



Tecnostamp



UTENSILI PER PRESSE PIEGATRICI



TOOLING FOR PRESS BRAKES



UTILLAJE PARA PLEGADORA



UTILLAJE PARA DOBRADEIRAS



OUTILS POUR PRESSE PLIEUSE



WERKZEUGE FÜR ABKANTPRESSEN



ED05

CORAL LINE

NO MARKING TOOLS

www.tecnostamp.eu



EXPERIENCE & INNOVATION



Da più di 30 anni mettiamo la nostra esperienza al servizio del cliente, progettando e producendo utensili per tutti i tipi di presse piegatrici e cesoie. I prodotti Tecnostamp vengono interamente progettati e costruiti in Italia e commercializzati in tutto il mondo; la nostra azienda offre anche un efficiente servizio post-vendita garantito dalla competenza dei nostri tecnici e dall'assistenza telefonica dell'ufficio commerciale.



For over 30 years Tecnostamp designs and produces tools for all types of press brakes and shears, offering its experience to meet customer requirements. Tecnostamp products are fully designed and produced in Italy and they are sold worldwide; our company also offers an efficient after sales service guaranteed by the experience of our technicians and by the helpline of our sales department.



De más de 30 años, empleamos nuestra experiencia al servicio del cliente, proyectando y produciendo utillajes para todo tipo de prensas plegadoras y cizalladura. Tecnostamp produce en su propia fabrica todos los productos y comercializa en todo el mundo; nuestra empresa también ofrece un servicio post-venta eficiente garantizado por la experiencia de nuestros técnicos y la asistencia telefónica de oficina comercial.



Há mais de 30 anos que colocámos a nossa experiência ao serviço do cliente, projetando e produzindo ferramentas para todos de tipos de quinadoras/dobreadeiras e fesoira. Os produtos Tecnostamp são inteiramente projetados e construídos em Itália e comercializados em todo o mundo; a nossa empresa também oferece um serviço pós-venda eficiente garantido pela experiência dos nossos técnicos e pela assistência telefónica de nosso escritório de vendas.



Depuis plus de 30 ans, nous mettons notre expérience au service de la clientèle, avec la conception et la production d'outils pour presses plieuses et cisailles. Les produits Tecnostamp sont entièrement conçus et fabriqués en Italie et vendus dans le monde; notre entreprise offre un service après-vente garanti par la compétence de nos techniciens et l'assistance téléphonique de notre bureau commercial.



Seit mehr als 30 Jahren setzt Tecnostamp seine Erfahrung in der Kundenbetreuung, Entwicklung und der Herstellung von Abkantwerkzeuge für alle Typen von Abkantpressen ein und scher. Unsere Produkte werden komplett in Italien entworfen, hergestellt und weltweit verkauft. Unser Unternehmen bietet Ihnen auch einen effizienten After-Sales-Service durch das Know-How unserer Techniker und die Hotline unseres Vertriebsbüros.



OUR LINES

RED LINE
ORANGE LINE
YELLOW LINE
GREEN LINE
BLUE LINE
MAGENTA LINE
CORAL LINE
GOLD LINE
SILVER LINE
BLACK LINE
RAINBOW LINE



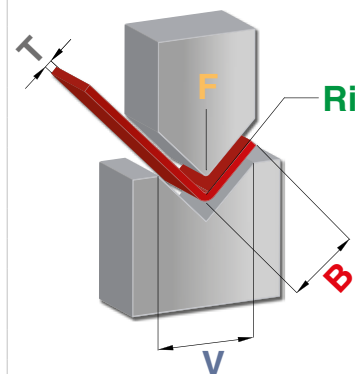
TABELLA DI PIEGATURA

FORZA NECESSARIA PER PIEGA A 90° IN ARIA DI LAMIERA CON RESISTENZA
 FORCE REQUIRED FOR 90° AIR BENDING, SHEET RESISTANCE
 FUERZA NECESARIA PARA PLEGAR A 90° CON LA RESISTENCIA
 FORÇA NECESSÁRIA PARA QUINAR/DOBRAR NO AR A 90° COM RESISTÊNCIA
 FORCE NÉCESSAIRE POUR LE PLIAGE EN L'AIR À 90° AVEC RÉSISTANCE
 ERFORDERLICHE PRESSKRAFT FÜR 90° FREIBIEGEN, ZUGFESTIGKEIT



R=45 Kg/mm^q

T	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
mm	4	5.5	7	8.5	11	14	17.5	22	28	35	45	55	71	89	113	140	175	B
	1	1.3	1.6	2	2.6	3.3	4	5	6.5	8	10	13	16	20	26	33	41	Ri
0.5	3																	
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											153	120	96	78	60			
15												188	150	120	95	75		
20													270	215	170	135	108	F
																		t/m



SPESSORE LAMIERA IN MM - THICKNESS OF THE SHEET IN MM - ESPESOR DE CHAPA MM
 ESPESSURA DA CHAPA EM MM - ÉPAISSEUR DE TÔLE EN MM - MATERIALDICKE IN MM

FORZA IN TON /METRO - FORCE IN TON /METER - FUERZA TON/METRO
 FORÇA TON/METRO - FORCE EN TON/METRE - PRESSKRAFT IN T/M

RAGGIO INTERNO - INSIDE RADIUS - RADIO INTERIOR - RAO INTERNO - RAYON INTÉRIEUR - INNENRADIUS

BORDO MINIMO POSSIBILE - MINIMUM FLANGE LENGHT - ALA MINIMA
 ABA MINIMA - BORD MINI POSSIBLE - KÜRZESTE SCHENKELLANGE

LARGHEZZA DEL V - V-OPENING - APERTURA MATRIZ - ABERTURA DO V - LARGEUR DU VE - MATRIZENÖFFNUNGSWEITE V

T

F

Ri

B

V

CALCOLO DELLA FORZA PER PIEGA IN ARIA

CALCULATION OF FORCE FOR AIR BENDING

CÁLCULO DE LA FUERZA DE PLEGADO AL AIRE

CÁLCULO DE FORÇA DA QUINAGEM/DOBRA NO AR

CALCUL DE LA FORCE POUR PLIAGE EN L'AIR

BESTIMMUNG DER PRESSKRAFT

$$F = \frac{T^2 \times 2 \times R}{1.4 \times V} = \dots\dots\dots \text{Tons/mt}$$

ALLUMINIO - ALUMINIUM - ALUMINIO - ALUMINIO - ALUMINIUM - ALUMINIUM

R=20-25 KG/MMQ

ACCIAIO DOLCE - MILD STEEL - ACERO - AÇO - ACIER - STAHL

R=40-45 KG/MMQ

INOX - STAINLESS STEEL - INOX - INOX - ACIER INOXYDABLE - EDELSTAHL

R=65-70 KG/MMQ

RAPPORTO TRA SPESSORE DI LAMIERA E AMPIEZZA DEL V - SHEET THICKNESS / V- WIDTH

CHAPA ESPESOR / ANCHO V - ESPESSURA DA CHAPA / LARGURA V

RAPPORT ÉPAISSEUR DE TÔLE / LARGEUR DU VE - MATERIALDICKE / MATRIZENÖFFNUNGSWEITE V

SPESSORE LAMIERA (mm) - SHEET THICKNESS (mm) - ESPESOR DE CHAPA (mm)	0.5 - 2.5	3 - 8	9 - 10	12 OR MORE
ESPESSURA DA CHAPA (mm) - ÉPAISSEUR DE TÔLE (mm) - MATERIALDICKE (mm)				
AMPIEZZA DEL V (mm) - V - WIDTH (mm) - ANCHO V (mm)	6 T	8 T	10 T	12 T
LARGURA V (mm) - LARGEUR DU VE (mm) - MATRIZENÖFFNUNGSWEITE V (mm)				

INTRODUZIONE	2
INTRODUCTION - INTRODUCCIÓN - INTRODUÇÃO - INTRODUCTION - EINFÜHRUNG	
TABELLA DI PIEGATURA	3
BENDING CHART - TABLA DE PLEGADO - TABELA DE QUINAGEM/DOBRA - ABAQUE DE PLIAGE - PRESSKRAFTTABELLE	
TRATTAMENTI TERMICI E TIPO DI MATERIALE	5
HARDENED TREATMENT AND TYPE OF MATERIAL - TRATAMIENTOS ENDURECIDOS Y TIPO DE MATERIAL	
TRATAMENTOS TÉRMICOS E TIPO DE MATERIAL - TRAITEMENTS THERMIQUES ET TYPE DE MATÉRIEL - HÄRTEBEHANDLUNG UND ART DES MATERIALS	
UNIBEND	7
UNIBEND - UNIBEND - UNIBEND - UNIBEND - UNIBEND - UNIBEND	
SUPPORTI E MATRICI A RULLI	13
ADAPTERS AND ROLLER DIE - SOPORTES MATRICES DE RODILLOS - SUPORTES E MATRIZES DE BAIXA FRICÇÃO	
SUPPORTS ET MATRICES A ROULEAUX - HALTER UND MATRIZE MIT EINLAUFWELLEN	
MATRICI A RULLI VARIABILI	17
ADJUSTABLE ROLLER DIE - MATRICES DE RODILLOS REGULABLES - SUPORTES E MATRIZES DE ROLOS	
MATRICES A ROULEAUX VARIABLES - VERSTELLBARE MATRIZE MIT EINLAUFWELLEN	
CONTENITORI E INSERTI IN POLIURETANO	19
HOLDERS AND POLYURETHANE INSERTS - CONTENEDORES INSERTOS POLIURETANO - SUPORTES E INSERTOS EM POLIURETANO	
CONTENEURS ET INSERTS POLYURÉTHANE - PU-AUFNAHMEN UND POLSTER	
CONTENITORI E INSERTI IN NYLON	23
NYLON INSERTS HOLDERS - SOPORTES ENCASTRES DE NYLON - SUPORTES PARA INSERTOS DE NYLON	
CONTENEURS ET INSERTS EN NYLON - HALTER FÜR KUNSTSTOFFMATRIZEN	
PELLICOLA ANTIGRAFFIO E TENDIPELLICOLA	27
PROTECTIVE FILM AND FOLDER FOR PROTECTIVE FILM - GOMAPROTECCIÓN Y TENSORES - PELÍCULA PROTETORA DE CHAPA E ESTICADOR DE PELÍCULA	
FILM DE PROTECTION ET TENDEURS - ABKANTFOLIEN UND ABKANTFOLIENHALTER	
INDEX CODE	34
INDEX CODE - INDEX CODE - INDEX CODE - INDEX CODE - INDEX CODE - INDEX CODE	

TRATTAMENTI TERMICI E TIPO DI MATERIALE

TRATTAMENTI TERMICI - HARDENED TREATMENT - TRATAMIENTOS ENDURECIDOS - TRATAMENTOS TÉRMICOS - TRAITEMENTS THERMIQUES - HÄRTEBEHANDLUNG

GLI UTENSILI STANDARD E SPECIALI SONO TEMPRATI AD INDUZIONE SULLE PARTI USURABILI A 52-55 HRC.

THE STANDARD AND SPECIAL TOOLS ARE INDUCTION HARDENED TO 52-55 HRC ON WEAR PARTS.

LAS HERRAMIENTAS ESTÁNDAR Y ESPECIALES VIENEN TEMPLADAS POR INDUCCIÓN DE 52-55 HRC EN PIEZAS DE DESGASTE.

AS FERRAMENTAS STANDARD E ESPECIAIS SÃO TEMPERADAS POR INDUÇÃO 52-55 HRC NA ZONA DE DESGASTE.

LES OUTILS STANDARDS ET SPÉCIAUX SONT TREMPÉS PAR INDUCTION À 52-55 HRC SUR LES PARTIES TRAVAILLANTES.

DIE VERSCHLEISSTEILE DER STANDARD UND SONDERWERKZEUGE SIND INDUKTIV AUF 52-55HRC GEHÄRTET.

