

WILA STYLE

TOP spol. s r.o.
LANTIS

Press brake tooling and equipment

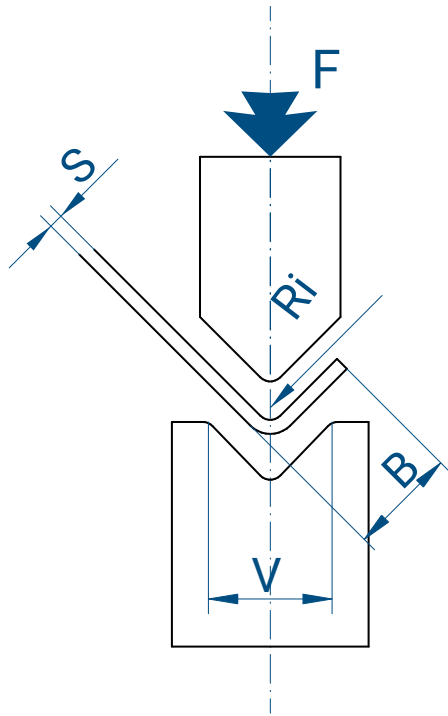
**UTENSILI E
ATTREZZATURE
PER PRESSE PIEGATRICI**

TOP
LANTIS 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

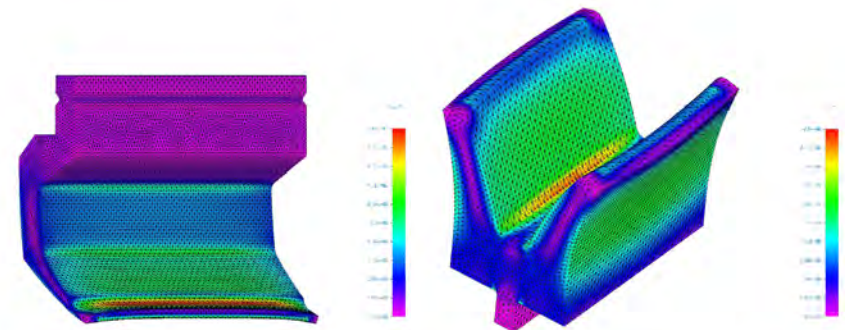


Tabella di piegatura in aria - Acciaio dolce / Air bending table - Mild Steel

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

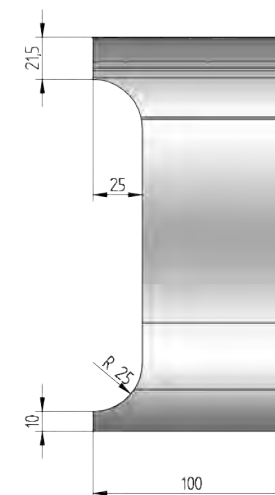
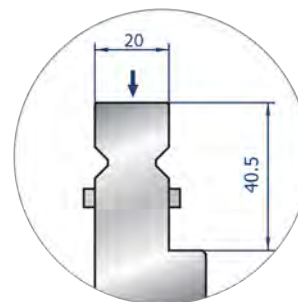
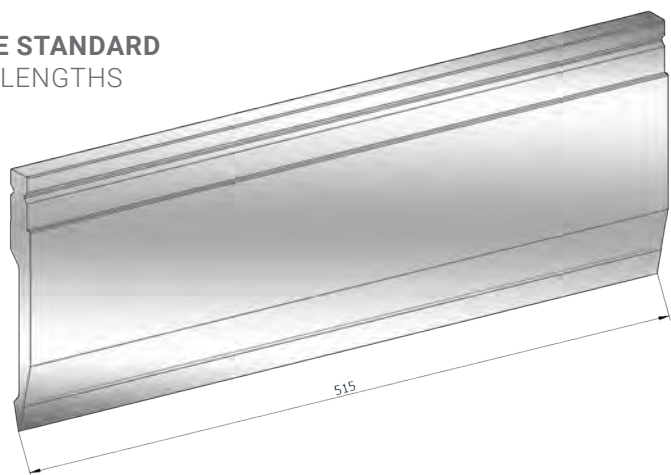
S			mm	0,5	0,6	0,8	1	1,2	1,5	2	2,5	3	4	5	6	8	10	12	15	20	25	30	
6	4	1		5	6	11	17	25															
8	5,5	1,3			6	8	12	19	26														
10	7	1,6				6	11	16	23	42													
12	8,5	2					9	12	20	34	54												
16	11	2,6						9	14	26	40	59											
20	14	3,3							12	20	33	47	84										
25	17,5	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

