BYSTRONIC STYLE

TOP LANTIS spol. s r.o.

Press brake tooling and equipment

UTENSILI E ATTREZZATURE PER PRESSE PIEGATRICI


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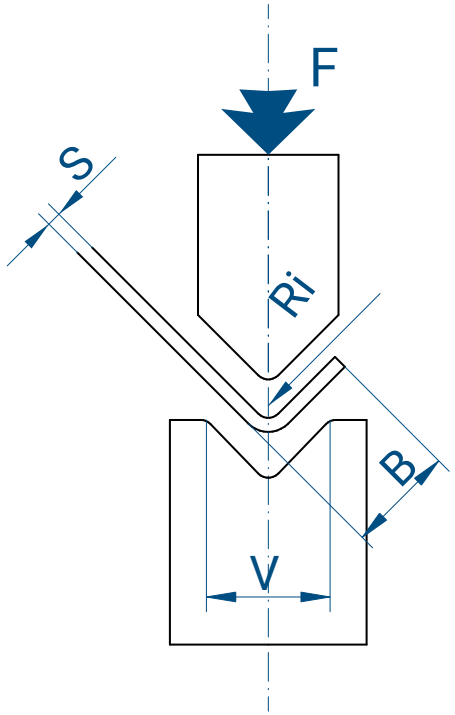
Calcolo della forza di piega in aria

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/mmq Aluminium 20-25 kg/mmq
F	Forza in T/m Force in T/m	**R**	Acciaio dolce 40-45 kg/mmq Mild steel 40-45 kg/mmq
B	Bordo minimo Shortest edge	**R**	Inox 65-70 kg/mmq Stainless steel 65-70 kg/mmq

