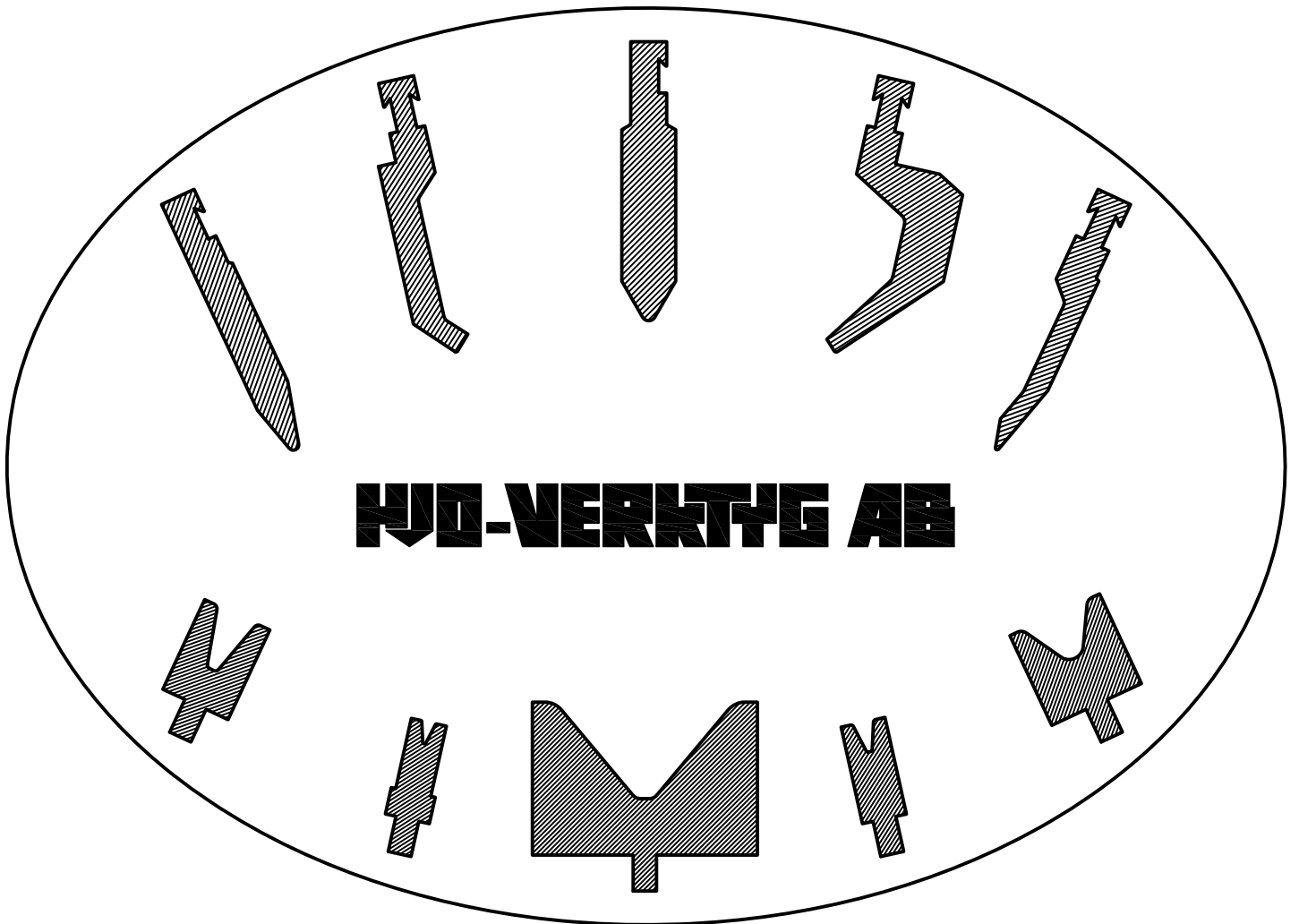


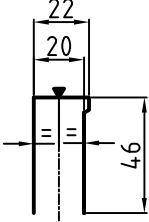
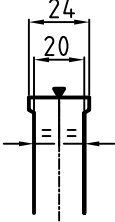
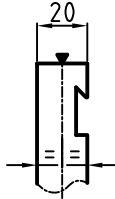
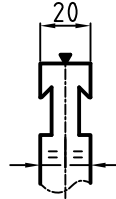
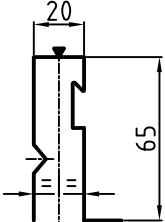
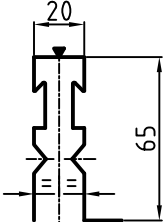
Kantpressverktyg av typ Beyeler



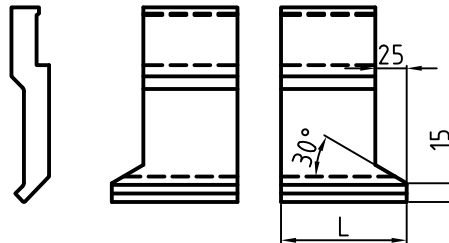
Hjo-Verktyg AB, Industrigatan 38, 544 50 Hjo
Telefon 0503-130 80, Telefax 0503-120 19
Internet www.hjoverktyg.se
E-post info@hjoverktyg.se

Stansfästen samt delningar

Ver 2.0

<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: $10+15+20+30+50+100+200+275+300=1000\text{mm}$