WILA

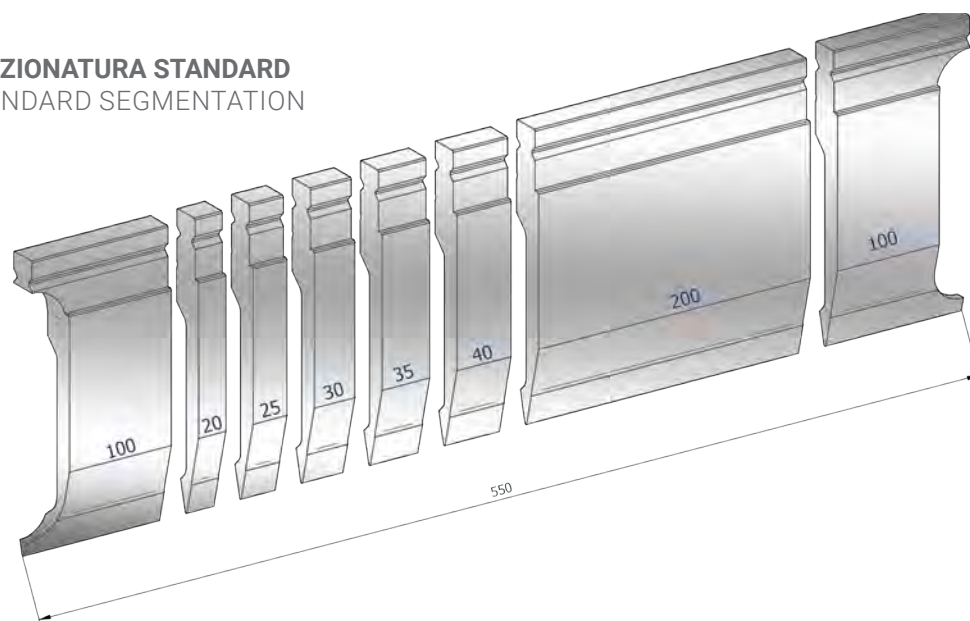
PUNZONI / PUNCHES	11	MATRICI / DIES	25
• Lunghezze standard /Standard lengths	11	• Lunghezze standard /Standard lengths	25
• Modifiche a richiesta / Modifications on request	13	• Modifiche a richiesta / Modifications on request	27
• Punzoni / Punches 86°.....	15-17	• Matrici 86°.....	29-39
• Punzoni / Punches 28°.....	19-23	• Matrici 30°.....	41-50

LUNGHEZZE STANDARD
STANDARD LENGTHS



FRESATURA SCARPETTA
MILLED HORN

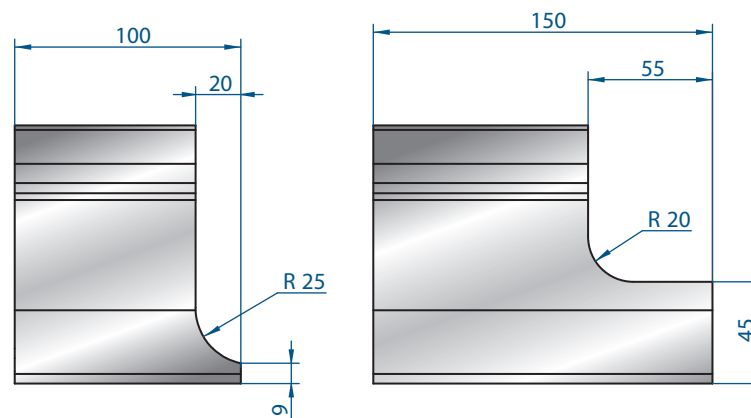
FRAZIONATURA STANDARD
STANDARD SEGMENTATION



Il pulsante di sicurezza viene montato standard su tutti gli utensili con peso fino a 12,5 Kg