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

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

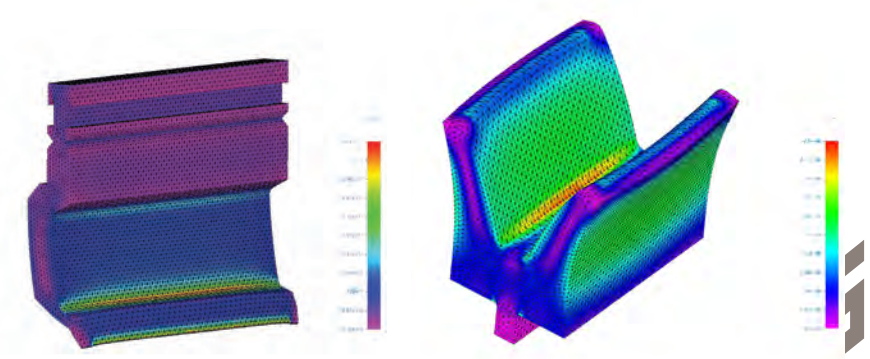


Tabella di piegatura in aria - Acciaio dolce / Air bending table - Mild Steel

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

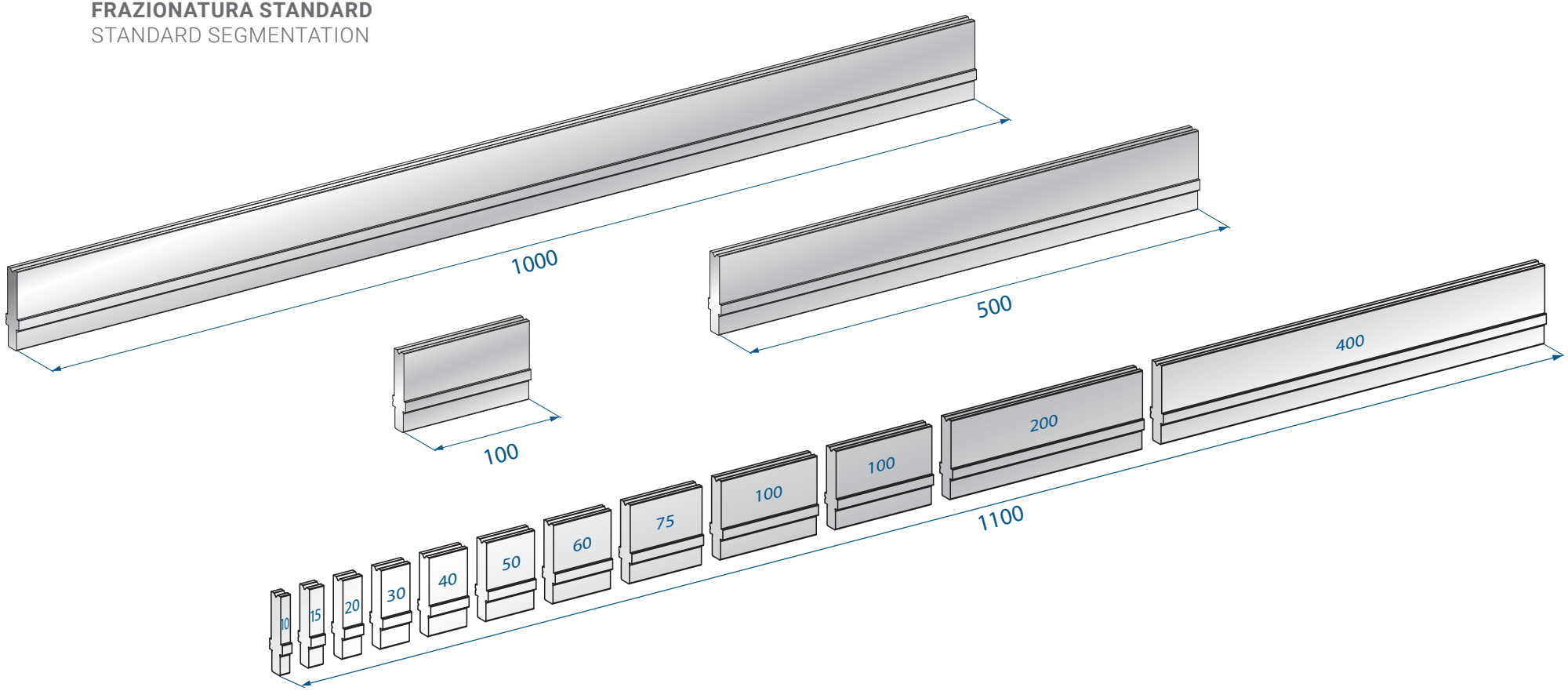
Tabella di piegatura in aria - Acciaio inox / Air bending table - Stainless Steel

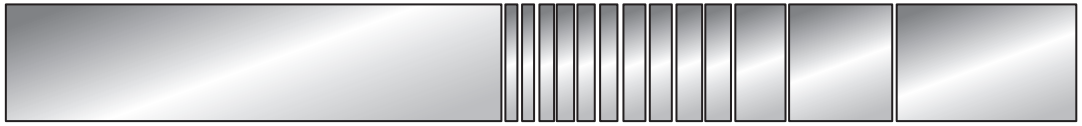
S			mm	0,5	0,6	0,8	1	1,2	1,5	2	2,5	3	4	5	6	8	10	12	15	20	25	30
6	4	1		5	6	**11**	17	25														
8	5,5	1,3			6	8	**12**	19	26													
10	7	1,6				6	11	**16**	23	42												
12	8,5	2					9	12	**20**	34	54											
16	11	2,6						9	14	**26**	40	59										
20	14	3,3							12	20	**33**	47	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

