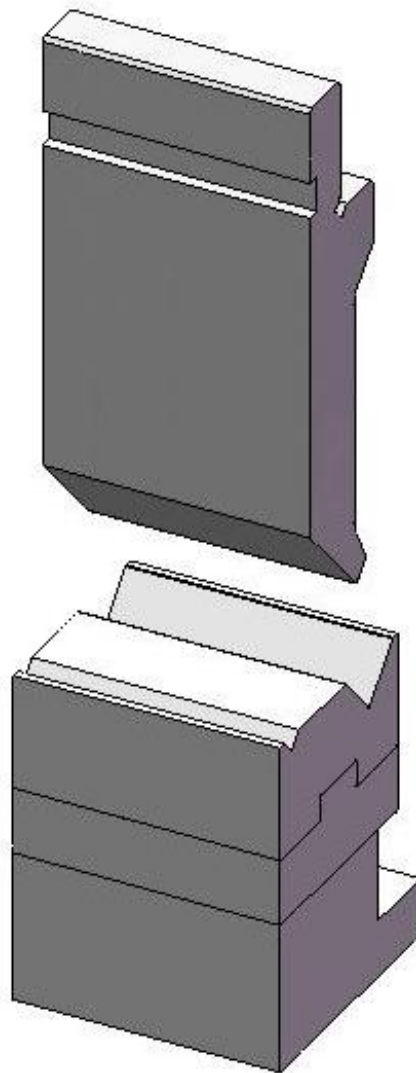


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Contact: Cameron Chen

折弯机模具

Press Brake Tooling



马鞍山嘉铭机械刃模有限公司

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Email: jaminnar@outlook.com

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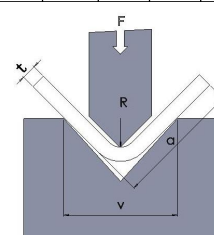
自由折弯的折弯压力对照表

Capacity chart for air bending

本表格中的数据是在 90° 折弯，材料抗拉强度 $\delta b=420\text{MPa}$ ，折弯长度为 1m 基础上计算的结果。

The given data has been calculated based upon bending material with a tensile strength of $\delta b=420\text{ MPa}$ over a length of 1m.

V	6	8	10	12	16	18	20	24	32	35	40	50	60	63	80	100	120	130	140	150	160	180	190	200	230	260
b	4.5	5	7	8.5	12	13	15	17	23	25	28	35	43	45	57	71	85	92	100	105	115	130	135	140	160	180
r	1	1.2	1.6	2	2.5	2.8	3	3.5	5	5.5	6	8	9.5	10	12	15.5	19	21	23	24.5	26	28	30	32	36	40
0.5	2.5																									
0.8	7	4.8																								
1.0	11	8	6																							
1.2		12	9	7																						
1.5			15	12	8																					
2.0				23	16	13	12	9.5																		
2.5					26	22	20	15	11	H																
3.0							30	24	16	14	12															
4.0								44	31	28	23	18														
5.0									53	47	43	31	25													
6.0											61	45	36	34												
8.0												88	69	65	47	36										
10														110	80	60	47	43	39							
12															120	90	71	65	58	55	50					
16																	140	125	115	105	95	81	80	71		
18																			148	135	125	110	100	95	80	
20																						140	130	120	110	90



内径 R 约等于凹模开口宽度 V 的 16%

The internal radius R corresponds to approximate 16% of the die opening V

自由折弯建议凹模开口宽度 V

Recommended die opening V for air bending

材料厚度/Material thickness	t	0.5~2.5mm	3~8mm	9~10mm	>12mm
凹模开口宽度/Die opening	V	$6 \times t$	$8 \times t$	$10 \times t$	$12 \times t$

折弯力/Bending force for

铝 Alu	$\delta b=300\text{ MPa}$	$F=F(\text{表}) \times 0.65$ $F=F(\text{chart}) \times 0.65$
不锈钢 S.S	$\delta b=700\text{ MPa}$	$F=F(\text{表}) \times 1.6$ $F=F(\text{chart}) \times 1.6$

折弯压力吨位计算公式（参考值）

Determination of the bending force for air bending (approximation)

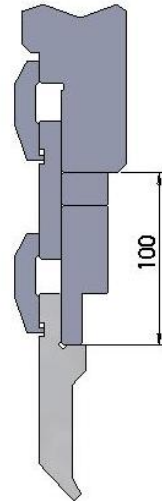
$$F(\text{chart}) = 65 \times t^2 / V \quad (\text{Ton} / \text{m})$$

上模夹紧形式

Upper tooling clamping

普通斜楔夹紧

common wedge clamping

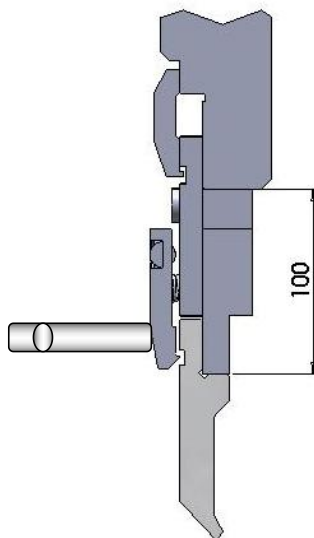


适用于 50t~160t 之间欧式上模的安装

Suited to 50t~160t machines installing of Europe type punch

机械快速夹紧

Mechanical rapid clamping

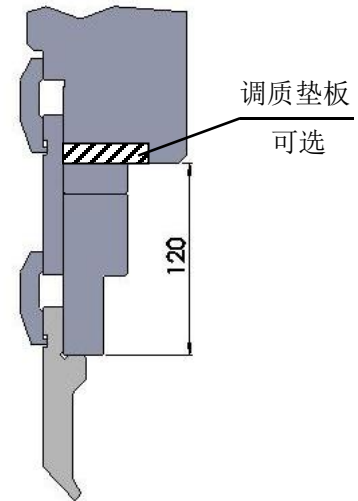


快夹可以方便欧式上模的快速安装

Rapid clamping is convenient to installing the European type punch quickly

重型斜楔夹紧

High-duty wedge clamping

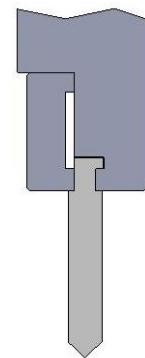


适用于 220t 以上欧式上模的安装

Suited to the installing of Europe type punch over 220t nominal pressure machine

美式夹紧

American type clamping



适用于美式上模的安装

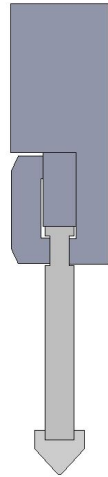
Suited to install the American type punch

上模夹紧形式

Upper tooling clamping

重载直联型夹紧

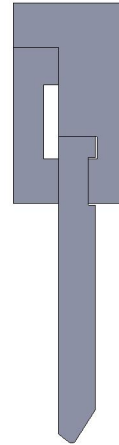
Heavy duty direct-link type clamping



适用于滑块受重载的安装
Suited to install the ram which bear overload

重载直联型夹紧

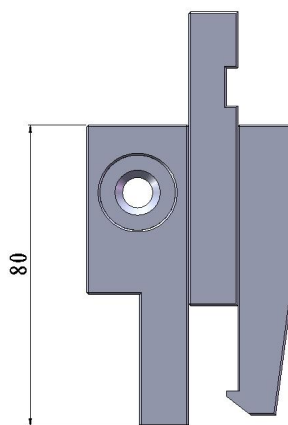
Heavy duty direct-link type clamping



适用于滑块受重载的安装
Suited to install the ram which bear overload

YAWEI 上模液压夹紧

YAWEI upper tooling hydraulic clamping



适用于上模的快速安装
Suited to install the upper tooling quickly

WILA 上模液压夹紧式

WILA upper tooling hydraulic clamping

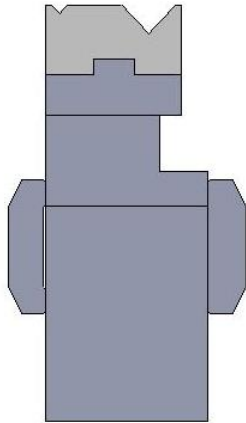


NSCL II with Top with Safety Click

下模夹紧形式

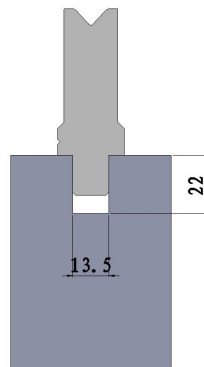
Dies tooling clamping

2V- “T” 型快换式 2V-T quick-change type



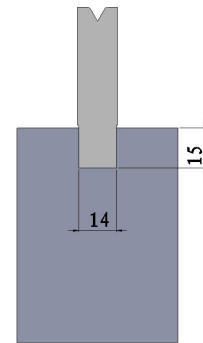
下模口可快速更换
the die opening can be quick
changed

1V 插槽式 1V slot



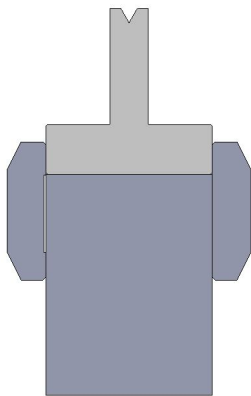
模具肩部受力
the shoulder of tooling
bear the force

1V 插槽式 1V slot



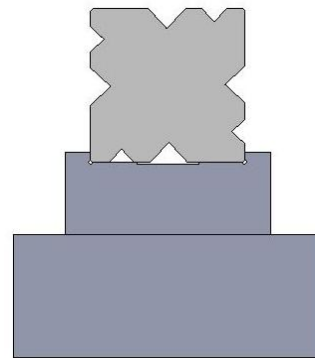
模具底部受力
the bottom of tooling
bear the force

1V- “T” 型夹紧式 1V-T clamping type



适用于”T”型 1V 下模
Suited to T type 1V bottom tooling

多 V 插槽分段式 multi-V slot subsection

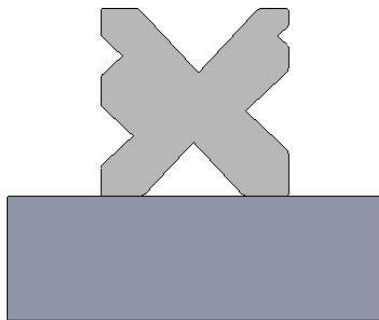


适用于分段多 V 下模
Suited to subsection multi-V bottom
tooling

下模夹紧形式

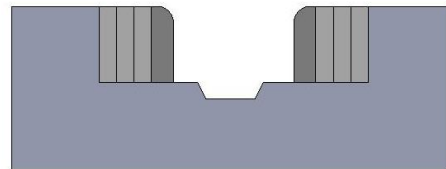
Dies tooling clamping

多 V 工作台式
multi-V worktable type
clamping



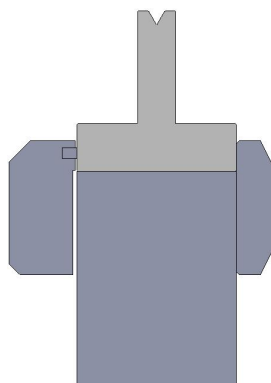
适用于整体多 V 下模
Suited to whole multi-V bottom tooling

