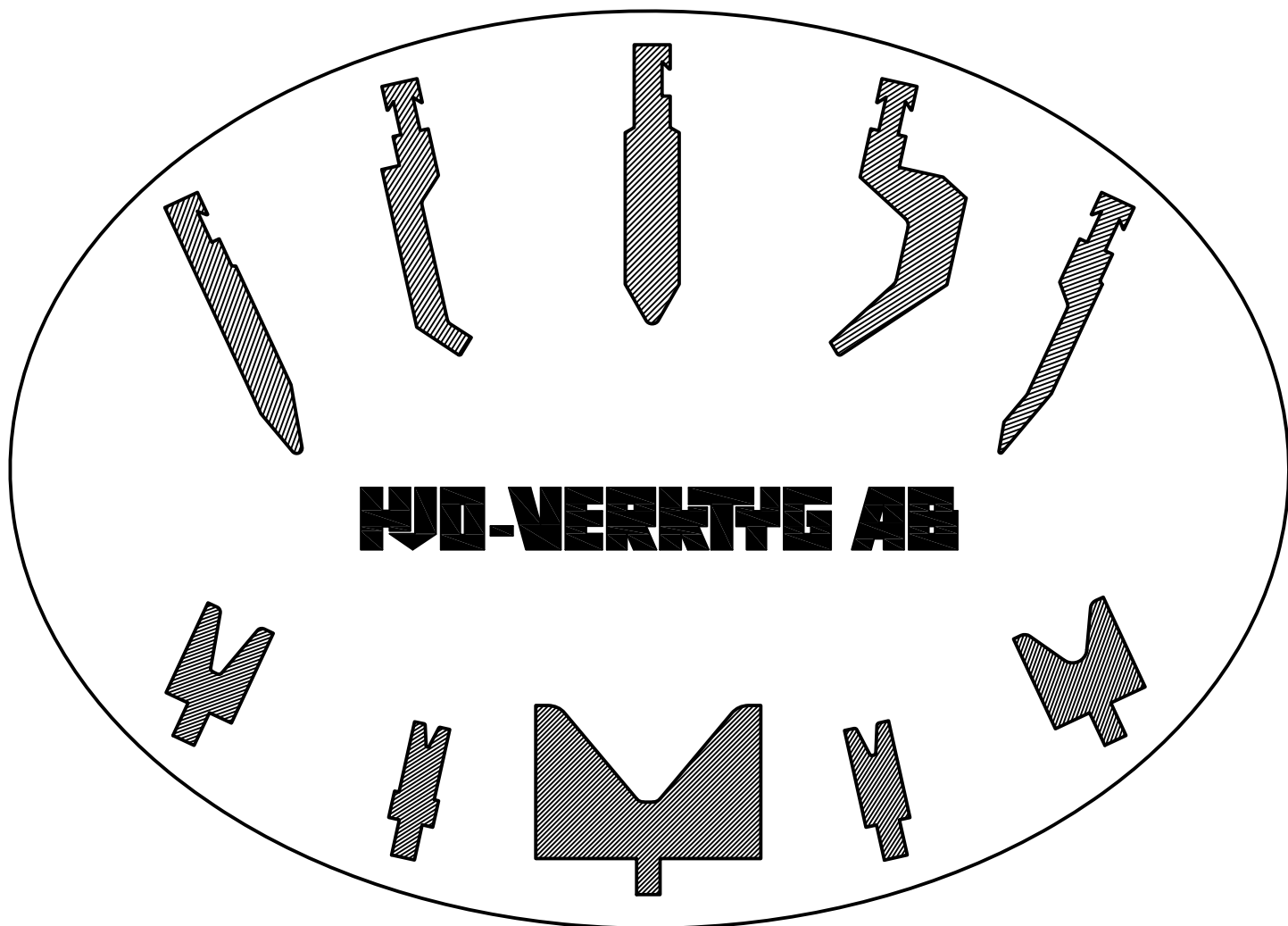
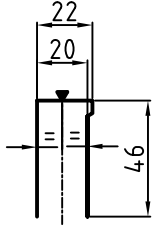
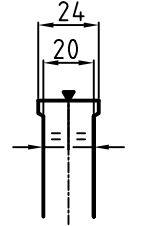
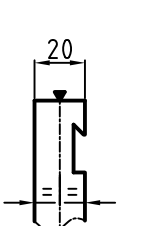
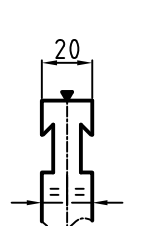
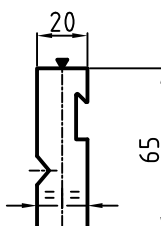
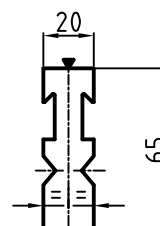


