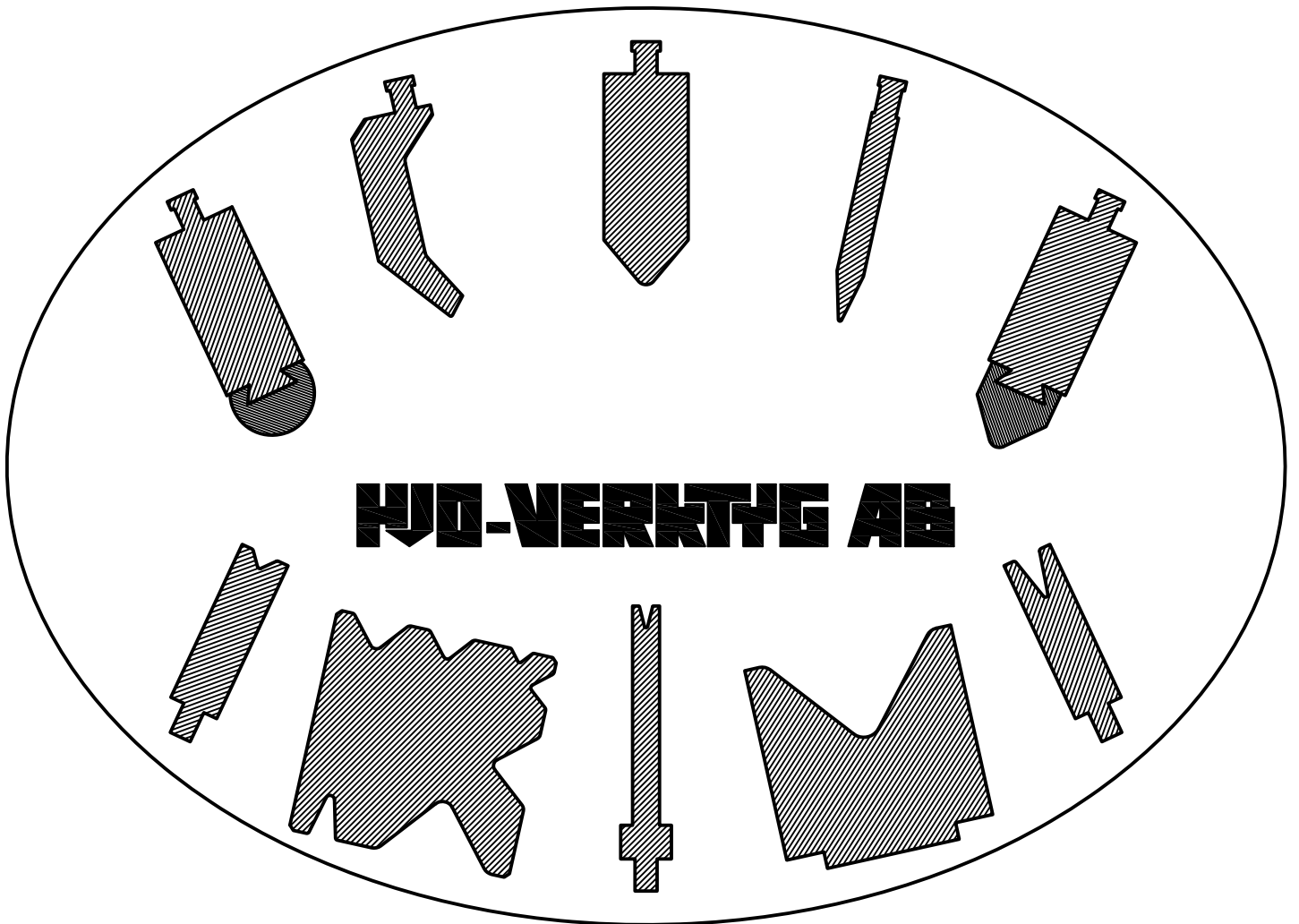


Kantpressverktyg av typ Ursviken

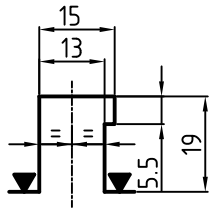


Hjo-Verktyg AB, Industrigatan 38, 544 50 Hjo
Telefon 0503-130 80, Telefax 0503-120 19
Internet www.hjoverktyg.se
E-post info@hjoverktyg.se