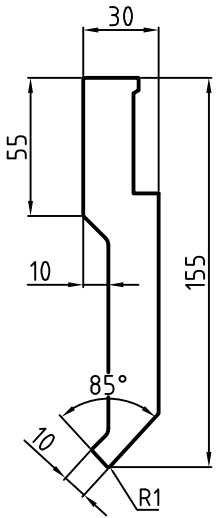
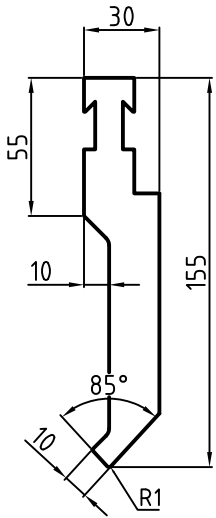
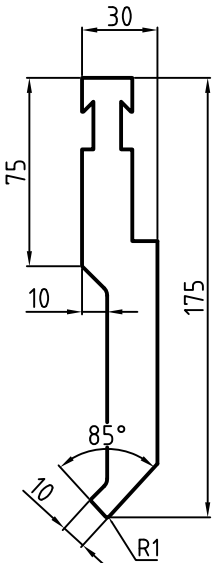
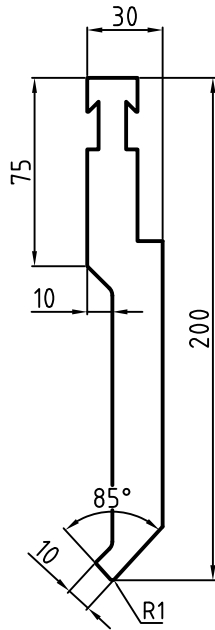
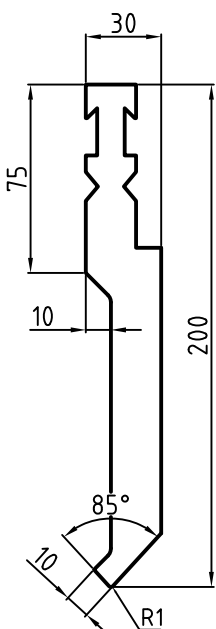
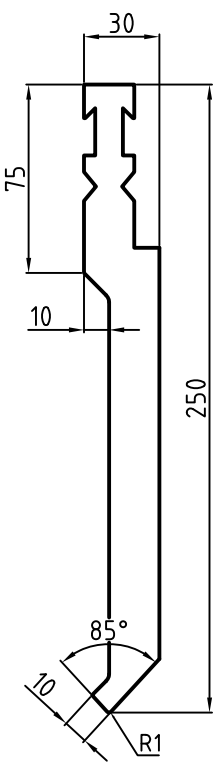
Alt 2 Delning typ FSL: $10+15+20+30+50+100+200+300+375=1100\text{mm}$

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

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

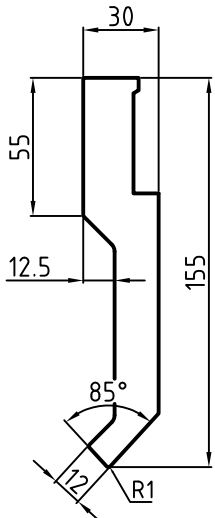
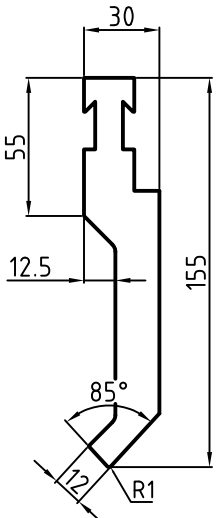
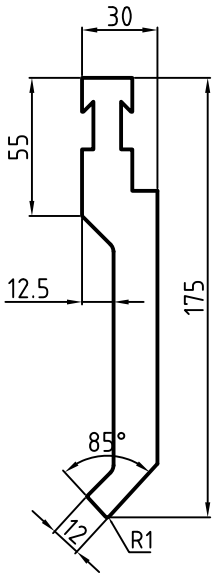
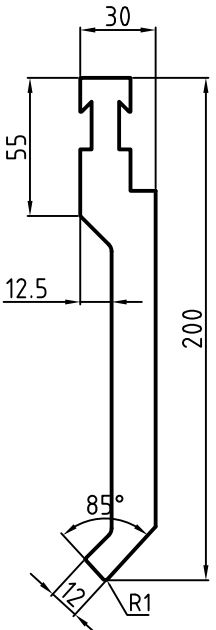
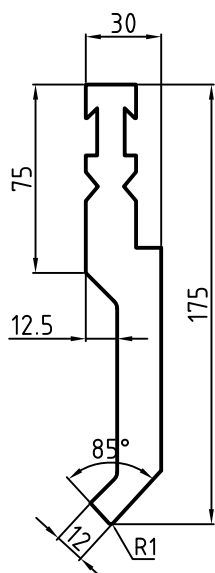
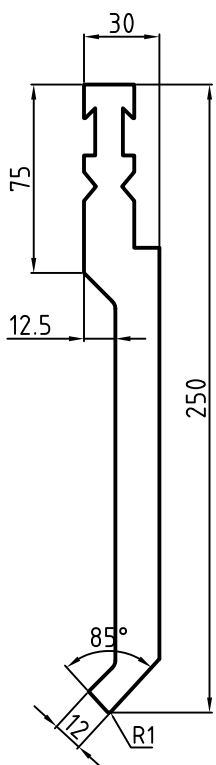
Stansar med 85° spetsvinkel

