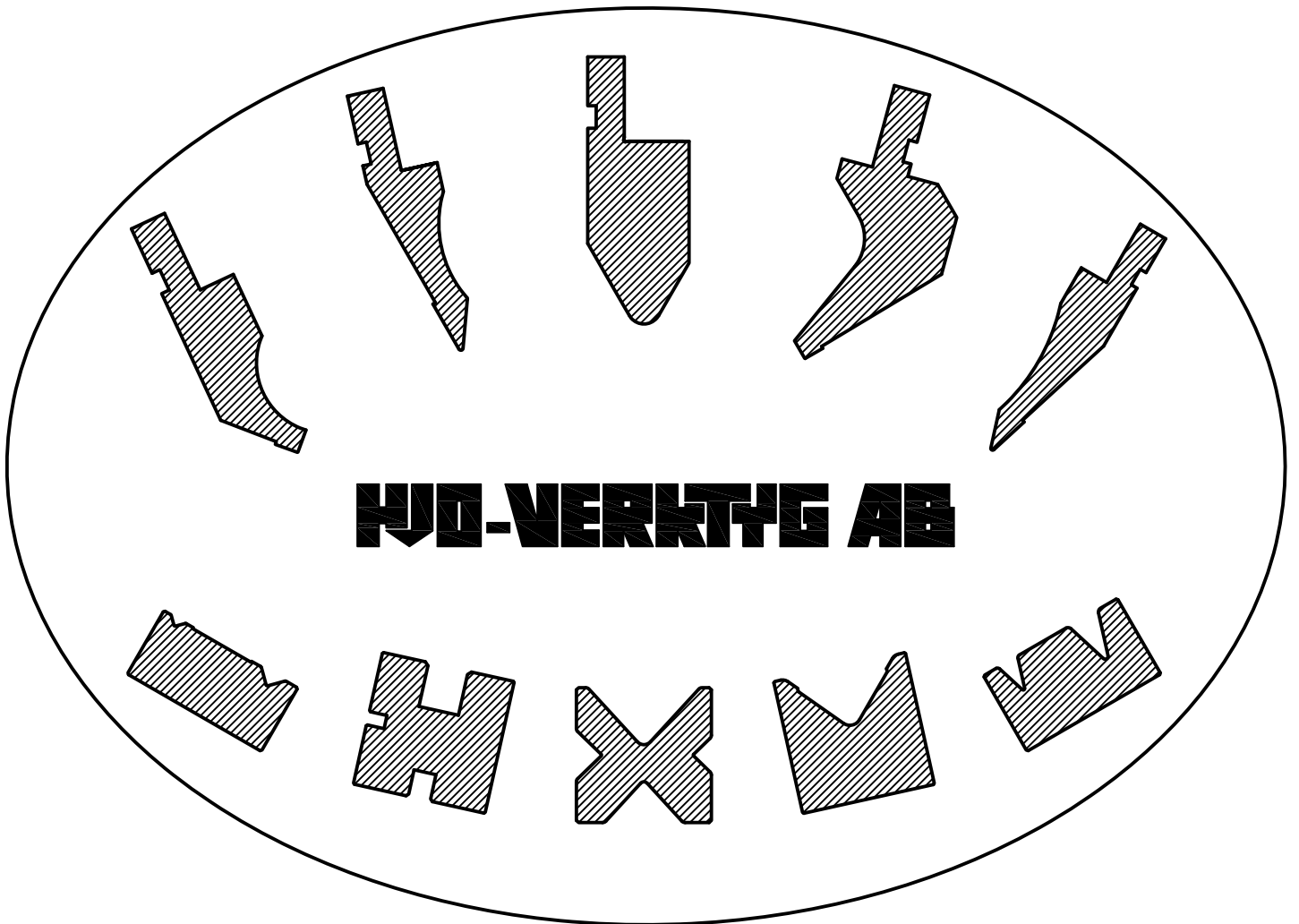


Kantpressverktyg



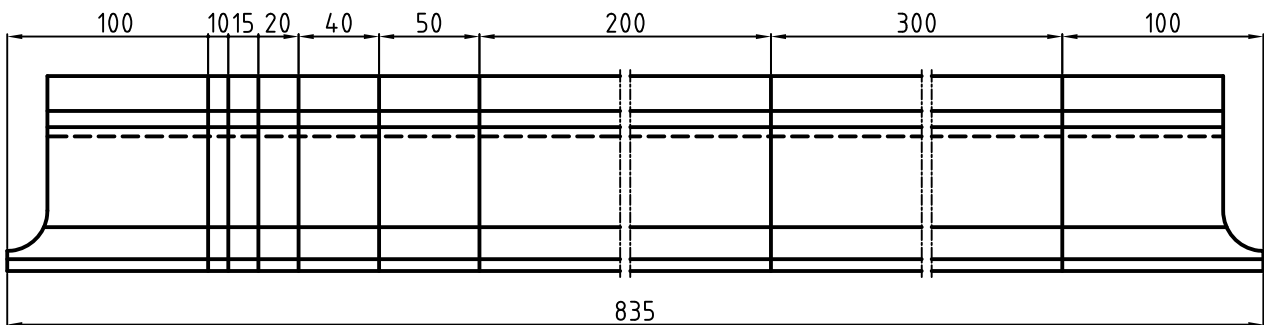
Hjo-Verktyg AB, Industrigatan 38, 544 50 Hjo
Telefon 0503-130 80, Telefax 0503-120 19
Internet www.hjoverktyg.se
E-post info@hjoverktyg.se

Stansfästen samt delningar

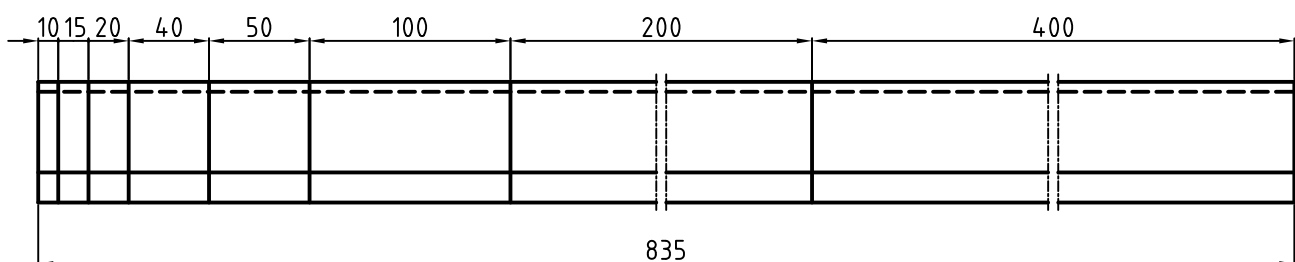
Ver 1.3

| | | | |
|------------------------|----------------------------------|---|----------------------|
| <p>Typ A</p> | <p>Typ B</p> | <p>Typ U</p> | <p>Typ FR</p> |
| <p>Typ Euro</p> | <p>Typ Donewell/Safan</p> | <p>Ex. montering av fästtapp på standarddyna</p> | |

Standarddelning på stansar



Standarddelning på dynor



Stansar 90°

Ver 1.3

| | | | |
|---|---|--|---|
| <p>10.10/90° R=0.2/0.8 100 T/m</p> | <p>10.116/90° R=0.2 15 T/m</p> | <p>10.201/90° R=0.2 30 T/m</p> | <p>10.203/90° R=0.2 30 T/m</p> |
| <p>10.14/90° R=0.2/0.8 70 T/m</p> | <p>10.146/90° R=0.2/0.8 50 T/m</p> | <p>10.15/90° R=0.2/0.8 50 T/m</p> | <p>10.048/90° R=0.2/0.8 50 T/m</p> |
| <p>10.16/90° R=0.2 15 T/m</p> | <p>10.108/90° R=0.2 50 T/m</p> | | |

