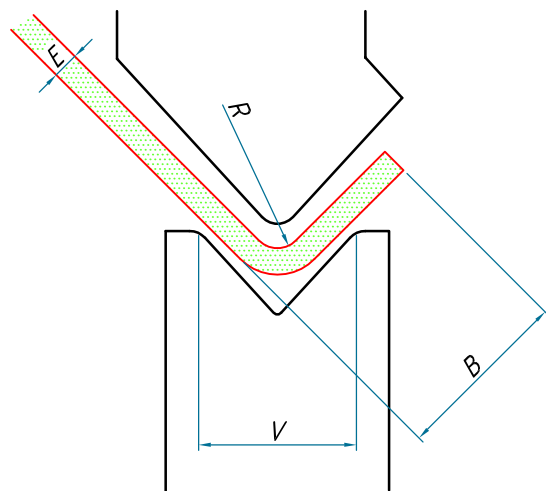
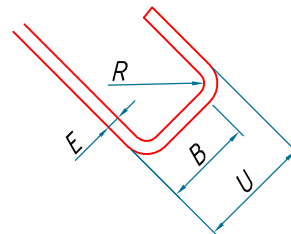


# Abaque de pliage



$R$  = Rayon intérieur de pliage  
 $B$  = Bord minimum



En cas de retour d'aile,  $B = U - R - E$

$V$	$R$	$B$	<i>Epaisseur de tôle : <math>E</math></i>																	
			0.5	0.8	1	1.2	1.5	2	2.5	3	4	5	6	8	10	12	15	20	25	30
4	0.7	2.6	4	10.5																
6	1	4	3	7	11	16														
8	1.3	5.5	2	5	8	12	18.5													
10	1.7	7		4	6.5	9.5	15	26.5												
12	2	8.5			5.5	8	12.5	22	34.5											
16	2.7	11.5				6	9.5	16.5	26	37.5										
20	3.3	14					7.5	13	21	30	53									
25	4	17.5						10.5	16.5	24	42	66								
30	5	21.5							14	20	35	55	79							
35	6	25								17	30	47	68							
40	7	28.5								15	26.5	42	60	106						
50	8	35.5									21	33	48	85	132					
60	10	42.5										27.5	40	71	110	159				
80	13	57											30	53	83	119	186			
100	17	71												43	66	95	149			
125	21	88.5													53	76	119	211		
160	26	113														60	93	165	260	
200	33	141															75	132	207	300
250	42	177																106	165	240
300	50	212																88	140	200
360	60	255																	115	165

Les valeurs sont données pour un acier doux type S235 ( $42\text{kg/mm}^2$ )

Pour les autres aciers, il faut appliquer un coefficient proportionnel :

- Acier S355 ( $55\text{ kg/mm}^2$ ) coeff. 1.3
- Inox 304 ( $64\text{ kg/mm}^2$ ) coeff. 1.5
- Alu AG3 ( $24\text{ kg/mm}^2$ ) coeff. 0.6

## \* Le Pliage en l'air à fond de vé

*C'est la technique la plus couramment utilisée.*

Choix du Vé : 6 à 8 x l'épaisseur jusqu'à 4mm  
8 à 12 x l'épaisseur au delà de 4mm

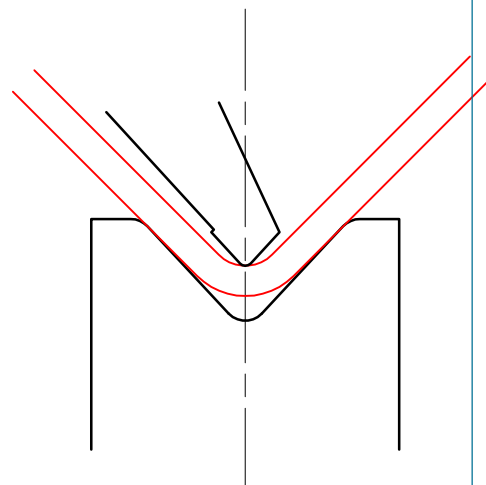
Le rayon interieur du pli  $R_i \geq$  épaisseur de tôle

les avantages :

- Puissance utile minimum
- Possibilité d'ajuster l'angle

les inconvénients :

- Variation du résultat en fonction du sens de laminage de la feuille de tôle



## \* Le Pliage en l'air partiel

*C'est une technique assez utilisée. C'est le même mode opératoire de le pliage à fond de vé mais la pénétration est arrêtée avant pour obtenir un angle plus ouvert.*

Choix du Vé : 10 à 15 x l'épaisseur

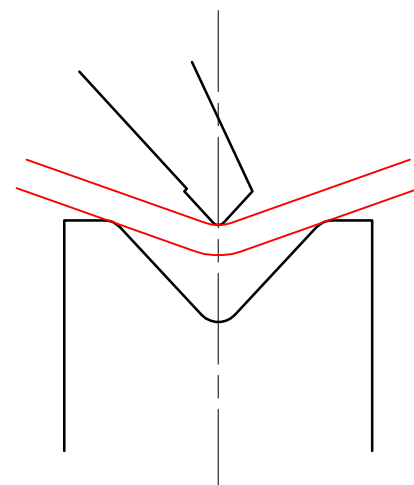
Le rayon interieur du pli  $R_i >$  épaisseur de tôle

les avantages :

- Puissance utile minimum
- Possibilité d'ajuster l'angle
- La forme des outils importe peu

les inconvénients :

- Peu de précision dans l'angle de pliage



## \* Le Pliage en frappe

*C'est une technique très peu utilisée, qui consiste à marquer la fibre neutre de la tôle pour annuler le retour élastique du pli*

Choix du Vé : 5 à 6 x l'épaisseur

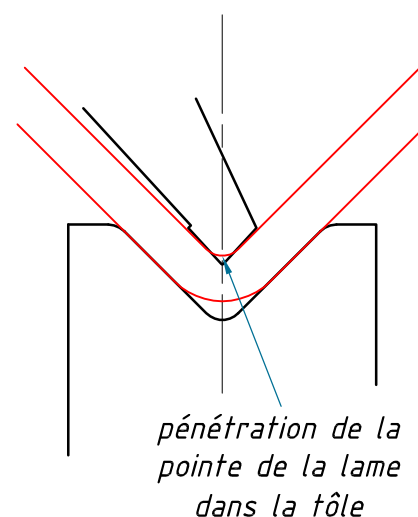
Cette méthode est utilisée pour des tôles jusqu'à 20/10

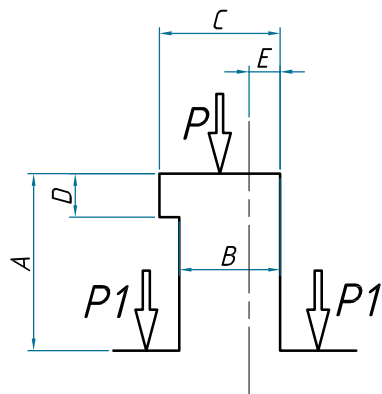
les avantages :

- Répétabilité du pli
- Précision de l'angle

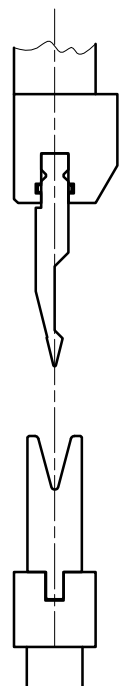
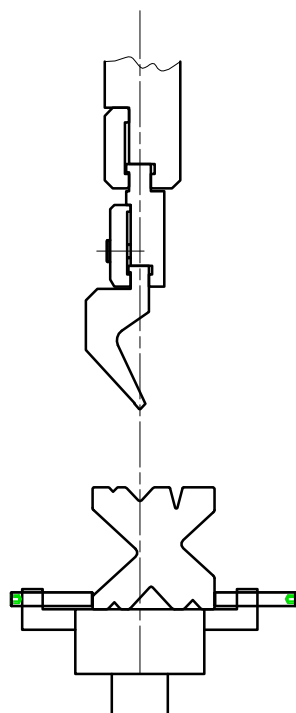
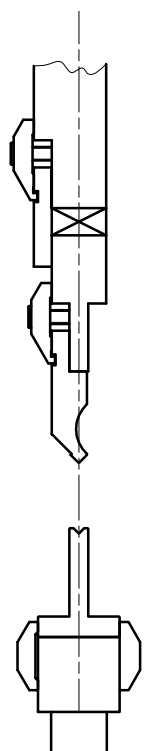
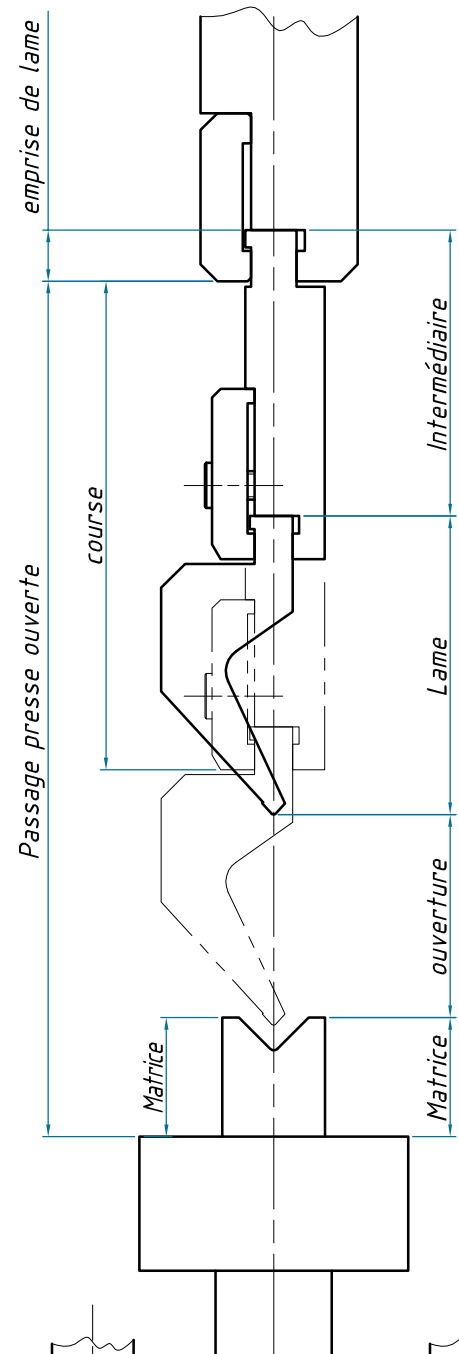
les inconvénients :

- Très grande puissance utile
- Lame et matrice doivent être à l'angle souhaité





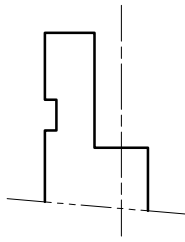
*P : Simple appuis*  
*P1 : Double appuis*



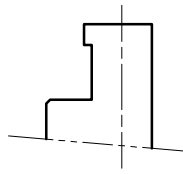
# Modification de rayons

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

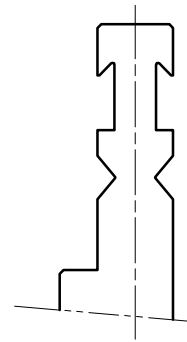
Attache **AMADA**



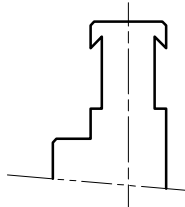
Attache **COLLY**



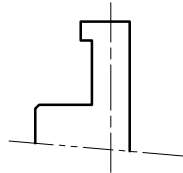
Attache **BEYELER**



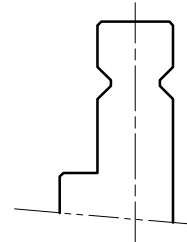
Attache **PERROT**



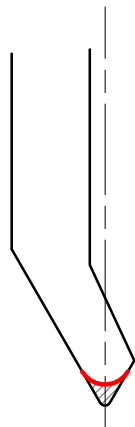
Attache **LVD**



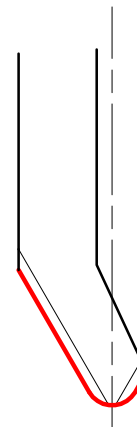
Attache **WILA ,  
TRUMPF**



*Nous pouvons réaliser à la demande des  
rayons spéciaux sur toutes les lames standards*



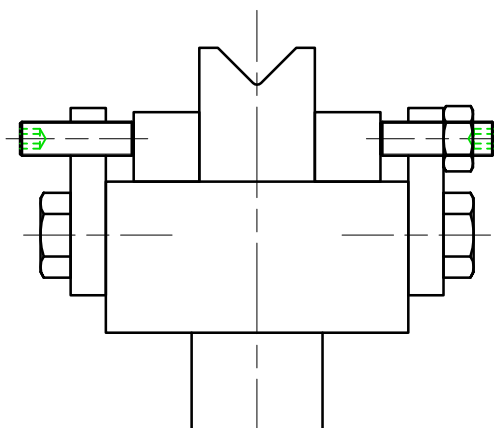
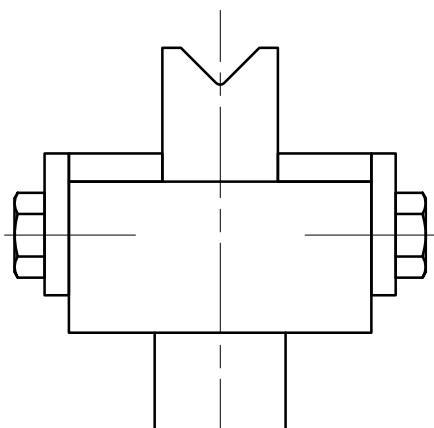
*Avec modification  
de la hauteur  
(standard modifié)*



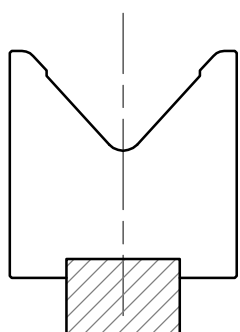
*Sans modification  
de la hauteur  
(fabrication spéciale)*



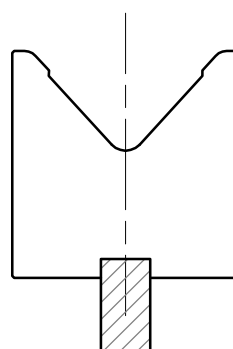
## \* Le bridage des matrices



## \* Exemples d'adaptations de matrices standards sur différentes presses



*Rajout d'un talon  
largeur 30 pour  
adaptation sur  
colly*

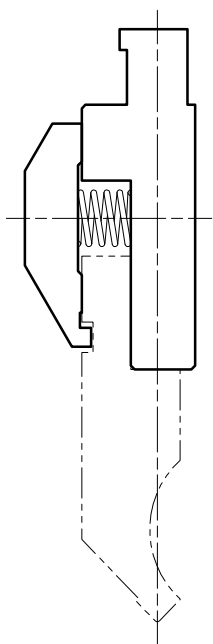


*Rajout d'un talon  
largeur 13 pour  
adaptation sur  
beyeler ou trumpf*

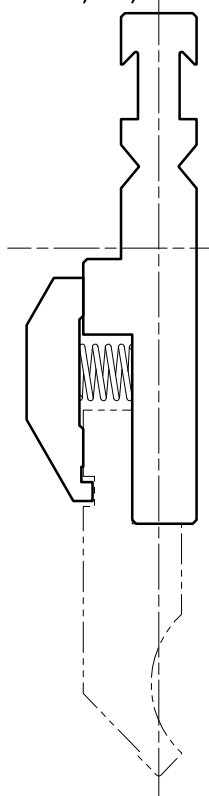
# Adaptateurs pour lames type AMADA

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

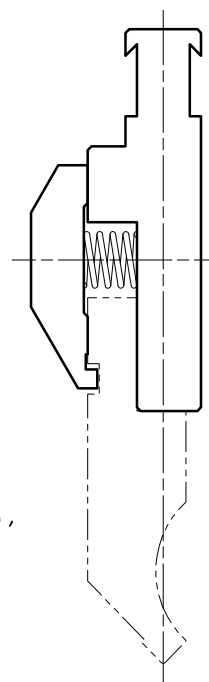
Attache **COLLY**  
nez de 13,5, 16



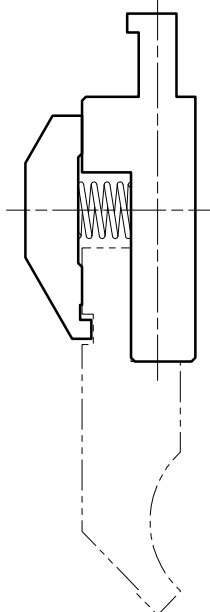
Attache **BEYELER** type  
R, RF, RF-A, S



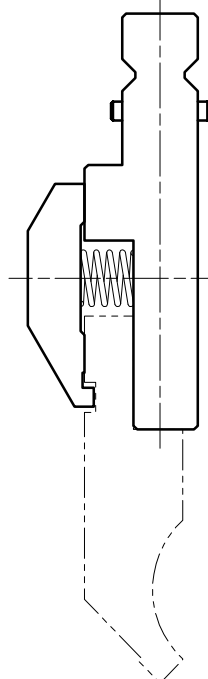
Attache **PERROT**



Attache **LVD**  
nez de 10, 15

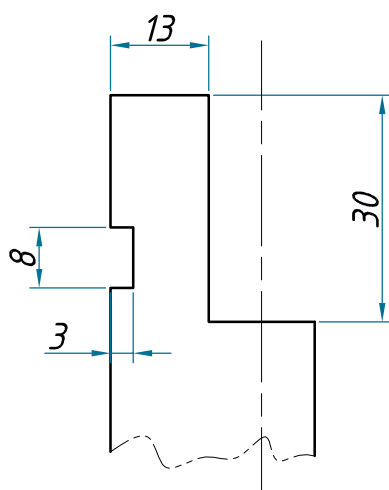


Attache **WILA, TRUMPF**

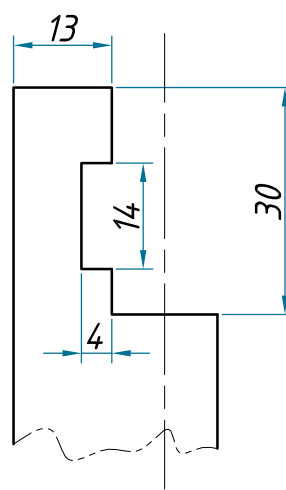


## Attache

Modèle **AMADA**



Modèle **EURO**

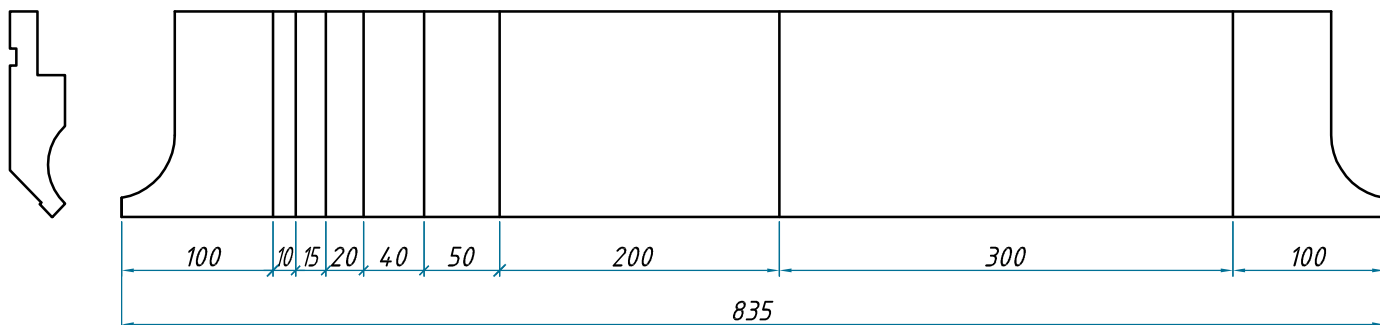


# AMADA Typ 90°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

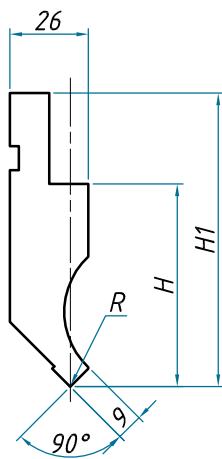
*Les lames Amada typ sont disponibles  
en long. 415, 835 et 805/835 fractionnée*

