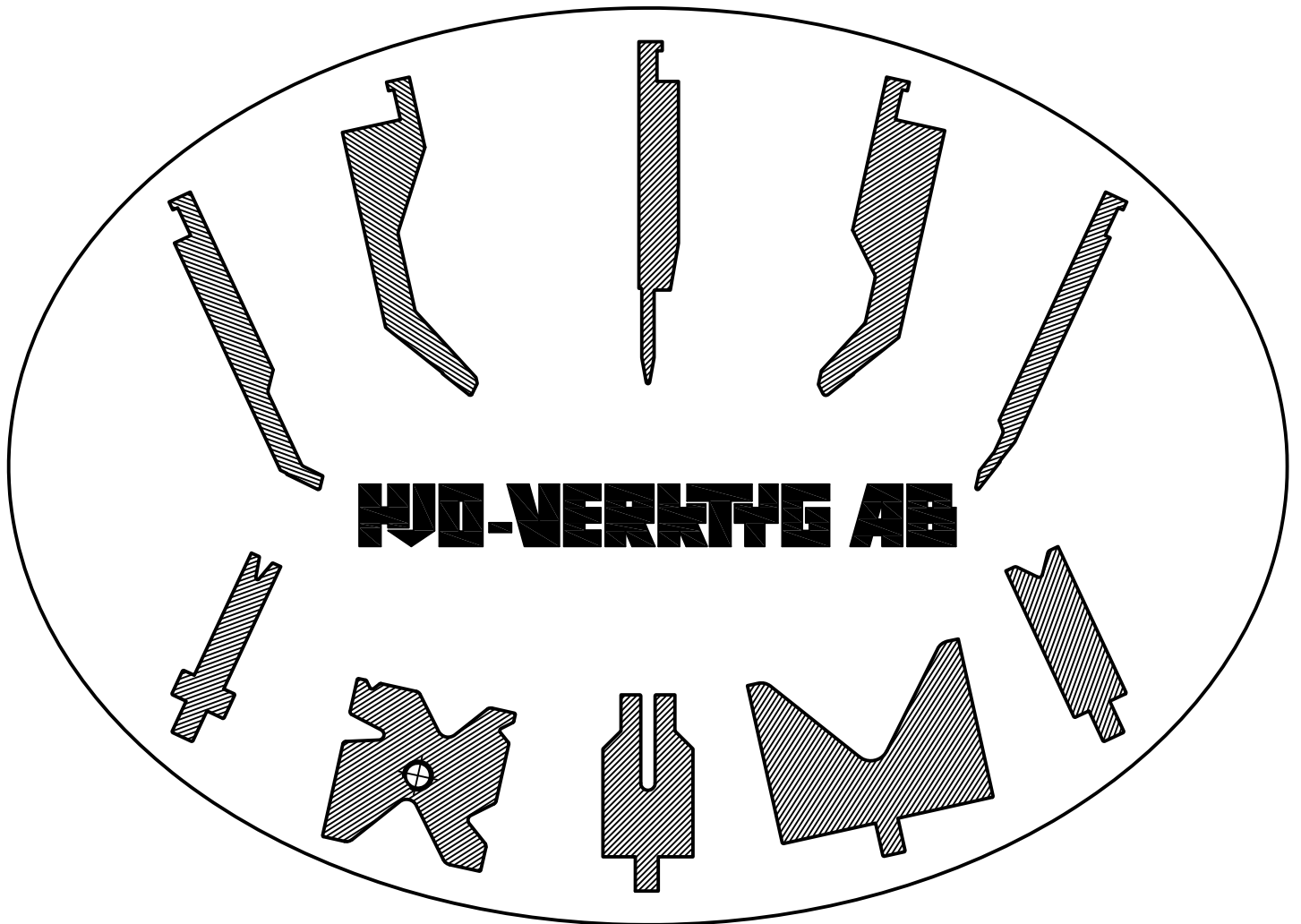


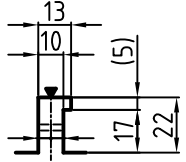
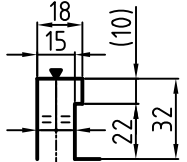
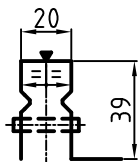
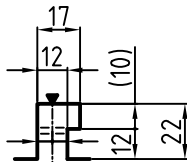
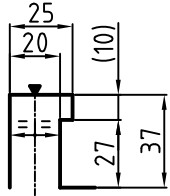
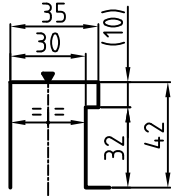
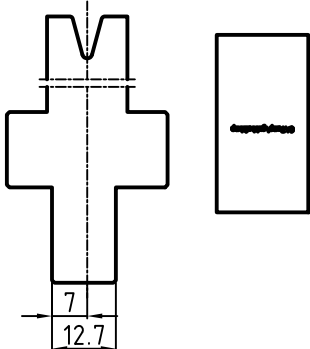
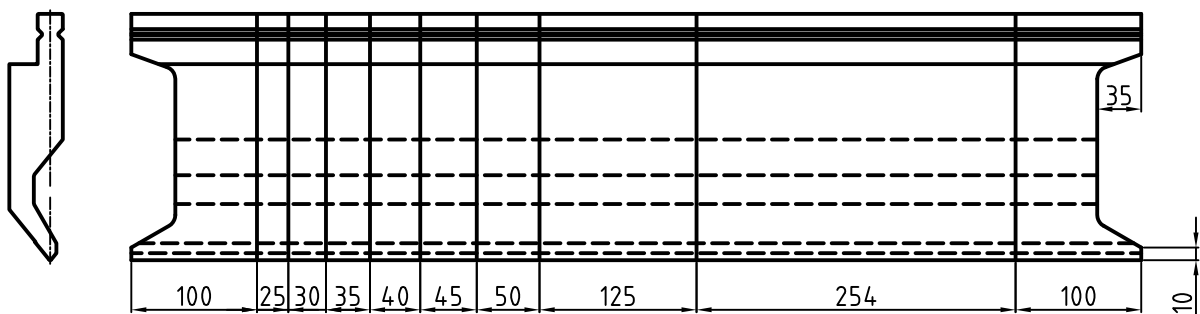
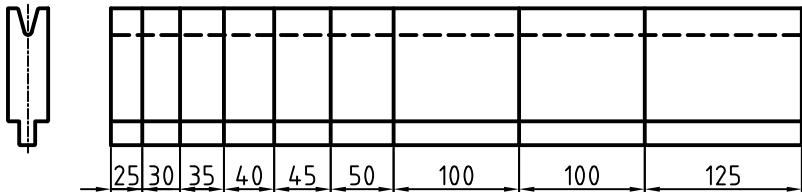
Kantpressverktyg av typ LVD



