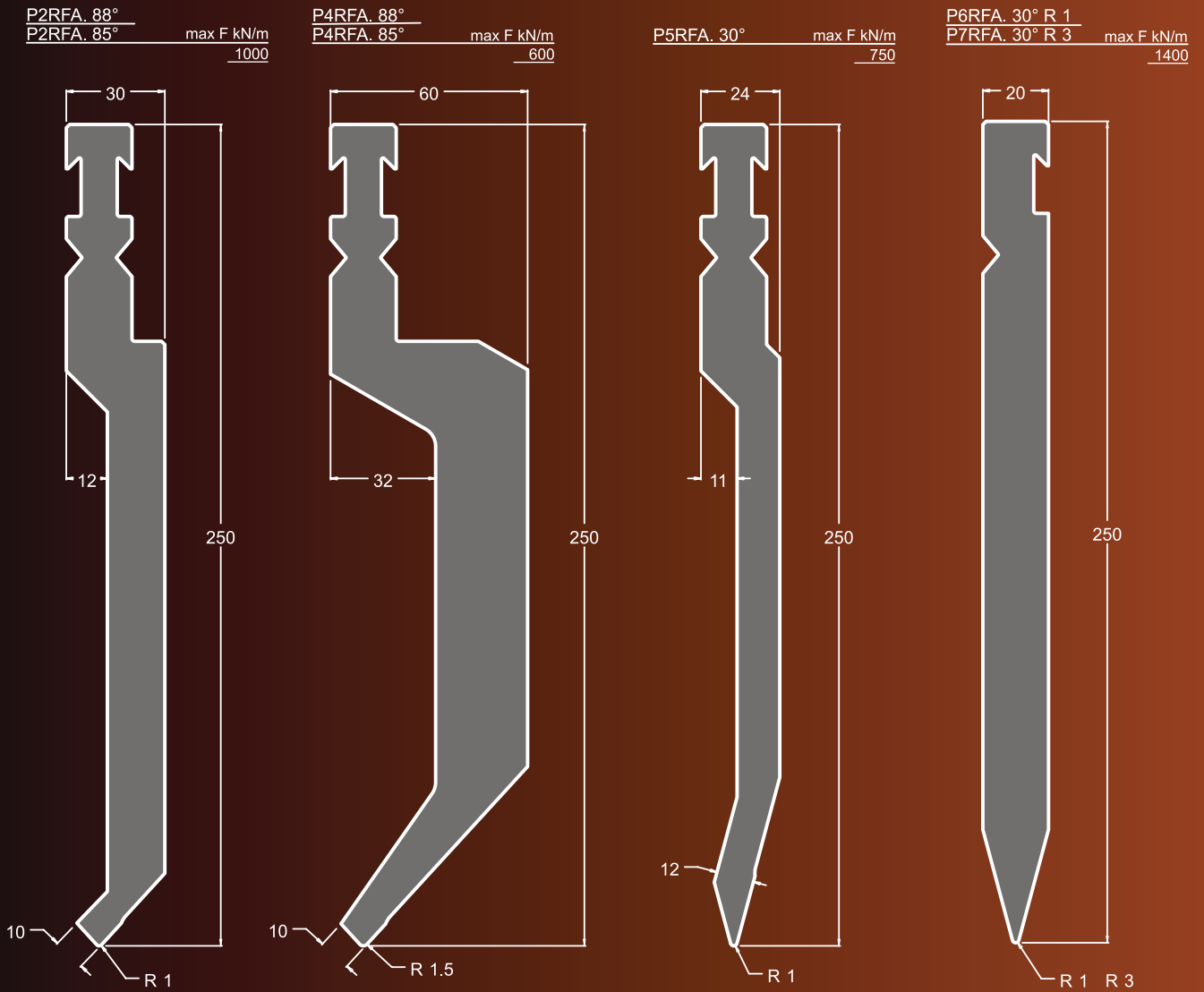
Type A

R
6
8
10
12
15
20

Type B

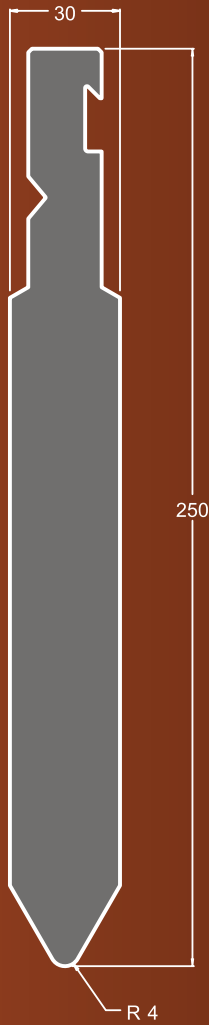
R
25
30
35

Punzoni - Punches - Stempel (System Beyeler)

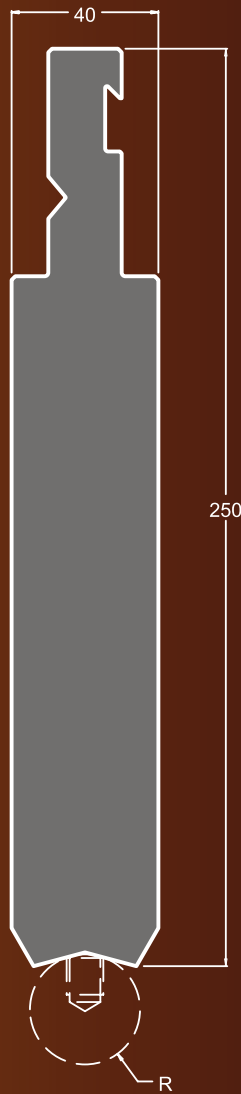


Punzoni - Punches - Stempel (System Beyeler)

P9RFA. 30° max F kN/m
1600

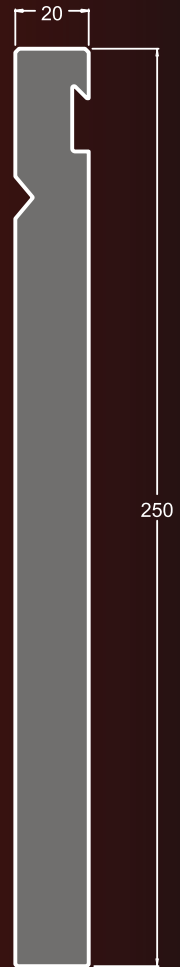


P10RFA max F kN/m
1000



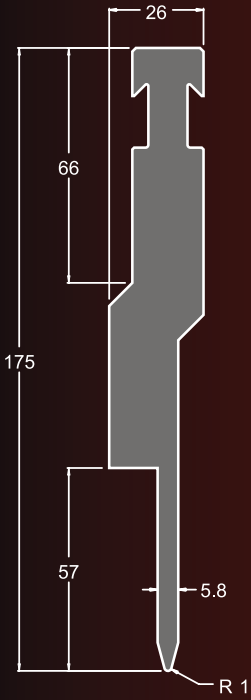
R
14
17.5
20
22.5
25
27.5
30
32.5
35
40

P11RFA max F kN/m
1600

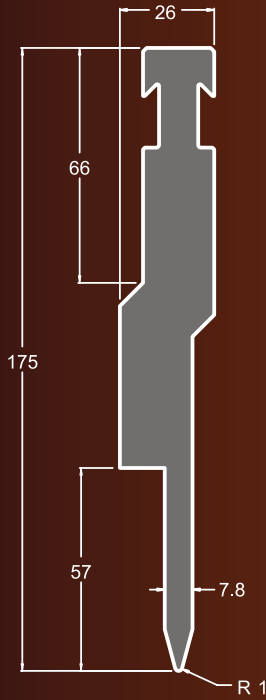


Punzoni - Punches - Stempel (System Beyeler)

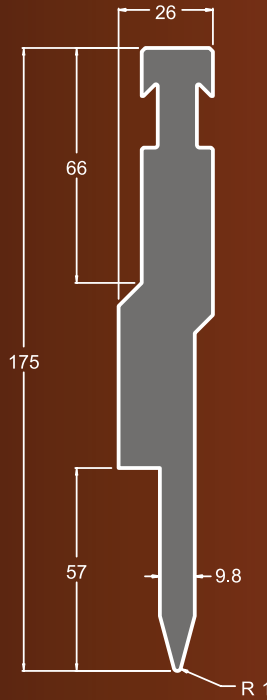
PV906R. 30°
PV906RFA. 30° max F kN/m
600