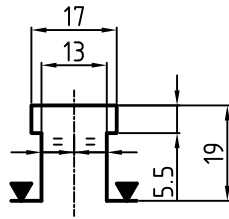
Stansfästen samt delningar

Ver 1.2

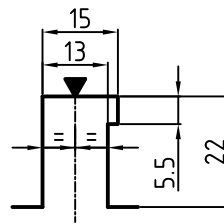
Fäste med enkel klack och presstryck på sidorna



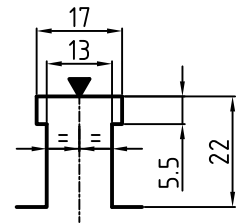
Fäste med dubbel klack och presstryck på sidorna



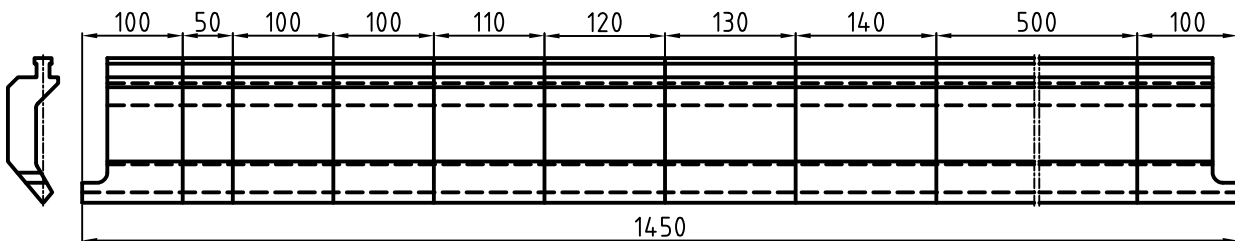
Fäste med enkel klack och presstryck på toppen



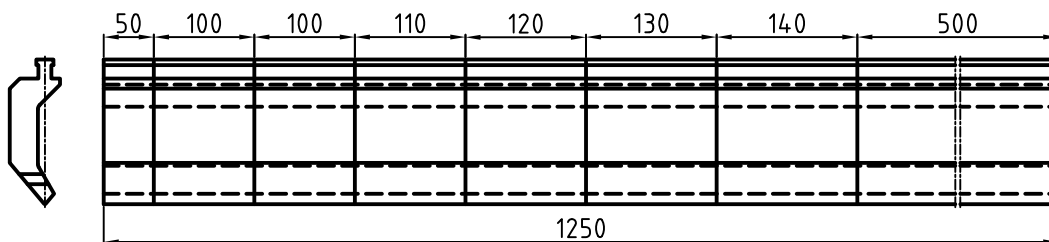
Fäste med dubbel klack och presstryck på toppen



Standarddelning på stansar med "horn"
Behövs längre verktyg addera delar L=1000mm



Standarddelning på stansar utan "horn"
Behövs längre verktyg addera delar L=1000mm



Standarddelning på dynor är lika delningen för stansar
men då "horn" används på stansen ersätts denna med
2st delar L=100mm

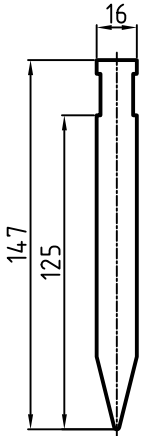
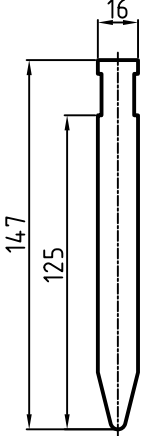
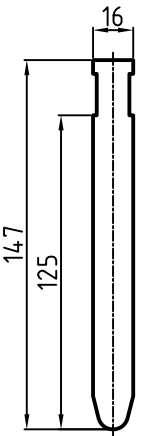
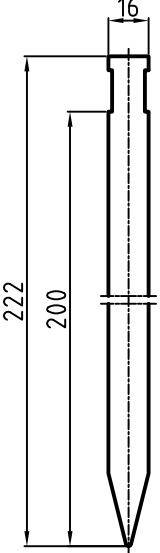
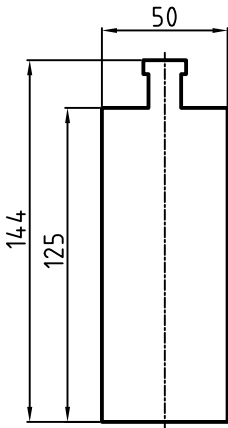
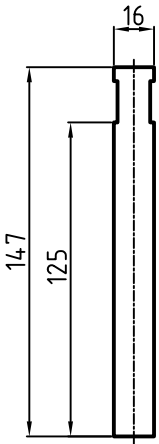
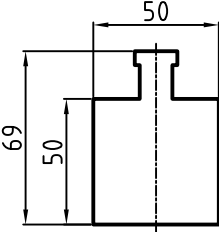
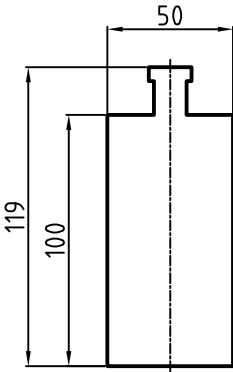
Stansar 80°