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

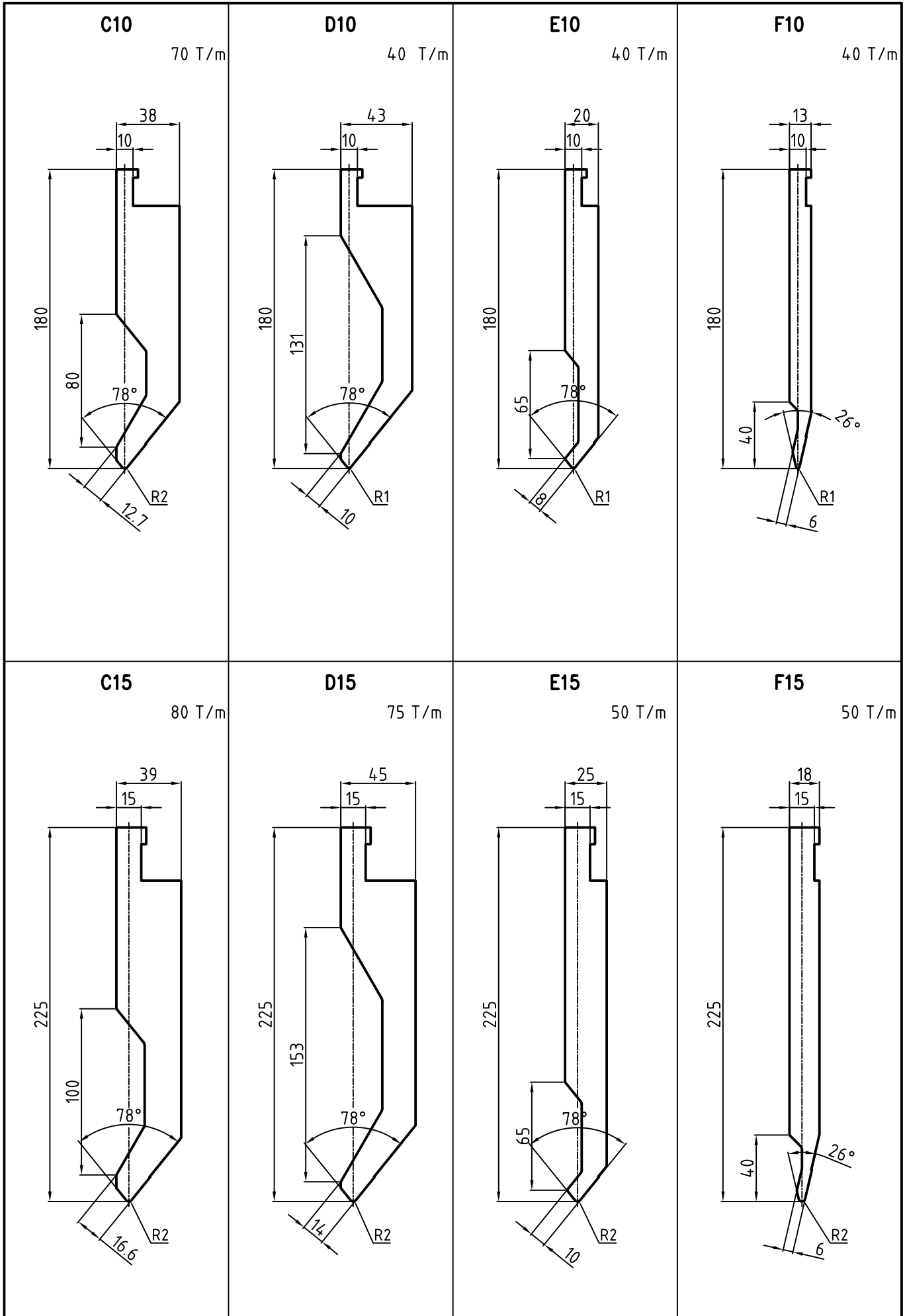
Stansfästen samt delningar

Ver 1.1

<p>Fäste typ LVD "Classic" 10mm</p> 	<p>Fäste typ LVD "Classic" 15mm</p> 	<p>Fäste typ Wila</p> 	<p>Fäste typ LVD 2</p> 
<p>Fäste typ LVD 4</p> 	<p>Fäste typ LVD 5</p> 		
<p>Fäste för enspårsdynor</p> 			
<p>Standarddelning på stansar</p> 			
<p>Standarddelning på dynor</p> 			