Ver 2.0

<p>P2S 100 T/m</p>  <p>Technical drawing of the P2S punch. It features a 30mm wide top edge, a 55mm long upper section, and a 10mm offset from the centerline. The total length is 155mm. The bottom tip has an 85-degree angle and a 10mm radius (R1).</p>	<p>P2R 100 T/m</p>  <p>Technical drawing of the P2R punch. It features a 30mm wide top edge, a 55mm long upper section, and a 10mm offset from the centerline. The total length is 155mm. The bottom tip has an 85-degree angle and a 10mm radius (R1).</p>	<p>P2RF 100 T/m</p>  <p>Technical drawing of the P2RF punch. It features a 30mm wide top edge, a 75mm long upper section, and a 10mm offset from the centerline. The total length is 175mm. The bottom tip has an 85-degree angle and a 10mm radius (R1).</p>	<p>P2RF/200 100 T/m</p>  <p>Technical drawing of the P2RF/200 punch. It features a 30mm wide top edge, a 75mm long upper section, and a 10mm offset from the centerline. The total length is 200mm. The bottom tip has an 85-degree angle and a 10mm radius (R1).</p>
<p>P2RFA 100 T/m</p>  <p>Technical drawing of the P2RFA punch. It features a 30mm wide top edge, a 75mm long upper section, and a 10mm offset from the centerline. The total length is 200mm. The bottom tip has an 85-degree angle and a 10mm radius (R1).</p>	<p>P2RFA/250 100 T/m</p>  <p>Technical drawing of the P2RFA/250 punch. It features a 30mm wide top edge, a 75mm long upper section, and a 10mm offset from the centerline. The total length is 250mm. The bottom tip has an 85-degree angle and a 10mm radius (R1).</p>		

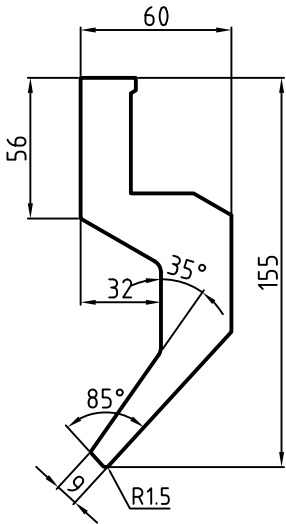
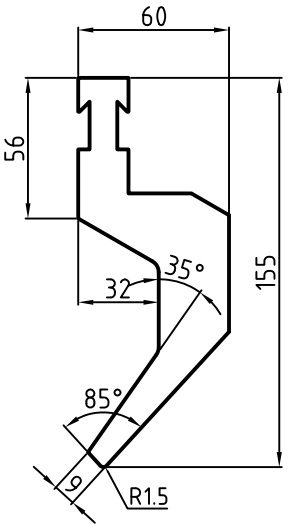
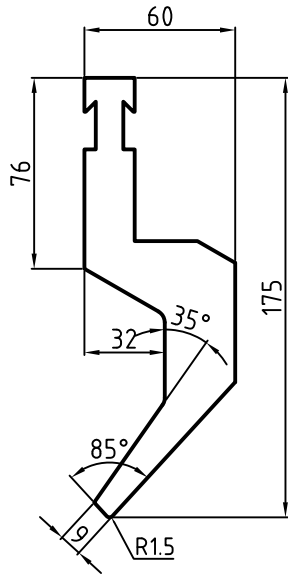
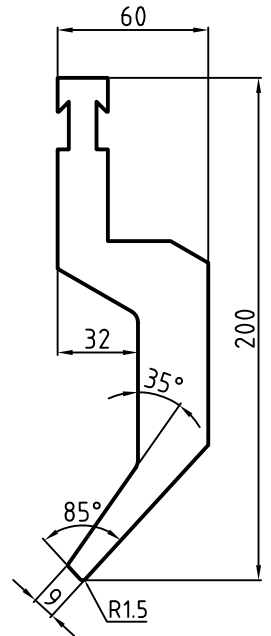
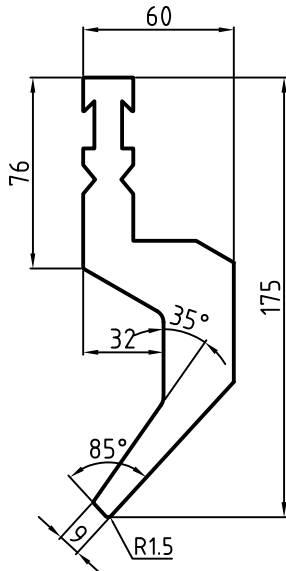
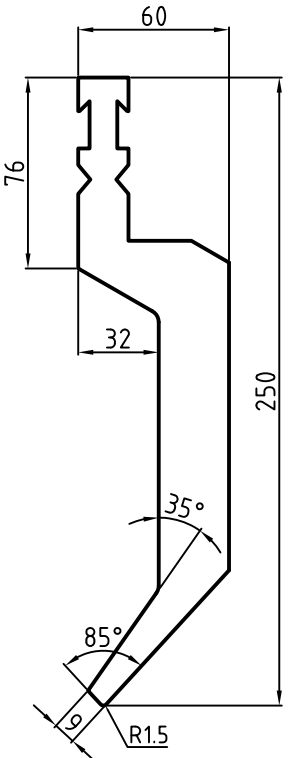
Stansar med 85° spetsvinkel