下模插片式
Adjustable insert type for bottom tooling



模口可分级增大
the die orifice can graded increase

YAWI 下模液压夹紧
YAWEI bottom tooling hydraulic clamping



适用于下模快速安装
Suited to quick install the bottom tooling

WILA 下模液压夹紧
WILA bottom tooling hydraulic clamping



NSCR II with OZU bottom tooling

标准上模

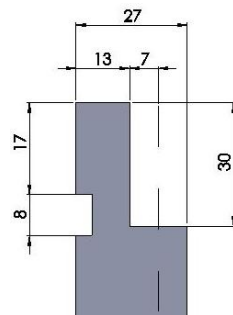
Standard punches

上模模柄结构

Upper tooling fixtures

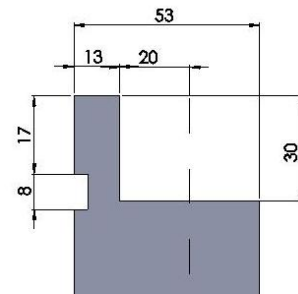
标准欧式

European type tooling



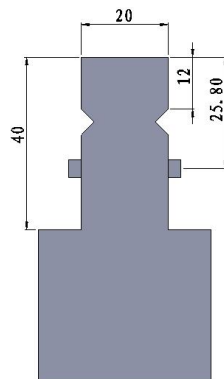
加强型欧式

European type tooling



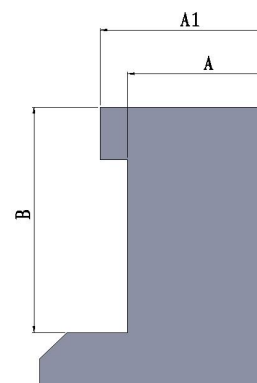
WILA 式

WILA type tooling



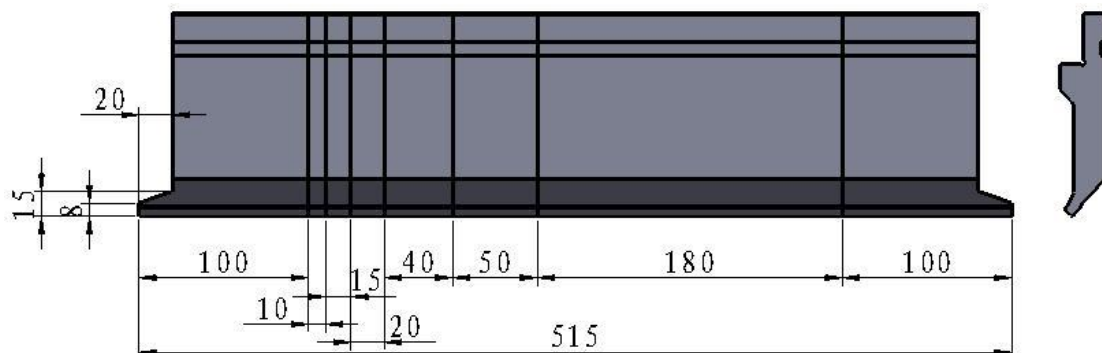
重载直联式

Heavy-duty direct-link type



上模标准分段方式

Segmentation of punch

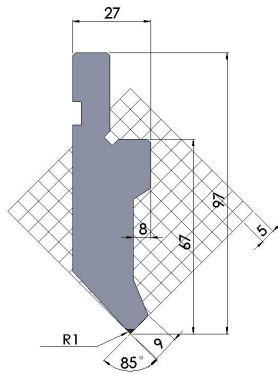


标准上模 85°

Standard punches 85°

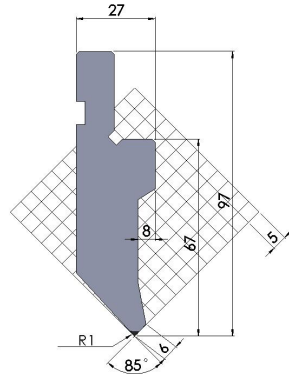
10.100

Max Tons:100t/m



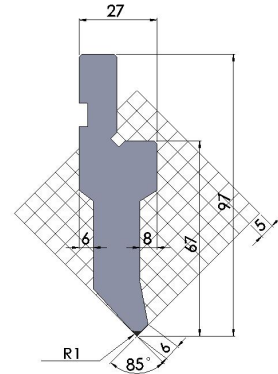
10.101

Max Tons:80t/m



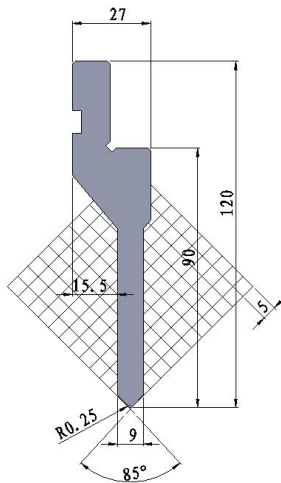
10.102

Max Tons:60t/m



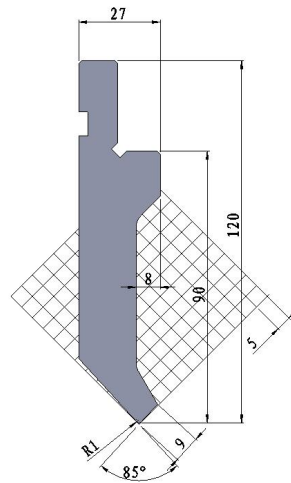
10.103

Max Tons:80t/m



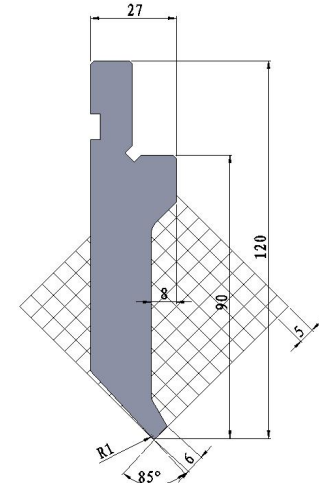
10.104

Max Tons:100t/m



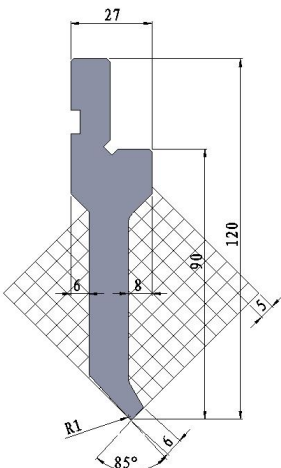
10.105

Max Tons:80t/m



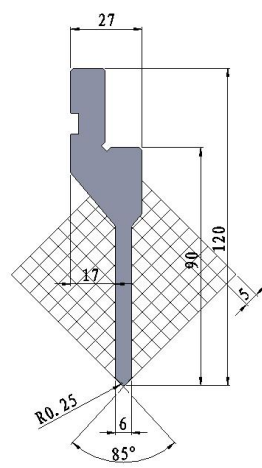
10.106

Max Tons:50t/m



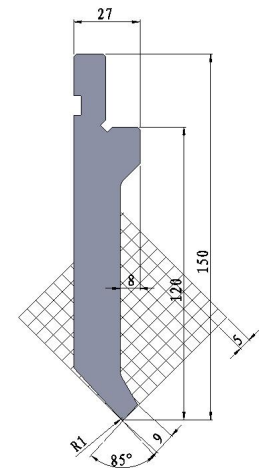
10.107

Max Tons:50t/m



10.108

Max Tons:100t/m

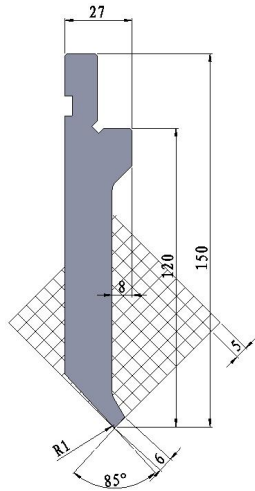


标准上模 85°

Standard punches 85°

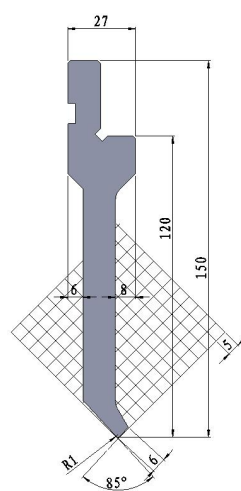
10.109

Max Tons:80t/m



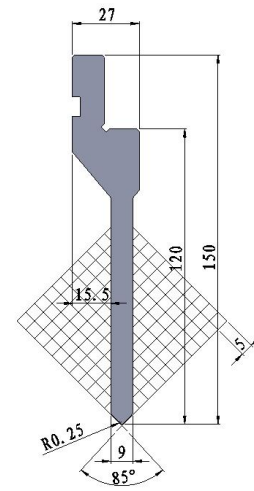
10.110

Max Tons:40t/m



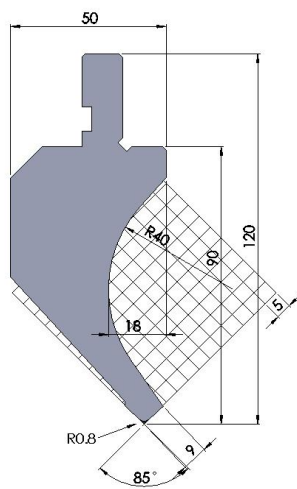
10.111

Max Tons:80t/m



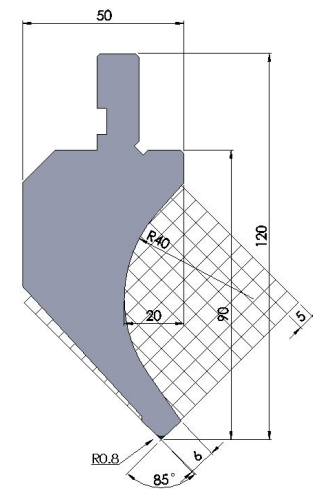
10.112

Max Tons:70t/m



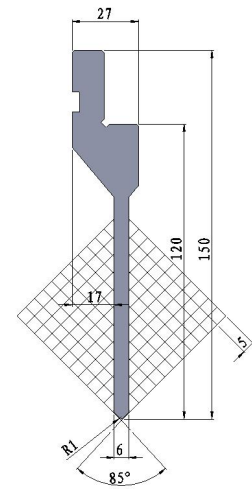
10.113

Max Tons:40t/m



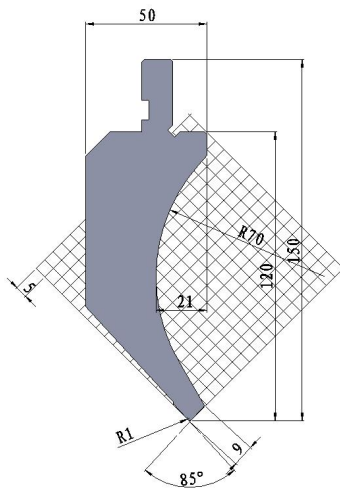
10.114

Max Tons:50t/m



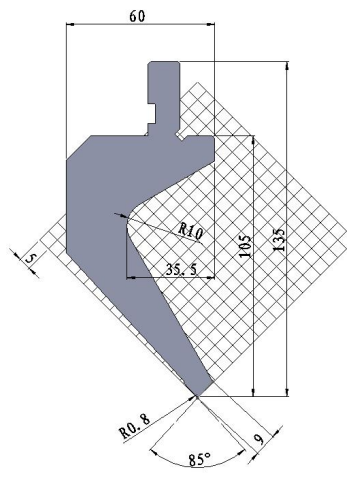
10.115

Max Tons:50t/m



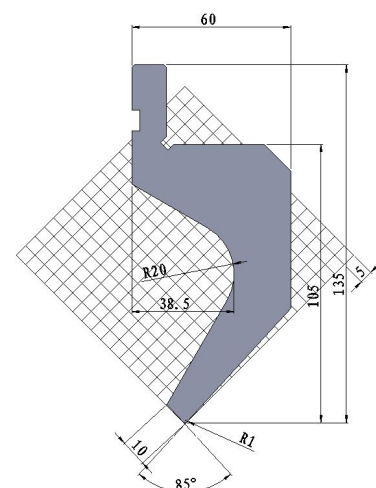
10.116

Max Tons:60t/m



10.117

Max Tons:45t/m

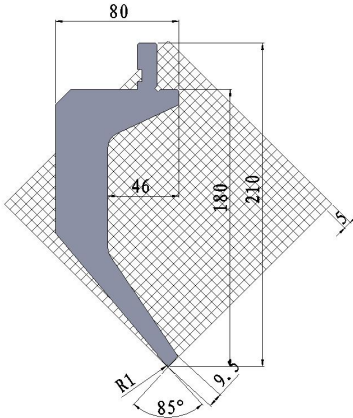


标准上模 85°

Standard punches 85°

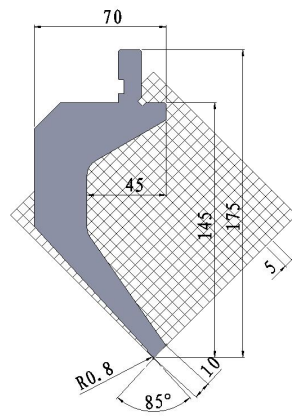
10.118

Max Tons:80t/m



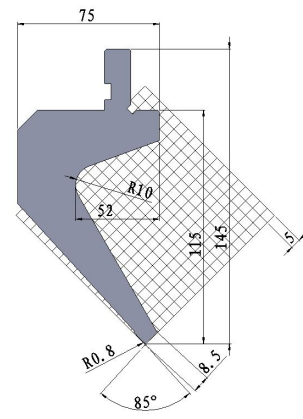
10.119

Max Tons:80t/m



10.120

Max Tons:50t/m

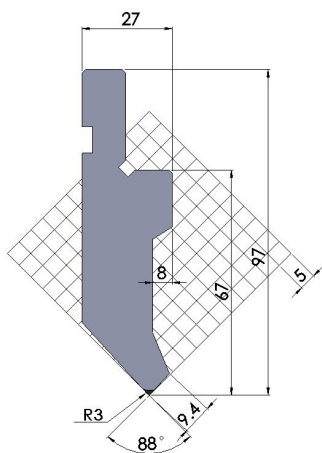


标准上模 88°

Standard punches 88°

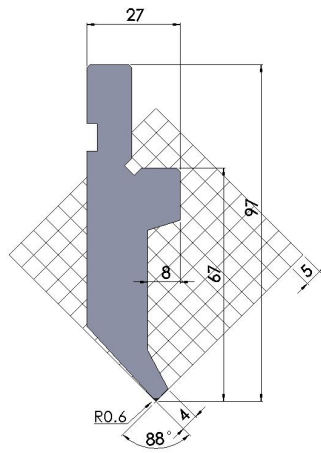
10.130

Max Tons:100t/m



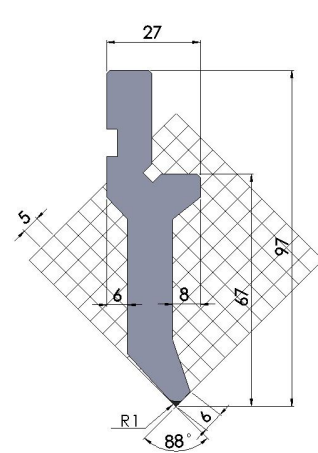
10.131

Max Tons:80t/m



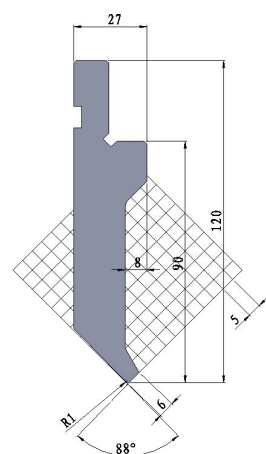
10.132

Max Tons:60t/m



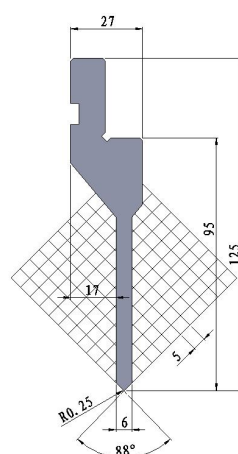
10.133

Max Tons:100t/m



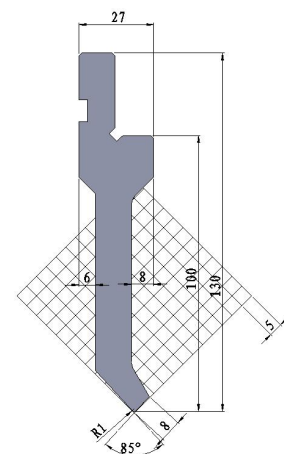
10.134

Max Tons:50t/m



10.135

Max Tons:20t/m

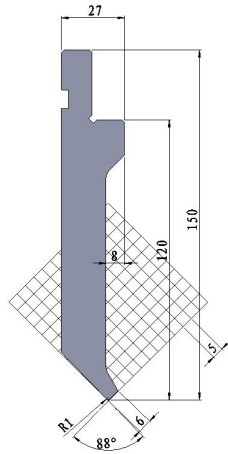


标准上模 88°

Standard punches 88°

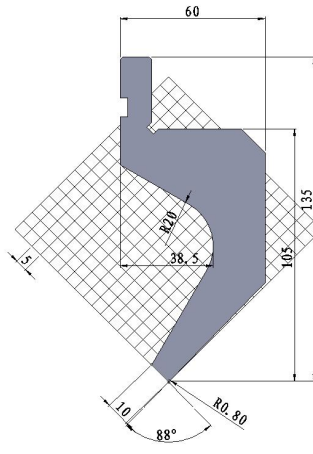
10.136

Max Tons:80t/m



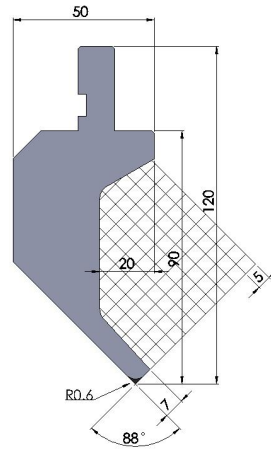
10.137

Max Tons:45t/m



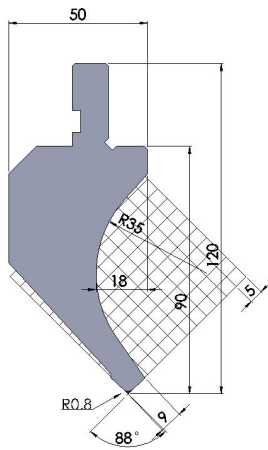
10.138

Max Tons:20t/m



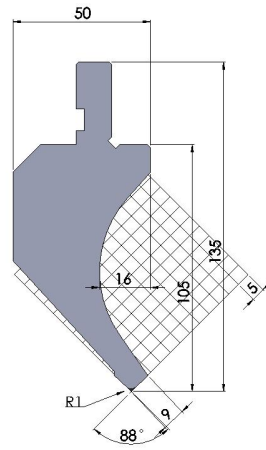
10.139

Max Tons:70t/m