Kantpressverktyg av typ Beyeler

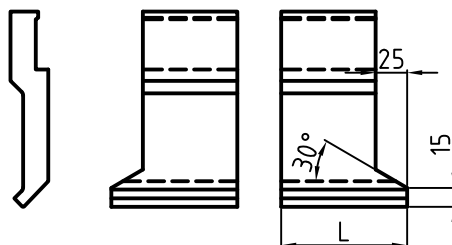


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Stansfästen samt delningar

<p>Fäste typ S enkelt</p> 	<p>Fäste typ S dubbelt</p> 	<p>Fäste typ R enkelt</p> 	<p>Fäste typ R dubbelt</p> 
<p>Fäste typ RF-A enkelt</p> 	<p>Fäste typ RF-A dubbelt</p> 		

Utformning av "Horn"



Standarddelning på stansar av typ S eller R (H=155mm)

Alt 1 Delning typ FSC: $10+15+20+30+50+100+200+275+300=1000\text{mm}$

Alt 2 Delning typ FSL: $10+15+20+30+50+100+200+300+375=1100\text{mm}$

Standarddelning på stansar av typ SF, RF eller RF-A (H=175mm)

Delning typ FSH: $50+55+60+65+70+75+80+85+90+95+100+150+200+300=1475\text{mm}$

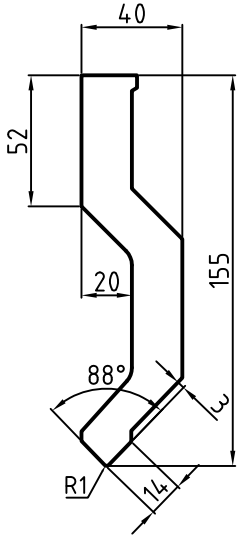
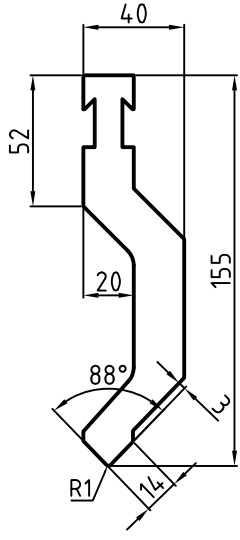
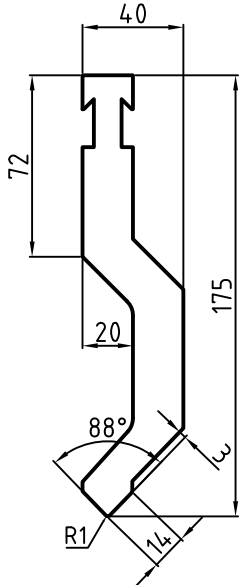
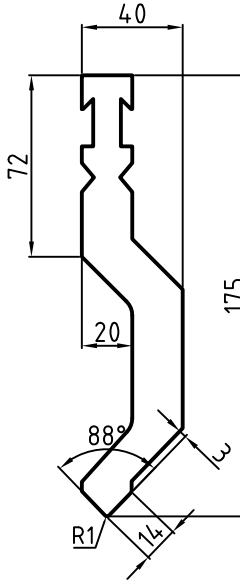
Stansar med 88° spetsvinkel

<p>P2S 130 T/m</p>	<p>P2R 130 T/m</p>	<p>P2SF 130 T/m</p>	<p>P2RF 130 T/m</p>
<p>P2RF-A 130 T/m</p>	<p>P3S 130 T/m</p>	<p>P3R 130 T/m</p>	<p>P3SF 130 T/m</p>