## Détail du fractionnement standard 835mm



### 10.10/90°

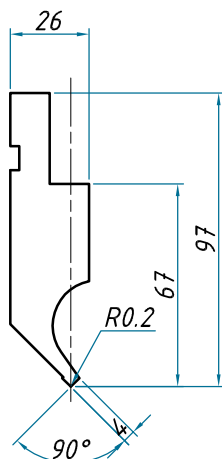
100T/m



R	H	H1
0.2	67	97
0.8	66.7	96.7

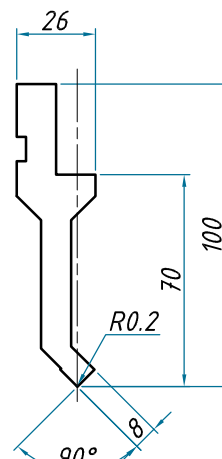
### 10.116/90°

15T/m



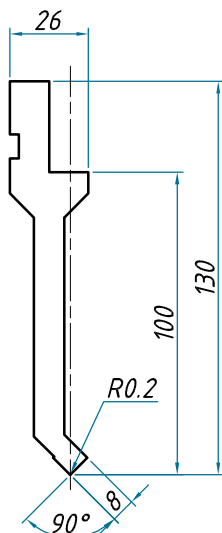
### 10.201/90°

30T/m



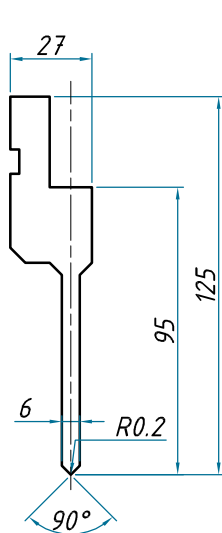
### 10.203/90°

30T/m



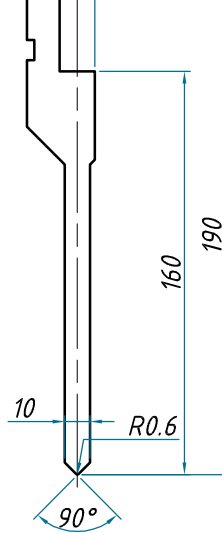
### 10.108/90°

50T/m



### 10.110/90°

50T/m

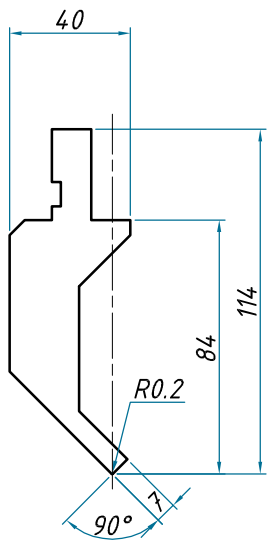


# AMADA Typ 90°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

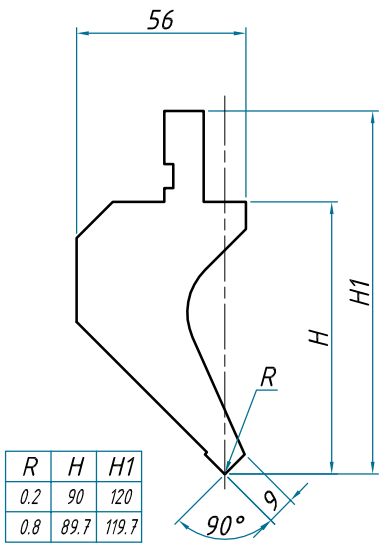
10.16/90°

15T/m



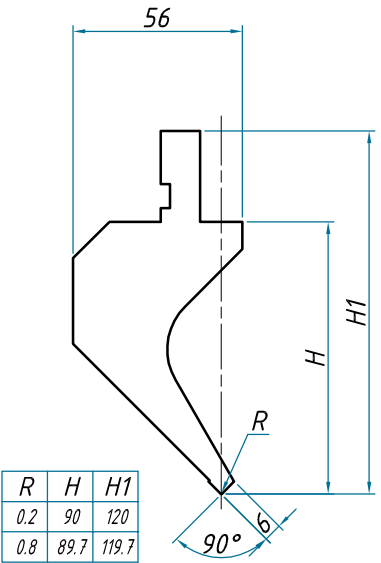
10.14/90°

70T/m



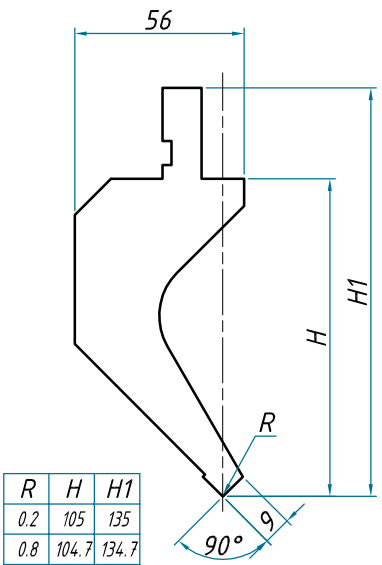
10.146/90°

50T/m



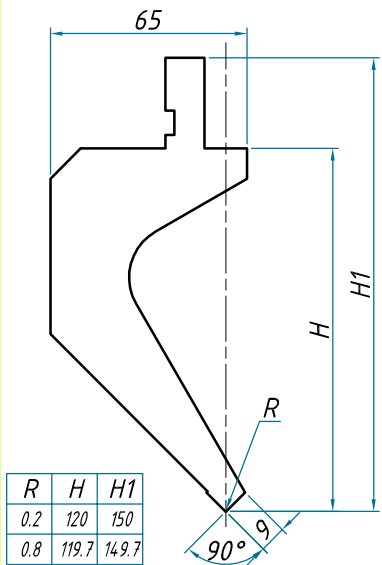
10.15/90°

50T/m



10.048/90°

50T/m



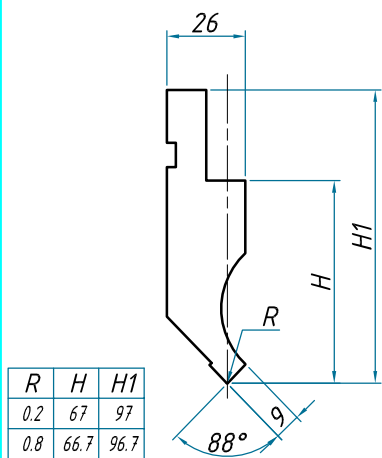
PHOTO

# AMADA Typ 88°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

## 10.10/88°

100T/m

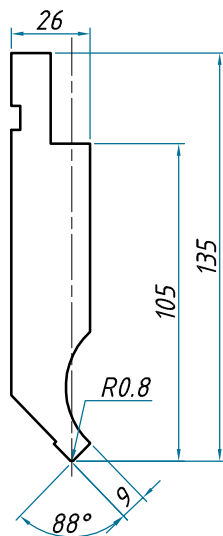


R	H	H1
0.2	67	97
0.8	66.7	96.7
3	65.7	95.7

Existe aussi en 85°

## 10.10 - 10.39

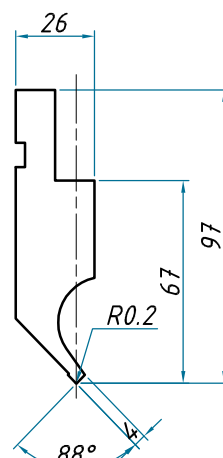
100T/m



Existe aussi en 85°

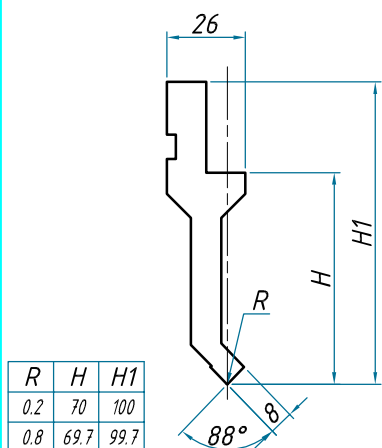
## 10.116/88°

15T/m



## 10.200/88°

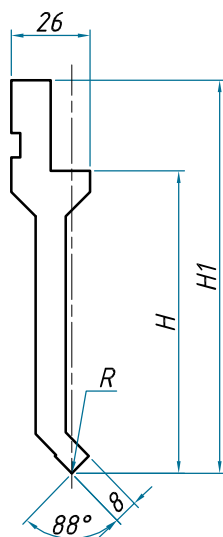
30T/m



R	H	H1
0.2	70	100
0.8	69.7	99.7

## 10.202/88°

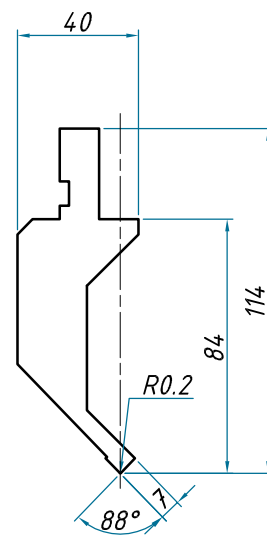
30T/m



R	H	H1
0.2	100	130
0.8	99.7	129.7

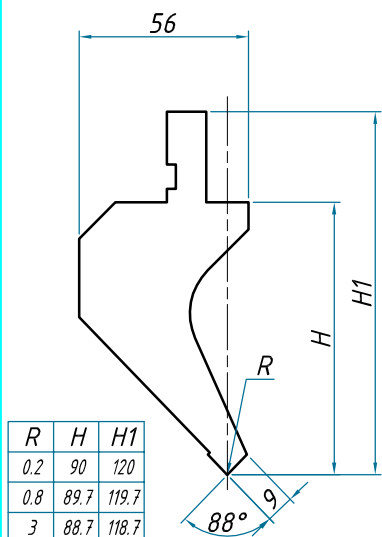
## 10.16/88°

15T/m



## 10.14/88°

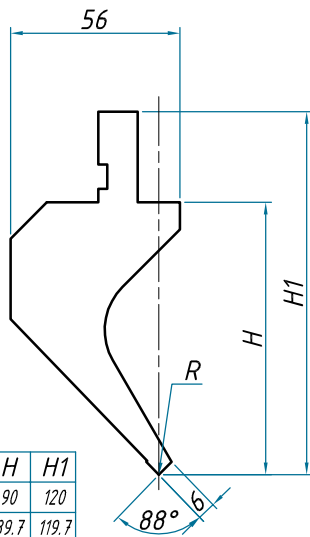
70T/m



R	H	H1
0.2	90	120
0.8	89.7	119.7
3	88.7	118.7

## 10.146/88°

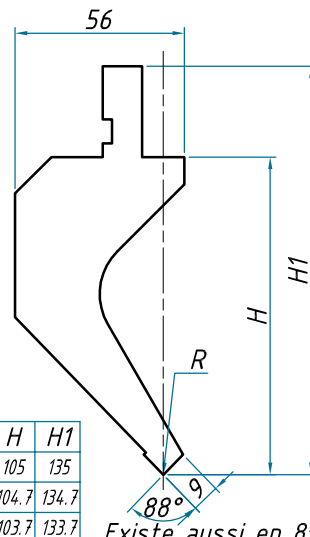
50T/m



R	H	H1
0.2	90	120
0.8	89.7	119.7

## 10.15/88°

50T/m



R	H	H1
0.2	105	135
0.8	104.7	134.7
3	103.7	133.7

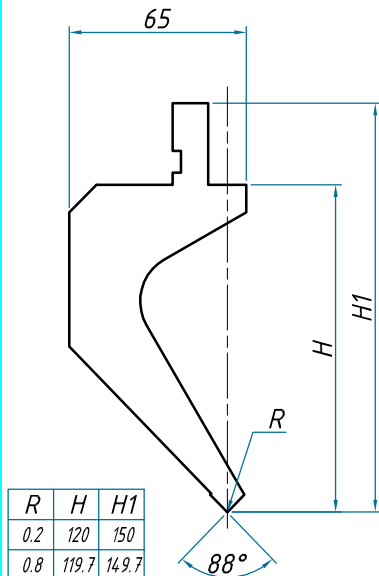
Existe aussi en 85°

# AMADA Typ 88°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

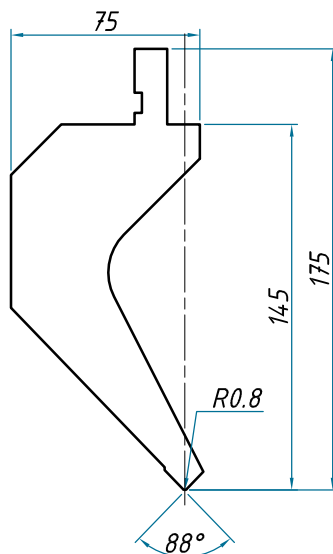
**10.047/88°**

50T/m



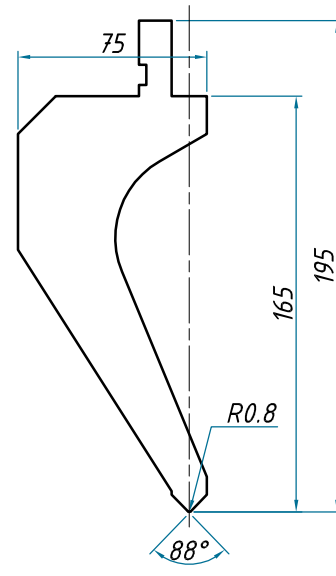
**10.050/88°**

80T/m



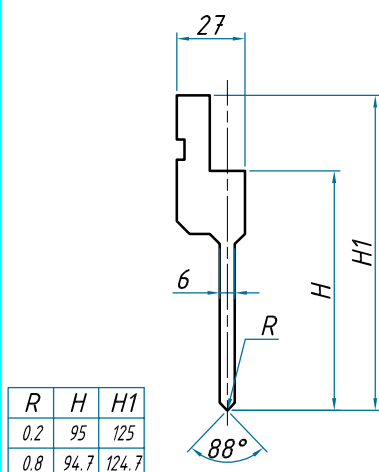
**10.065/88°**

60T/m



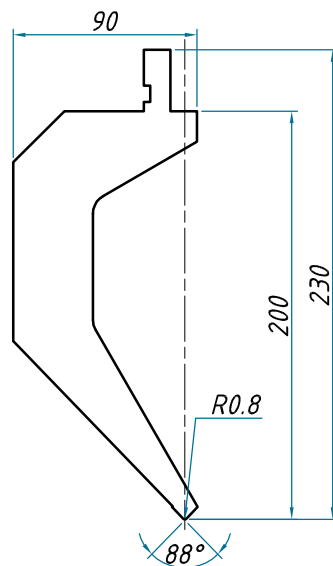
**10.109/88°**

50T/m



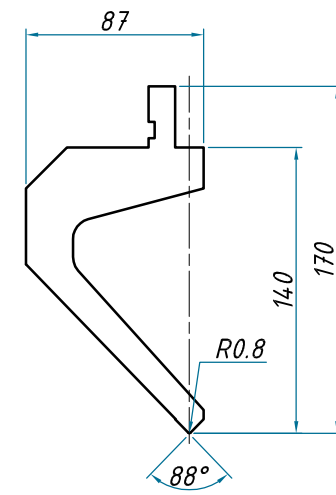
**10.291/88°**

85T/m

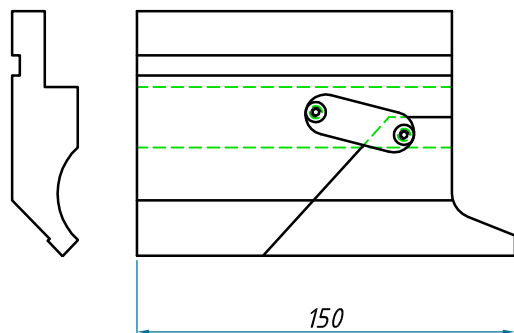


**10.090/88°**

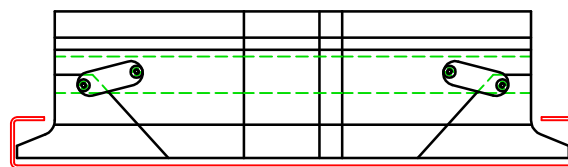
18T/m



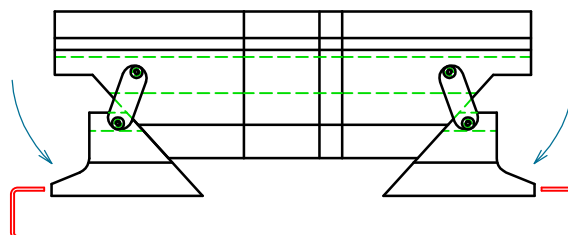
## Bigornes mobiles



En position  
haute pour  
le pliage



En position  
basse pour  
sortir la pièce

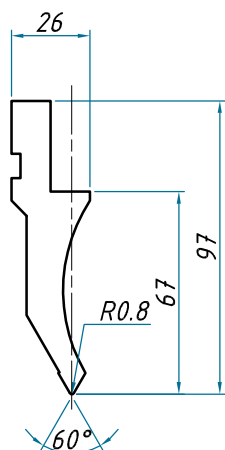


# AMADA Typ 60°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

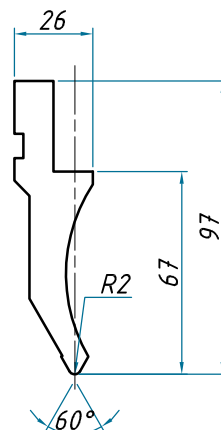
**10.18/60°**

50T/m



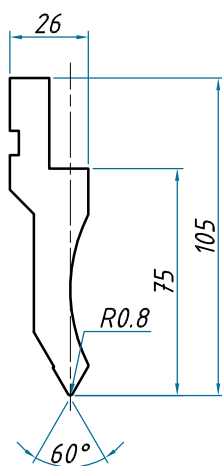
**10.19/60°**

50T/m



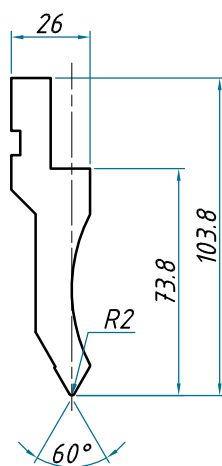
**10.20/60°-R0.8**

70T/m



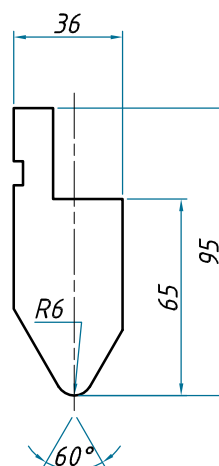
**10.20/60°-R2**

70T/m



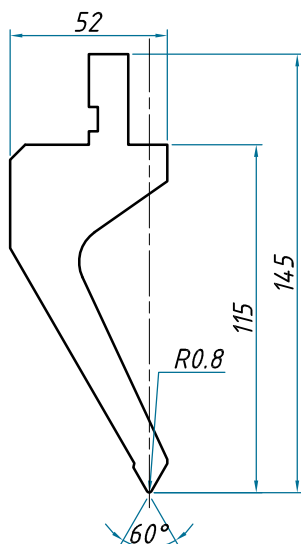
**10.13/60°**

100T/m



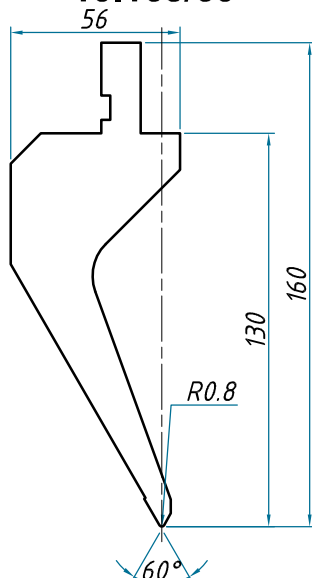
**10.272/60°**

40T/m



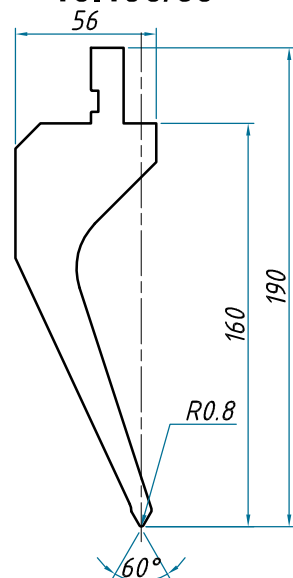
**10.163/60°**

40T/m



**10.190/60°**

40T/m

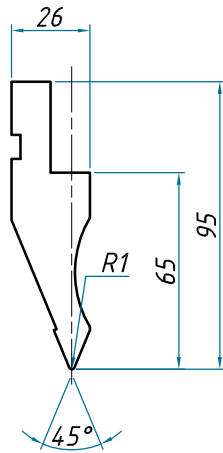


# AMADA Typ 45° 35°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

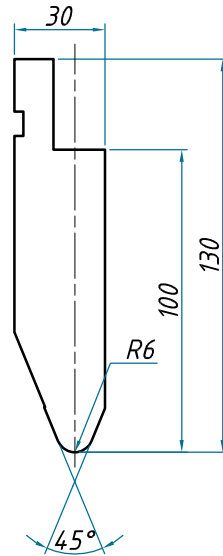
**10.11/45°**

70T/m



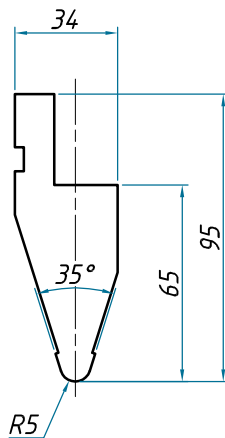
**10.253/45°**

100T/m



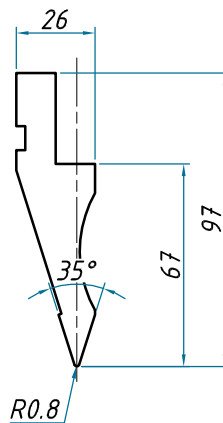
**10.13/35°**

100T/m



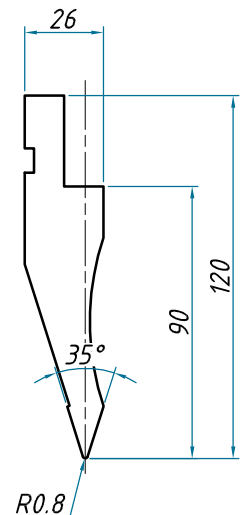
**10.11/35°**

50T/m



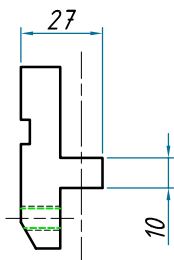
**10.12/35°**

50T/m



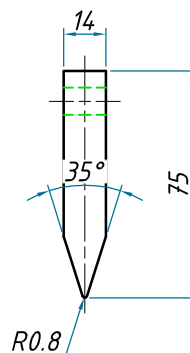
**40.08**

50T/m



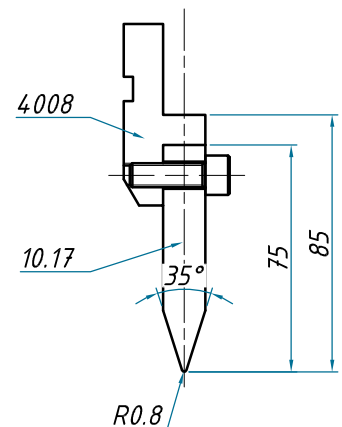
**10.17/35°**

50T/m



**40.08 + 10.17**

50T/m



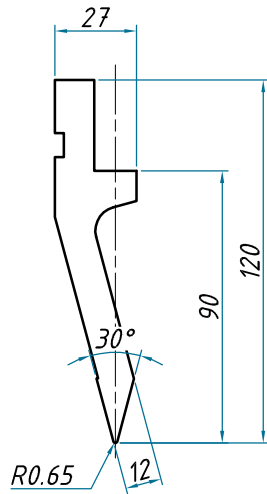


# AMADA Typ 30° 26°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

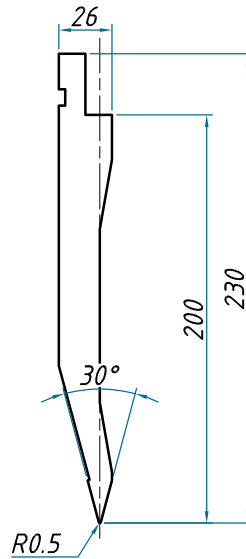
**10.061/30°**

40T/m



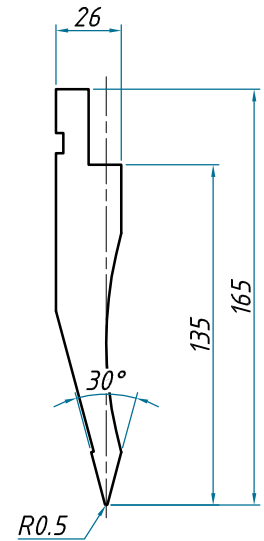
**10.292/30°**

50T/m



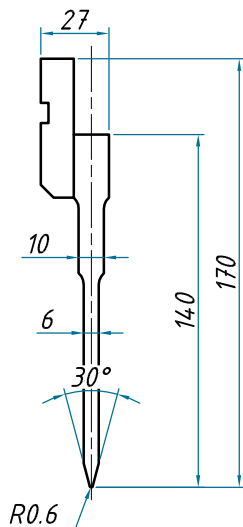
**10.211/30°**

50T/m



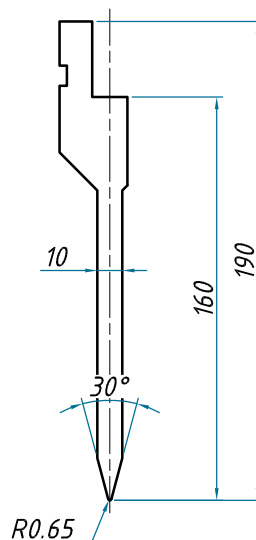
**10.086/30°**

40T/m



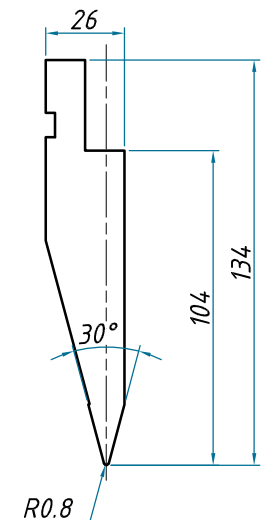
**10.088/30°**

50T/m



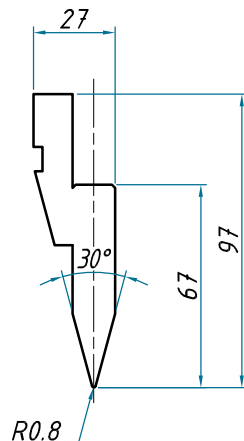
**10.210/30°**

100T/m



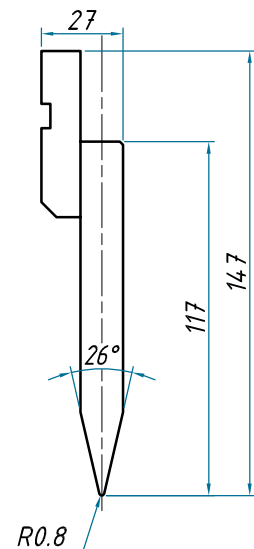
**10.103/30°**

50T/m



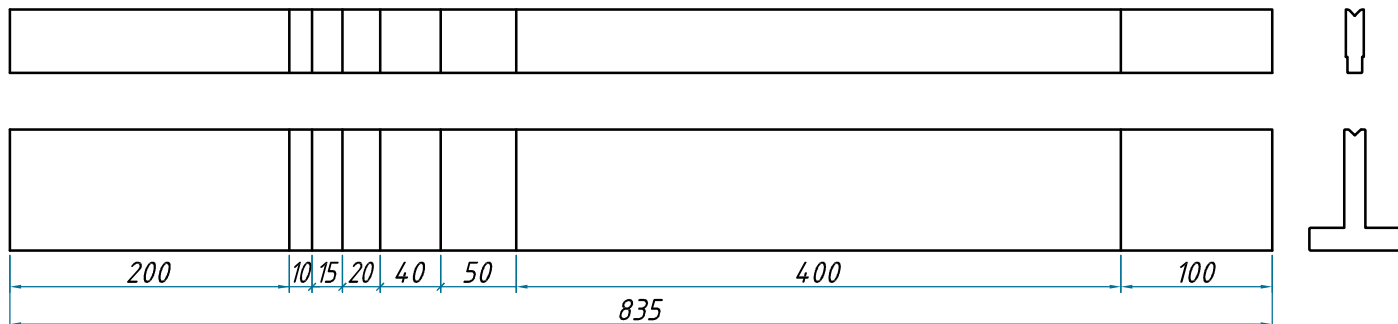
**10.18/26°**

50T/m



*Les matrices Amada typ sont disponibles  
en long. 415, 835 et 805/835 fractionnée*

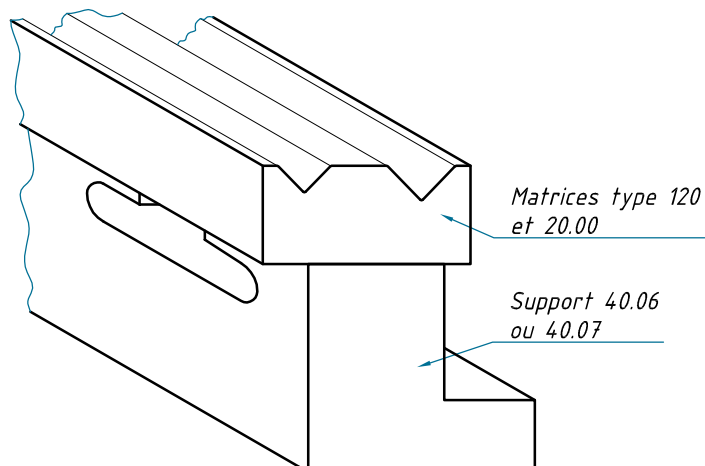
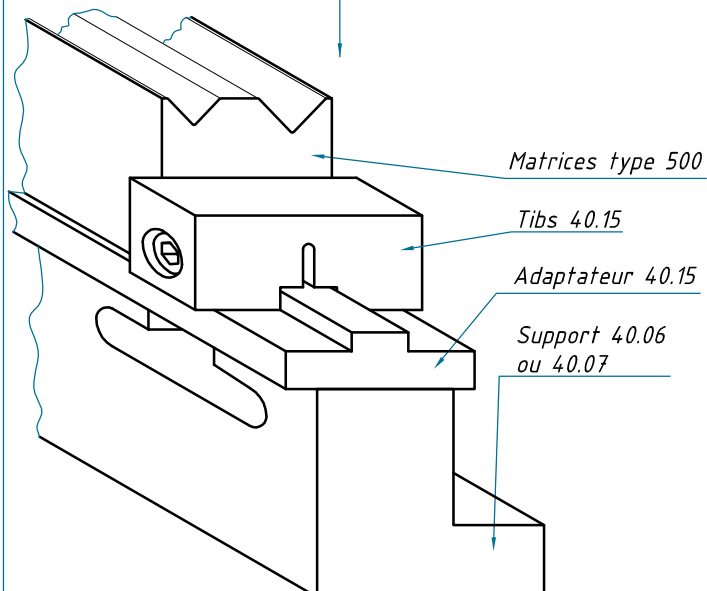
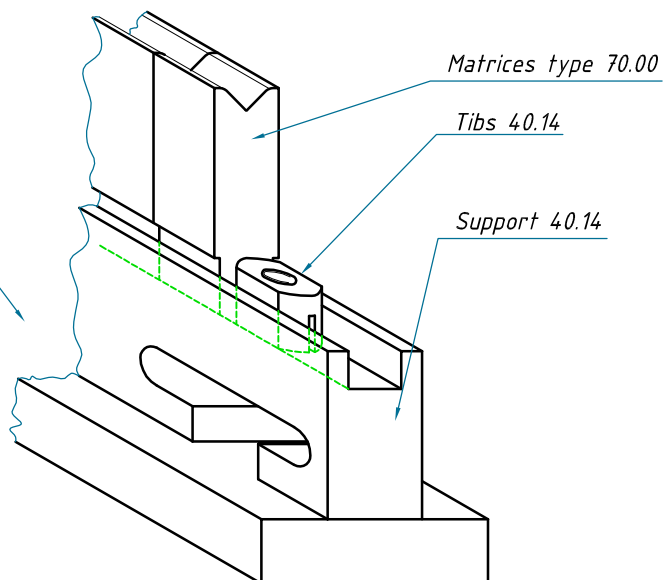
## Détail du fractionnement standard 835mm



*Les matrices type 70.00 sont posées dans  
le support 40.14, les éléments fractionnés  
peuvent être maintenus à l'aide de Tibs*

*Les matrices type 120 et 20.00 sont  
vissées sur un support 40.06 ou 40.07*

*Les matrices type 500 sont posées sur  
l'adaptateur 40.15 qui est vissé sur un  
support 40.06 ou 40.07, les éléments  
fractionnés peuvent être maintenus  
à l'aide de Tibs*

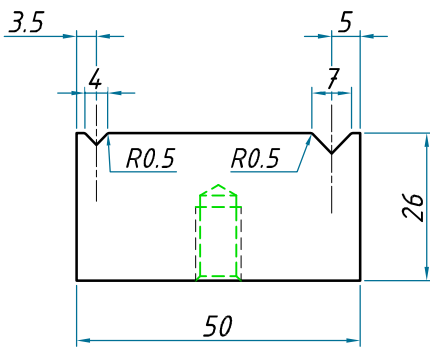


# AMADA Typ 90°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

**121/90°**

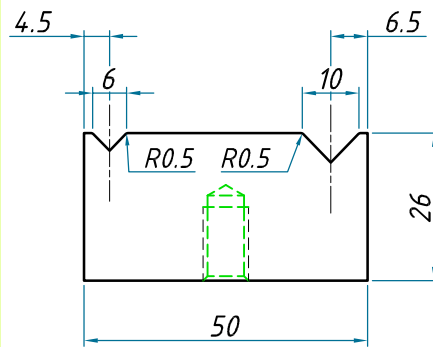
60T/m



*Les vés sont à 90°*

**123/90°**

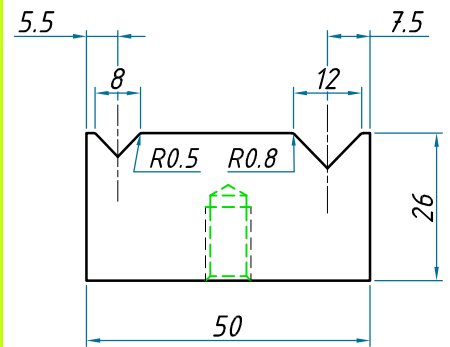
70T/m



*Les vés sont à 90°*

**124/90°**

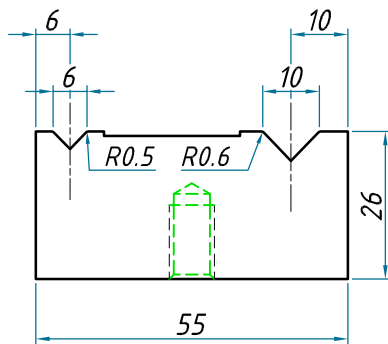
80T/m



*Les vés sont à 90°*

**2012/90°**

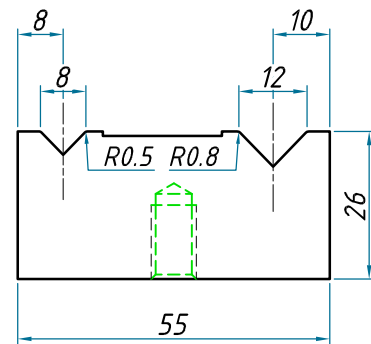
80T/m



*Les vés sont à 90°*

**2013/90°**

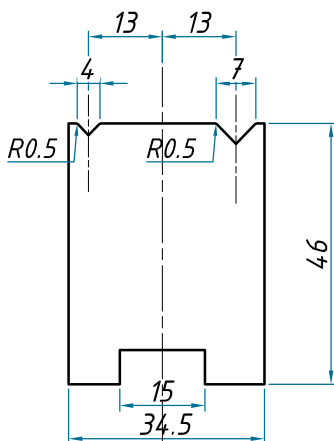
80T/m



*Les vés sont à 90°*

**501/90°**

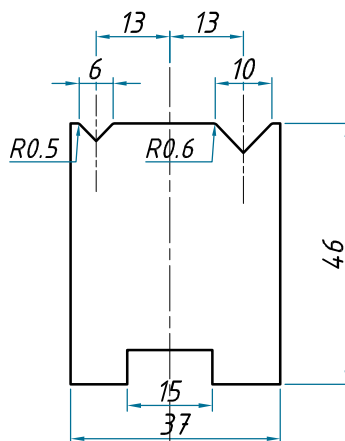
60T/m



*Les vés sont à 90°*

**502/90°**

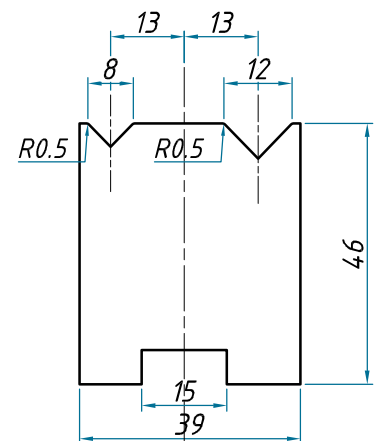
70T/m



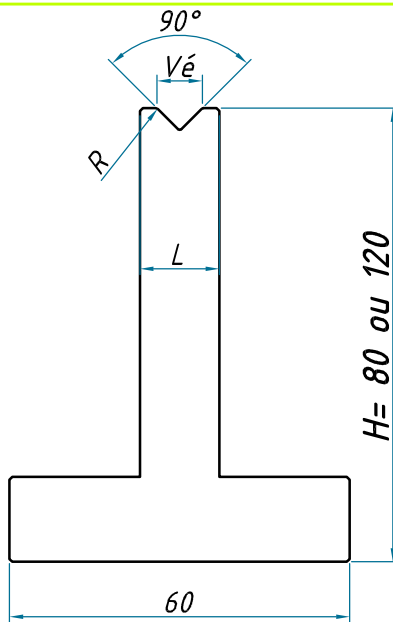
*Les vés sont à 90°*

**503/90°**

70T/m

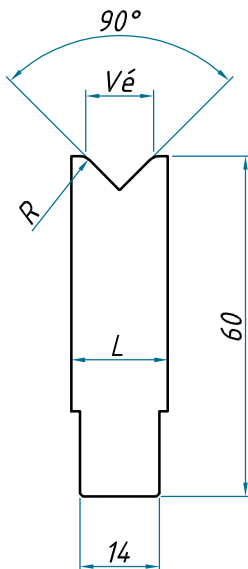


*Les vés sont à 90°*



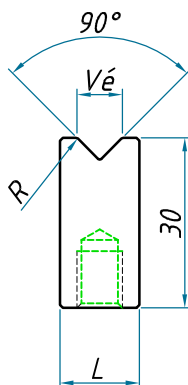
Modèle	Vé	R	L	F' maxi
<b>20.41/90°</b>	<b>6</b>	R0.5	<b>14</b>	95T/m
<b>20.42/90°</b>	<b>8</b>	R0.5	<b>14</b>	95T/m
<b>20.43/90°</b>	<b>10</b>	R0.6	<b>18</b>	95T/m
<b>20.44/90°</b>	<b>12</b>	R0.8	<b>18</b>	95T/m