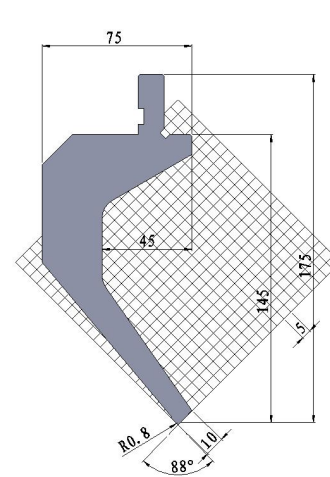
10.140

Max Tons:50t/m



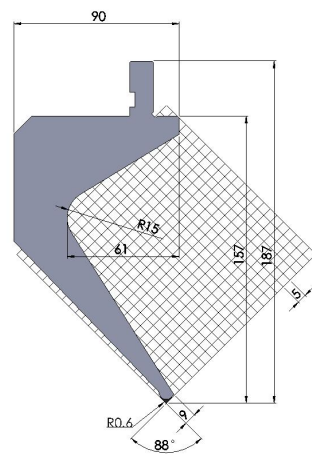
10.141

Max Tons:50t/m



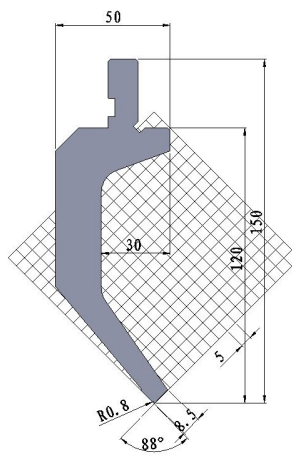
10.142

Max Tons:30t/m



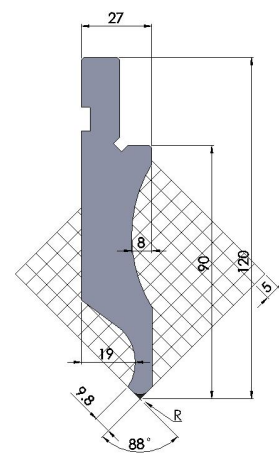
10.143

Max Tons:20t/m



10.144

Max Tons:50t/m



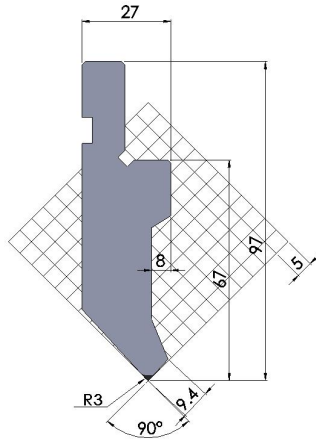
+

标准上模 90°

Standard punches 90°

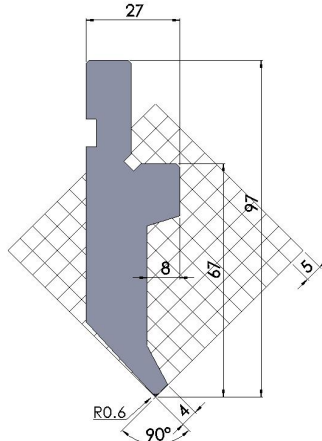
10.150

Max Tons:100t/m



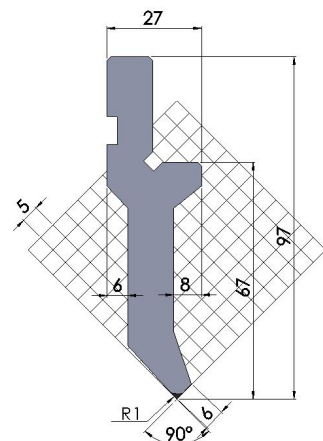
10.151

Max Tons:35t/m



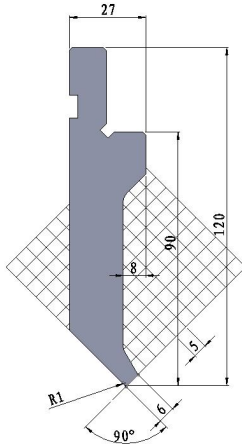
10.152

Max Tons:80t/m



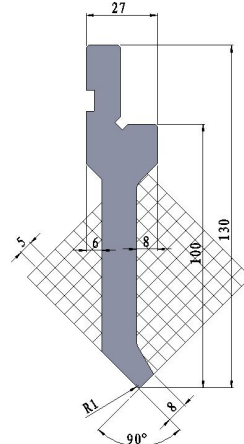
10.153

Max Tons:80t/m



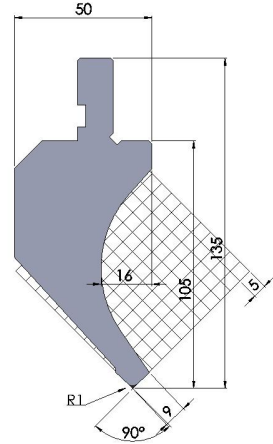
10.154

Max Tons:20t/m



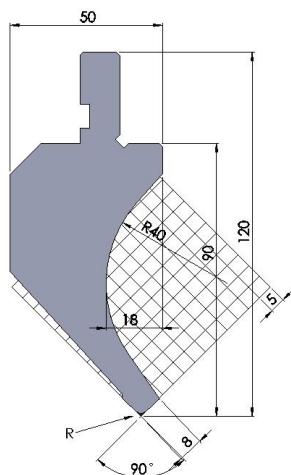
10.155

Max Tons:50t/m



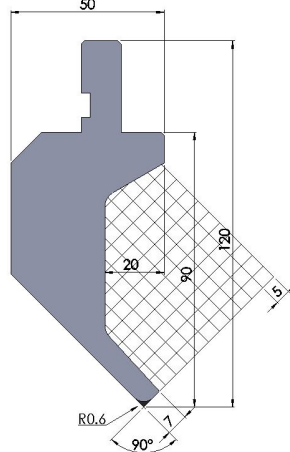
10.156

Max Tons:60t/m



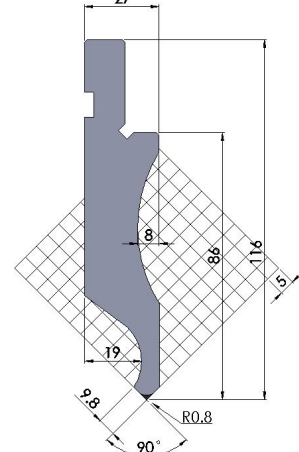
10.157

Max Tons:20t/m



10.158

Max Tons:50t/m

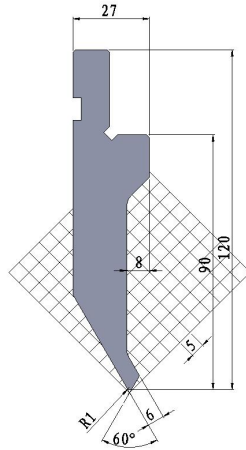


标准上模 60°

Standard punches 60°

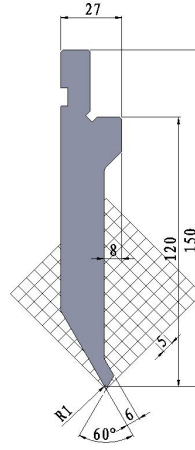
10.170

Max Tons:80t/m



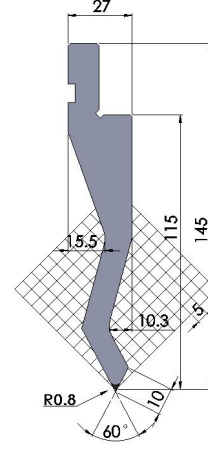
10.171

Max Tons:80t/m



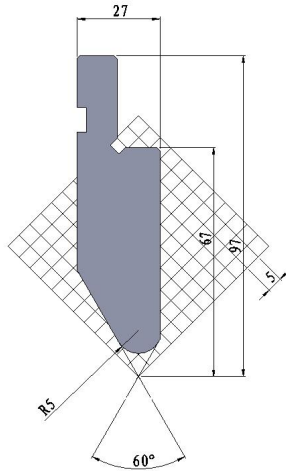
10.172

Max Tons:40t/m



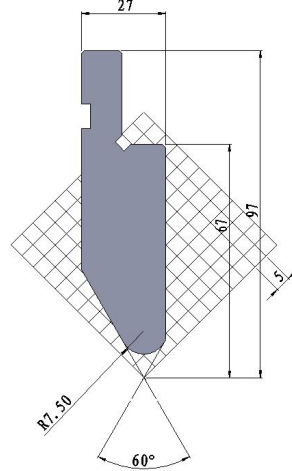
10.173

Max Tons:100t/m



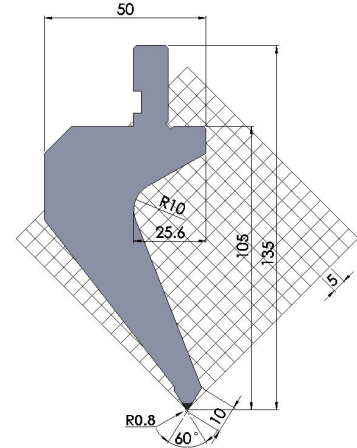
10.174

Max Tons:100t/m



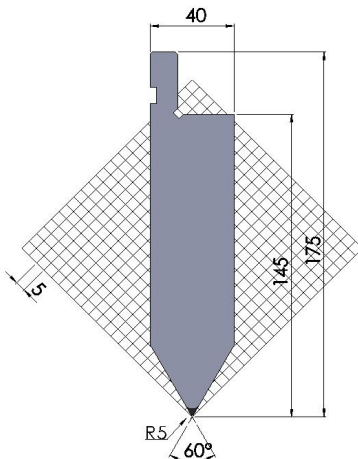
10.175

Max Tons:60t/m



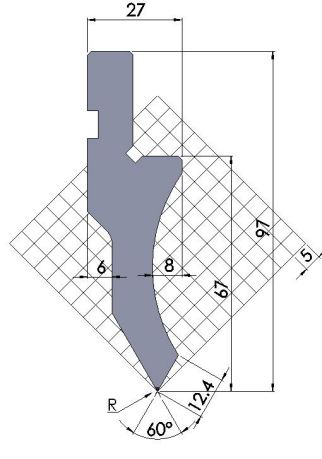
10.176

Max Tons:160t/m



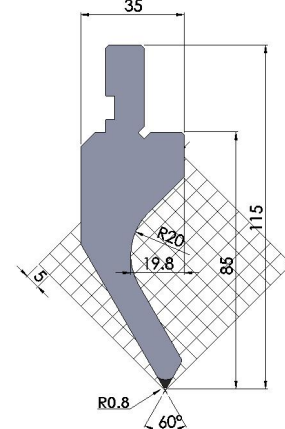
10.177

Max Tons:60t/m



10.178

Max Tons:40t/m

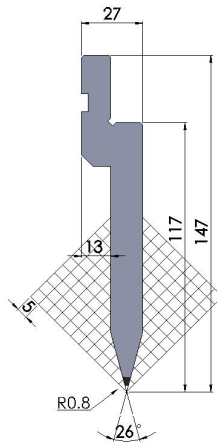


标准上模 26° 30° 35°

Standard punches 26° 30° 35°

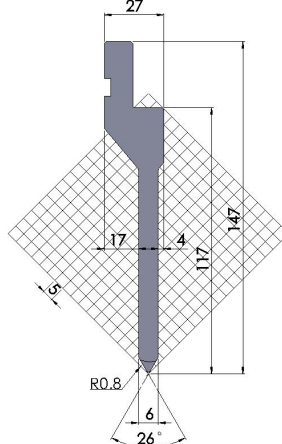
10.190

Max Tons:80t/m



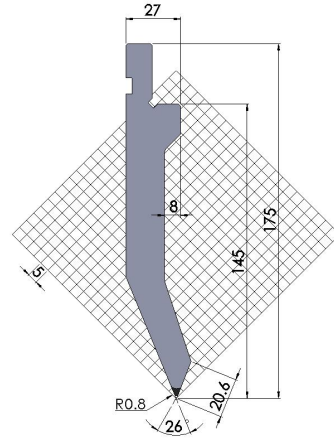
10.191

Max Tons:80t/m



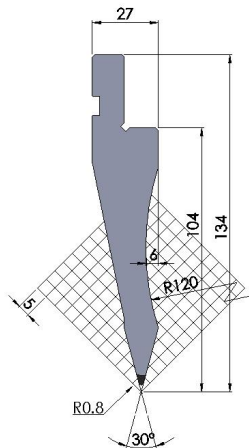
10.192

Max Tons:90t/m



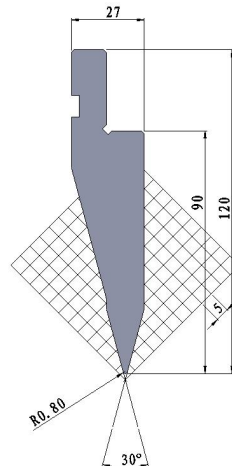
10.193

Max Tons:70t/m



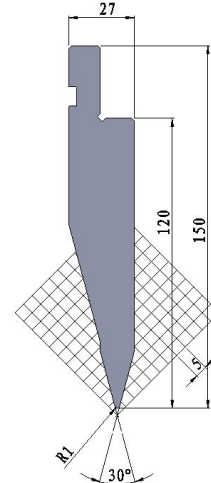
10.194

Max Tons:100t/m



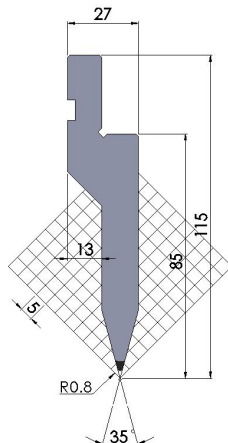
10.195

Max Tons:100t/m



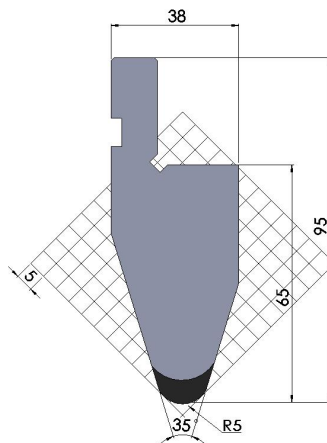
10.196

Max Tons:80t/m



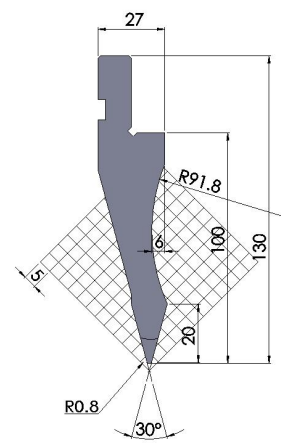
10.197

Max Tons:160t/m



10.198

Max Tons:70t/m

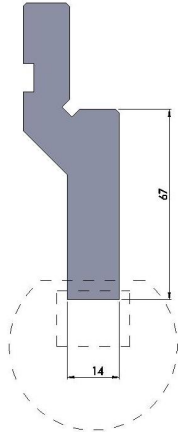


标准 R 型圆模

Standard R-type round tooling

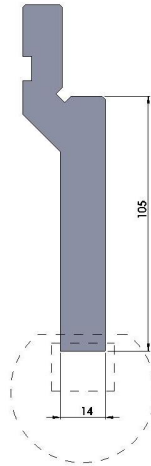
10.210

Max Tons:100t/m



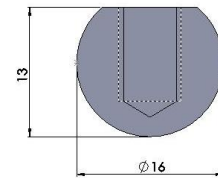
10.211

Max Tons:100t/m



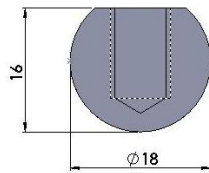
10.212

Max Tons:80t/m



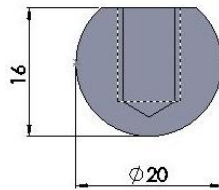
10.213

Max Tons:80t/m



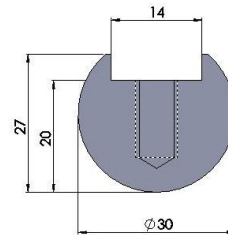
10.214

Max Tons:80t/m



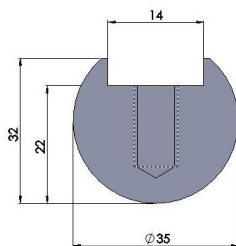
10.215

Max Tons:80t/m



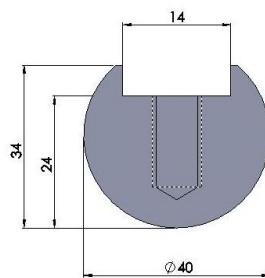
10.216

Max Tons:80t/m



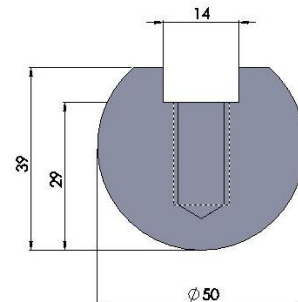
10.217

Max Tons:80t/m



10.218

Max Tons:80t/m

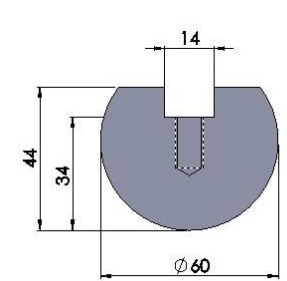


标准 R 型圆模

Standard R-type round tooling

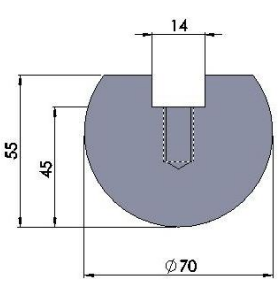
10.219

Max Tons:80t/m