TRATTAMENTI ANTIUSURA - ANTIWEAR TREATMENT - TRATAMIENTOS ANTI-DESGASTE - TRATAMENTOS ANTI-DESGASTE - TRAITEMENTS ANTI-USURE - BEHANDLUNG FÜR VERSCHLEISSCHUTZ

A RICHIESTA DEL CLIENTE, SUGLI UTENSILI COSTRUITI IN 42CRM04, PUÒ ESSERE FATTO UN TRATTAMENTO ANTIUSURA DI NITRURAZIONE.

ON REQUEST ON THE TOOLING IN 42CRM04 TECNOSTAMP CAN MAKE AN ANTIWEAR-NITRIDING TREATMENT.

OPCIONALMENTE, AL UTILLAJE EN 42CRM04, SE LE PUEDE HACER UN TRATAMIENTO ANTI-DESGASTE – NITRURACIÓN.

A PEDIDO DO CLIENTE EM FERRAMENTAS FABRICADAS EM 42CRM04, TECNOSTAMP PODE FAZER UM TRATAMENTO DE NITRETAÇÃO ANTI-DESGASTE.

SUR DEMANDE LES OUTILS EN 42CRM04 PEUVENT SUBIR UN TRAITEMENT ANTI-USURE EN NITRURATION.

AUF ANFRAGE AUF DEM WERKZEUG IN 42CRM04 TECNOSTAMP KANN EINE ANTIVERSCHLEISS - NITRIERBEHANDLUNG ZU MACHEN.

TRATTAMENTI ANTIRUGGINE - RUSTING TREATMENT - TRATAMIENTOS ANTI-OXIDACIÓN - TRATAMENTOS ANTI OXIDAÇÃO - TRAITEMENTS ANTIROUILLE - BEHANDLUNG GEGEN ROST

A RICHIESTA DEL CLIENTE SUGLI UTENSILI PUÒ ESSERE FATTO IL TRATTAMENTO ANTI RUGGINE DI ZINCATURA.

AN ANTI RUST-GALVANIZED TREATMENT CAN BE MADE ON TOOLS ON REQUEST.

OPCIONALMENTE, A LOS UTILLAJES SE LES PUEDE DAR UN TRATAMIENTO ANTI-ÓXIDO-GALVANIZADO.

A PEDIDO DO CLIENTE, A TECNOSTAMP PODE FAZER UM TRATAMENTO ANTIFERRUGEM ZINCADO.

SUR DEMANDE UN TRAITEMENT ANTI-ROUILLE PEUT ÊTRE RÉALISÉ EN GALVANISÉ.

AUF ANFRAGE KANN TECNOSTAMP MEINE ANTI-ROST BEHANDLUNG ANBIETEN.

TIPO DI MATERIALE - TYPE OF MATERIAL - TIPO DE MATERIAL UTILIZADO - TIPO DE MATERIAL UTILIZADO - TYPE DE MATÉRIEL - ART DES MATERIALS

	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191). STEEL C45 (UNI EN 10083 W.1. : 1.1191). ACERO C45 (UNI EN 10083 W.1. : 1.1191). AÇO C45 (UNI EN 10083 W.1. : 1.1191). ACIER C45 (UNI EN 10083 W.1. : 1.1191). STAHL C45 (UNI EN 10083 W.1. : 1.1191).
	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191) TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL C45 (UNI EN 10083 W.1. : 1.1191) INDUCTION TEMPERED (52-55 HRC) ON WEAR PARTS. ACERO C45 (UNI EN 10083 W.1. : 1.1191) TEMPLADO A INDUCCIÓN EN ZONA DE DESGASTE (52/55 HRC). AÇO C45 (UNI EN 10083 W.1. : 1.1191) TEMPERADO POR INDUÇÃO NAS ZONAS DE DESGASTE (52-55 HRC). ACIER C45 (UNI EN 10083 W.1. : 1.1191) TREMPÉ PAR INDUCTION (52-55 HRC) SUR LES PARTIES TRAVAILLANTES. STAHL C45 (UNI EN 10083 W.1. : 1.1191), VERSCHLEISSTEILE INDUKTIV AUF (52-55HRC) GEHÄRTET.
	ACCIAIO C45 (UNI EN 10083 W.1. : 1.1191) BONIFICATO R=80-85 KG/MMQ TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL C45 (UNI EN 10083 W.1. : 1.1191) HARDENED R=80-85 KG/MMQ INDUCTION TEMPERED (52-55 HRC) ON WEAR PARTS. ACERO C45 (UNI EN 10083 W.1. : 1.1191) BONIFICADO R=80-85 KG/MMQ TEMPLADO A INDUCCIÓN EN ZONA DE DESGASTE (52/55 HRC). AÇO C45 (UNI EN 10083 W.1. : 1.1191) BONIFICADO R=80-85 KG/MMQ TEMPERADO POR INDUÇÃO NAS ZONAS DE DESGASTE (52-55 HRC). ACIER C45 (UNI EN 10083 W.1. : 1.1191) RESISTANCE R = 80-85 KG/MMQ ET TREMPÉ PAR INDUCTION (52-55 HRC) SUR LES PARTIES TRAVAILLANTES. STAHL C45 (UNI EN 10083 W.1. : 1.1191) VERGÜTET R=80-85 KG/MM2 AN DEN ABNUTZUNGSKANTEN INDUKTIV GEHÄRTET AUF (52/55 HRC).
	ACCIAIO 42CRM04 (UNI EN 10083 W.1. : 1.7225) BONIFICATO R=95-105 KG/MMQ TEMPRATO AD INDUZIONE (52/55 HRC) SULLE PARTI USURABILI. STEEL 42 CRM04 (UNI EN 10083 W.1. : 1.7225) HARDENED R=95-105 KG/MMQ INDUCTION TEMPERED (52-55 HRC) ON WEAR PART. ACERO 42CRM04 (UNI EN 10083 W.1. : 1.7225) BONIFICADO R=95-105 KG/MMQ TEMPLADO A INDUCCIÓN EN ZONA DE DESGASTE (52/55 HRC). AÇO 42 CRM04 (UNI EN 10083 W.1. : 1.7225) BONIFICADO R=95-105 KG/MMQ TEMPERADO POR INDUÇÃO NAS ZONAS DE DESGASTE (52-55 HRC). ACIER 42 CRM04 (UNI EN 10083 W.1. : 1.7225) RESISTANCE R=95-105 KG/MMQ ET TREMPÉ PAR INDUCTION (52-55 HRC) SUR LES PARTIES TRAVAILLANTES. STAHL 42 CRM04 (UNI EN 10083 W.1. : 1.7225) VERGÜTET R=95-105 KG/MM2 AN DEN ABNUTZUNGSKANTEN INDUKTIV GEHÄRTET AUF (52/55 HRC).



UNIBEND



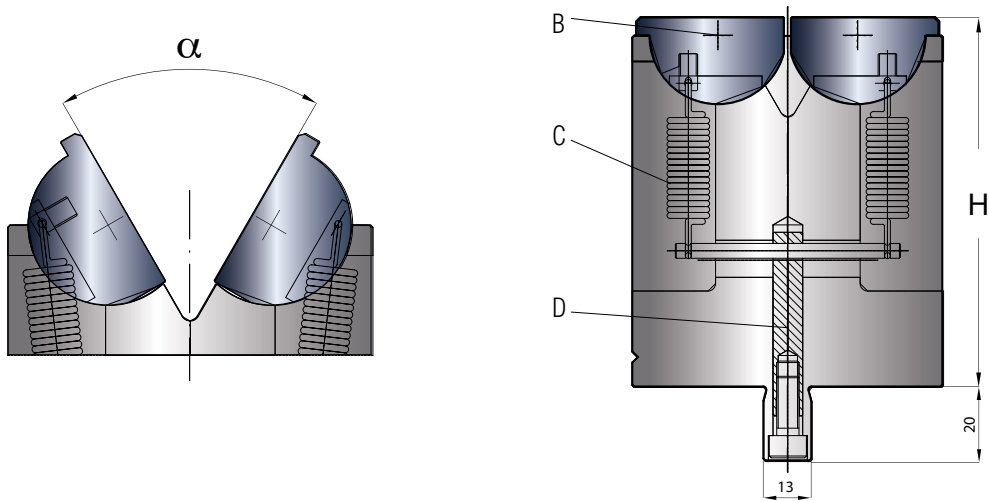
CORAL LINE

NO MARKING TOOLS

UNIBEND E ADATTATORI - UNIBEND AND ADAPTERS - UNIBEND Y ADAPTADORES

UNIBEND E ADAPTADORES - UNIBEND ET ADAPTATEURS - UNIBEND UND MATRIZENADAPTER

LA NUOVA GAMMA DI MATRICI UNIBEND - THE NEW RANGE OF UNIBEND DIES - LA NUEVA GAMA DE MATRICES UNIBEND
A NOVA GAMA DE MATRIZES UNIBEND - LA NOUVELLE GAMME DE MATRICES UNIBEND - DIE NEUE REIHE VON UNIBEND MATRIZEN



LEGENDA		LEGEND	LEYENDA	LEGENDA	LÉGENDE	LEGENDE
H	=	ALTEZZA	HEIGHT	ALTURA	HAUTEUR	STEMPELHÖHE
α	=	ANGOLO	ANGLE	ÂNGULO	ANGLE	WINKEL
B	=	INSERTO ROTANTE	ROTATING ROOL	INSERTO ROTANTE	INSERT ROTATIF	DREHENDER EINSATZ
C	=	MOLLA A TRAZIONE	SPRING	MUELLE	RESSORTS	FEDER
D	=	PERNO TENSORE	PIN	PERNO TENSOR	GOUPILLE	STIFT
L	=	LUNGHEZZA	LENGHT	LONGITUDE	LONGUEUR	LÄNGEN

La nuova gamma di matrici UniBend prodotte da Tecnostamp offre notevoli vantaggi :

- Riduzione dei tempi di cambio utensile poichè con la stessa matrice è possibile piegare spessori diversi
- Riduzione del 90% dei segni dovuti allo strisciamento della lamiera
- Possibilità di piegare pezzi con bordi stretti
- Riduzione della deformazione di fori e asole coincidenti con le linee di piegatura.

The new range of UniBend dies produced by Tecnostamp offers significant advantages :

- Less tool change because a single die can bend a wide range of material thickness
- Reduction of 90% of the bending marks on the sheet metal
- Possibility to bend short flanges

La nueva gama de matrices Unibend producido por Tecnostamp ofrece ventajas considerables:

- Reducción de los tiempos de cambio de herramienta, ya que con la misma matriz que pueda plegar diferentes espesores
- Reducción de 90% de las señales debido a la hoja deslizante
- Capacidad para doblar piezas con bordes estrechos
- Reducción de la deformación de los orificios y ranuras coincidentes con las líneas de plegado.



A nova gama de matrizes Unibend produzidas pela Tecnostamp oferece vantagens consideráveis:

- Tempos de mudança/troca de ferramenta reduzidos porque com a mesma matriz podem ser quinadas/dobradas diferentes espessuras
- Redução de 90% dos riscos causados pelo deslizamento da chapa
- Capacidade de quinar/dobrar peças com abas estreitas
- Redução da deformação de furos e ranhuras coincidentes com as linhas de quinagem/dobragem.

La nouvelle gamme de matrices Unibend produite par Tecnostamp offre des avantages considérables:

- Réduction du temps de changement d'outil puisqu' avec la même matrice vous pouvez plier différentes épaisseurs
- Réduction de 90% des marques due au coulissement de la tôle
- Possibilité de plier des pièces avec des bords étroits
- Réduction de la déformation des trous et des fentes qui coïncident avec les lignes de pliage.