Ver 2.0

<p>P3S 100 T/m</p>  <p>Technical drawing of the P3S punch. It features a 30mm wide top edge, a 55mm high upper section, and a 12.5mm offset from the left edge. The punch has a 155mm total length and an 85° tip angle. The tip is chamfered with a 12mm chamfer and a radius R1.</p>	<p>P3R 100 T/m</p>  <p>Technical drawing of the P3R punch. It features a 30mm wide top edge, a 55mm high upper section, and a 12.5mm offset from the left edge. The punch has a 155mm total length and an 85° tip angle. The tip is chamfered with a 12mm chamfer and a radius R1.</p>	<p>P3RF 100 T/m</p>  <p>Technical drawing of the P3RF punch. It features a 30mm wide top edge, a 55mm high upper section, and a 12.5mm offset from the left edge. The punch has a 175mm total length and an 85° tip angle. The tip is chamfered with a 12mm chamfer and a radius R1.</p>	<p>P3RF/200 100 T/m</p>  <p>Technical drawing of the P3RF/200 punch. It features a 30mm wide top edge, a 55mm high upper section, and a 12.5mm offset from the left edge. The punch has a 200mm total length and an 85° tip angle. The tip is chamfered with a 12mm chamfer and a radius R1.</p>
<p>P3RFA 100 T/m</p>  <p>Technical drawing of the P3RFA punch. It features a 30mm wide top edge, a 75mm high upper section, and a 12.5mm offset from the left edge. The punch has a 175mm total length and an 85° tip angle. The tip is chamfered with a 12mm chamfer and a radius R1.</p>	<p>P3RFA/250 100 T/m</p>  <p>Technical drawing of the P3RFA/250 punch. It features a 30mm wide top edge, a 75mm high upper section, and a 12.5mm offset from the left edge. The punch has a 250mm total length and an 85° tip angle. The tip is chamfered with a 12mm chamfer and a radius R1.</p>		

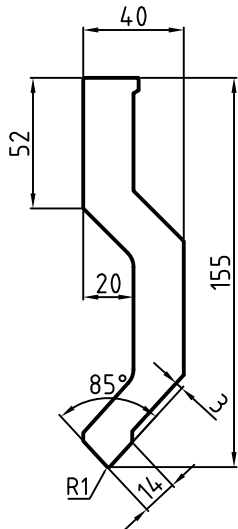
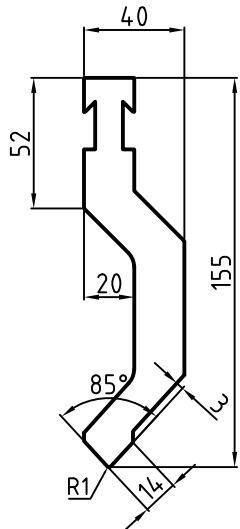
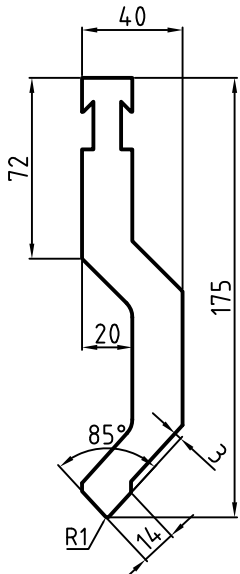
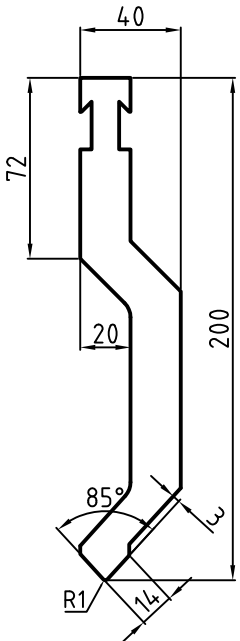
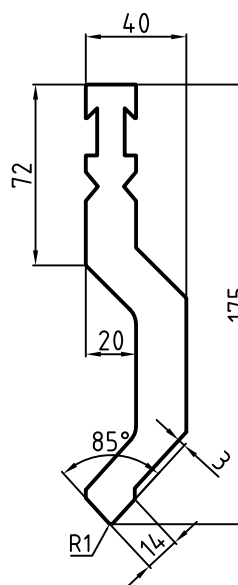
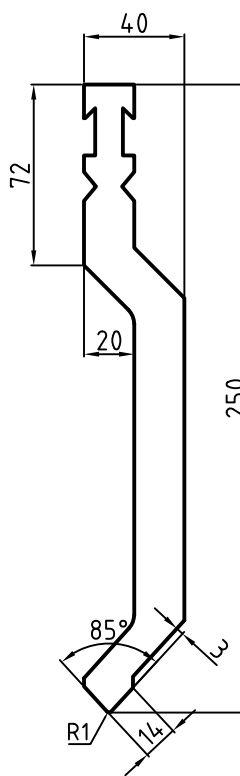
Stansar med 85° spetsvinkel