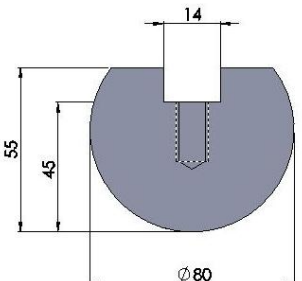
10.220

Max Tons:80t/m



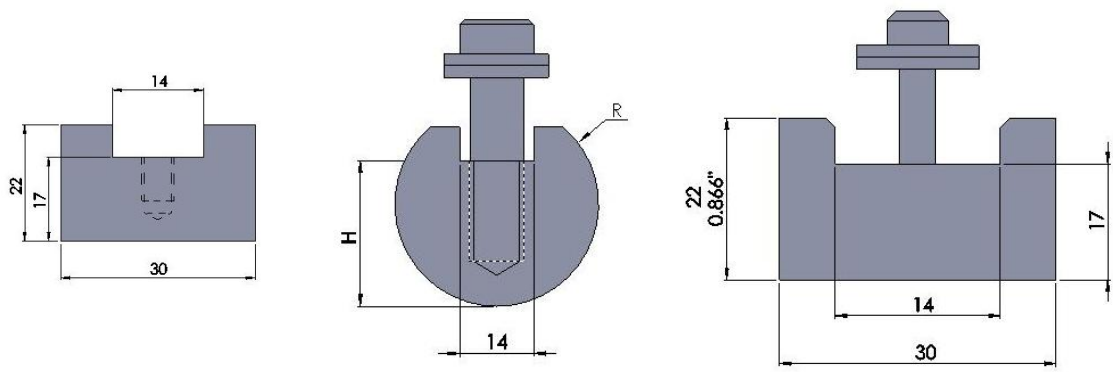
10.221

Max Tons:80t/m



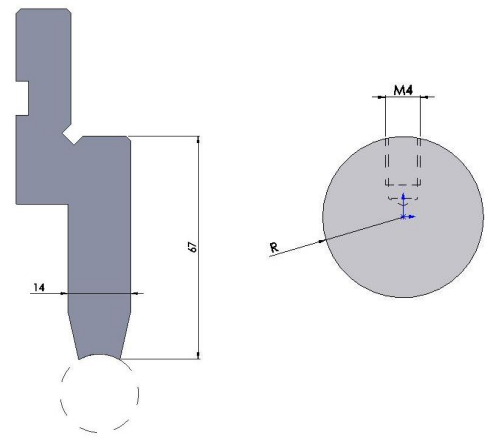
10.222

Max Tons:80t/m



10.230

Max Tons:80t/m



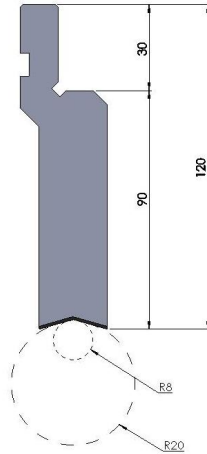
		Rmm		Rmm
10.231	R3	3	R5.5	5.5
10.232	R3.5	3.5	R6	6
10.233	R4	4	R6.5	6.5
10.234	R4.5	4.5	R7	7
10.235	R5	5	R7.5	7.5

标准圆模

Standard round tooling

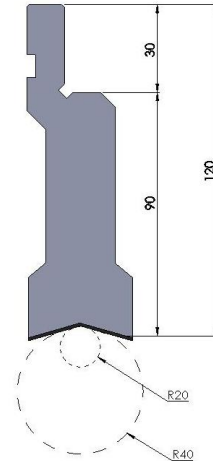
10.240

Max Tons:100t/m

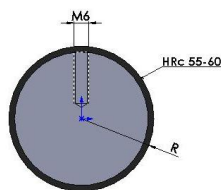
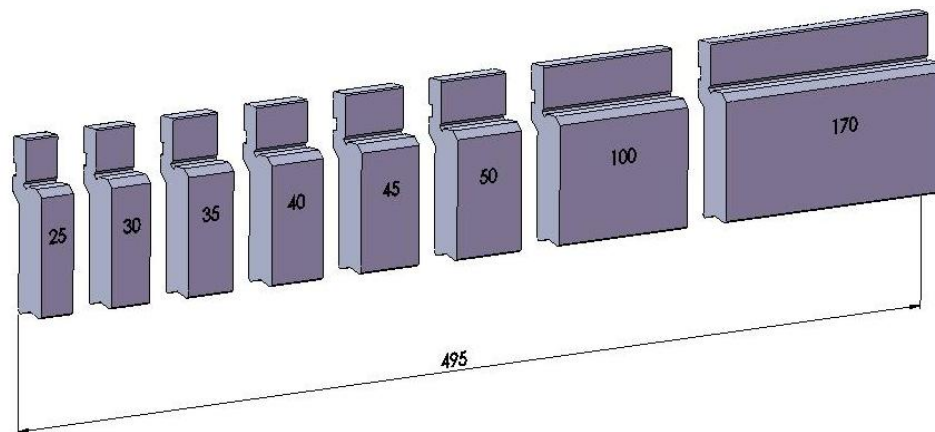


10.241

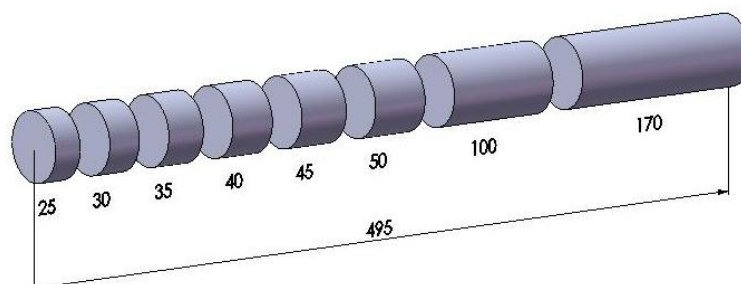
Max Tons:100t/m



分段方式 / Segmentation



		Rmm		Rmm
10.242	R8	8	R20	20
10.243	R10	10	R25	25
10.244	R12.5	12.5	R30	30
10.245	R15	15	R35	35
10.246	R17.5	17.5	R40	40



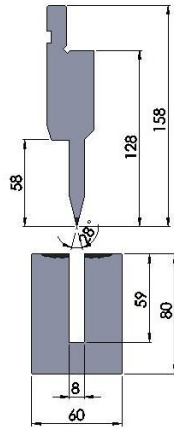
复平模具

Flattening tooling

10.250+20.134

10.250 Max Tons:A 80t/m B 100t/m

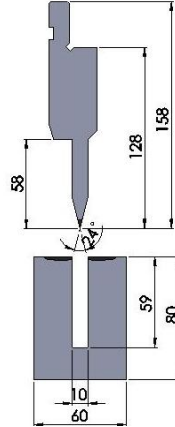
20.134 Max Tons:A 50t/m B 100t/m



10.251+20.135

10.251 Max Tons:A 80t/m B 100t/m

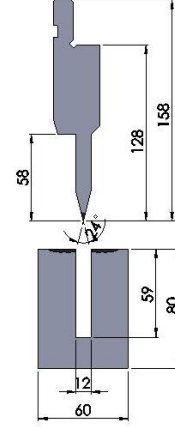
20.135 Max Tons:A 50t/m B 100t/m



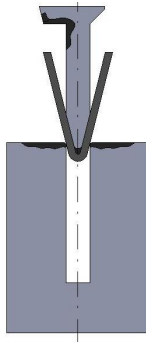
10.252+20.136

10.252 Max Tons:A 80t/m B 100t/m

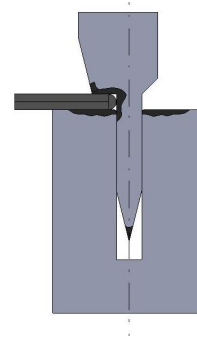
20.136 Max Tons:A 50t/m B 100t/m



A



B



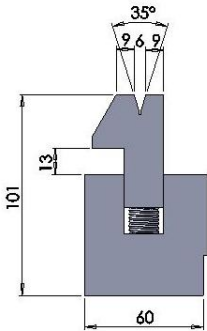
s mm	A mm	450Mpa t/m	700Mpa t/m	s mm	A mm	450Mpa t/m	700Mpa t/m
0.6	3.0	9	15	0.6	1.2	23	35
0.8	3.0	12	20	0.8	1.6	32	50
1.0	3.5	15	25	1.0	2.0	40	60
1.25	3.5	17	26	1.25	2.5	50	80
1.5	4.6	22	38	1.5	3.0	63	95
2.0	5.5	30	50	2.0	4.0	80	130

复平模具

Flattening tooling

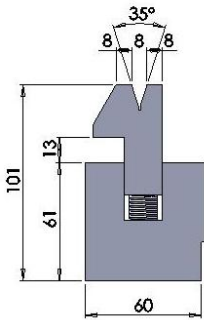
10.260

Max Tons:60t/m



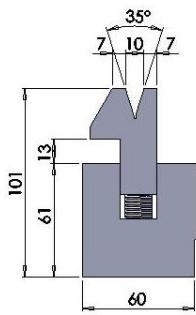
10.261

Max Tons:60t/m



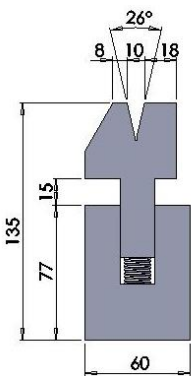
10.262

Max Tons:60t/m



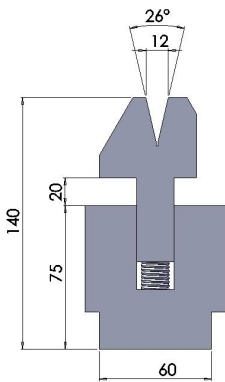
10.263

Max Tons:100t/m



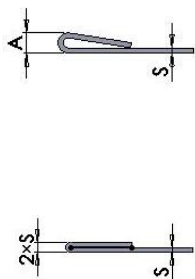
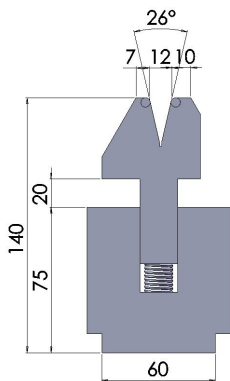
10.264

Max Tons:100t/m



10.265

Max Tons:100t/m



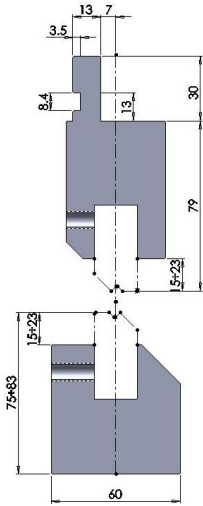
S mm	A Mm	450Mpa t/m	700Mpa t/m	s mm	A Mm	450Mpa t/m	700Mpa t/m
0.6	3.0	9	15	0.6	1.2	23	35
0.8	3.0	12	20	0.8	1.6	32	50
1.0	3.5	15	25	1.0	2.0	40	60
1.25	3.5	17	26	1.25	2.5	50	80
1.5	4.6	22	38	1.5	3.0	63	95
2.0	5.5	30	50	2.0	4.0	80	130
2.5	6.5	55		2.5	5.0	90	
3.0	8.0	70		3.0	6.0	100	

注：气动复平模可订制（含低划伤式）

标准 Z 型模
Standard Z-type tooing

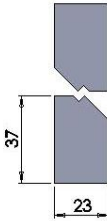
10.270

Max Tons:100t/m



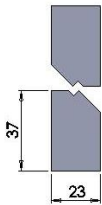
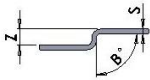
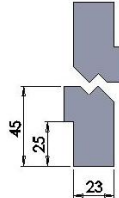
10.271

Max Tons:100t/m

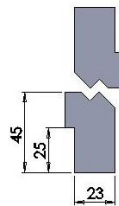
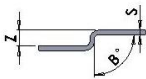


10.272

Max Tons:100t/m



	Z mm	B°	s max	max t/m
Z-1	1	160°	0.5	100
Z-1.5	1.5	160°	0.6	100
Z-2	2	150°	0.8	100
Z-2.5	2.5	140°	1.0	100
Z-3	3	90°	1.0	100
Z-3.5	3.5	90°	1.2	100
Z-4	4	90°	1.2	100
Z-4.5	4.5	90°	1.5	100
Z-5	5	90°	1.5	100
Z-5.5	5.5	90°	1.5	100
Z-6	6	90°	1.5	100
Z-6.5	6.5	90°	1.5	100
Z-7	7	90°	2	100
Z-7.5	7.5	90°	2	100
Z-8	8	90°	2.5	100