The safety button is a standard supply on all tooling up to 12.5kg weigh

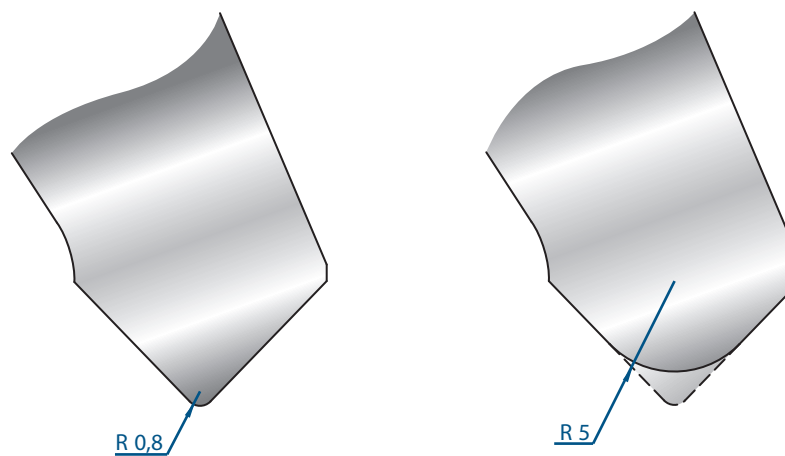
SCARPETTE SPECIALI
SPECIAL HORNS



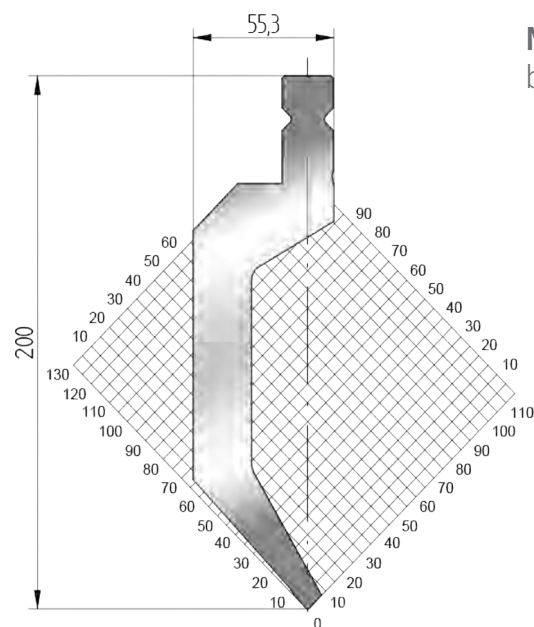
TAGLI A RICHIESTA
SPECIAL SEGMENTATION



MODIFICA RAGGIO
RADIUS MODIFICATION



1323



Mat = 42CrMo4
bonificato / tempered