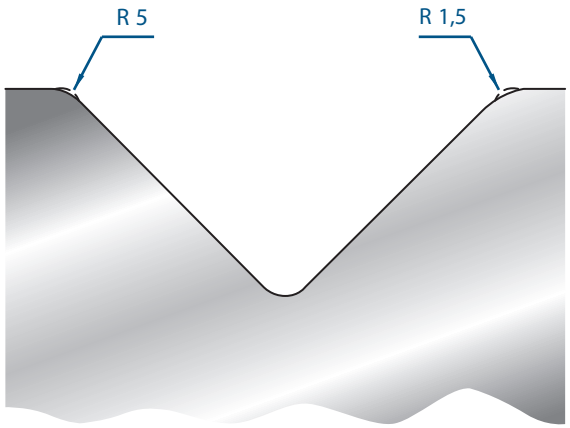
BYSTRONIC

FRAZIONATURA STANDARD
STANDARD SEGMENTATION

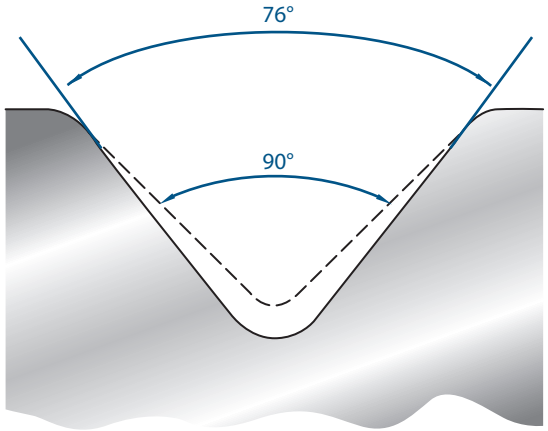




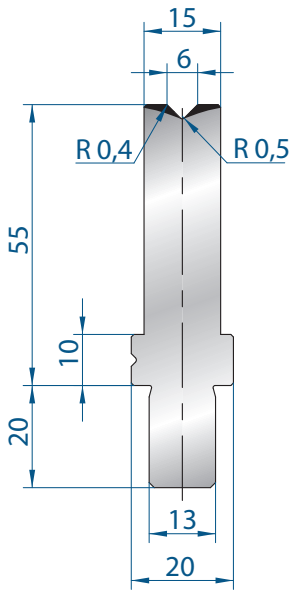
TAGLI A RICHIESTA
SPECIAL SEGMENTATION



MODIFICA RAGGIO
RADIUS MODIFICATION



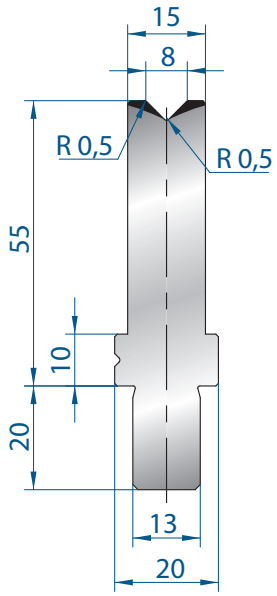
MODIFICA ANGOLO
ANGLE MODIFICATION



3241

Mat = C45
Max T/m = 100
α = 88°

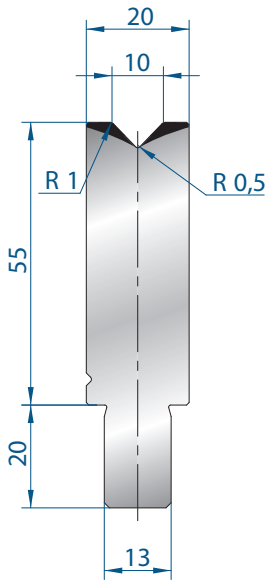
1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg



3242

Mat = C45
Max T/m = 100
α = 88°

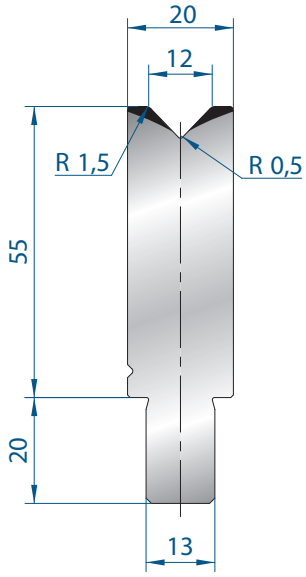
1000 mm	9,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	9,0 kg
100 mm	0,8 kg



3106

Mat = C45
Max T/m = 100
α = 88°

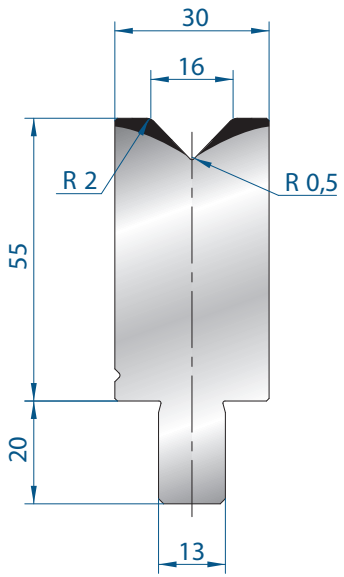
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	1,0 kg