Standardlängder för stansar och dynor

415mm samt 835mm

De flesta stansarna och dynorna kan även erhållas
sektionerade i satser enligt sid.2

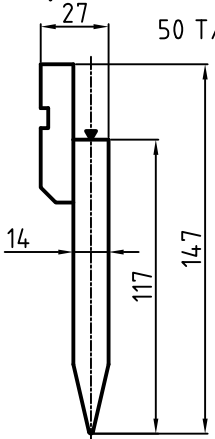
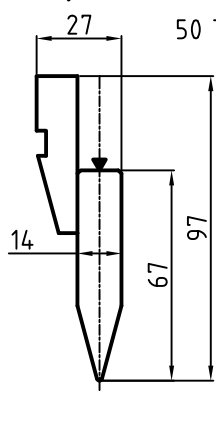
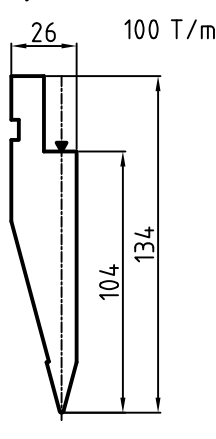
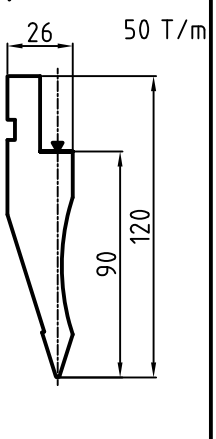
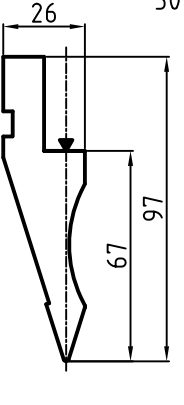
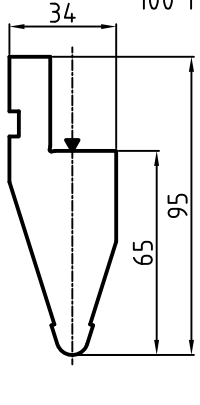
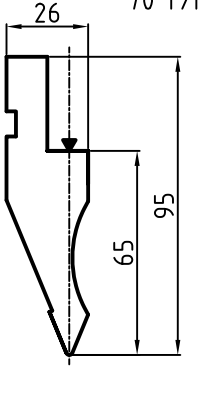
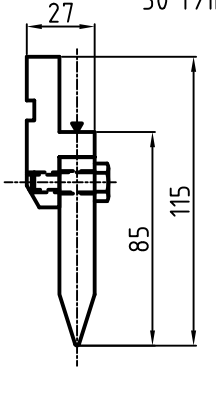
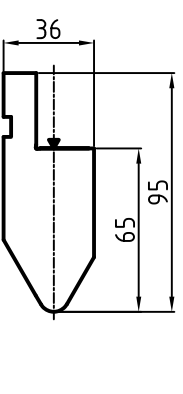
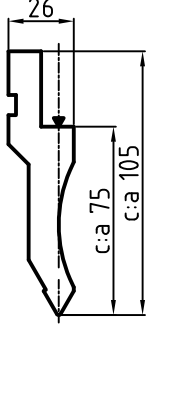
Stansar 88°

Ver 1.3

| | | | |
|--|--|---|--|
| <p>10.10/88° R=0.2/0.8/3.0 100 T/m</p> | <p>10.116/88° R=0.2 15 T/m</p> | <p>10.200/88° R=0.2/0.8 30 T/m</p> | <p>10.202/88° R=0.2/0.8 30 T/m</p> |
| <p>10.14/88° R=0.2/0.8/3.0 70 T/m</p> | <p>10.146/88° R=0.2/0.8 50 T/m</p> | <p>10.15/88° R=0.2/0.8/3.0 50 T/m</p> | <p>10.047/88° R=0.2/0.8 50 T/m</p> |
| <p>10.049/88° R=0.8 50 T/m</p> | <p>10.16/88° R=0.2 15 T/m</p> | <p>10.109/88° R=0.2/0.8 50 T/m</p> | |
| | | | |

Stansar 26°- 60°

Ver 1.3

| | | | |
|--|---|--|--|
| <p>10.18/26° R=0.8 50 T/m</p>  | <p>10.103/30° R=0.8 50 T/m</p>  | <p>10.210/30° R=0.8 100 T/m</p>  | <p>10.12/35° R=0.8 50 T/m</p>  |
| <p>10.11/35° R=0.8 50 T/m</p>  | <p>10.13/35° R=5 100 T/m</p>  | <p>10.11/45° R=1.0 70 T/m</p>  | <p>40.08+10.17/35° R=0.8 50 T/m</p>  |
| <p>10.13/60° R=6 100 T/m</p>  | <p>10.20/60° R=0.8/2.0 70 T/m</p>  | | |

Standardlängder för stansar och dynor

415mm samt 835mm

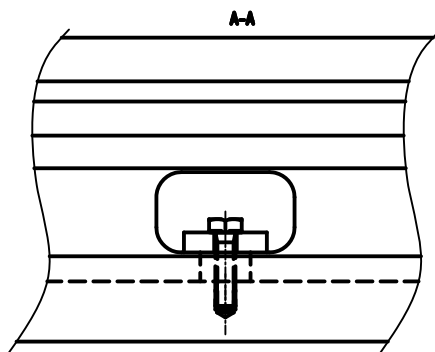
De flesta stansarna och dynorna kan även erhållas
sektionerade i satser enligt sid.2

Radiestans, Plattningsstans samt hållare

Ver 1.3

| | | | |
|--|--|--|--|
| <p>40.30</p> <p>ø6-ø8-ø10</p> <p>ø12-ø16-ø20</p> | <p>40.05</p> <p>27</p> <p>97</p> <p>67</p> <p>14</p> <p>A</p> <p>A</p> | <p>40.02</p> <p>30</p> <p>14</p> <p>28</p> | <p>40.09 Typ Amada</p> <p>D</p> <p>D=20, 25, 30, 35, 40, 50, 60, 80, 100mm</p> |
|--|--|--|--|