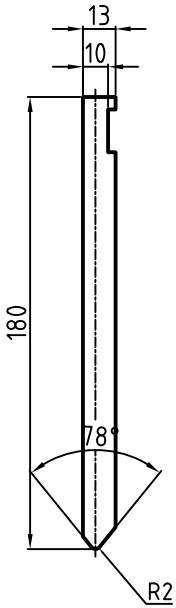
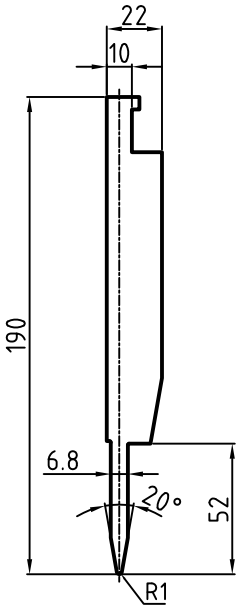
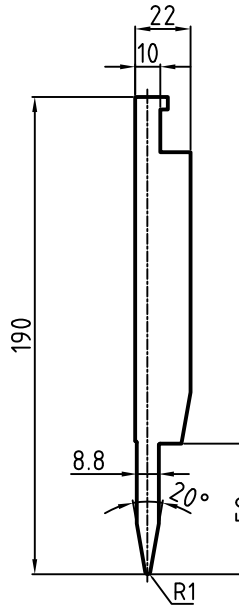
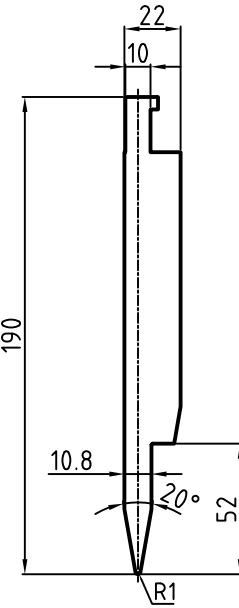
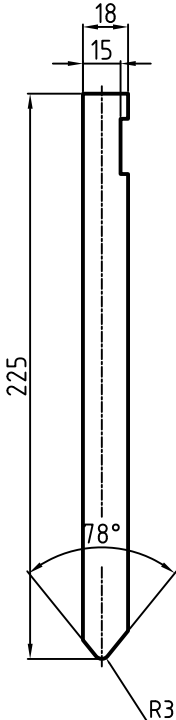
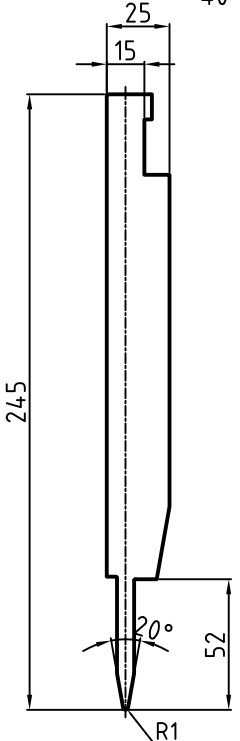
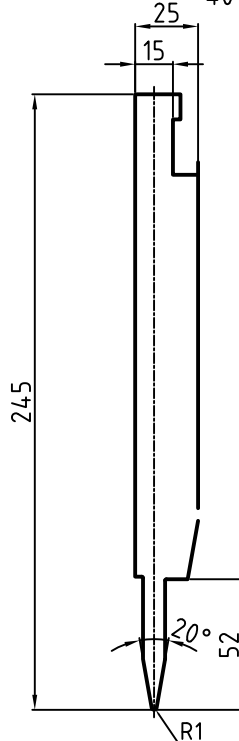
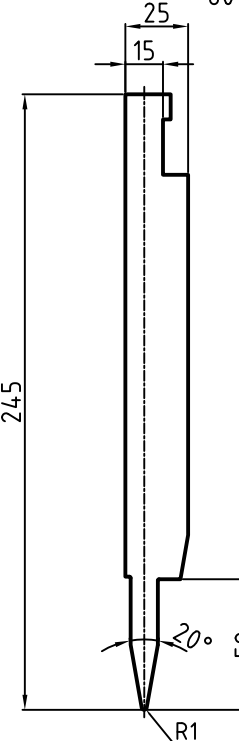
Stansar med LVD "Classic" fäste