Ces matrices sont disponibles en hauteur 80 ou 120



Modèle	Vé	R	L	F' maxi
<b>70.90°</b>	<b>6</b>	R1.5	<b>14</b>	95T/m
<b>71.90°</b>	<b>8</b>	R1.5	<b>14</b>	95T/m
<b>73.90°</b>	<b>10</b>	R2	<b>15</b>	95T/m
<b>75.90°</b>	<b>12</b>	R2.5	<b>17</b>	95T/m

Matrices à utiliser avec support type 40.14



Modèle	Vé	R	L	F' maxi
<b>320/90°</b>	<b>6</b>	R1.5	<b>14</b>	95T/m
<b>321/90°</b>	<b>8</b>	R1.5	<b>14</b>	95T/m
<b>323/90°</b>	<b>10</b>	R2	<b>15</b>	95T/m
<b>324/90°</b>	<b>12</b>	R2.5	<b>17</b>	95T/m

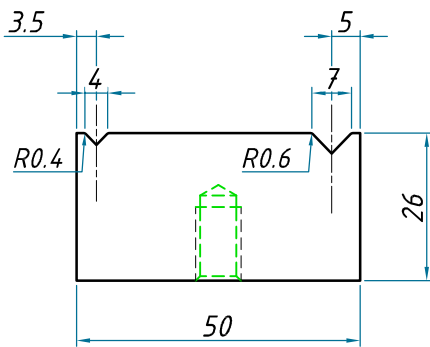
Matrices à utiliser avec support type 330

# AMADA Typ 88°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

**121/88°**

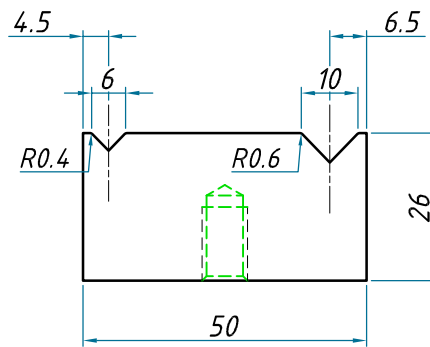
60T/m



*Les vés sont à 88°*

**123/88°**

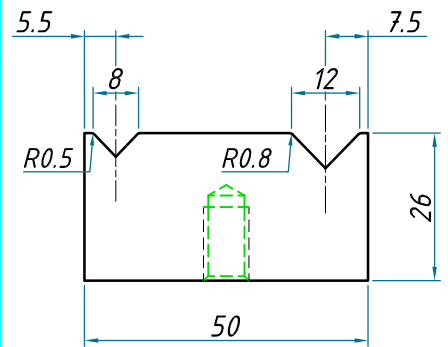
70T/m



*Les vés sont à 88°*

**124/88°**

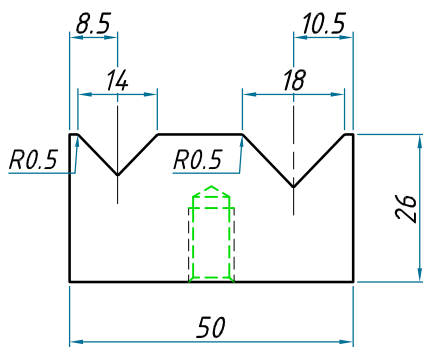
80T/m



*Les vés sont à 88°*

**125/88°**

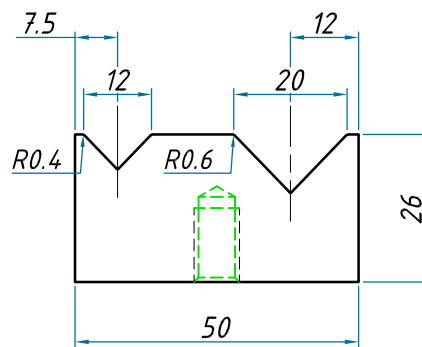
100T/m



*Les vés sont à 88°*

**126/88°**

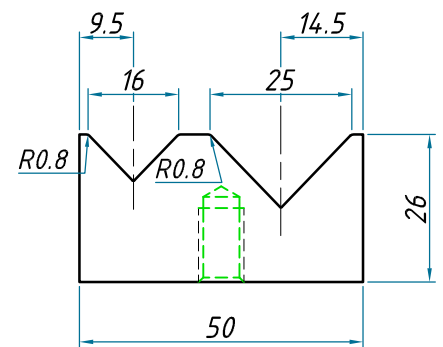
100T/m



*Les vés sont à 88°*

**127/88°**

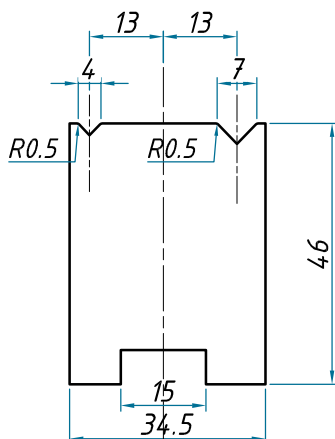
70T/m



*Les vés sont à 88°*

**501/88°**

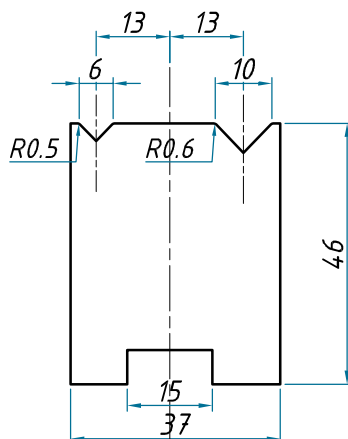
60T/m



*Les vés sont à 88°*

**502/88°**

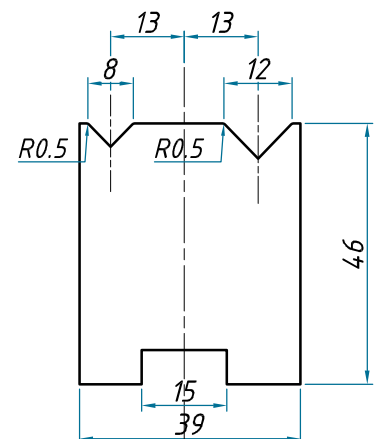
70T/m



*Les vés sont à 88°*

**503/88°**

70T/m



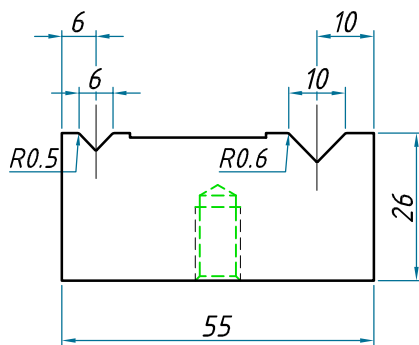
*Les vés sont à 88°*

# AMADA Typ 88°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

**2012/88°**

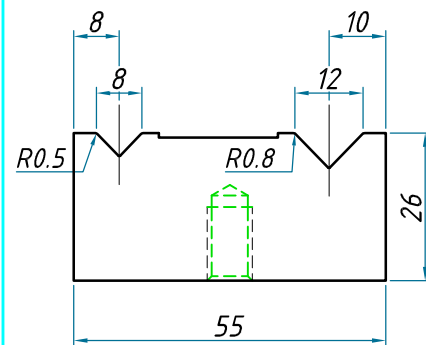
80T/m



*Les vés sont à 88°*

**2013/88°**

80T/m

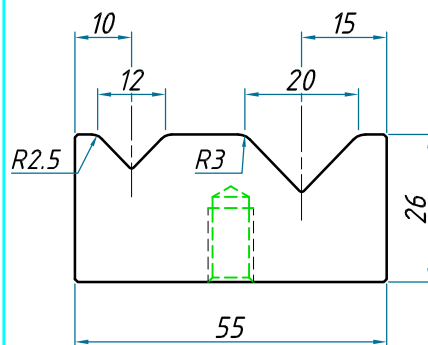


*Les vés sont à 88°*

*Toutes les règles à deux vés sont fournies sans visserie, laquelle est livrée avec les supports 40.06/40.07 ou en supplément*

**2014/88°**

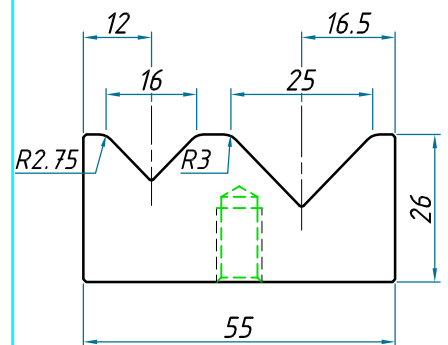
100T/m



*Les vés sont à 88°*

**2015/88°**

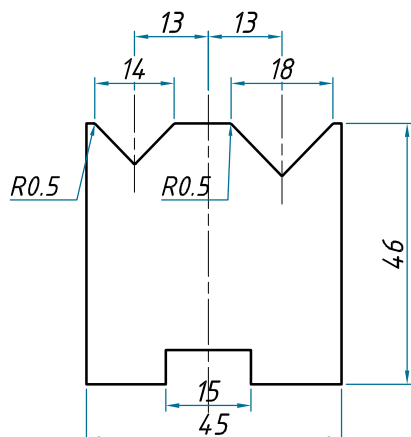
100T/m



*Les vés sont à 88°*

**504/88°**

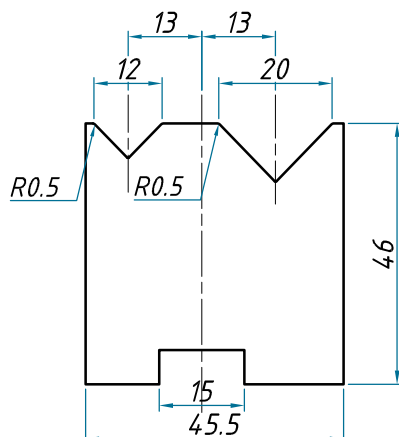
100T/m



*Les vés sont à 88°*

**505/88°**

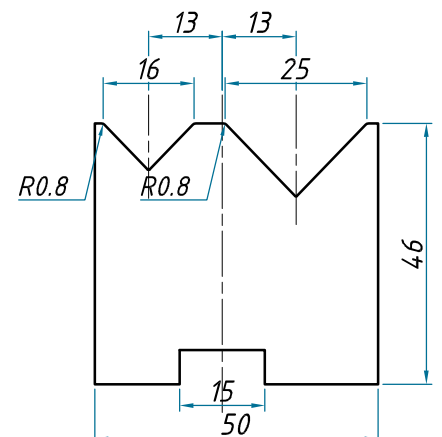
100T/m



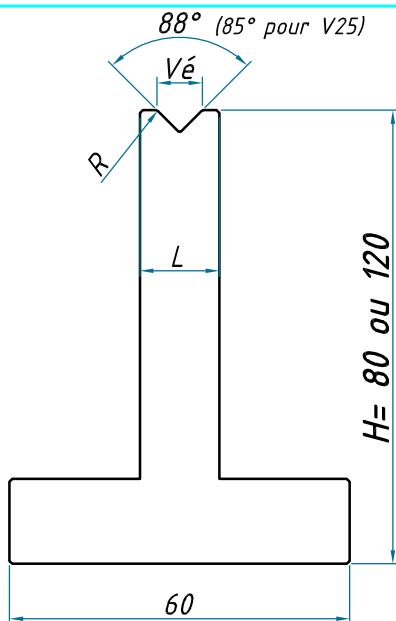
*Les vés sont à 88°*

**506/88°**

100T/m

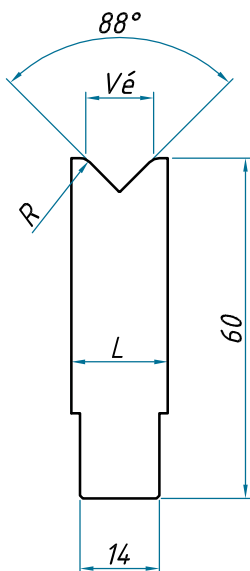


*Les vés sont à 88°*



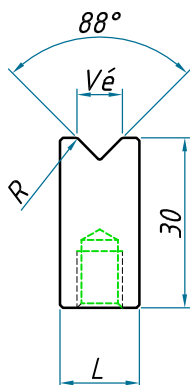
Modèle	Vé	R	L	F' maxi
20.42/88°	8	R0.5	14	95T/m
20.43/88°	10	R0.6	18	95T/m
20.44/88°	12	R0.8	18	95T/m
20.45/88°	16	R2.5	24	95T/m
20.46/88°	20	R3	30	95T/m
20.47/85°	25	R3	35	100T/m

Ces matrices sont disponibles en hauteur 80 ou 120



Modèle	Vé	R	L	F' maxi
70.88°	6	R1.5	14	95T/m
71.88°	8	R1.5	14	95T/m
72.88°	10	R2	15	95T/m
74.88°	12	R2.5	17	95T/m
76.88°	14	R2.5	18	95T/m
77.88°	16	R2.5	24	95T/m
78.88°	18	R2.5	28	95T/m
79.88°	20	R3	30	95T/m
80.88°	25	R3	35	95T/m

Matrices à utiliser avec support type 40.14

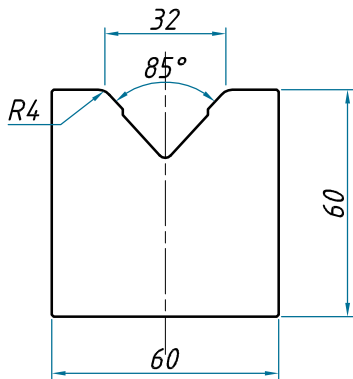


Modèle	Vé	R	L	F' maxi
320/88°	6	R1.5	14	95T/m
321/88°	8	R1.5	14	95T/m
322/88°	10	R2	15	95T/m
326/88°	12	R2.5	17	95T/m
325/88°	14	R2.5	18	95T/m

Matrices à utiliser avec support type 330

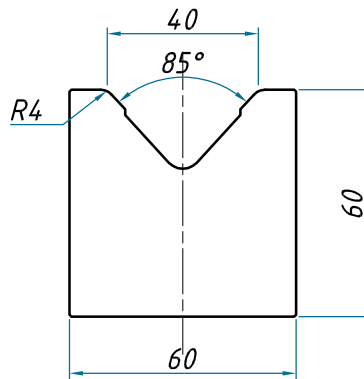
**20.11/32**

100T/m



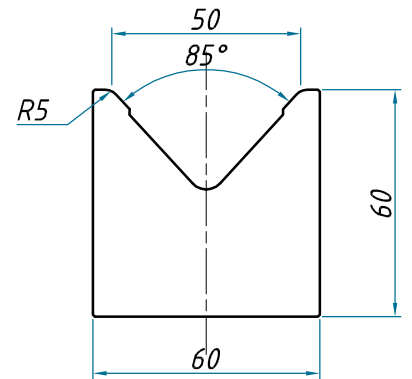
**20.11/40**

100T/m



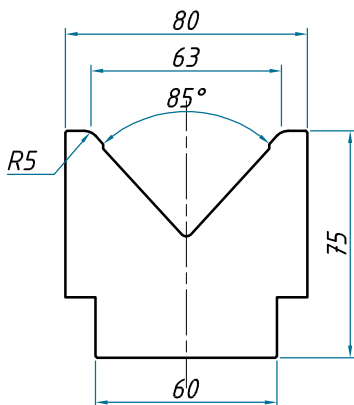
**20.11/50**

100T/m



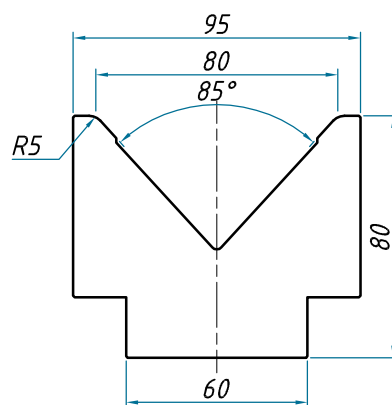
**20.11/63**

100T/m



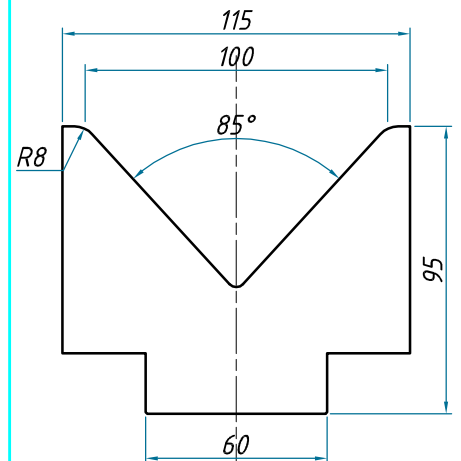
**20.11/80**

100T/m



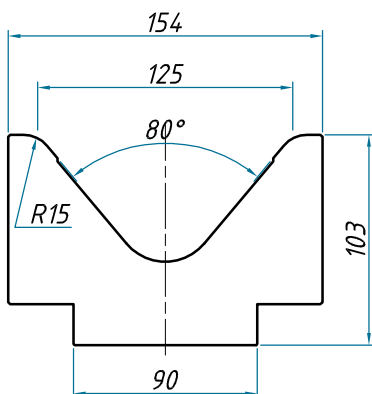
**20.11/100**

100T/m



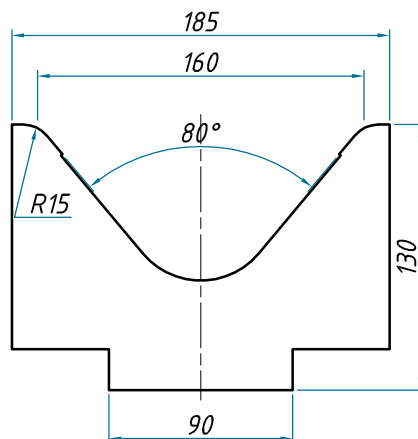
**20.11/125**

100T/m



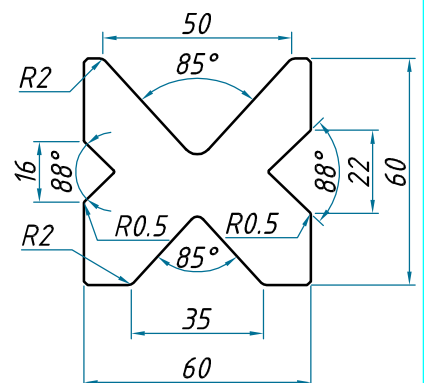
**20.11/160**

100T/m



**20.09**

100T/m



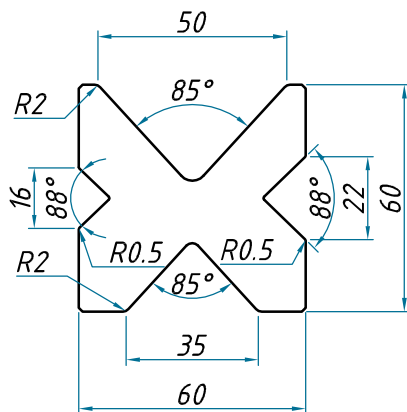


# AMADA Typ multivés

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

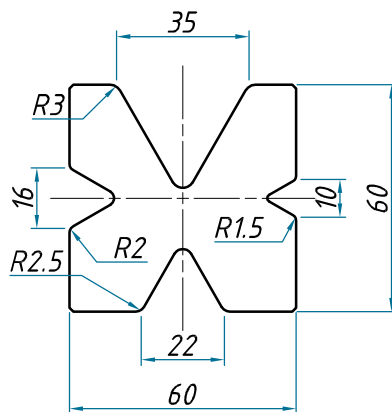
**20.09**

100T/m



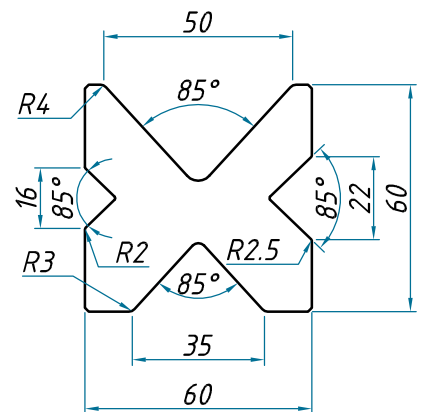
**20.09/60°**

70T/m



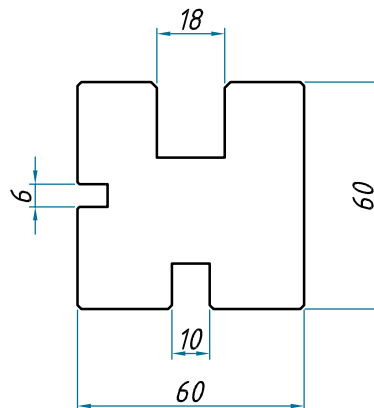
**20.09/85°**

100T/m



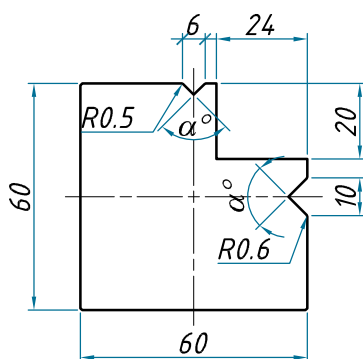
**20.08**

100T/m



**20.16/88°**  
**20.16/90°**

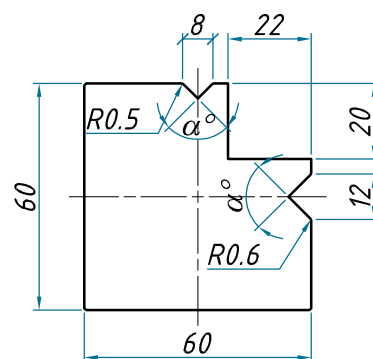
95T/m



Disponible en 88° ou 90°

**20.17/88°**  
**20.17/90°**

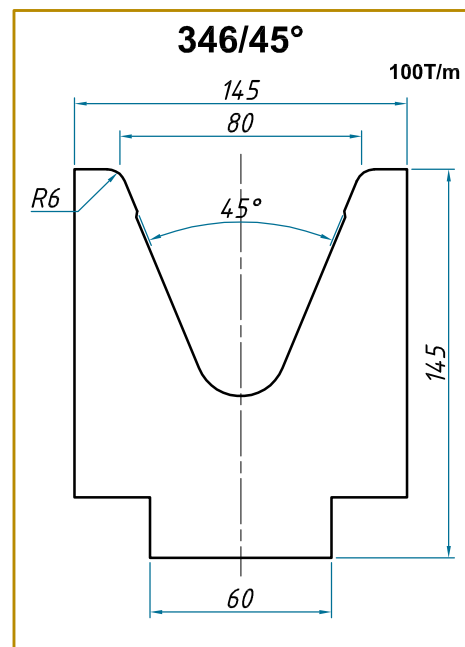
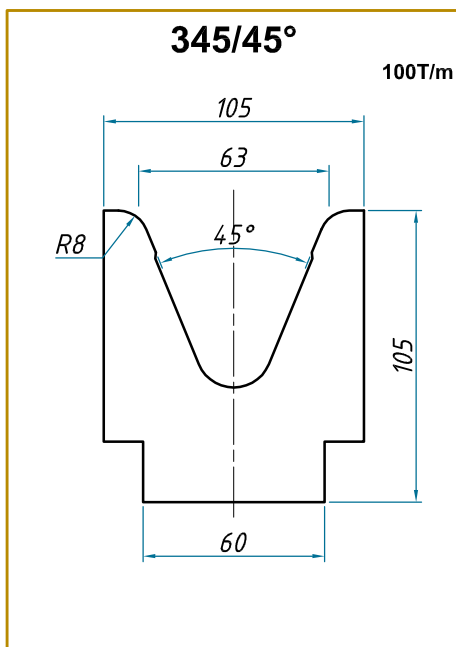
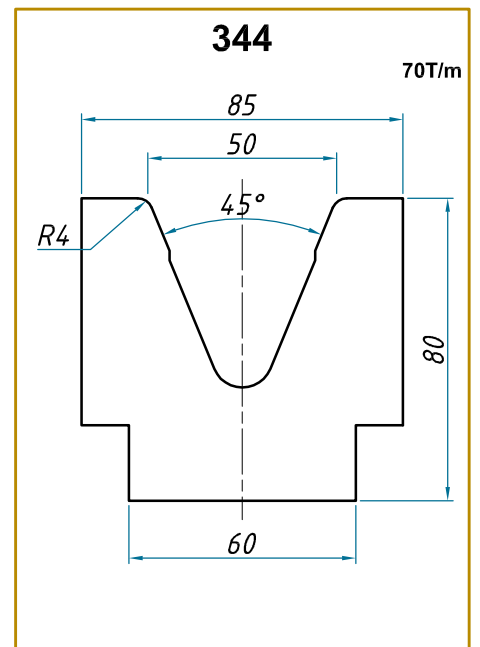
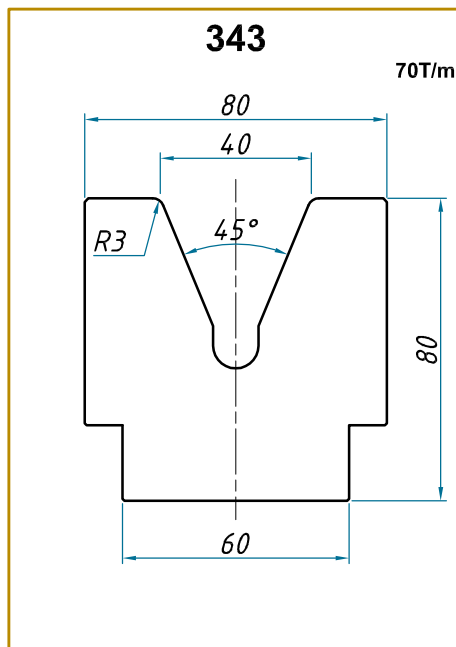
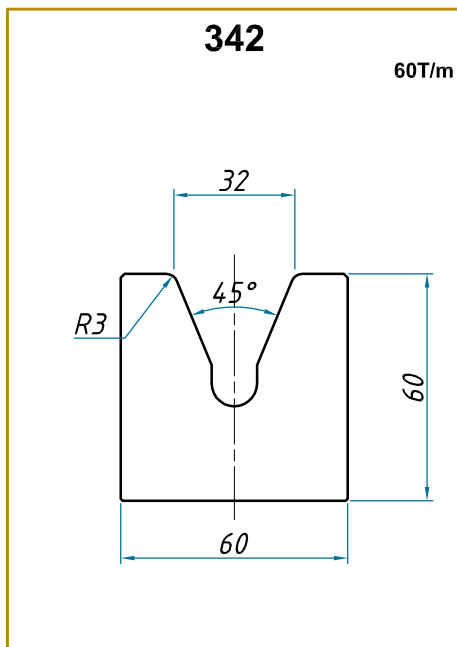
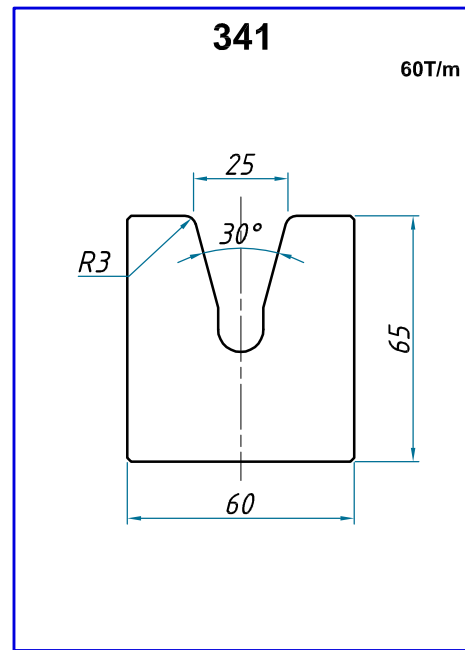
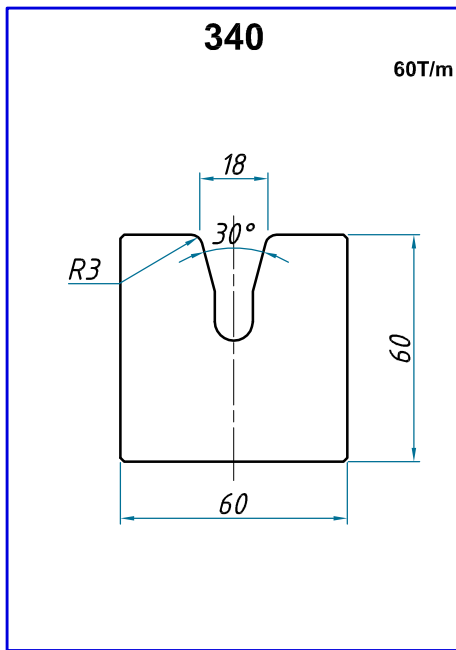
95T/m