Ver 2.0

<p>P4S 70 T/m</p> 	<p>P4R 70 T/m</p> 	<p>P4RF 70 T/m</p> 	<p>P4RF/200 70 T/m</p> 
<p>P4RFA 70 T/m</p> 	<p>P4RFA/250 70 T/m</p> 		

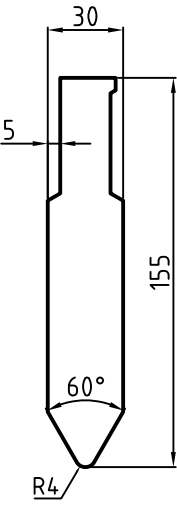
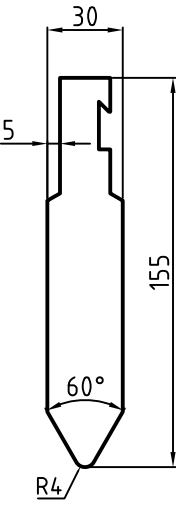
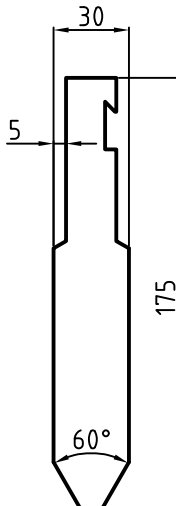
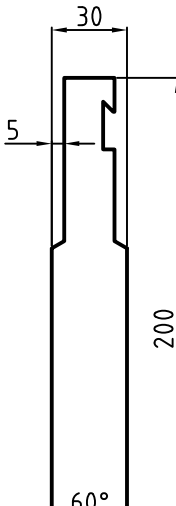
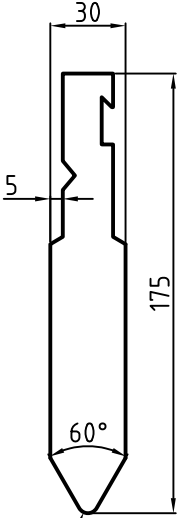
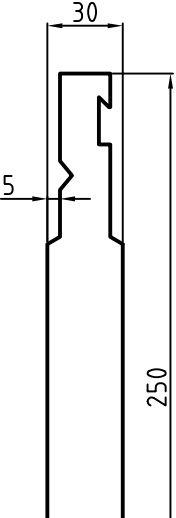
Stansar med 85° spetsvinkel

Ver 2.0

<p>P8S 100 T/m</p> 	<p>P8R 100 T/m</p> 	<p>P8RF 100 T/m</p> 	<p>P8RF/200 100 T/m</p> 
<p>P8RFA 100 T/m</p> 	<p>P8RFA/250 100 T/m</p> 		

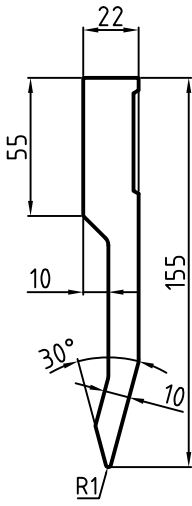
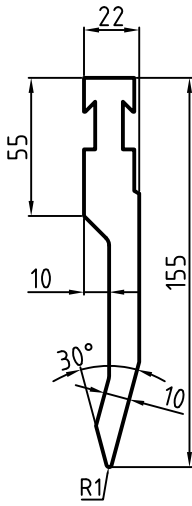
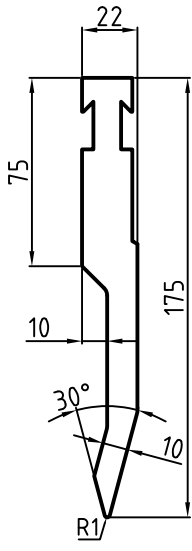
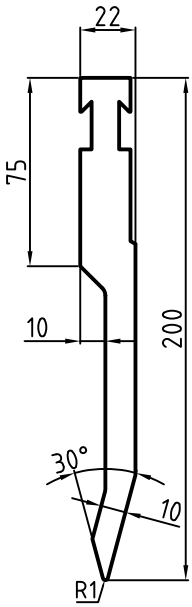
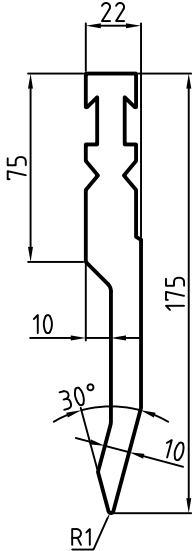
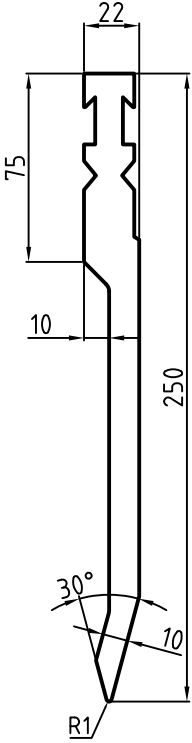
Stansar med 60° spetsvinkel