Ver 1.2

<p>49252 R=1 75 T/m</p>	<p>49253 R=3 100 T/m</p>	<p>52323 R=6 100 T/m</p>	<p>52324 R=1 75 T/m</p>
<p>52325 R=1 35 T/m</p>	<p>52326 R=1 15 T/m</p>	<p>52329 R=1 100 T/m</p>	<p>52330 R=3 100 T/m</p>
<p>49254 R=6 350 T/m</p>	<p>49255 R=12 350 T/m</p>	<p>52331 R=20 350 T/m</p>	<p>52332 R=25 600 T/m</p>

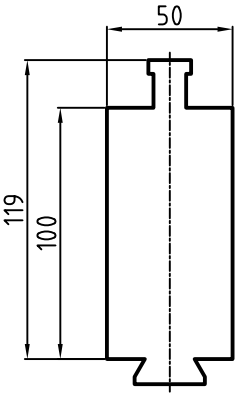
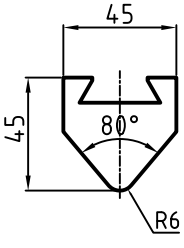
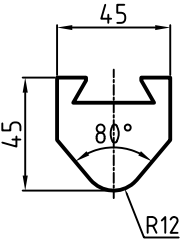
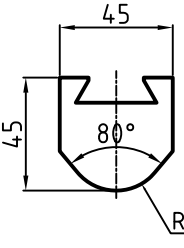
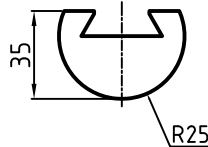
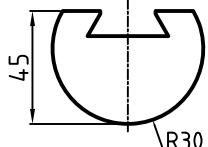
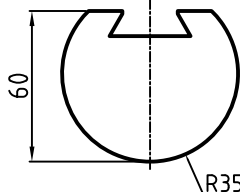
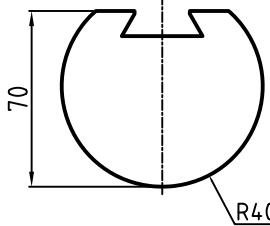
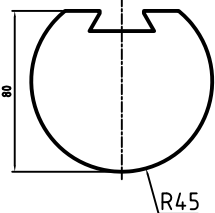
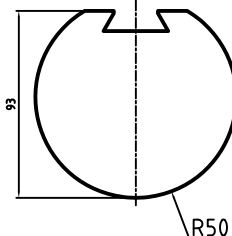
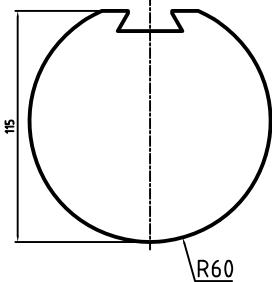
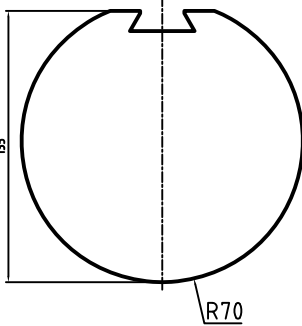
Stansar 28°/ Plattningsstansar

Ver 1.2

<p>49256 R=1 75 T/m</p> 	<p>49728 R=3 100 T/m</p> 	<p>52338 R=6 100 T/m</p> 	<p>52339 R=1 75 T/m</p> 
<p>52333 350 T/m</p> 	<p>52334 100 T/m</p> 	<p>52335 350 T/m</p> 	<p>52336 350 T/m</p> 