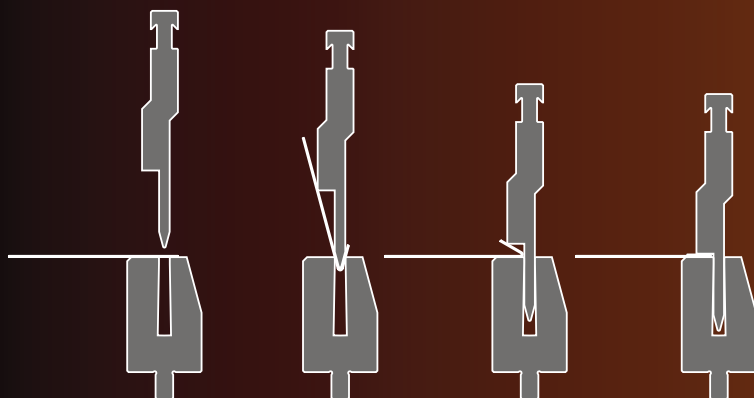
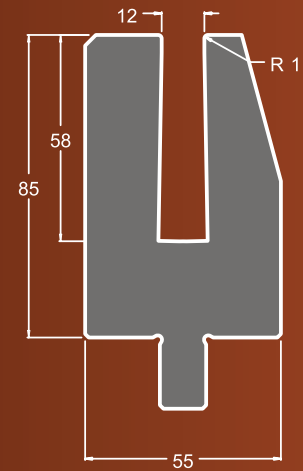
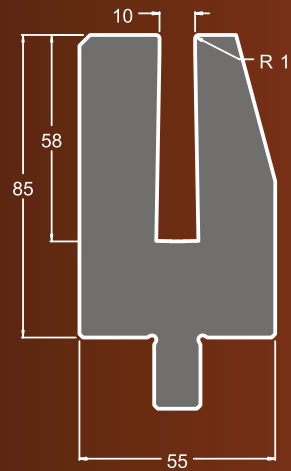
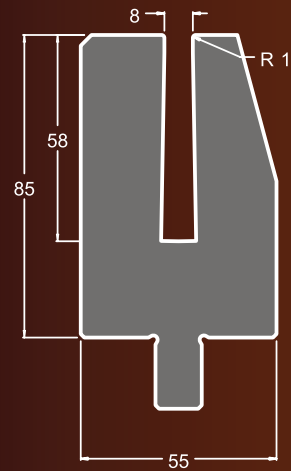
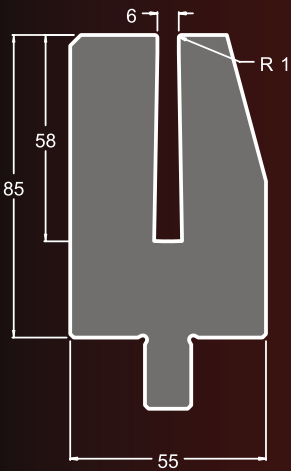
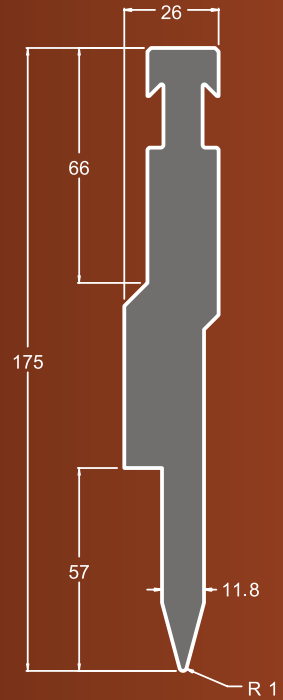
PV908R. 30°
PV908RFA. 30° max F kN/m
600



PV910R. 30°
PV910RFA. 30° max F kN/m
600

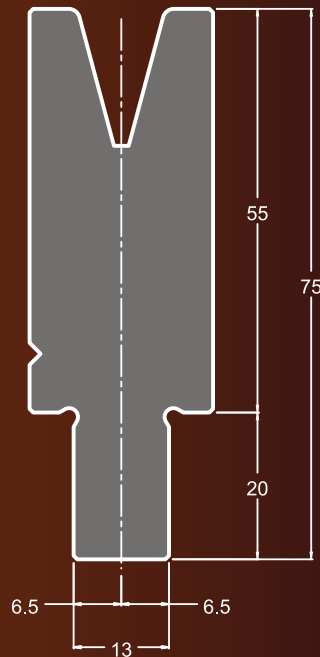


PV912R. 30°
PV912RFA. 30° max F kN/m
600



S	t/m	C	t/m	D
0.6	9	3.0	32	1.2
0.8	13	3.0	34	1.6
1.0	15	3.5	36	2.0
1.2	18	3.5	46	2.4
1.6	24	3.5	48	3.2
2.0	42	4.5	52	4.0

Matrici - Dies - Matrizen (System Beyeler)



Acciaio 42CrMo4 bonificato a 23-28 Hrc
 42CrMo4 Steel Hard. & Temp. to Hrc 23-28
 42CrMo4 Stahl Vergütet auf Hrc 23-28

- Il nuovo processo di tempra profonda a CNC, è oggi disponibile con profondità minima di 4mm e durezza fino a 58HRC.
- The new CNC-Dee-phardening process, it is now able to consistently harden to Rockwell 58C at depth of 4mm.
- CNC-Dee-phardening ist ein Härtingsverfahren das neulich von Toolspres worden ist für Anwendung bei Abkantwerkzeugen.

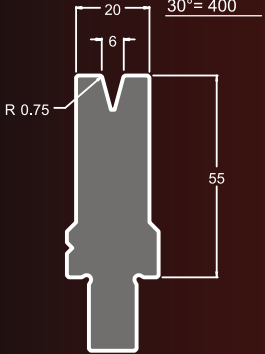


Basic segment 1000 mm

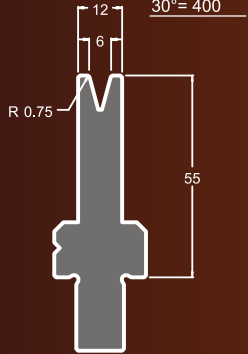


Matrici - Dies - Matrizen (System Beyeler)

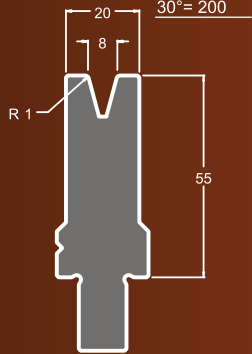
M6. 30° max F kN/m
 90°= 900
 60°= 600
 30°= 400



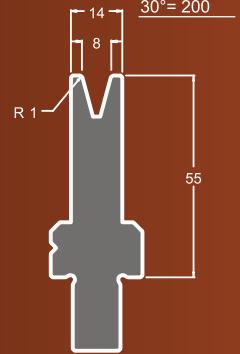
M6S. 30° max F kN/m
 90°= 900
 60°= 600
 30°= 400



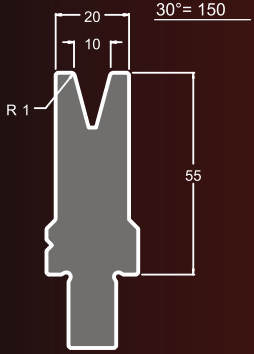
M8. 30° max F kN/m
 90°= 800
 60°= 400
 30°= 200



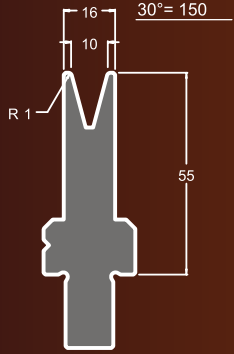
M8S. 30° max F kN/m
 90°= 800
 60°= 400
 30°= 200



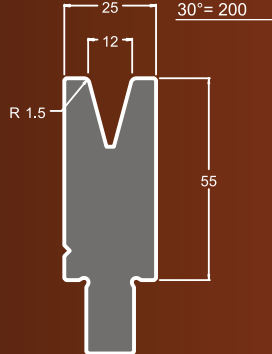
M10. 30° max F kN/m
 90°= 700
 60°= 400
 30°= 150



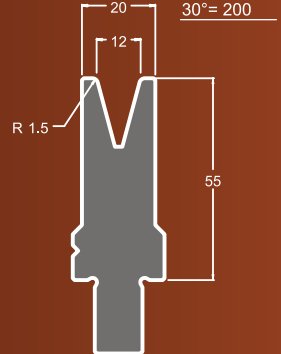
M10S. 30° max F kN/m
 90°= 700
 60°= 400
 30°= 150



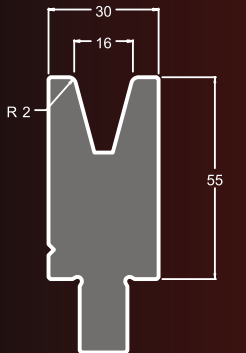
M12. 30° max F kN/m
 90°= 700
 60°= 420
 30°= 200



