

BYSTRONIC STYLE

TOP spol. s r.o.
LANTIS

Press brake tooling and equipment

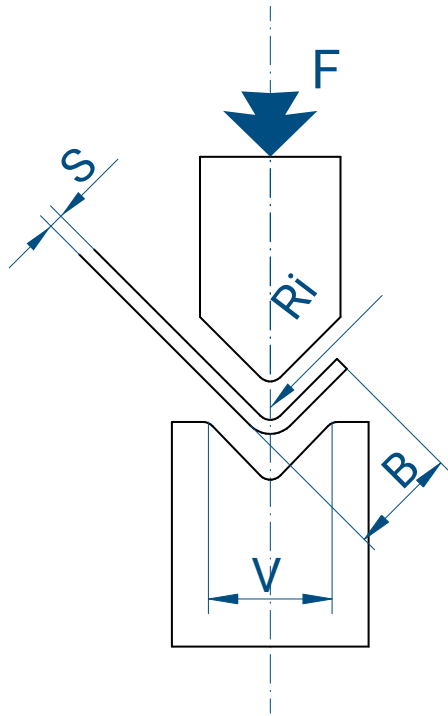
**UTENSILI E
ATTREZZATURE
PER PRESSE PIEGATRICI**

TOP
LAN TIS spol. s r.o.



Calcolo della forza di piega in aria

Air bending force calculation



S	Spessore lamiera - mm Sheet metal thickness - mm	Ri	Raggio interno Inside radius
V	Larghezza del V V-opening	R	Alluminio 20-25 kg/mm ² Aluminium 20-25 kg/mm ²
F	Forza in T/m Force in T/m	R	Acciaio dolce 40-45 kg/mm ² Mild steel 40-45 kg/mm ²
B	Bordo minimo Shortest edge	R	Inox 65-70 kg/mm ² Stainless steel 65-70 kg/mm ²

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

Relazione tra spessore lamiera e larghezza V

Sheet metal thickness/V-shape width ratio

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

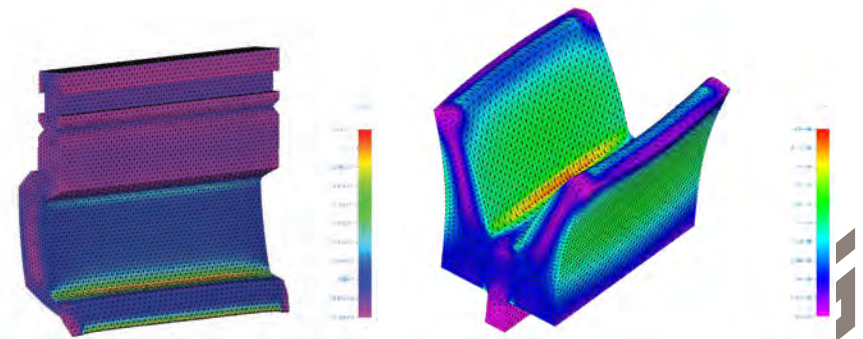


Tabella di piegatura in aria - Acciaio dolce / Air bending table - Mild Steel

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

t/m

Tabella di piegatura in aria - Acciaio inox / Air bending table - Stainless Steel

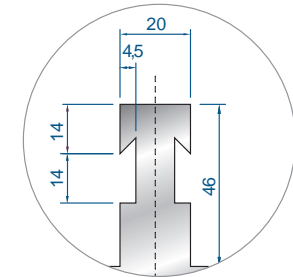
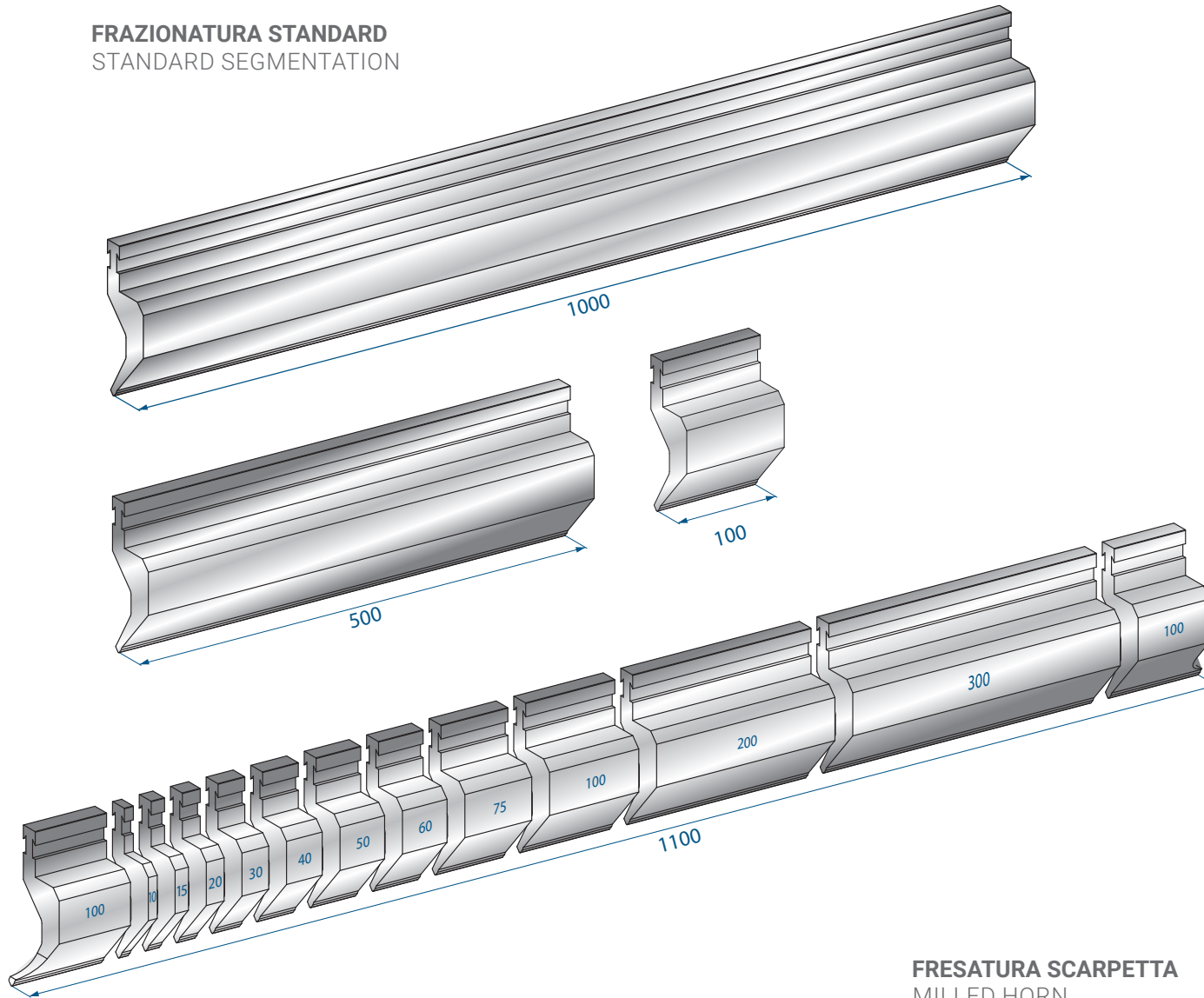
S			mm	0,5	0,6	0,8	1	1,2	1,5	2	2,5	3	4	5	6	8	10	12	15	20	25	30	
6	4	1		5	6	11	17	25															
8	5,5	1,3			6	8	12	19	26														
10	7	1,6				6	11	16	23	42													
12	8,5	2					9	12	20	34	54												
16	11	2,6						9	14	26	40	59											
20	14	3,3							12	20	33	47	84										
25	17,5	4								17	26	37	65	104									
32	22	5									20	30	53	81	117								
40	28	6,5										23	42	65	93	166							
50	35	8											33	51	75	132	208						
63	45	10												40	59	106	163						
80	55	13													47	82	132	187					
100	71	16														67	104	149	233				
125	89	20															82	121	187	334			
160	113	26																93	148	264	412		
200	140	33																	117	210	327	467	
250	175	41																		168	264	373	
320	226	53																			132	202	296
V	B	Ri																					F

t/m

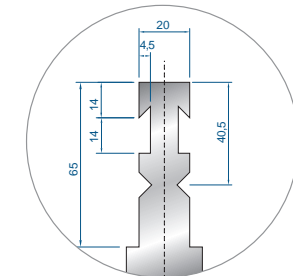
BYSTRONIC

PUNZONI / PUNCHES	10	• Punzoni / Punch type RF-A 30°	23-25
• Frazionatura standard / Standard segmentation	10	MATICI / DIES	27
• Modifiche a richiesta / Modifications on request	11	• Frazionatura standard / Standard segmentation	27
BYSTRONIC R		• Modifiche a richiesta / Modifications on request	29
• Punzoni / Punch type R 86°	13	• Matrici 1V / 1V dies 88°	31-35
• Punzoni / Punch type R 85°	14-15	• Matrici 1V / 1V dies 85°	37
• Punzoni / Punch type R 30°	17-19	• Matrici 1V / 1V dies 60°	39
• Punzoni / Punch type R 28°	20	• Matrici 1V / 1V dies 30°	41-47
BYSTRONIC RF-A		• Piegaschiaccia / Flattening hemming tools	49-50
• Punzoni / Punch type RF-A 88°	21		