3107

Mat = C45
Max T/m = 100
α = 88°

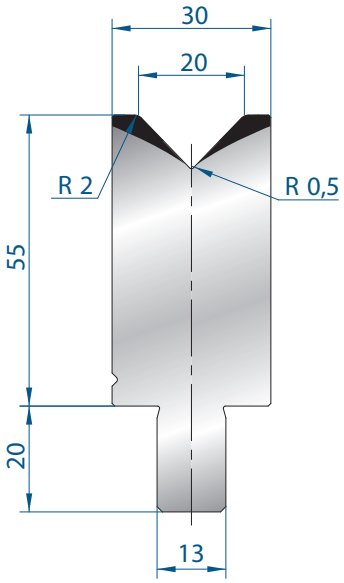
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	1,0 kg



3108

Mat = C45
Max T/m = 100
α = 88°

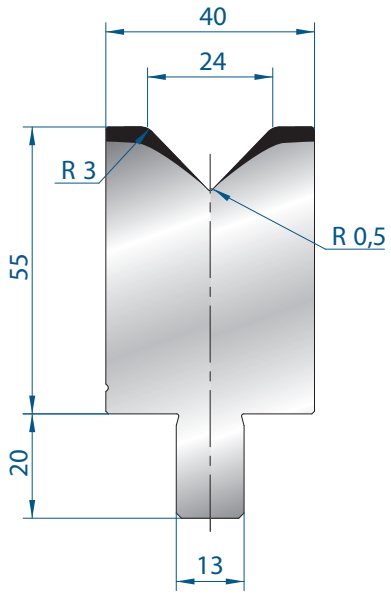
1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



3109

Mat = C45
Max T/m = 100
α = 88°

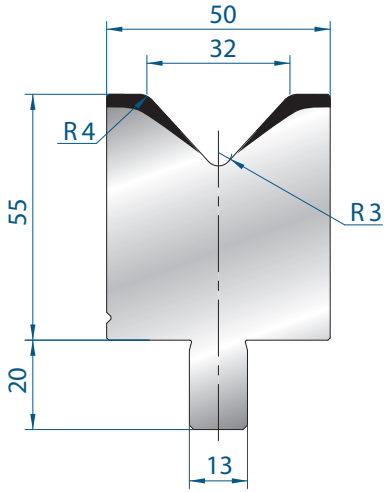
1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



3110

Mat = C45
Max T/m = 100
α = 88°

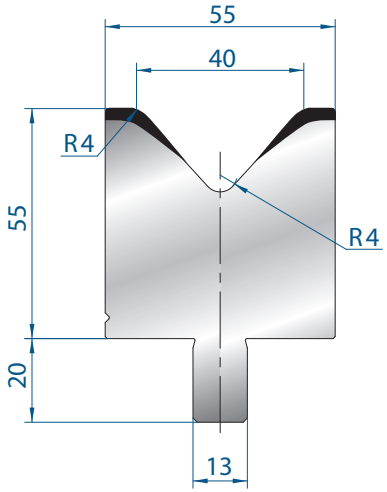
1000 mm	18,0 kg
500 mm	9,0 kg
1100 mm FRAZ. / SECT.	18,0 kg
100 mm	1,8 kg



3111

Mat = C45
Max T/m = 100
α = 85°

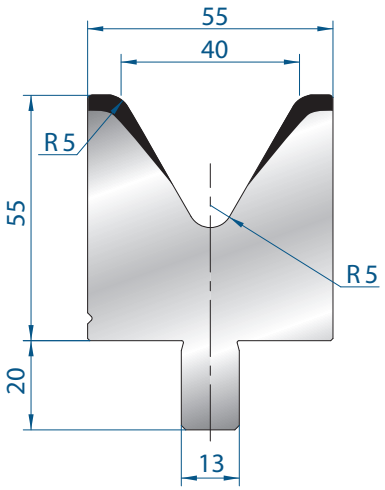
1000 mm	21,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	21,0 kg
100 mm	2,0 kg