Sidvy radiestanshållare 40.05
tillsammans med radienos 40.09



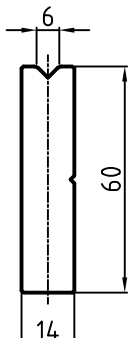
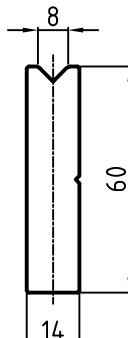
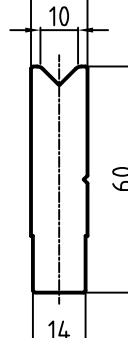
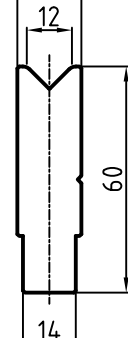
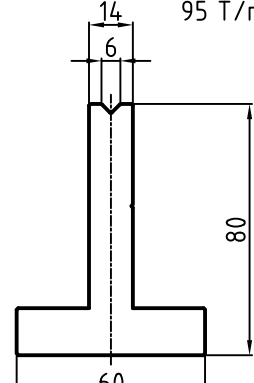
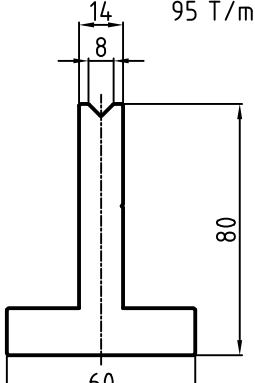
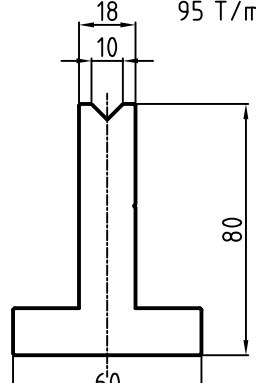
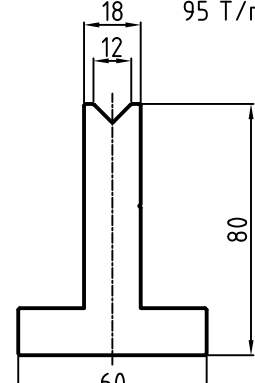
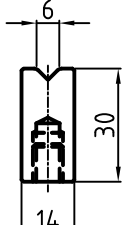
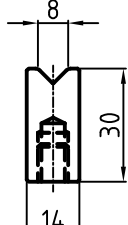
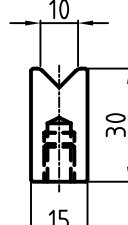
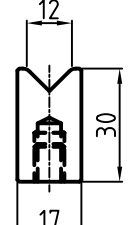
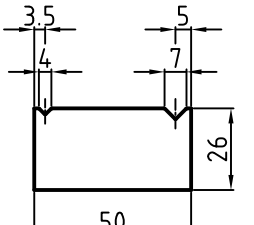
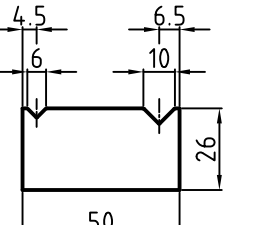
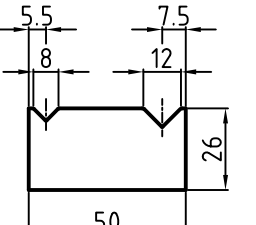
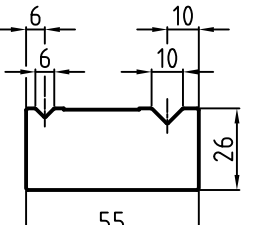
Standardlängder för stansar och dynor

415mm samt 835mm

De flesta stansarna och dynorna kan även erhållas
sektionerade i satser enligt sid.2

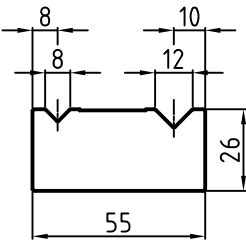
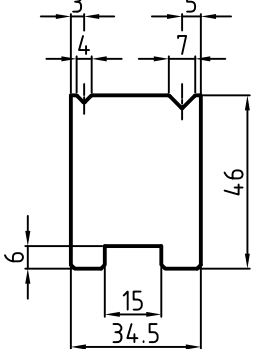
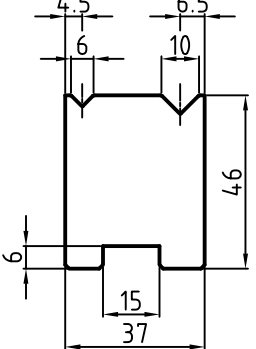
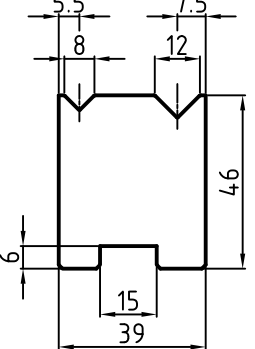
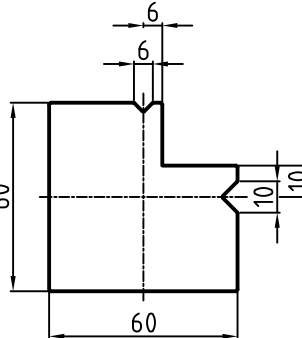
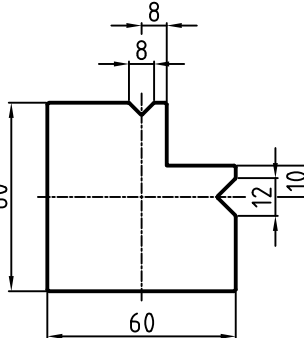
Dynor 90°

Ver 1.3

| | | | |
|---|---|--|---|
| <p>70.90° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>71.90° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>73.90° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>75.90° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> |
| <p>20.41/90° 95 T/m</p>  | <p>20.42/90° 95 T/m</p>  | <p>20.43/90° 95 T/m</p>  | <p>20.44/90° 95 T/m</p>  |
| <p>320/90°</p>  <p>Avsedd för hållare 330</p> | <p>321/90°</p>  <p>Avsedd för hållare 330</p> | <p>323/90°</p>  <p>Avsedd för hållare 330</p> | <p>324/90°</p>  <p>Avsedd för hållare 330</p> |
| <p>121.90° Genomhärdat 60 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>123.90° Genomhärdat 70 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>124.90° Genomhärdat 80 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>20.12/90° 80 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> |

Dynor 90°

Ver 1.3

| | | | |
|---|--|---|--|
| <p>20.13/90° 80 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>501/90° 60 T/m</p>  <p>Avsedd för hållare 40.15</p> | <p>502/90° 70 T/m</p>  <p>Avsedd för hållare 40.15</p> | <p>503/90° 70 T/m</p>  <p>Avsedd för hållare 40.15</p> |
| <p>20.16</p>  | <p>20.17</p>  | | |
| | | | |

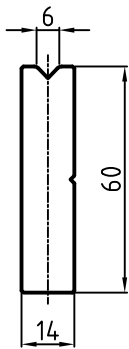
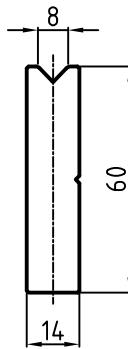
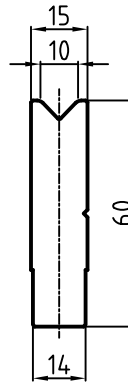
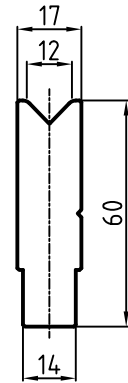
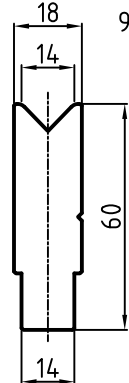
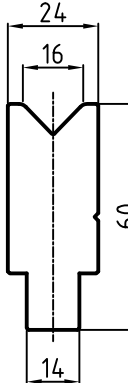
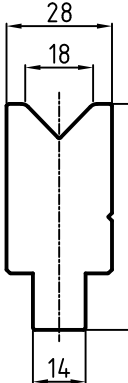
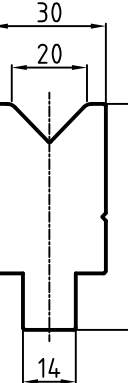
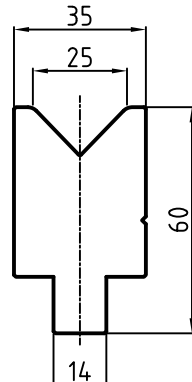
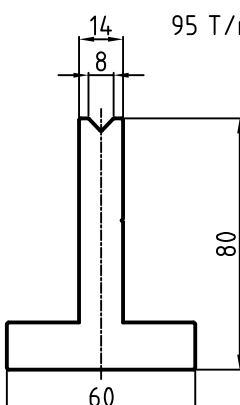
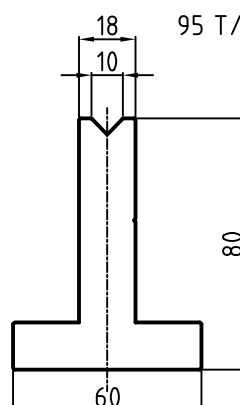
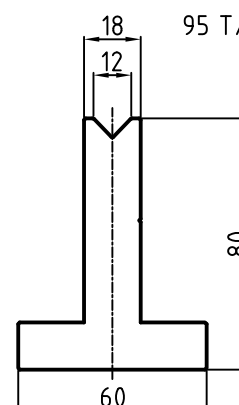
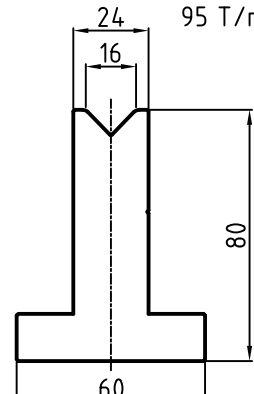
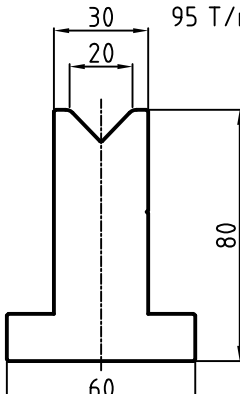
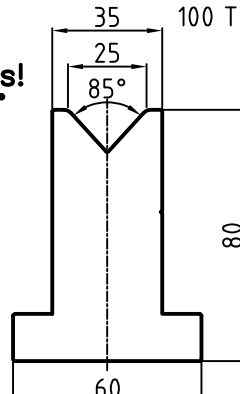
Standardlängder för stansar och dynor