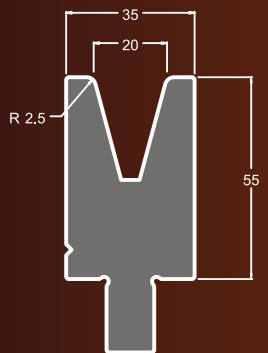
M12S. 30° max F kN/m
 90°= 700
 60°= 420
 30°= 200



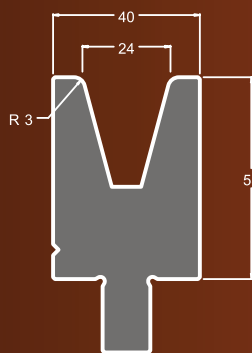
M16. 30° max F kN/m
 90°= 900
 60°= 550
 30°= 200



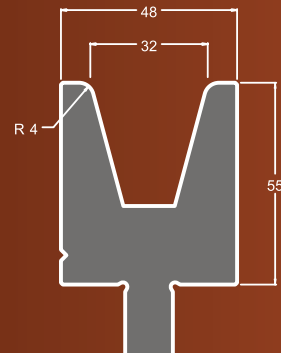
M20. 30° max F kN/m
 90°= 950
 60°= 600
 30°= 200



M24. 30° max F kN/m
 90°= 1000
 60°= 600
 30°= 200

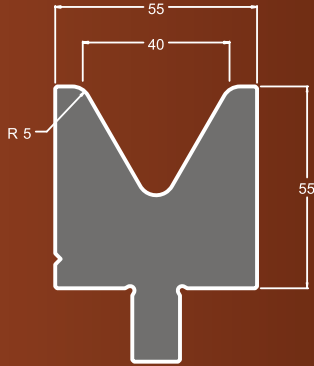


M32. 30° max F kN/m
 90°= 1500
 60°= 700
 30°= 500

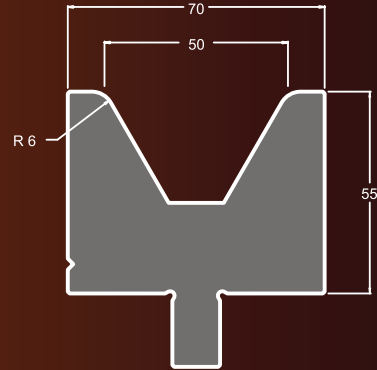


Matrici - Dies - Matrizen (System Beyeler)

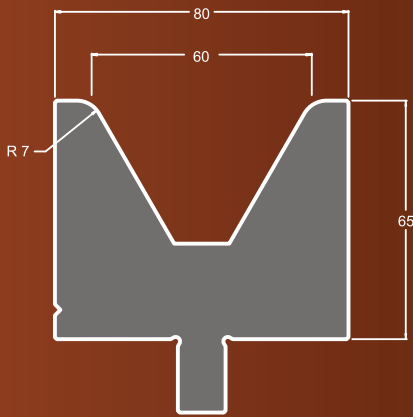
M40. 60° max F kN/m
 $\frac{90^\circ = 1600}{60^\circ = 1300}$



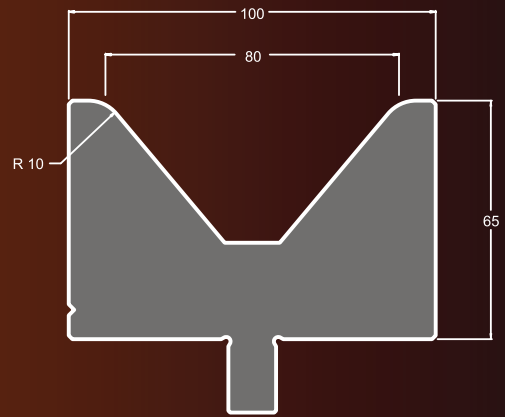
M50. 60° max F kN/m
 $\frac{90^\circ = 1700}{60^\circ = 1200}$



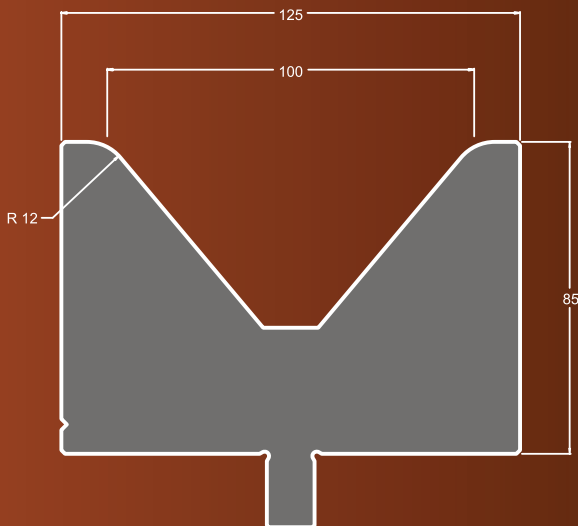
M60. 60° max F kN/m
 $\frac{90^\circ = 1800}{60^\circ = 1100}$



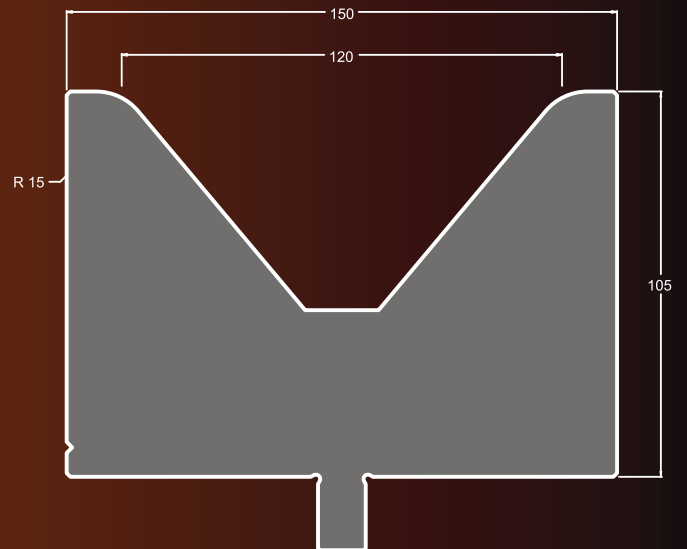
M80. 80° max F kN/m
 $\frac{90^\circ = 1700}{60^\circ = 1200}$



M100. 80° max F kN/m
 $\frac{90^\circ = 2300}{60^\circ = 1200}$

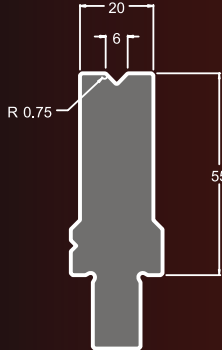


M120. 80° max F kN/m
 $\frac{90^\circ = 3000}{60^\circ = 1200}$

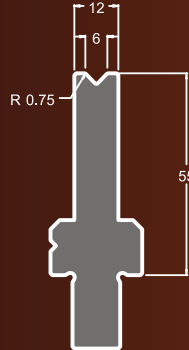


Matrici - Dies - Matrizen (System Beyeler)