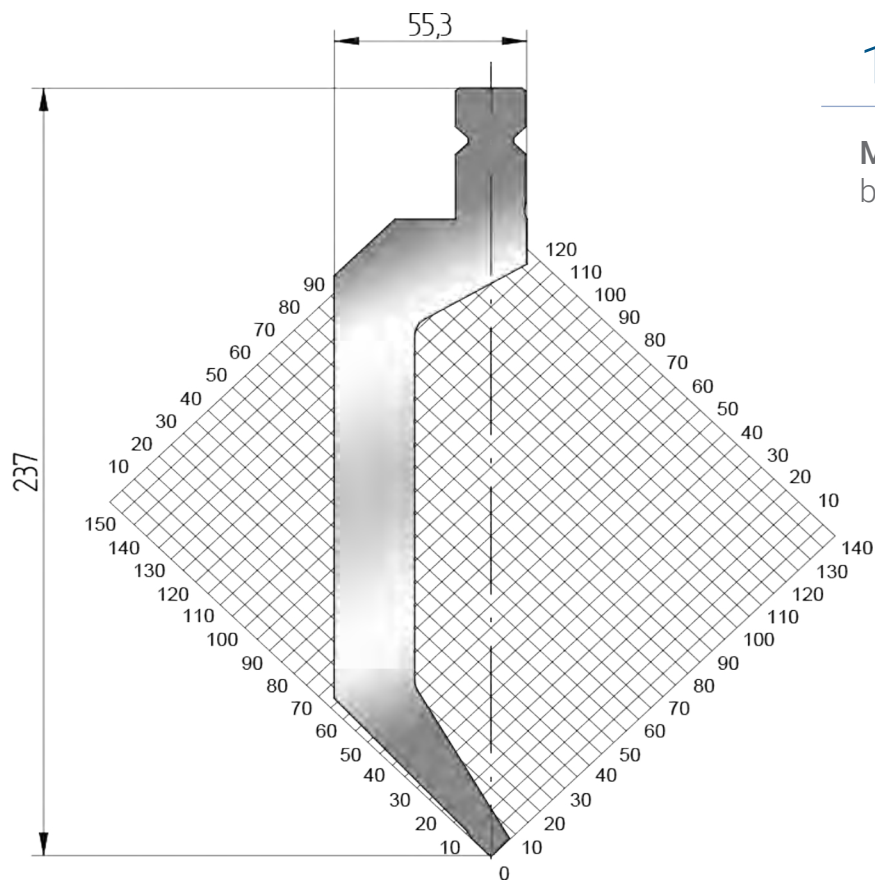
H = 200.00

Max T/m = 65

α = 86°

R = 1

515 mm	19,1 kg
550 mm FRAZ. / SECT.	19 kg



1324

Mat = 42CrMo4
bonificato / tempered

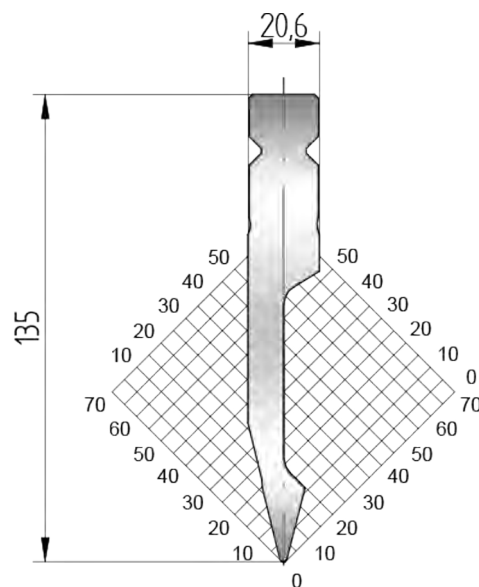
H = 237.00

Max T/m = 65

$\alpha = 86^\circ$

R = 1

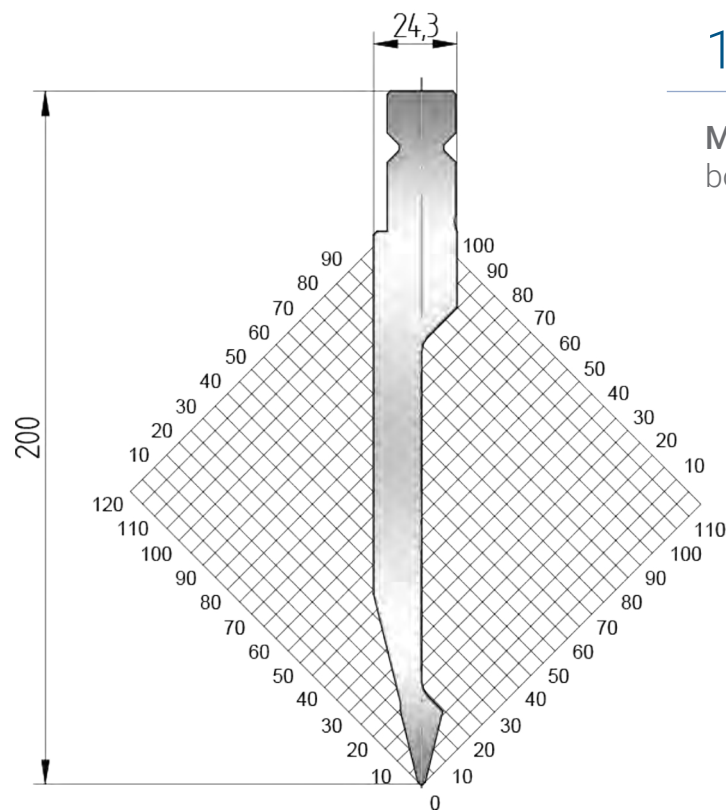
515 mm	22,5 kg
550 mm FRAZ. / SECT.	22,3 kg