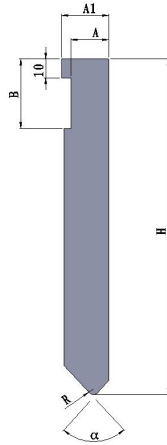


	Z mm	B°	s max	max t/m
Z-9	9	90°	2.5	100
Z-10	10	90°	3	100
Z-11	11	90°	3	100
Z-12	12	90°	3	100

标准重载直联型上模

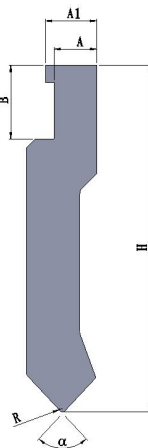
Standard heavy duty direct-link type tooling

10.280



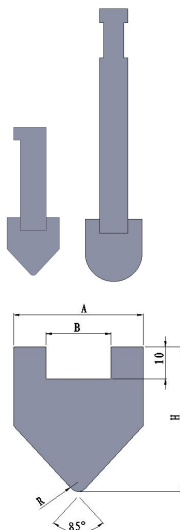
代号	A	A1	H	B	α	模尖 R Top end R	maxT/m
1	20	25	180	37	85°	R3	100
2	25	30	180	42	85°	R5	120
3	30	35	200	42	85°	R8	150
4	40	45	200	52	85°	R10	200

10.281



代号 Code	A	A1	H	B	α	模尖 R Top end R	maxT/m
1	20	25	180	37	85°	R3	100
2	25	30	180	42	85°	R5	120
3	30	35	200	42	85°	R8	150
4	40	45	200	52	85°	R10	200

10.290

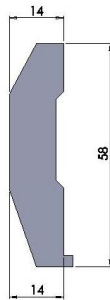


序号 Code	A	B	H	模尖 R Top end R	上模角度 α Tooling angle α
1	40	20	45	R3	85°
2	45	25	50	R3	85°
3	50	30	55	R5	85°
4	55	35	60	R5	85°
5	60	40	65	R8	85°
6	70	50	80	R10	85°

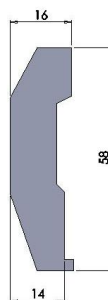
上模附件

Accessories of upper tooling

10.300

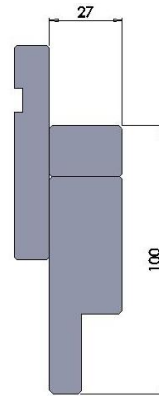


10.301



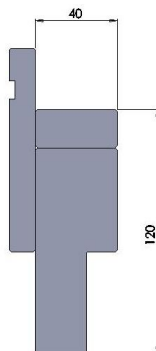
10.302

Max Tons:100t/m



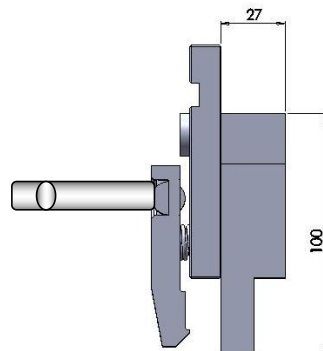
10.303

Max Tons:100t/m



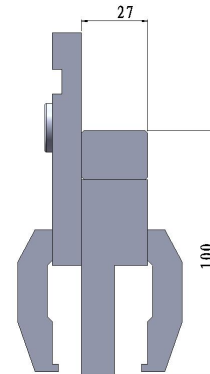
10.304

Max Tons:100t/m



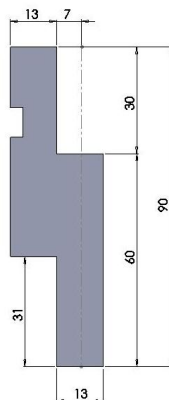
10.305

Max Tons:100t/m

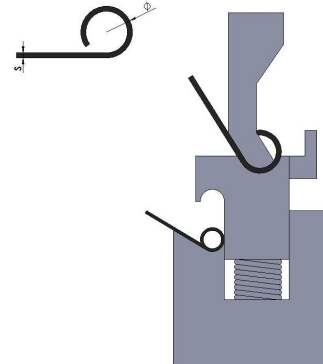
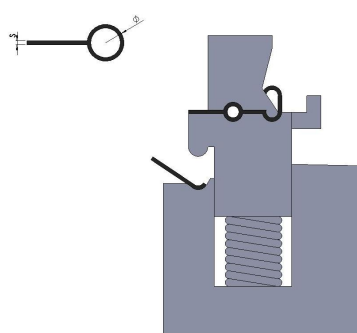