FRAZIONATURA STANDARD
STANDARD SEGMENTATION

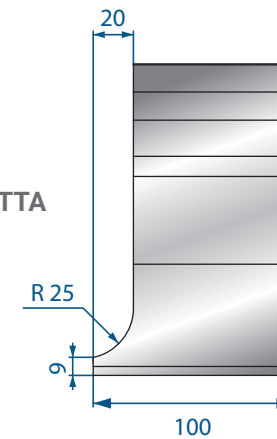


BYSTRONIC R
pagina / page 13

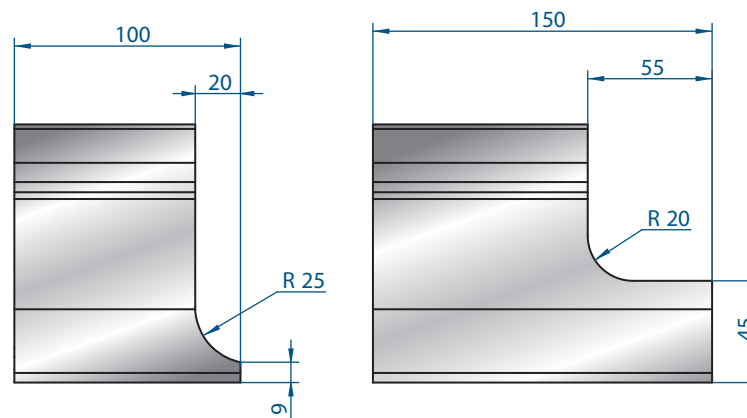


BYSTRONIC RF-A
pagina / page 21

FRESATURA SCARPETTA
MILLED HORN



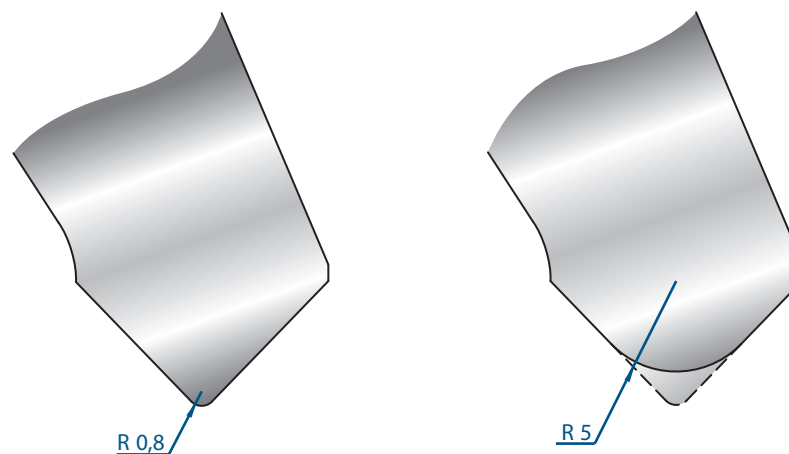
SCARPETTE SPECIALI
SPECIAL HORNS

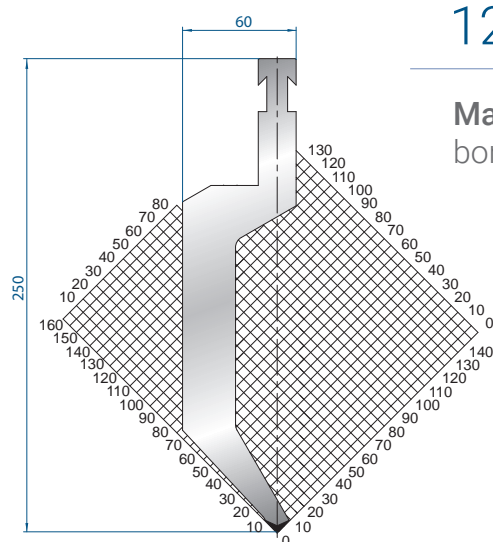


TAGLI A RICHIESTA
SPECIAL SEGMENTATION



MODIFICA RAGGIO
RADIUS MODIFICATION





1298

Mat = 42CrMo4
bonificato / tempered

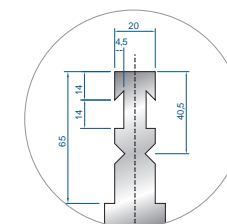
H = 250.00

Max T/m = 60

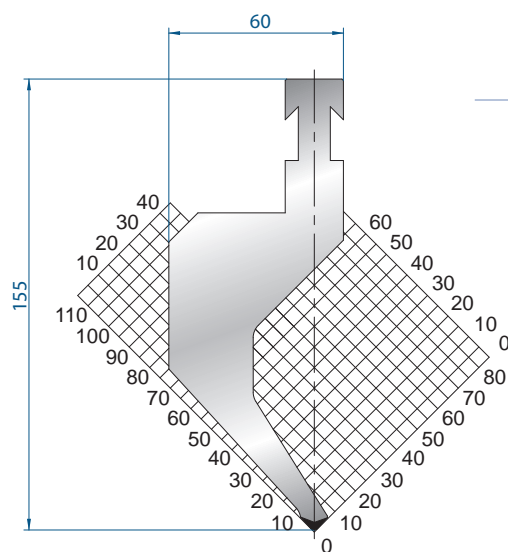
α = 86°

R = 1.5

500 mm	25,0 kg
1100 mm FRAZ. / SECT.	55,0 kg
100 mm	5,0 kg



ATTACCO RF-A
INCLUSO SU RICHIESTA
RF-A TANG INCLUDED
ON DEMAND



1216

Mat = C45
bonificato / tempered

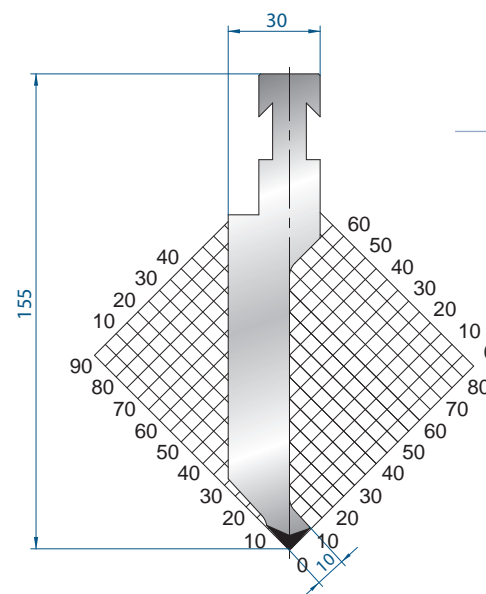
H = 155.00

Max T/m = 50

$\alpha = 85^\circ$

R = 1.5

1000 mm	30,0 kg
500 mm	15,0 kg
1100 mm FRAZ. / SECT.	30,0 kg
100 mm	3,0 kg



1218

Mat = C45
bonificato / tempered

H = 155.00

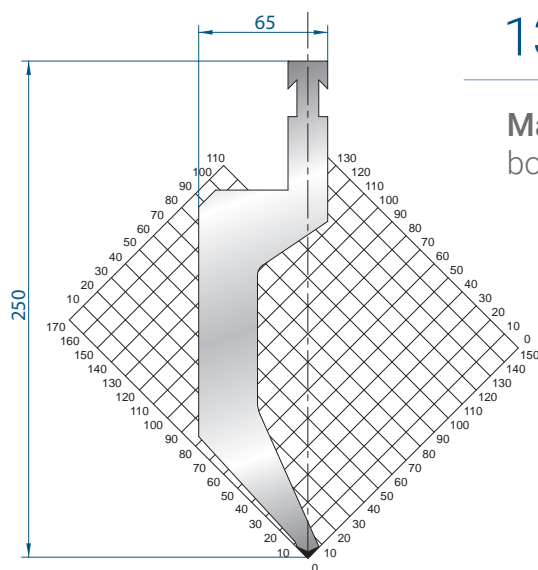
Max T/m = 100

$\alpha = 85^\circ$

R = 1

1000 mm	23,0 kg
500 mm	12,5 kg
1100 mm FRAZ. / SECT.	30,0 kg
100 mm	3,0 kg





1321

Mat = 42CrMo4
bonificato / tempered