1325

Mat = 42CrMo4
 bonificato / tempered
H = 135.00
Max T/m = 100
 α = 28°
R = 1

515 mm	7,2 kg
550 mm FRAZ. / SECT.	7,3 kg



1326

Mat = 42CrMo4
bonificato / tempered

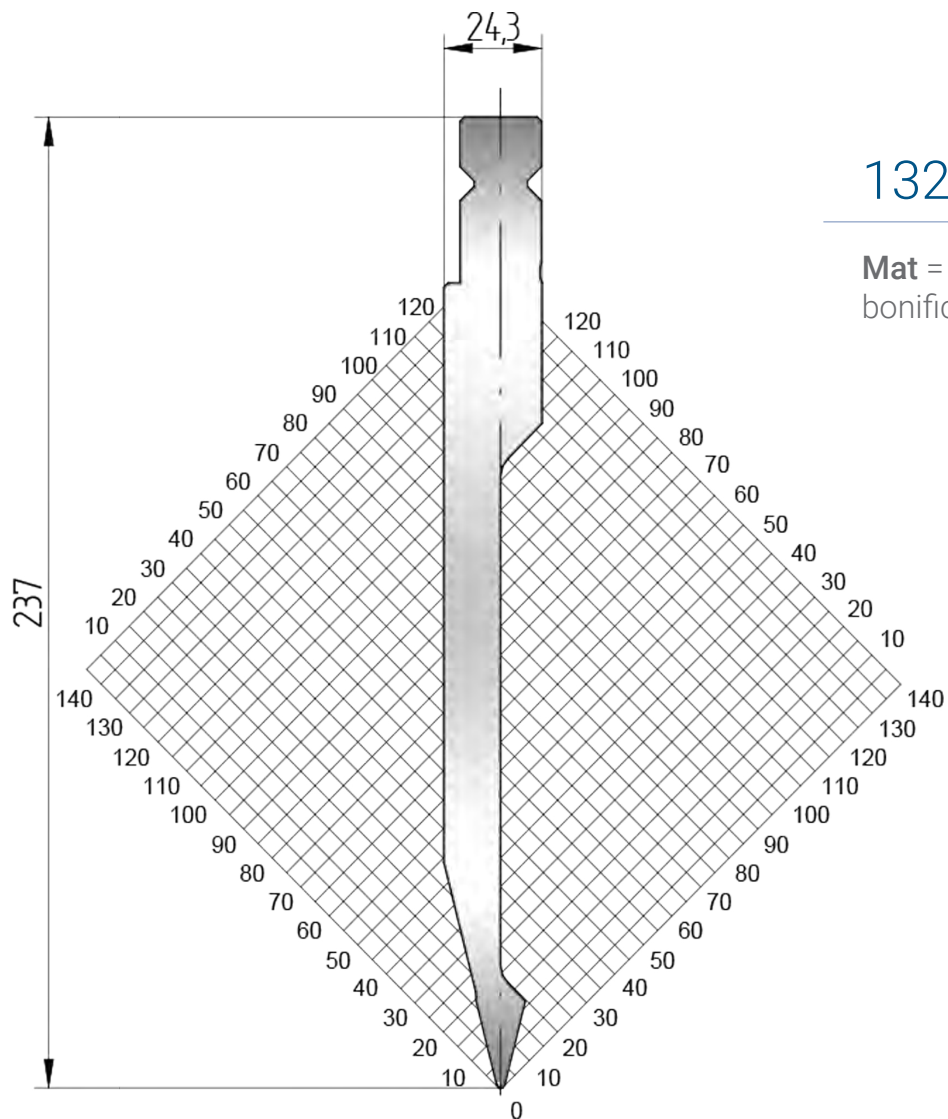
H = 200.00

Max T/m = 80

α = 28°

R = 1

515 mm	12,1 kg
550 mm FRAZ. / SECT.	12,1 kg

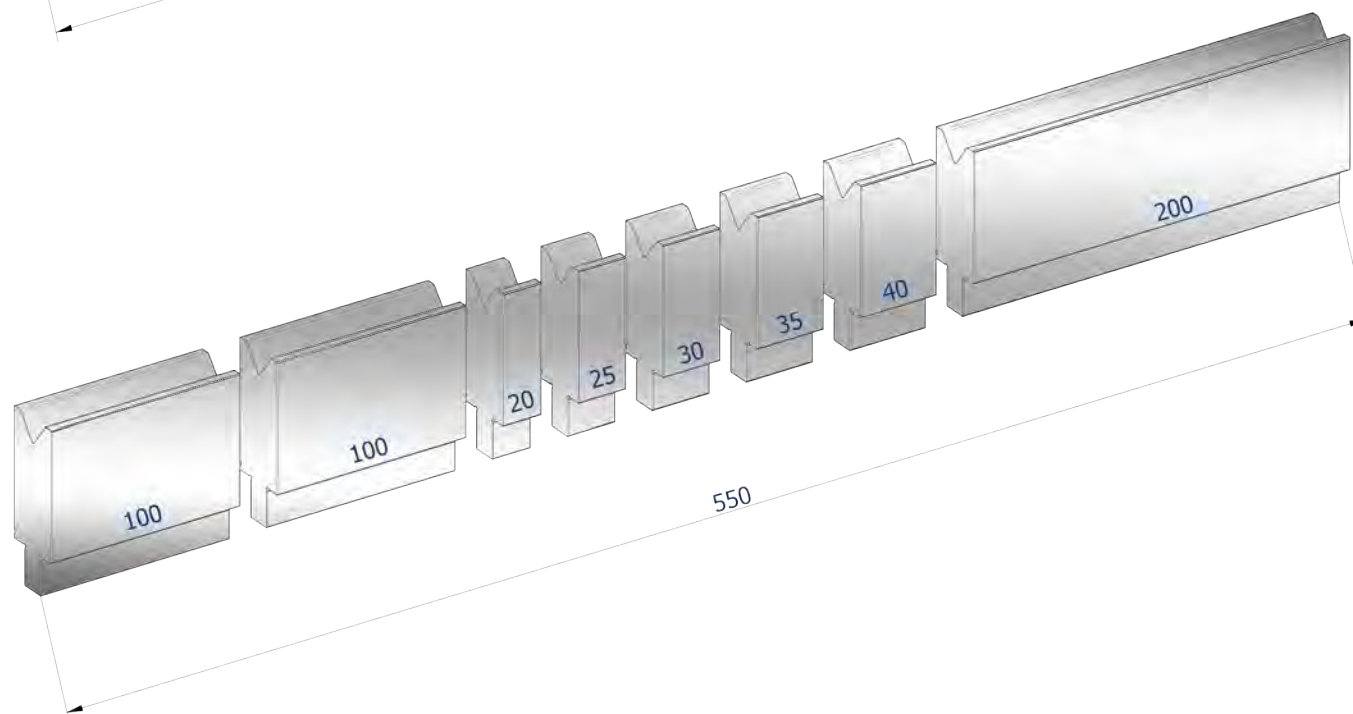
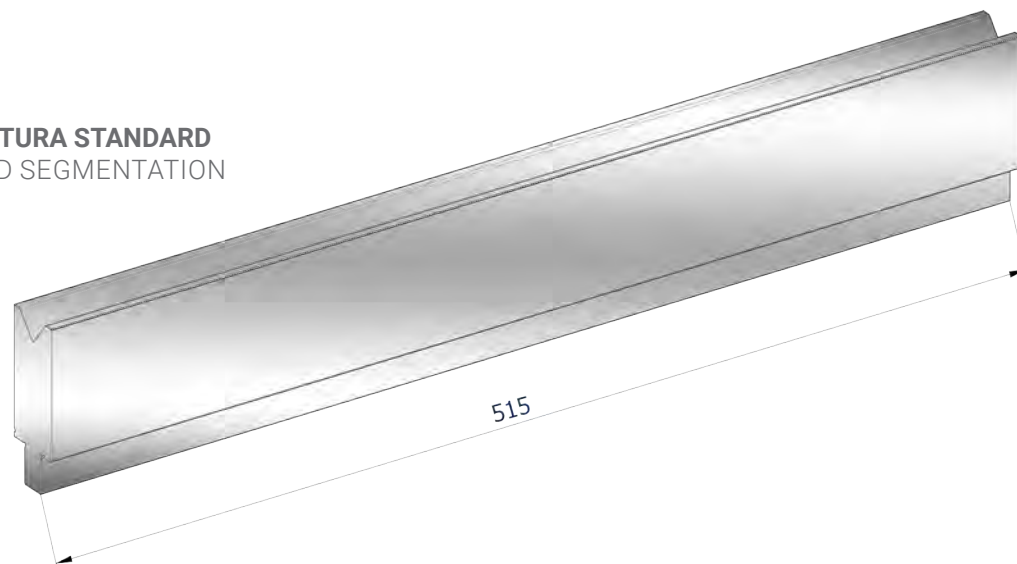