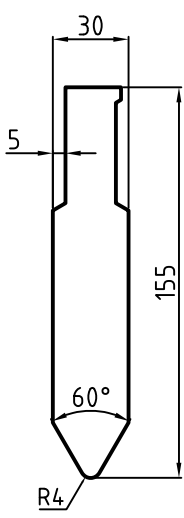
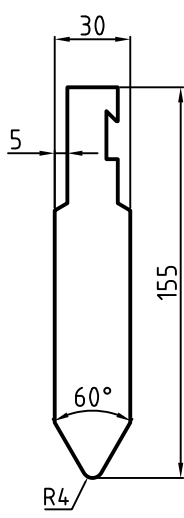
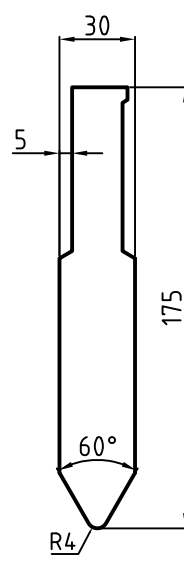
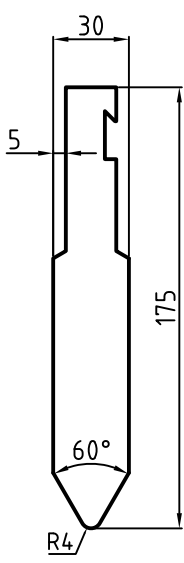
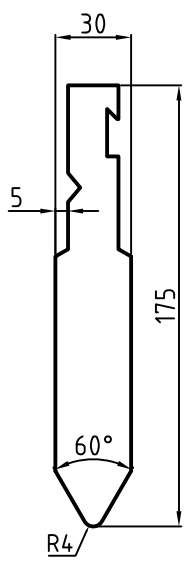
Stansar med 88° spetsvinkel

<p>P3RF 130 T/m</p>	<p>P3RF-A 130 T/m</p>	<p>P4S 90 T/m</p>	<p>P4R 90 T/m</p>
<p>P4SF 90 T/m</p>	<p>P4RF 90 T/m</p>	<p>P4RF-A 90 T/m</p>	

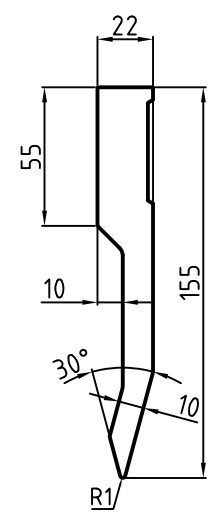
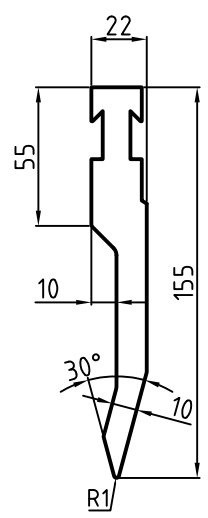
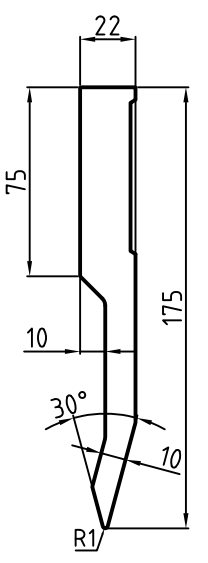
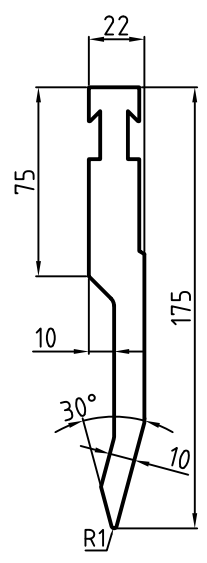
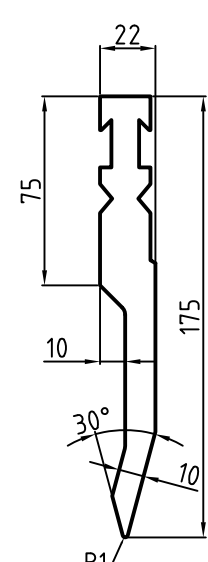
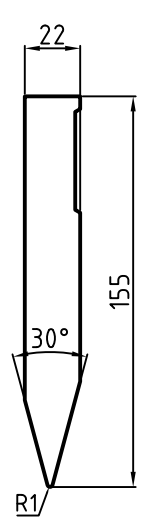
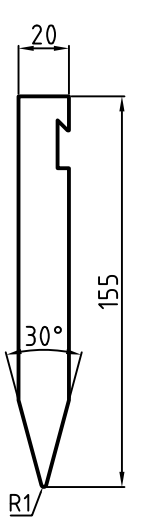
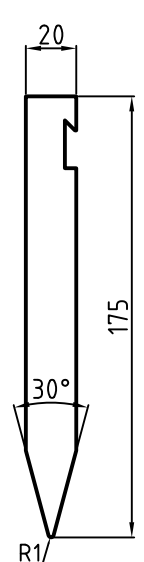
Stansar med 88° spetsvinkel