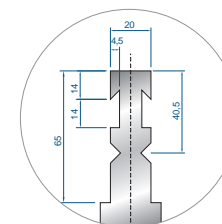
H = 250.00

Max T/m = 100

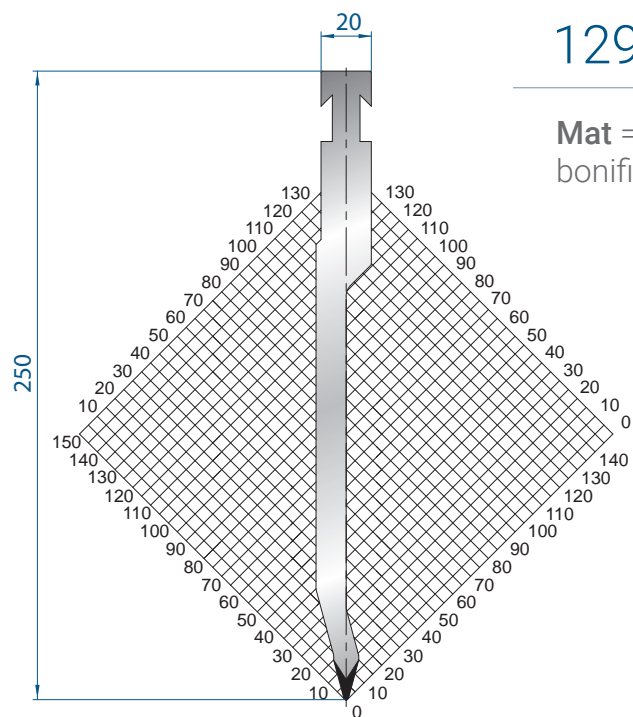
α = 85°

R = 1.5

500 mm	27,9 kg
1100 mm FRAZ. / SECT.	61,0 kg
100 mm	5,6 kg



ATTACCO RF-A
INCLUSO SU RICHIESTA
RF-A TANG INCLUDED
ON DEMAND



1299

Mat = 42CrMo4
bonificato / tempered

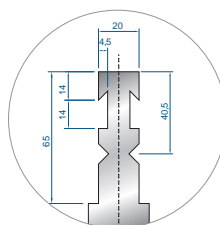
H = 250.00

Max T/m = 80

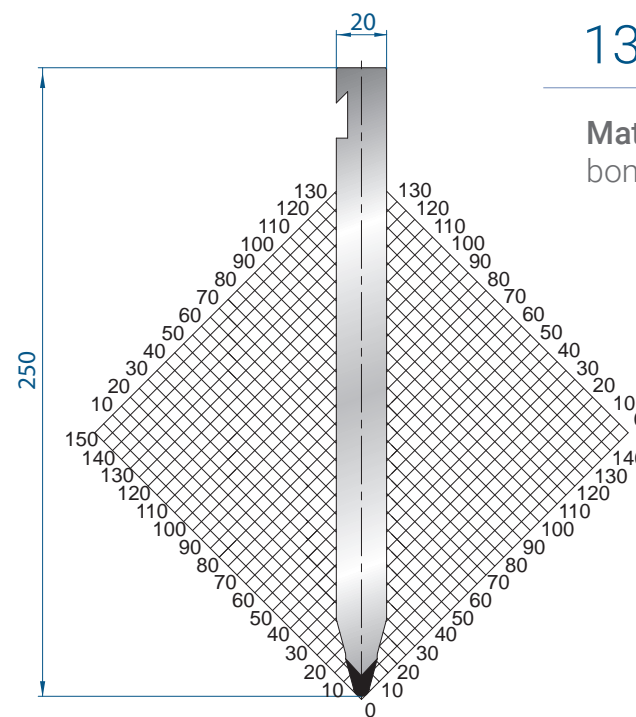
$\alpha = 30^\circ$

R = 1

500 mm	13,3 kg
1100 mm FRAZ. / SECT.	29,2 kg
100 mm	2,6 kg



ATTACCO RF-A
INCLUSO SU RICHIESTA
RF-A TANG INCLUDED
ON DEMAND



1300

Mat = 42CrMo4
bonificato / tempered

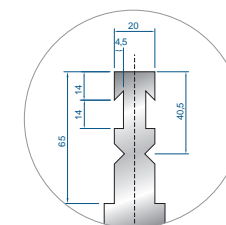
H = 250.00

Max T/m = 120

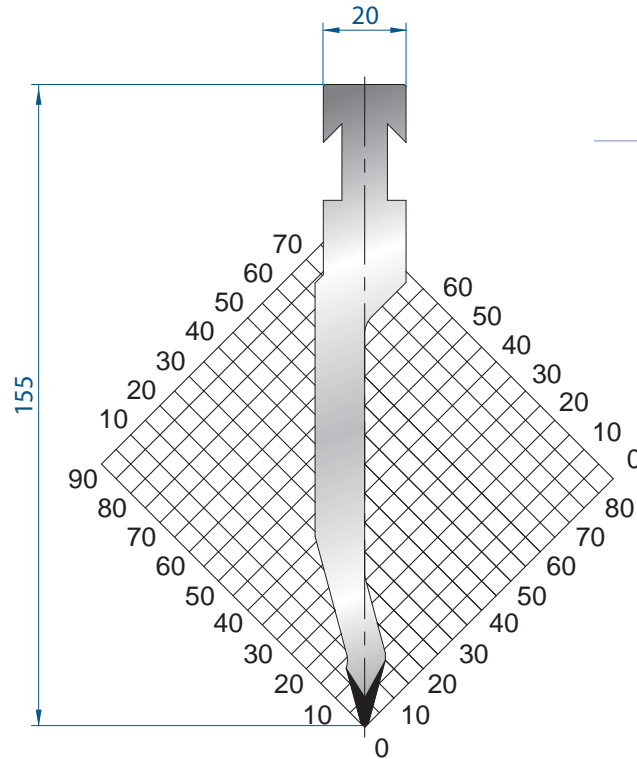
$\alpha = 30^\circ$

R = 3

500 mm	21,0 kg
1100 mm FRAZ. / SECT.	46,0 kg
100 mm	4,2 kg



ATTACCO RF-A
INCLUSO SU RICHIESTA
RF-A TANG INCLUDED
ON DEMAND

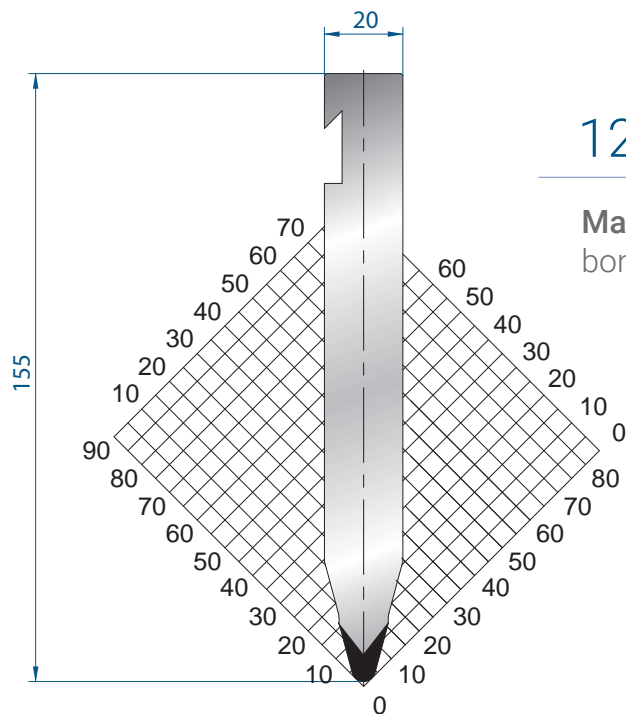


1220

Mat = C45
 bonificato / tempered
H = 155.00
Max T/m = 80
 α = 30°
R = 1

1000 mm	16,0 kg
500 mm	8,0 kg
1100 mm FRAZ. / SECT.	16,0 kg
100 mm	1,6 kg

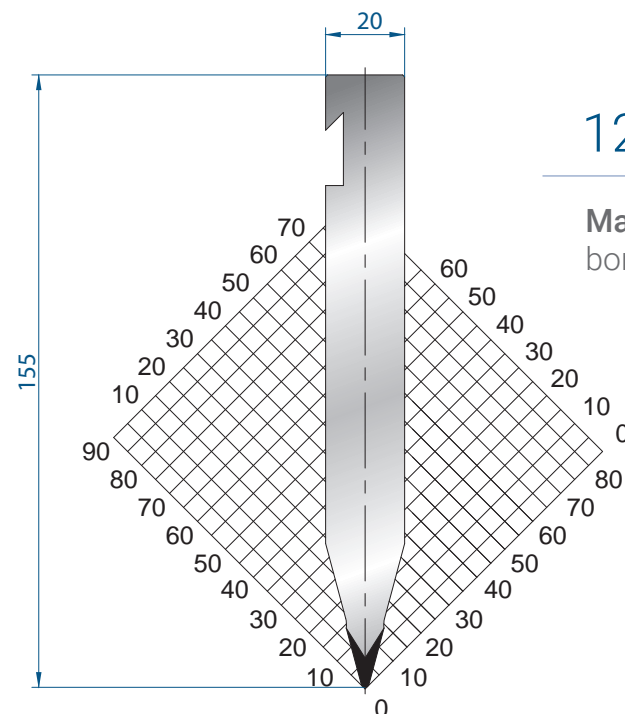




1225

Mat = C45
 bonificato / tempered
H = 155.00
Max T/m = 100
 $\alpha = 30^\circ$
R = 3