415mm samt 835mm

De flesta stansarna och dynorna kan även erhållas
sektionerade i satser enligt sid.2

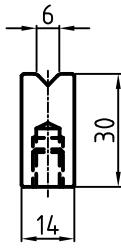
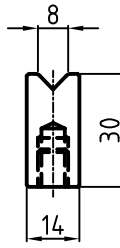
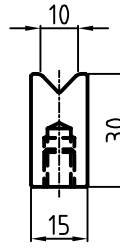
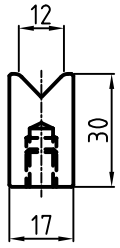
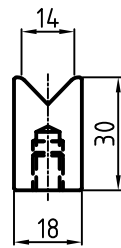
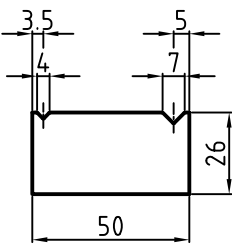
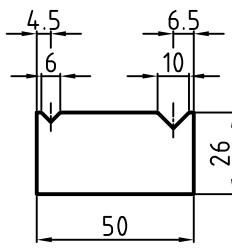
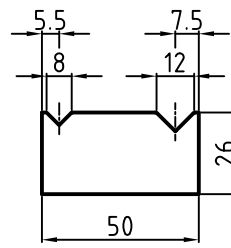
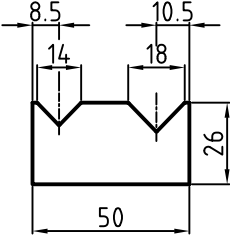
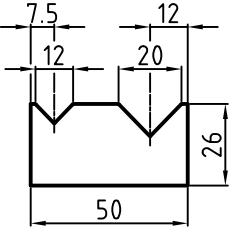
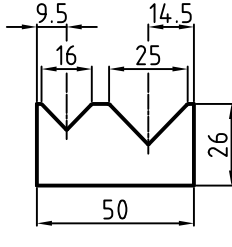
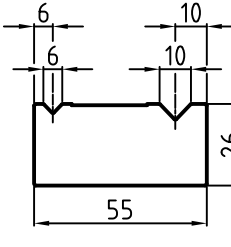
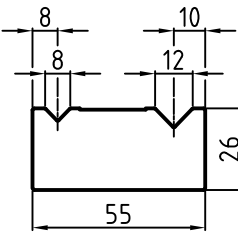
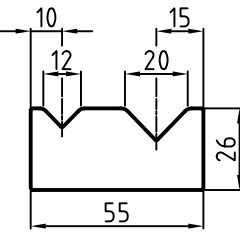
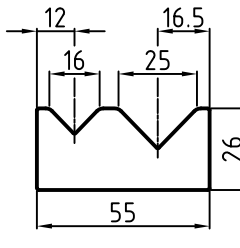
Dynor 88°

Ver 1.3

| | | | |
|---|--|---|--|
| <p>70.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>71.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>72.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>74.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> |
| <p>76.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>77.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>78.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>79.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> |
| <p>80.88° 95 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>20.42/88° 95 T/m</p>  | <p>20.43/88° 95 T/m</p>  | <p>20.44/88° 95 T/m</p>  |
| <p>20.45/88° 95 T/m</p>  | <p>20.46/88° 95 T/m</p>  | <p>20.47/85° 100 T/m</p> <p>Obs! 85°</p>  | |

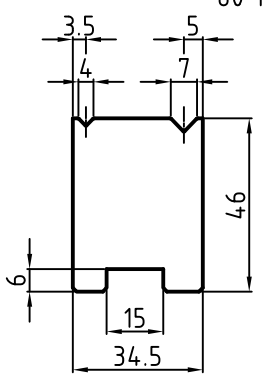
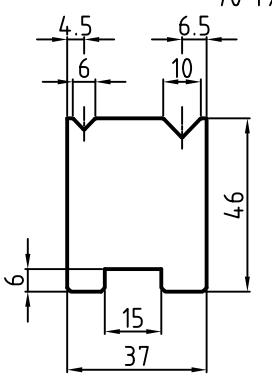
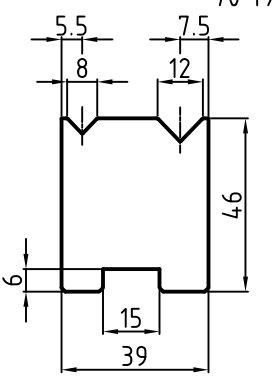
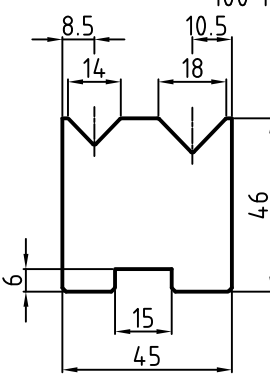
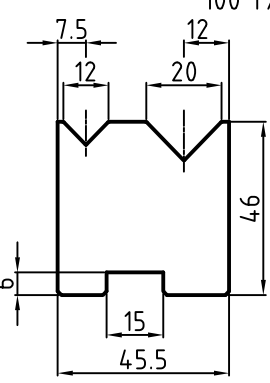
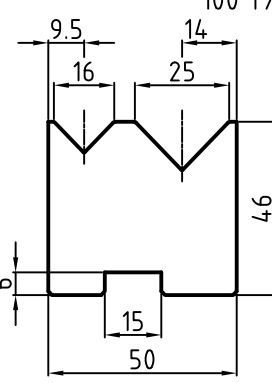
Dynor 88°

Ver 1.3

| | | | |
|--|--|---|---|
| <p>320/88°</p>  <p>Avsedd för hållare 330</p> | <p>321/88°</p>  <p>Avsedd för hållare 330</p> | <p>322/88°</p>  <p>Avsedd för hållare 330</p> | <p>326/88°</p>  <p>Avsedd för hållare 330</p> |
| <p>325/88°</p>  <p>Avsedd för hållare 330</p> | <p>121.88° Genomhärdat 60 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>123.88° Genomhärdat 70T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>124.88° Genomhärdat 80 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> |
| <p>125.88° Genomhärdat 100 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>126.88° Genomhärdat 100 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>127.88° Genomhärdat 100 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>20.12/88° 80 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> |
| <p>20.13/88° 80 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>20.14/88° 100 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>20.15/88° 100 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | |

Dynor 88°

Ver 1.3

| | | | |
|--|--|---|---|
| <p>501/88° 60 T/m</p>  <p>Avsedd för hållare 40.15</p> | <p>502/88° 70 T/m</p>  <p>Avsedd för hållare 40.15</p> | <p>503/88° 70 T/m</p>  <p>Avsedd för hållare 40.15</p> | <p>504/88° 100 T/m</p>  <p>Avsedd för hållare 40.15</p> |
| <p>505/88° 100 T/m</p>  <p>Avsedd för hållare 40.15</p> | <p>506/88° 100 T/m</p>  <p>Avsedd för hållare 40.15</p> | | |
| | | | |

Standardlängder för stansar och dynor

415mm samt 835mm

De flesta stansarna och dynorna kan även erhållas
sektionerade i satser enligt sid.2

Dynor 80-85°

Ver 1.3

| | | | |
|-------------------------------------|-------------------------------------|---|-------------------------------------|
| <p>20.08 100 T/m</p> | <p>20.09 100 T/m</p> | <p>20.11/32 100 T/m</p> | <p>20.11/40 100 T/m</p> |
| <p>20.11/50 100 T/m</p> | <p>20.11/63 100 T/m</p> | <p>20.11/80 100 T/m</p> | <p>20.11/100 100 T/m</p> |
| <p>20.11/125 100 T/m</p> | <p>20.11/160 100 T/m</p> | <p>20.47/85° 100 T/m</p> <p>Finns även under 88° dynor</p> | |

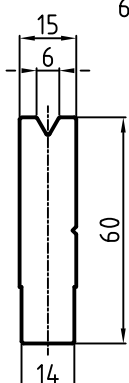
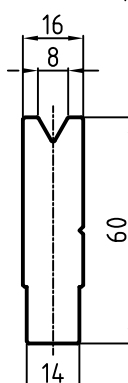
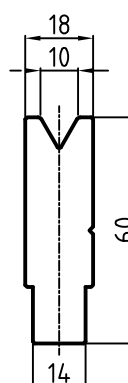
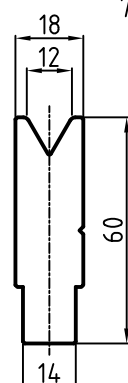
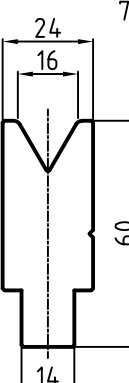
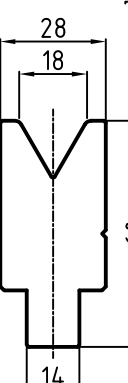
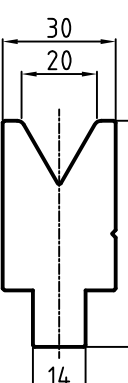
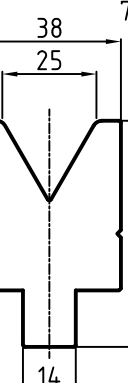
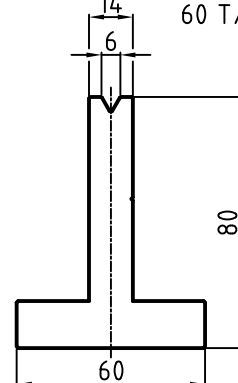
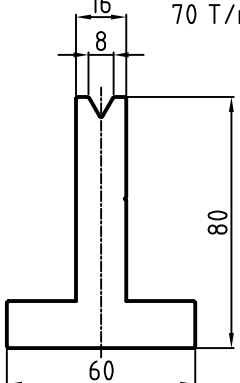
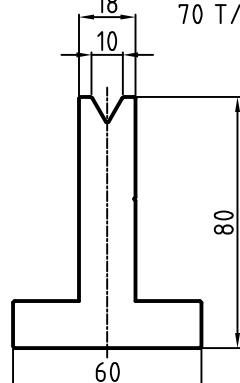
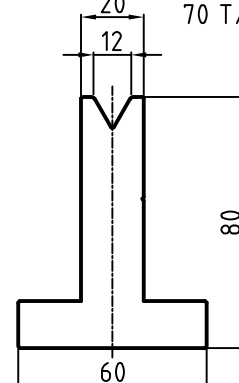
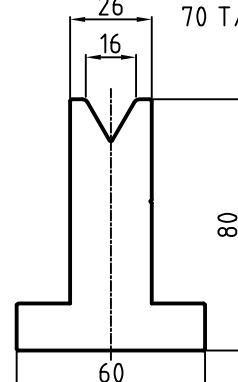
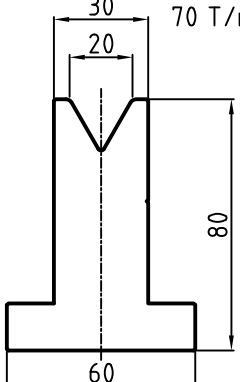
Standardlängder för stansar och dynor

415mm samt 835mm

De flesta stansarna och dynorna kan även erhållas
sektionerade i satser enligt sid.2

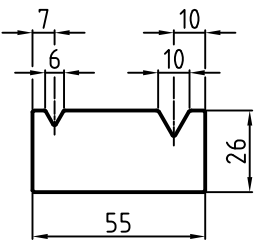
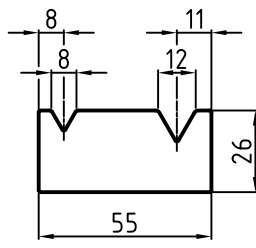
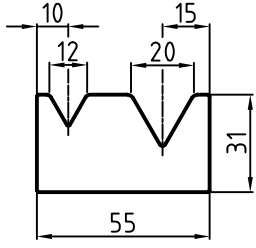
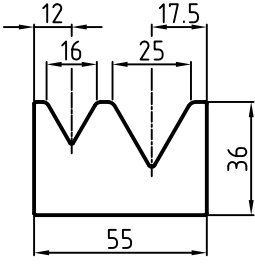
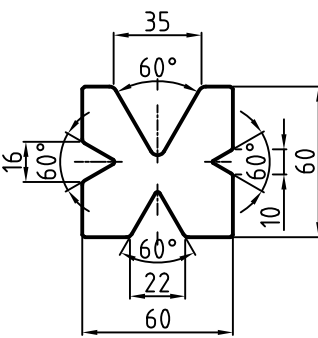
Dynor 60°

Ver 1.3

| | | | |
|--|--|---|--|
| <p>70.60° 60 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>71.60° 70 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>73.60° 70 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>75.60° 70 T/m</p>  <p>Avsedd för hållare 40.14</p> |
| <p>77.60° 70 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>78.60° 70 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>79.60° 70 T/m</p>  <p>Avsedd för hållare 40.14</p> | <p>80.60° 70 T/m</p>  <p>Avsedd för hållare 40.14</p> |
| <p>20.41/60° 60 T/m</p>  | <p>20.42/60° 70 T/m</p>  | <p>20.43/60° 70 T/m</p>  | <p>20.44/60° 70 T/m</p>  |
| <p>20.45/60° 70 T/m</p>  | <p>20.46/60° 70 T/m</p>  | | |

Dynor 60°

Ver 1.3

| | | | |
|---|---|--|---|
| <p>20.12/60° 70 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>20.13/60° 70 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>20.14/60° 70 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>20.15/60° 70 T/m</p>  <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> |
| <p>20.09/60°</p>  | | | |
| | | | |

Standardlängder för stansar och dynor

415mm samt 835mm

De flesta stansarna och dynorna kan även erhållas
sektionerade i satser enligt sid.2