<p>P8S 105 T/m</p>  <p>Technical drawing of the P8S punch profile. It shows a cross-section with a top width of 40, a height of 52, and a total length of 155. The profile has a 20-wide top section, a 20-wide middle section, and a bottom section with an 88-degree tip angle. A fillet radius R1 is shown at the bottom, and a 14-degree chamfer is indicated at the base.</p>	<p>P8R 105 T/m</p>  <p>Technical drawing of the P8R punch profile. It is similar to P8S but has a different internal profile. Dimensions include a top width of 40, a height of 52, and a total length of 155. It features a 20-wide top section, a 20-wide middle section, and an 88-degree tip angle with a fillet radius R1 and a 14-degree chamfer.</p>	<p>P8RF 105 T/m</p>  <p>Technical drawing of the P8RF punch profile. It has a top width of 40, a height of 72, and a total length of 175. The profile includes a 20-wide top section, a 20-wide middle section, and an 88-degree tip angle with a fillet radius R1 and a 14-degree chamfer.</p>	<p>P8RF-A 105 T/m</p>  <p>Technical drawing of the P8RF-A punch profile. It has a top width of 40, a height of 72, and a total length of 175. The profile includes a 20-wide top section, a 20-wide middle section, and an 88-degree tip angle with a fillet radius R1 and a 14-degree chamfer.</p>

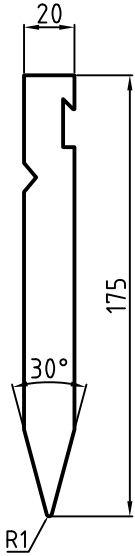
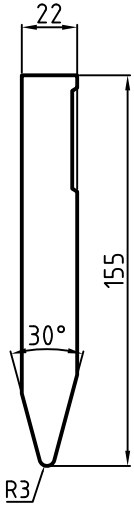
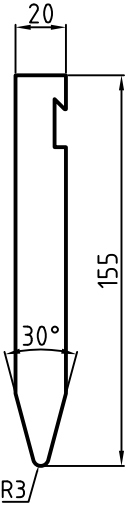
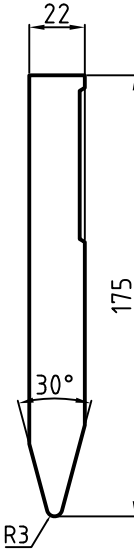
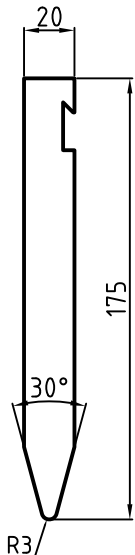
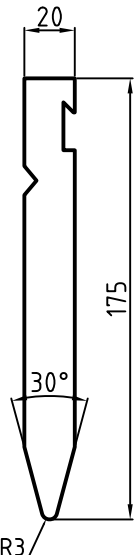
Stansar med 60° spetsvinkel

<p>P9S 160 T/m</p> 	<p>P9R 160 T/m</p> 	<p>P9SF 160 T/m</p> 	<p>P9RF 160 T/m</p> 
<p>P9RF-A 160 T/m</p> 			