Ver 2.0

<p>P9S 200 T/m</p>  <p>Technical drawing of a punch (P9S) with a 60° tip angle. The punch has a diameter of 30 mm and a length of 155 mm. The tip is chamfered with a 60° angle and a radius of R4. The punch is shown with a 5 mm diameter hole through its center.</p>	<p>P9R 200 T/m</p>  <p>Technical drawing of a punch (P9R) with a 60° tip angle. The punch has a diameter of 30 mm and a length of 155 mm. The tip is chamfered with a 60° angle and a radius of R4. The punch is shown with a 5 mm diameter hole through its center.</p>	<p>P9RF 200 T/m</p>  <p>Technical drawing of a punch (P9RF) with a 60° tip angle. The punch has a diameter of 30 mm and a length of 175 mm. The tip is chamfered with a 60° angle and a radius of R4. The punch is shown with a 5 mm diameter hole through its center.</p>	<p>P9RF/200 200 T/m</p>  <p>Technical drawing of a punch (P9RF/200) with a 60° tip angle. The punch has a diameter of 30 mm and a length of 200 mm. The tip is chamfered with a 60° angle and a radius of R4. The punch is shown with a 5 mm diameter hole through its center.</p>
<p>P9RFA 200 T/m</p>  <p>Technical drawing of a punch (P9RFA) with a 60° tip angle. The punch has a diameter of 30 mm and a length of 175 mm. The tip is chamfered with a 60° angle and a radius of R4. The punch is shown with a 5 mm diameter hole through its center.</p>	<p>P9RFA/250 200 T/m</p>  <p>Technical drawing of a punch (P9RFA/250) with a 60° tip angle. The punch has a diameter of 30 mm and a length of 250 mm. The tip is chamfered with a 60° angle and a radius of R4. The punch is shown with a 5 mm diameter hole through its center.</p>		

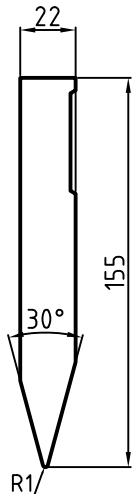
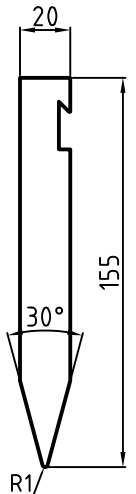
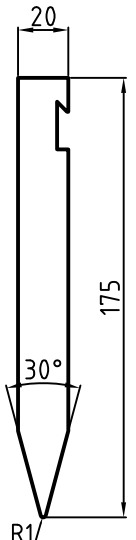
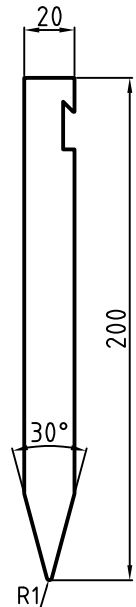
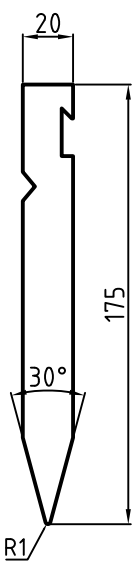
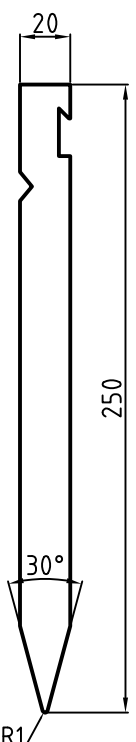
Stansar med 30° spetsvinkel

Ver 2.0

<p>P5S 100 T/m</p>  <p>Technical drawing of the P5S punch. It features a 22mm wide top edge, a 55mm long upper section, and a 10mm wide section below. The total length is 155mm. The tip has a 30-degree angle and a 10mm wide section. A radius of R1 is indicated at the tip.</p>	<p>P5R 100 T/m</p>  <p>Technical drawing of the P5R punch. It features a 22mm wide top edge, a 55mm long upper section, and a 10mm wide section below. The total length is 155mm. The tip has a 30-degree angle and a 10mm wide section. A radius of R1 is indicated at the tip.</p>	<p>P5RF 100 T/m</p>  <p>Technical drawing of the P5RF punch. It features a 22mm wide top edge, a 75mm long upper section, and a 10mm wide section below. The total length is 175mm. The tip has a 30-degree angle and a 10mm wide section. A radius of R1 is indicated at the tip.</p>	<p>P5RF/200 100 T/m</p>  <p>Technical drawing of the P5RF/200 punch. It features a 22mm wide top edge, a 75mm long upper section, and a 10mm wide section below. The total length is 200mm. The tip has a 30-degree angle and a 10mm wide section. A radius of R1 is indicated at the tip.</p>
<p>P5RFA 100 T/m</p>  <p>Technical drawing of the P5RFA punch. It features a 22mm wide top edge, a 75mm long upper section, and a 10mm wide section below. The total length is 175mm. The tip has a 30-degree angle and a 10mm wide section. A radius of R1 is indicated at the tip.</p>	<p>P5RFA/250 100 T/m</p>  <p>Technical drawing of the P5RFA/250 punch. It features a 22mm wide top edge, a 75mm long upper section, and a 10mm wide section below. The total length is 250mm. The tip has a 30-degree angle and a 10mm wide section. A radius of R1 is indicated at the tip.</p>		

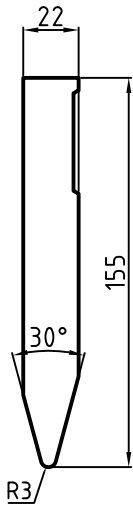
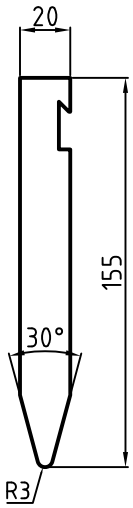
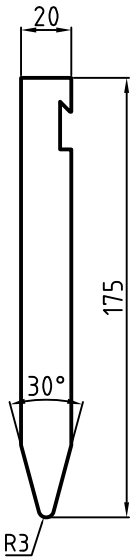