Disponible en 88° ou 90°

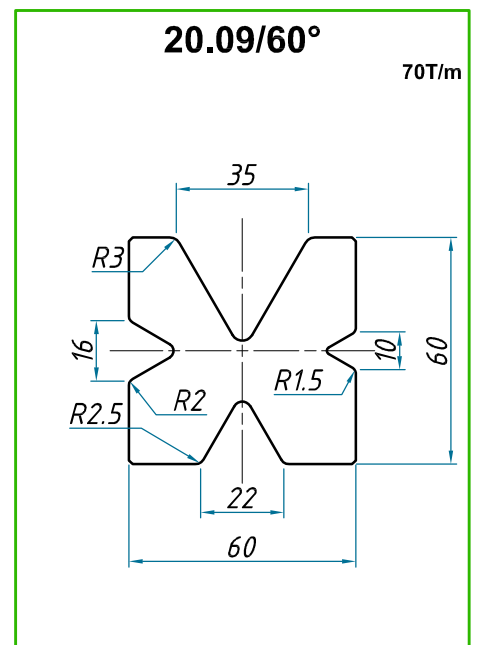
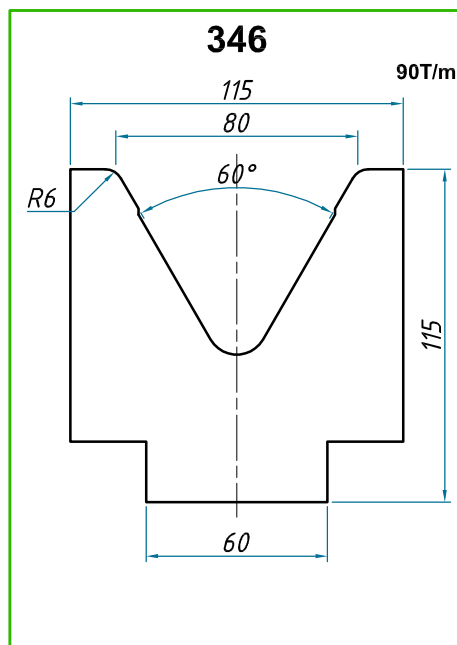
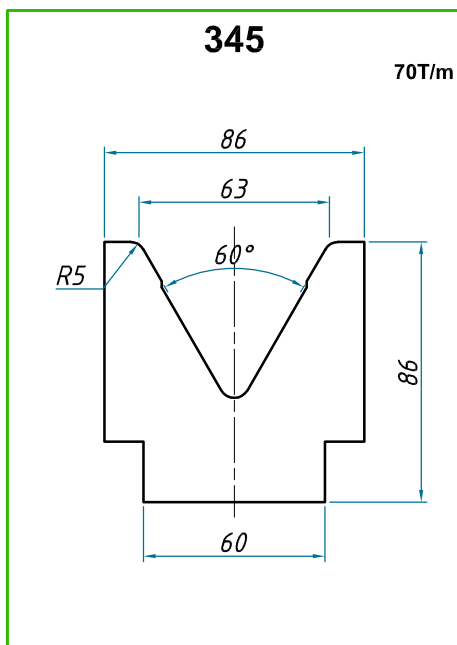
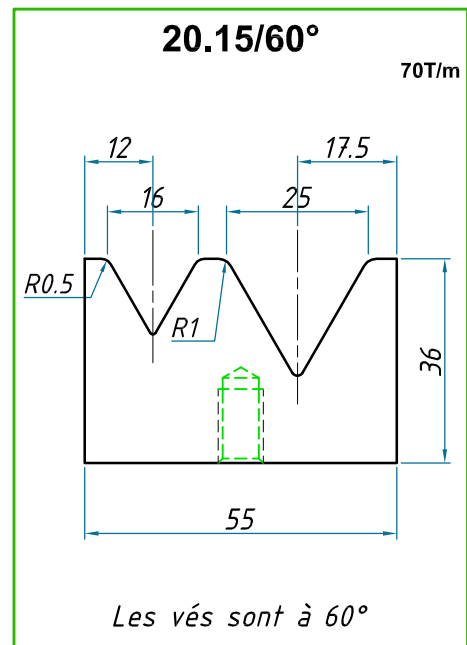
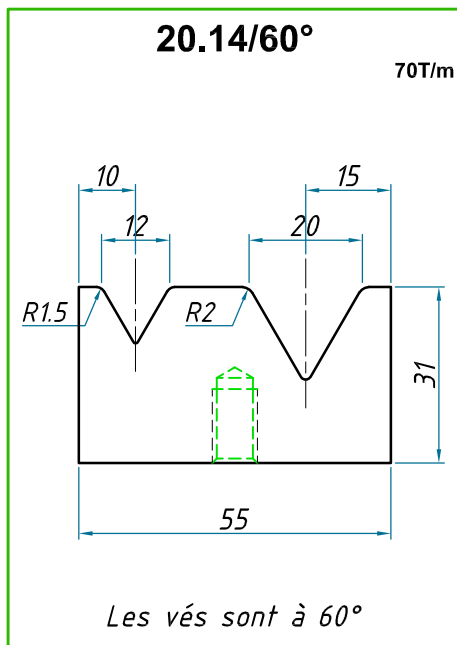
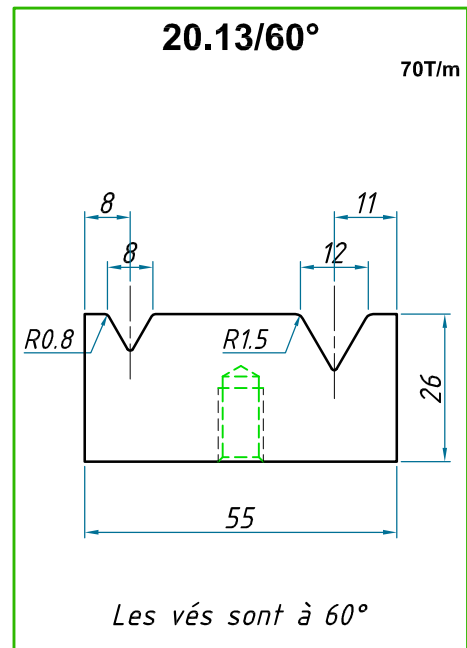
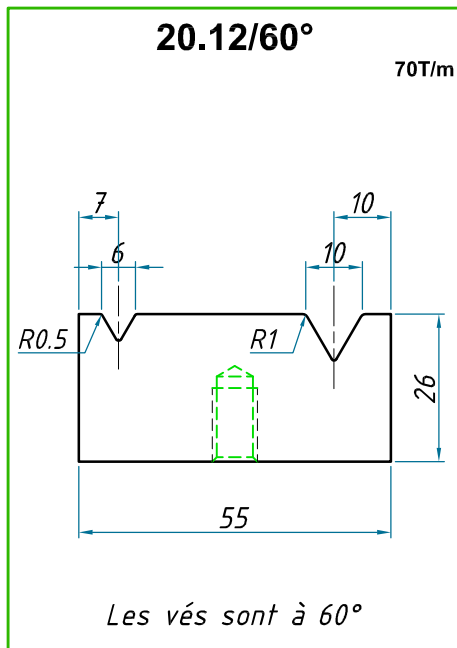
# AMADA Typ 30° 45°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)



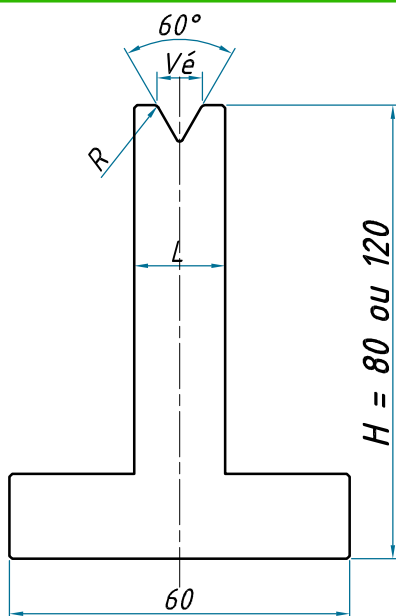
# AMADA Typ 60°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)



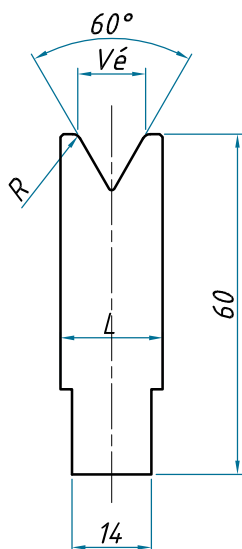
# AMADA Typ 60° 45°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)



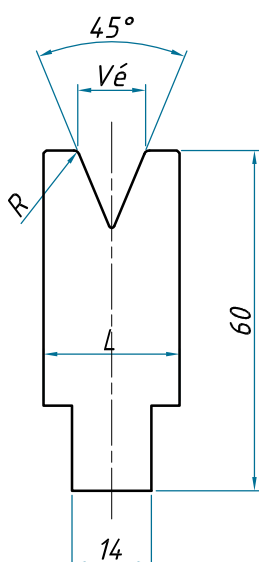
Modèle	Vé	R	L	F' maxi
20.41/60°	6	R0.5	14	60T/m
20.42/60°	8	R0.8	16	70T/m
20.43/60°	10	R1	18	70T/m
20.44/60°	12	R1.5	20	70T/m
20.45/60°	16	R2	26	70T/m
20.46/60°	20	R2	30	70T/m
20.47/60°	25	R3	35	60T/m

Ces matrices sont disponibles en hauteur 80 ou 120



Modèle	Vé	R	L	F' maxi
70.60°	6	R0.5	15	60T/m
71.60°	8	R0.5	16	70T/m
73.60°	10	R1	18	70T/m
75.60°	12	R1.5	18	70T/m
77.60°	16	R2	24	70T/m
78.60°	18	R2	28	70T/m
79.60°	20	R2	30	70T/m
80.60°	25	R3	38	70T/m

Matrices à utiliser avec support type 40.14

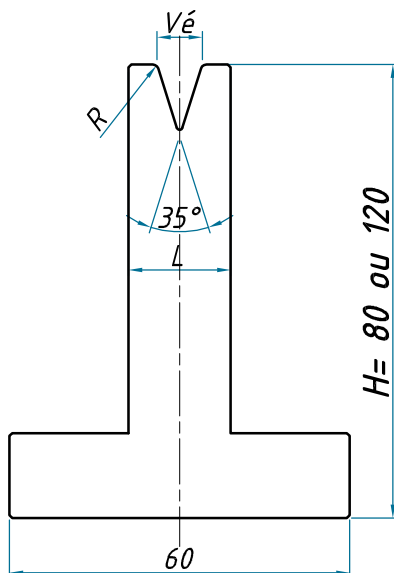
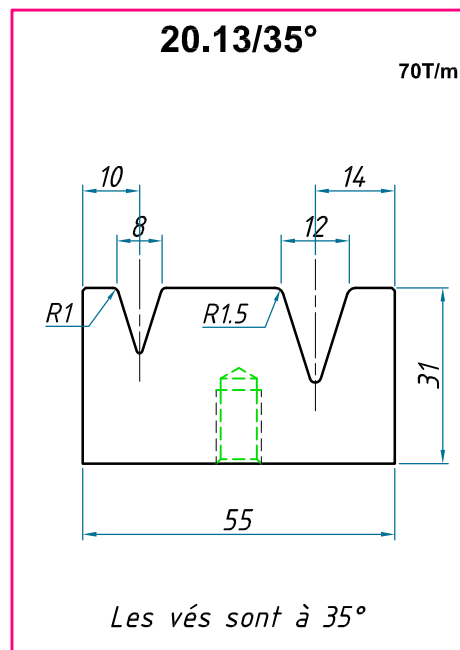
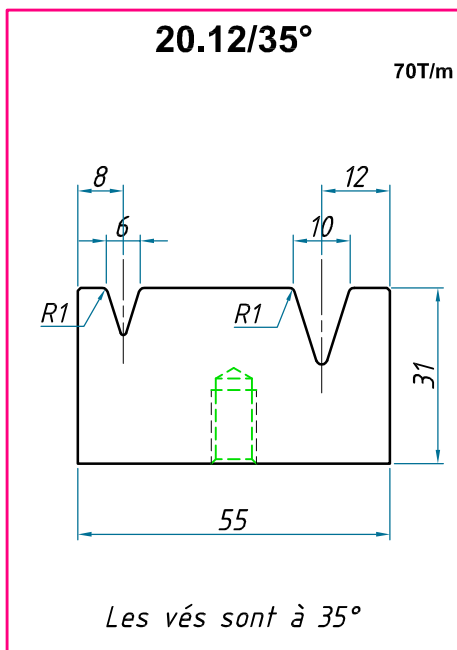


Modèle	Vé	R	L	F' maxi
70.45°	6	R0.8	16	60T/m
71.45°	8	R1	18	70T/m
73.45°	10	R1	20	70T/m
75.45°	12	R1	24	70T/m
77.45°	16	R1.5	28	70T/m
79.45°	20	R2	32	70T/m
80.45°	25	R2.5	40	70T/m

Matrices à utiliser avec support type 40.14

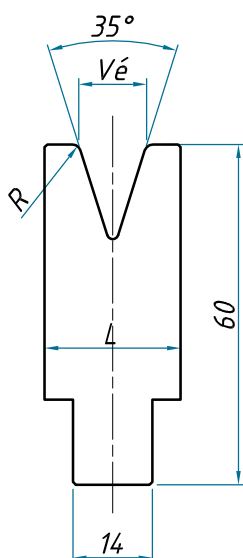
# AMADA Typ 35°

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)



Modèle	Vé	R	L	F' maxi
20.41/35°	6	R1	16	50T/m
20.42/35°	8	R1	18	50T/m
20.43/35°	10	R1	20	50T/m
20.44/35°	12	R1.5	24	50T/m
20.45/35°	16	R2	30	50T/m
20.46/35°	20	R2	35	50T/m
20.47/35°	25	R3	40	60T/m

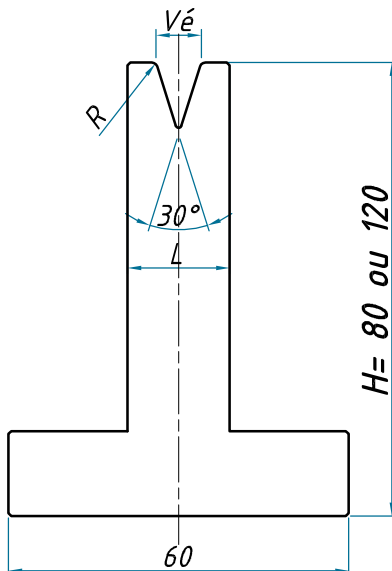
Ces matrices sont disponibles en hauteur 80 ou 120



Modèle	Vé	R	L	F' maxi
70.35°	6	R1	16	50T/m
71.35°	8	R1	18	50T/m
73.35°	10	R1	20	50T/m
75.35°	12	R1.5	24	50T/m
77.35°	16	R2	30	50T/m
79.35°	20	R2	35	50T/m
80.35°	25	R3	40	60T/m

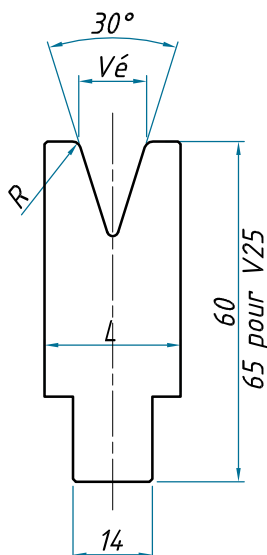
Matrices à utiliser avec support type 40.14

PHOTO



Modèle	Vé	R	L	F' maxi
20.41/30°	6	R1	16	50T/m
20.42/30°	8	R1	18	50T/m
20.43/30°	10	R1	20	50T/m
20.44/30°	12	R1.5	24	50T/m
20.45/30°	16	R2	30	50T/m
20.46/30°	20	R2	35	50T/m
20.47/30°	25	R3	40	50T/m

Ces matrices sont disponibles en hauteur 80 ou 120



Modèle	Vé	R	L	F' maxi
70.30°	6	R0.6	14	35T/m
71.30°	8	R0.8	18	35T/m
73.30°	10	R1	24	50T/m
75.30°	12	R1.5	24	40T/m
77.30°	16	R2	30	45T/m
79.30°	20	R2.5	35	50T/m
80.30°	25	R3	45	50T/m

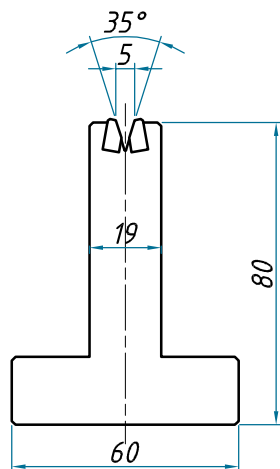
Matrices à utiliser avec support type 40.14

# AMADA Typ 35° Inserts téflons

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

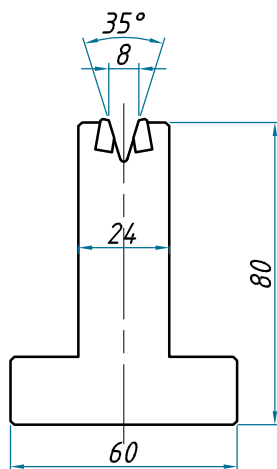
**20.30/35°**

20T/m



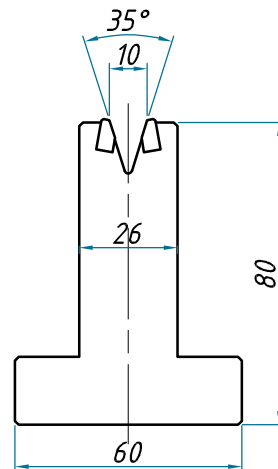
**20.32/35°**

20T/m



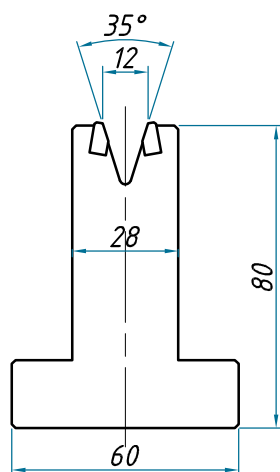
**20.33/35°**

20T/m



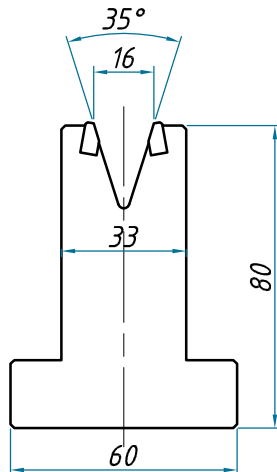
**20.34/35°**

20T/m



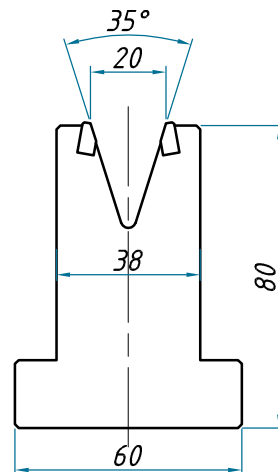
**20.35/35°**

20T/m

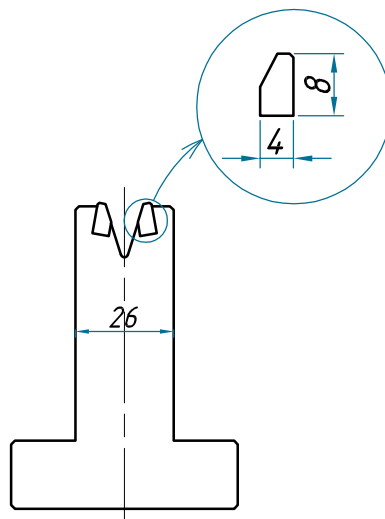


**20.36/35°**

20T/m



**20.30-T**



*Ce type de matrice est utilisé principalement pour plier de la tôle délicate qui doit être sans marquage.*

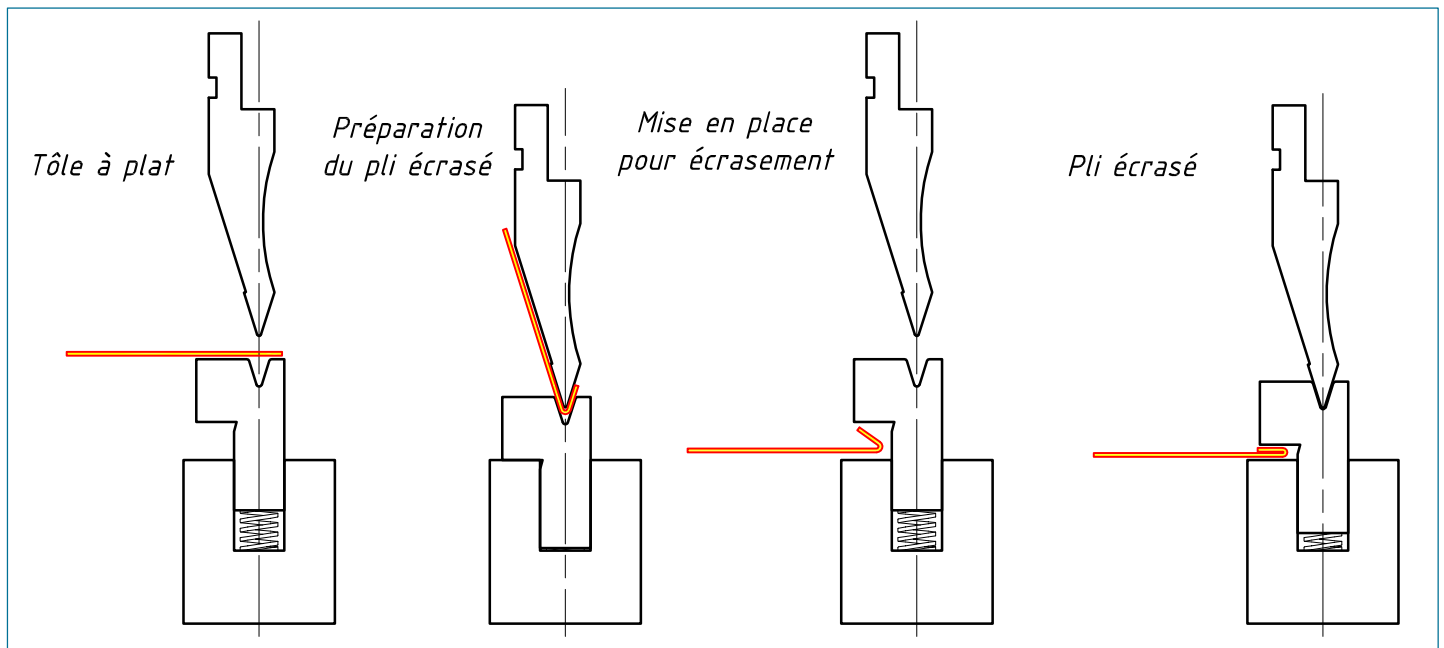
*L'insert en téflon est fourni en pièce de rechange et peut-être remplacé par le client lui-même garantissant des coûts inférieurs et prolongeant la durée de vie de la matrice*

*Ces matrices ont une longueur 835 fractionnée spécifique :  
20 + 25 + 40 + 50 + 100 + 200 + 400*



PHOTO

# AMADA Typ Plis écrasés



notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)



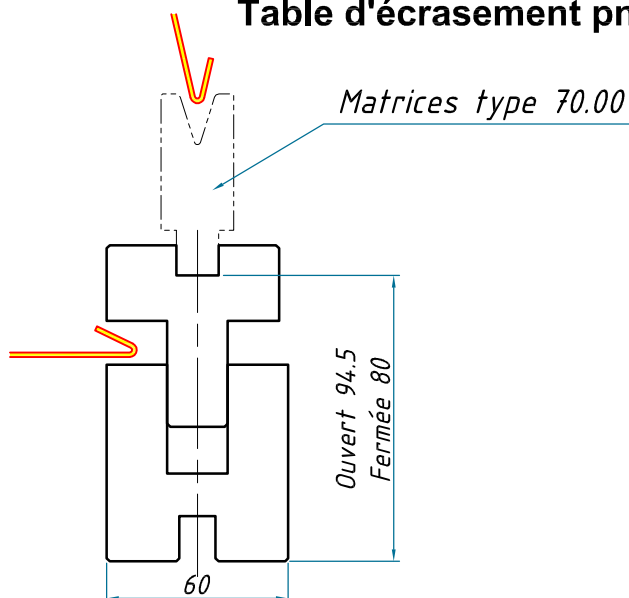
**Acier** ~ 40kg/mm<sup>2</sup>

Épaisseur	 goutte	 jointif
6/10	9T/m	23T/m
8/10	12T/m	32T/m
10/10	15T/m	40T/m
125/100	17T/m	50T/m
15/10	22T/m	63T/m
20/10	30T/m	80T/m
25/10	55T/m	90T/m
30/10	70T/m	100T/m

**Inox** ~ 70kg/mm<sup>2</sup>

Épaisseur	 goutte	 jointif
6/10	15T/m	35T/m
8/10	20T/m	50T/m
10/10	25T/m	60T/m
125/100	26T/m	80T/m
15/10	38T/m	95T/m
20/10	50T/m	130T/m
25/10	90T/m	180T/m
30/10	100T/m	210T/m

## Table d'écrasement pneumatique



La table d'écrasement se positionne sur le tablier de la presse.

L'ouverture/fermeture est pneumatique.

Elle est disponible avec commande manuelle ou par électrovanne actionnée par la commande numérique.

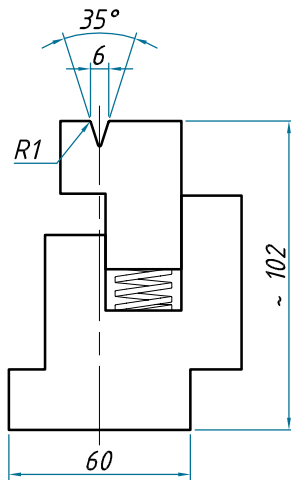


# AMADA Typ Plis écrasés

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

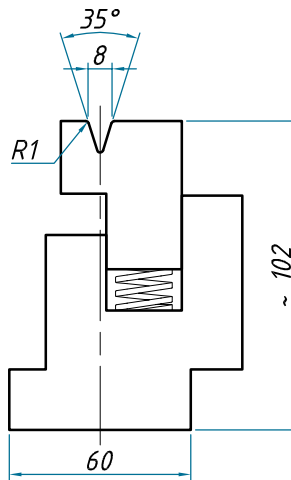
30.01 / 6-35°

60T/m



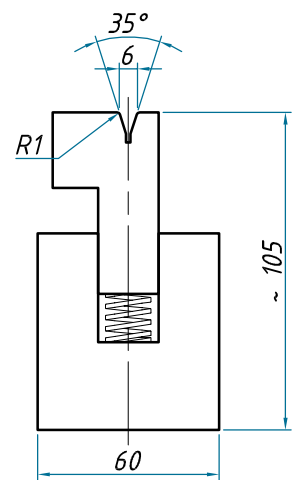
30.01 / 8-35°

50T/m



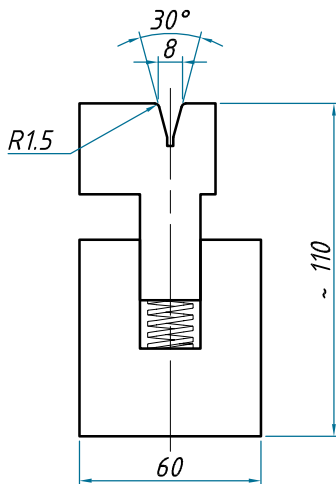
30.02 / 6-35°

80T/m



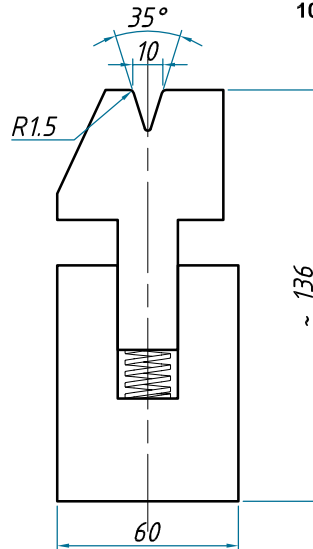
30.02 / 8-30°

80T/m



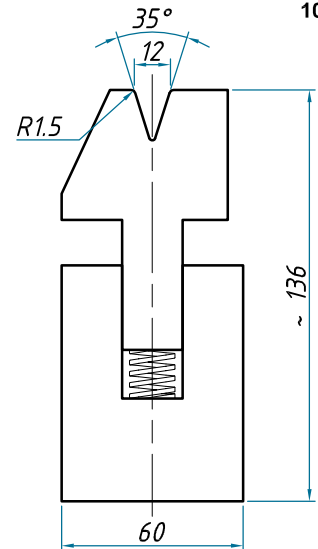
30.01 / 10-35°

100T/m



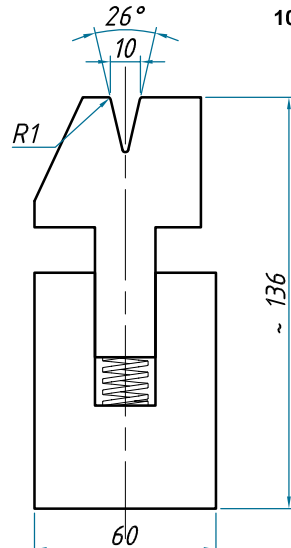
30.01 / 12-35°

100T/m



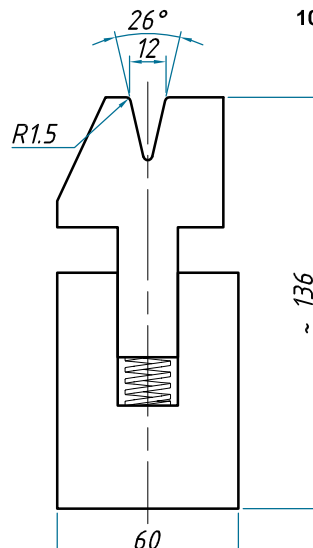
30.01 / 10-26°

100T/m



30.01 / 12-26°

100T/m



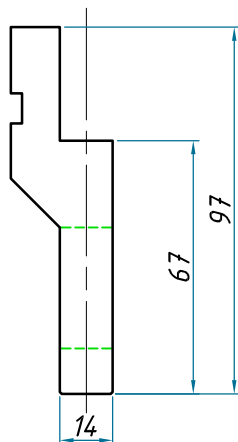
Sur demande, la gamme  
entière des modèles 30.01  
et 30.02 est disponible avec  
fonctionnement **pneumatique**,  
manuel ou avec électrovanne  
actionnée par la commande  
numérique de la presse