Verktgshållare/Verktgsspetsar

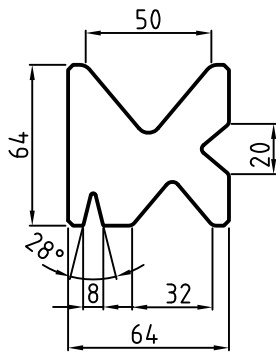
Ver 1.2

<p>52340 200 T/m</p> 	<p>52341 200 T/m</p> 	<p>52342 200 T/m</p> 	<p>52343 200 T/m</p> 
<p>52344 200 T/m</p> 	<p>52345 200 T/m</p> 	<p>52346 200 T/m</p> 	<p>52347 200 T/m</p> 
<p>52348 200 T/m</p> 	<p>52349 200 T/m</p> 	<p>52350 200 T/m</p> 	<p>52351 200 T/m</p> 

Flerspårsdynor

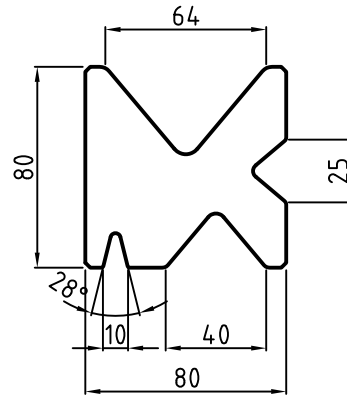
Ver 1.2

33258



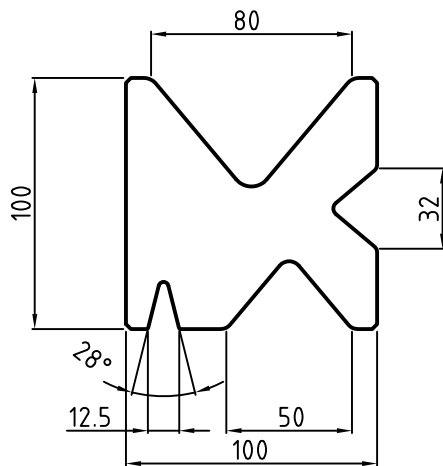
Ej angivna spårvinklar är 80°

33259



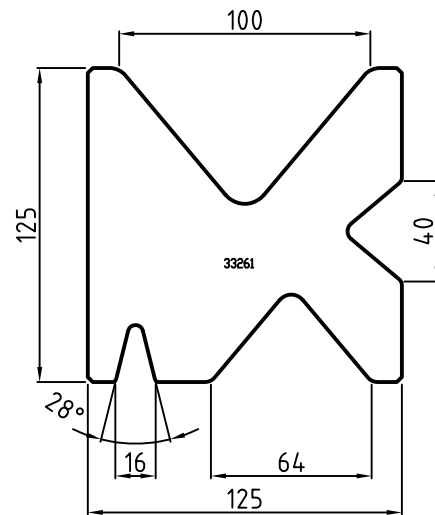
Ej angivna spårvinklar är 80°

33260



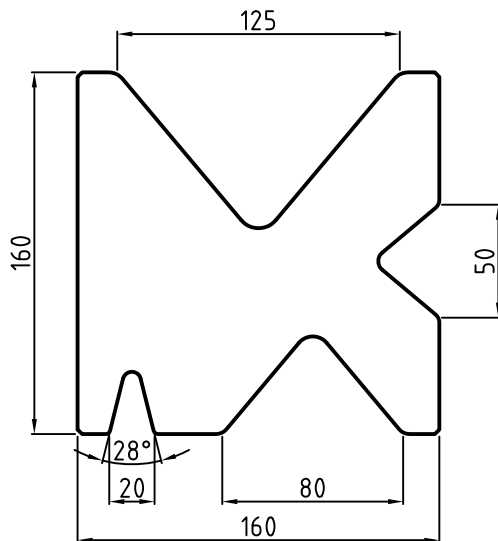