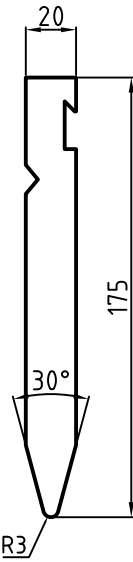
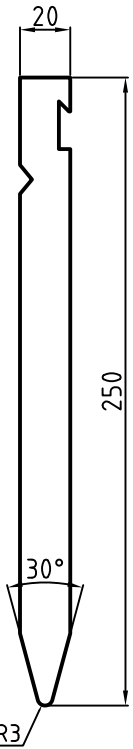
Stansar med 30° spetsvinkel

Ver 2.0

<p>P6S 150 T/m</p> 	<p>P6R 150 T/m</p> 	<p>P6RF 150 T/m</p> 	<p>P6RF/200 150 T/m</p> 
<p>P6RFA 150 T/m</p> 	<p>P6RFA/250 150 T/m</p> 		

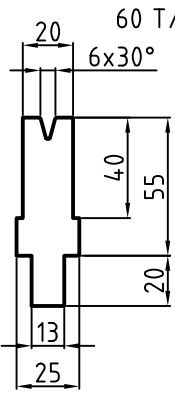
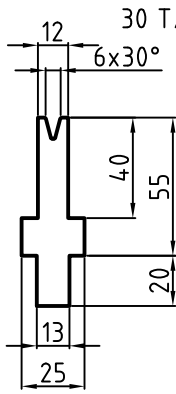
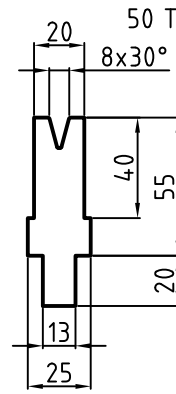
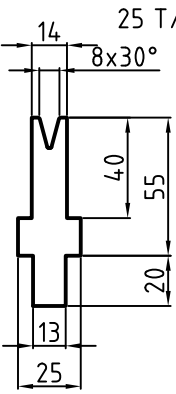
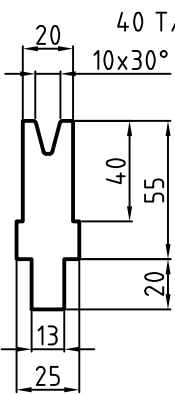
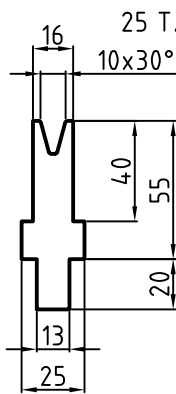
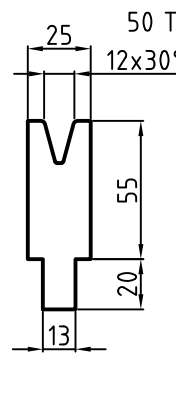
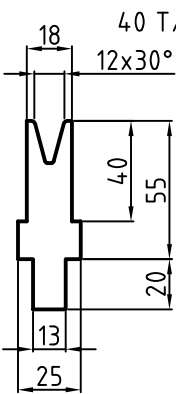
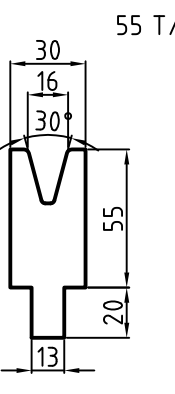
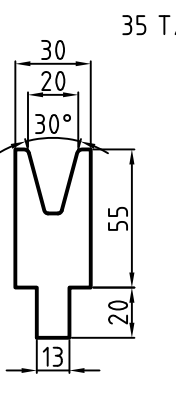
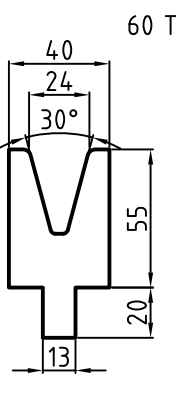
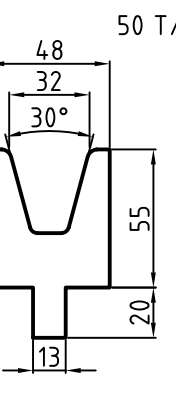
Stansar med 30° spetsvinkel

Ver 2.0

<p>P7S 200 T/m</p> 	<p>P7R 200 T/m</p> 	<p>P7RF 200 T/m</p> 	<p>P7RF/200 200 T/m</p> 
<p>P7RFA 200 T/m</p> 	<p>P7RFA/250 200 T/m</p> 		