Die neue Serie UniBend Matrizen von Tecnostamp.Sie bieten erhebliche Vorteile:

- Reduzierte Werkzeugwechselzeiten, da mit der gleichen Matrice unterschiedliche Materialstärken gekantet werden können.
- Reduzierung von 90% der Abdrücke auf den Kantteilen.
- Kantung von kurzen Schenkeln.
- Weniger deformation bei der Kantung von Löcher und Schlitzen nahe an der Biegelinie

LA NUOVA GAMMA DI MATRICI UNIBEND - THE NEW RANGE OF UNIBEND DIES - LA NUEVA GAMA DE MATRICES UNIBEND
A NOVA GAMA DE MATRIZES UNIBEND - LA NOUVELLE GAMME DE MATRICES UNIBEND - DIE NEUE REIHE VON UNIBEND MATRIZEN

La nuova gamma di matrici UniBend prodotte da Tecnostamp è stata concepita con attacco tipo Wila, ma può essere utilizzata su tutti i tipi di presse piegatrici utilizzando la vasta gamma di adattatori inferiori disponibili a magazzino e illustrati di seguito.

The new range of UniBend dies produced by Tecnostamp is with Wila style system attack but can be used on all types of press-brakes using the wide range of lower adapters available ex stock.

La nueva gama de Unibend producida por la matriz Tecnostamp está diseñado con el tipo Wila ataque, pero se puede utilizar en todo tipo de prensas plegadoras utilizando la amplia gama de adaptadores más extenso disponibles en stock.

A nova gama de matrizes Unibend produzidas pela Tecnostamp foi projetada com aperto tipo Wila, mas pode ser usada em todos os tipos de quinadoras/dobreadeiras utilizando a vasta gama de adaptadores inferiores disponíveis em stock/estoque.

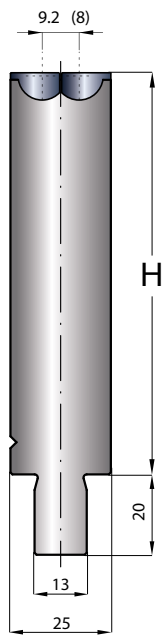
La nouvelle gamme Unibend fabriquée par Tecnostamp a été conçue avec attache type Wila mais peut être utilisée sur tout type de presse en utilisant notre large gamme d'adaptateurs inférieurs disponibles en stock.

Die neue Serie UniBend Matrizen von Tecnostamp wird mit Wila-Aufnahme hergestellt. Sie sind aber mittels der ab Lager lieferbaren Matrizenadaptern auf allen Abkantpressen einsetzbar.



CODE	α	V	H	T/Mt	Mt
29.000	40°	8	100.00	100	

40°

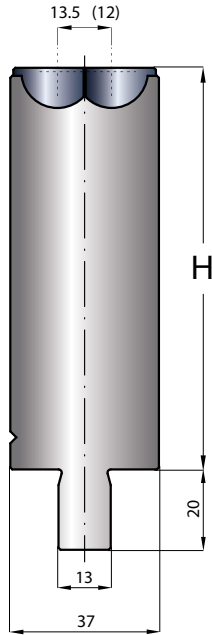


Min and Max sheet thickness - 0,5 / 2 mm
Minimum flange lenght 6 mm
Maximum punch radius at 90° = 2,0
Minimum bending angle - 40°

LENGTH	50	100	200	300	500

CODE	α	V	H	T/Mt	Mt
29.100	60°	12	100.00	130	

60°

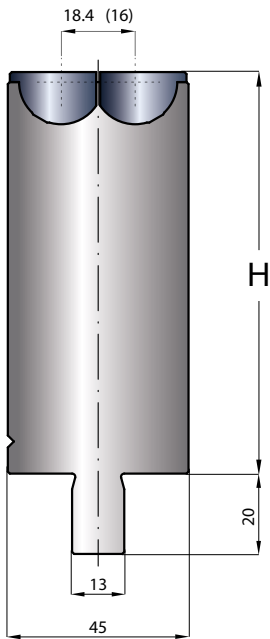


Min and Max sheet thickness - 1 / 3 mm
Minimum flange lenght 8,5 mm
Maximum punch radius at 90° = 3,0
Minimum bending angle - 60°

LENGTH	50	100	200	300	500

CODE	α	V	H	T/Mt	Mt
29.150	60°	16	100.00	150	

60°



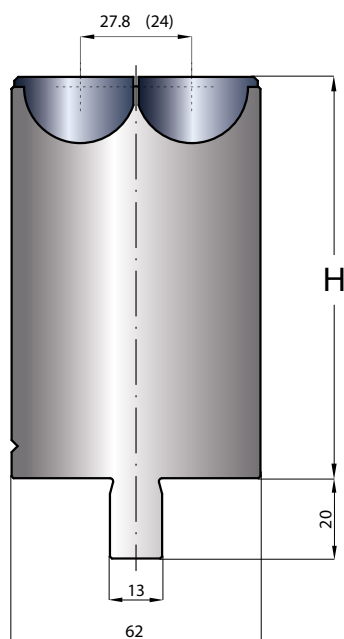
Min and Max sheet thickness - 1 / 4 mm
Minimum flange lenght 13 mm
Maximum punch radius at 90° = 4,0
Minimum bending angle - 60°

LENGTH	50	100	200	300	500



CODE	α	V	H	T/Mt	Mt
29.200	60°	24	100.00	150	

60°

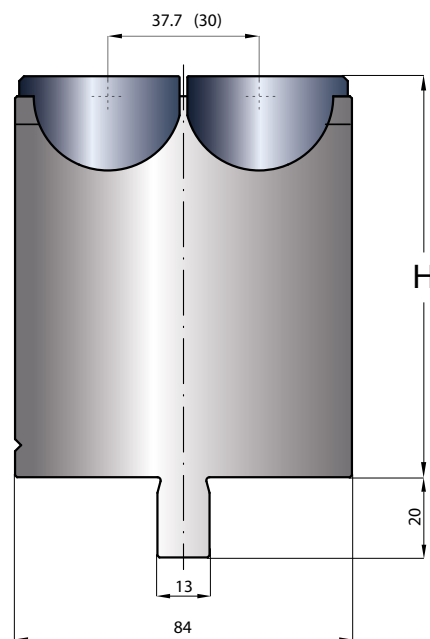


Min and Max sheet thickness - 1 / 5 mm
 Minimum flange length 17 mm
 Maximum punch radius at 90° = 6,0
 Minimum bending angle - 60°

LENGTH	50	100	200	300	500
--------	----	-----	-----	-----	-----

CODE	α	V	H	T/Mt	Mt
29.300	60°	30	100.00	200	

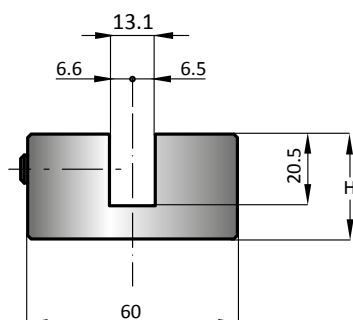
60°



Min and Max sheet thickness - 1 / 6 mm
 Minimum flange length 23,5 mm
 Maximum punch radius at 90° = 8,0
 Minimum bending angle - 60°

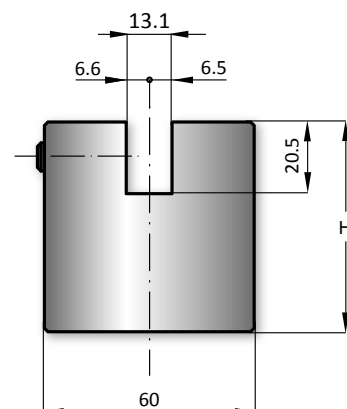
LENGTH	50	100	200	300	500
--------	----	-----	-----	-----	-----

CODE	L	H	T/Mt	Mt
60.910	1000	30.00	100	



ADATTATORE- ADAPTER - ADAPTADORE
 ADAPTADORE - ADAPTATEUR - ADAPTER
 AMADA-BEYELER/TRUMPF

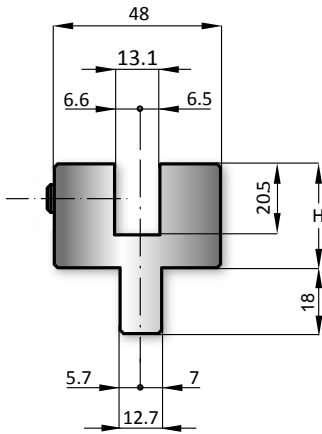
CODE	L	H	T/Mt	Mt
60.920	1000	60.00	100	



ADATTATORE- ADAPTER - ADAPTADORE
 ADAPTADORE - ADAPTATEUR - ADAPTER
 AMADA-BEYELER/TRUMPF

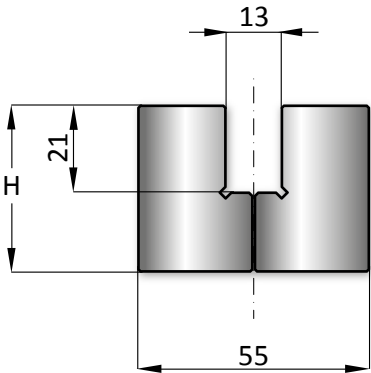
ADATTATORI UNIBEND

CODE	L	H	T/Mt	Mt
60.935	1000	30.00	100	



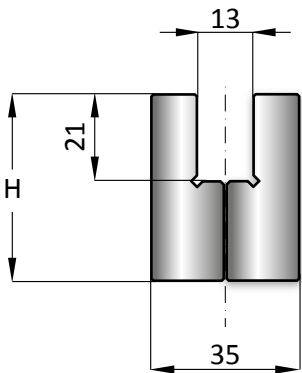
ADATTATORE- ADAPTER - ADAPTADORE
ADAPTADORE - ADAPTATEUR - ADAPTER
LVD-BEYELER/TRUMPF