Ej angivna spårvinklar är 80°

33261



Ej angivna spårvinklar är 80°

33262

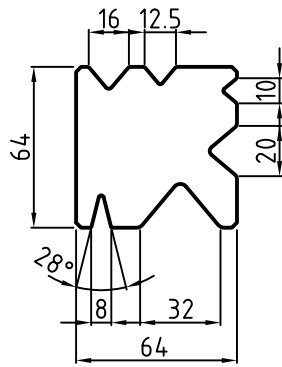


Ej angivna spårvinklar är 80°

Flerspårsdynor

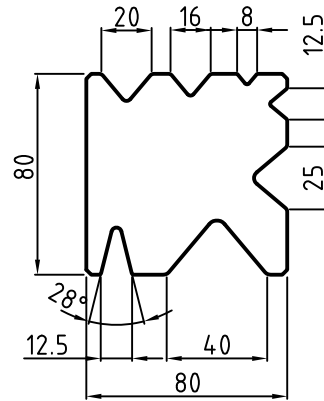
Ver 1.2

52353



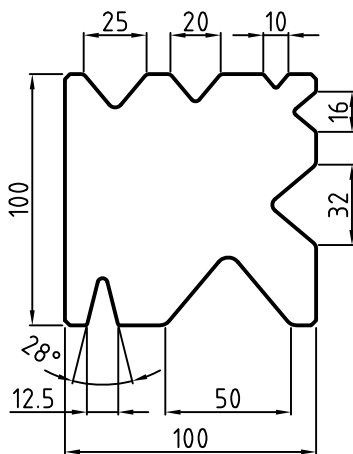
Ej angivna spårvinklar är 80°

52354



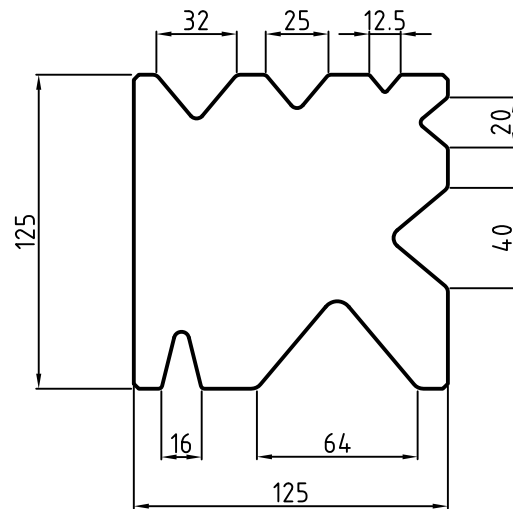
Ej angivna spårvinklar är 80°

52355



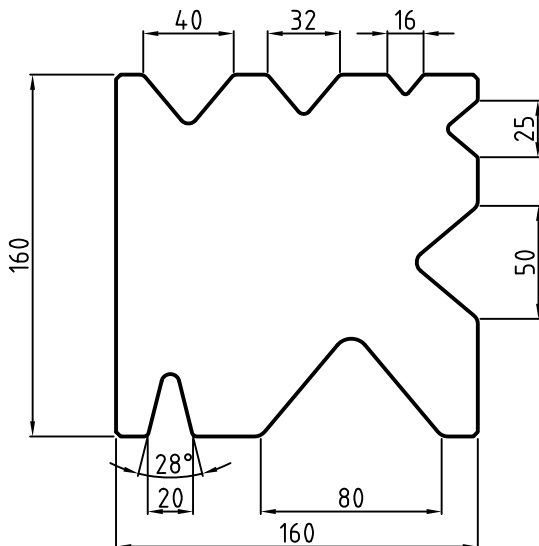
Ej angivna spårvinklar är 80°

52356



Ej angivna spårvinklar är 80°

52357

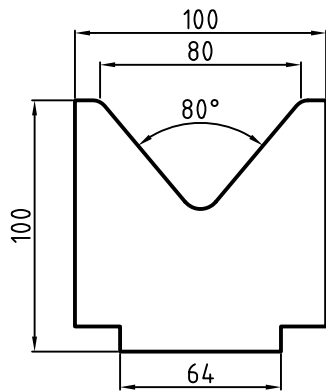


Ej angivna spårvinklar är 80°

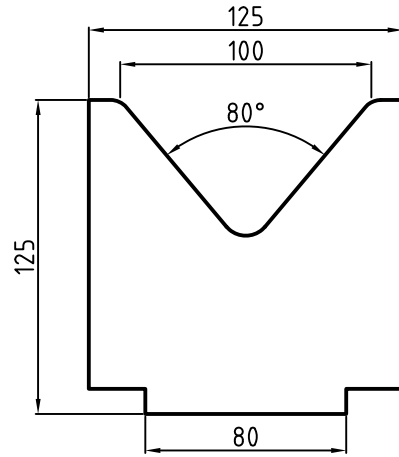
Dynor med fot 80°