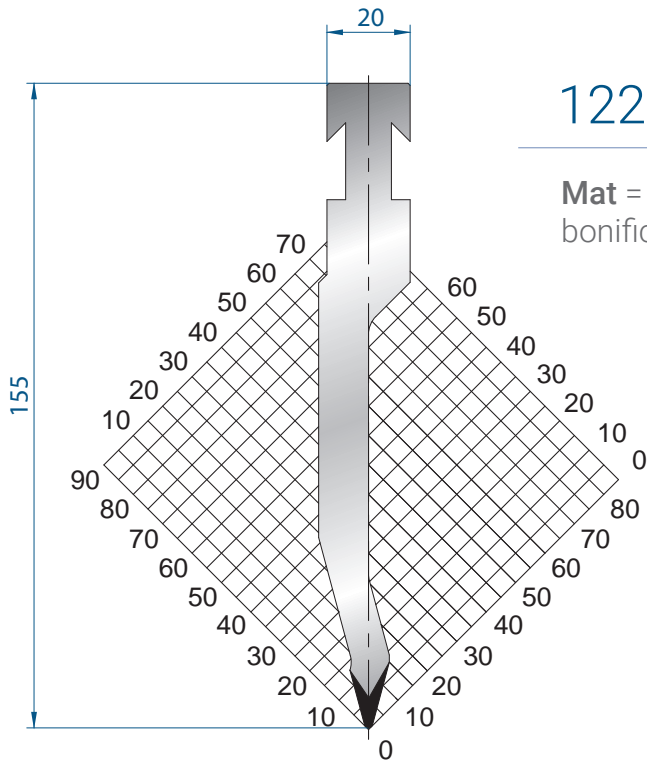
1000 mm	16,0 kg
500 mm	8,0 kg
1100 mm FRAZ. / SECT.	16,0 kg
100 mm	1,6 kg



1226

Mat = C45
 bonificato / tempered
H = 155.00
Max T/m = 100
 $\alpha = 30^\circ$
R = 1

1000 mm	21,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	21,0 kg
100 mm	2,0 kg

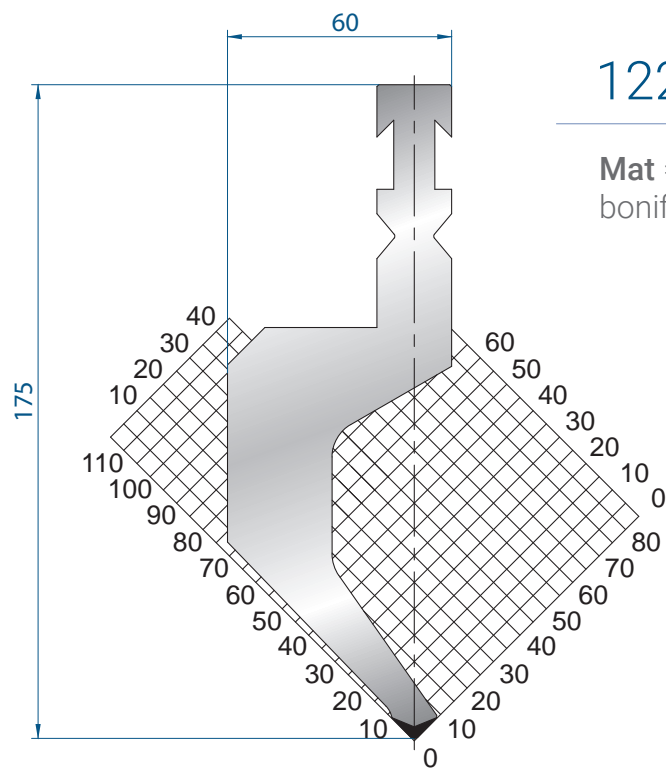


1221

Mat = C45
bonificato / tempered
H = 155.00
Max T/m = 80
 α = 28°
R = 1

1000 mm	16,0 kg
500 mm	8,0 kg
1100 mm FRAZ. 7 SECT.	16,0 kg
100 mm	1,6 kg

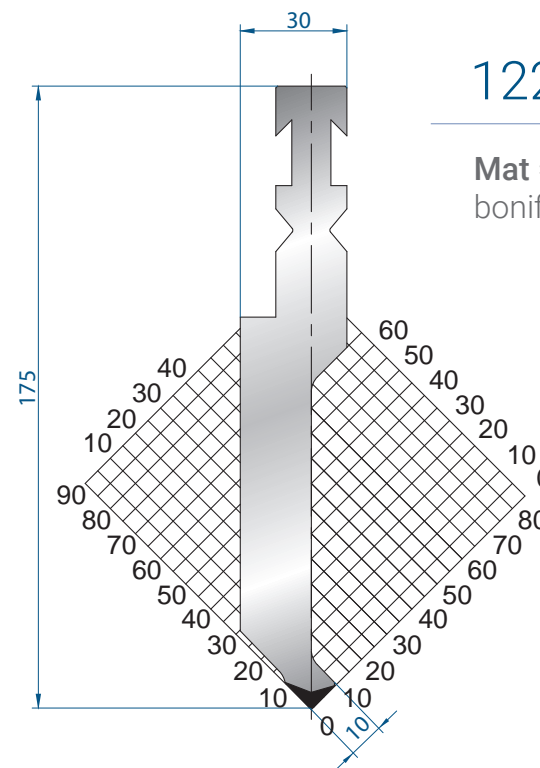




1227

Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 50
α = 88°
R = 1.5

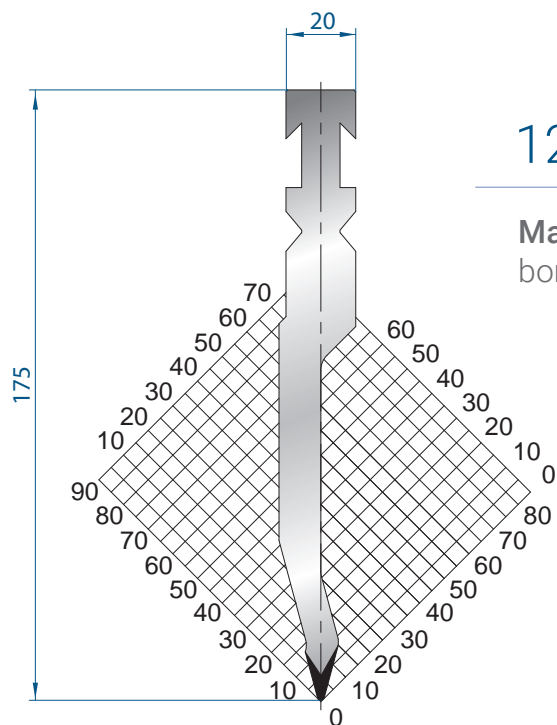
1000 mm	33,0 kg
500 mm	16,0 kg
1100 mm FRAZ. / SECT.	33,0 kg
100 mm	3,2 kg