CODE	L	H	T/Mt	Mt
60.940	500	40.00	100	



ADATTATORE- ADAPTER - ADAPTADORE
ADAPTADORE - ADAPTATEUR - ADAPTER
WILA / EHT

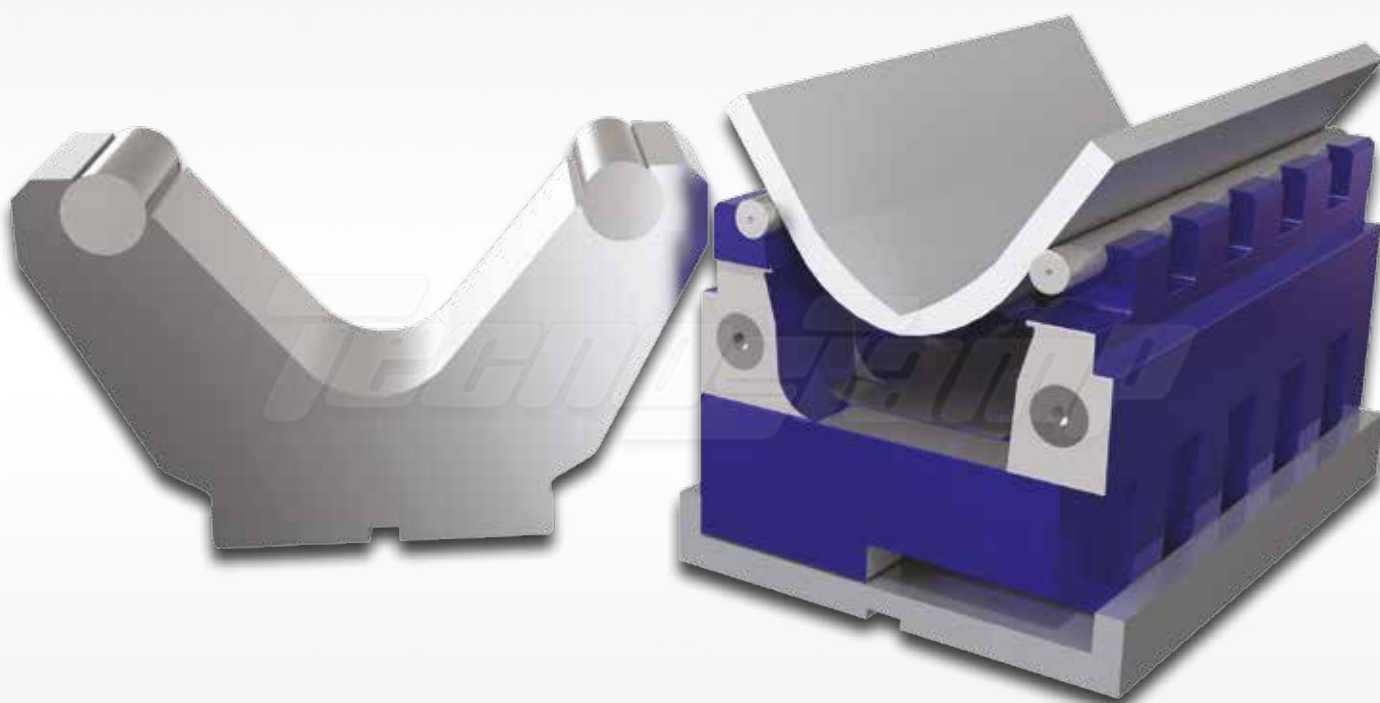
CODE	L	H	T/Mt	Mt
60.950	500	45.00	100	



ADATTATORE- ADAPTER - ADAPTADORE
ADAPTADORE - ADAPTATEUR - ADAPTER
WILA / WEINBRENNER



SUPPORTI MATRICI A RULLI



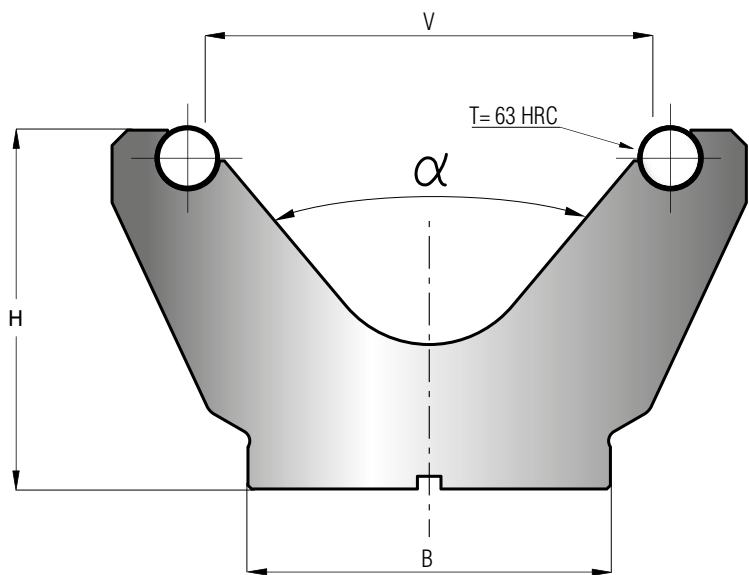
CORAL LINE

NO MARKING TOOLS

SUPPORTI E MATRICI A RULLI - ADAPTERS AND ROLLER DIE

SOPORTES MATRICES DE RODILLOS - SUPORTES E MATRIZES DE ROLOS

SUPPORTS ET MATRICES A ROULEAUX - HALTER UND MATRIZE MIT EINLAUFWELLEN



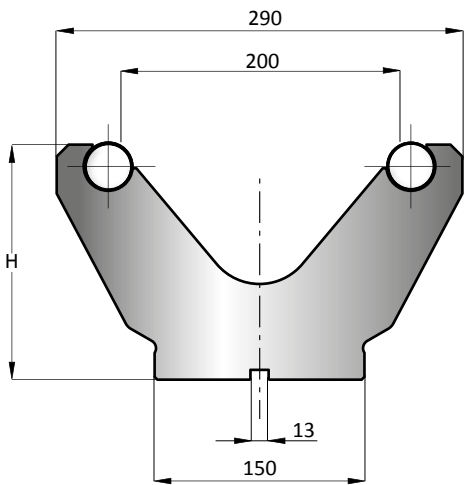
LENGTH 100



	LEGENDA	LEGEND	LEYENDA	LEGENDA	LÉGENDE	LEGENDE
H	= ALTEZZA	HEIGHT	ALTURA	ALTURA	HAUTEUR	STEMPELHÖHE
α	= ANGOLO	ANGLE	ÂNGULO	ÂNGULO	ANGLE	WINKEL
B	= BASE	WIDTH	BASE	BASE	BASE	BREITE
V	= AMPIEZZA CAVA	DIE OPENING	ANCHO V	ABERTURA DO V	LARGEUR DE VE	ÖFFNUNGSWEITE
T	= TEMpra AD INDUZIONE	INDUCTION HARDENING	TEMPLADO A INDUCCIÓN	TEMPERA POR INDUÇÃO	TREMPÉ PAR INDUCTION	INDUKTIV GEHÄRTET
L	= LUNGHEZZA	LENGHT	LONGITUDE	COMPRIMENTO	LONGUEUR	LÄNGEN

CODE	α	H	T/Mt	Mt
20.720	80°	170.00	200	

80°

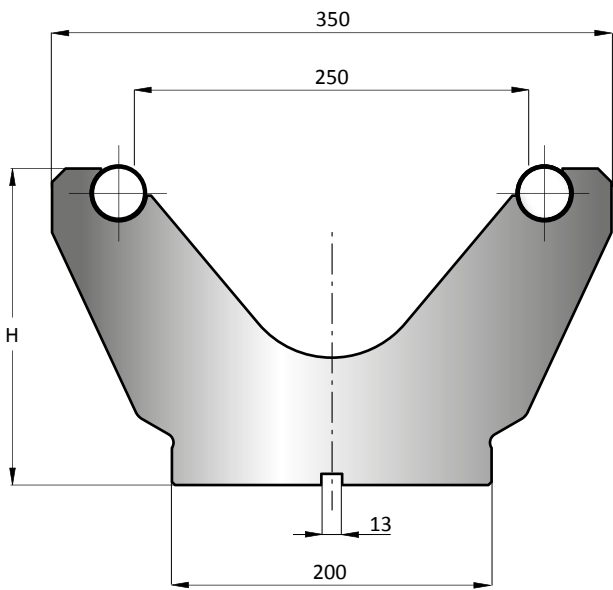


LENGTH 100



CODE	α	H	T/Mt	Mt
20.725	80°	200.00	200	

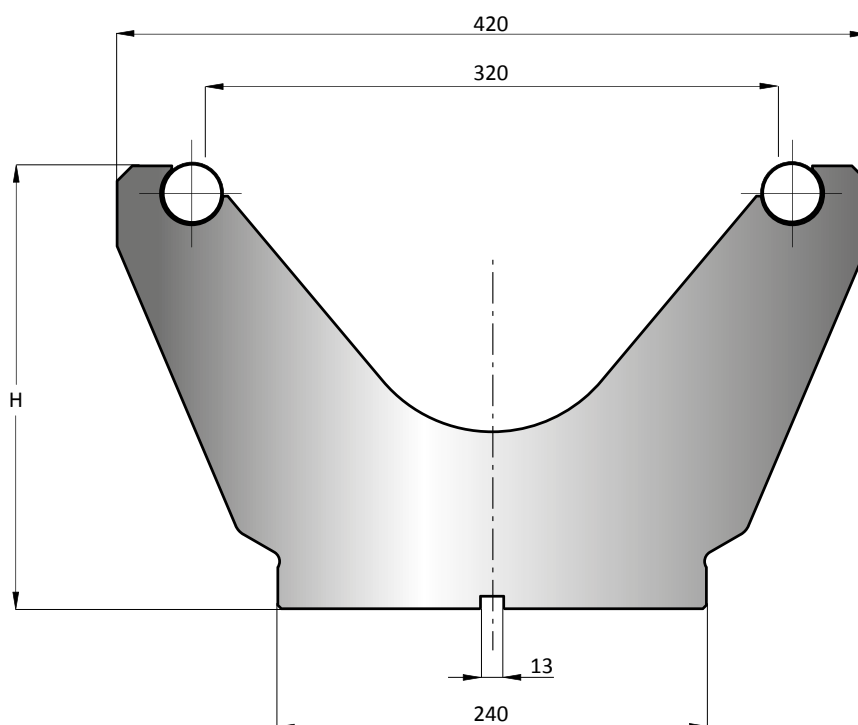
80°



LENGTH 100



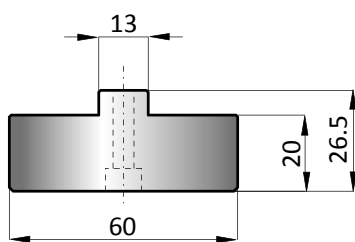
CODE	α	H	T/Mt	Mt
20.732	80°	250.00	200	



LENGTH 100

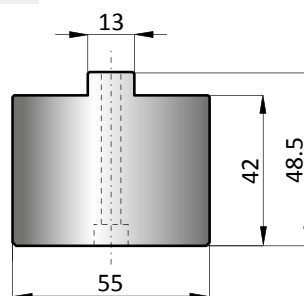
ADATTATORI - ADAPTERS - ADAPTADORES - ADAPTADORES - ADAPTATEURS - ADAPTER
 PROLUNGA - EXTENSION - ADAPTADORES - EXTENSÃO - EXTENSION - VERLÄNGERUNG

CODE	L
20.701	100



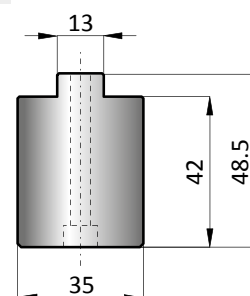
AMADA SYSTEM

CODE	L
20.707	100



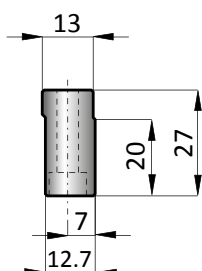
EHT SYSTEM

CODE	L
20.709	100



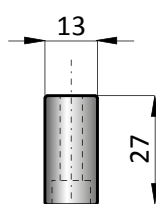
WEINBRENNER SYSTEM

CODE	L
20.705	100



LVD SYSTEM

CODE	L
20.703	100

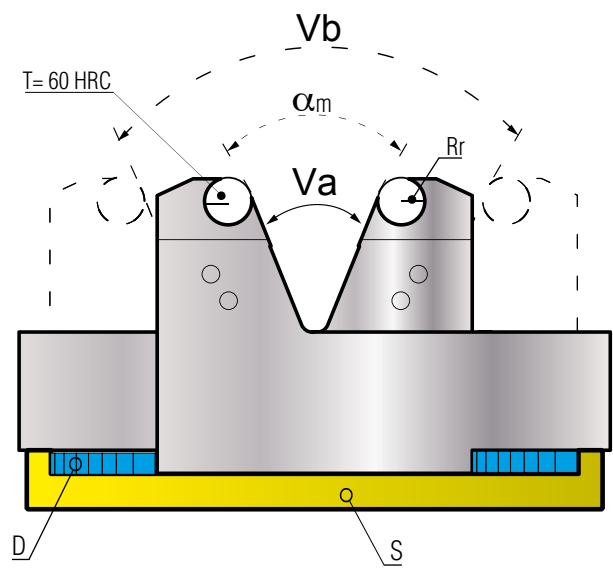


BEYELER / TRUMPF SYSTEM



MATRICI VARIABILI A RULLI

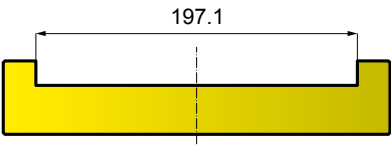
SCHEMA DI MONTAGGIO - ASSEMBLY SCHEME - ESQUEMA DE MONTAJE - ESQUEMA DE MONTAGEM - \ - MONTAGESCHEMA