# AMADA Typ Accessoires

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

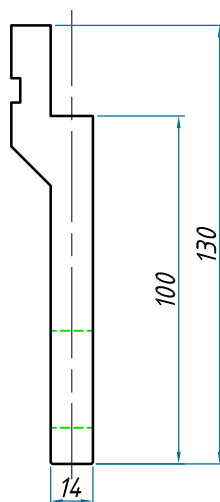
**40.05**

100T/m



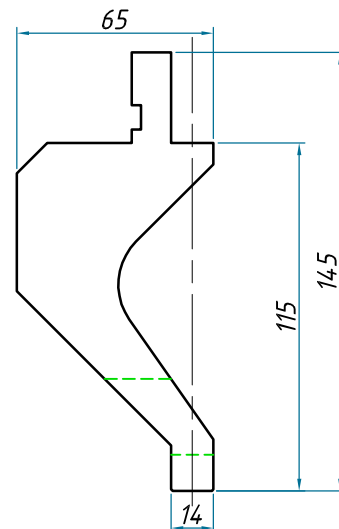
**40.116**

100T/m

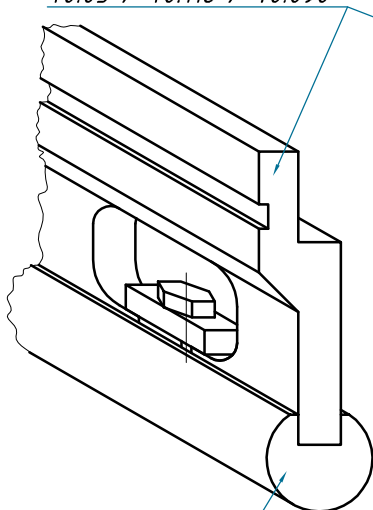


**40.090**

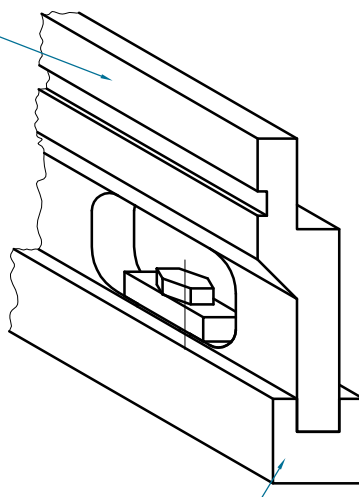
40T/m



Porte-règle  
40.05 / 40.116 / 40.090



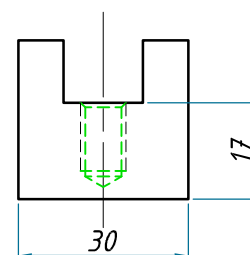
Règle à rayonner 40.09



Règle à écraser 40.02

**40.02**

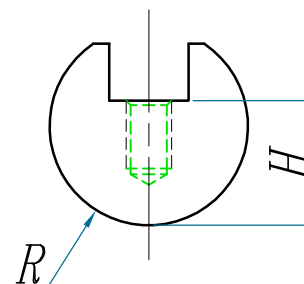
100T/m



**40.09**

100T/m

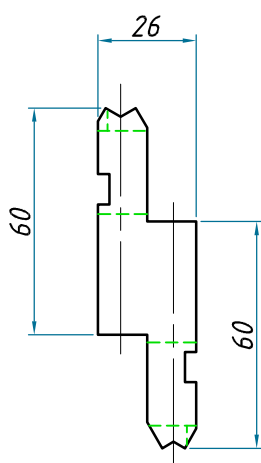
Modèle	R	H
40.09/20	10	12
40.09/25	12.5	17
40.09/30	15	20
40.09/35	17.5	22
40.09/40	20	24
40.09/50	25	29
40.09/60	30	34
40.09/80	40	44
40.09/100	50	70



Toutes les règles sont  
fournies sans visserie,  
laquelle est livrée  
avec les portes-règles  
ou en supplément

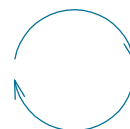
**40.30**

70T/m



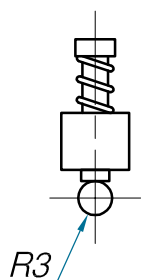
Montage coté A  
pour R3 à 5

Montage coté B  
pour R6 à 10

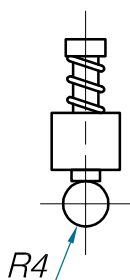


**40.31**

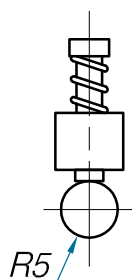
**Pour coté A**



**40.31/06**

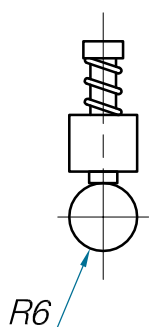


**40.31/08**

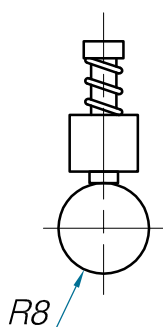


**40.31/10**

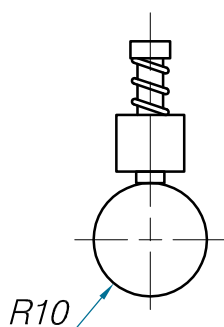
**Pour coté B**



**40.31/12**



**40.31/16**

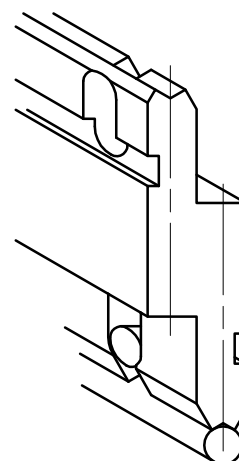


**40.31/20**

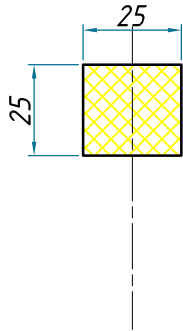
**Fractionnement**

Longueur 835  
fractionnée en :

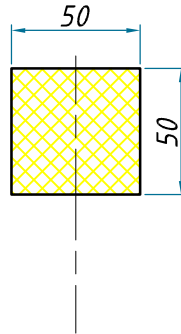
$20 + 25 + 30 + 35 + 40$   
 $+ 50 + 70 + 165 + 200$   
 $+ 2 \text{ bigornes de } 100\text{mm}$



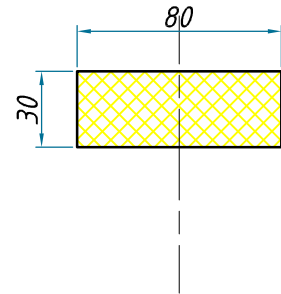
**61.1**



**61.3**

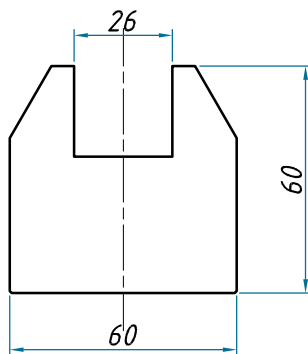


**61.4**



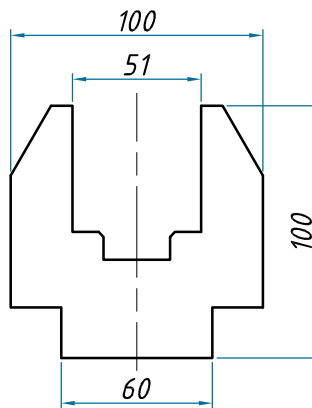
**60.1**

100T/m



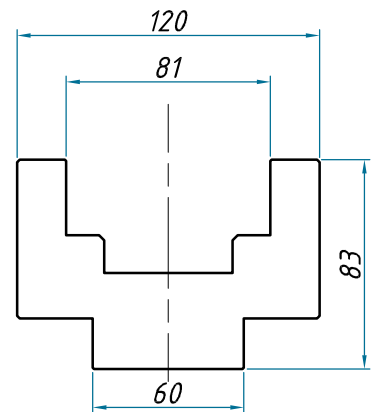
**60.3**

100T/m



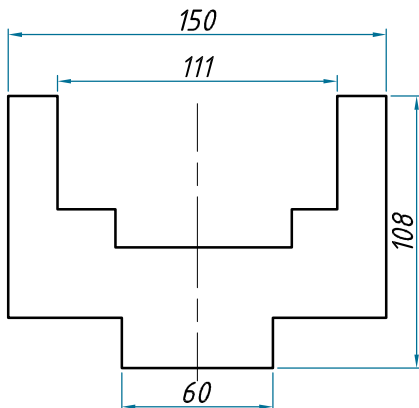
**60.4**

100T/m

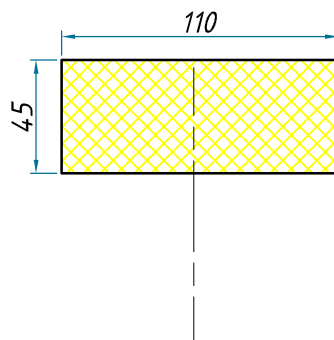


**60.5**

100T/m



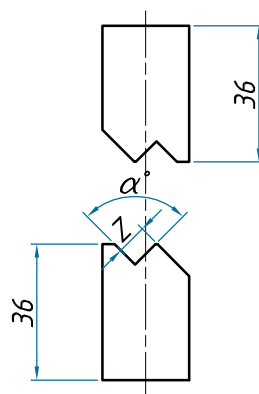
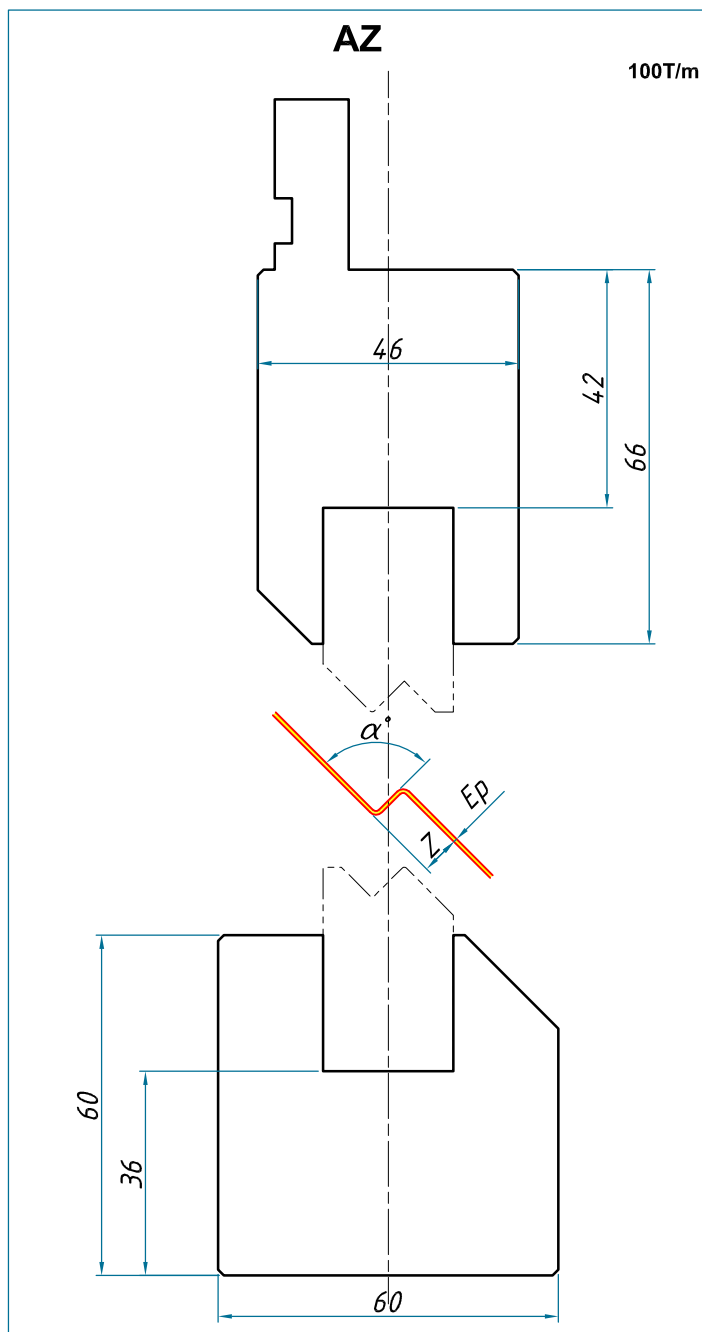
**61.5**



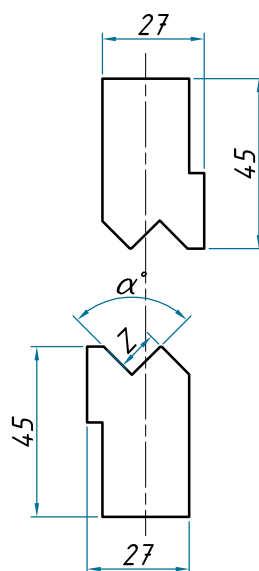
*Le pliage sur élastomère permet, sur des tôles fines, de faire un pliage sans marque, un rayon en bord de tôle, un pliage avec un trou en bord de pli, etc.*

# AMADA Typ Plis en Z

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

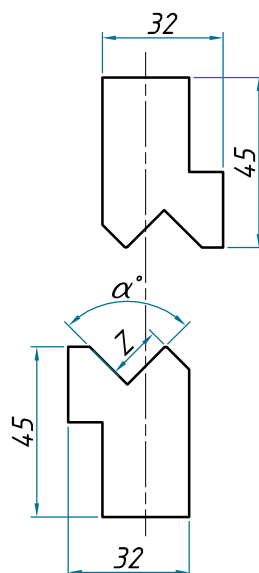
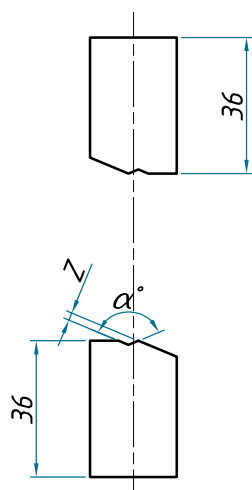


Modèle	Z	$\alpha^\circ$
<b>Z1-90</b>	<b>1</b>	<b>90°</b>
<b>Z1.5-90</b>	<b>1.5</b>	<b>90°</b>
<b>Z2-90</b>	<b>2</b>	<b>90°</b>
<b>Z2.5-90</b>	<b>2.5</b>	<b>90°</b>
<b>Z3-90</b>	<b>3</b>	<b>90°</b>
<b>Z3.5-90</b>	<b>3.5</b>	<b>90°</b>
<b>Z4-90</b>	<b>4</b>	<b>90°</b>
<b>Z4.5-90</b>	<b>4.5</b>	<b>90°</b>
<b>Z5-90</b>	<b>5</b>	<b>90°</b>
<b>Z5.5-90</b>	<b>5.5</b>	<b>90°</b>
<b>Z6-90</b>	<b>6</b>	<b>90°</b>
<b>Z6.5-90</b>	<b>6.5</b>	<b>90°</b>
<b>Z7-90</b>	<b>7</b>	<b>90°</b>
<b>Z7.5-90</b>	<b>5</b>	<b>90°</b>
<b>Z8-90</b>	<b>8</b>	<b>90°</b>



Modèle	Z	$\alpha^\circ$
<b>Z9-90</b>	<b>9</b>	<b>90°</b>
<b>Z10-90</b>	<b>10</b>	<b>90°</b>
<b>Z11-90</b>	<b>11</b>	<b>90°</b>
<b>Z12-90</b>	<b>12</b>	<b>90°</b>

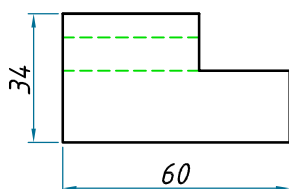
Modèle	Z	$\alpha^\circ$
<b>Z1-160</b>	<b>1</b>	<b>160°</b>
<b>Z1.5-160</b>	<b>1.5</b>	<b>160°</b>
<b>Z2-150</b>	<b>2</b>	<b>150°</b>
<b>Z2.5-140</b>	<b>2.5</b>	<b>140°</b>



Modèle	Z	$\alpha^\circ$
<b>Z13-90</b>	<b>13</b>	<b>90°</b>
<b>Z14-90</b>	<b>14</b>	<b>90°</b>
<b>Z15-90</b>	<b>15</b>	<b>90°</b>

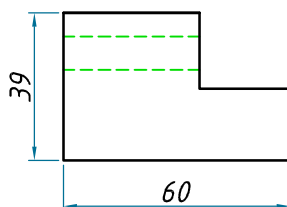
**40.06/34**

100T/m



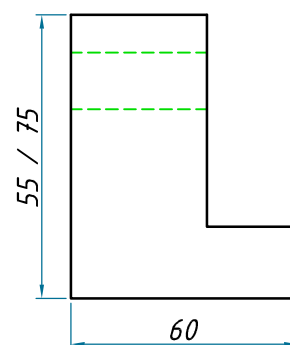
**40.06/39**

100T/m



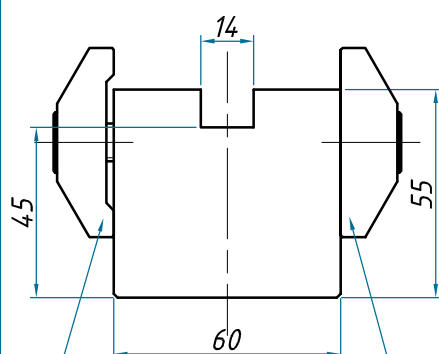
**40.07/55**  
**40.07/75**

100T/m



**40.58**

100T/m

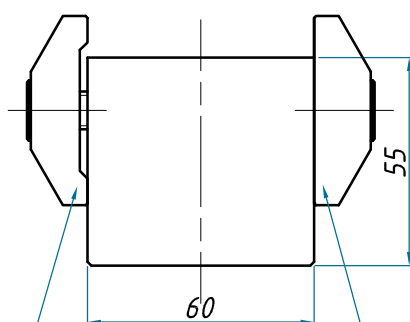


Brides de serrage  
Ref. ST41

Brides fixes  
Ref. ST55

**40.55**

100T/m

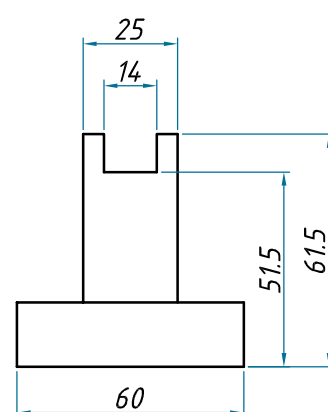


Brides de serrage  
Ref. ST41

Brides fixes  
Ref. ST55

**40.14**

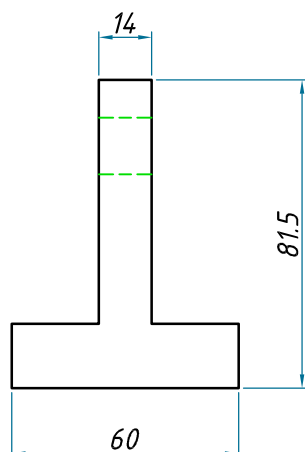
100T/m



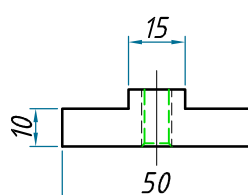
Alignement réglable par vis

**330**

100T/m

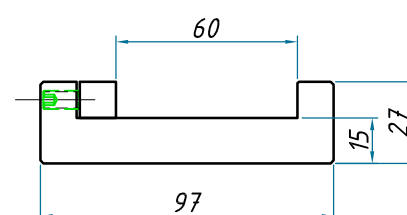


**4015**

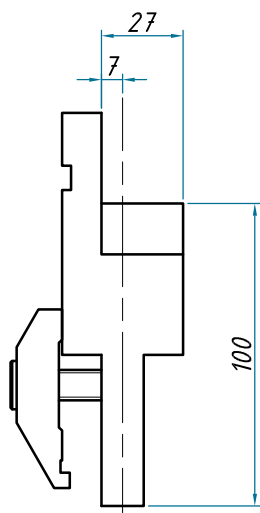


**40.60**

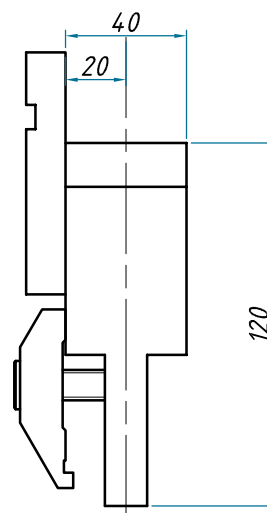
100T/m



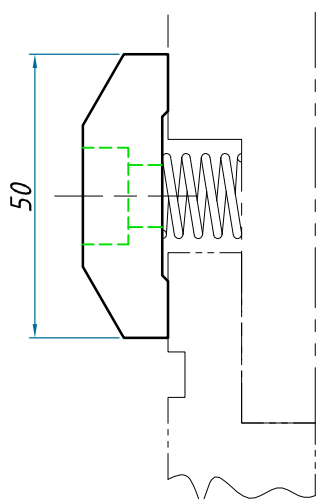
**40.03**



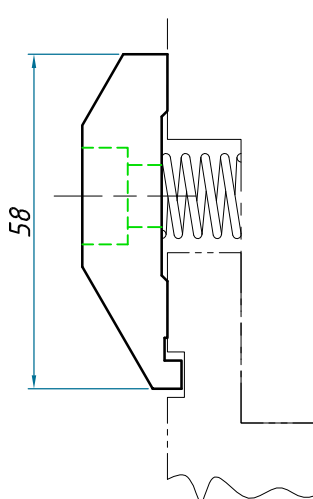
**40.50**



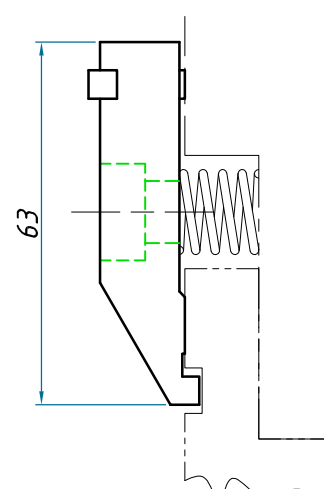
**ST41**



**ST43**

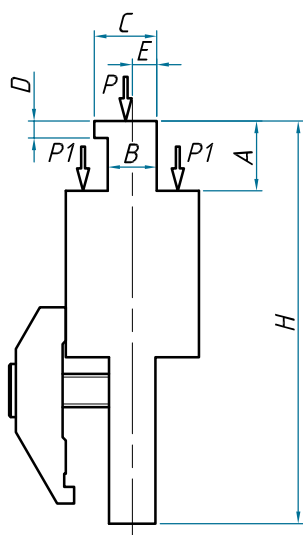


**ST44**



*Serrage rapide par levier*

**40.20**

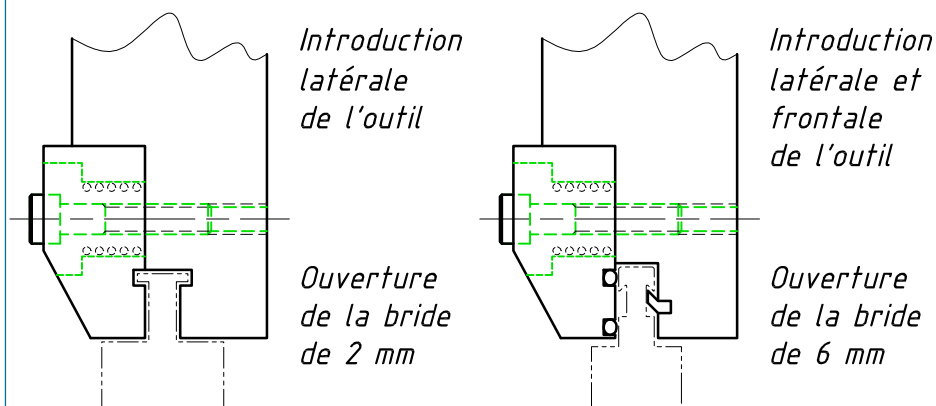


*Pour toute demande,  
veuillez nous indiquer :*

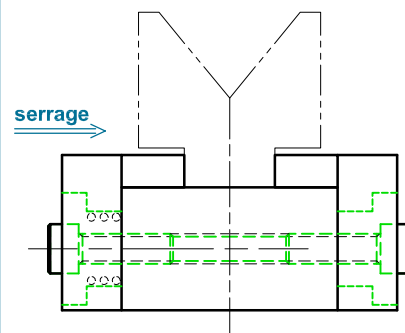
- Hauteur totale H
- Cotes d'attache A, B, C, D et E
- Les faces d'appuis sur la presse P ou P1
- La longueur L

*Nous vous proposons  
aussi sur étude, le  
chargement frontal  
des outils*

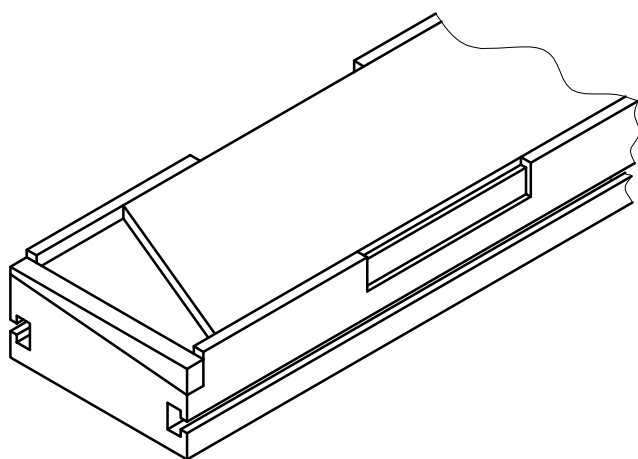
## Systèmes de blocage hydrauliques



## Systèmes de blocage hydrauliques



## Table de bombage spéciale à l'aide de cales coniques



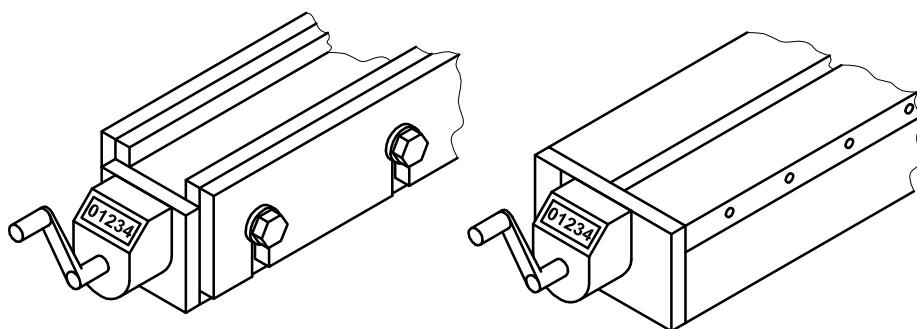
*On sait que l'angle de pli n'est pas égal sur la longueur totale à cause des flexions qui se vérifient pendant le travail sur les presses.*

*Ce problème est résolu grâce aux tables de bombage qui, par un système de cales coniques, manuel ou automatique, permet de compenser les flexions.*

*Deux compensations possibles :*

*Longitudinales pour les déformations linéaires et transversale pour les déformations localisées.*

## Table de bombage standard manuelle

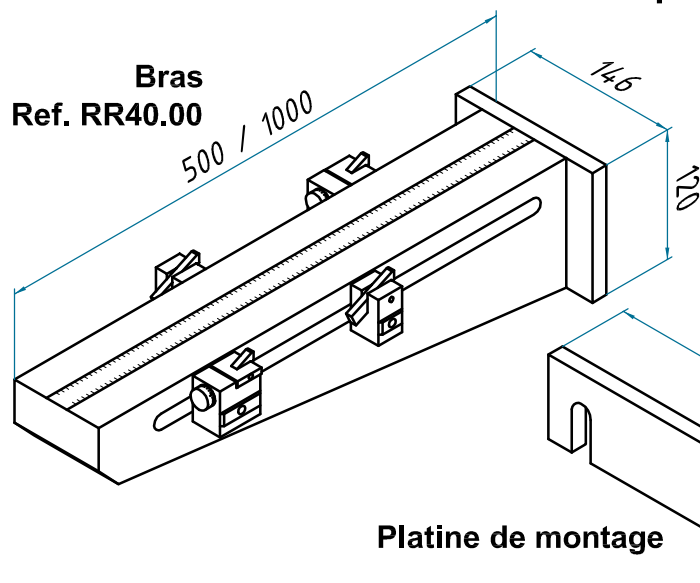


PHOTO

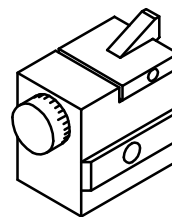


## Butées avants pour presse plieuse

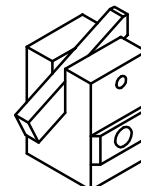
Bras  
Ref. RR40.00  
500 / 1000



Butée micro  
Ref. 6036

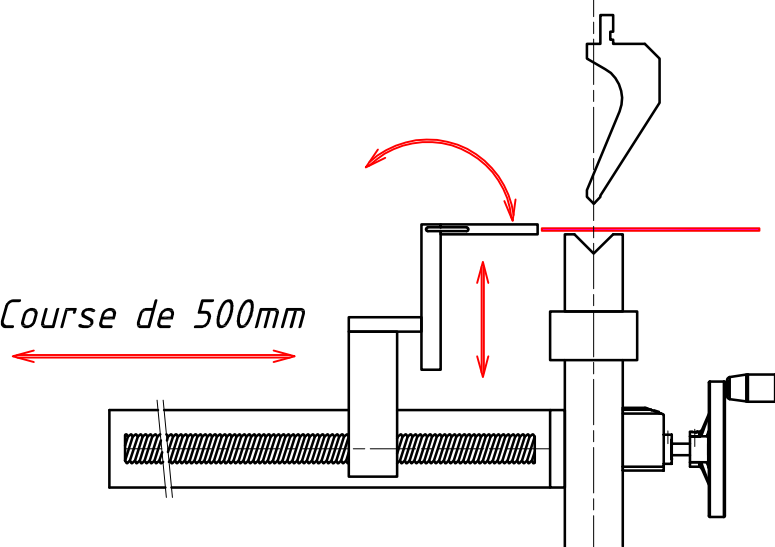


Butée escamotable  
Ref. 6032



## Butée arrière type BM pour presse plieuse

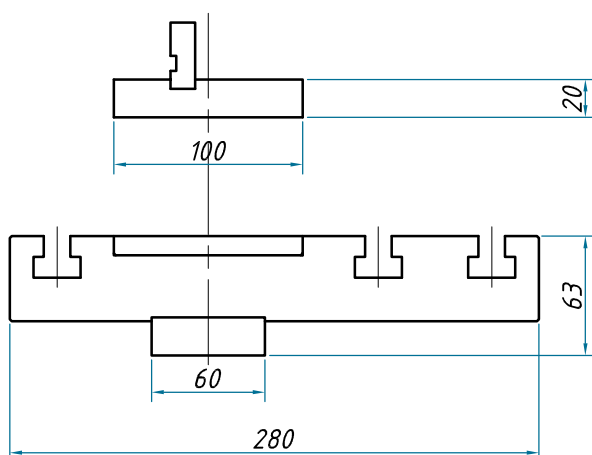
Course de 500mm



Commande par volant  
ou motorisable  
Butée éclipseable et  
réglable en hauteur