Ver 1.2

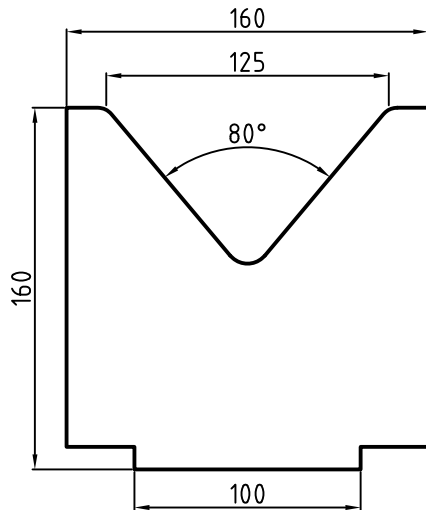
45954



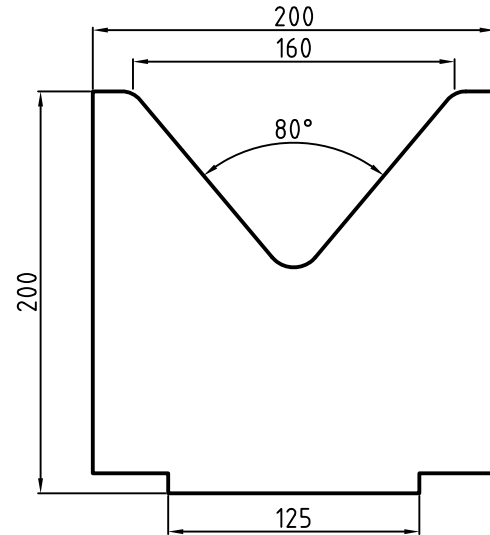
45955



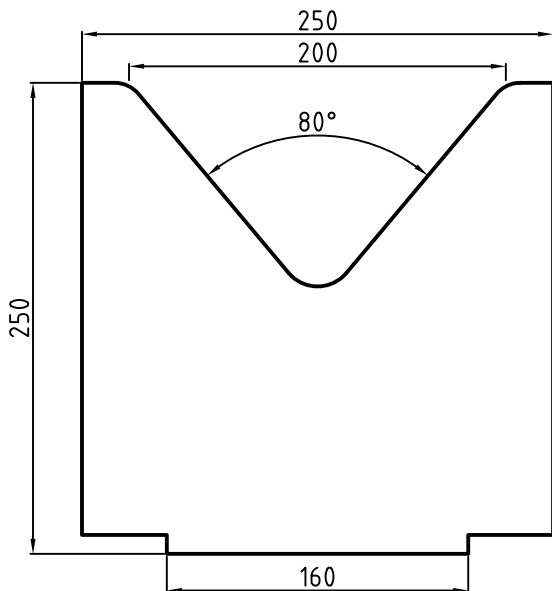
45372



45956

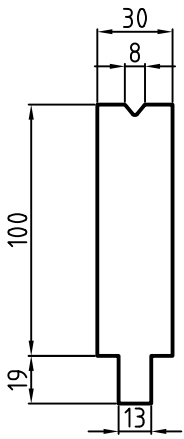
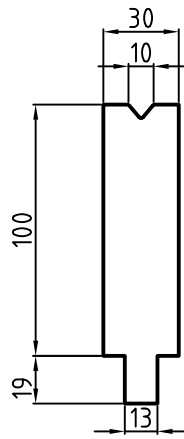
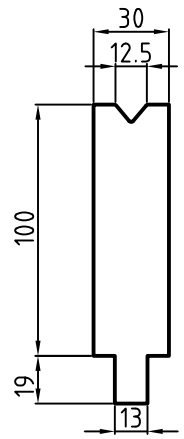
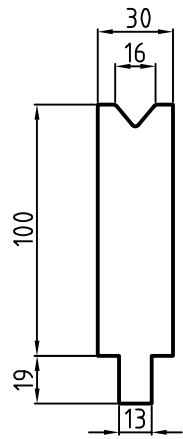
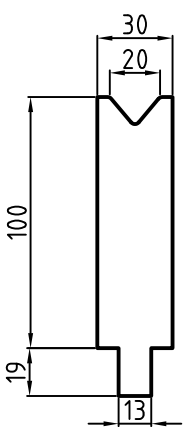
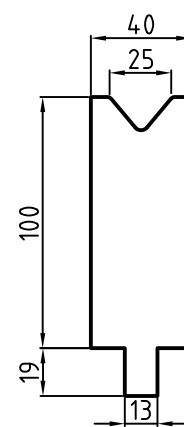
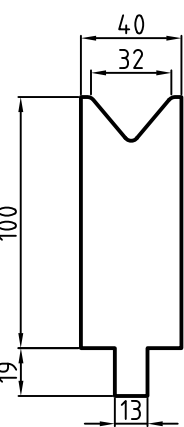
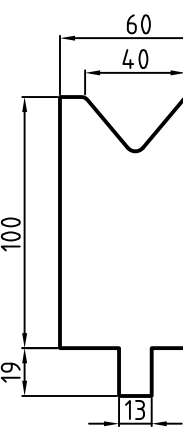
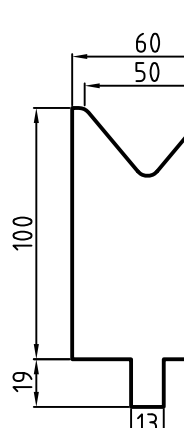
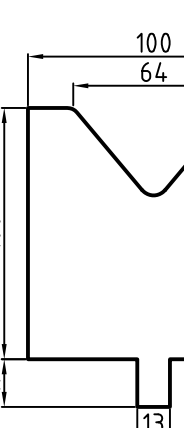
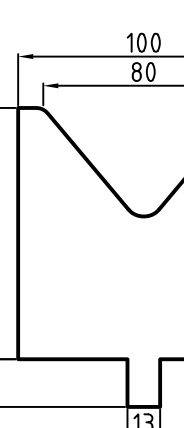