	LEGENDA	LEGEND	LEYENDA	LEGENDA	LÉGENDE	LEGENDE
Va	= V minima	V min	V min.	V mín.	V min.	Min. V
Vb	= V massima	V maximum	V max.	V máx.	V max.	Max. V
αm	= ANGOLO MINIMO	ANGLE minimum	ÂNGULO	ÂNGULO mínimo	ANGLE minimum	WINKEL
Rr	= RAGGIO RULLI	ROLLER RADIUS	RADIO RODILLOS	RAIO DOS ROLETES	RAYON ROULEAUX	RADIUS DER ROLLEN
D	= DISTANZIALE	SPACER	SEPARADORES	INSERTOS DISTANCIADORES	DISTANCE	LEISTEN
S	= SUPPORTO	HOLDER	SOPORTE	SUPORTE	SUPPORT	HALTER
T	= TEMPRA A CUORE	TROUGH HARDENED	TEMPLADO A NÚCLEO	TEMPERA POR INDUÇÃO	TREMPE A COEUR	DURCHGEHÄRTET

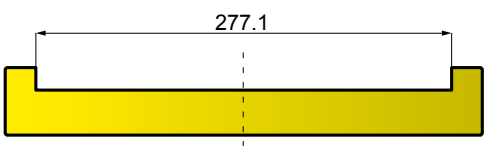
ADATTATORI - ADAPTERS - ADAPTADORES - ADAPTADORES - ADAPTATEURS - ADAPTER
PROLUNGA - EXTENSION - ADAPTADORES - EXTENSÃO - EXTENSION - VERLÄNGERUNG

CODE
60.411



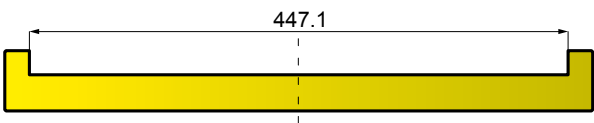
SUPPORTO - HOLDER - SOPORTE
SUPORTE - SUPPORT - HALTER

CODE
60.412



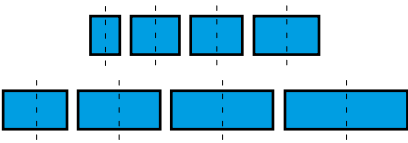
SUPPORTO - HOLDER - SOPORTE
SUPORTE - SUPPORT - HALTER

CODE
60.413



SUPPORTO - HOLDER - SOPORTE
SUPORTE - SUPPORT - HALTER

CODE
60.409

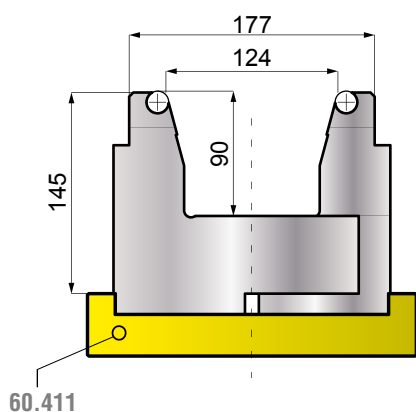


DISTANZIALE - SPACER - SEPARADORES
DISTANCIADORES - DISTANCE - LEISTEN

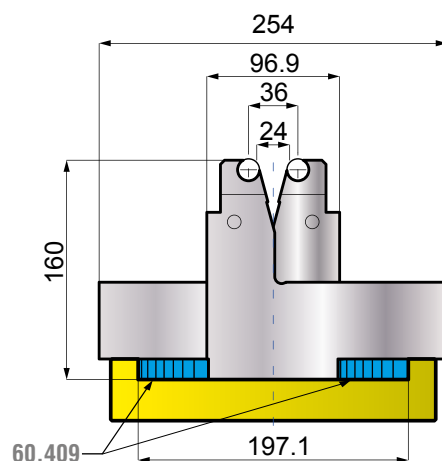
LENGTH 2 5 10 15 20 30 40 50

MATRICI VARIABILI A RULLI

CODE	α_m	Va	Vb	Rr	T/Mt	Mt
60.401	30°	24	124	8.00	125	

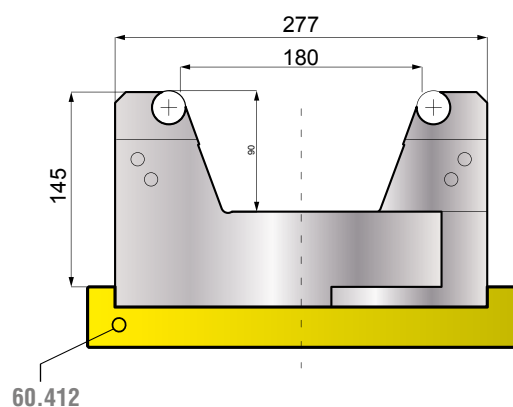


LENGTH 250 500 1000

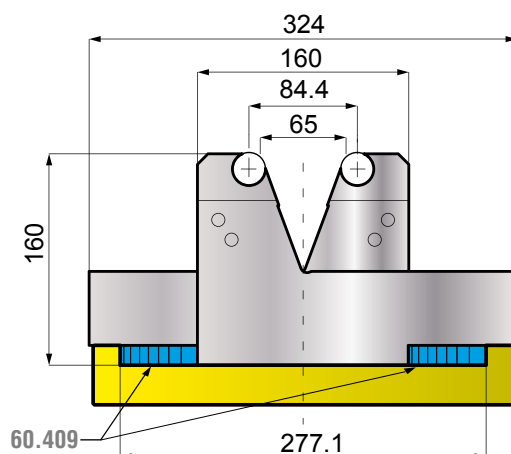


Max sp 3 - 15mm
Max tk 3 - 15mm
Máx. esp 3 - 15mm
Max esp 3 - 15mm
Max t 3 - 15mm
Max t 3 - 15mm

CODE	α_m	Va	Vb	Rr	T/Mt	Mt
60.402	60°	65	180	12.50	200	

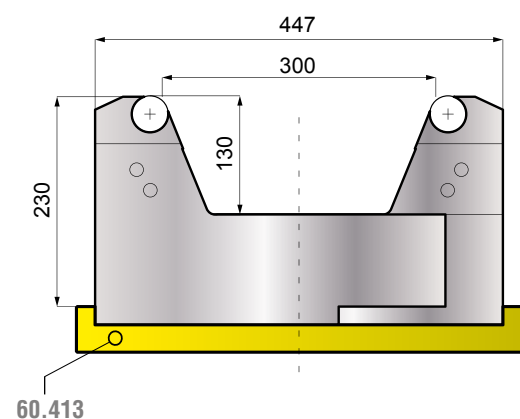


LENGTH 250 500 1000

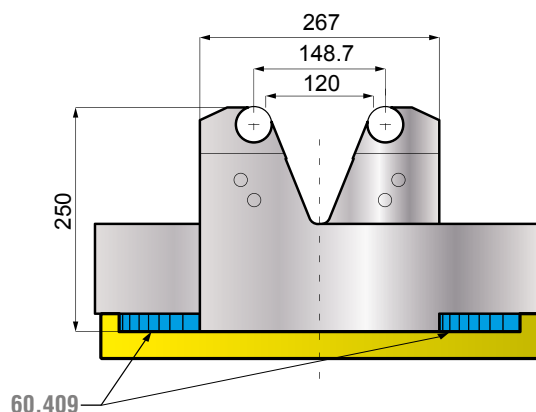


Max sp 6 - 20mm
Max tk 6 - 20mm
Máx. esp 6 - 20mm
Max esp 6 - 20mm
Max t 6 - 20mm
Max t 6 - 20mm

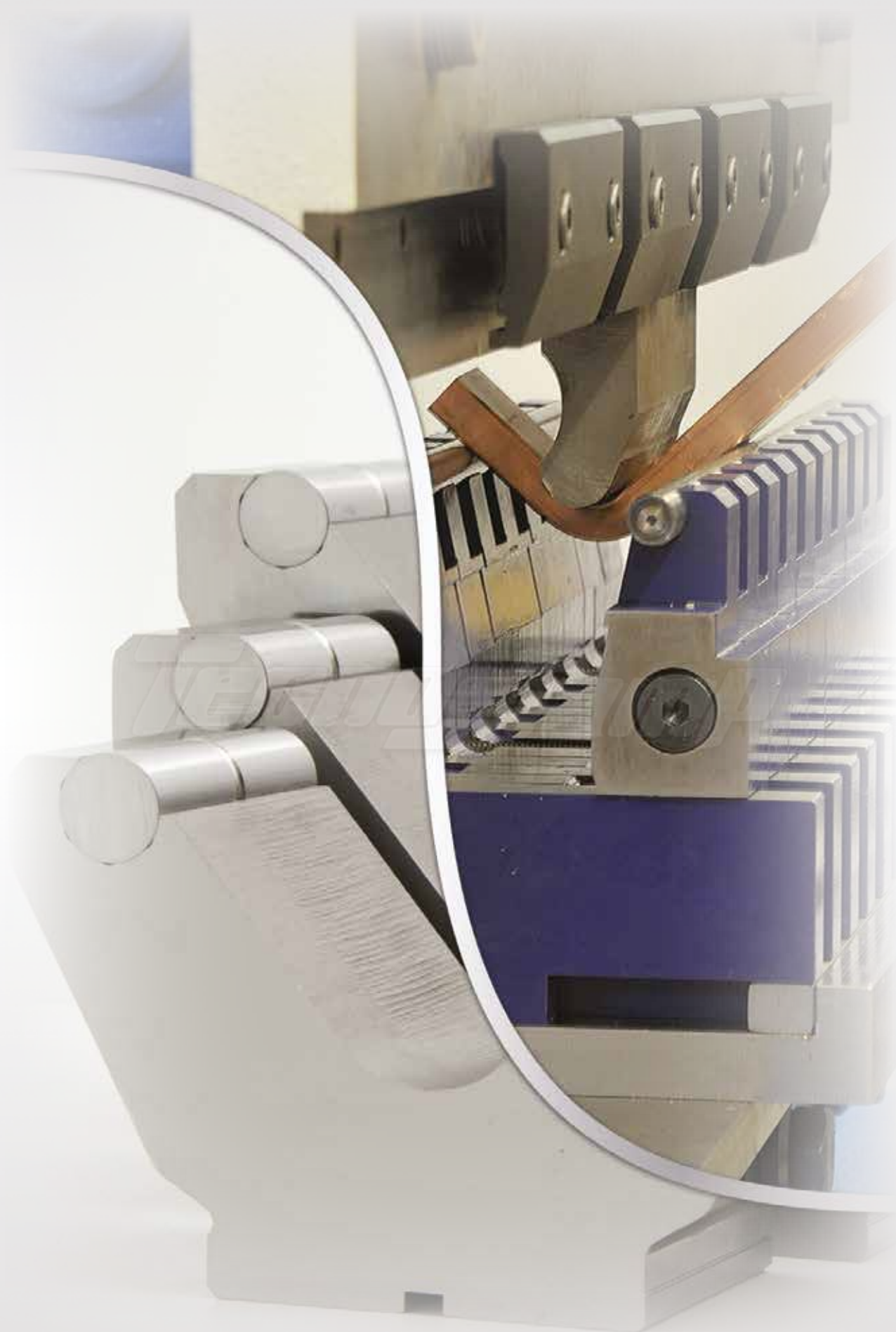
CODE	α_m	Va	Vb	Rr	T/Mt	Mt
60.403	60°	120	300	20.00	400	