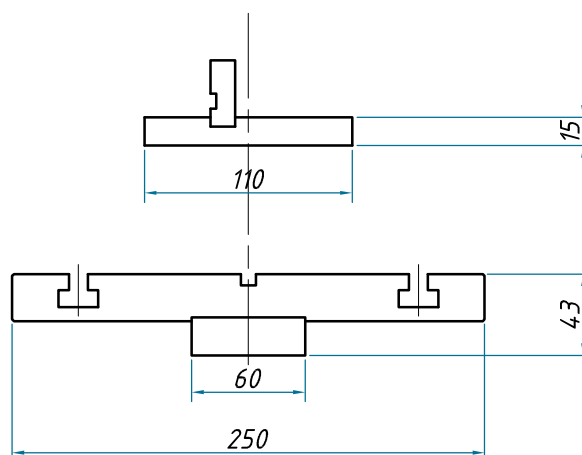
40.10 / 40.11

Montage pour unités de poinçonnage



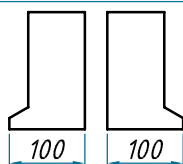
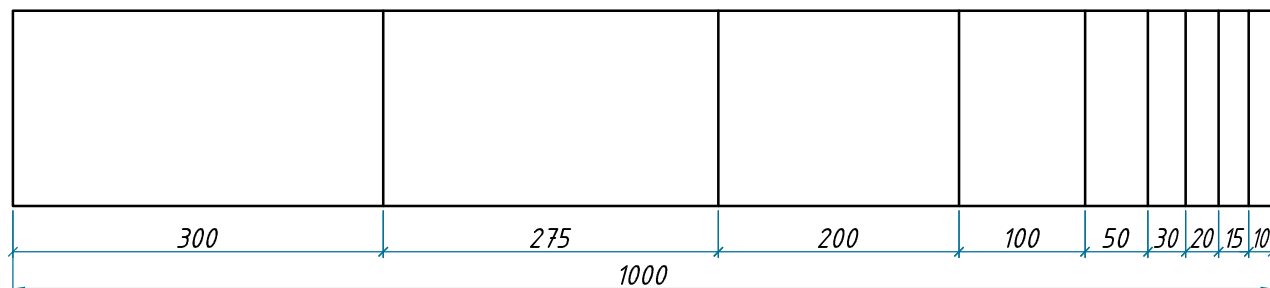
40.20 / 40.30

Montage pour unités de poinçonnage



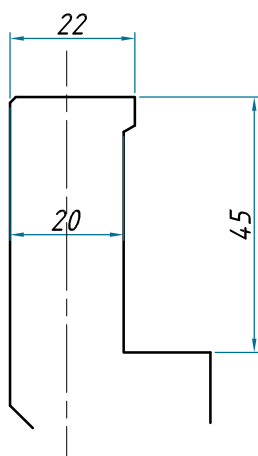
*Toutes les lames Bystronic – Beyeler typ sont disponibles  
en long. 515, 1000 fractionnée et jeu de bigornes de 100*

## Détail du fractionnement standard 1000mm

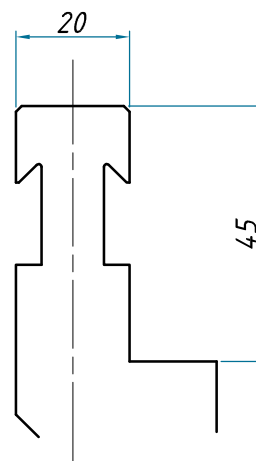


*Les bigornes ne sont pas incluses dans le fractionnement*

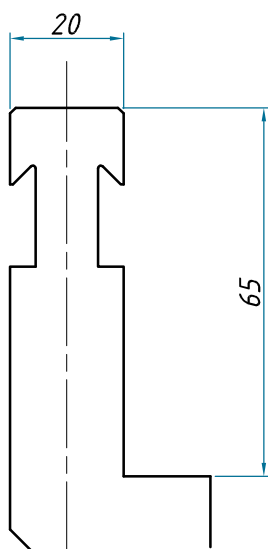
### Type S



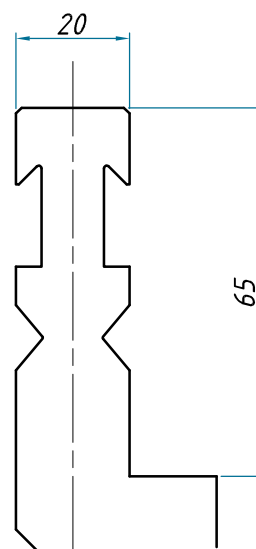
### Type R



### Type RF



### Type RF-A

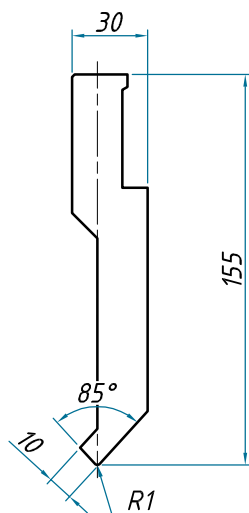


# BYSTRONIC - BEYELER Typ

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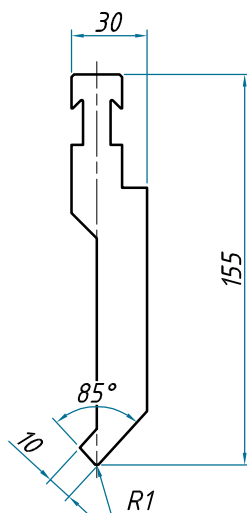
**P2 S**

130T/m



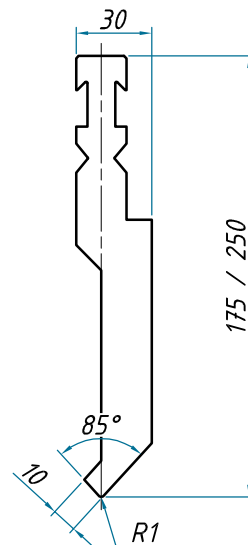
**P2 R**

130T/m



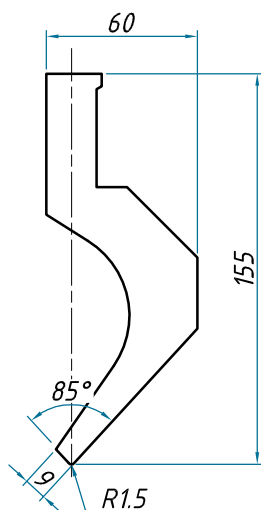
**P2 RF-A**

130T/m



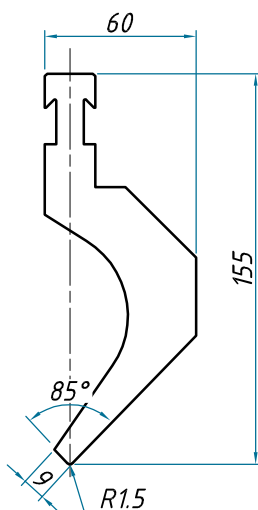
**P4 S**

90T/m



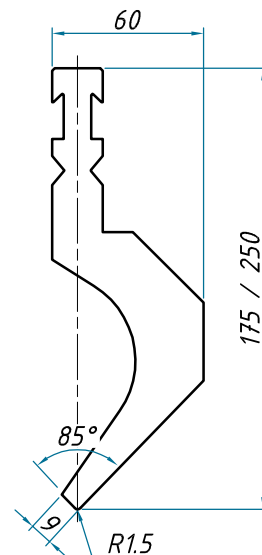
**P4 R**

90T/m



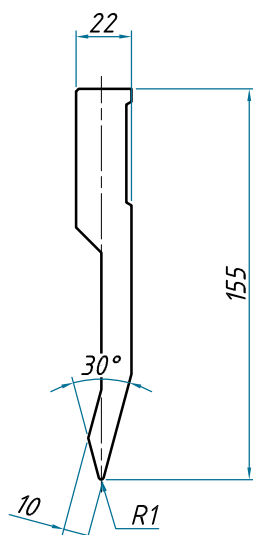
**P4 RF-A**

90T/m



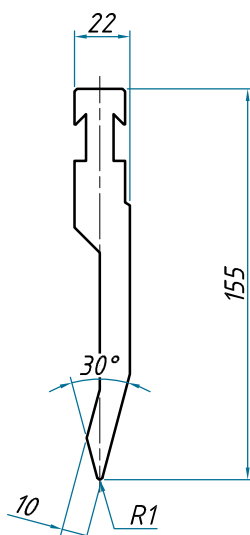
**P5 S**

100T/m



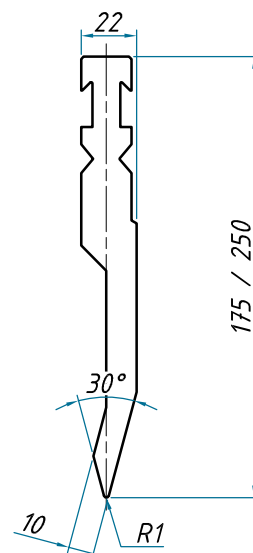
**P5 R**

100T/m



**P5 RF-A**

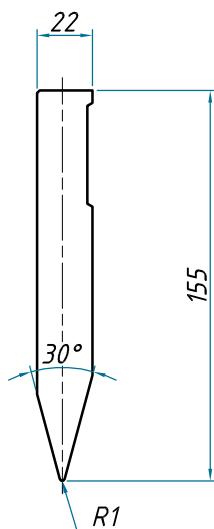
100T/m



**P40**

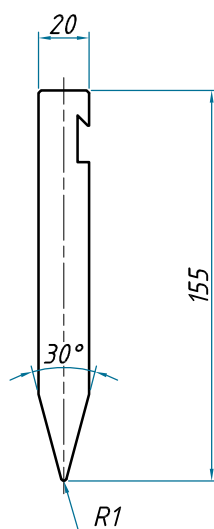
**P6 S**

160T/m



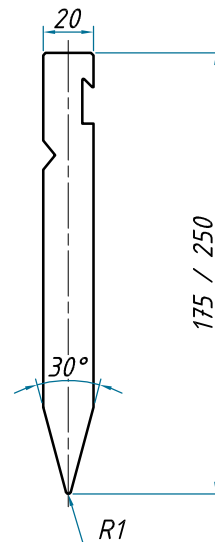
**P6 R**

160T/m



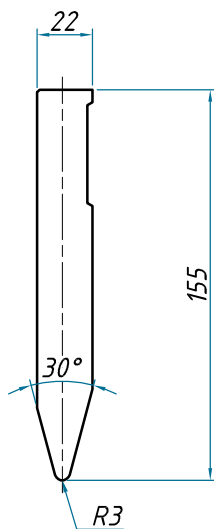
**P6 RF-A**

160T/m



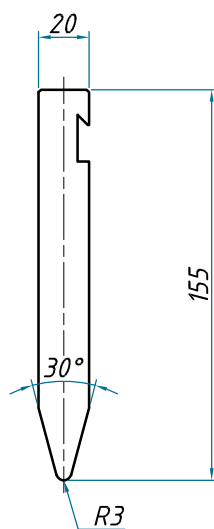
**P7 S**

160T/m



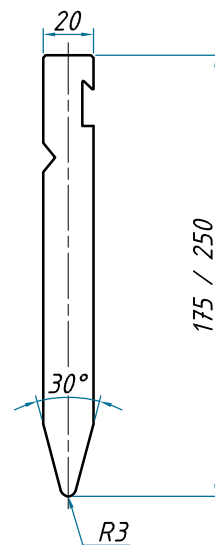
**P7 R**

160T/m



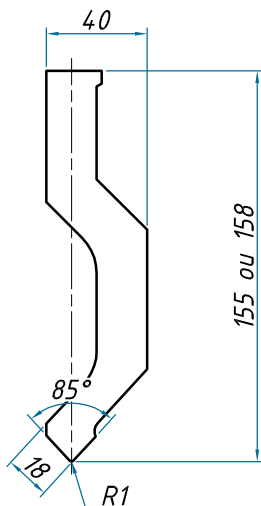
**P7 RF-A**

160T/m



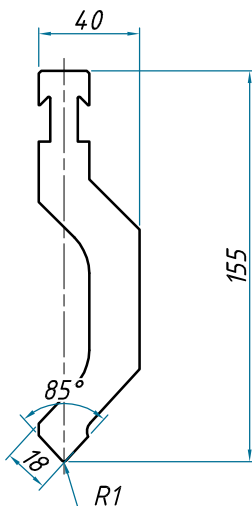
**P8 S**

100T/m



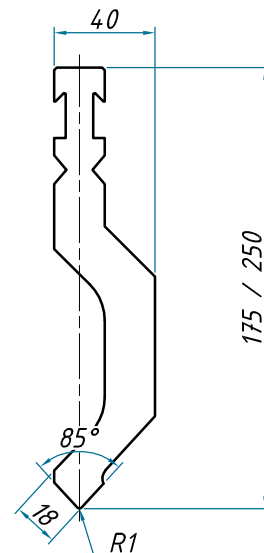
**P8 R**

100T/m



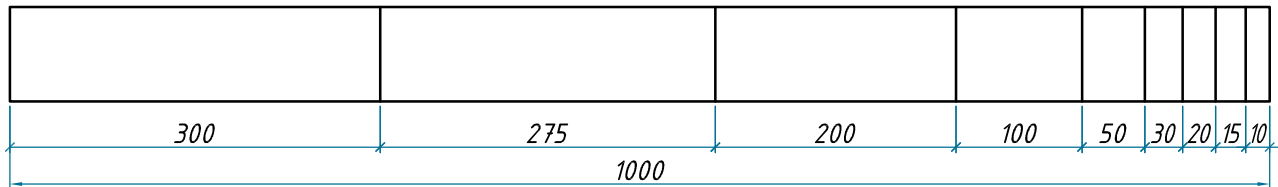
**P8 RF-A**

100T/m



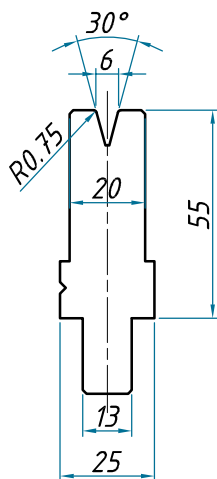
*Toutes les matrices Bystronic – Beyeler typ sont disponibles  
en long. 515 et 1000 fractionnée*

## Détail du fractionnement standard 1000mm



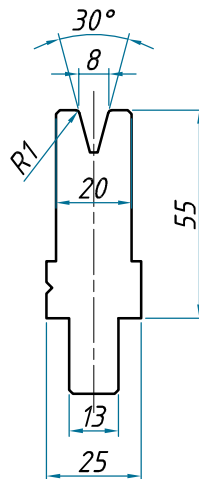
### M6/30°

60T/m



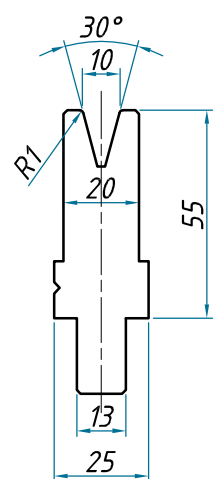
### M8/30°

50T/m



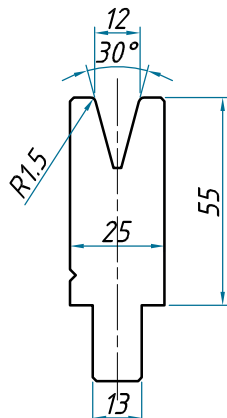
### M10/30°

40T/m



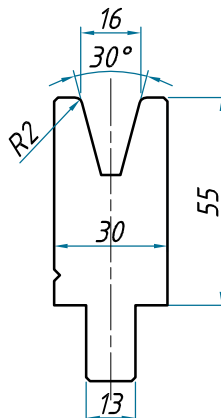
### M12/30°

50T/m



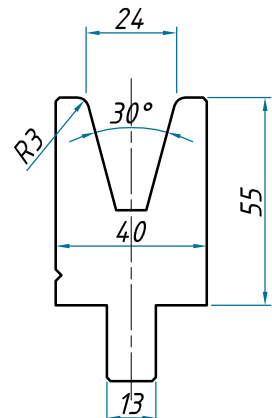
### M16/30°

55T/m



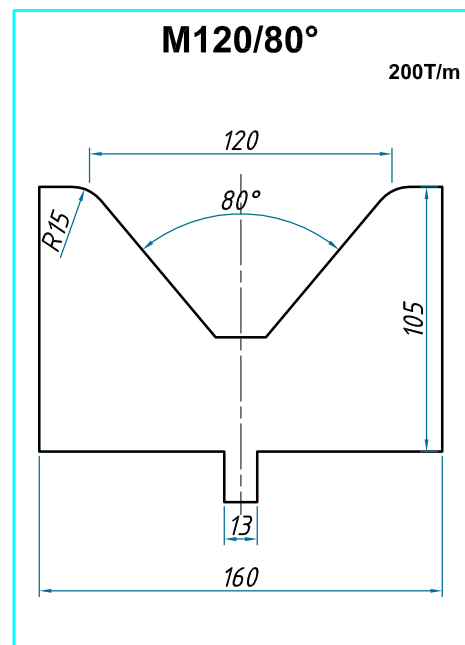
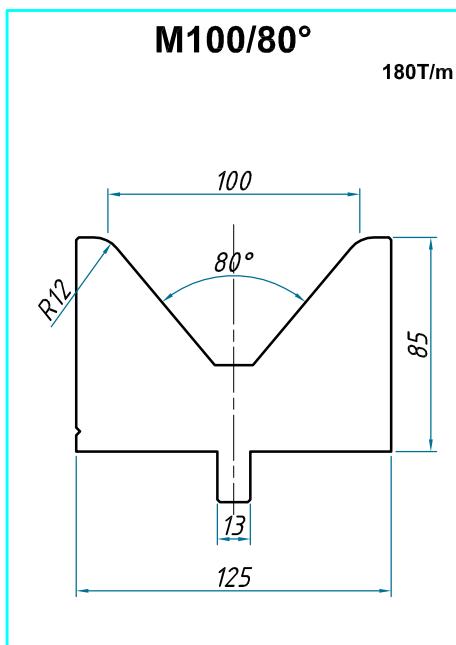
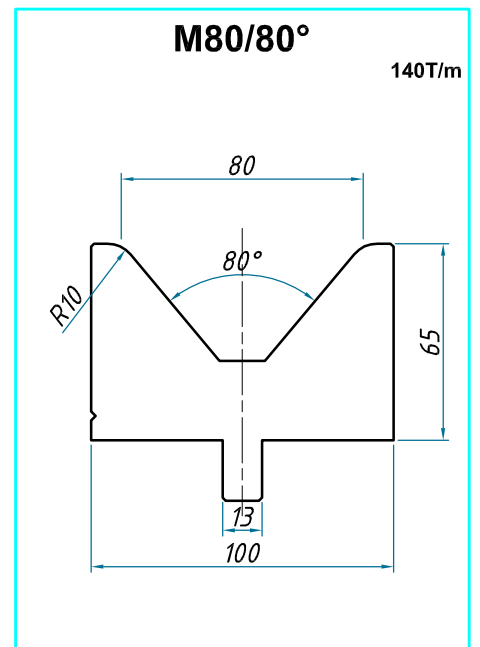
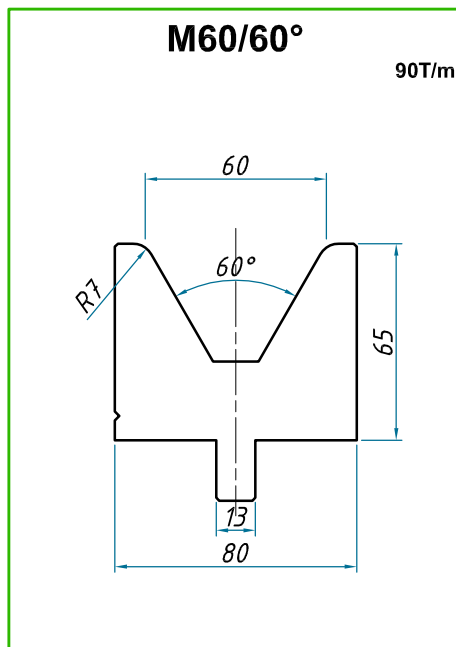
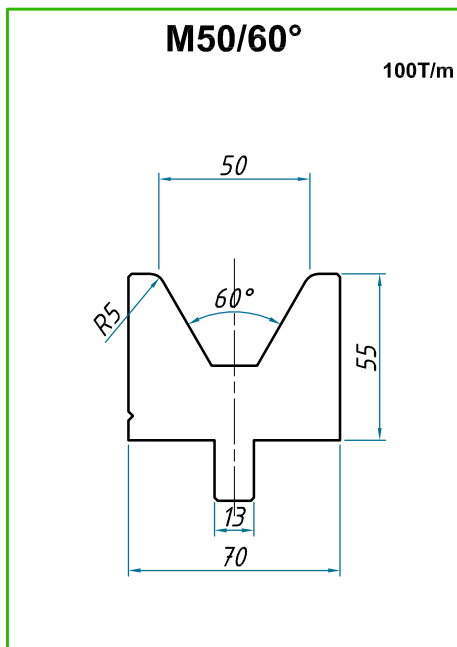
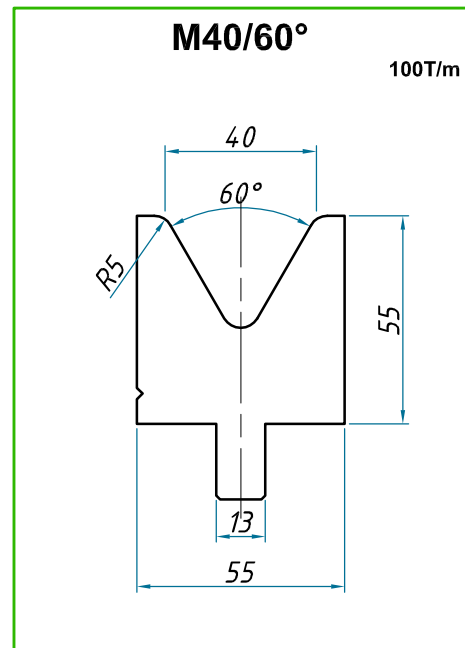
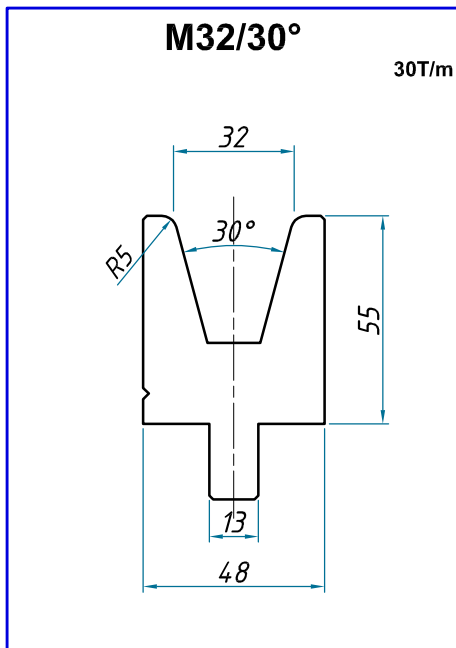
### M24/30°

60T/m



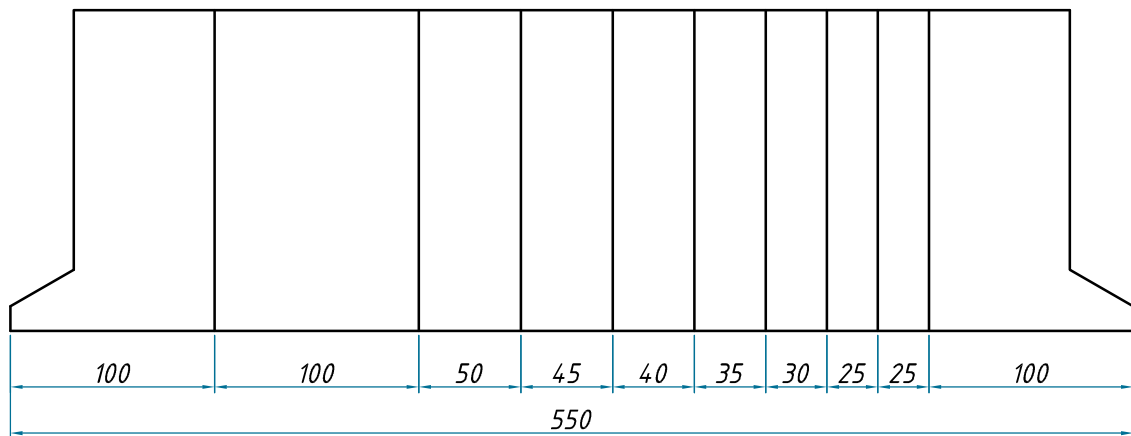
# BYSTRONIC - BEYELER Typ

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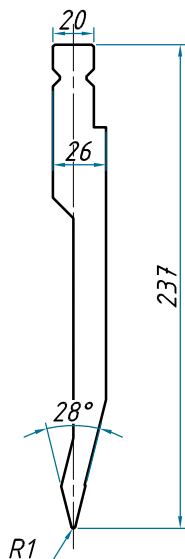
*Les lames Speedline typ sont disponibles  
en long. 500 et 550 fractionnée*

## Détail du fractionnement standard



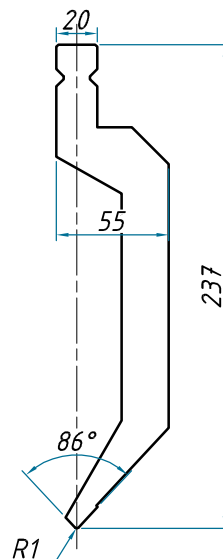
### SPE 10.61/28°

60T/m



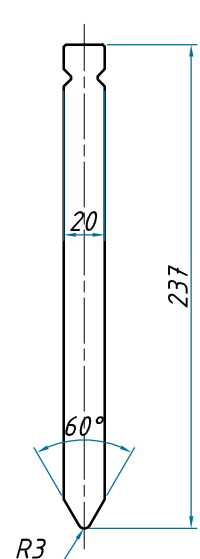
### SPE 10.62/86°

50T/m



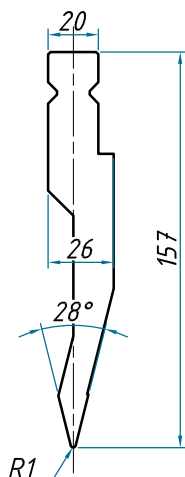
### SPE 10.63/60°

140T/m



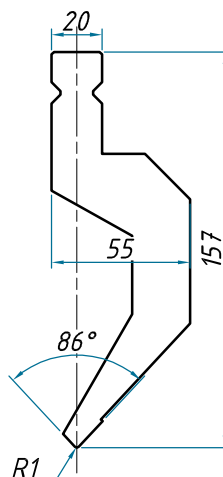
### SPE 10.64/28°

100T/m



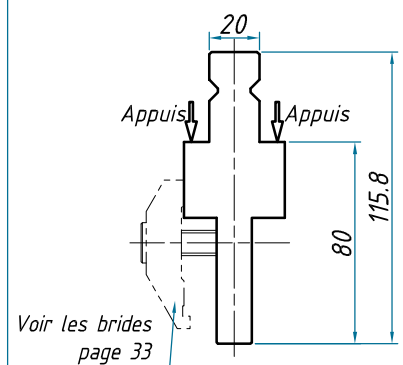
### SPE 10.65/86°

65T/m



### SPE 40.01

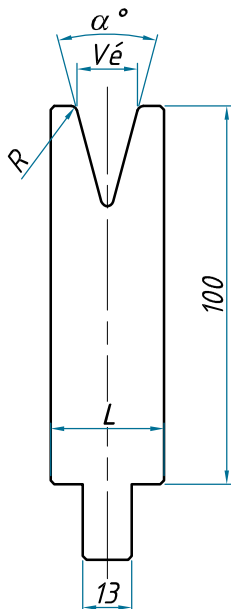
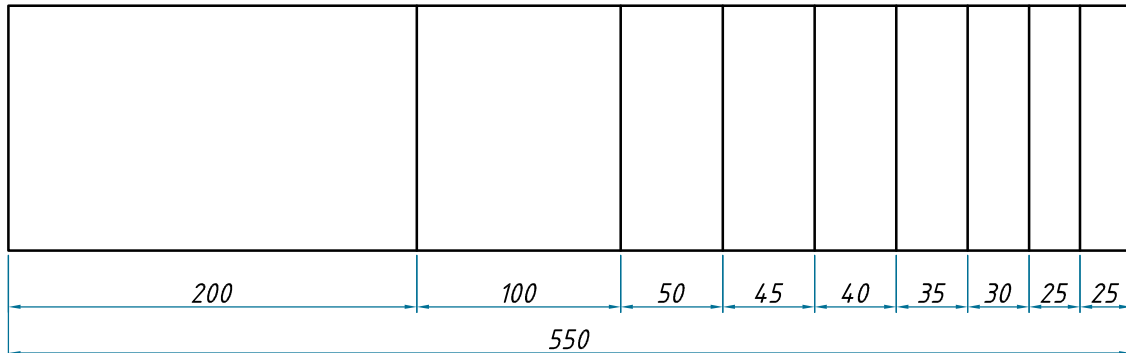
100T/m