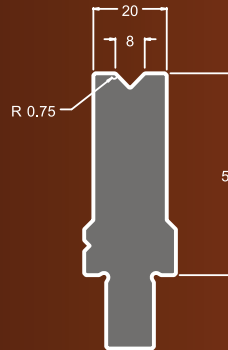
M6. 88°
M6. 85° max F kN/m
90°= 900



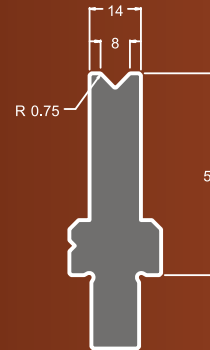
M6S. 88°
M6S. 85° max F kN/m
90°= 900



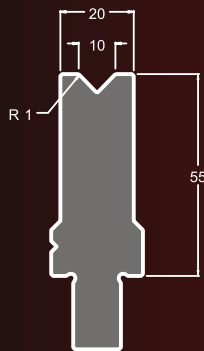
M8. 88°
M8. 85° max F kN/m
90°= 800



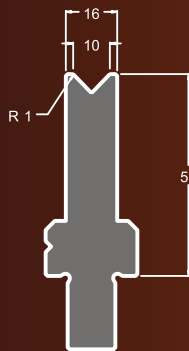
M8S. 88°
M8S. 85° max F kN/m
90°= 800



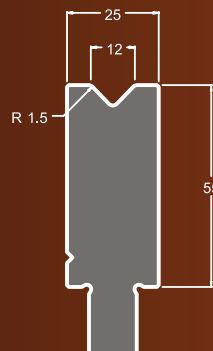
M10. 88°
M10. 85° max F kN/m
90°= 700



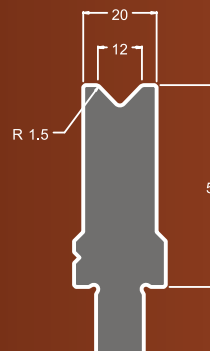
M10S. 88°
M10S. 85° max F kN/m
90°= 700



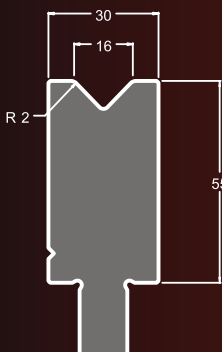
M12. 88°
M12. 85° max F kN/m
90°= 700



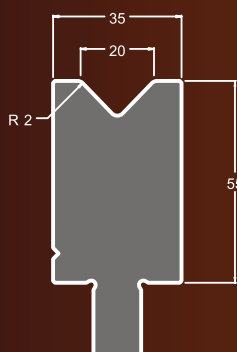
M12S. 88°
M12S. 85° max F kN/m
90°= 700



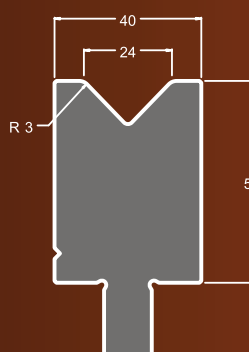
M16. 88°
M16. 85° max F kN/m
90°= 900



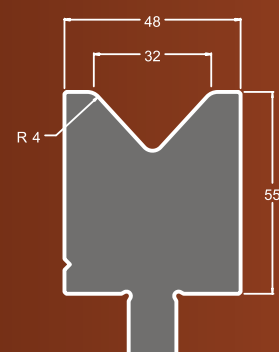
M20. 88°
M20. 85° max F kN/m
90°= 900



M24. 88°
M24. 85° max F kN/m
90°= 1000

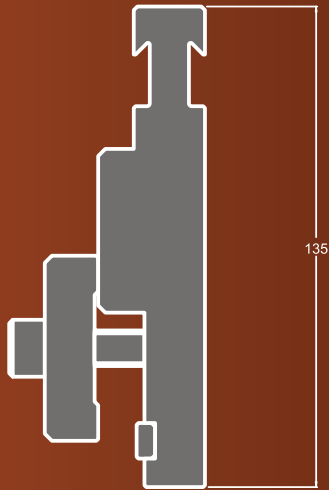


M32. 85° max F kN/m
90°= 1500

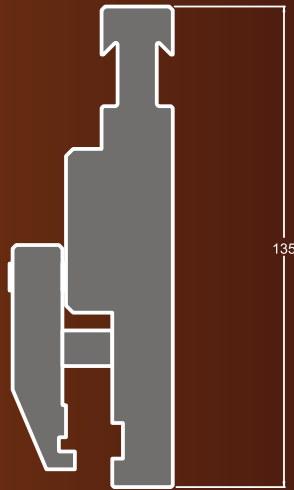


Matrici - Dies - Matrizen (System Beyeler)

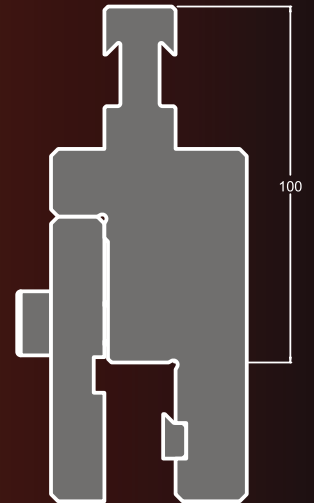
Adaptor R-Euro A



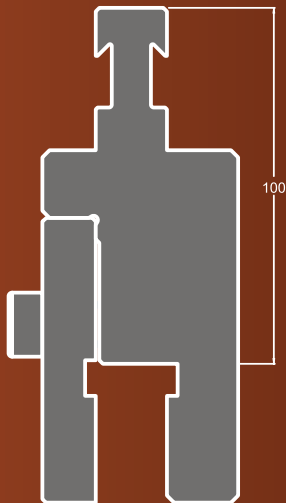
Adaptor R-EuroB



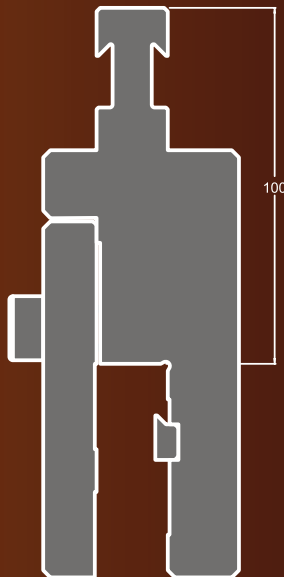
Adaptor R-R



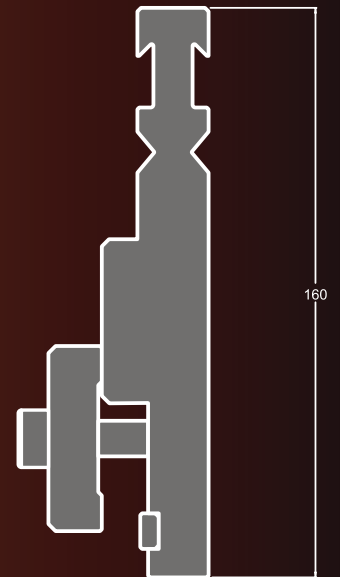
Adaptor R-S



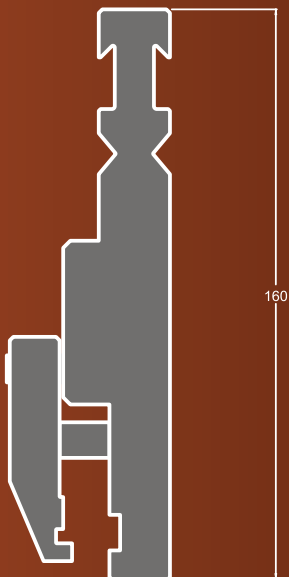
Adaptor R-RFA



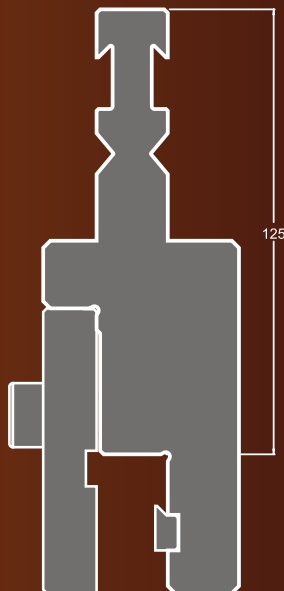
Adaptor RFA-EuroA



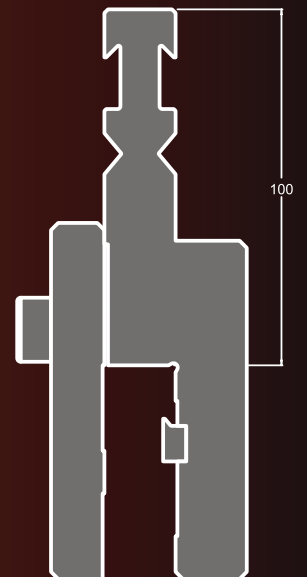
Adaptor RFA-EuroB



Adaptor RFA-R



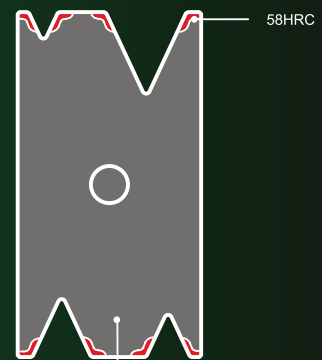
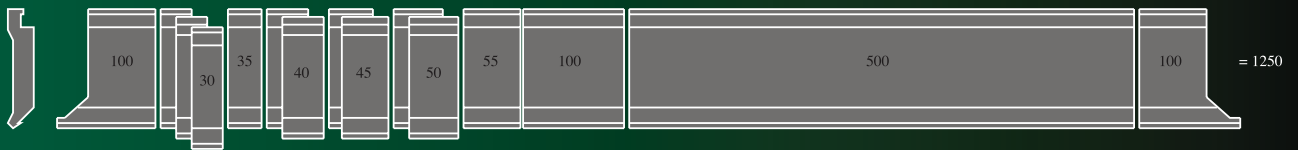
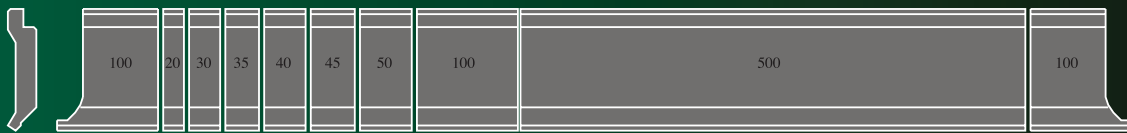
Adaptor RFA-RFA