10.306

Max Tons:100t/m



特殊折弯方式 / special bending mode

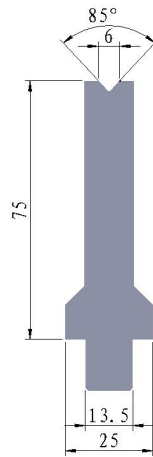


1V 下模

1V lower dies

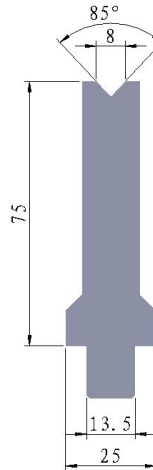
20.100

Max Tons:40t/m



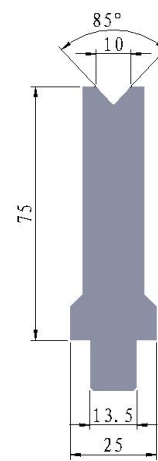
20.101

Max Tons:40t/m



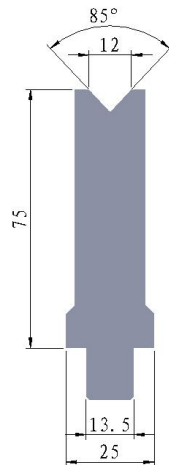
20.102

Max Tons:50t/m



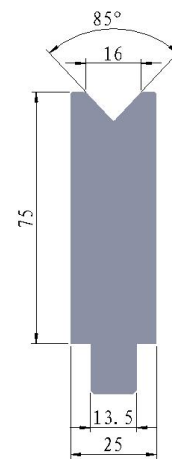
20.103

Max Tons:60t/m



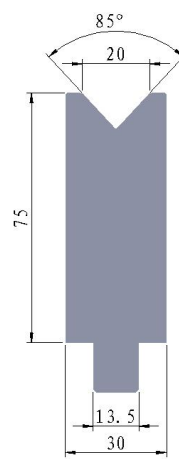
20.104

Max Tons:80t/m



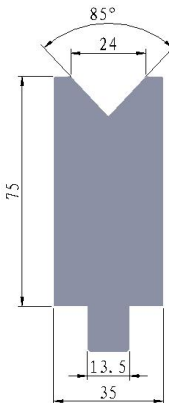
20.105

Max Tons:85t/m



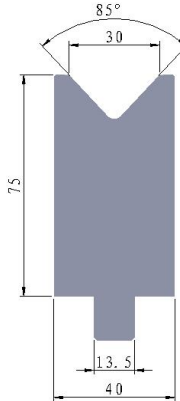
20.106

Max Tons:90t/m



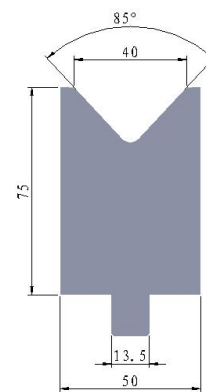
20.107

Max Tons:100t/m



20.108

Max Tons:100t/m

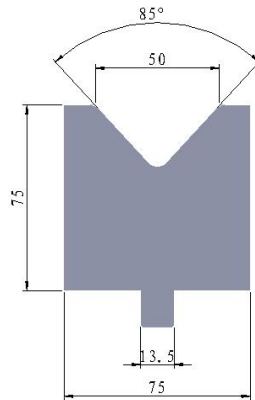


1V 下模

1V lower dies

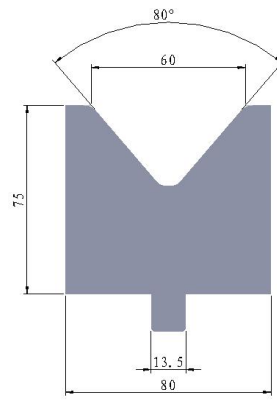
20.109

Max Tons:100t/m



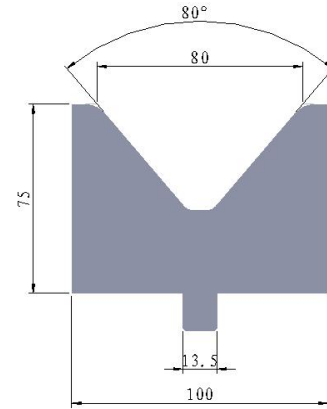
20.110

Max Tons:100t/m



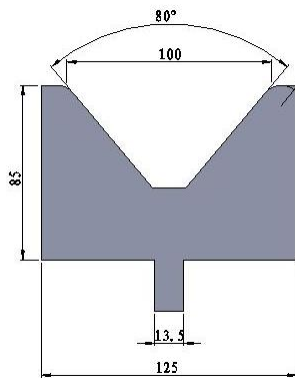
20.111

Max Tons:100t/m



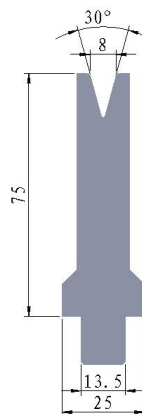
20.112

Max Tons:145t/m



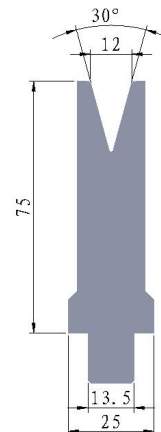
20.120

Max Tons:40t/m



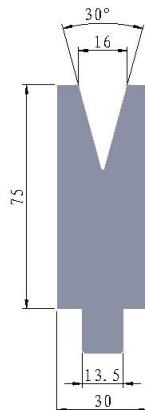
20.121

Max Tons:40t/m



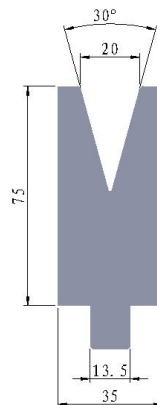
20.122

Max Tons:55t/m



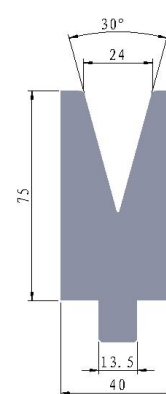
20.123

Max Tons:55t/m



20.124

Max Tons:60t/m

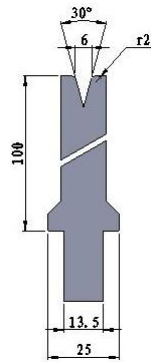


1V 下模

1V lower dies

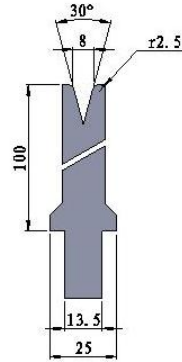
20.125

Max Tons:40t/m



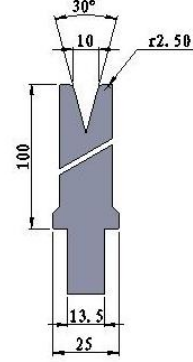
20.126

Max Tons:40t/m



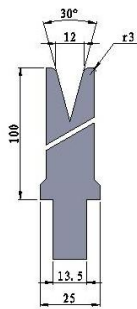
20.127

Max Tons:40t/m



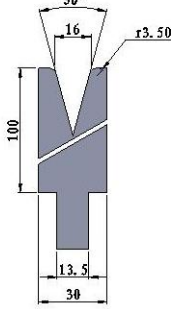
20.128

Max Tons:40t/m



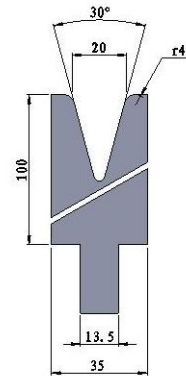
20.129

Max Tons:55t/m



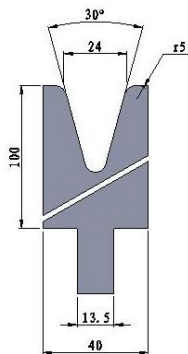
20.130

Max Tons:55t/m



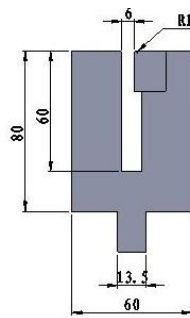
20.131

Max Tons:60t/m



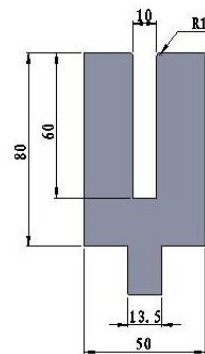
20.132

Max Tons:50t/m



20.133

Max Tons:50t/m

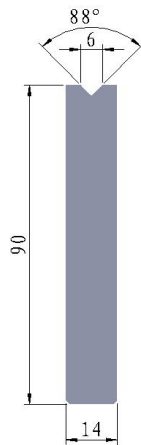


1V 下模

1V lower dies

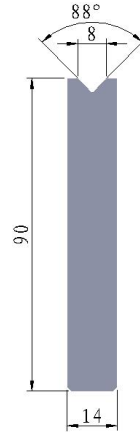
20.140

Max Tons:95t/m



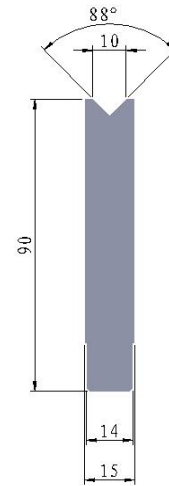
20.141

Max Tons:95t/m



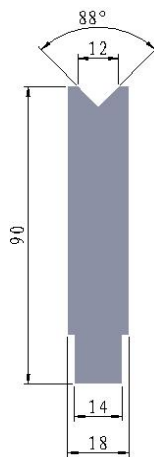
20.142

Max Tons:95t/m



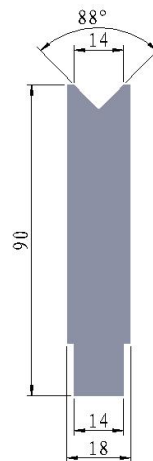
20.143

Max Tons:95t/m



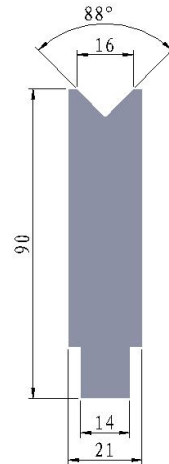
20.144

Max Tons:95t/m



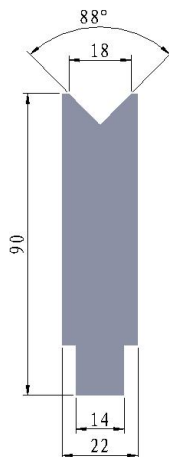
20.145

Max Tons:95t/m



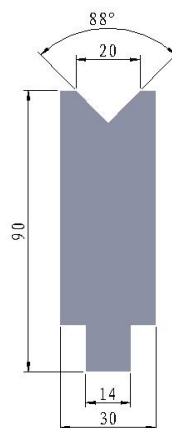
20.146

Max Tons:95t/m



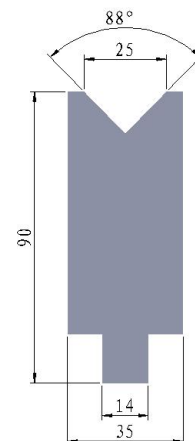
20.147

Max Tons:95t/m



20.148

Max Tons:95t/m

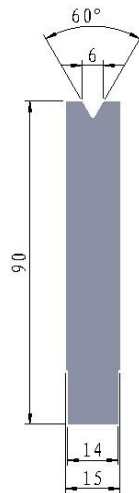


1V 下模

1V lower dies

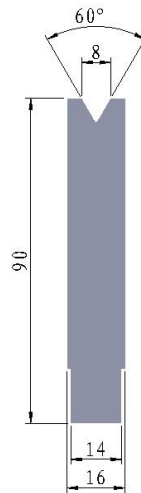
20.160

Max Tons:60t/m



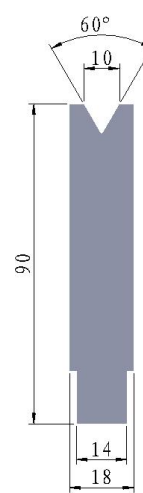
20.161

Max Tons:65t/m



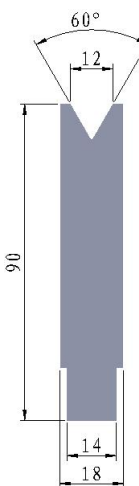
20.163

Max Tons:70t/m



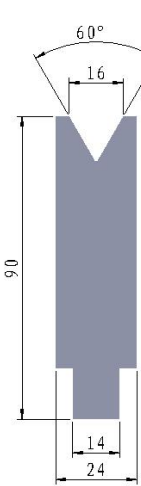
20.164

Max Tons:70t/m



20.165

Max Tons:70t/m



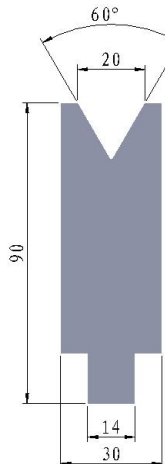
20.166

Max Tons:70t/m



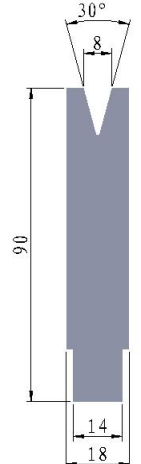
20.167

Max Tons:70t/m



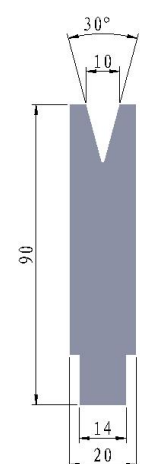
20.168

Max Tons:65t/m



20.169

Max Tons:70t/m

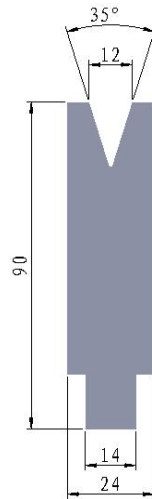


1V 下模

1V lower dies

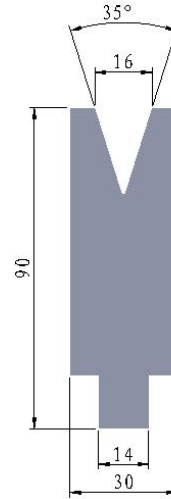
20.170

Max Tons:70t/m



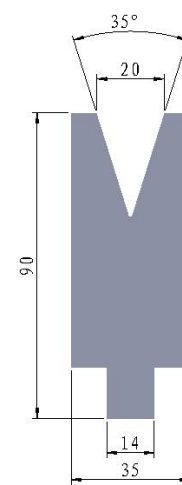
20.171

Max Tons:70t/m



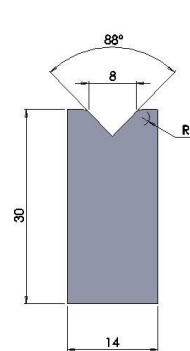
20.172

Max Tons:70t/m



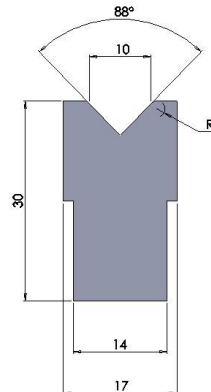
20.173

Max Tons:95t/m



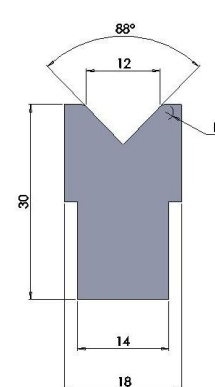
20.174

Max Tons:95t/m

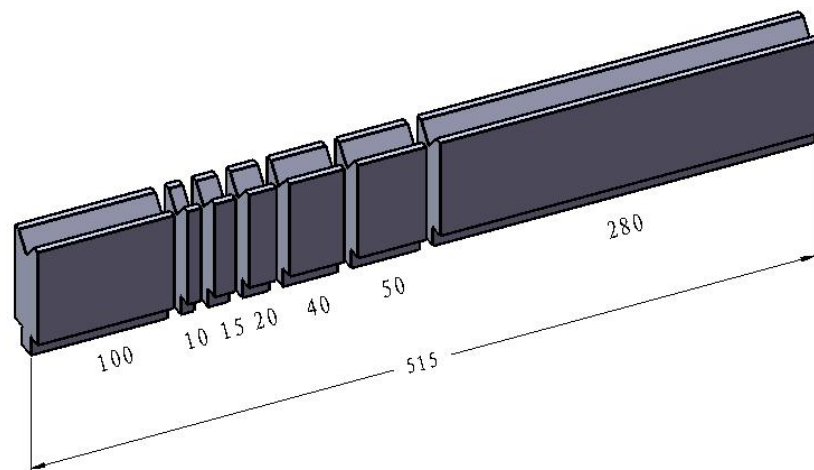


20.175

Max Tons:95t/m



分段方式 / Segmentation of lower tools



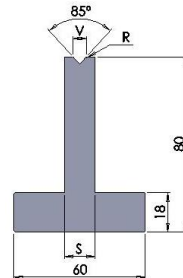
1V 下模

1V lower dies

20.350/Tx

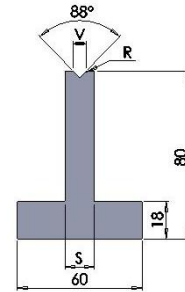
Max Tons:100t/m

	Vmm	Rmm	Smm	max t/m
T6	6	0.4	14	100
T8	8	0.5	14	100
T10	10	0.8	18	100
T12	12	2.75	18	100
T16	16	2.75	24	100
T20	20	3	30	100
T25	25	3	35	100
TR6	6	2.75	14	100
TR8	8	2.75	14	100
TR10	10	2.75	18	100



20.351/Tx

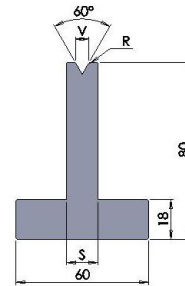
Max Tons:100t/m



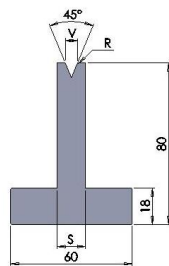
20.352/Tx

Max Tons:60t/m

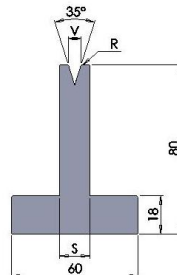
	Vmm	Rmm	Smm	max t/m
T6	6	0.5	14	60
T8	8	0.8	14	60
T10	10	0.8	18	60
T12	12	0.8	18	60
T16	16	2.75	24	60
T20	20	3	30	60
T25	25	3	35	60
TR6	6	1.5	14	60
TR8	8	1.5	14	60
TR10	10	2.75	18	60
TR12	12	2.75	18	60



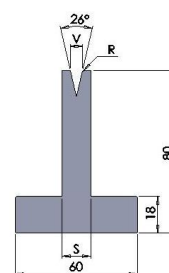
20.353/Tx



20.354/Tx



20.355/Tx



	Vmm	Rmm	Smm	max t/m		Vmm	Rmm	Smm	max t/m		Vmm	Rmm	Smm	max t/m
T6	6	0.8	14	50	T6	6	0.8	14	35	T6	6	0.8	16	20
T8	8	1	18	50	T8	8	1	16	35	T8	8	1	20	20
T10	10	1.2	18	50	T10	10	1.2	20	40	T10	10	1.2	24	20
T12	12	1.6	24	50	T12	12	1.6	22	40	T12	12	1.6	26	20
T16	16	2.75	26	50	T16	16	3	30	45					
T20	20	3	30	50	T20	20	3	35	50					
T25	25	3	37	50	T25	25	3	40	50					

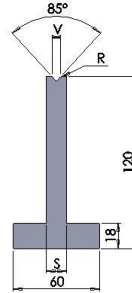
1V 下模

1V lower dies

20.356/Tx

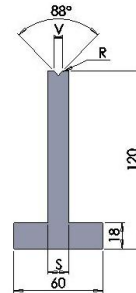
Max Tons:100t/m

	Vmm	Rmm	Smm	max t/m
T6	6	0.4	14	100
T8	8	0.5	14	100
T10	10	0.8	18	100
T12	12	2.75	18	100
T16	16	2.75	24	100
T20	20	3	30	100
T25	25	3	35	100
TR6	6	2.75	14	100
TR8	8	2.75	14	100
TR10	10	2.75	18	100



20.357/Tx

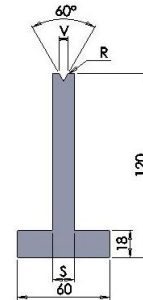
Max Tons:100t/m



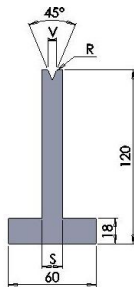
20.358/Tx

Max Tons:60t/m

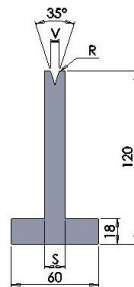
	Vmm	Rmm	Smm	max t/m
T6	6	0.5	14	60
T8	8	0.8	14	60
T10	10	0.8	18	60
T12	12	0.8	18	60
T16	16	2.75	24	60
T20	20	3	30	60
T25	25	3	35	60
TR6	6	1.5	14	60
TR8	8	1.5	14	60
TR10	10	2.75	18	60
TR12	12	2.75	18	60



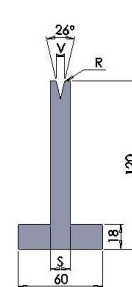
20.359/Tx



20.360/Tx



20.361/Tx



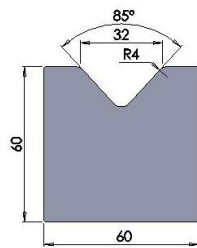
	Vmm	Rmm	Smm	max t/m		Vmm	Rmm	Smm	max t/m		Vmm	Rmm	Smm	max t/m
T6	6	0.8	14	50	T6	6	0.8	14	35	T6	6	0.8	16	20
T8	8	1	18	50	T8	8	1	16	35	T8	8	1	20	20
T10	10	1.2	18	50	T10	10	1.2	20	40	T10	10	1.2	24	20
T12	12	1.6	24	50	T12	12	1.6	22	40	T12	12	1.6	26	20
T16	16	2.75	26	50	T16	16	3	30	45					
T20	20	3	30	50	T20	20	3	35	50					
T25	25	3	37	50	T25	25	3	40	50					

1V 下模

1V lower dies

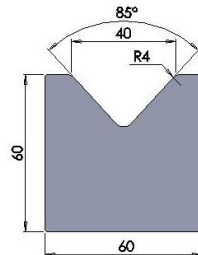
20.400

Max Tons:100t/m



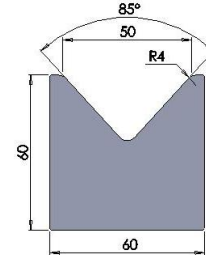
20.401

Max Tons:100t/m



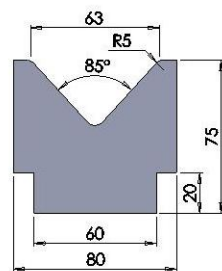
20.402

Max Tons:100t/m



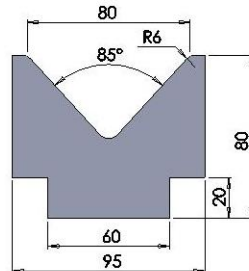
20.403

Max Tons:100t/m



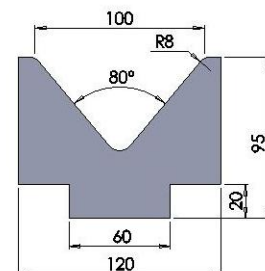
20.404

Max Tons:100t/m



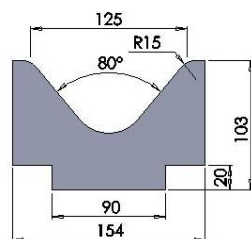
20.410

Max Tons:100t/m



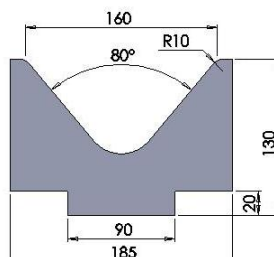
20.411

Max Tons:100t/m



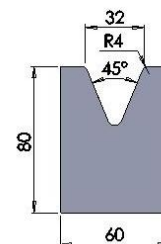
20.412

Max Tons:100t/m



20.420

Max Tons:100t/m

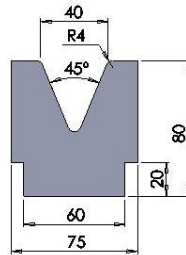


1V 下模

1V lower dies

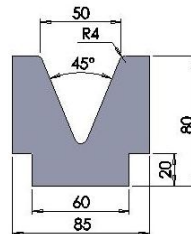
20.421

Max Tons:100t/m



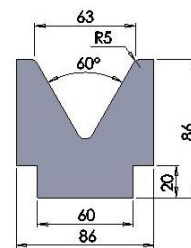
20.422

Max Tons:100t/m



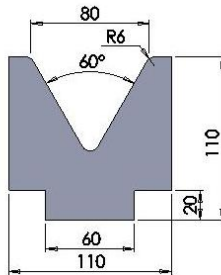
20.430

Max Tons:100t/m



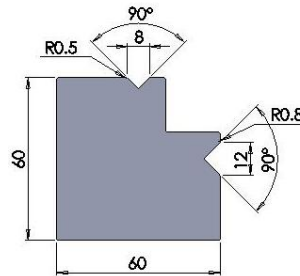
20.431

Max Tons:100t/m



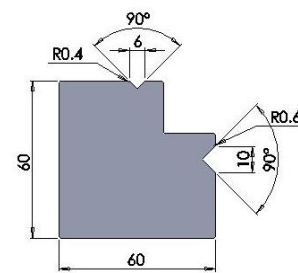
20.440

Max Tons:80t/m

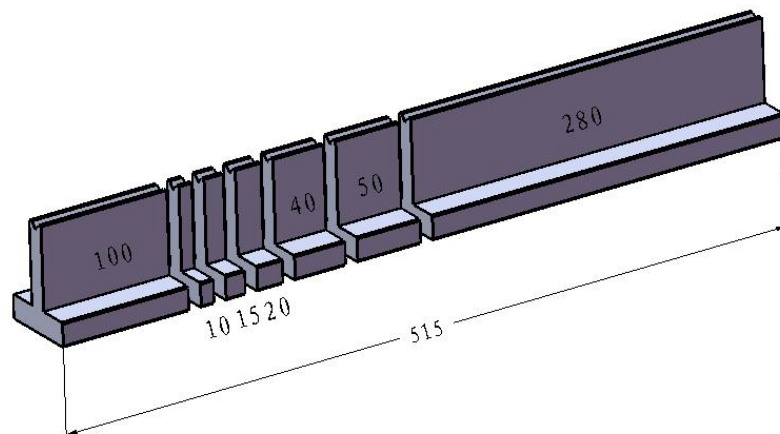


20.441

Max Tons:80t/m



分段方式 / Segmentation of lower dies



1V 下模

1V lower dies

低划伤下模 / Low Friction Dies 20.181~20.186

复合模具用于自由折弯

Compound dies are press brake dies for “airbending” only.