3112

Mat = C45
Max T/m = 100
α = 85°

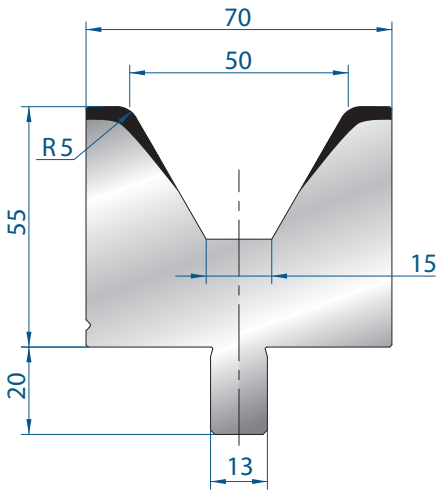
1000 mm	21,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	21,0 kg
100 mm	2,0 kg



3113

Mat = C45
Max T/m = 100
α = 60°

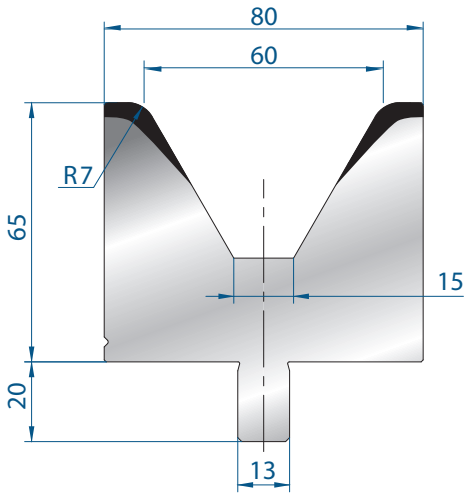
1000 mm	20,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	20,0 kg
100 mm	2,0 kg



3179

Mat = C45
Max T/m = 100
α = 60°

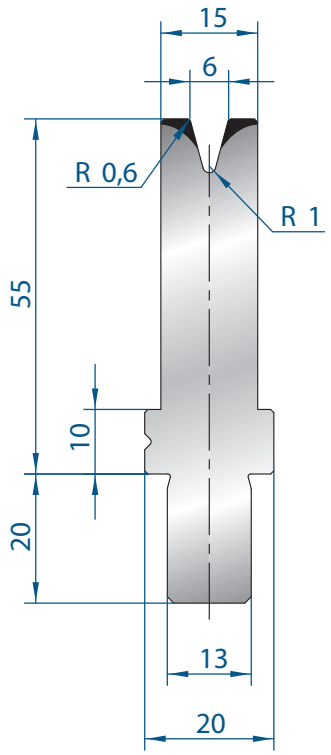
1000 mm	24,0 kg
500 mm	12,0 kg
1100 mm FRAZ. / SECT.	24,0 kg
100 mm	2,4 kg



3114

Mat = C45
Max T/m = 100
α = 60°

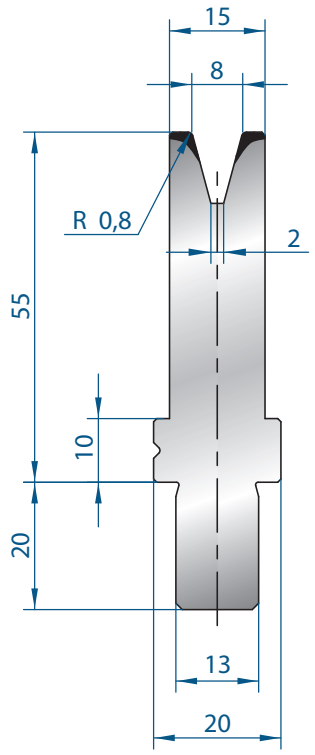
1000 mm	31,0 kg
500 mm	15,0 kg
1100 mm FRAZ. / SECT.	31,0 kg
100 mm	3,0 kg