45957



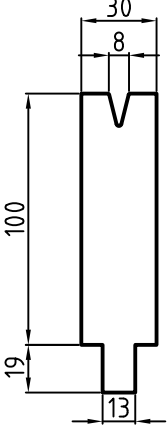
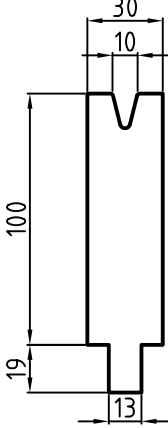
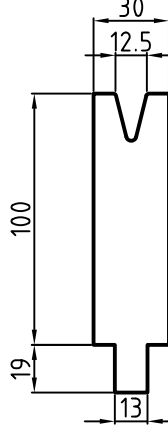
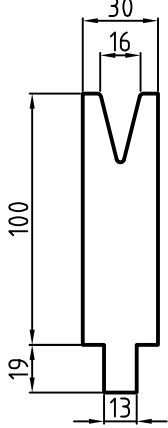
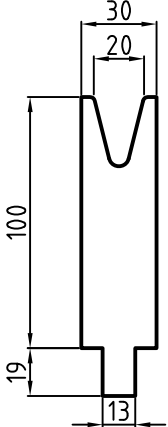
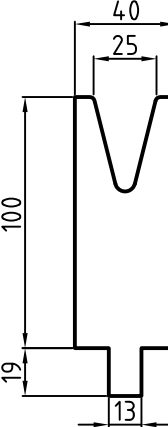
Enspårsdynor 80° H=100mm

Ver 1.2

<p>52365 125 T/m</p> 	<p>52366 125 T/m</p> 	<p>52367 100 T/m</p> 	<p>52368 80 T/m</p> 
<p>52369 70 T/m</p> 	<p>52370 80 T/m</p> 	<p>52371 70 T/m</p> 	<p>52372 125 T/m</p> 
<p>52373 100 T/m</p> 	<p>52374 190 T/m</p> 	<p>52375 170 T/m</p> 	