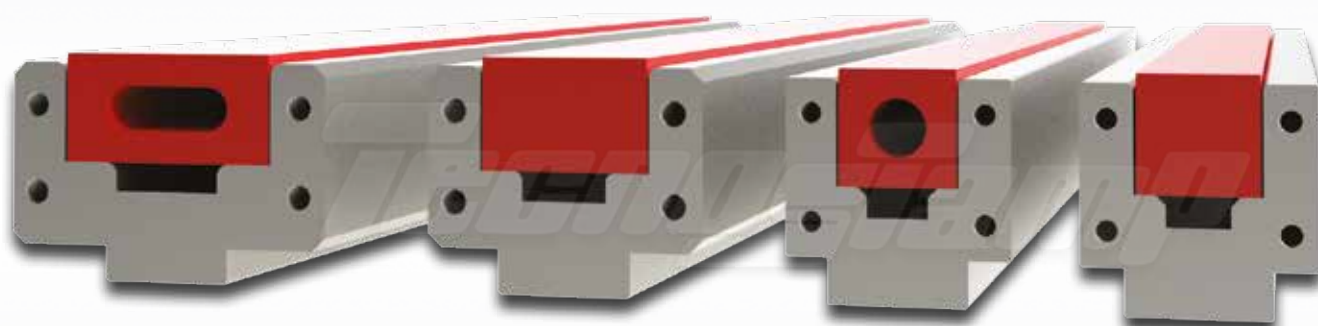
LENGTH 600



Max sp 10 - 30mm
Max tk 10 - 30mm
Máx. esp 10 - 30mm
Max esp 10 - 30mm
Max t 10 - 30mm
Max t 10 - 30mm



CONTENITORI E INSERTI IN POLIURETANO



CORAL LINE

NO MARKING TOOLS

CONTENITORI E INSERTI IN POLIURETANO - HOLDERS AND POLYURETHANE INSERTS

CONTENEDORES Y LOS INSERTOS DE POLIURETANO - SOPORTES E INSERTOS EM POLIURETANO

CONTENEURS ET INSERTS POLYURÉTHANE - PU-AUFNAHMEN UND POLSTER

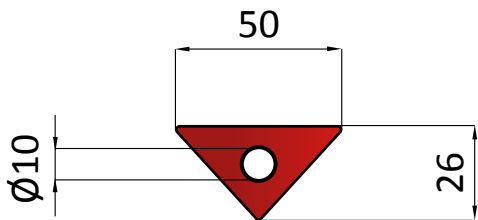
CONTENITORI E INSERTI IN POLIURETANO

POLIURETANO - URETHANE - BLOQUE
POLIURETANO QUADRADO - COUSSINS POLYURÉTHANE PLEIN - POLYURETHAN-EINLAGE



UTILIZZARE I PRODOTTI IN NYLON E POLIURETANO PER EVITARE GRAFFI DOVUTI ALLA PIEGATURA.
USE NYLON AND POLYURETHANE PRODUCTS TO TO AVOID SCRATCHES DURING BENDING.
USO DE LOS PRODUCTOS DE NYLON Y POLIURETANO MATERIALES PARA EVITAR ARAÑAZOS DEBIDO A LA FLEXIÓN.
USAR OS PRODUTOS EM NYLON E POLIURETANO PARA EVITAR RISCO DEVIDO À FLEXÃO.
UTILISER LES PRODUITS NYLON ET POLYURÉTHANE POUR ÉVITER LES RAYURES EN RAISON DE LA FOLD.
VERWENDEUNG DER POLYAMID- UND POLYURETHANEINSÄTZE ZU VERMEIDEN KRATZER AUFGRUND DER FOLD.

CODE	H
21.280	26.00



INSERTO IN GOMMA PER MATRICE COD. 21.207
POLYURETHANE INSERT FOR DIE COD. 21.207
INSERCIÓN DE POLIURETANO PARA LA MATRICES COD. 21.207
INSERTO EM POLIURETANO PARA MATRIZ CÓD. 21.207
INSERT POLYURÉTHANE POUR MATRICE 21.207
POLYURETHANEINSATZ FÜR DIE MATRIZE 21.207

LENGTH 415 835

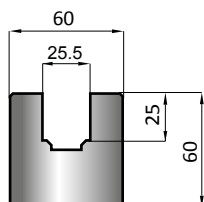


CONTENITORI E INSERTI IN POLIURETANO

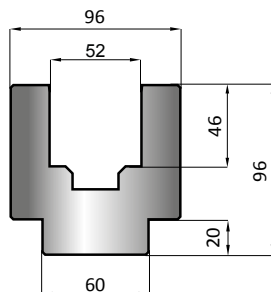
CONTENITORE PER GOMMA - URETHANE HOLDER - APOYO PARA EL POLIURETANO - CONTENTOR PARA POLIURETANO