Ver 1.1



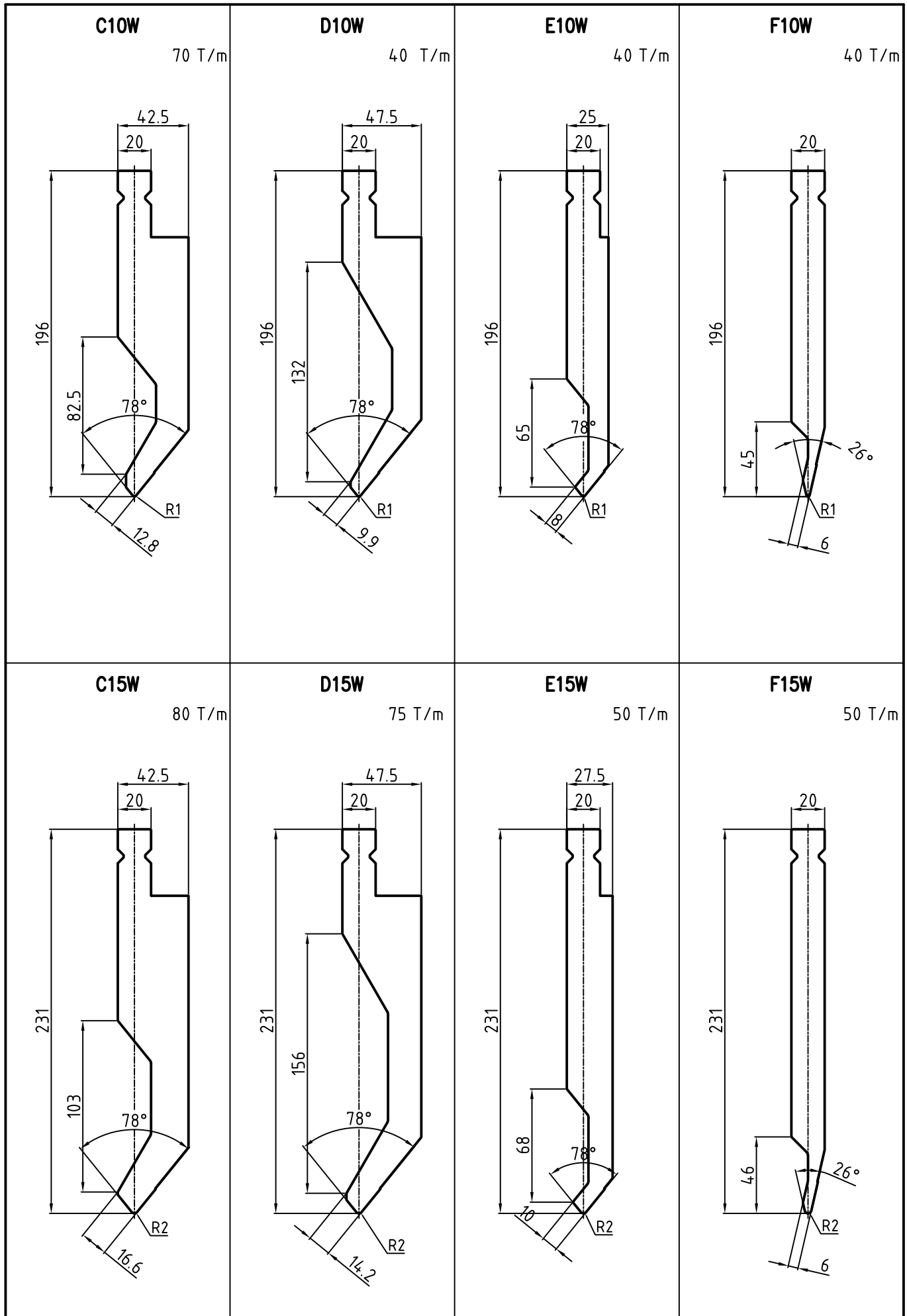
Stansar med LVD "Classic" fäste

Ver 1.1

<p>R10 80 T/m</p> 	<p>P10.08 40 T/m</p>  <p>Används tillsammans med dyna T08.90</p>	<p>P10.10 40 T/m</p>  <p>Används tillsammans med dyna T10.90</p>	<p>P10.12 40 T/m</p>  <p>Används tillsammans med dyna T12.90</p>
<p>R15 120 T/m</p> 	<p>P15.08 40 T/m</p>  <p>Används tillsammans med dyna T08.90 alt. T08.13</p>	<p>P15.10 40 T/m</p>  <p>Används tillsammans med dyna T10.90 alt. T10.13</p>	<p>P15.12 60 T/m</p>  <p>Används tillsammans med dyna T12.90 alt. T12.13</p>