1229

Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 100
α = 88°
R = 1

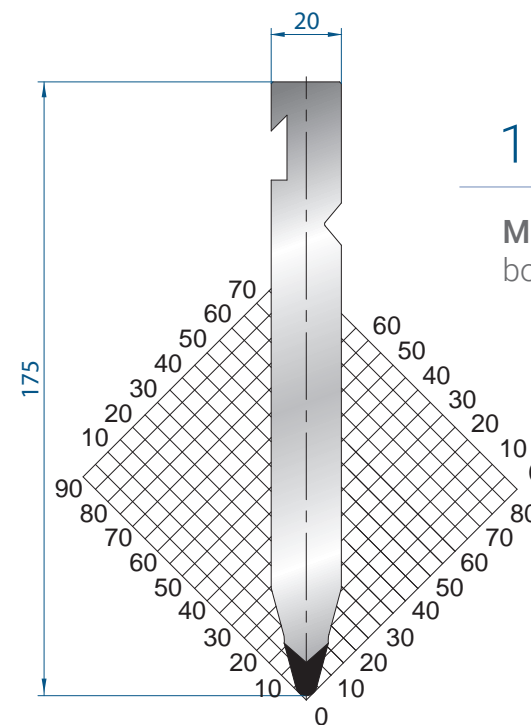
1000 mm	26,0 kg
500 mm	13,0 kg
1100 mm FRAZ. / SECT.	26,0 kg
100 mm	2,6 kg



1230

Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 80
 $\alpha = 30^\circ$
R = 1

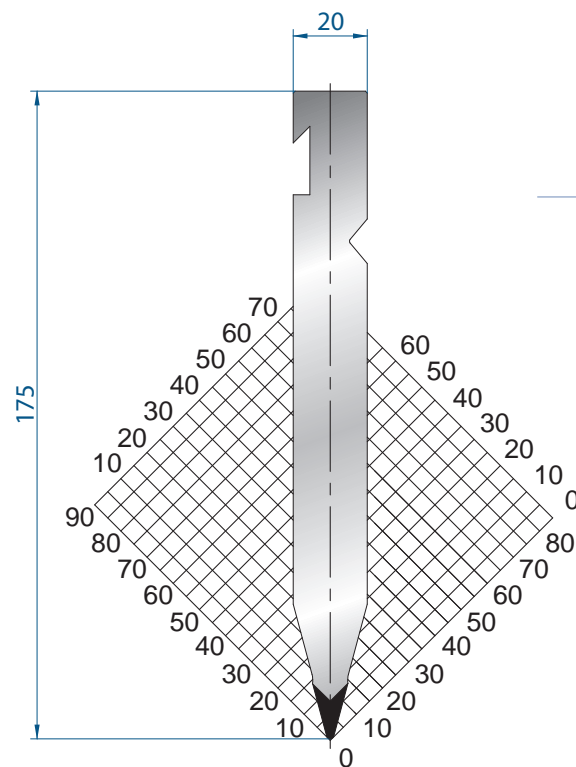
1000 mm	16,0 kg
500 mm	8,0 kg
1100 mm FRAZ. / SECT.	16,0 kg
100 mm	1,6 kg



1231

Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 100
 $\alpha = 30^\circ$
R = 3

1000 mm	25,0 kg
500 mm	12,0 kg
1100 mm FRAZ. / SECT.	25,0 kg
100 mm	2,4 kg

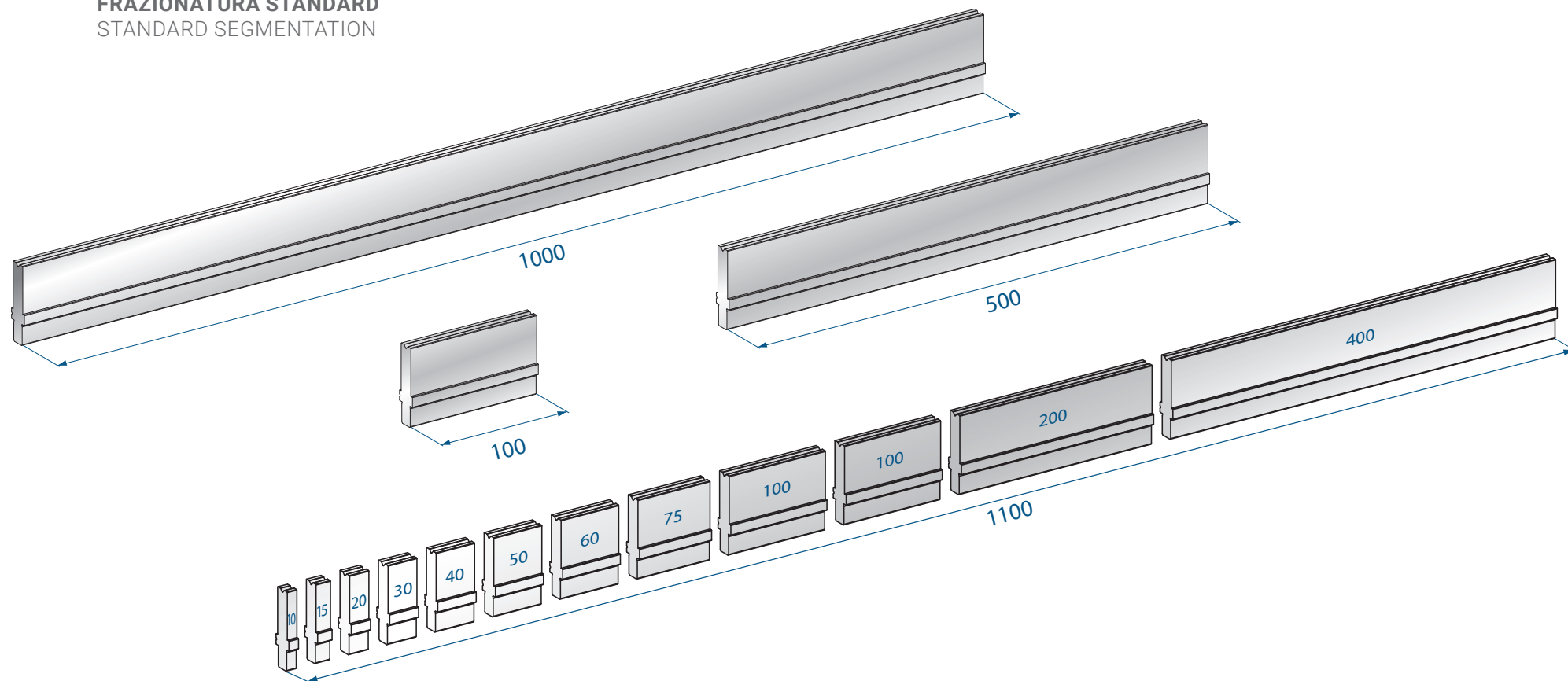


1232

Mat = C45
 bonificato / tempered
H = 175.00
Max T/m = 100
 α = 30°
R = 1

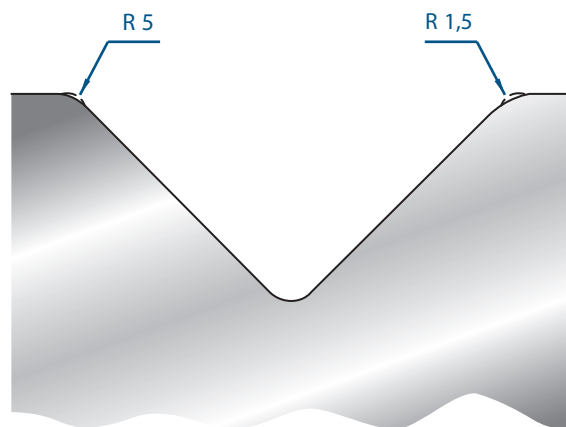
1000 mm	25,0 kg
500 mm	12,0 kg
1100 mm <small>FRAZ. / SECT.</small>	25,0 kg
100 mm	2,4 kg