Punzoni/Matrici - Punches/Dies - Stempel/Matrizen (System Colly)



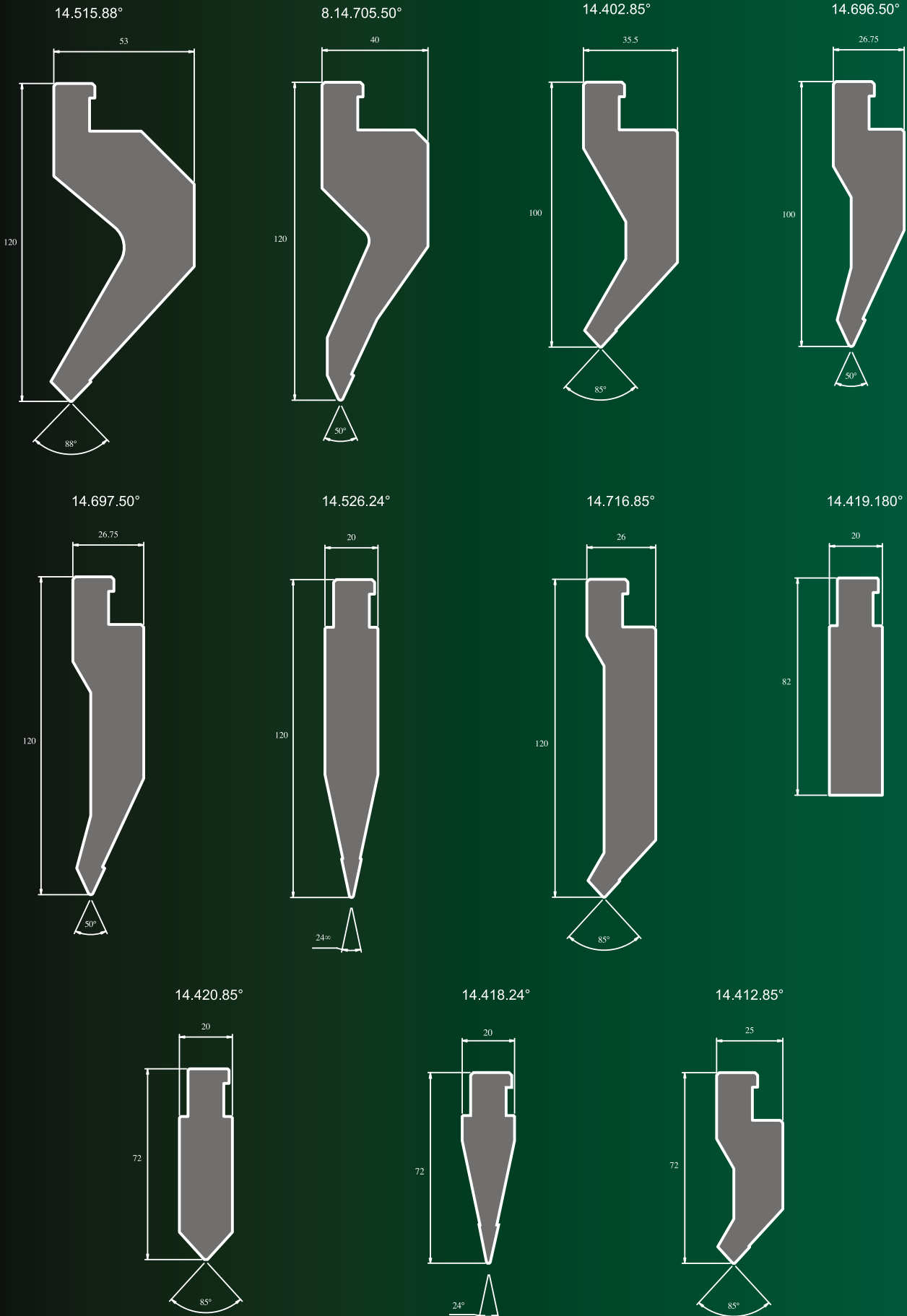
Acciaio 42CrMo4 bonificato a 23-28 Hrc
 42CrMo4 Steel Hard. & Temp. to Hrc 23-28
 42CrMo4 Stahl Vergütet auf Hrc 23-28



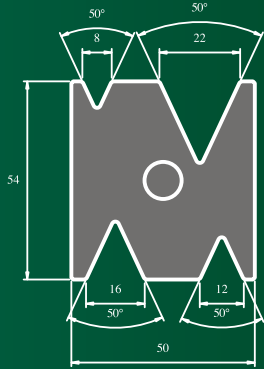
Acciaio 42CrMo4 bonificato a 23-28 Hrc
 42CrMo4 Steel Hard. & Temp. to Hrc 23-28
 42CrMo4 Stahl Vergütet auf Hrc 23-28

- Il nuovo processo di tempra profonda a CNC, è oggi disponibile con profondità minima di 4mm e durezza fino a 58HRC.
- The new CNC-Deephardening process, it is now able to consistently harden to Rockwell 58C at depth of 4mm.
- CNC-Deephardening ist ein Härtingsverfahren das neulich von Toolspress worden ist für Anwendung bei Abkantwerkzeugen.

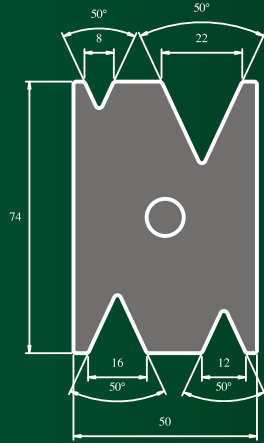
Punzoni - Punches - Stempel (System Colly)



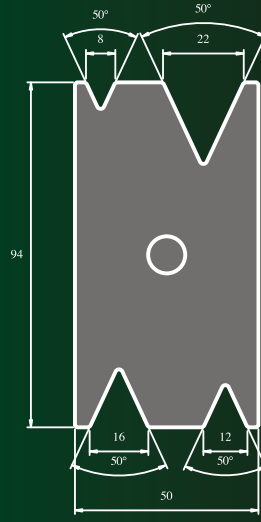
Matrici - Dies - Matrizen (System Colly)