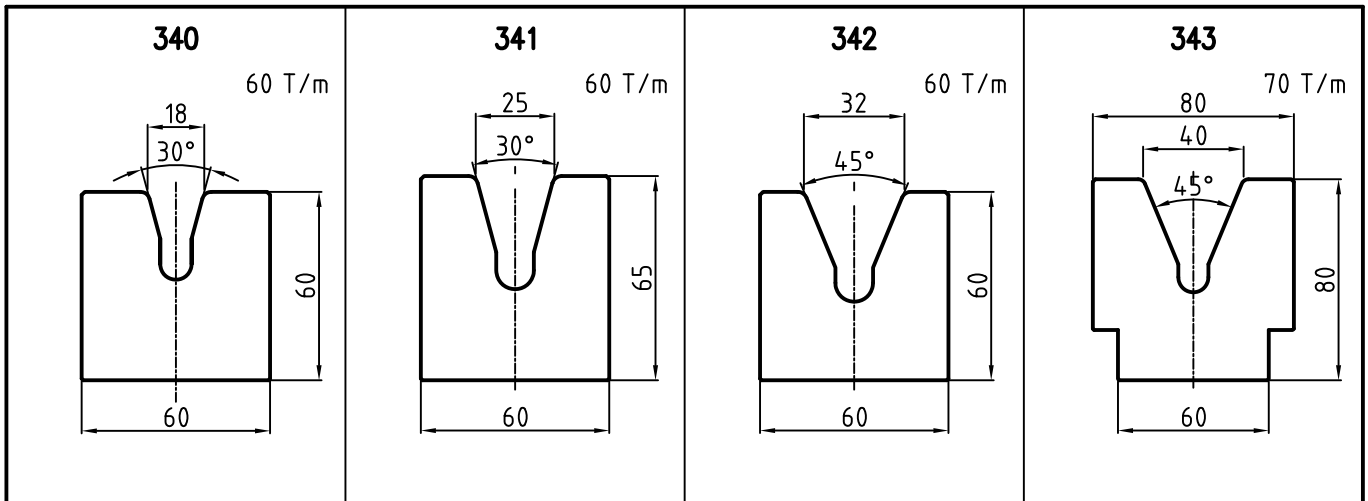
Dynor 30-45°

Ver 1.3

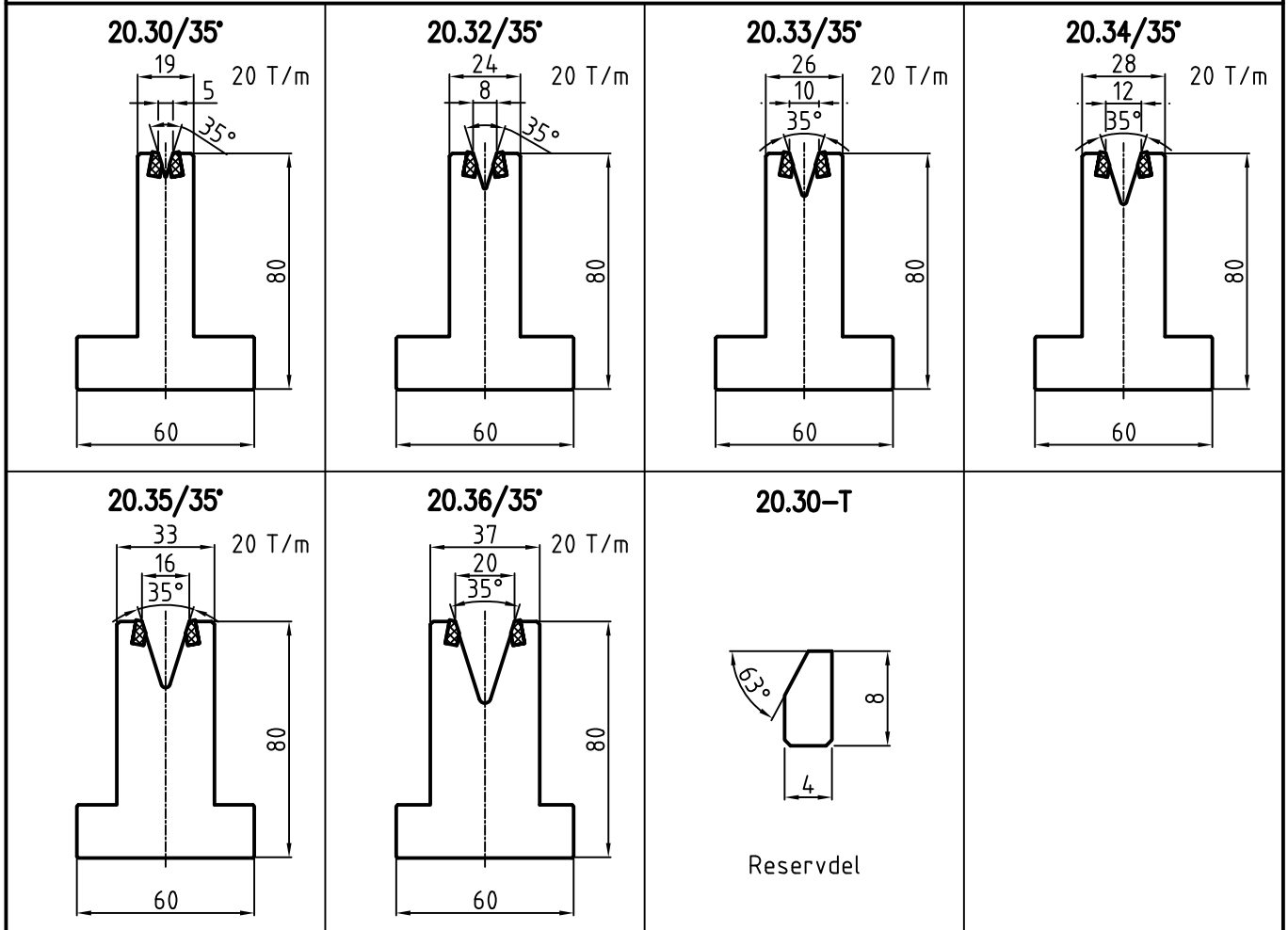
| | | | |
|---|---|---|---|
| <p>70.35° 60 T/m</p> <p>Avsedd för hållare 40.14</p> | <p>71.35° 70 T/m</p> <p>Avsedd för hållare 40.14</p> | <p>73.35° 70 T/m</p> <p>Avsedd för hållare 40.14</p> | <p>75.35° 70 T/m</p> <p>Avsedd för hållare 40.14</p> |
| <p>77.35° 70 T/m</p> <p>Avsedd för hållare 40.14</p> | <p>79.35° 70 T/m</p> <p>Avsedd för hållare 40.14</p> | <p>20.41/35° 50 T/m</p> | <p>20.42/35° 50 T/m</p> |
| <p>20.43/35° 50 T/m</p> | <p>20.44/35° 50 T/m</p> | <p>20.45/35° 50 T/m</p> | <p>20.46/35° 50 T/m</p> |
| <p>20.12/35° 70 T/m</p> <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>20.13/35° 70 T/m</p> <p>Avsedd för hållare 40.06, 40.07/55 - 75</p> | <p>337</p> | |