FRAZIONATURA STANDARD
STANDARD SEGMENTATION

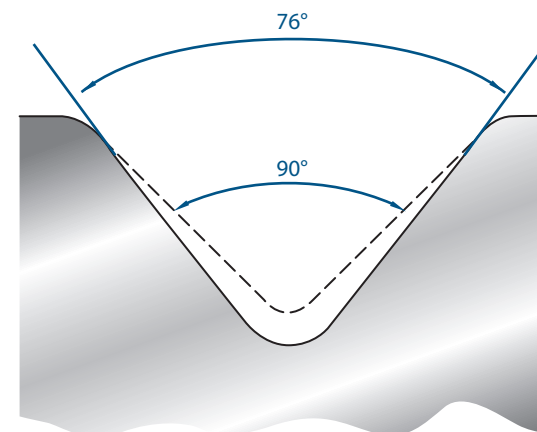




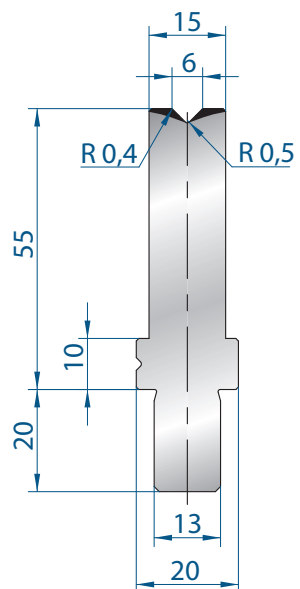
TAGLI A RICHIESTA
SPECIAL SEGMENTATION



MODIFICA RAGGIO
RADIUS MODIFICATION



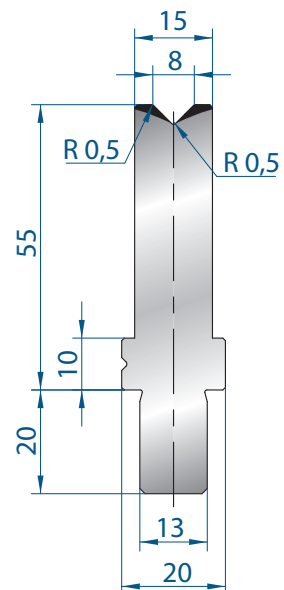
MODIFICA ANGOLO
ANGLE MODIFICATION



3241

Mat = C45
Max T/m = 100
α = 88°

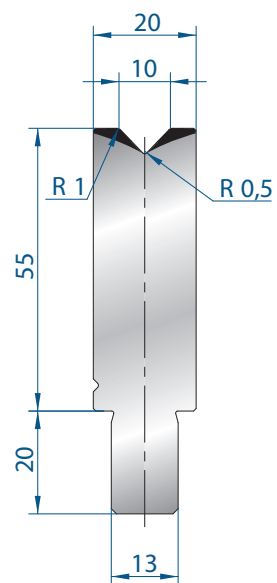
1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg



3242

Mat = C45
Max T/m = 100
α = 88°

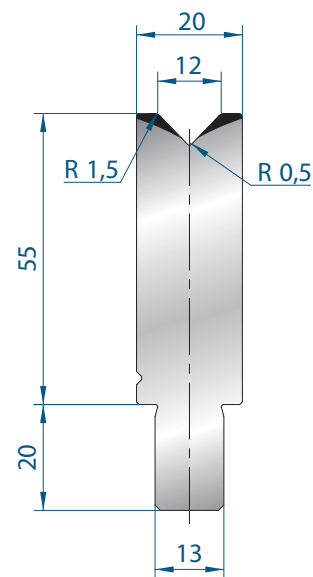
1000 mm	9,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	9,0 kg
100 mm	0,8 kg



3106

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

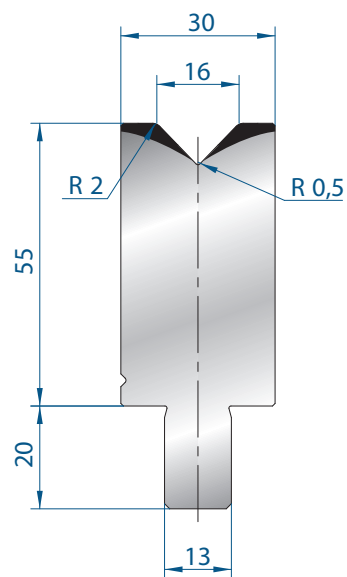
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	1,0 kg



3107

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

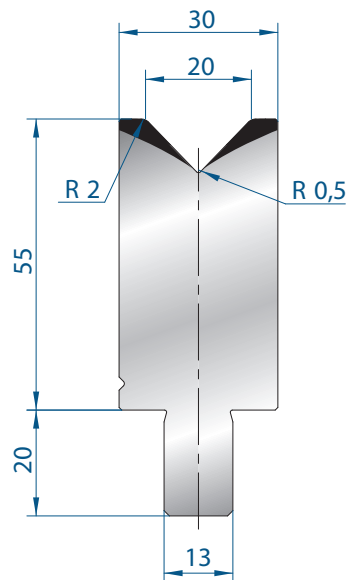
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	1,0 kg



3108

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

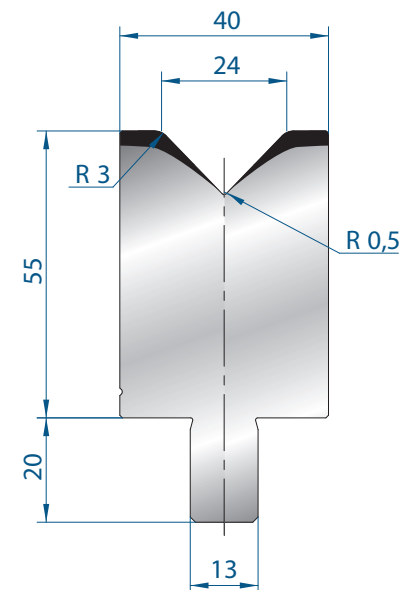
1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



3109

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

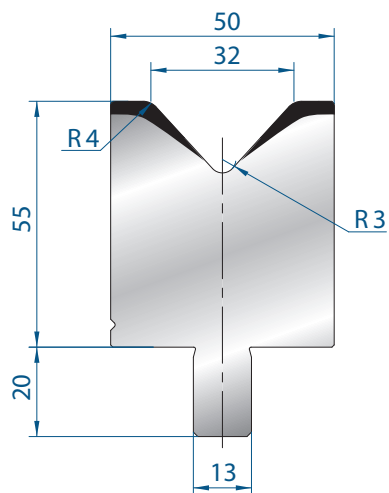
1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



3110

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

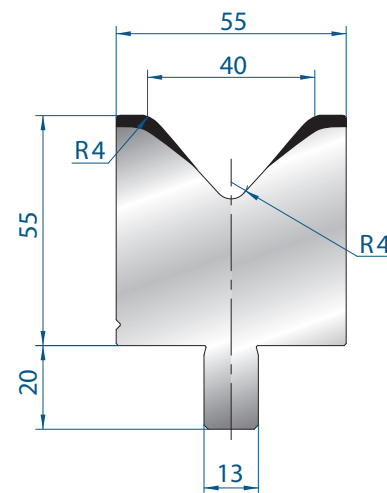
1000 mm	18,0 kg
500 mm	9,0 kg
1100 mm FRAZ. / SECT.	18,0 kg
100 mm	1,8 kg



3111

Mat = C45
Max T/m = 100
 $\alpha = 85^\circ$

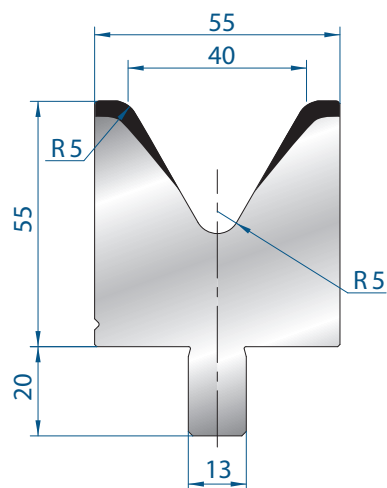
1000 mm	21,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	21,0 kg
100 mm	2,0 kg



3112

Mat = C45
Max T/m = 100
 $\alpha = 85^\circ$

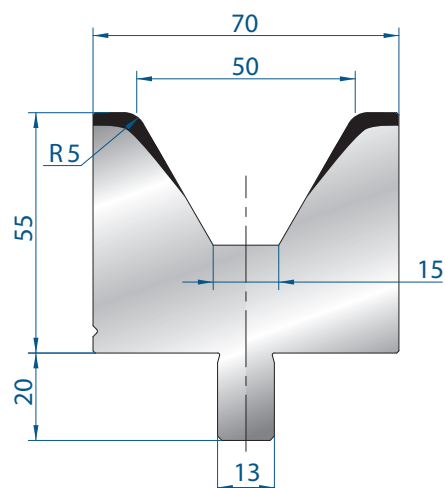
1000 mm	21,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	21,0 kg
100 mm	2,0 kg



3113

Mat = C45
Max T/m = 100
 $\alpha = 60^\circ$

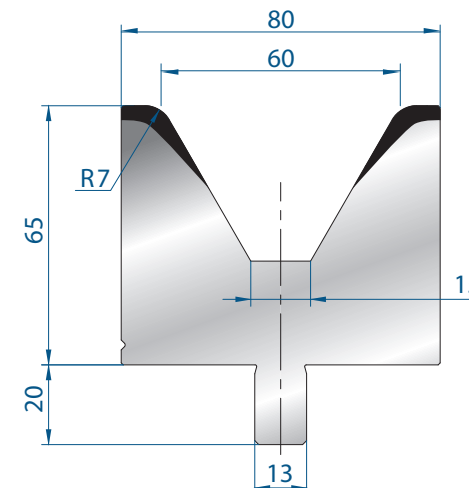
1000 mm	20,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	20,0 kg
100 mm	2,0 kg