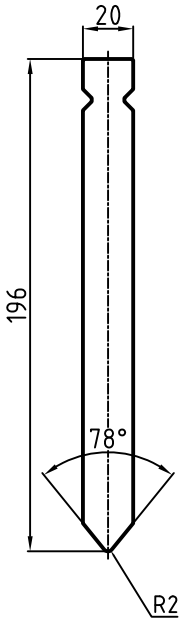
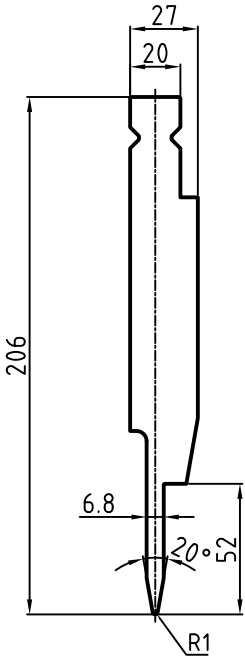
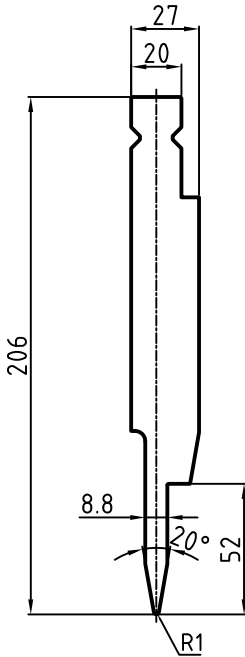
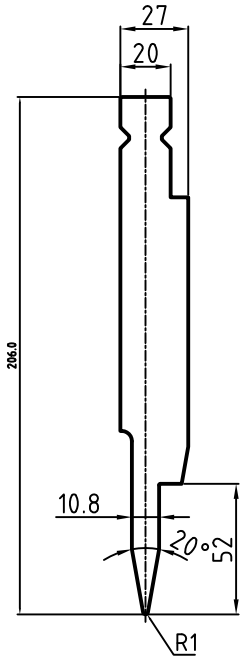
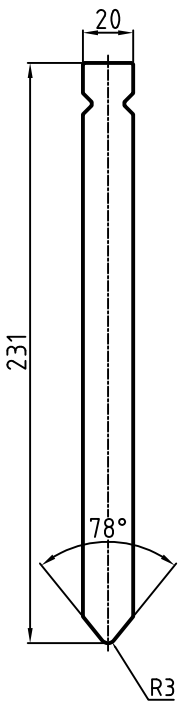
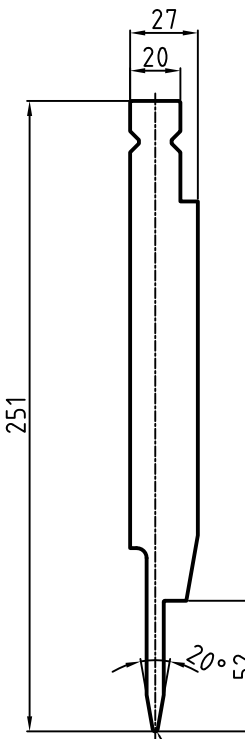
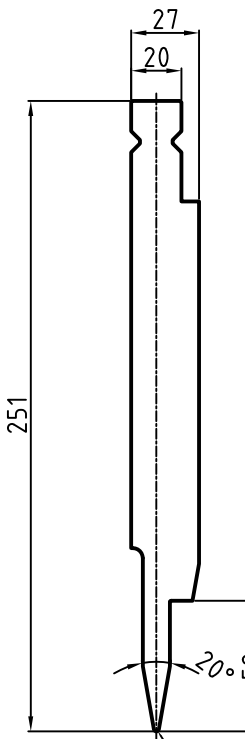
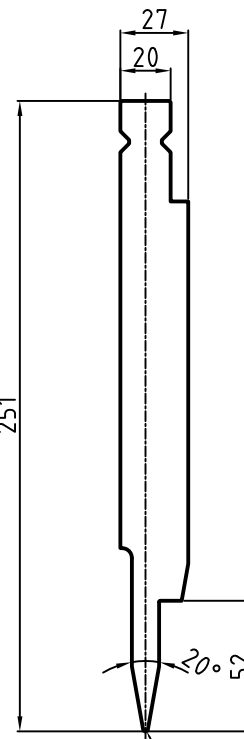
Stansar med Wila fäste

Ver 1.1



Stansar med Wila fäste

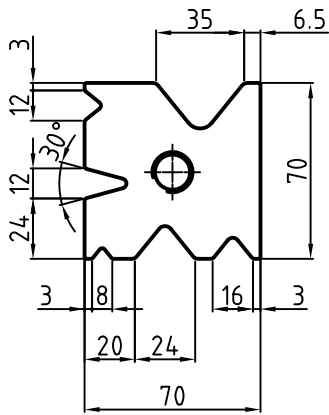
Ver 1.1

<p>R10W 80 T/m</p> 	<p>P10.08W 40 T/m</p>  <p>Används tillsammans med dyna T08.90</p>	<p>P10.10W 40 T/m</p>  <p>Används tillsammans med dyna T10.90</p>	<p>P10.12W 40 T/m</p>  <p>Används tillsammans med dyna T12.90</p>
<p>R15W 120 T/m</p> 	<p>P15.08W 40 T/m</p>  <p>Används tillsammans med dyna T08.90 alt. T08.13</p>	<p>P15.10W 40 T/m</p>  <p>Används tillsammans med dyna T10.90 alt. T10.13</p>	<p>P15.12W 60 T/m</p>  <p>Används tillsammans med dyna T12.90 alt. T12.13</p>