可最大程度地减少压痕

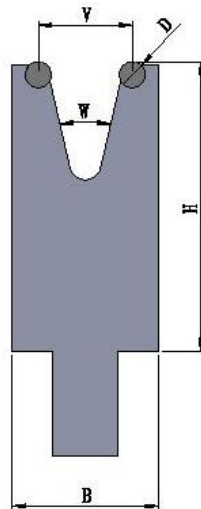
Minimal marking on the bend parts.

圆棒可以更换，以防磨损

The die bars are interchangeable in case of wear.

特殊的应用，圆棒可以选用不同材料，有镀锡、青铜或非金属圆棒

Choose of optimal radius material, Bronze or non metallic bars can be supplied for special application, The bars can be TIN coated for longer life and less friction.

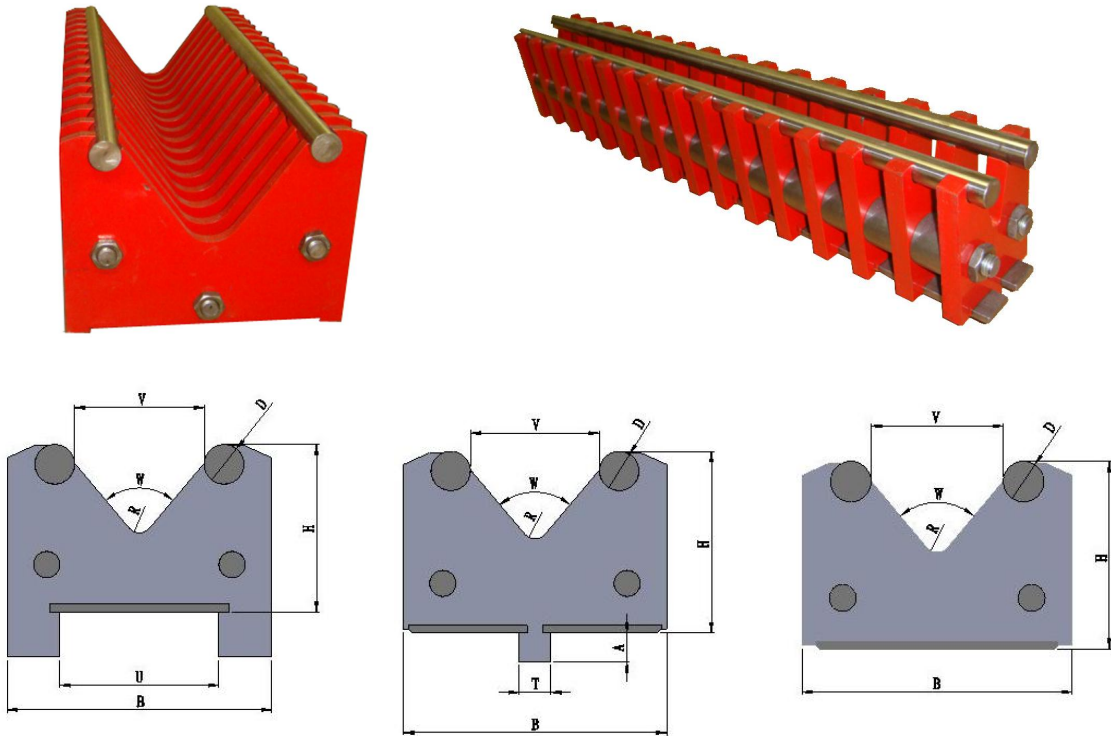


	V mm	D mm	W (°)	B mm	H mm	Max Tons t/m
20.181	8	3	30	20	75	20
20.182	12	4	30	24	75	30
20.183	16	5	30	28	75	40
20.184	20	5	30	32	75	45
20.185	24	6	30	40	75	50
20.186	32	8	60	52	75	60

1V 下模

1V lower dies

低划伤下模 / Low Friction Dies 20.191~20.204



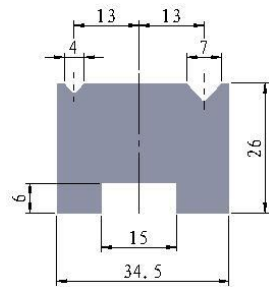
	V mm	D mm	W (°)	B mm	H mm	R mm	Max Tons t/m
20.191	32	10	28	53	75	5	50
20.192	32	10	85	53	75	5	70
20.193	40	10	85	62	75	5	80
20.194	48	10	85	70	75	5	90
20.195	50	15	40	85	90	7	80
20.196	60	15	40	110	110	10	100
20.197	80	20	50	150	130	10	120
20.198	100	20	60	170	140	18	150
20.199	120	25	60	190	160	18	180
20.200	150	25	60	235	180	25	200
20.201	200	30	80	300	220	30	250
20.202	250	30	80	350	300	40	300
20.203	300	40	80	440	360	40	400
20.204	400	50	80	570	400	50	500

2V 下模

2V lower dies

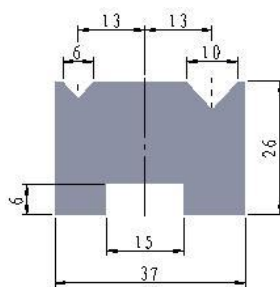
20.220

Max Tons:70t/m



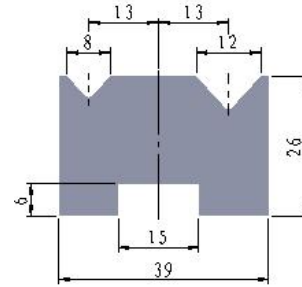
20.221

Max Tons:80t/m



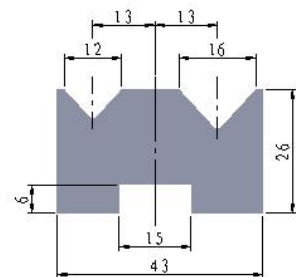
20.222 (互换性模具)

Max Tons:80t/m



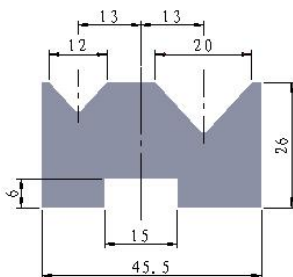
20.223 (互换性模具)

Max Tons:80t/m



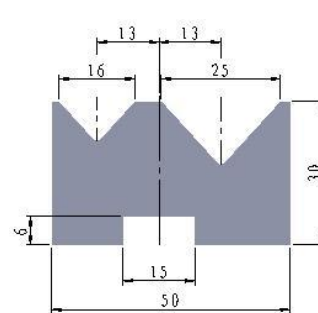
20.224

Max Tons:80t/m



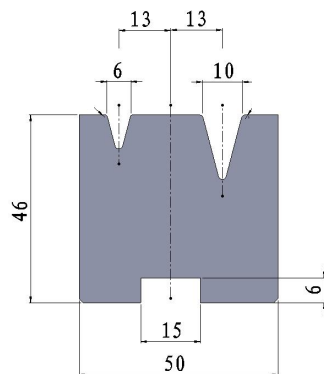
20.225 (互换性模具)