CONTENEURS POUR POLYURÉTHANE - AUFNAHME FÜR POLYURETHANEINSÄTZE

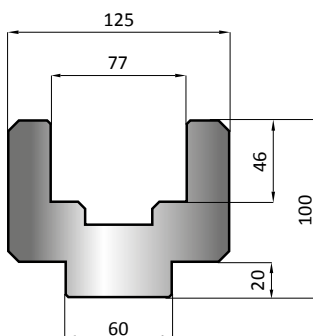
CODE	H
20.271	60.00



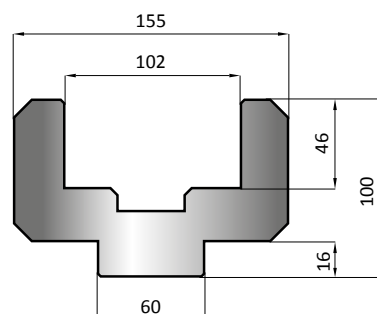
CODE	H
20.272	96.00



CODE	H
20.273	100.00



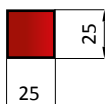
CODE	H
20.274	100.00



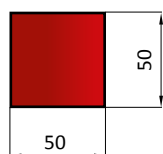
LENGTH 415 835

POLIURETANO - URETHANE - BLOQUE - POLIURETANO QUADRADO - COUSSINS POLYURÉTHANE PLEIN - POLYURETHAN-EINLAGE

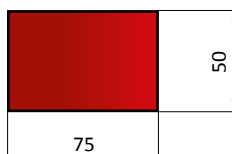
CODE	H
20.292	25.00



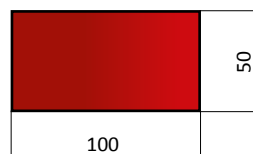
CODE	H
20.291	50.00



CODE	H
20.290	50.00



CODE	H
20.289	50.00

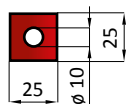


LENGTH 415 835

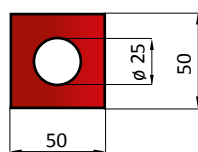
POLIURETANO FORATO - URETHANE WITH HOLE - BLOQUE PERFORADO

POLIURETANO PERFURADO - COUSSINS POLYURÉTHANE PERFORÉS - POLYURETHAN EINLAGE MIT KERNLOCH

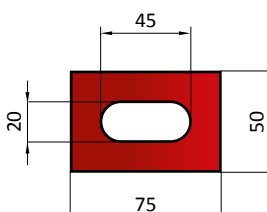
CODE	H
21.292	25.00



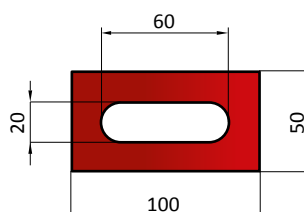
CODE	H
21.291	50.00



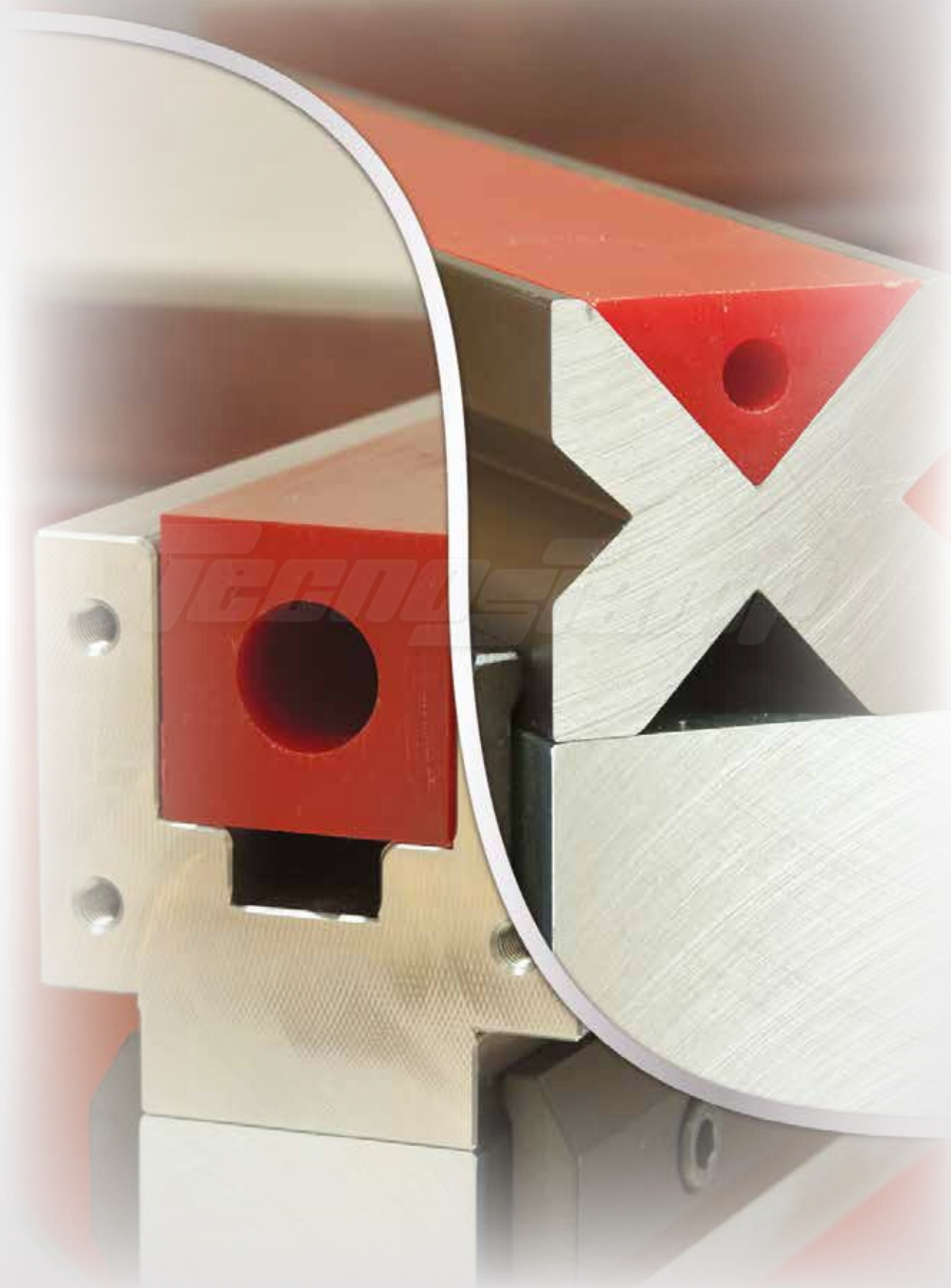
CODE	H
21.290	50.00



CODE	H
21.289	50.00



LENGTH 415 835



CONTENITORI INSERTI NYLON



CORAL LINE

NO MARKING TOOLS

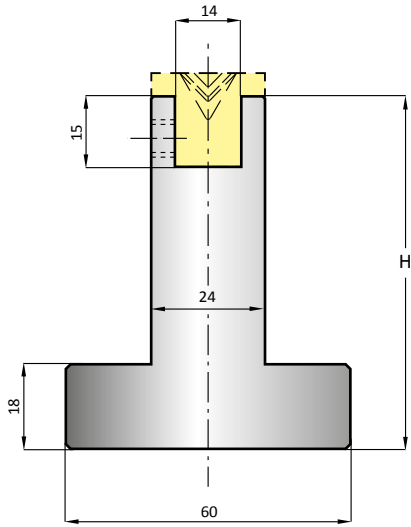
CONTENITORI E INSERTI IN NYLON - NYLON INSERTS AND HOLDERS

SOPORTES ENCASTRES DE NYLON - SUPORTES E INSERTOS EM NYLON

SUPPORTÉS ET MATRICES EN NYLON - HALTERPAAR UND KUNSTSTOFFMATRIZEN

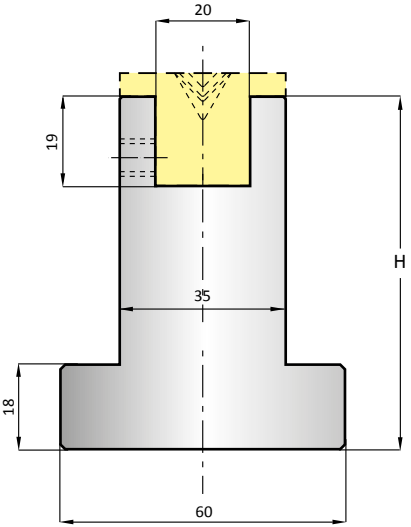
CONTENITORI E INSERTI IN NYLON

CODE	H	Mt
22.001	75.00	



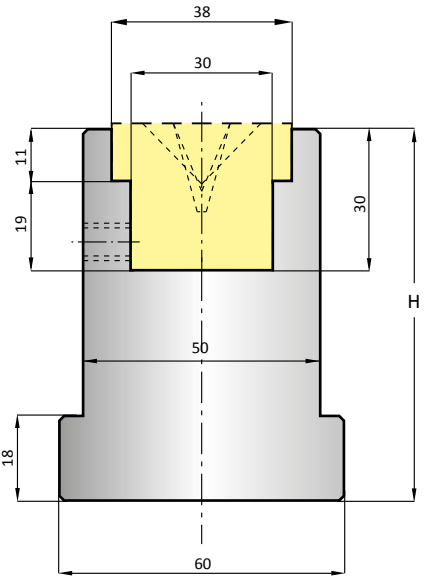
LENGTH 415 835

CODE	H	Mt
22.002	75.00	



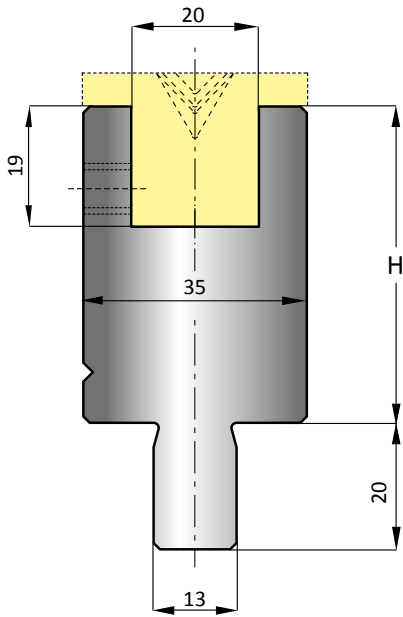
LENGTH 415 835

CODE	H	Mt
22.003	79.00	



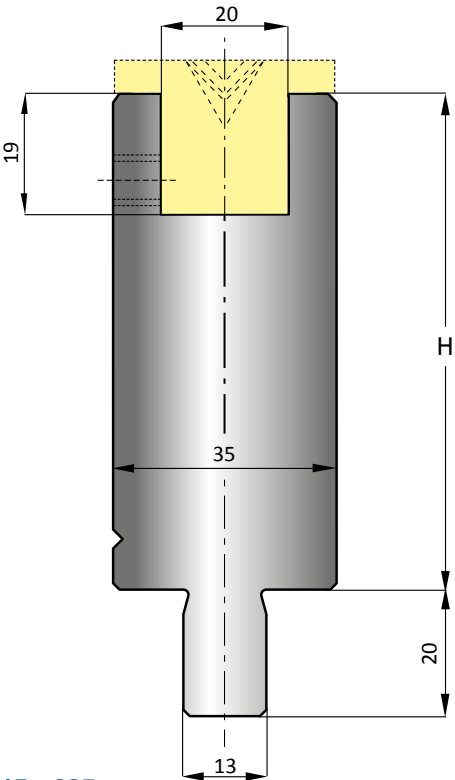
LENGTH 415 835

CODE	H	Mt
22.004	50.00	



LENGTH 415 835

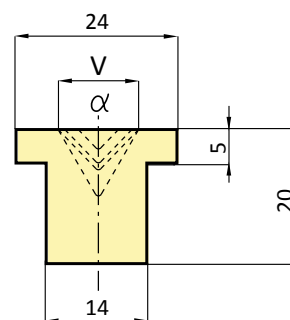
CODE	H	Mt
22.005	95.00	



LENGTH 415 835

INSERTI IN NYLON

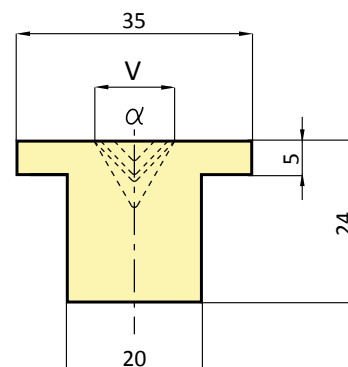
CODE	α	V	T/mt
31.306	30°	6	20
31.308	30°	8	20
31.406	45°	6	20
31.408	45°	8	20
31.410	45°	10	20
31.606	60°	6	20
31.608	60°	8	20
31.610	60°	10	20
31.806	88°	6	20
31.808	88°	8	20
31.810	88°	10	20



LENGTH 415 835

CODE	α	V	T/mt
32.306	30°	6	20
32.308	30°	8	20
32.310	30°	10	20
32.406	45°	6	20
32.408	45°	8	20
32.410	45°	10	20
32.412	45°	12	20
32.606	60°	6	20
32.608	60°	8	20
32.610	60°	10	20

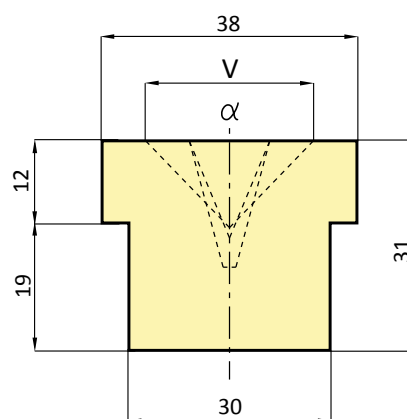
CODE	α	V	T/mt
32.612	60°	12	20
32.616	60°	16	20
32.806	88°	6	20
32.808	88°	8	20
32.810	88°	10	20
32.812	88°	12	20
32.816	88°	16	20



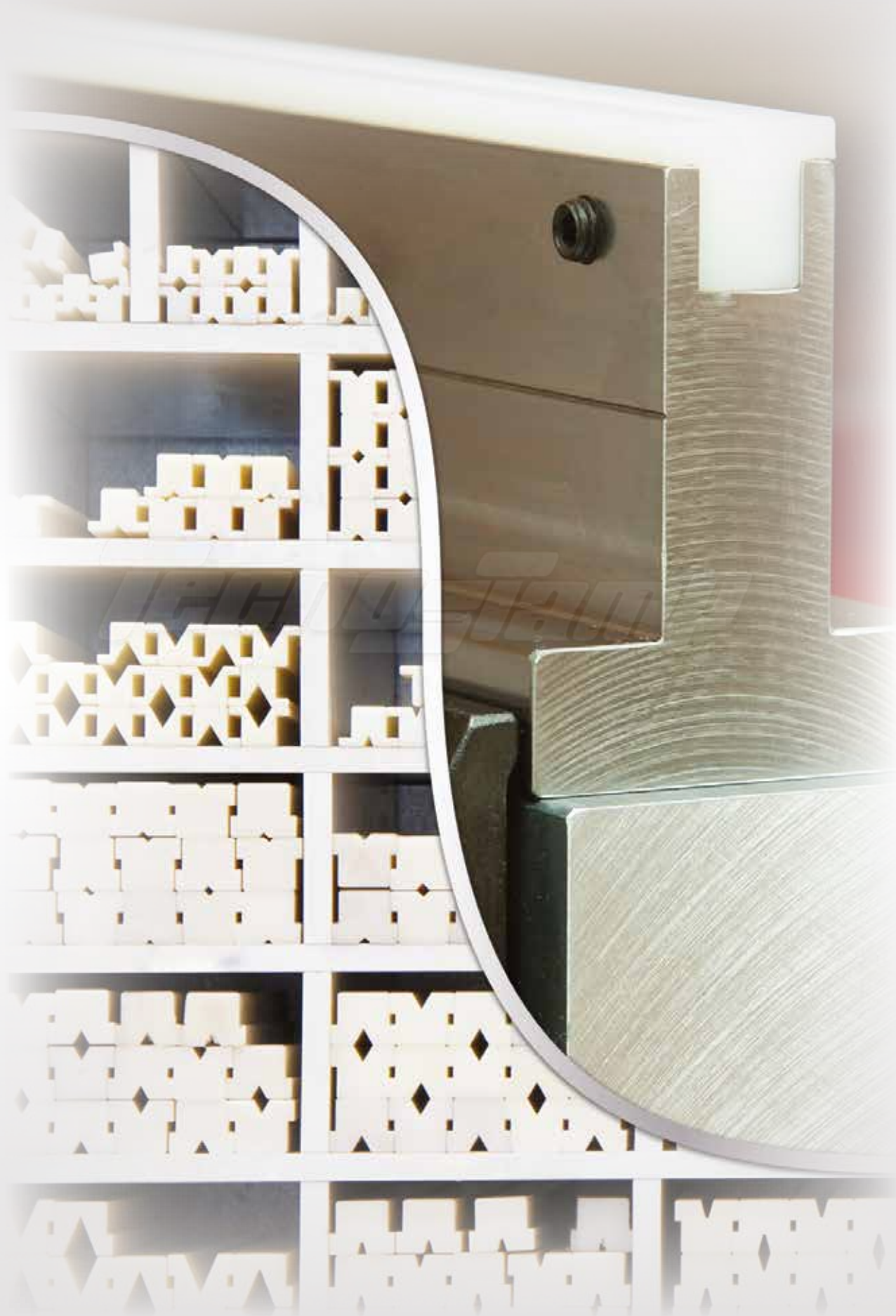
LENGTH 415 835

CODE	α	V	T/mt
33.306	30°	6	20
33.308	30°	8	20
33.310	30°	10	20
33.312	30°	12	20
33.316	30°	16	20
33.406	45°	6	20
33.408	45°	8	20
33.410	45°	10	20
33.412	45°	12	20
33.416	45°	16	20
33.420	45°	20	20
33.606	60°	6	20

CODE	α	V	T/mt
33.608	60°	8	20
33.610	60°	10	20
33.612	60°	12	20
33.616	60°	16	20
33.620	60°	20	20
33.806	88°	6	20
33.808	88°	8	20
33.810	88°	10	20
33.812	88°	12	20
33.816	88°	16	20
33.820	88°	20	20
33.825	88°	25	20



LENGTH 415 835



PELLICOLE ANTIGRAFFIO TENDIPELLICOLA



GREEN LINE

ACCESSORIES FOR ALL PRESS BRAKES

PELLICOLA ANTIGRAFFIO E TENDIPELLICOLA

PROTECTIVE FILM AND FOLDER FOR PROTECTIVE FILM

GOMAPROTECCIÓN Y TENSORES

PELÍCULA PROTETORA DE CHAPA E ESTICADOR DE PELÍCULA

FILM DE PROTECTION ET TENDEURS

ABKANTFOLIEN UND ABKANTFOLIENHALTER

PELLICOLE ANTIGRAFFIO IN POLIURETANO

PELLICOLA DI POLIURETANO ANTIGRAFFIO - FILM OF POLYURETHANE ANTISCRATCH - GOMA POLIURETANO ANTI MARCAS
 FITA PROTETORA EM POLIURETANO - FILM DE PROTECTION ANTI MARQUAGE - ABKANTFOLIEN