Flerspårsdynor

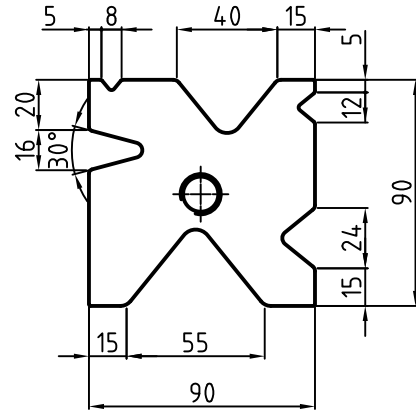
Ver 1.1

M70



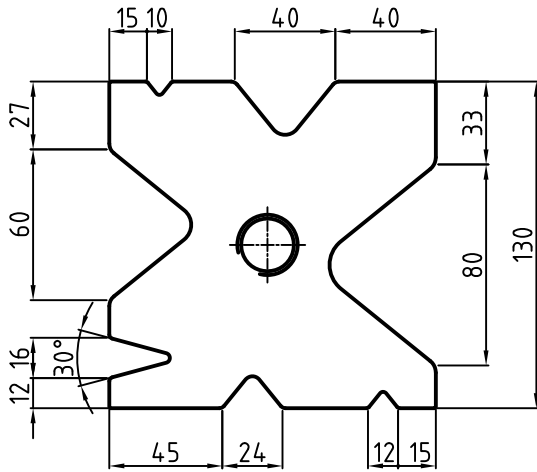
Ej angivna spårvinklar är 78°

M90



Ej angivna spårvinklar är 78°

M13



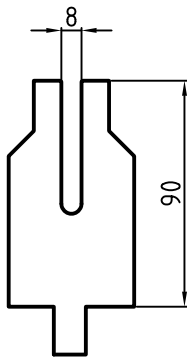
Ej angivna spårvinklar är 78°

Omslagsdynor

Ver 1.1

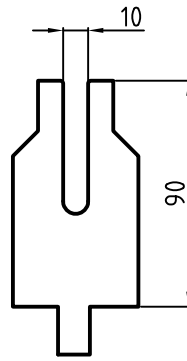
T08.90

35 T/m



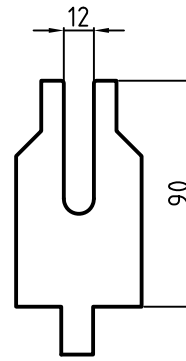
T10.90

35 T/m



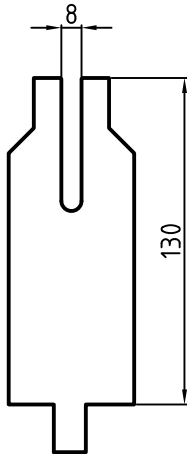
T12.90

35 T/m



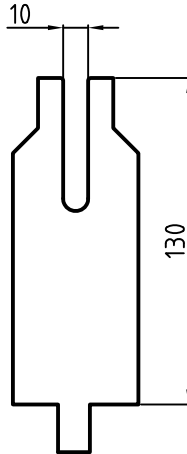
T08.13

35 T/m



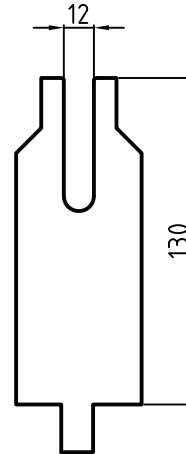
T10.13

35 T/m



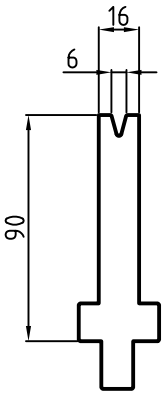
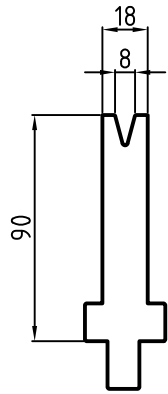
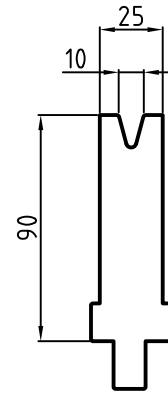
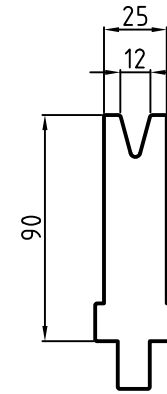
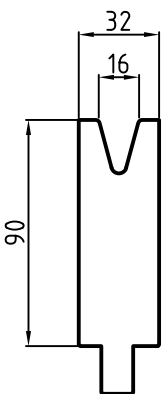
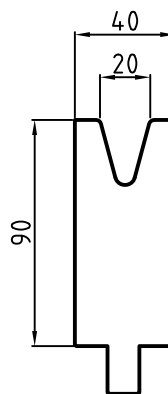
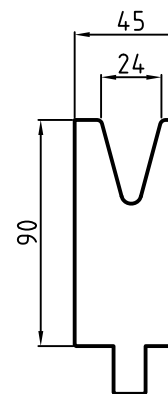
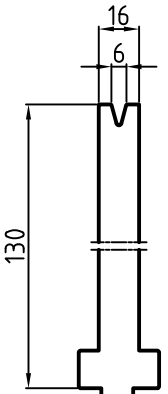
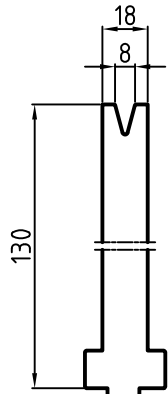
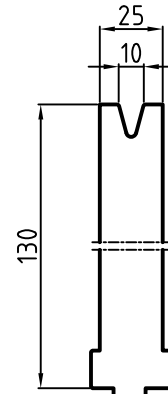
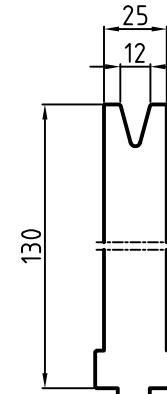
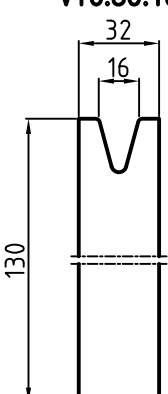
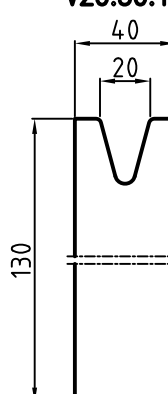
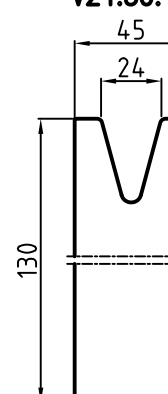
T12.13