3115

Mat = C45
Max T/m = 35
α = 30°

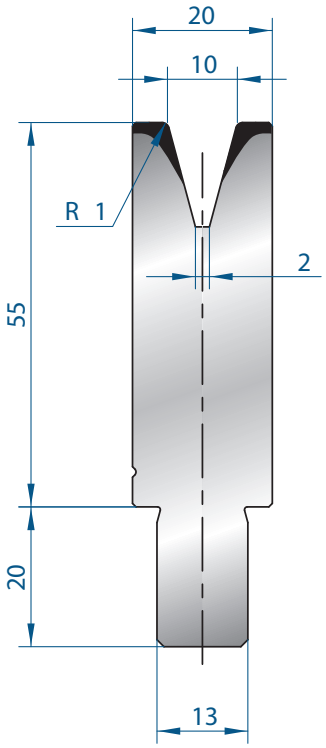
1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg



3116

Mat = C45
Max T/m = 40
α = 30°

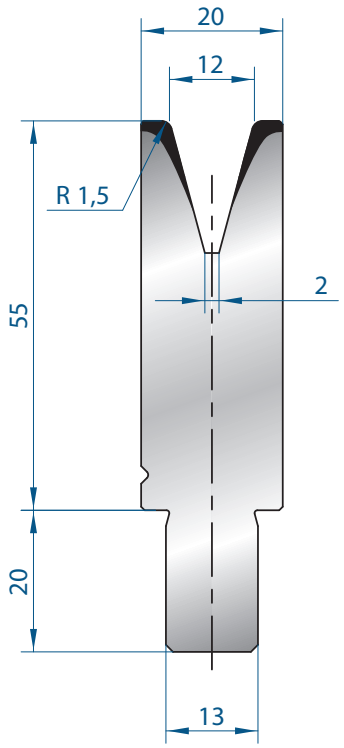
1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg



3117

Mat = C45
Max T/m = 50
α = 30°

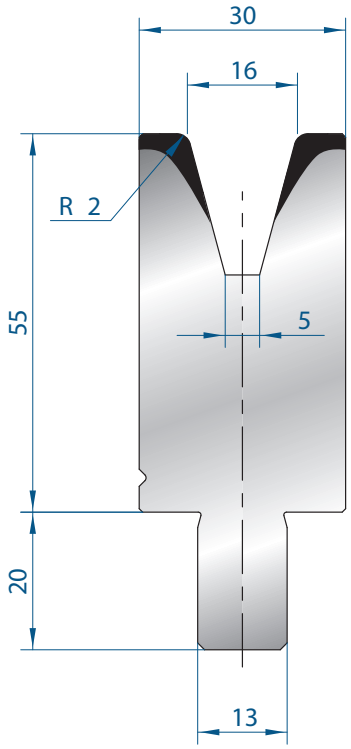
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	2,5 kg



3118

Mat = C45
Max T/m = 40
α = 30°

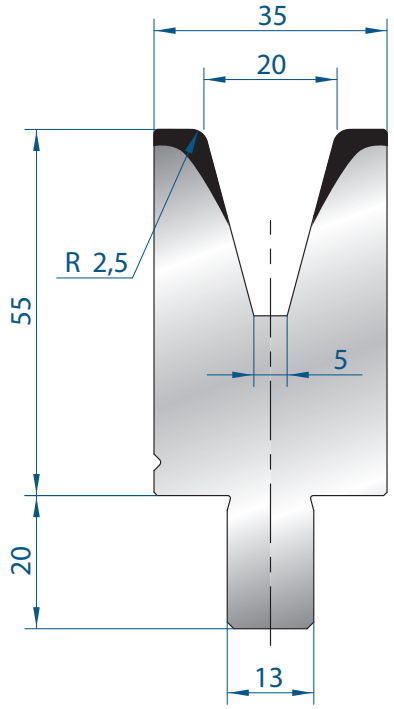
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	2,5 kg