3179

Mat = C45
Max T/m = 100
 $\alpha = 60^\circ$

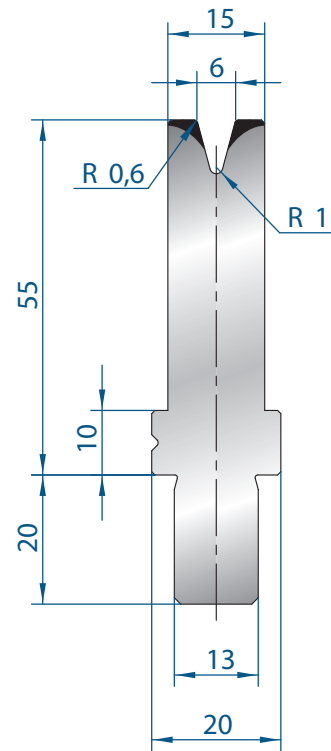
1000 mm	24,0 kg
500 mm	12,0 kg
1100 mm FRAZ. / SECT.	24,0 kg
100 mm	2,4 kg



3114

Mat = C45
Max T/m = 100
 $\alpha = 60^\circ$

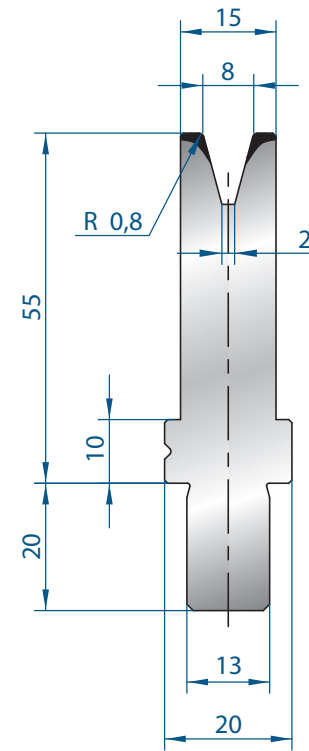
1000 mm	31,0 kg
500 mm	15,0 kg
1100 mm FRAZ. / SECT.	31,0 kg
100 mm	3,0 kg



3115

Mat = C45
Max T/m = 35
 $\alpha = 30^\circ$

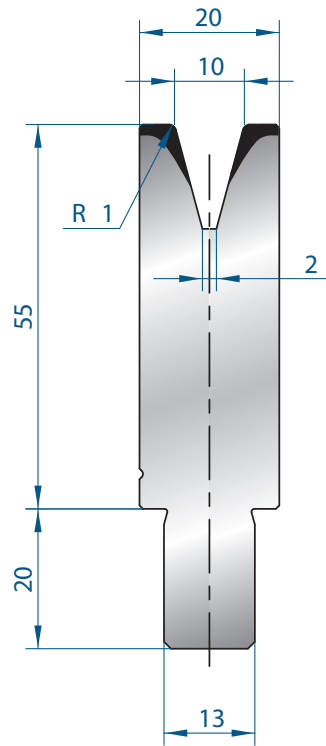
1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg



3116

Mat = C45
Max T/m = 40
 $\alpha = 30^\circ$

1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg



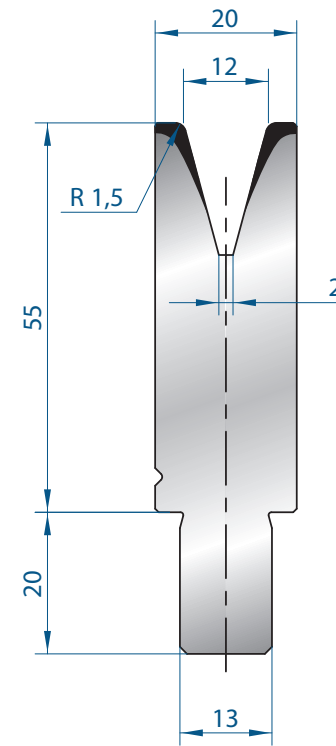
3117

Mat = C45

Max T/m = 50

$\alpha = 30^\circ$

1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	2,5 kg



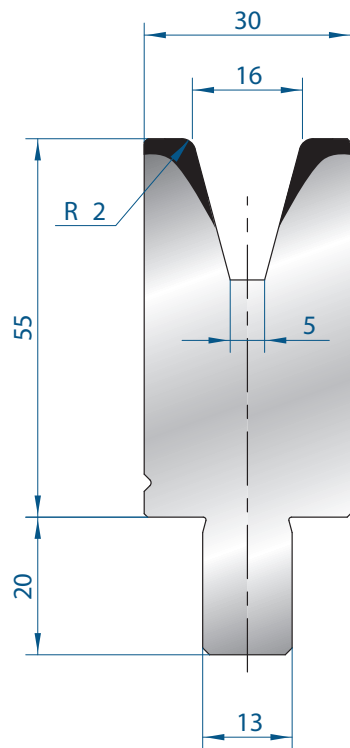
3118

Mat = C45

Max T/m = 40

$\alpha = 30^\circ$

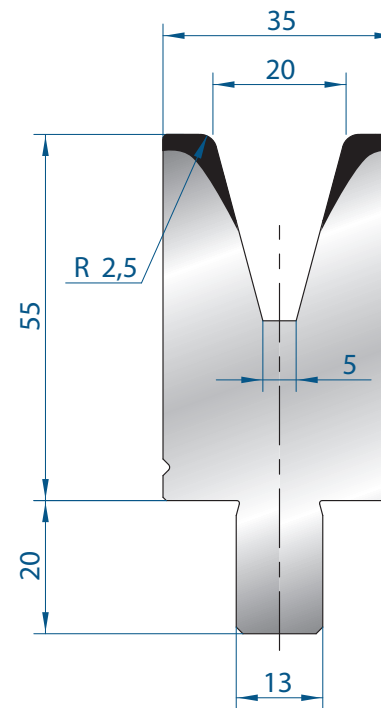
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	2,5 kg



3119

Mat = C45
Max T/m = 50
 $\alpha = 30^\circ$

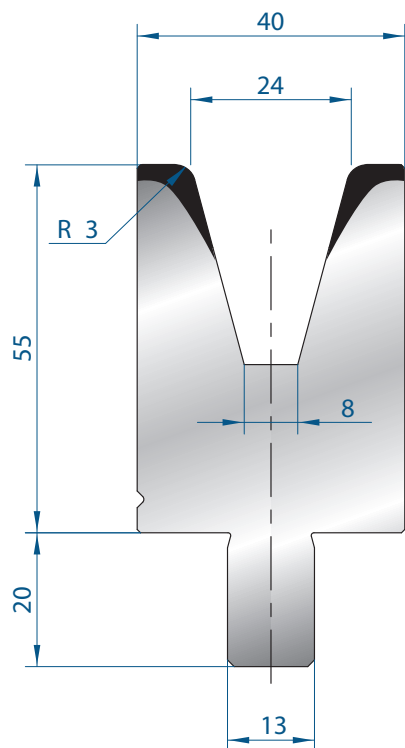
1000 mm	13,0 kg
500 mm	6,0 kg
1100 mm FRAZ. / SECT.	13,0 kg
100 mm	1,2 kg



3120

Mat = C45
Max T/m = 55
 $\alpha = 30^\circ$

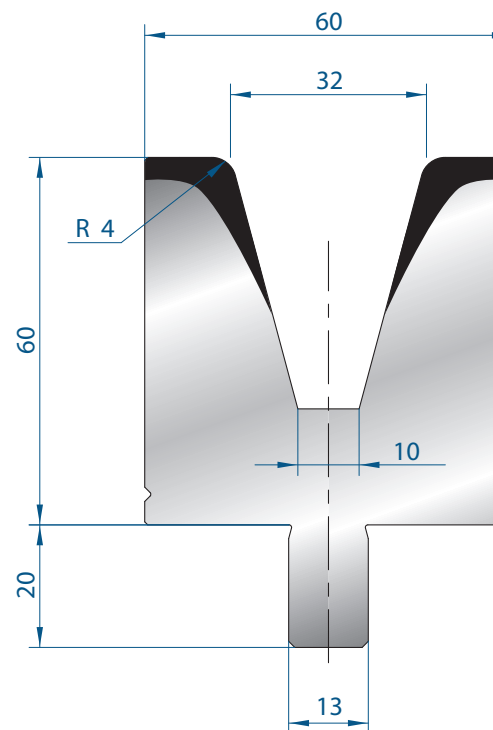
1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