35 T/m



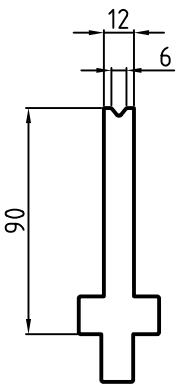
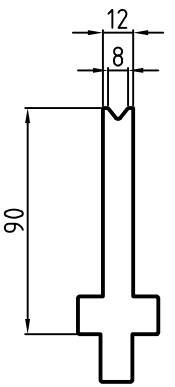
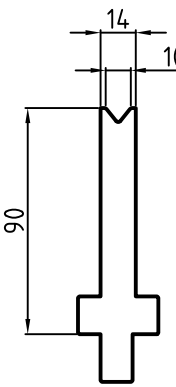
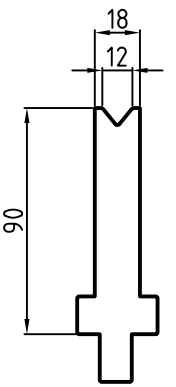
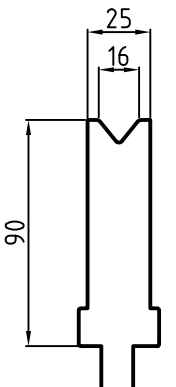
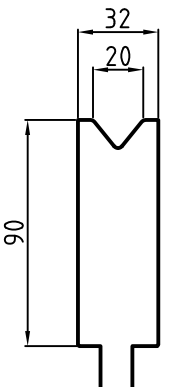
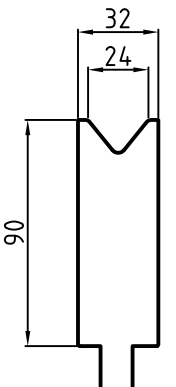
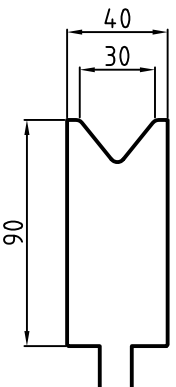
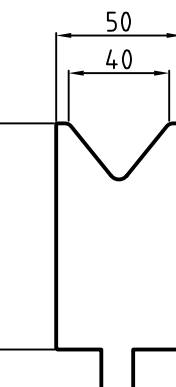
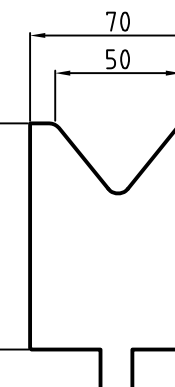
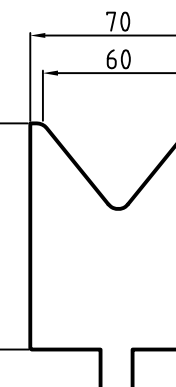
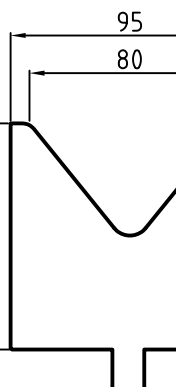
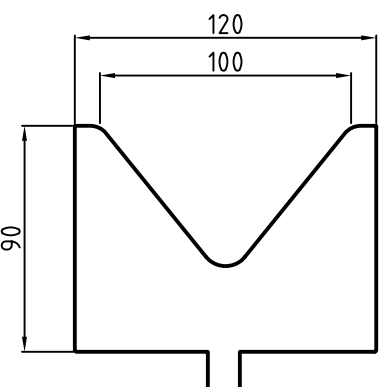
Enspårsdynor 30°

Ver 1.1

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<p>V16.30.90 38 T/m</p> 	<p>V20.30.90 38 T/m</p> 	<p>V24.30.90 55 T/m</p> 	
<p>V06.30.13 20 T/m</p> 	<p>V08.30.13 22 T/m</p> 	<p>V10.30.13 30 T/m</p> 	<p>V12.30.13 38 T/m</p> 
<p>V16.30.13 38 T/m</p> 	<p>V20.30.13 38 T/m</p> 	<p>V24.30.13 55 T/m</p> 	