	LEGENDA	LEGEND	LEYENDA	LEGENDA	LÉGENDE	LEGENDE
S =	SPESSORE	THICKNESS	ESPESOR	ESPESSURA	ÉPAISSEUR	BLECHSTÄRKE
L =	LARGHEZZA	WIDTH	ANCHO	LARGURA	LARGEUR	WEITE



PELLICOLE ANTIGRAFFIO IN POLIURETANO

CODE	S	L
40.810	0.8	95



LENGTH | 33 mt

CODE	S	L
40.820	0.5	95



LENGTH | 33 mt

CODE	S	L
40.830	0.5	35



LENGTH | 33 mt

CODE	S	L
40.840	0.5	150



LENGTH | 33 mt

TENDIPELLICOLA STANDARD E MAGNETICO

TENDIPELLICOLA STANDARD E MAGNETICO - STANDARD AND MAGNETIC FILM HOLDER - TENSOR GOMA STANDARD Y MAGNÉTICO

ESTICADOR DE PELÍCULA STANDARD E MAGNÉTICO - TENDEURS STANDARDS ET MAGNÉTIQUES POUR FILM DE PROTECTION - ABKANTFOLIENHALTER, STANDARD UND MAGNETISCH

CODE

40.800



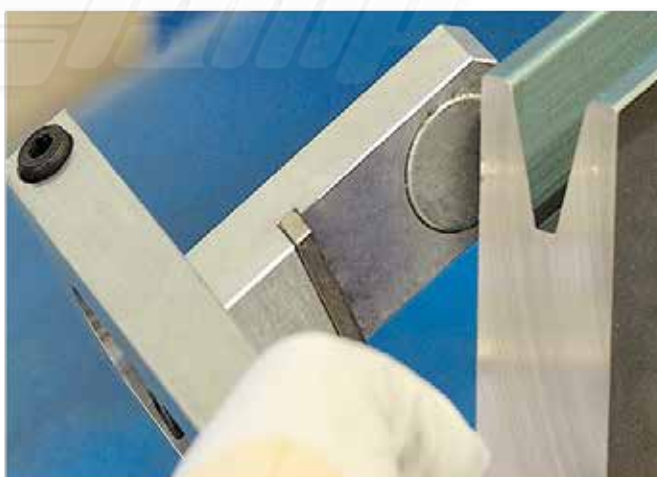
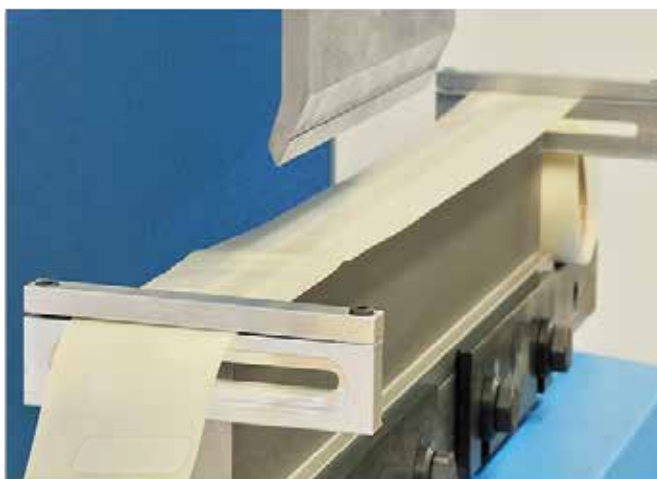
STANDARD SYSTEM

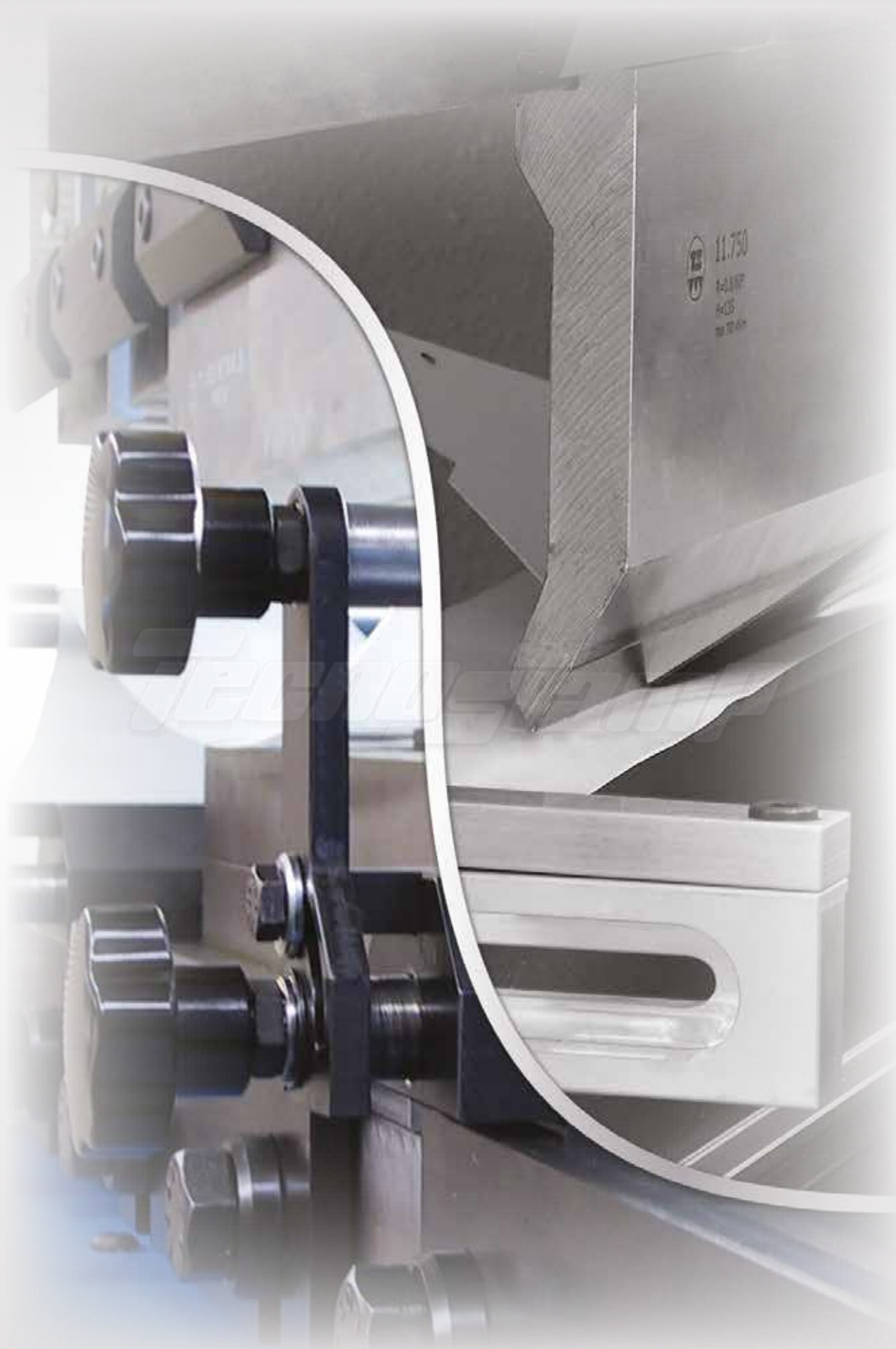
CODE

40.850



MAGNETIC SYSTEM





I NOSTRI CATALOGHI

I CATALOGHI SONO DISPONIBILI SUL SITO WEB - THE CATALOGS ARE AVAILABLE ON THE WEBSITE

LOS CATÁLOGOS ESTÁN DISPONIBLES EN EL SITIO WEB - OS CATÁLOGOS ESTÃO DISPONÍVEIS NO SITE

LES CATALOGUES SONT DISPONIBLES SUR LE SITE WEB - DIE KATALOGE SIND AUF DER WEBSITE VERFÜGBAR



RED LINE

AMADA - PROMECAM STYLE



BLUE LINE

WILA - TRUMPF STYLE



ORANGE LINE

BYSTRONIC - BEYELER STYLE



RAINBOW LINE

LVD - EHT - WEINBRENNER - NEWTON STYLE



BLACK LINE

AMERICAN STYLE



CORAL LINE

NO MARKING TOOLS

I NOSTRI CATALOGHI

I CATALOGHI SONO DISPONIBILI SUL SITO WEB - THE CATALOGS ARE AVAILABLE ON THE WEBSITE

LOS CATÁLOGOS ESTÁN DISPONIBLES EN EL SITIO WEB - OS CATÁLOGOS ESTÃO DISPONÍVEIS NO SITE

LES CATALOGUES SONT DISPONIBLES SUR LE SITE WEB - DIE KATALOGE SIND AUF DER WEBSITE VERFÜGBAR



MAGENTA LINE

ADAPTERS FOR ALL PRESS BRAKES



YELLOW LINE

RECTILINEAR BLADES



GREEN LINE

ACCESSORIES FOR ALL PRESS BRAKES



SILVER LINE

WORKING - MODIFICATION - REFURBISHED TOOLING



GOLD LINE

SPECIAL TOOLING FOR ALL PRESS BRAKES



QR CODE

GO TO THE WEBSITE WWW.TECNOSTAMP.EU

INDEX CODE

CODE	α	PAGE	CODE	α	PAGE
20.270	80°	14	32.610	60°	25
20.271		21	32.612	60°	25
20.272		21	32.616	60°	25
20.273		21	32.806	88°	25
20.274		21	32.808	88°	25
20.289		21	32.810	88°	25
20.290		21	32.812	88°	25
20.291		21	32.816	88°	25
20.292		21	33.306	30°	25
20.701		15	33.308	30°	25
20.703		15	33.310	30°	25
20.705		15	33.312	30°	25
20.707		15	33.316	30°	25
20.709		15	33.406	45°	25
20.725	80°	14	33.408	45°	25
20.732	80°	15	33.410	45°	25
21.280		20	33.412	45°	25
21.289		21	33.416	45°	25
21.290		21	33.420	45°	25
21.291		21	33.606	60°	25
21.292		21	33.608	60°	25
22.001		24	33.610	60°	25
22.002		24	33.612	60°	25
22.003		24	33.616	60°	25
22.004		24	33.620	60°	25
22.005		24	33.806	88°	25
29.000	40°	10	33.808	88°	25
29.100	60°	10	33.810	88°	25
29.150	60°	10	33.812	88°	25
29.200	60°	11	33.816	88°	25
29.300	60°	11	33.820	88°	25
31.306	30°	25	33.825	88°	25
31.308	30°	25	40.800		29
31.406	45°	25	40.810		28
31.408	45°	25	40.820		28
31.410	45°	25	40.830		28
31.606	60°	25	40.840		28
31.608	60°	25	40.850		29
31.610	60°	25	60.401		17
31.806	88°	25	60.402		17
31.808	88°	25	60.403		17
31.810	88°	25	60.409		16
32.306	30°	25	60.411		16
32.308	30°	25	60.412		16
32.310	30°	25	60.413		16
32.406	45°	25	60.910		11
32.408	45°	25	60.920		11
32.410	45°	25	60.935		12
32.412	45°	25	60.940		12
32.606	60°	25	60.950		12
32.608	60°	25			

Tecno-Tamp



**Via Vittime della Pertite, 71
29121 Piacenza ITALIA**

Tel +39 0523 499712 - Fax +39 0523 497020
www.tecnostamp.eu - tecnostamp@tecnostamp.it