*Pour adaptation de  
lames type Amada*

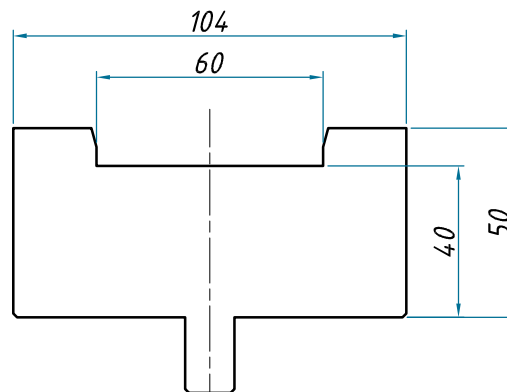
*Les matrices Speedline typ sont disponibles  
en long. 500 et 550 fractionnée*

## Détail du fractionnement standard



Modèle	V <sub>e</sub>	α°	R	L	F' maxi
SPE 8/30°	8	30°	R1	20	50T/m
SPE 10/30°	10	30°	R1	20	40T/m
SPE 12/30°	12	30°	R1	25	50T/m
SPE 16/30°	16	30°	R1.6	30	55T/m
SPE 20/30°	20	30°	R2	35	55T/m
SPE 24/30°	24	30°	R2.5	40	60T/m
SPE 40/80°	40	80°	R5	55	100T/m
SPE 50/80°	50	80°	R5	65	100T/m

## SPE 40.40



*Pour adaptation de  
matrices type Amada*

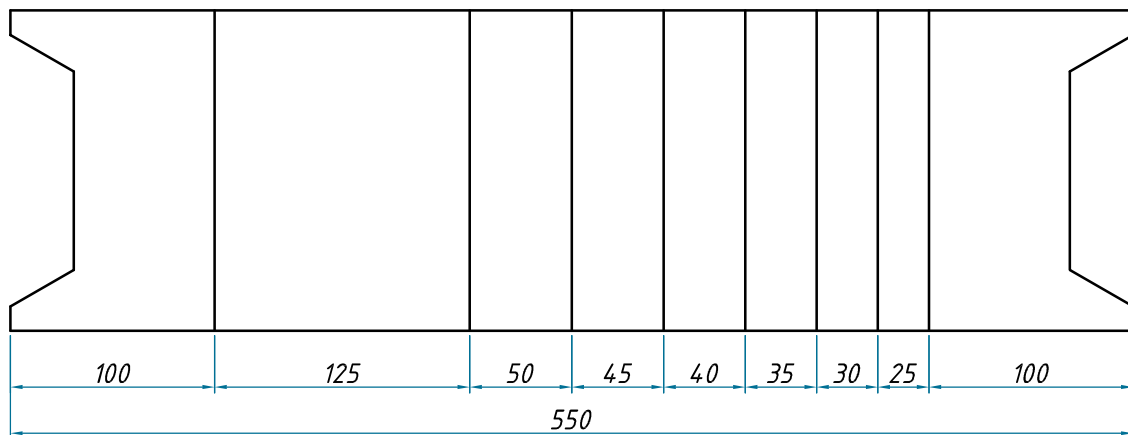


# LVD Typ

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

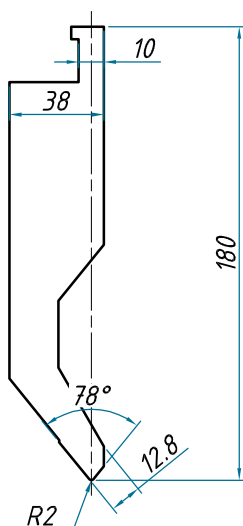
*Les lames LVD typ sont disponibles  
en long. 508 et 550 fractionnée*

## Détail du fractionnement standard de lame



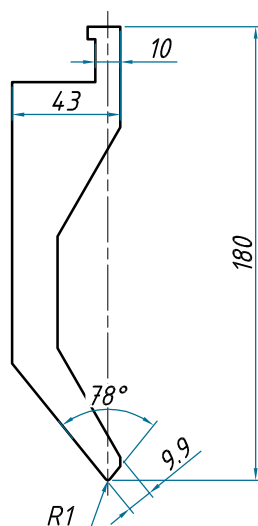
### C10

70T/m



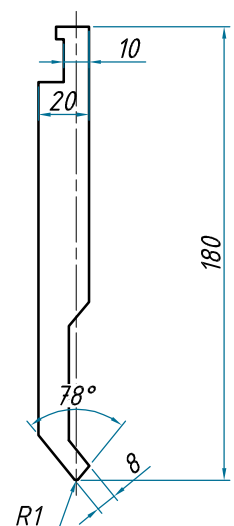
### D10

45T/m



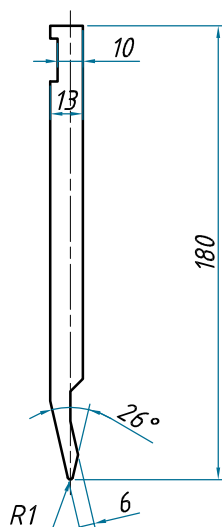
### E10

40T/m



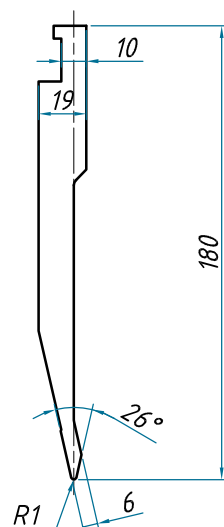
### F10

50T/m



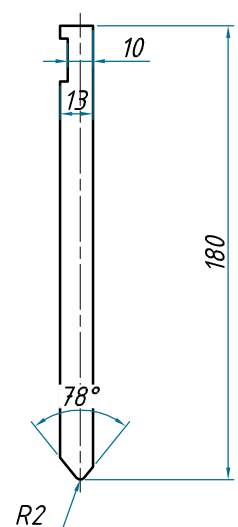
### J10

40T/m



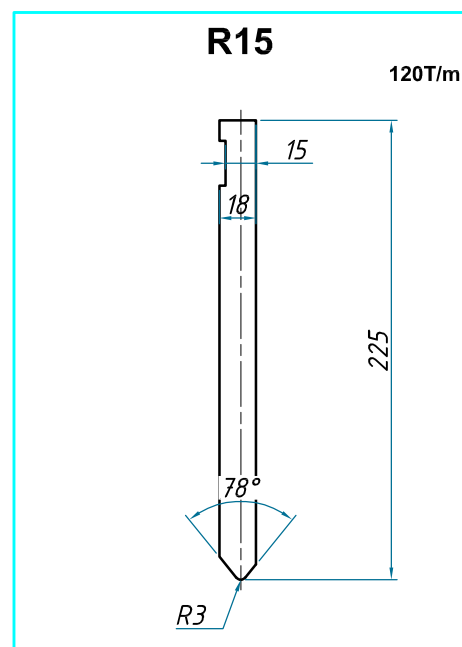
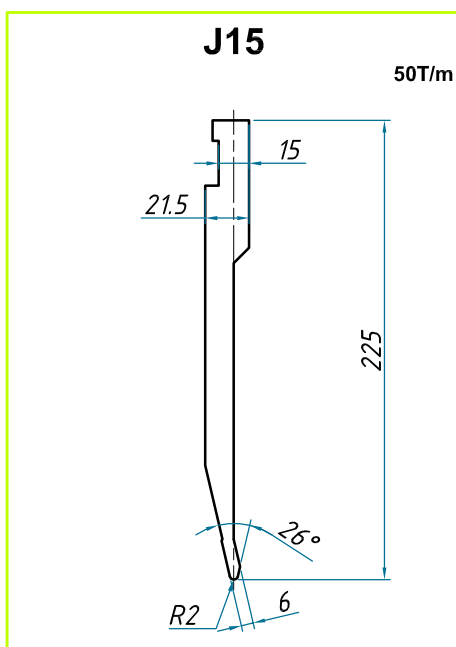
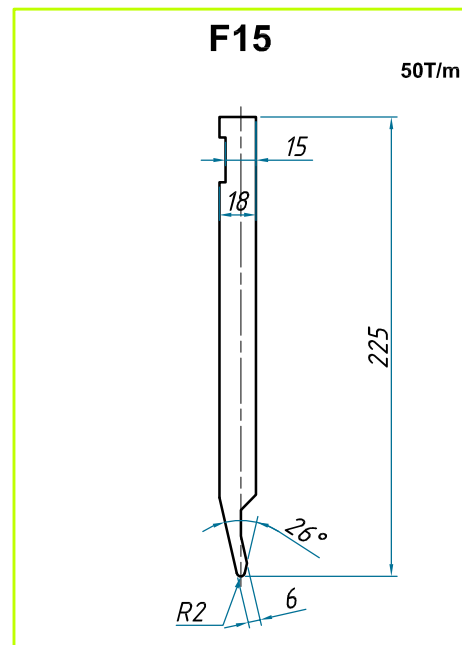
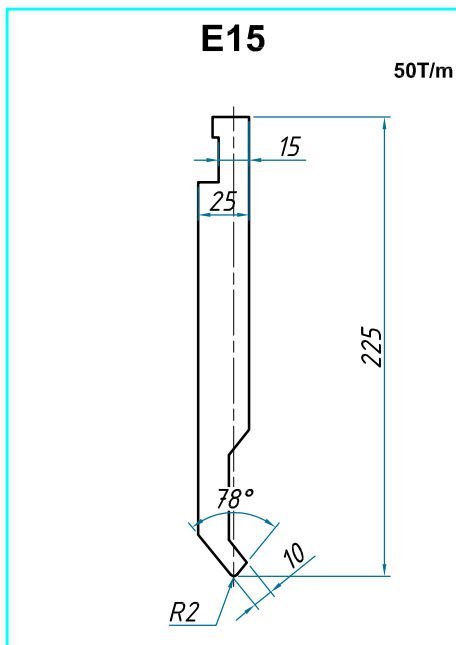
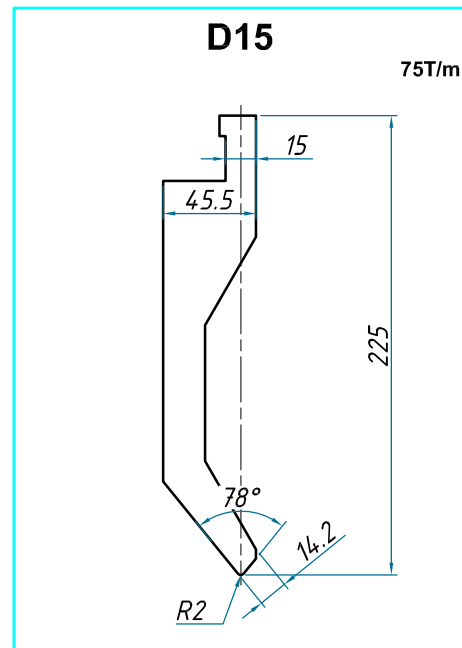
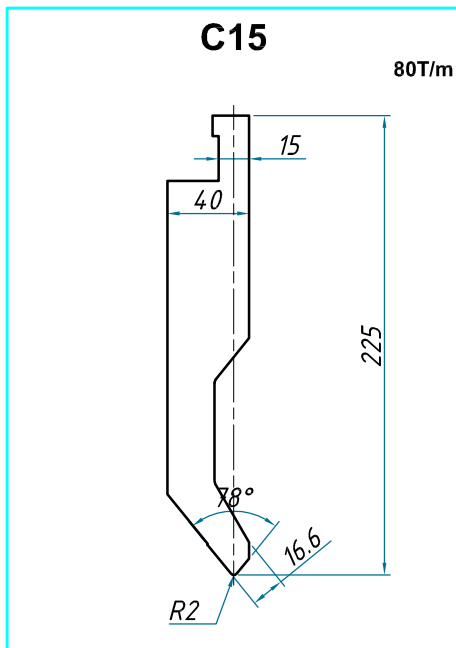
### R10

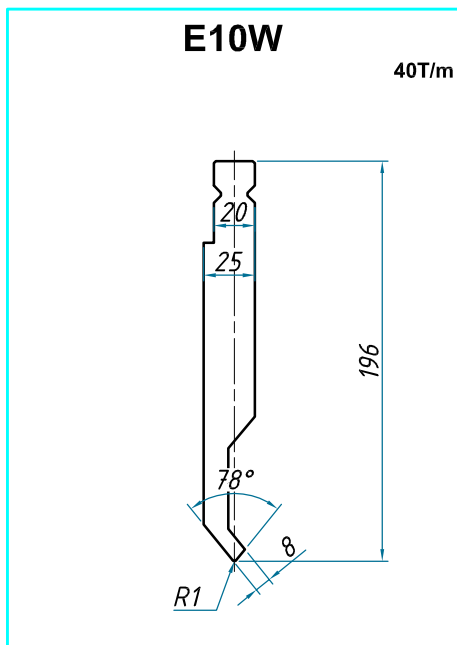
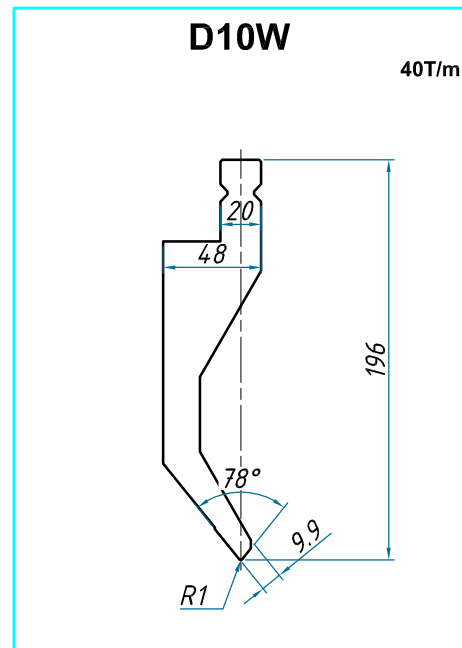
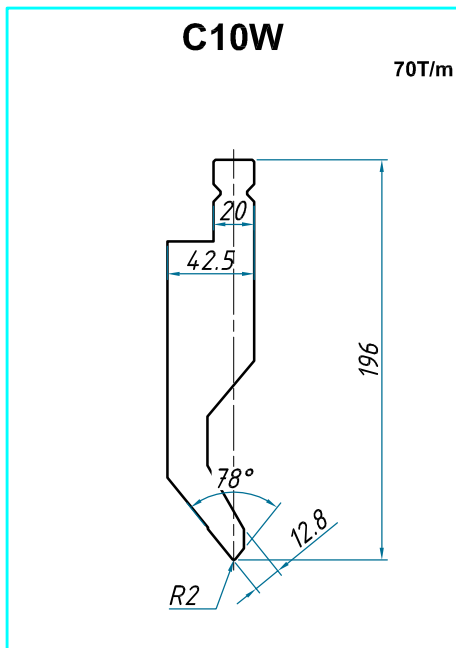
100T/m



# LVD Typ

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

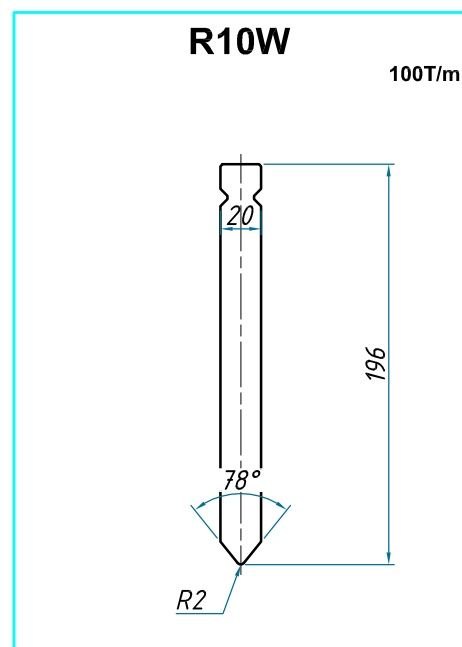
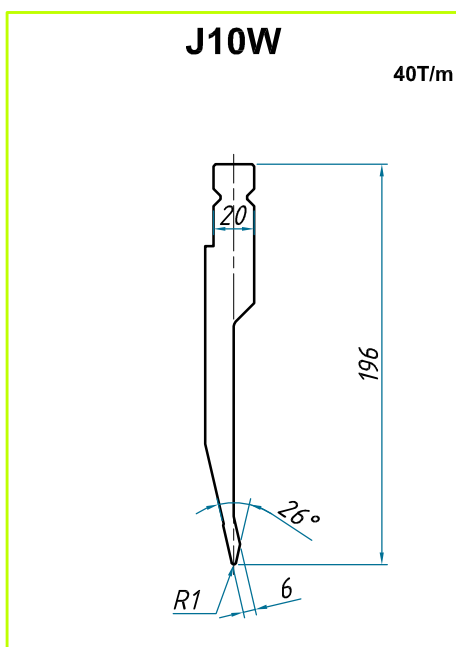
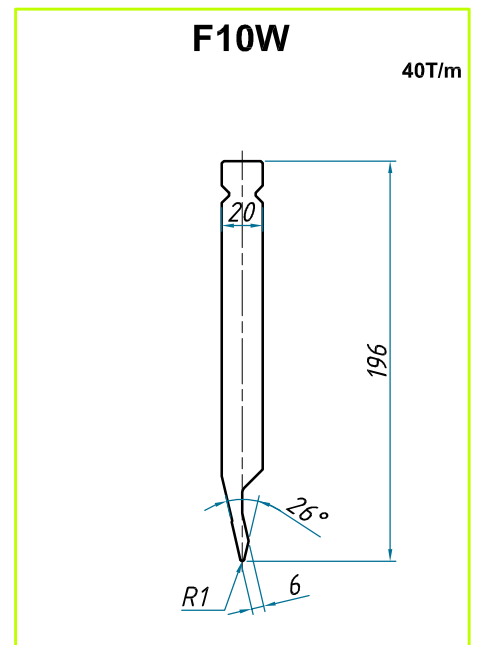




*Toutes les lames  
n'excédant pas 12.5kg  
sont prévues pour  
recevoir les poussoirs  
de sécurité.*

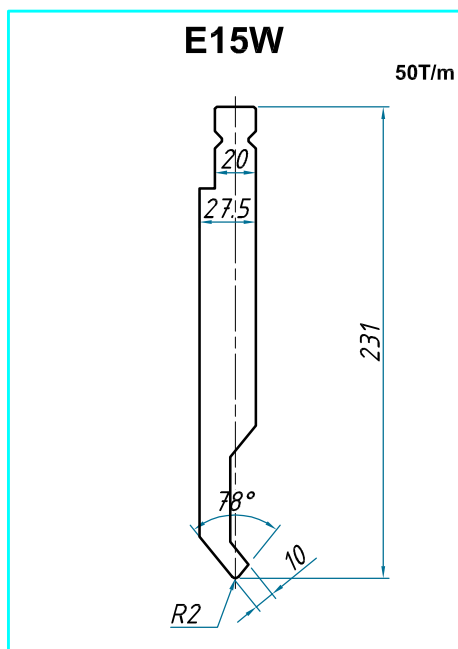
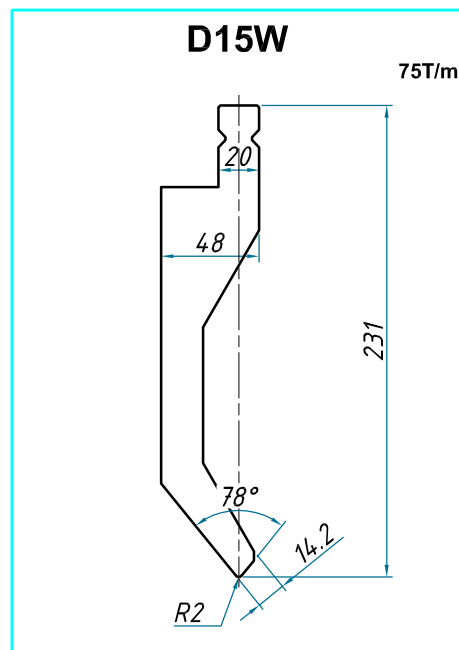
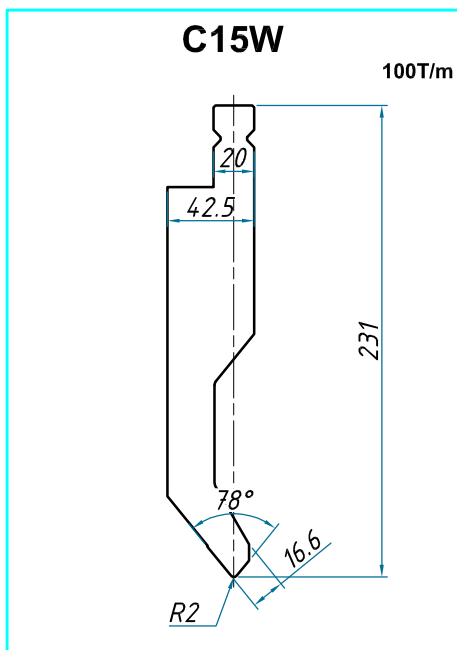
*Les poussoirs sont à  
commander séparément*

*Détail des poussoirs page 55*



# LVD Typ

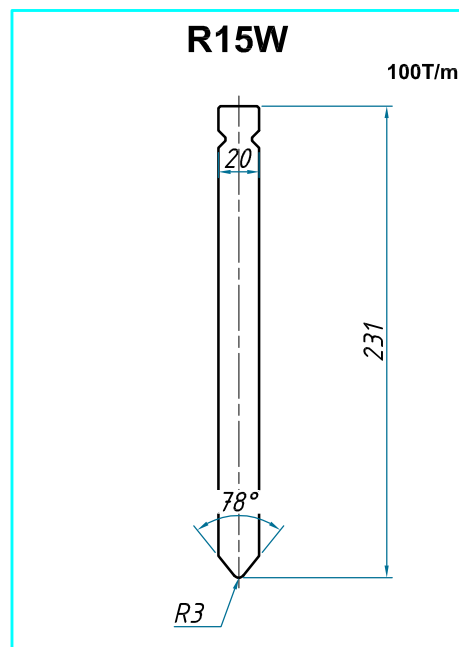
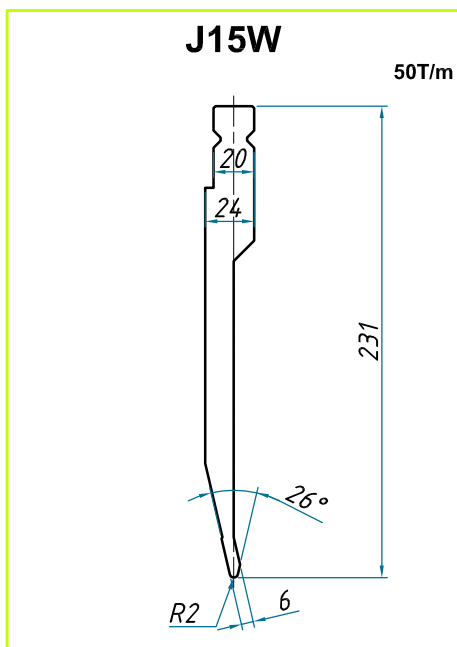
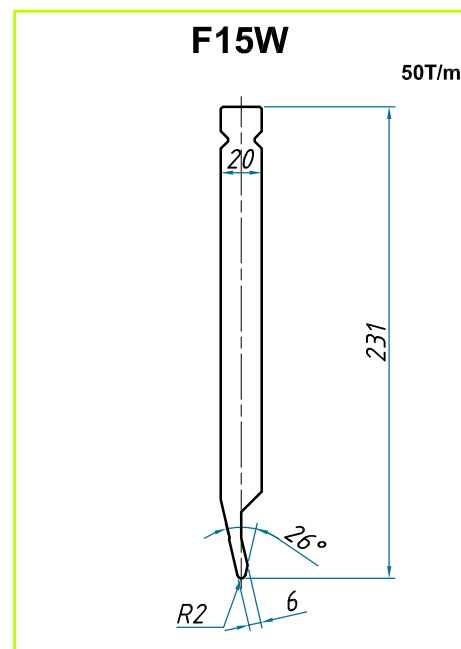
notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)



*Toutes les lames  
n'excédant pas 12.5kg  
sont prévues pour  
recevoir les poussoirs  
de sécurité.*

*Les poussoirs sont à  
commander séparément*

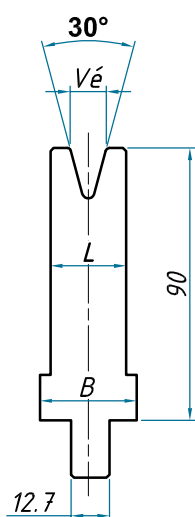
*Détail des poussoirs page 55*



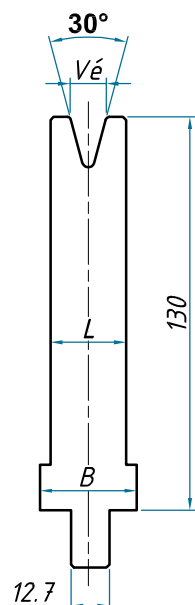
Les matrices LVD typ sont disponibles  
en long. 508 et 550 fractionnée

## Détail du fractionnement standard de matrice

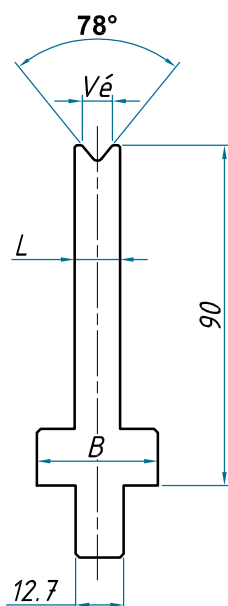
125	100	100	50	45	40	35	30	25
550								



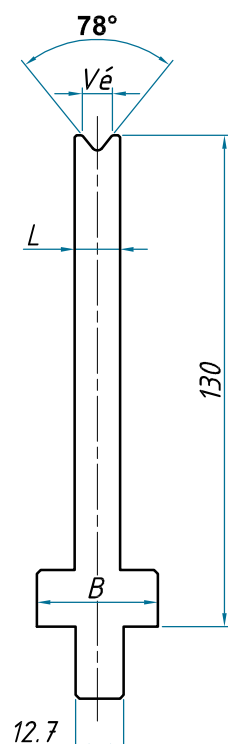
Modèle	V <sub>e</sub>	B	L	F maxi
V6/30°	6	32	16	20T/m
V8/30°	8	32	18	22T/m
V10/30°	10	32	25	30T/m
V12/30°	12	32	32	38T/m
V16/30°	16	40	32	38T/m
V20/30°	20	40	40	38T/m
V24/30°	24	45	45	55T/m
V30/30°	30	70	70	60T/m
V40/30°	40	75	75	60T/m
V50/30°	50	95	95	78T/m



Modèle	V <sub>e</sub>	B	L	F maxi
V6/30°	6	32	16	20T/m
V8/30°	8	32	18	22T/m
V10/30°	10	32	25	30T/m
V12/30°	12	32	32	38T/m
V16/30°	16	40	32	38T/m
V20/30°	20	40	40	38T/m
V24/30°	24	45	45	55T/m
V30/30°	30	70	70	60T/m
V40/30°	40	75	75	60T/m
V50/30°	50	95	95	78T/m



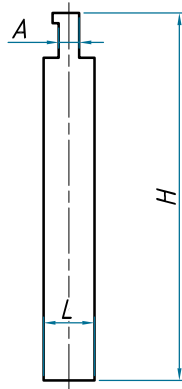
Modèle	Vé	B	L	F maxi
V6/78°	6	32	12	40T/m
V8/78°	8	32	12	40T/m
V10/78°	10	32	14	50T/m
V12/78°	12	32	18	60T/m
V16/78°	16	32	25	80T/m
V20/78°	20	32	32	100T/m
V24/78°	24	32	32	100T/m
V30/78°	30	40	40	110T/m
V40/78°	40	50	50	130T/m
V50/78°	50	70	70	150T/m
V60/78°	60	70	70	150T/m
V80/78°	80	95	95	150T/m
V100/78°	100	120	120	150T/m



Modèle	Vé	B	L	F maxi
V6/78°	6	32	12	40T/m
V8/78°	8	32	12	40T/m
V10/78°	10	32	14	50T/m
V12/78°	12	32	18	60T/m
V16/78°	16	32	25	80T/m
V20/78°	20	32	32	100T/m
V24/78°	24	32	32	100T/m
V30/78°	30	40	40	110T/m
V40/78°	40	50	50	130T/m
V50/78°	50	70	70	150T/m
V60/78°	60	70	70	150T/m
V80/78°	80	95	95	150T/m
V100/78°	100	120	120	150T/m