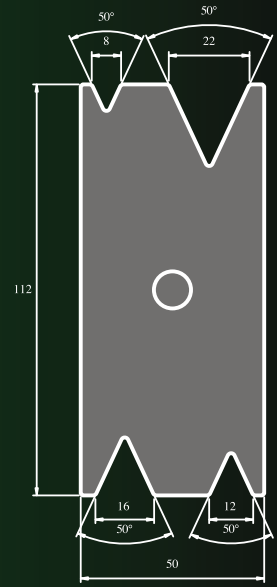
6.14.767



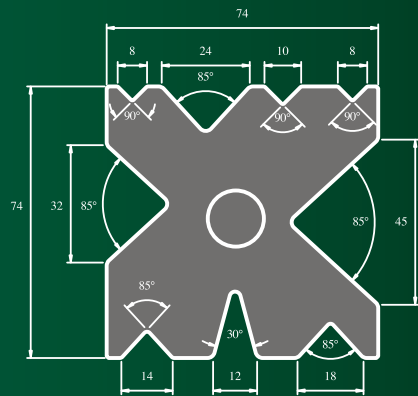
6.14.768



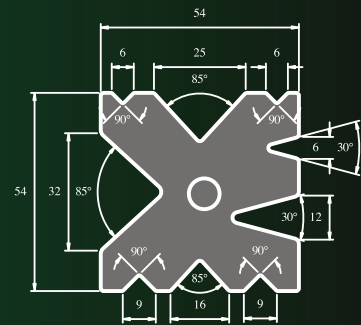
6.14.769



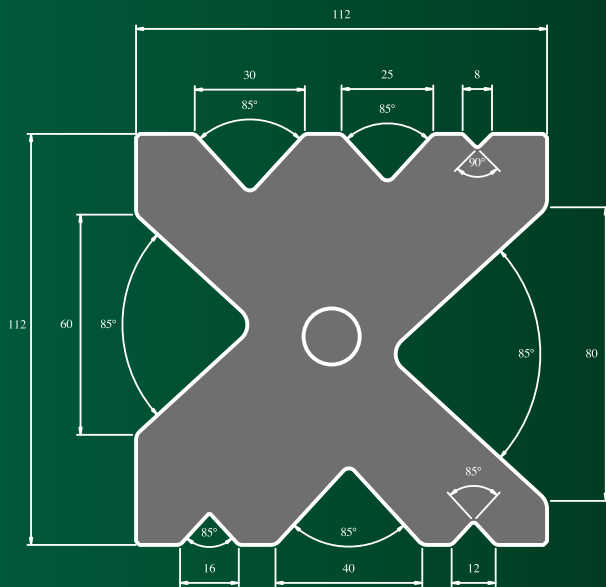
6.14.770



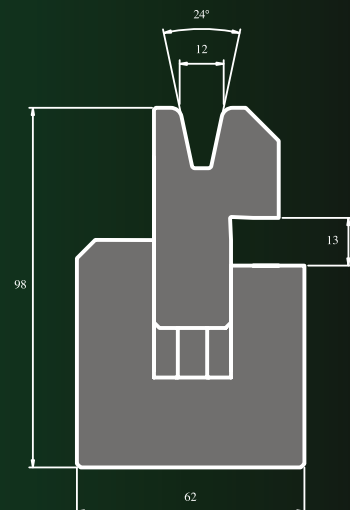
14.318



14.319



14.518

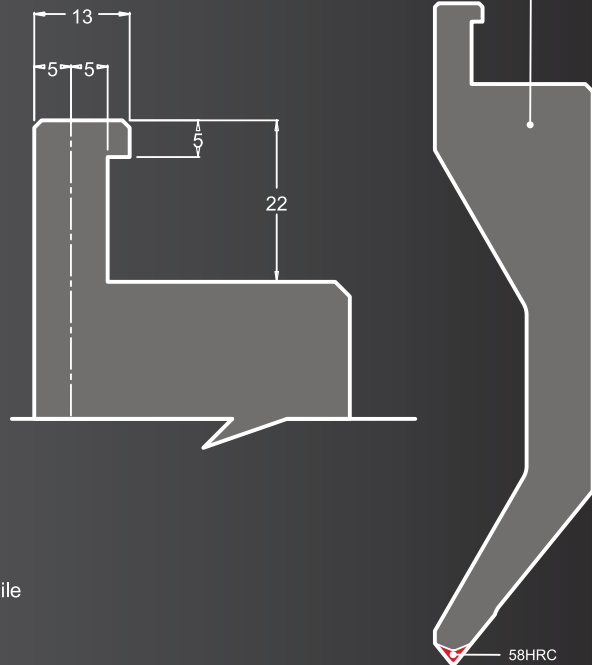


u479 v12

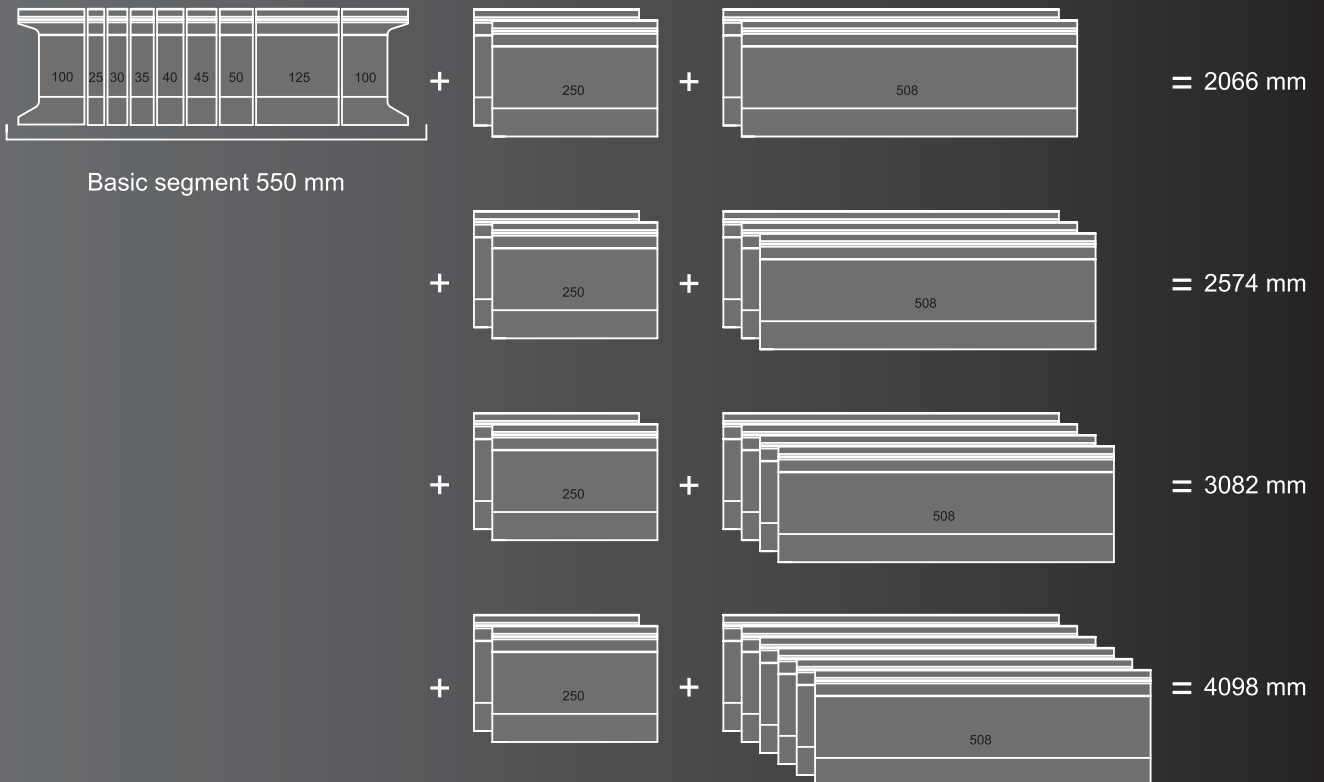
Punzoni - Punches - Stempel (System LVD)



Acciaio 42CrMo4 bonificato a 23-28 Hrc
 42CrMo4 Steel Hard. & Temp. to Hrc 23-28
 42CrMo4 Stahl Vergütet auf Hrc 23-28

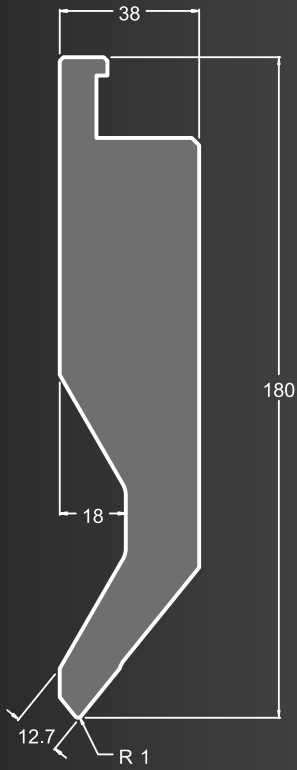


- Il nuovo processo di tempra profonda a CNC, è oggi disponibile con profondità minima di 4mm e durezza fino a 58HRC.
- The new CNC-Dee-phardening process, it is now able to consistently harden to Rockwell 58C at depth of 4mm.
- CNC-Dee-phardening ist ein Härtingsverfahren das neulich von Toolspres worden ist für Anwendung bei Abkantwerkzeugen.