Dynor 30-45°

Ver 1.3

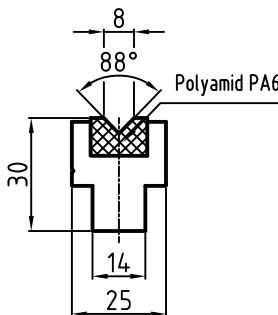
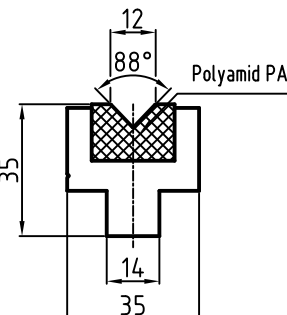
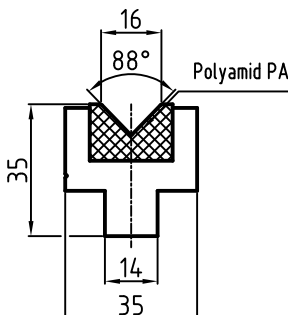
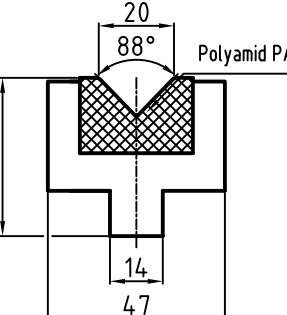
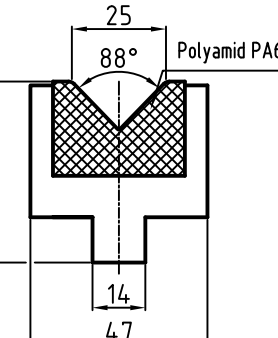
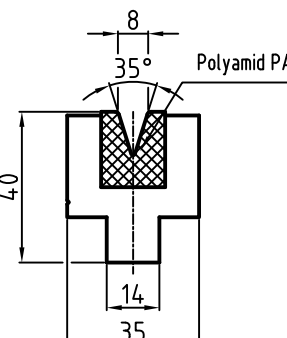
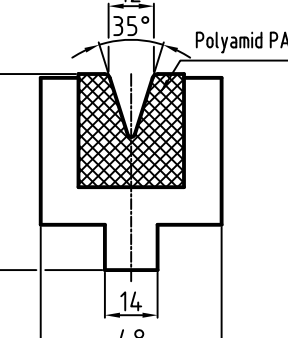
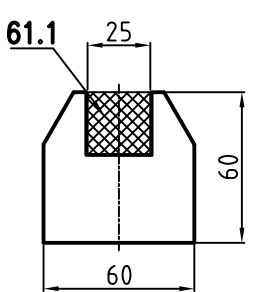
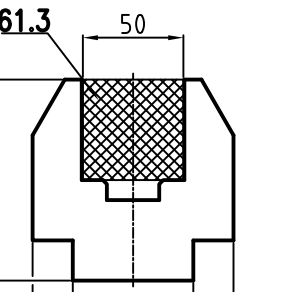
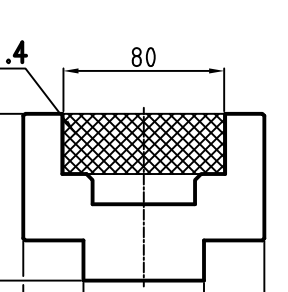
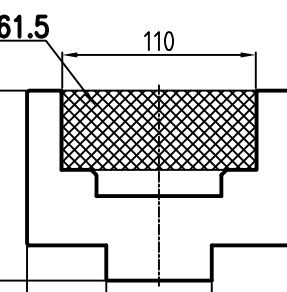

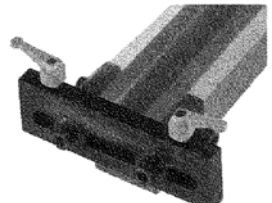


Plast/Polyuretan dynor



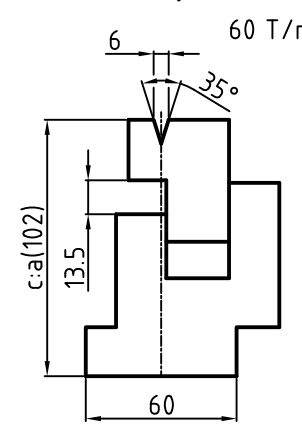
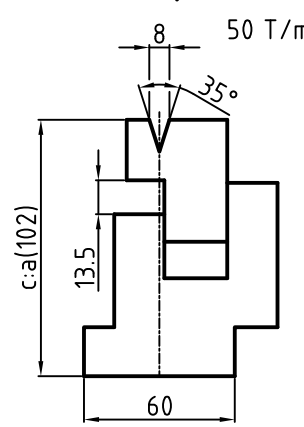
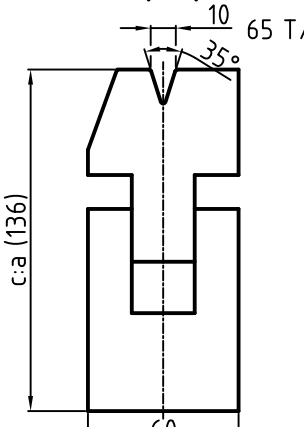
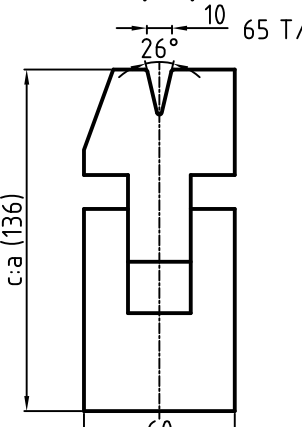
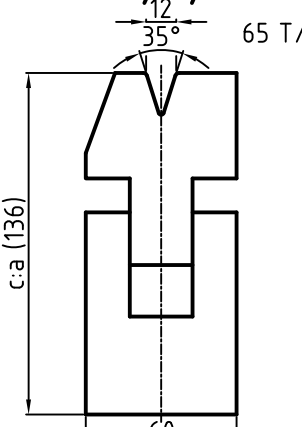
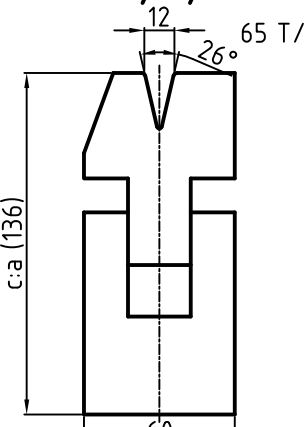
Plast/Polyuretan dynor

Ver 1.3

| | | | |
|---|--|--|--|
| <p>20.00.176/8x88°</p>  <p>Avsedd för hållare 40.14</p> | <p>20.00.176/12x88°</p>  <p>Avsedd för hållare 40.14</p> | <p>20.00.176/16x88°</p>  <p>Avsedd för hållare 40.14</p> | <p>20.00.176/20x88°</p>  <p>Avsedd för hållare 40.14</p> |
| <p>20.00.176/25x88°</p>  <p>Avsedd för hållare 40.14</p> | <p>20.00.176/8x35°</p>  <p>Avsedd för hållare 40.14</p> | <p>20.00.176/12x35°</p>  <p>Avsedd för hållare 40.14</p> | |
| <p>60.1</p>  | <p>60.3</p>  | <p>60.4</p>  | <p>60.5</p>  |
| <p>Polyuretanfilm för skydd av detaljer vid bockning</p>  <p>PU-film 0,4x100</p> | <p>Hållare för polyuretanfilm</p>  <p>Filmhållare, par.</p> | | |

Omslagsverktyg

Ver 1.3

| | | | |
|--|--|--|---|
| <p>30.01/6 60 T/m</p>  | <p>30.01/8 50 T/m</p>  | <p>30.01/10/35° 65 T/m</p>  | <p>30.01/10/26° 65 T/m</p>  |
| <p>30.01/12/35° 65 T/m</p>  | <p>30.01/12/26° 65 T/m</p>  | | |
| | | | |
| | | | |