1327

Mat = 42CrMo4
 bonificato / tempered
H = 237.00
Max T/m = 80
 α = 28°
R = 1

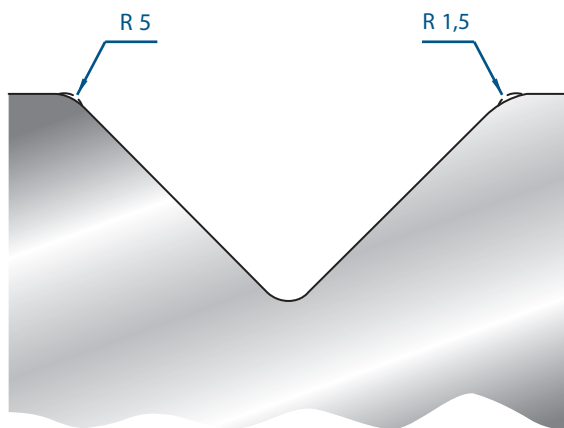
515 mm	14,7 kg
550 mm FRAZ. / SECT.	14,7 kg

FRAZIONATURA STANDARD
STANDARD SEGMENTATION

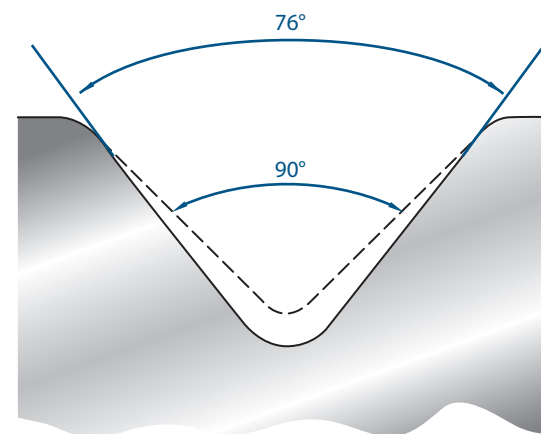




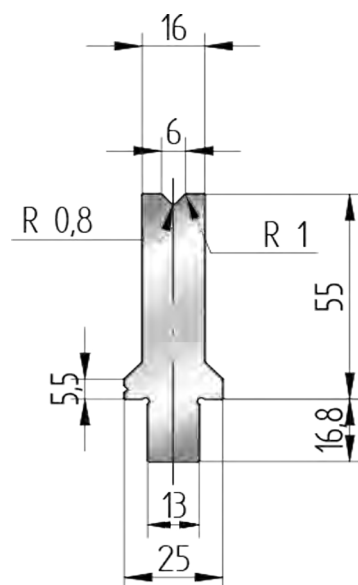
TAGLI A RICHIESTA
SPECIAL SEGMENTATION



MODIFICA RAGGIO
RADIUS MODIFICATION



MODIFICA ANGOLO
ANGLE MODIFICATION



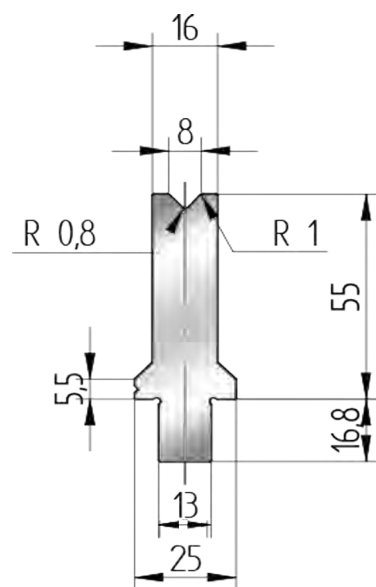
3250

Mat = 42CrMo4
bonificato / tempered

Max T/m = 120

α = 86°

515 mm	4,7 kg
550 mm FRAZ. / SECT.	5 kg



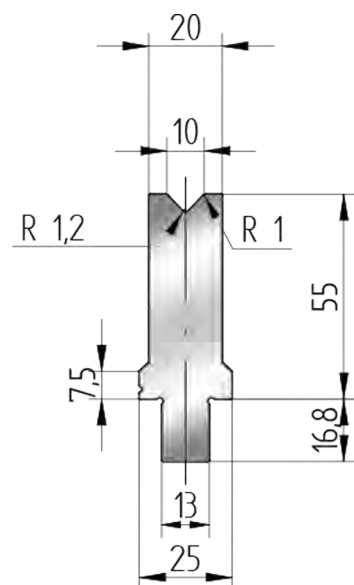
3251

Mat = 42CrMo4
bonificato / tempered

Max T/m = 120

α = 86°

515 mm	4,6 kg
550 mm FRAZ. / SECT.	4,9 kg



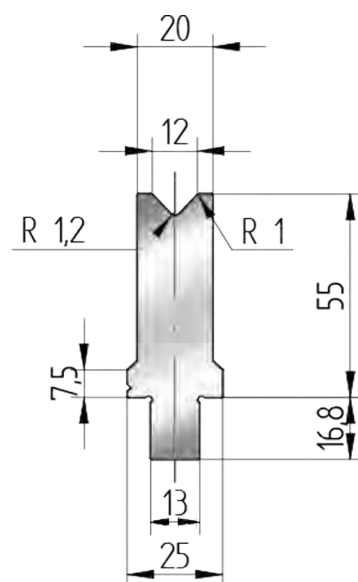
3252

Mat = 42CrMo4
bonificato / tempered

Max T/m = 120

α = 86°

515 mm	5,4 kg
550 mm FRAZ. / SECT.	5,7 kg



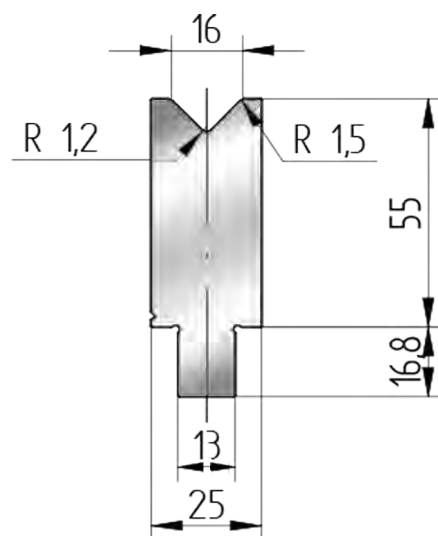
3253

Mat = 42CrMo4
bonificato / tempered

Max T/m = 120

α = 86°

515 mm	5,3 kg
550 mm FRAZ. / SECT.	5,7 kg



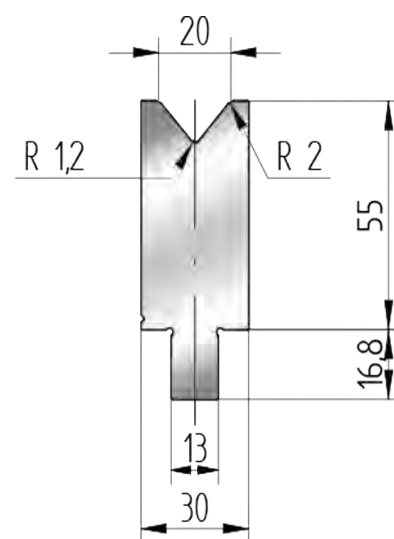