3121

Mat = C45
Max T/m = 65
 $\alpha = 30^\circ$

1000 mm	15,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	15,0 kg
100 mm	1,4 kg

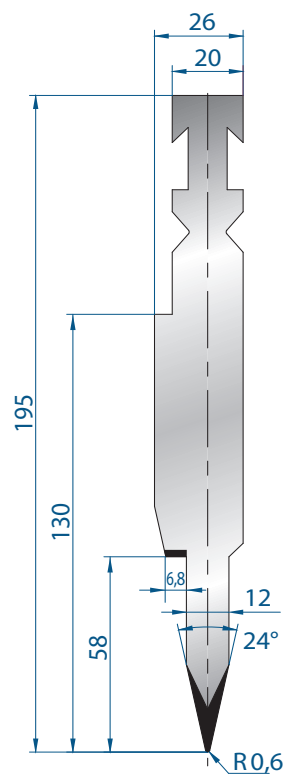


3122

Mat = C45
Max T/m = 65
 $\alpha = 30^\circ$

1000 mm	23,0 kg
500 mm	11,0 kg
1100 mm FRAZ. / SECT.	23,0 kg
100 mm	2,2 kg

500-550 Frazionato (Bonificato) / Sectioned (Quenched)

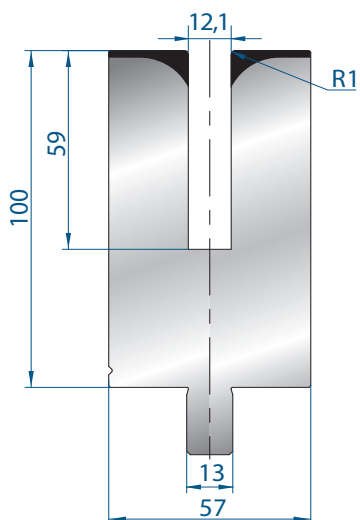


1254

Mat = C45
bonificato / tempered
Max T/m = 80

500 mm	14,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	2,8 kg

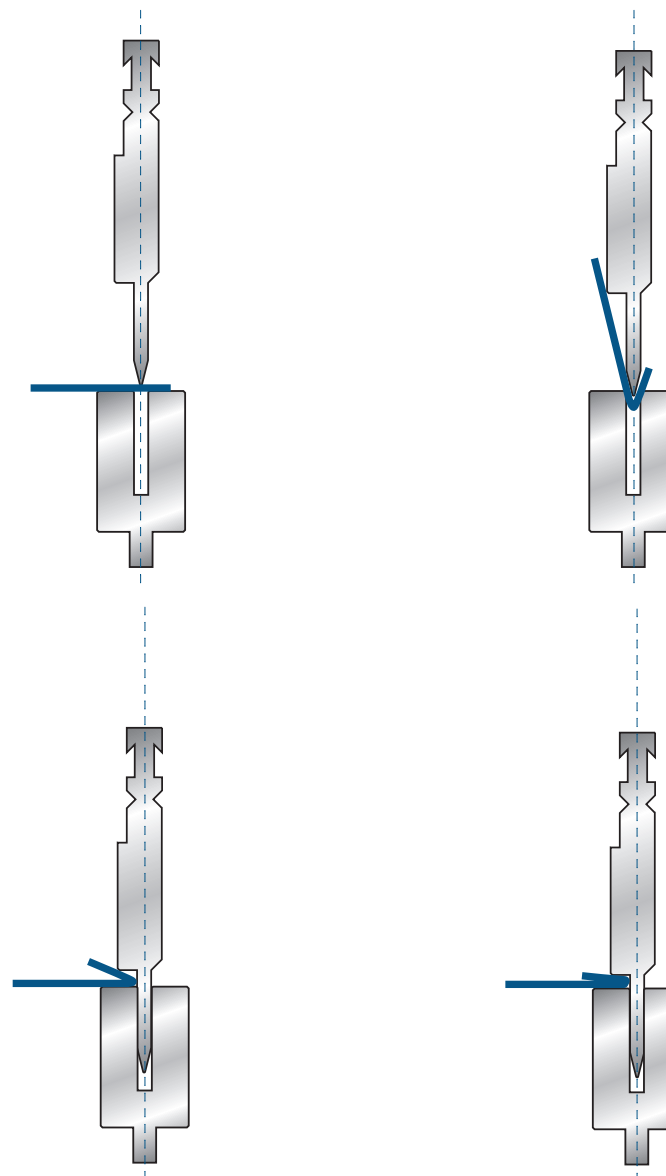
Spessore:
Max 1,5 mm Ferro
Thickness
Max 1,5 mm Mild steel

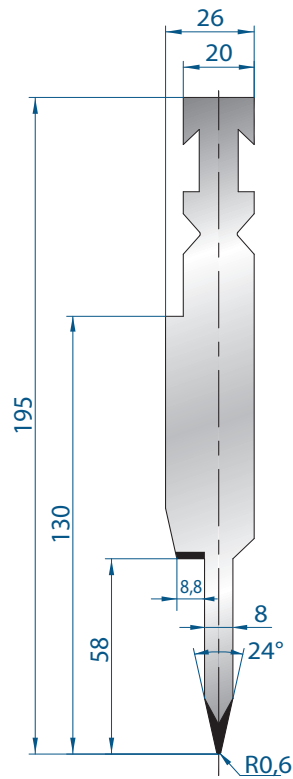


3175

Mat = C45
bonificato / tempered
Max T/m = 50

500 mm	20,0 kg
550 mm FRAZ. / SECT.	20,0 kg
100 mm	4,0 kg



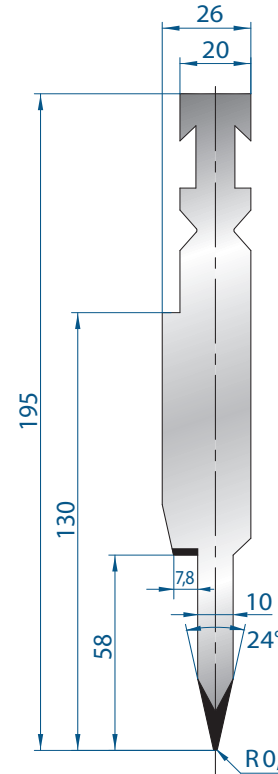


1252

Mat = C45
bonificato / tempered
Max T/m = 80

500 mm	13,0 kg
1100 mm FRAZ. / SECT.	13,0 kg
100 mm	2,6 kg

Spessore:
Max 1,2 mm Ferro
Thickness
Max 1,2 mm Mild steel

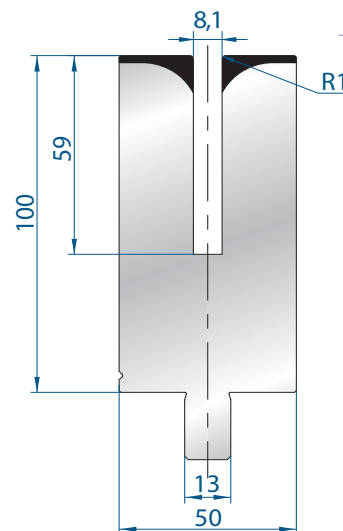


1253

Mat = C45
bonificato / tempered
Max T/m = 80

500 mm	13,0 kg
1100 mm FRAZ. / SECT.	13,0 kg
100 mm	2,6 kg

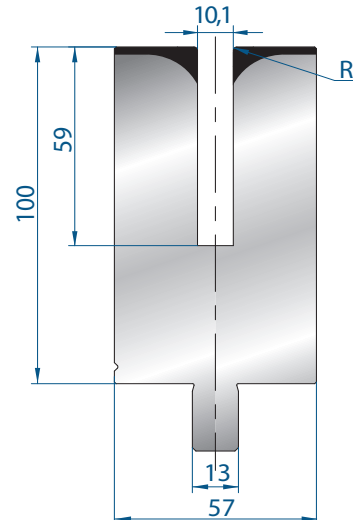
Spessore:
Max 1,5 mm Ferro
Thickness
Max 1,5 mm Mild steel



3157

Mat = C45
bonificato / tempered
Max T/m = 50

500 mm	21,0 kg
550 mm FRAZ. / SECT.	21,0 kg
100 mm	4,2 kg



3174

Mat = C45
bonificato / tempered
Max T/m = 50

500 mm	20,0 kg
550 mm FRAZ. / SECT.	20,0 kg
100 mm	4,0 kg



TOP
LANTIS spol. s r.o.





Top Lantis spol.s r.o.

Molebnurk 4
679 13 - Vysočany

Email: info@toplantis.cz
Tel: +421 728 863 013

www.toplantis.cz