3119

Mat = C45
Max T/m = 50
α = 30°

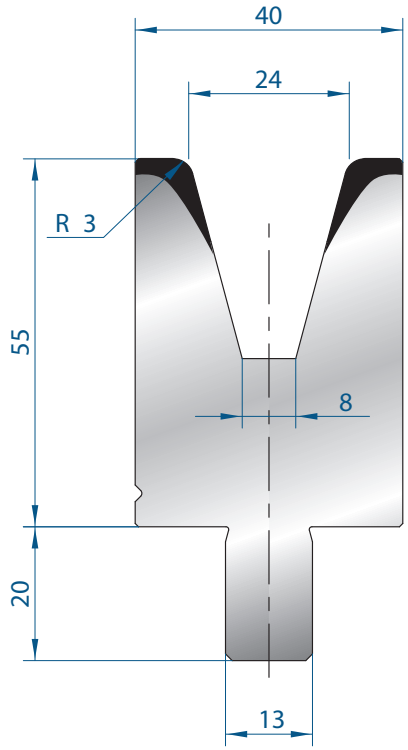
1000 mm	13,0 kg
500 mm	6,0 kg
1100 mm FRAZ. / SECT.	13,0 kg
100 mm	1,2 kg



3120

Mat = C45
Max T/m = 55
α = 30°

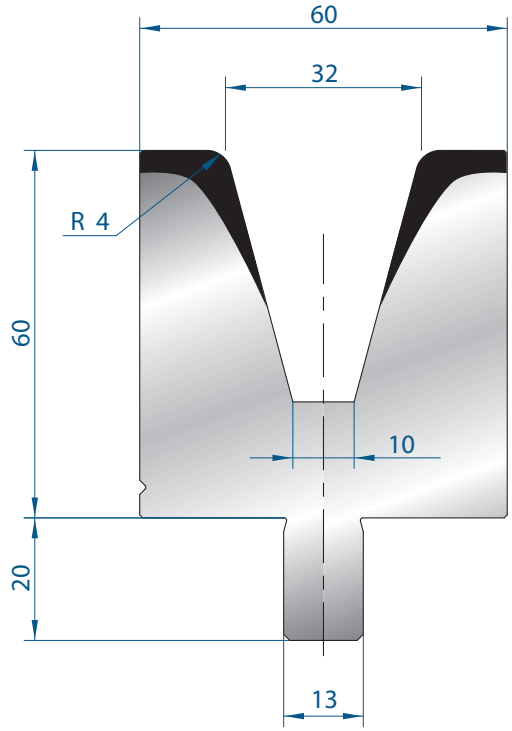
1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



3121

Mat = C45
Max T/m = 65
α = 30°

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

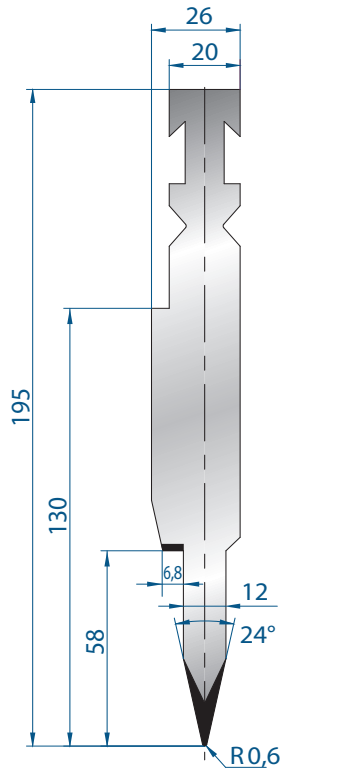


3122

Mat = C45
Max T/m = 65
α = 30°

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)

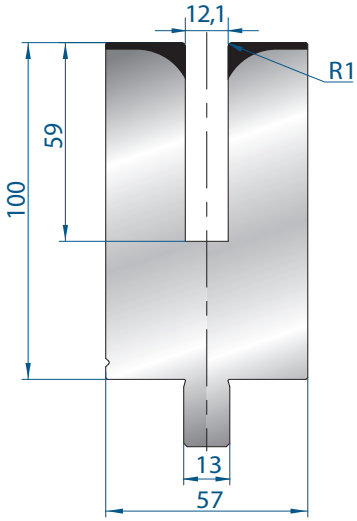


1254

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

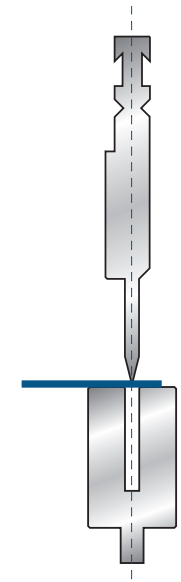
Spessore:
Max 1,5 mm Ferro
Thickness
Max 1,5 mm Mild steel