3254

Mat = 42CrMo4
bonificato / tempered

Max T/m = 120

α = 86°

515 mm	6,1 kg
550 mm FRAZ. / SECT.	6,6 kg



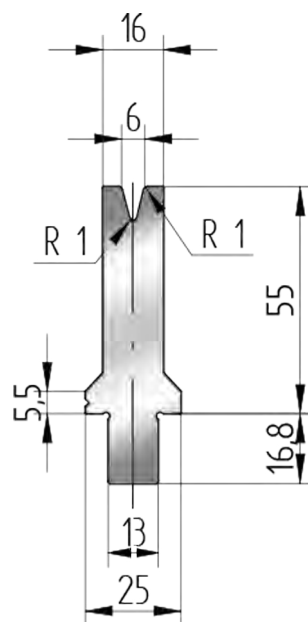
3255

Mat = 42CrMo4
bonificato / tempered

Max T/m = 120

α = 86°

515 mm	7,1 kg
550 mm FRAZ. / SECT.	7,7 kg



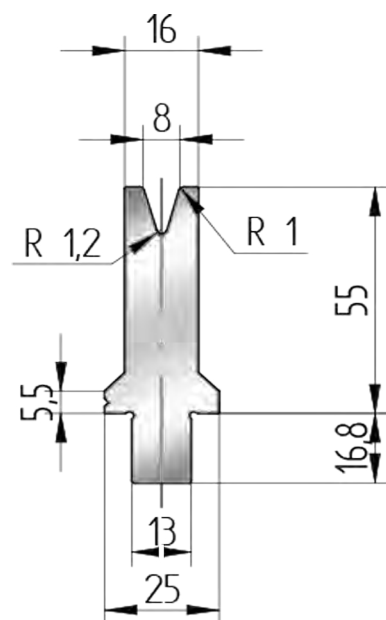
3260

Mat = 42CrMo4
bonificato / tempered

Max T/m = 25

α = 30°

515 mm	4,6 kg
550 mm FRAZ. / SECT.	4,9 kg



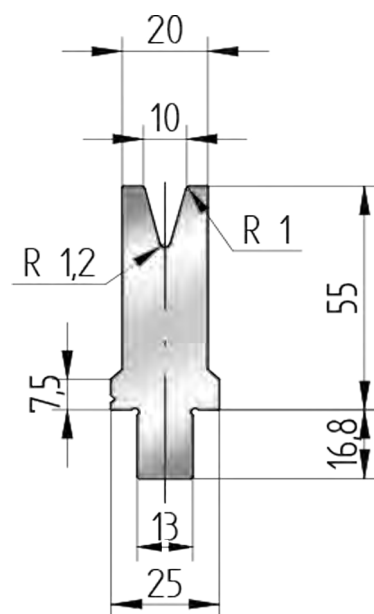
3261

Mat = 42CrMo4
bonificato / tempered

Max T/m = 25

$\alpha = 30^\circ$

515 mm	4,5 kg
550 mm FRAZ. / SECT.	4,8 kg



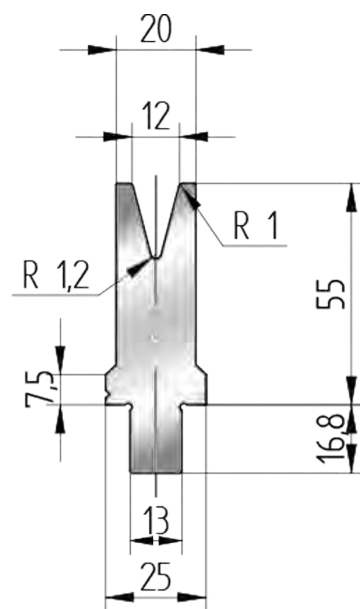
3262

Mat = 42CrMo4
bonificato / tempered

Max T/m = 20

α = 30°

515 mm	5,1 kg
550 mm FRAZ. / SECT.	5,5 kg



3263

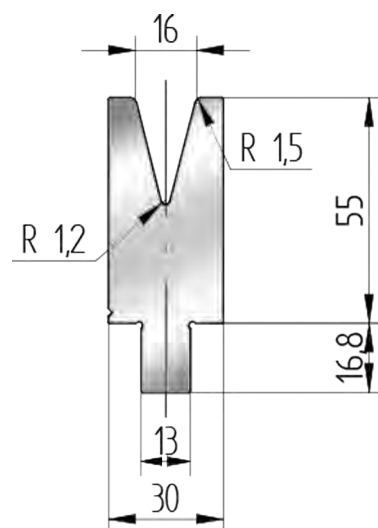
Mat = 42CrMo4

bonificato / tempered

Max T/m = 20

α = 30°

515 mm	5 kg
550 mm FRAZ. / SECT.	5,3 kg



3264

Mat = 42CrMo4

bonificato / tempered

Max T/m = 20

α = 30°

515 mm	6,6 kg
550 mm FRAZ. / SECT.	7 kg

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