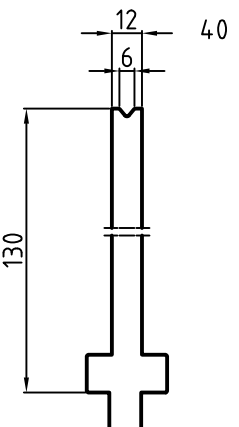
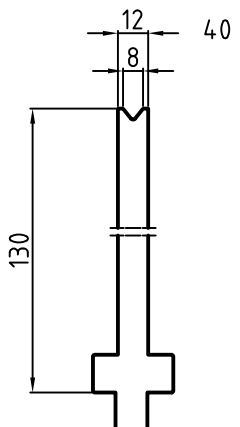
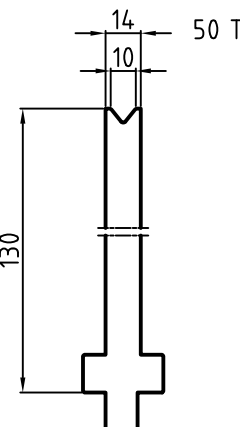
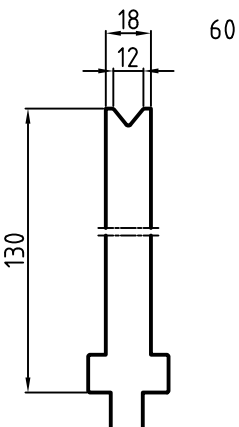
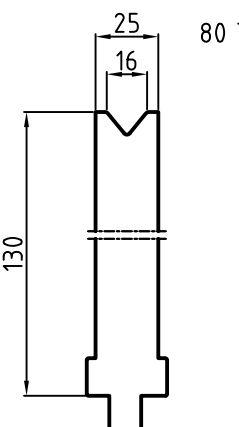
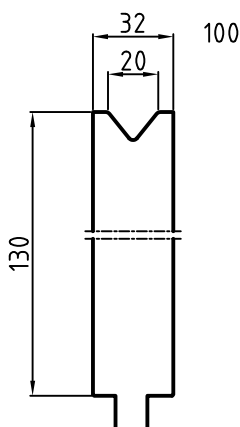
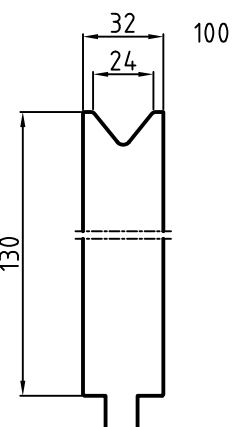
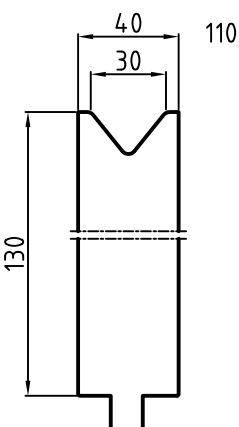
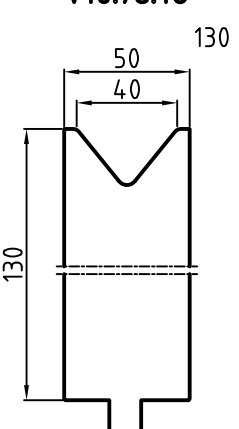
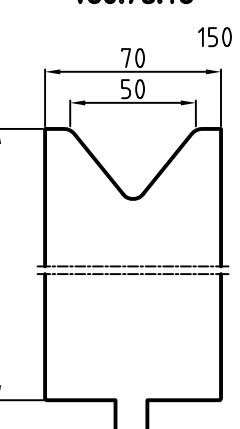
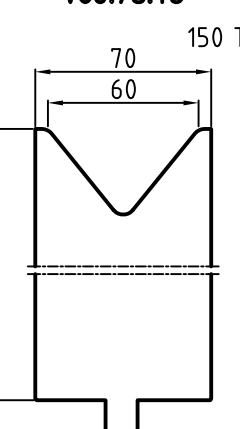
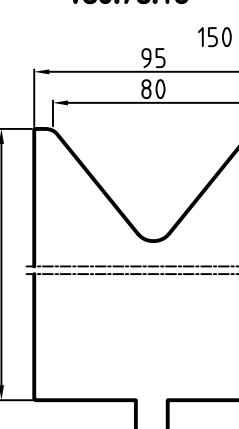
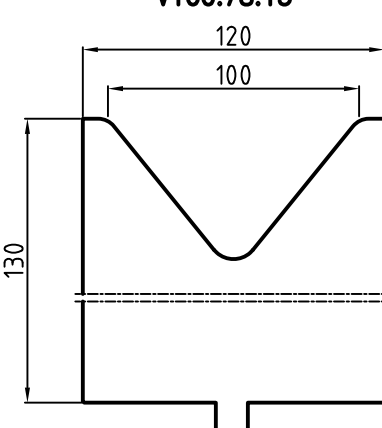
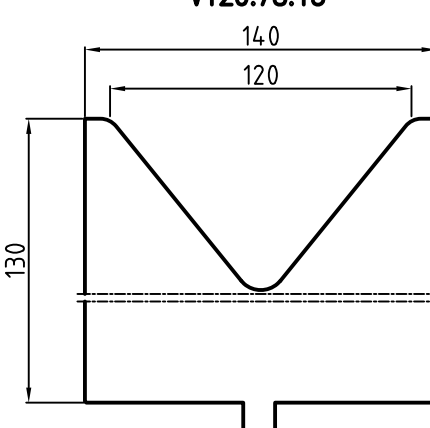
Enspårsvagn 78° höjd 90mm

Ver 1.1

<p>V06.78.90 40 T/m</p> 	<p>V08.78.90 40 T/m</p> 	<p>V10.78.90 50 T/m</p> 	<p>V12.78.90 60 T/m</p> 
<p>V16.78.90 80 T/m</p> 	<p>V20.78.90 100 T/m</p> 	<p>V24.78.90 100 T/m</p> 	<p>V30.78.90 110 T/m</p> 
<p>V40.78.90 130 T/m</p> 	<p>V50.78.90 150 T/m</p> 	<p>V60.78.90 150 T/m</p> 	<p>V80.78.90 150 T/m</p> 
<p>V100.78.90 150 T/m</p> 			

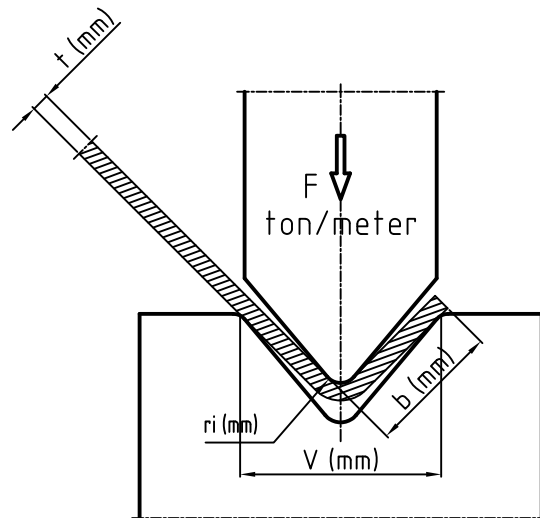
Enspårsdynor 78° höjd 130mm

Ver 1.1

<p>V06.78.13 40 T/m</p> 	<p>V08.78.13 40 T/m</p> 	<p>V10.78.13 50 T/m</p> 	<p>V12.78.13 60 T/m</p> 
<p>V16.78.13 80 T/m</p> 	<p>V20.78.13 100 T/m</p> 	<p>V24.78.13 100 T/m</p> 	<p>V30.78.13 110 T/m</p> 
<p>V40.78.13 130 T/m</p> 	<p>V50.78.13 150 T/m</p> 	<p>V60.78.13 150 T/m</p> 	<p>V80.78.13 150 T/m</p> 
<p>V100.78.13 150 T/m</p> 		<p>V120.78.13 150 T/m</p> 	

Presskrafttabell

Ver 1.1



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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