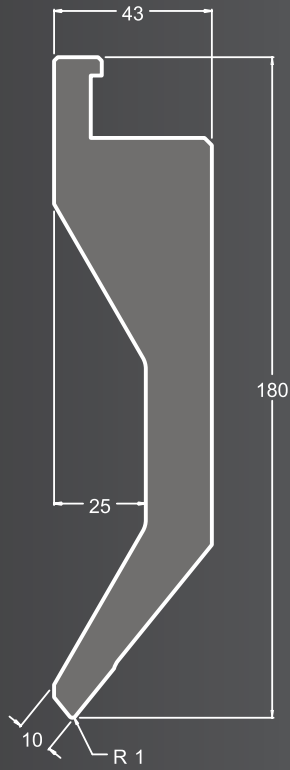


Punzoni - Punches - Stempel (System LVD)

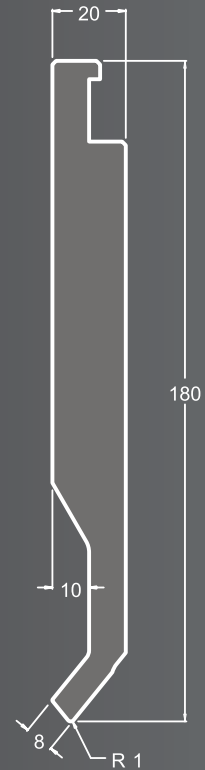
LPC. 78° max F kN/m
700



LPD. 78° max F kN/m
450



LPE. 78° max F kN/m
400



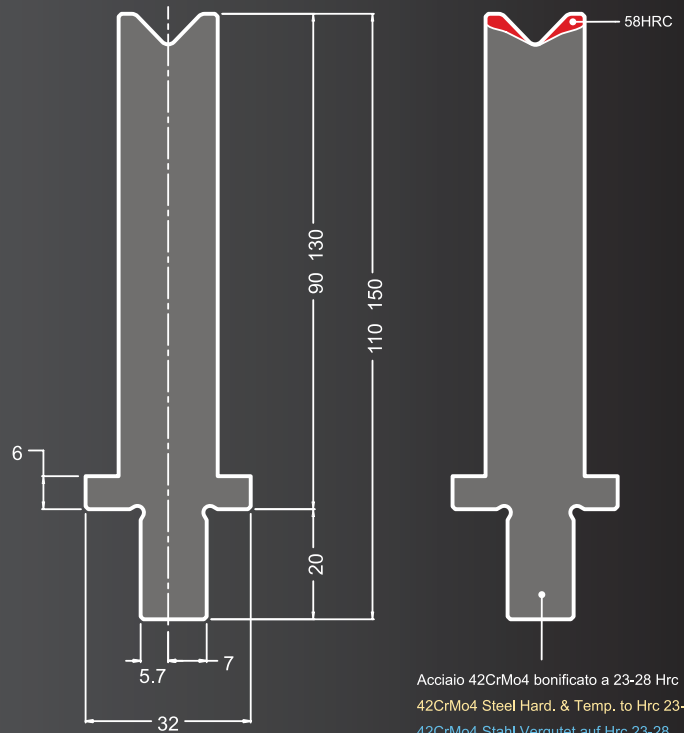
LPF. 26° max F kN/m
500



LPR. 78° max F kN/m
1000

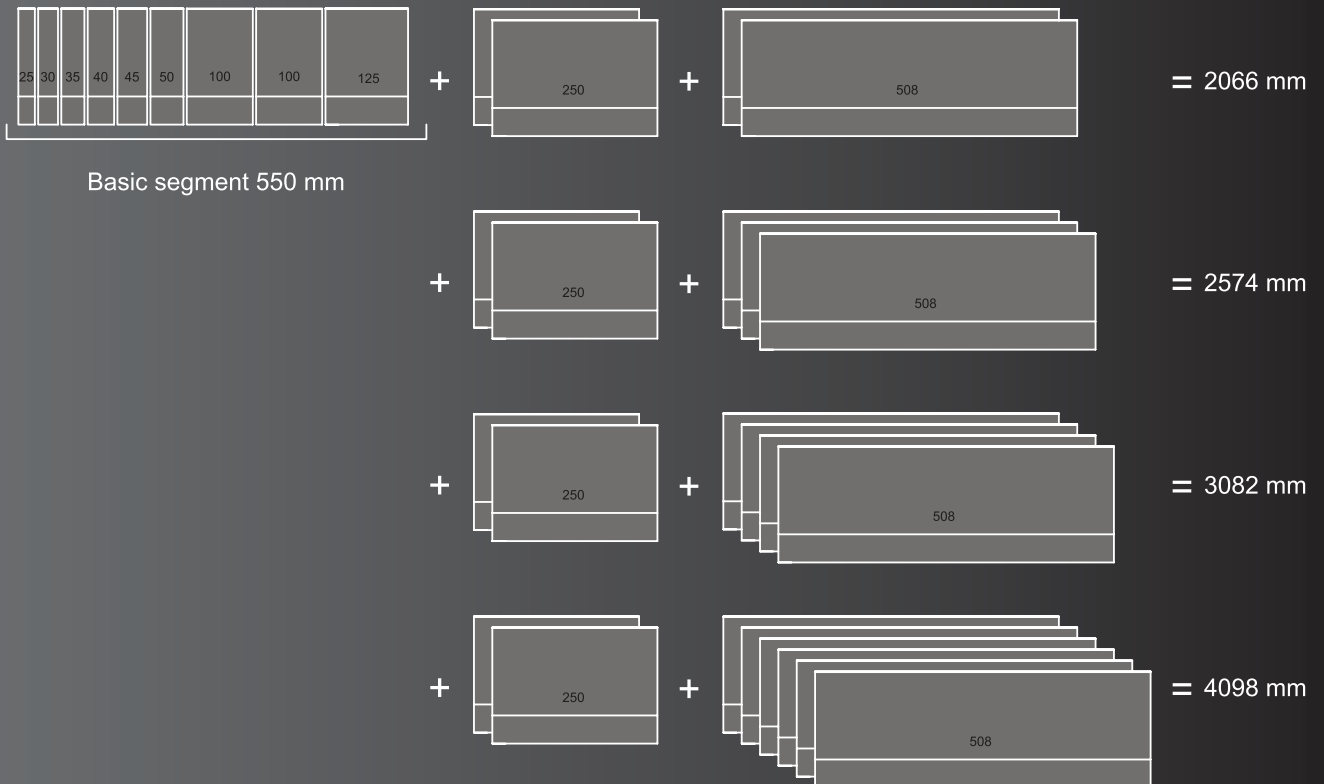


Matrici - Dies - Matrizen (System LVD)



- Il nuovo processo di tempra profonda a CNC, è oggi disponibile con profondità minima di 4mm e durezza fino a 58HRC.
- The new CNC-Deeaphardening process, it is now able to consistently harden to Rockwell 58C at depth of 4mm.
- CNC-Deeaphardening ist ein Härtingsverfahren das neulich von Toolspress worden ist für Anwendung bei Abkantwerkzeugen.

Acciaio 42CrMo4 bonificato a 23-28 Hrc
 42CrMo4 Steel Hard. & Temp. to Hrc 23-28
 42CrMo4 Stahl Vergutet auf Hrc 23-28



Matrici - Dies - Matrizen (System LVD)

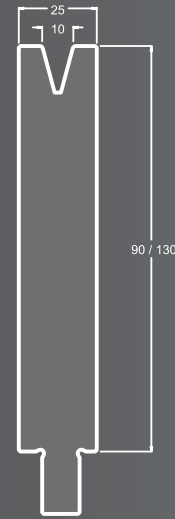
LM6. 30° max F kN/m
 90°= 800
 60°= 400
 30°= 200



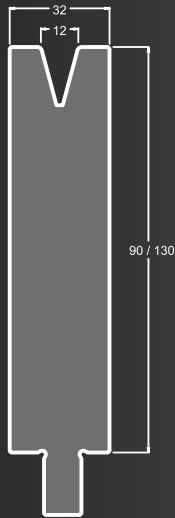
LM8. 30° max F kN/m
 90°= 800
 60°= 400
 30°= 200



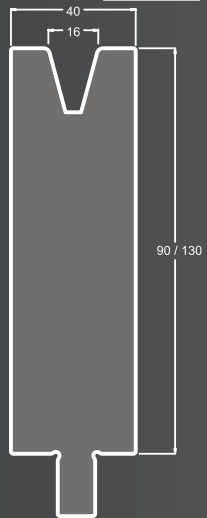
LM10. 30° max F kN/m
 90°= 850
 60°= 500
 30°= 300



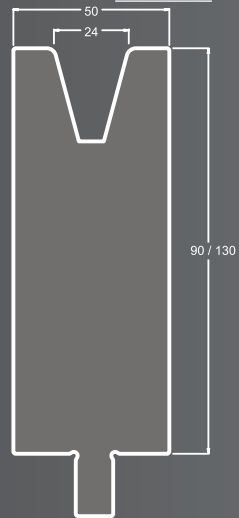
LM12. 30° max F kN/m
 90°= 900
 60°= 600
 30°= 400



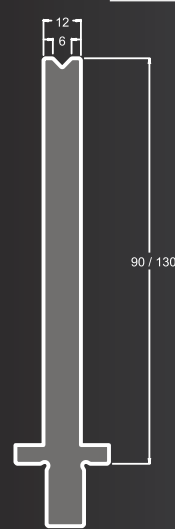
LM16. 30° max F kN/m
 90°= 900
 60°= 600
 30°= 400