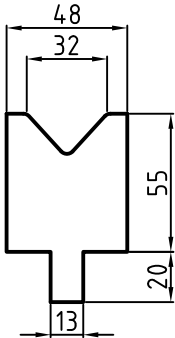
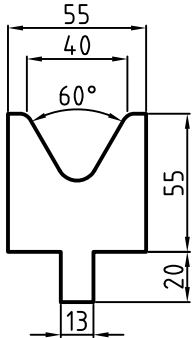
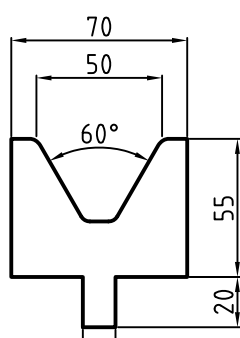
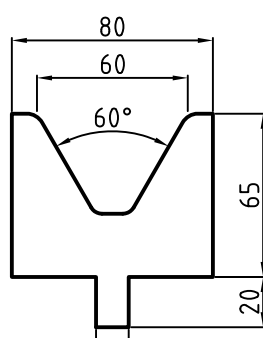
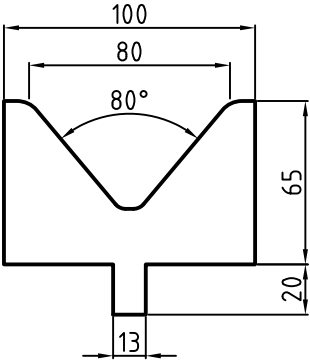
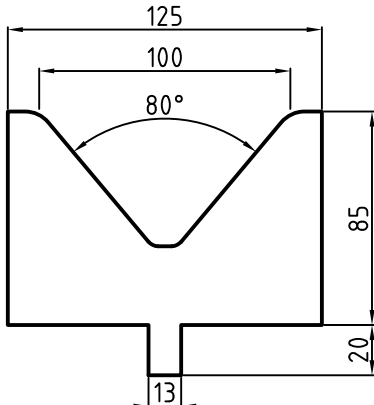
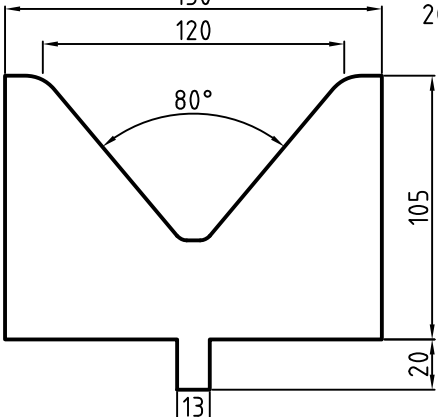
Enspårsdynor med 30° dynspår

Ver 2.0

<p>M6/30°</p> <p>60 T/m</p> 	<p>M6-S</p> <p>30 T/m</p> 	<p>M8/30°</p> <p>50 T/m</p> 	<p>M8-S</p> <p>25 T/m</p> 
<p>M10/30°</p> <p>40 T/m</p> 	<p>M10-S</p> <p>25 T/m</p> 	<p>M12/30°</p> <p>50 T/m</p> 	<p>M12-S</p> <p>40 T/m</p> 
<p>M16/30°</p> <p>55 T/m</p> 	<p>M20/30°</p> <p>35 T/m</p> 	<p>M24/30°</p> <p>60 T/m</p> 	<p>M32/30°</p> <p>50 T/m</p> 

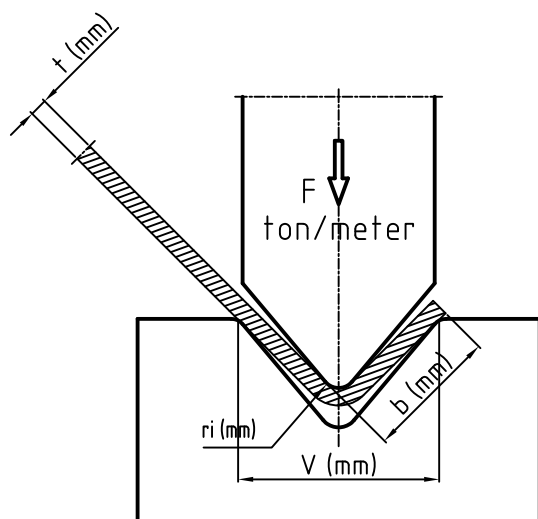
Enspårsvagn med 60°-85° dynspår

Ver 2.0

<p>M32/85°</p>  <p>Dimensions: 48 (top width), 32 (top width), 55 (height), 20 (flange height), 13 (flange width)</p>	<p>M40/60°</p> <p>130 T/m</p>  <p>Dimensions: 55 (top width), 40 (top width), 60° (angle), 55 (height), 20 (flange height), 13 (flange width)</p>	<p>M50/60°</p> <p>100 T/m</p>  <p>Dimensions: 70 (top width), 50 (top width), 60° (angle), 55 (height), 20 (flange height), 13 (flange width)</p>	<p>M60/60°</p> <p>110 T/m</p>  <p>Dimensions: 80 (top width), 60 (top width), 60° (angle), 65 (height), 20 (flange height), 13 (flange width)</p>
<p>M80</p> <p>160 T/m</p>  <p>Dimensions: 100 (top width), 80 (top width), 80° (angle), 65 (height), 20 (flange height), 13 (flange width)</p>	<p>M100</p> <p>200 T/m</p>  <p>Dimensions: 125 (top width), 100 (top width), 80° (angle), 85 (height), 20 (flange height), 13 (flange width)</p>		
<p>M120</p> <p>150</p> <p>200 T/m</p>  <p>Dimensions: 150 (top width), 120 (top width), 80° (angle), 105 (height), 20 (flange height), 13 (flange width)</p>			

Presskrafttabell

Ver 2.0



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

HJO-VERKTYG AB

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