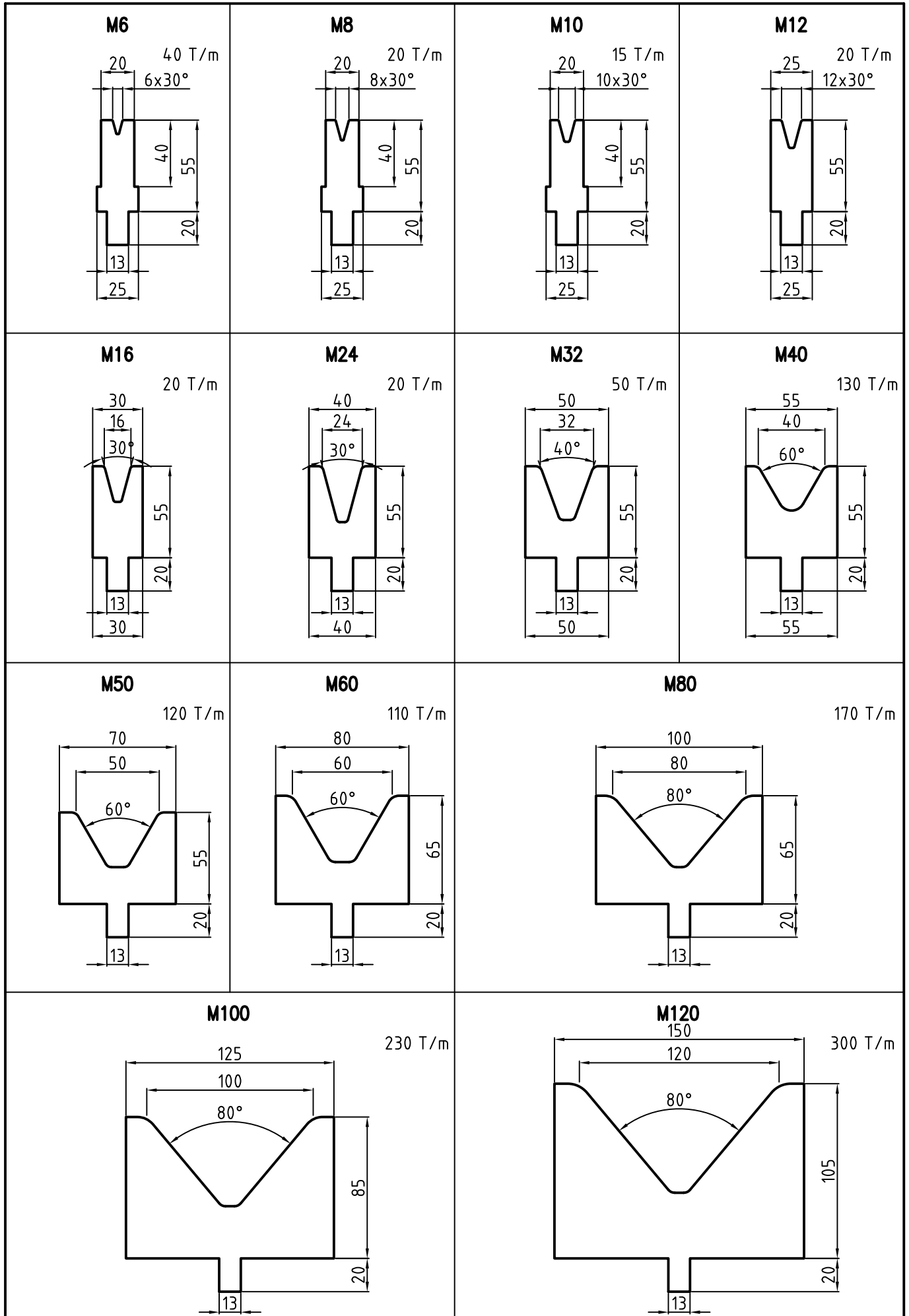
Stansar med 30° spetsvinkel

<p>P5S 100 T/m</p> 	<p>P5R 100 T/m</p> 	<p>P5SF 100 T/m</p> 	<p>P5RF 100 T/m</p> 
<p>P5RF-A 100 T/m</p> 	<p>P6S 160 T/m</p> 	<p>P6R 160 T/m</p> 	<p>P6RF 160 T/m</p> 

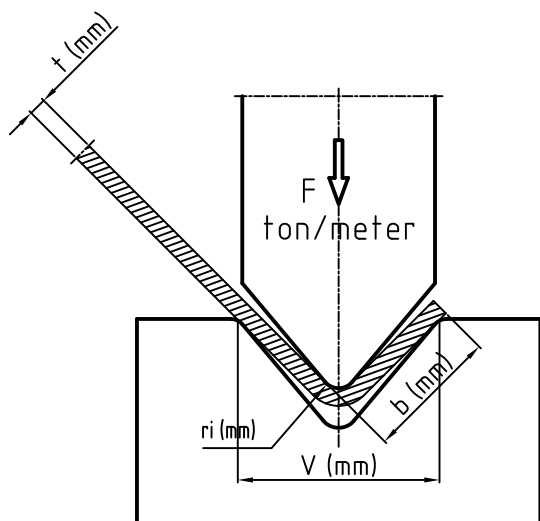
Stansar med 30° spetsvinkel

<p>P6RF-A 160 T/m</p> 	<p>P7S 160 T/m</p> 	<p>P7R 160 T/m</p> 	<p>P7SF 160 T/m</p> 
<p>P7RF 160 T/m</p> 	<p>P7RF-A 160 T/m</p> 		

Enspårsdynor



Presskrafttabell



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	310
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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