Max Tons:80t/m



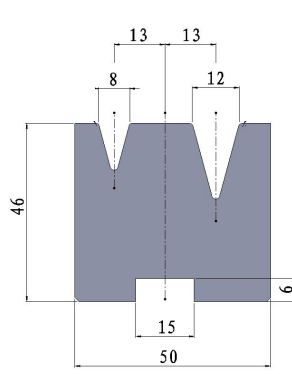
20.230

Max Tons:60t/m



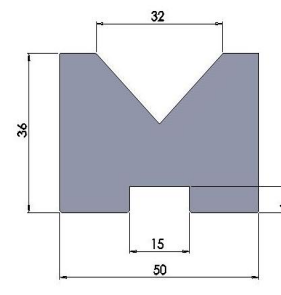
20.231

Max Tons:60t/m



20.232

Max Tons:100t/m

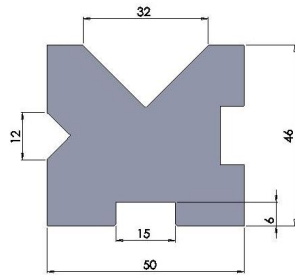


2V 下模

2V lower dies

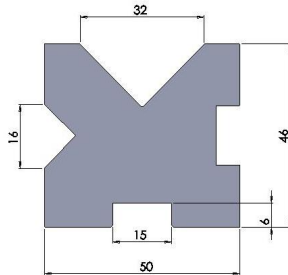
20.233

Max Tons:100t/m



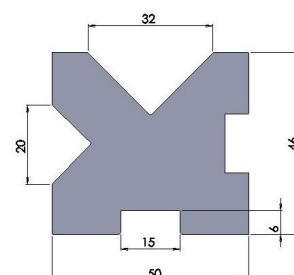
20.234

Max Tons:100t/m



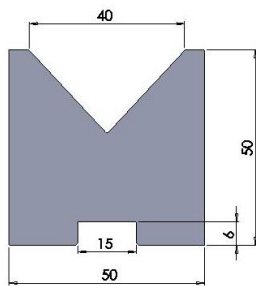
20.235

Max Tons:100t/m



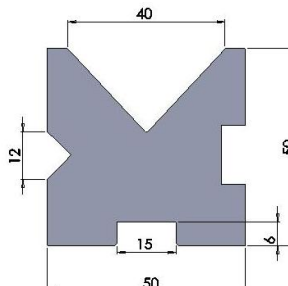
20.236

Max Tons:100t/m



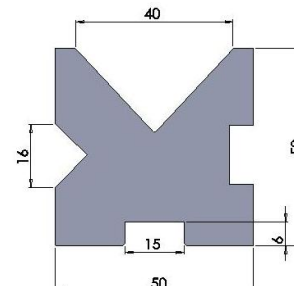
20.237

Max Tons:100t/m



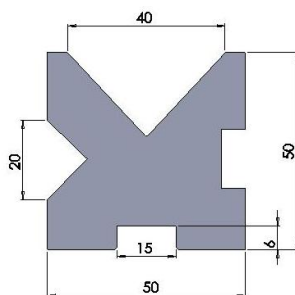
20.238

Max Tons:100t/m



20.239

Max Tons:1000t/m

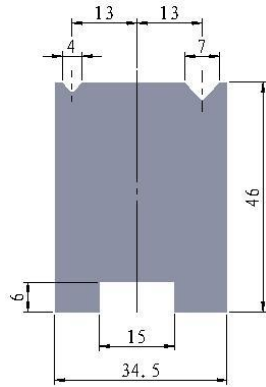


2V 下模

2V lower dies

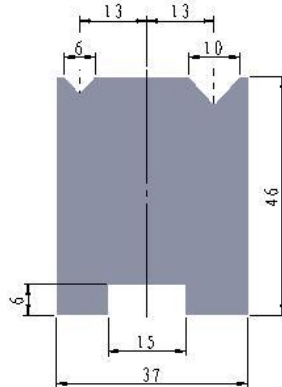
20.250

Max Tons:80t/m



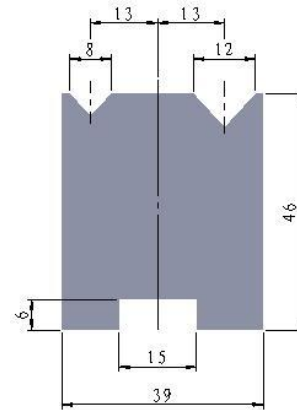
20.251

Max Tons:80t/m



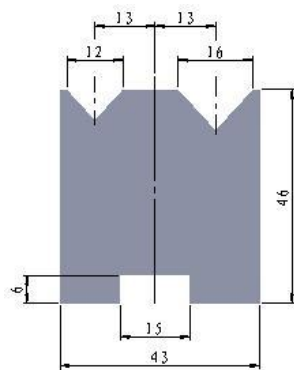
20.252

Max Tons:80t/m



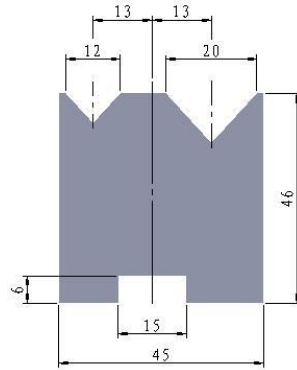
20.253

Max Tons:80t/m



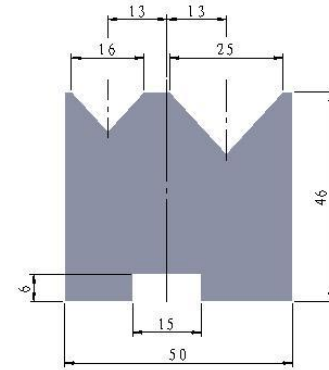
20.254

Max Tons:80t/m



20.255

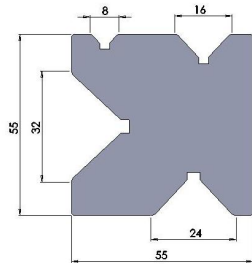
Max Tons:80t/m



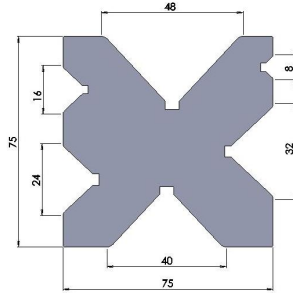
多 V 下模

multi-V lower dies

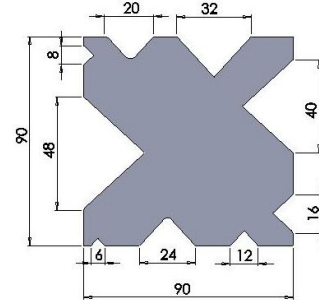
20.500



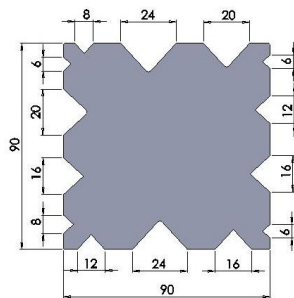
20.501



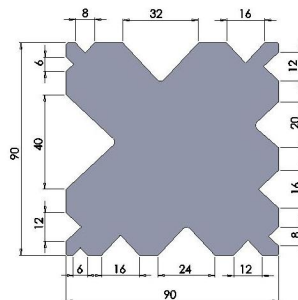
20.502



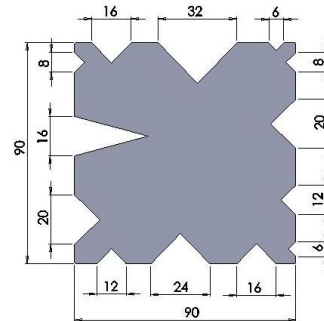
20.503



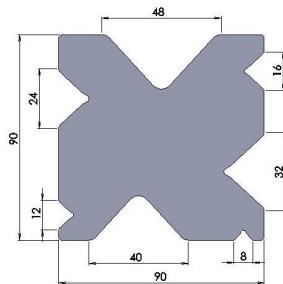
20.504



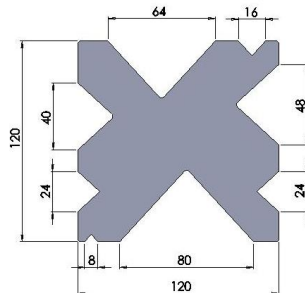
20.505



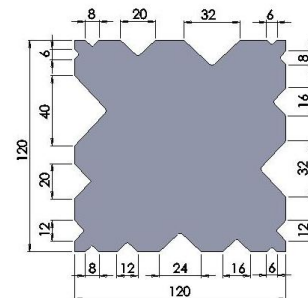
20.506



20.507



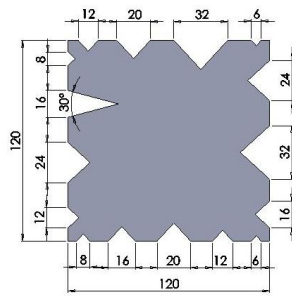
20.508



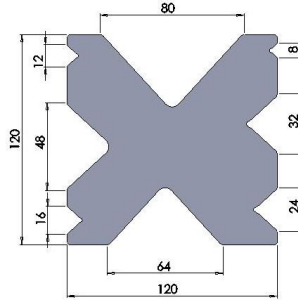
多 V 下模

multi-V lower dies

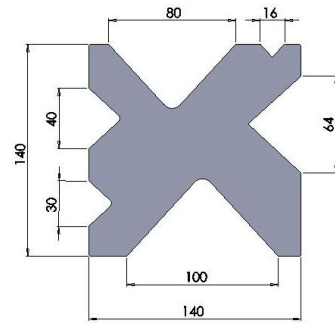
20.509



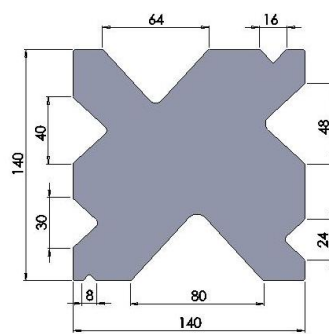
20.510



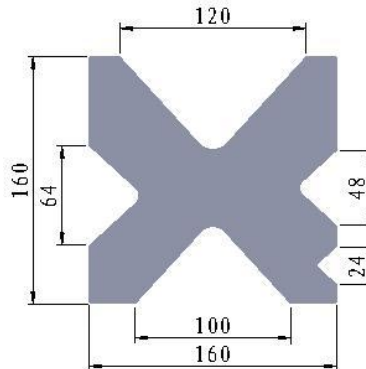
20.511



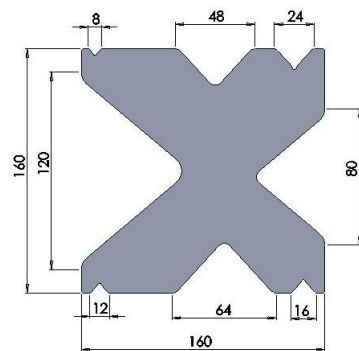
20.512



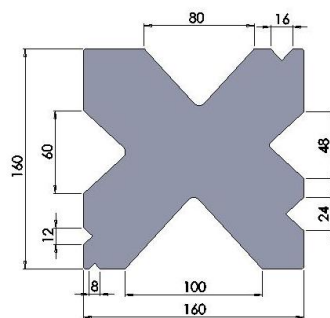
20.513



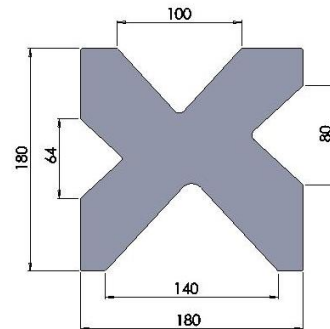
20.514



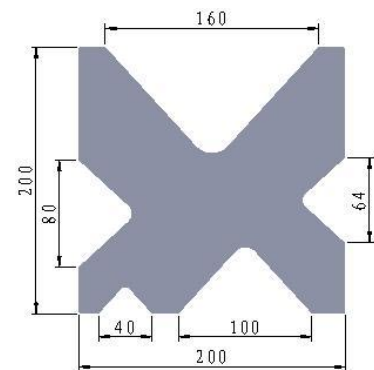
20.515



20.516



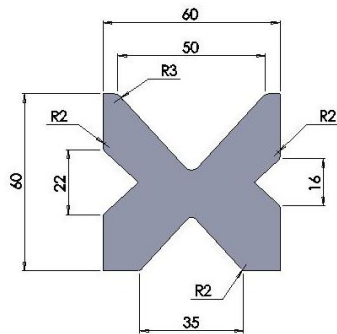
20.517



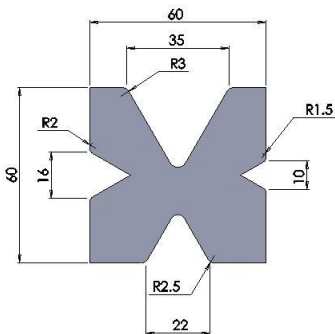
多 V 下模

multi-V lower dies

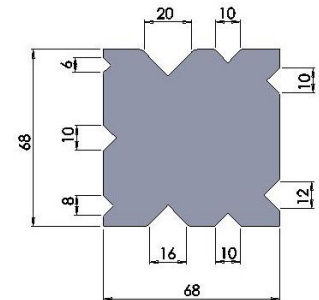
20.530



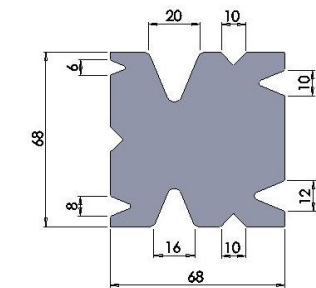
20.531



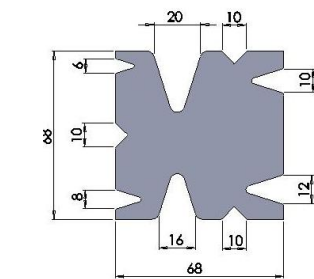
20.540



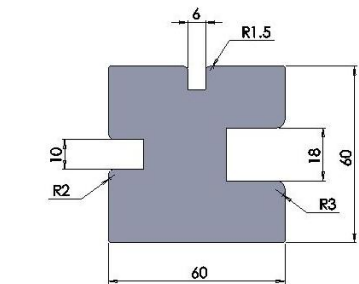
20.541



20.550



20551

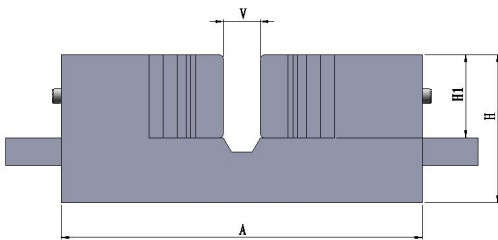


插片式下模

Combined dies

20.560

Max Tons:200t/m

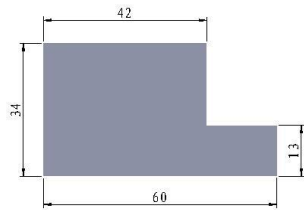


序号 Code	Vmax	A	H	H1
1	200	390	160	90
2	240	460	190	110
3	280	540	220	130
4	320	620	250	150
5	360	700	260	160
6	400	800	290	180

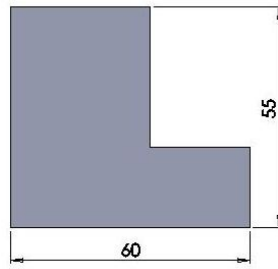
下模附件

Accessories of lower dies

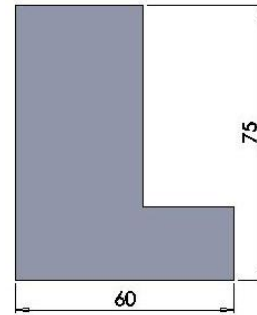
20.600 (可互换)



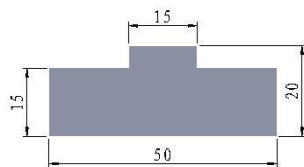
20.601



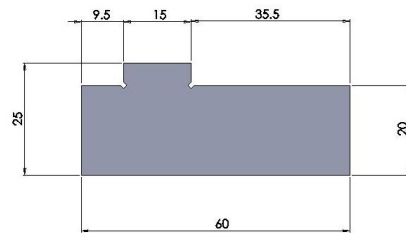
20.602



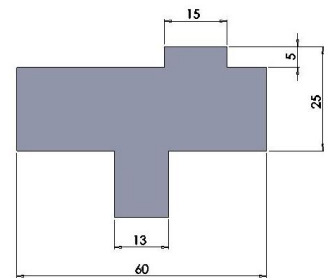
20.603 (可互换)



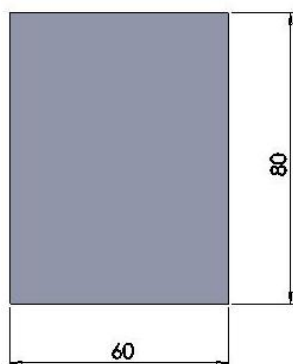
20.604



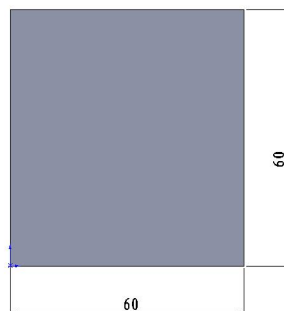
20.605



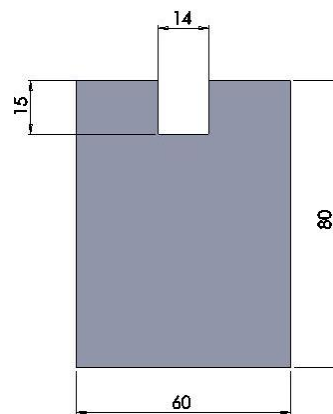
20.606



20.607



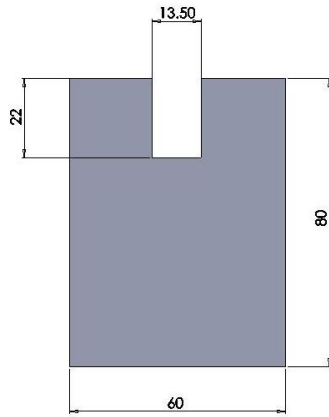
20.608



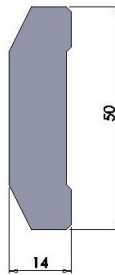
下模附件

Accessories of lower dies

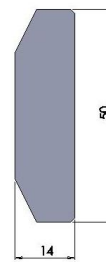
20.609



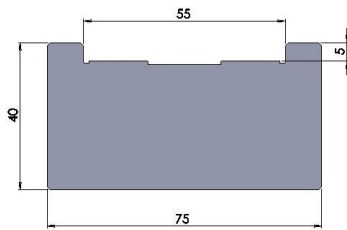
20.610



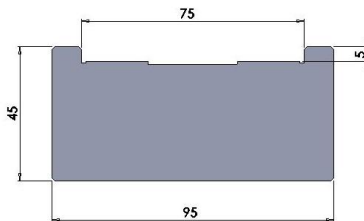
20.611



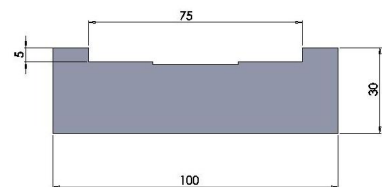
20.612



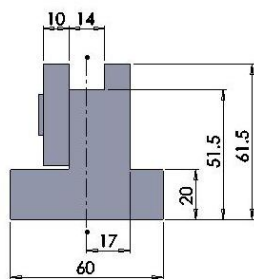
20.613



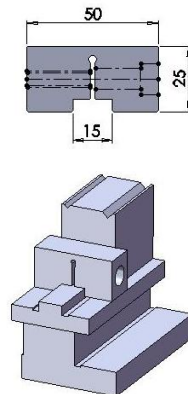
20.614



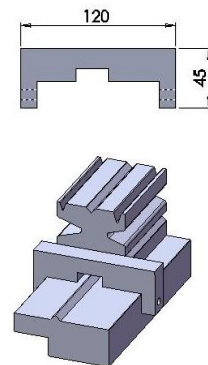
20.615



20.616



20.617



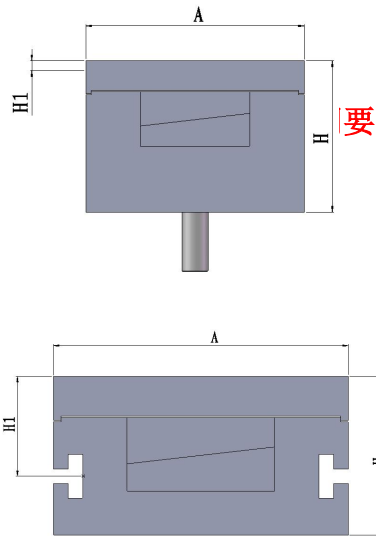
下模附件

Accessories of lower dies

机械补偿工作台

Mechanical crowning table

20.700



序号 Code	A	H	H1	T 型螺栓 T type bolt	应用范围 Application scope
1	90	110	9		50T~220T
2	200	110	60	M12	110T~160T
3	240	120	60	M12	220T~300T
4	320	140	60	M12	300T~500T
5	400	150	100	M20	500T~630T
6	480	150	100	M20	800T~1000T
7	560	175	120	M24	1000T~1200T
8	640	195	120	M24	1200T~1600T
9	720	195	120	M24	1600T~2000T
10	820	220	135	M24	2000T~2500T