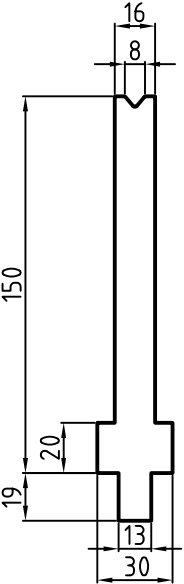
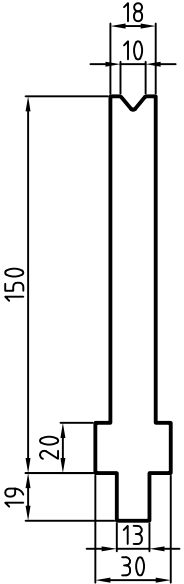
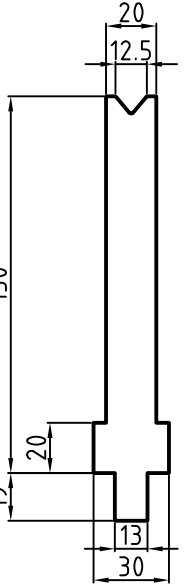
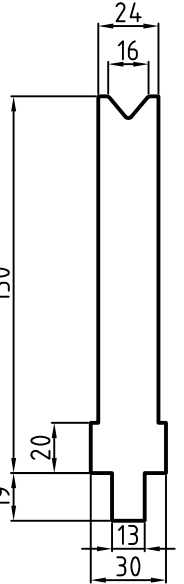
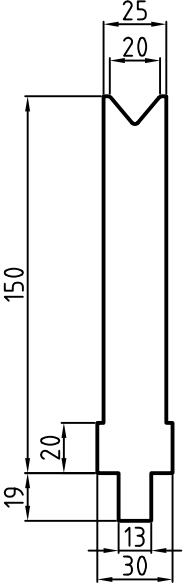
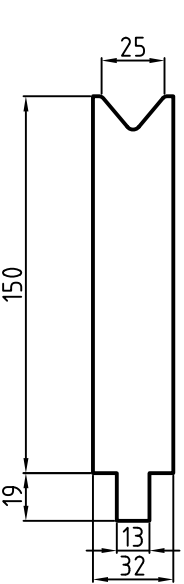
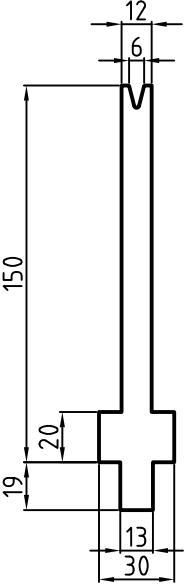
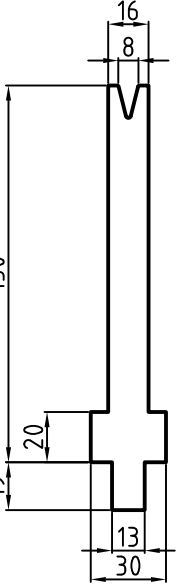
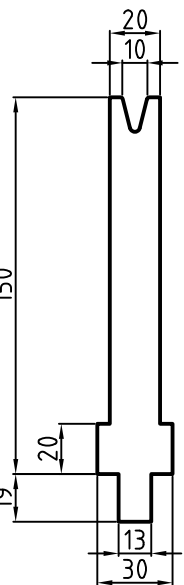
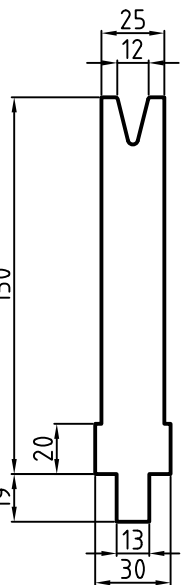
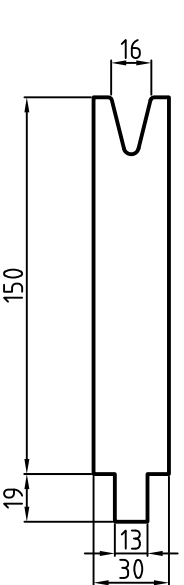
Enspårscydnor 28° H=100mm

Ver 1.2

<p>52376 70 T/m</p> 	<p>52377 50 T/m</p> 	<p>52378 30 T/m</p> 	<p>52379 25 T/m</p> 
<p>52380 20 T/m</p> 	<p>52381 25 T/m</p> 		

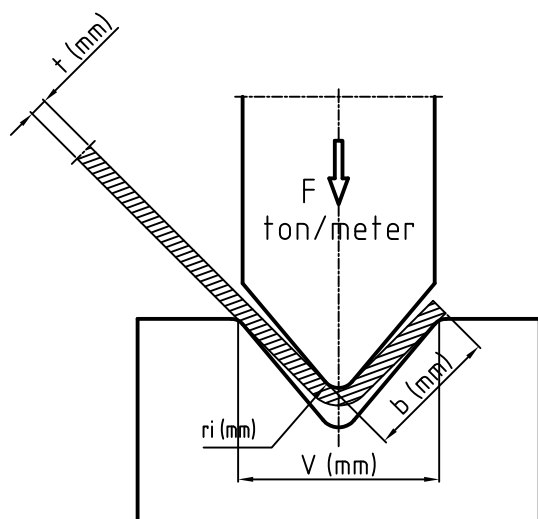
Enspårsdynor 80°/28° H=150mm

Ver 1.2

<p>56540 55 T/m</p> 	<p>56541 55 T/m</p> 	<p>56342 50 T/m</p> 	<p>56543 50 T/m</p> 
<p>56544 50 T/m</p> 	<p>56545 60 T/m</p> 	<p>56546 15 T/m</p> 	<p>56547 20 T/m</p> 
<p>56548 23 T/m</p> 	<p>56549 25 T/m</p> 	<p>56550 25 T/m</p> 	

Presskrafttabell

Ver 1.2



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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