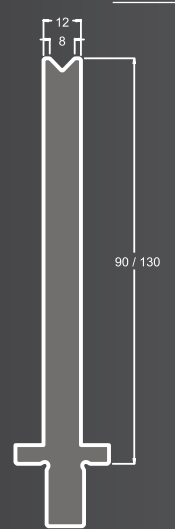
LM24. 30° max F kN/m
 90°= 1500
 60°= 700
 30°= 500



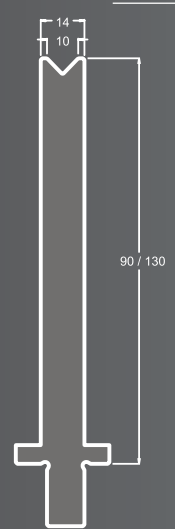
LM6. 78° max F kN/m
 90°= 400



LM8. 78° max F kN/m
 90°= 400



LM10. 78° max F kN/m
 90°= 500



Matrici - Dies - Matrizen (System LVD)

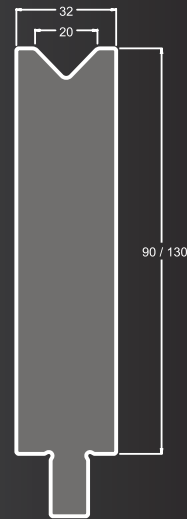
LM12. 78° max F kN/m
90°= 600



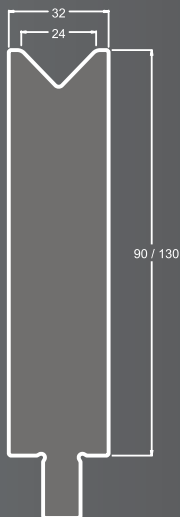
LM16. 78° max F kN/m
90°= 800



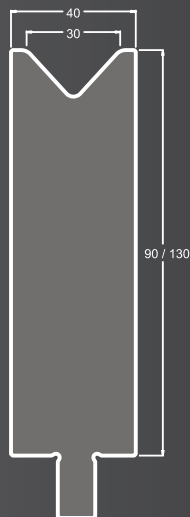
LM20. 78° max F kN/m
90°= 1000



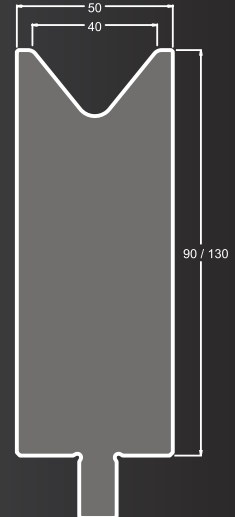
LM24. 78° max F kN/m
90°= 1000



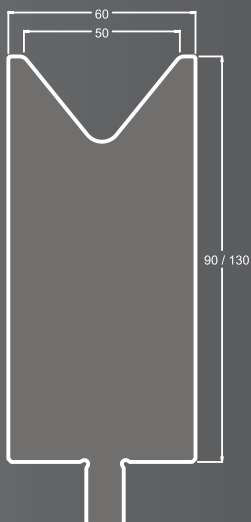
LM30. 78° max F kN/m
90°= 1100



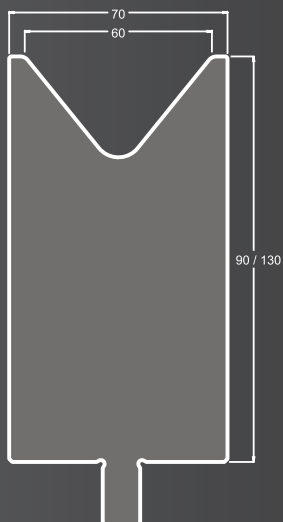
LM40. 78° max F kN/m
90°= 1300



LM50. 78° max F kN/m
90°= 1500



LM60. 78° max F kN/m
90°= 1500



LM70. 78° max F kN/m
90°= 1500

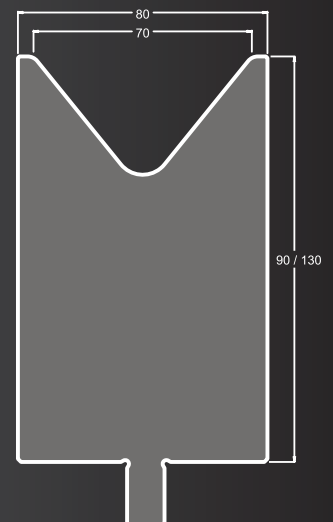


TABELLA DI PIEGATURA IN ARIA

AIR BENDING FORCE CHART

PRESSKRAFTTABELLE

S	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	320	400	500	630	V	
Spessore mm	4	5,5	7	8,5	11	14	17,5	22	28	35	45	55	71	89	113	140	175	226	280	350	450	630	B
	1	1,3	1,6	2	2,6	3,3	4	5	6,5	8	10	13	16	20	26	33	41	53	65	83	100	100	Ri
0,6	4	4																					
0,8	7	5	4																				
1	11	8	7	6																			
1,2	16	12	10	8	6																		
1,5		17	15	13	9	8																	
2			27	22	17	13	11																
2,5				35	26	21	17	13															
3					38	30	24	19	15														
4						54	42	34	27	21													
5							67	52	42	33	26												
6								75	60	48	38	30											
8									107	85	68	53	43										
10										134	105	85	67	53									
12												120	96	78	60								
15													150	120	95	75							
20														215	170	135	108	85					
25															265	210	170	130	105				
30																300	240	190	150	120			
40																	430	340	270	215			
50																		525	420	340	270		t/m

La tabella di piegatura qui sopra raffigurata e basata su acciaio medio con resistenza di 45-50 chilogrammi per millimetro quadrato. Per calcolare la forza approssimativa di piegatura richiesta per piegare altri tipi di materiale utilizzare il fattore di moltiplicazione qui sotto indicato. I valori indicati nelle tabelle sono validi per pieghe a 90°. In caso di pieghe a 30°, la capacità di Massimo carico si riduce.

The bending force (tonnage) figures listed above are based on mild steel with a tensile strength of 45/50 kilograms per square millimeter. To calculate the approximate bending force (tonnage) requirements of others materials, please use the multipliers listed. The mentioned values are valid for 90° bending. At coining with 30° degree, the max loading capacity is reduced.

Die oben angegebene Abkantkraft (Ton.) gilt für Normalstahl mit einer Zugfestigkeit von 45-50 kg/mm². Um die entsprechende Abkantkraft für andere Materialien zu berechnen, benutzen Sie bitte die angegebenen Multiplikatoren. Die angegebenen Werte sind das Biegen für 90° gültig. Beim Prägen mit 30° Matrizen ist die max. Belastbarkeit reduziert.

Formula Standard per selezionare l'apertura del "V"
 Standard formulas as for selecting a V-opening
 Standardformel zur festlegung der V-Öffnung

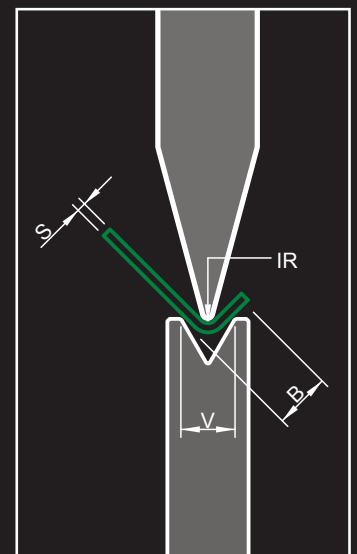
Spessore materiale (mm) Material thickness (mm) Blechedicke (mm)	0.5 - 2.5	3.0 - 8	9 - 10	12 - 30
Larghezza V V - opening V - Öffnung	S x 6	S x 8	S x 10	S x 12

S = Spessore del materiale 45Kg/m²
 F = Forza per 1 metro (Ton/Mt)
 IR= Raggio interno di piegatura (mm)
 B = Lunghezza bordo minimo (mm)
 V = Larghezza del V (mm)

Ottone dolce Soft Brass Weiches Messing	Ton x mt x 50%
Alluminio dolce Soft Aluminium Weiches Aluminium	Ton x mt x 50%
Lega di Alluminio trattato Heat Treated Aluminium Alloy Wärmebehandelte Aluminiumlegierung	Ton x mt x 150%
Acciaio Inox Stainless Steel Rostfreier Stahl	Ton x mt x 150%

S = Material thickness (45Kg/m²)
 F = Force per meter (Ton/Mt)
 IR= Inside Radius (mm)
 B = Minimum Hang lenght (mm)
 V = V - Opening (mm)

S = Blechedicke in mm:
 Zugfestigkeit ca. 45Kg/m²
 F = Enforderilche Press Kraft (Ton/Mt)
 IR= Produktinnenradius (mm)
 B = Kürzeste Schenkellänge (mm)
 V = V - Öffnung (mm)





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