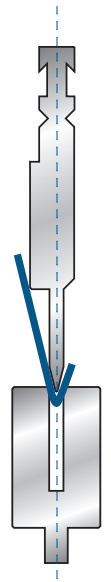


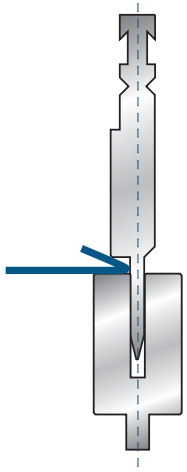
3175

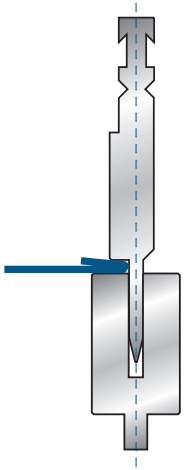
Mat = C45
bonificato / tempered
Max T/m = 50

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

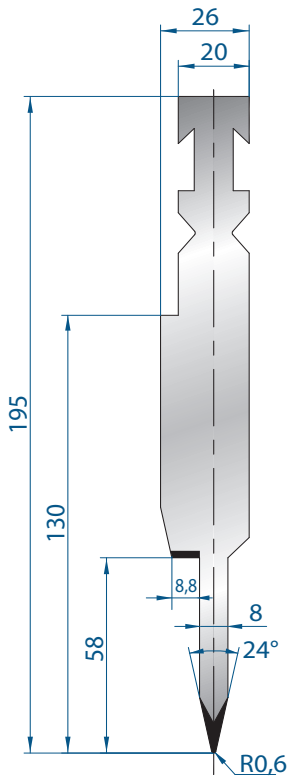








500-550 Frazionato (Bonificato) / Sectioned (Quenched)

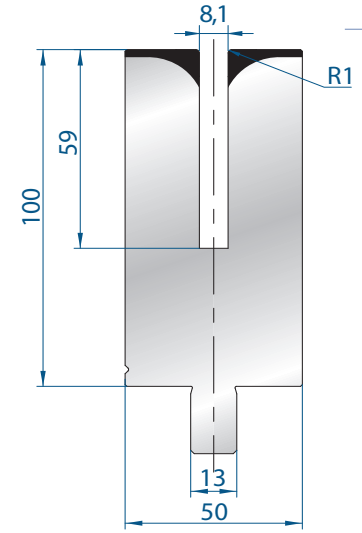


1252

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

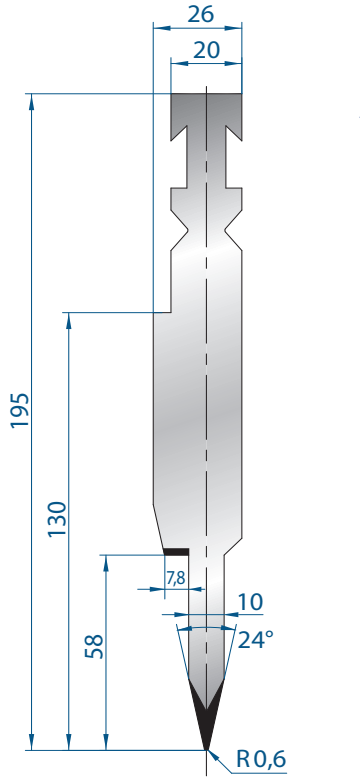
Spessore:
Max 1,2 mm Ferro
Thickness
Max 1,2 mm Mild steel



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

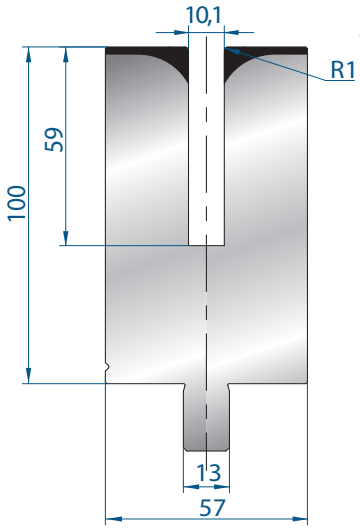


1253

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



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