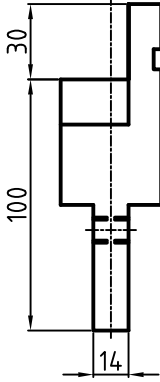
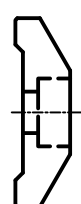
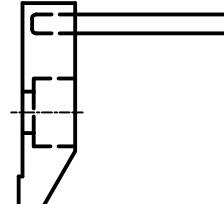
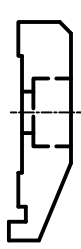
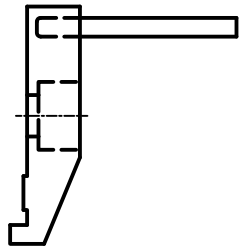
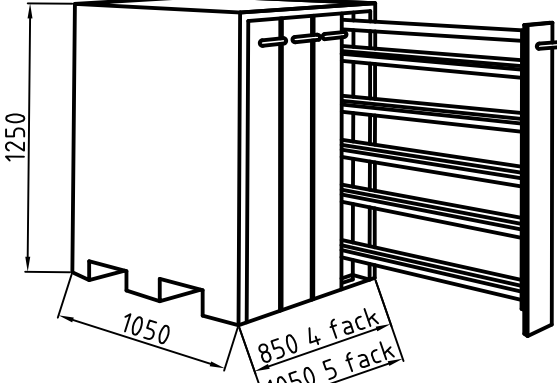
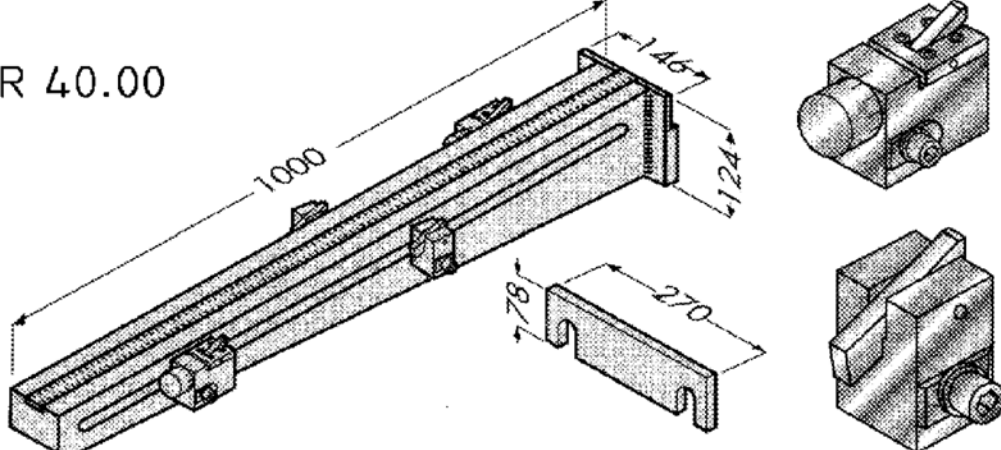
Dynhållare

Ver 1.3

| | | | |
|---|------------------------|------------------------|---|
| <p>40.14</p> | <p>40.15</p> | <p>40.55</p> | <p>330</p> |
| <p>40.06</p> | <p>40.07/55</p> | <p>40.07/75</p> | <p>40.14-TIBS</p> <p>Stopp till dynhållare 40.14</p> |
| <p>Sidvy dynhållare 40.06 Gäller även 40.07/55 - 75</p> | | | <p>40.15-TIBS</p> <p>Stopp till dynhållare 40.15</p> |
| | | | |

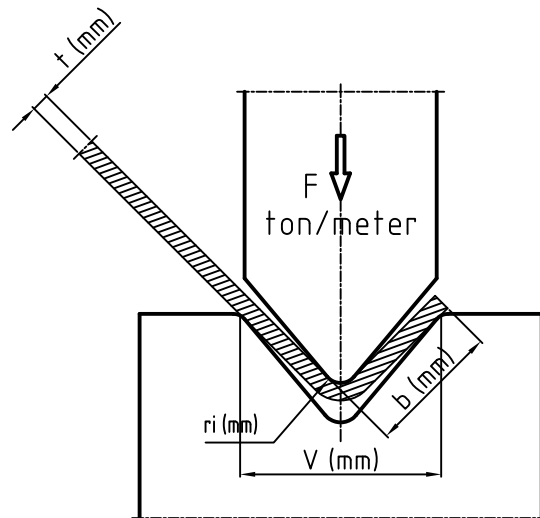
Mellanstycken och klämskenor mm.

Ver 13

| | | | |
|--|--|---|--|
| <p>40.03</p>  | <p>ST41</p>  | <p>ST42</p>  | <p>ST43</p>  |
| <p>ST44</p>  | | | |
| <p>Ex. 4 fack</p>  | | <p>Verktågsskåp med 4 resp. 5 fack</p> | |
| <p>RR 40.00</p>  | | | |

Presskrafttabell

Ver 1.3



| t mm | V | 6 | 8 | 10 | 12 | 16 | 20 | 24 | 32 | 40 | 48 | 64 | 80 | 100 | 150 | 200 | 250 | 320 | 400 | 500 |
|---------|----|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|----------------|----------------|----------------|----------------|----------------|-----|-----|
| | | b | 4 | 6 | 6,5 | 8 | 10 | 12 | 15 | 19 | 23 | 28 | 40 | 48 | 60 | 90 | 120 | 150 | 200 | 250 |
| ri | 1 | 1,3 | 1,6 | 2 | 2,6 | 3,3 | 4 | 5 | 6,5 | 8 | 10 | 13 | 16 | 25 | 30 | 40 | 53 | 65 | 83 | |
| 0,5 | | 3 | 2 | | | | | | | | | | | | | | | | | |
| 0,8 | | 7 | 5 | 4 | | | | | | | | | | | | | | | | |
| 1 | | 11 | 8 | 7 | 6 | | | | | | | | | | | | | | | |
| 1.2 | 16 | 12 | 10 | 8 | 6 | | | | | | | | | | | | | | | |
| 1.5 | | 17 | 15 | 13 | 9 | 8 | | | | | | | | | | | | | | |
| 2 | | | 28 | 23 | 17 | 13 | 11 | | | | | | | | | | | | | |
| 2,5 | | | | 36 | 27 | 22 | 17 | 13 | | | | | | | | | | | | |
| 3 | | | | | 38 | 30 | 25 | 19 | 15 | | | | | | | | | | | |
| 4 | | | | | | 54 | 43 | 34 | 27 | 22 | | | | | | | | | | |
| 5 | | | | | | | 68 | 52 | 42 | 34 | 26 | | | | | | | | | |
| 6 | | | | | | | | 75 | 60 | 49 | 38 | 30 | | | | | | | | |
| 8 | | | | | | | | | 107 | 86 | 65 | 53 | 43 | | | | | | | |
| 10 | | | | | | | | | | 135 | 105 | 85 | 67 | 44 | | | | | | |
| 12 | | | | | | | | | | | 150 | 120 | 96 | 63 | 47 | | | | | |
| 15 | | | | | | | | | | | | 188 | 150 | 98 | 75 | 59 | | | | |
| 20 | | | | | | | | | | | | | 175 | 135 | 108 | 85 | | | | |
| 25 | | | | | | | | | | | | | | 210 | 170 | 130 | 105 | | | |
| 30 | | | | | | | | | | | | | | | 240 | 190 | 150 | 120 | | |
| 40 | | | | | | | | | | | | | | | | 340 | 270 | 215 | | |
| 50 | | | | | | | | | | | | | | | | | 420 | 340 | | |

Presskraft F i ton/meter vid luftbockning av plåt med brotthållfasthet (Rm) på 400N/mm²

Rekommenderade värden

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