## H10 / H15

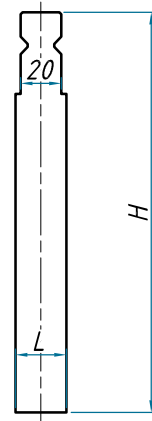
100T/m



modèle	A	L	H
H10	10	25	180
H15	15	30	225

## H10W / H15W

100T/m

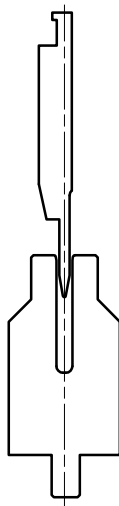


modèle	L	H
H10	25	196
H15	30	231

## Exemples d'empilage

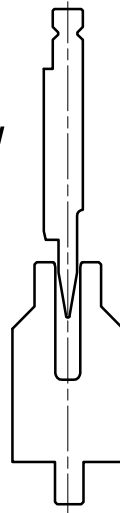
Lame  
P10.08

Matrice  
T08



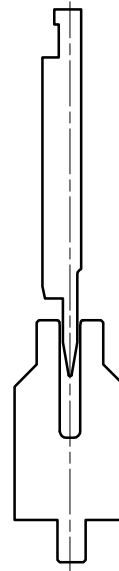
Lame  
P10.12W

Matrice  
T12



Lame  
P15.10

Matrice  
T10

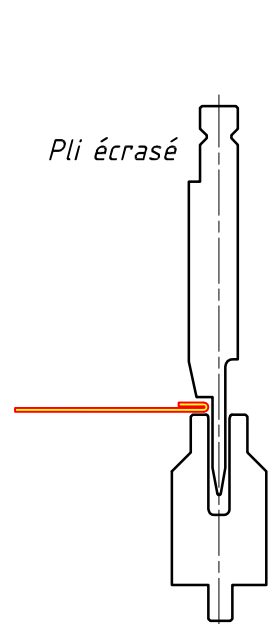
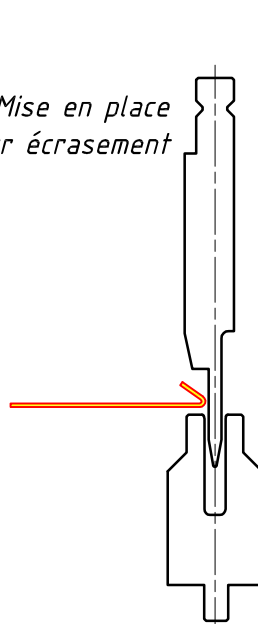
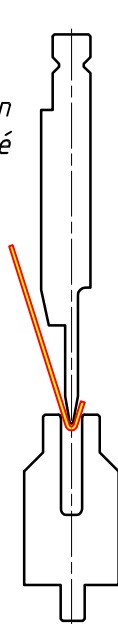
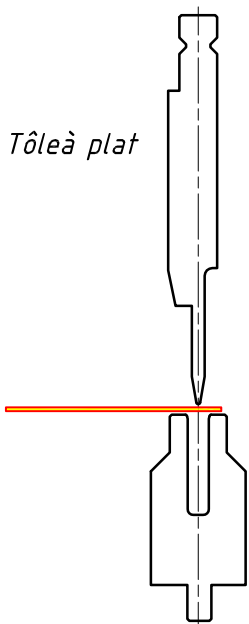


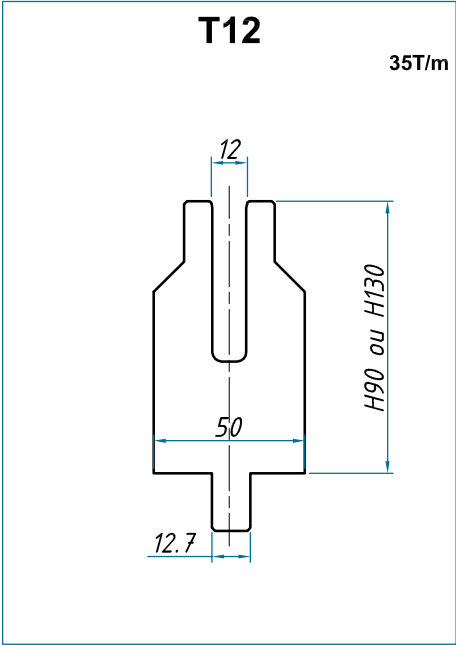
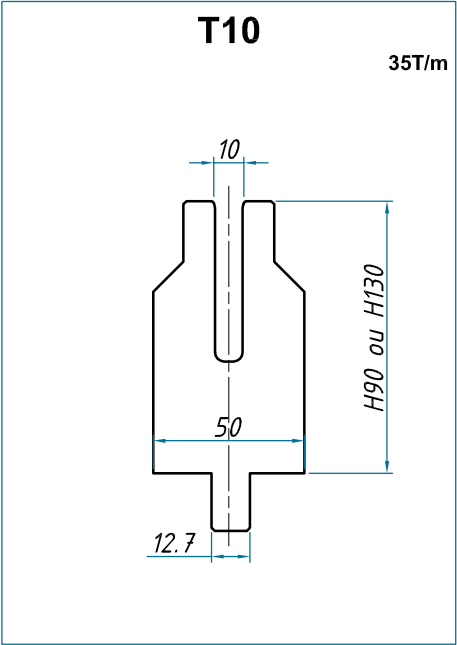
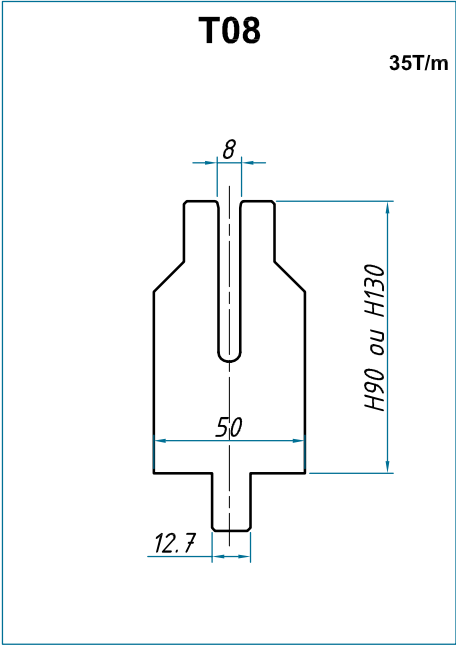
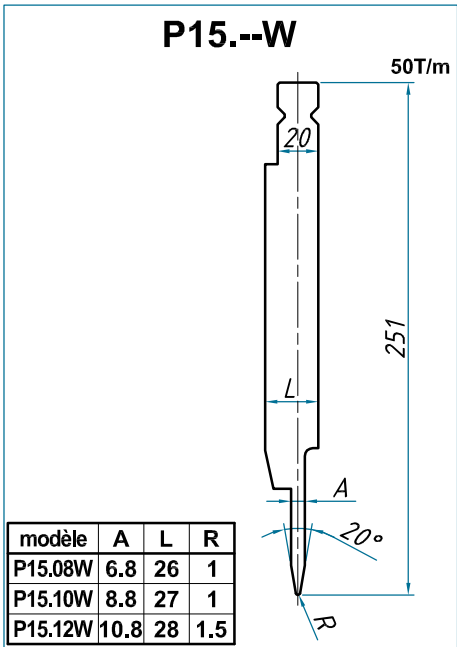
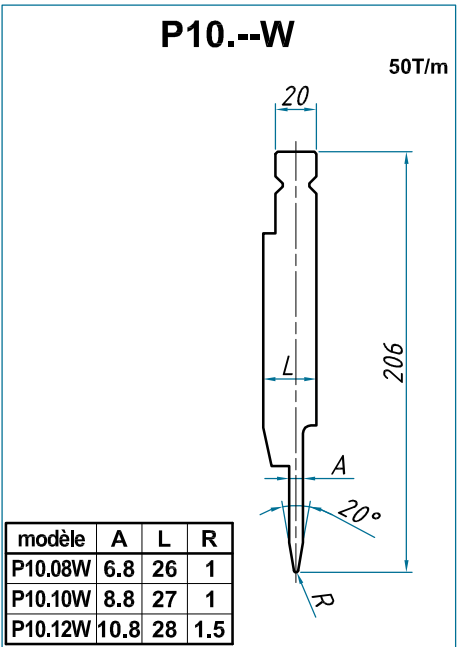
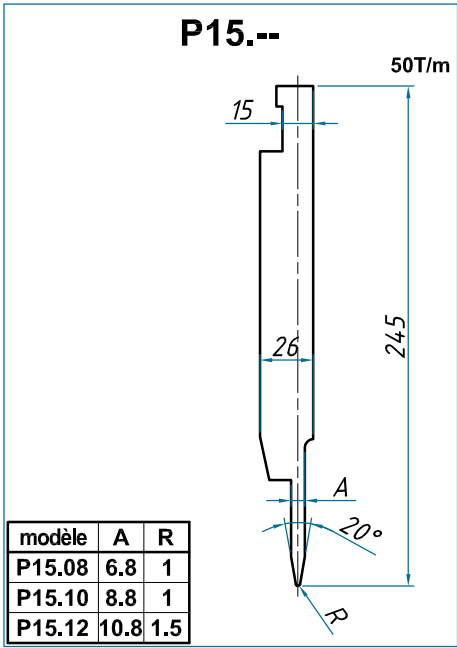
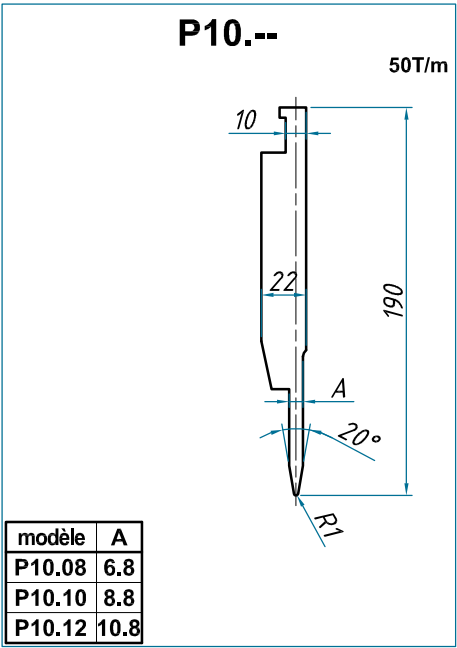
Tôle à plat

Préparation  
du pli écrasé

Mise en place  
pour écrasement

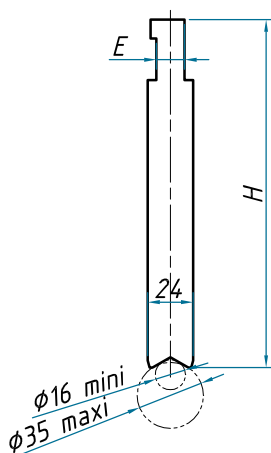
Pli écrasé





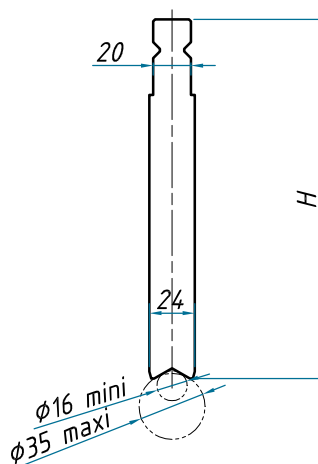


**Q10-16/35**  
**Q15-16/35**



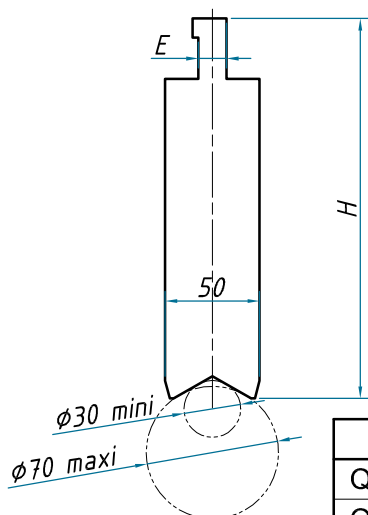
Modèle	E	H
Q10-16/35	10	174
Q15-16/35	15	184

**Q10W-16/35**  
**Q15W-16/35**



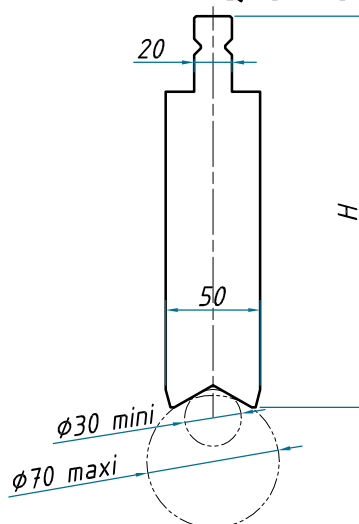
Modèle	H
Q10W-16/35	180
Q15W-16/35	190

**Q10-30/70**  
**Q15-30/70**



Modèle	E	H
Q10-30/70	10	191
Q15-30/70	15	201

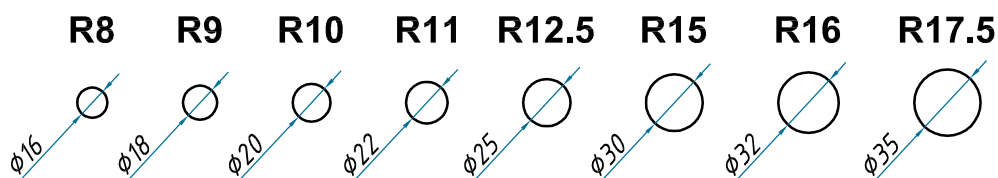
**Q10W-30/70**  
**Q15W-30/70**



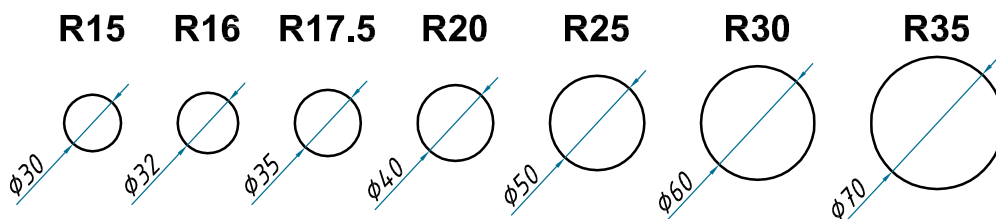
Modèle	H
Q10W-30/70	197
Q15W-30/70	207

## Règles à rayonner

Pour Q\*-16/35

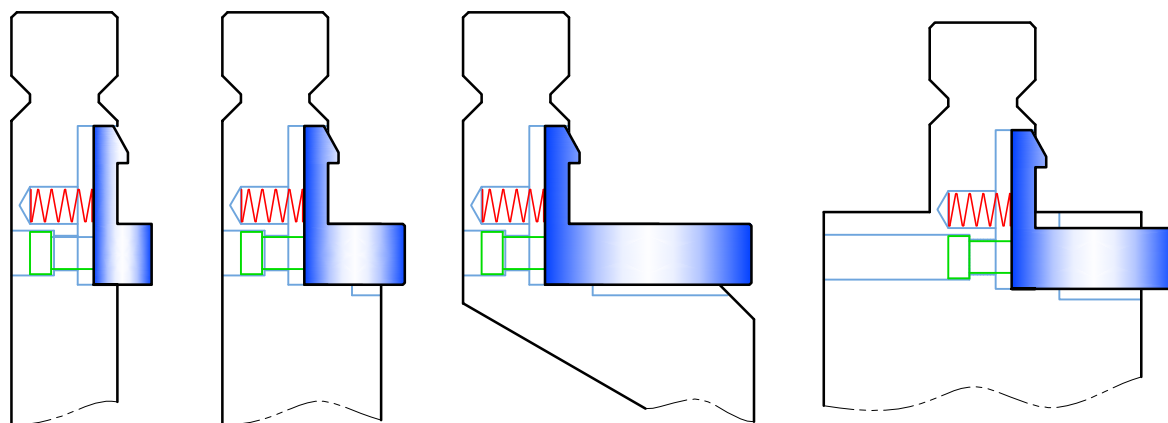


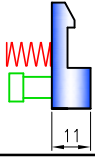
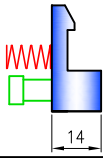
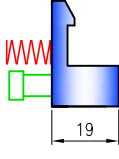
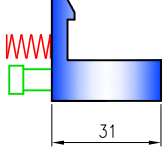
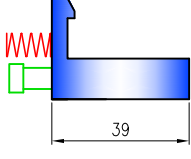
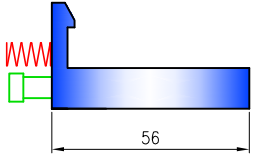
Pour Q\*-30/70



## POUSSOIRS DE SÉCURITÉ POUR POINÇONS TYPE LVD

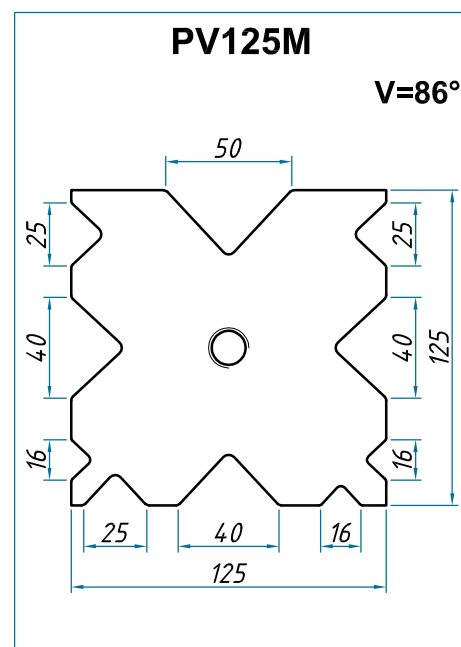
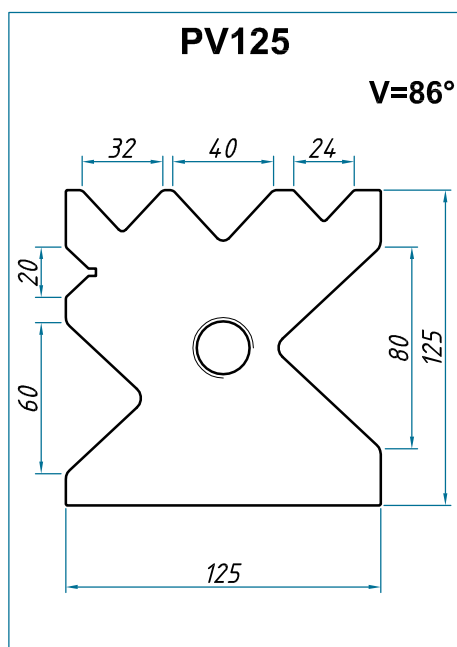
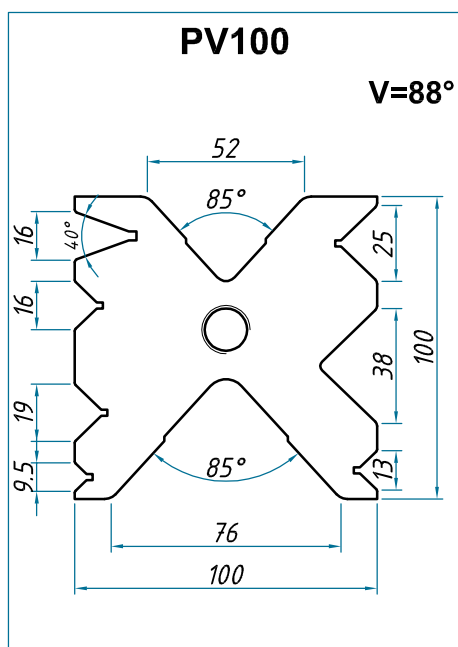
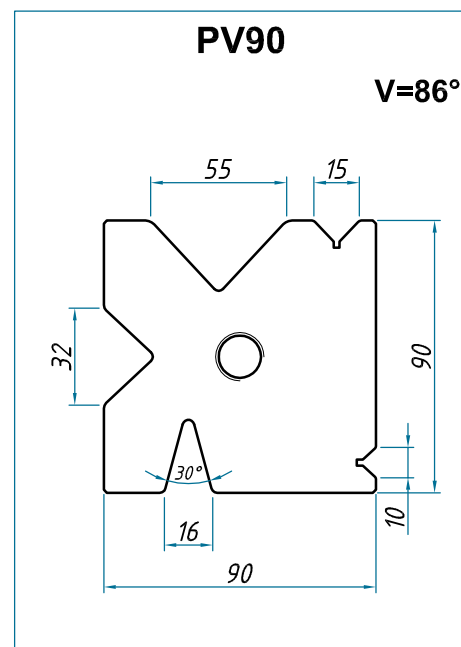
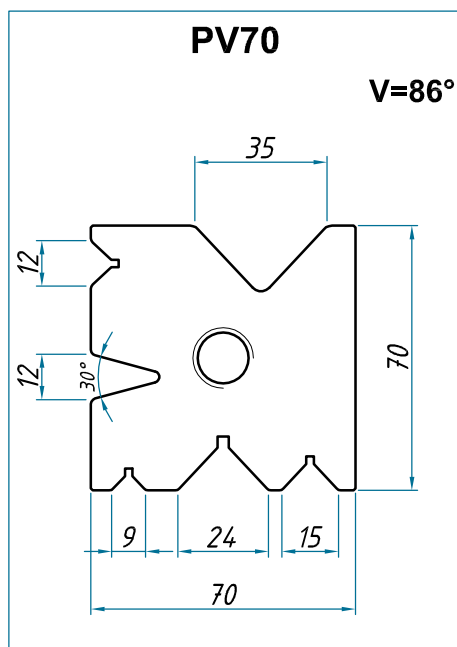
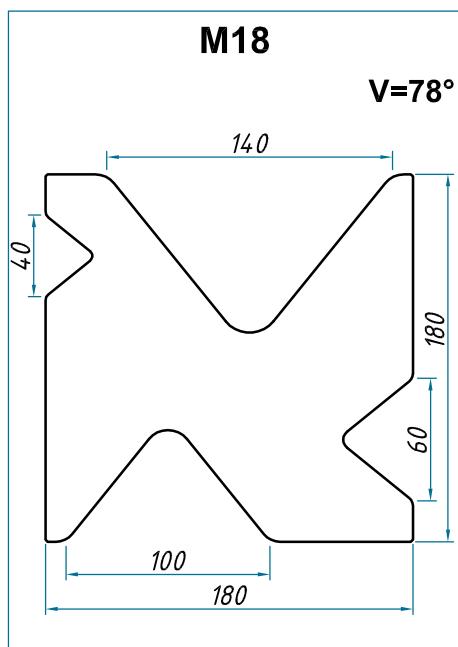
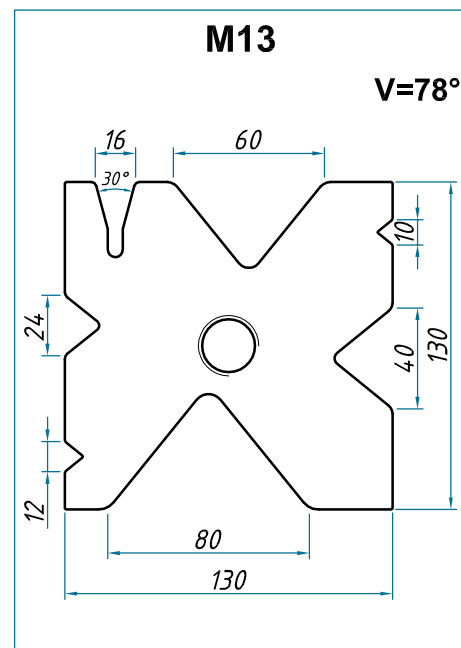
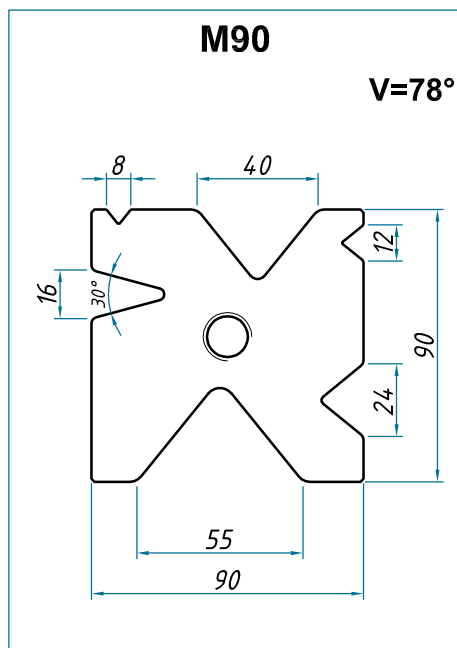
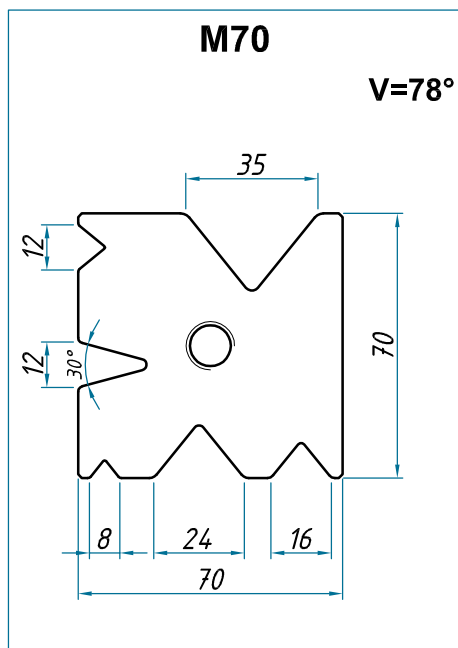
PERMETTANT DE MONTER ET DÉMONTER LE POINÇON VERTICALEMENT  
POUR POINÇON DONT LE POIDS EST INFÉRIEUR À 12,5 KG  
ET DONT LA LONGUEUR EST DE 100 MM MAXI



MODÈLE DE POUSOIR	MODÈLE DE LAME
SK001 	F10W - R10W - H10W F15W - R15W
SK002 	E10W - J10W H15W - J15W Q10W 16/35 - Q15W 16/35
SK003 	P10W E15W - P15W
SK004 	C10W - C15W Q10W 30/70 - Q15W 30/70
SK005 	D10W - D15W
SK006 	

# Multivés LVD Typ - HACO Typ

notre catalogue en ligne  
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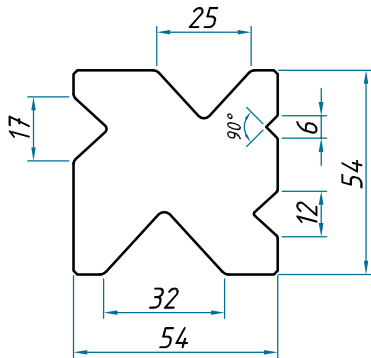


# Multivés COLLY Typ

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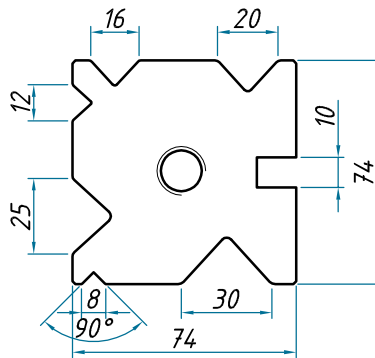
**14.355**

**V=85°**



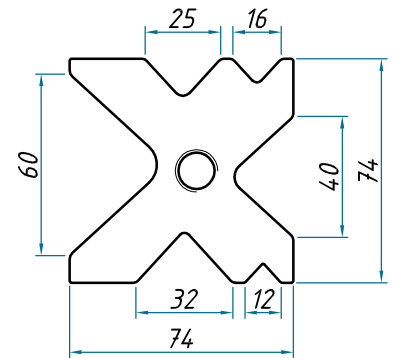
**14.414**

**V=85°**



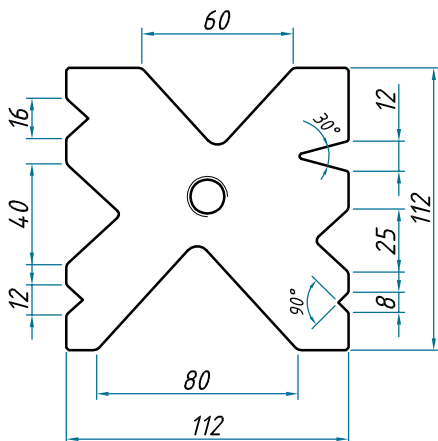
**8.11.14.130**

**V=85°**



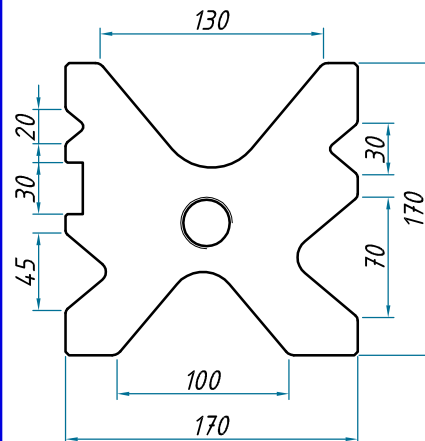
**14.518**

**V=85°**



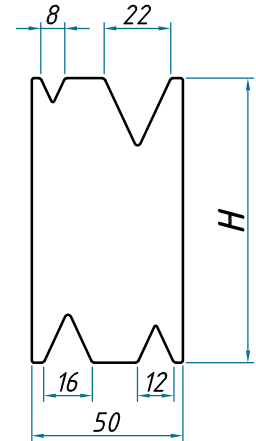
**14.707**

**V=80°**



**6.14.767**

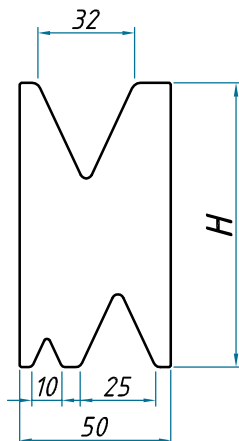
**V=50°**



modèle	14.767/1	14.767/2	14.767/3
H	74	94	112

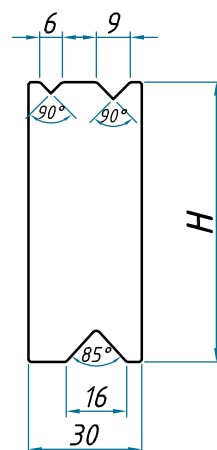
**20.710**

**V=50°**



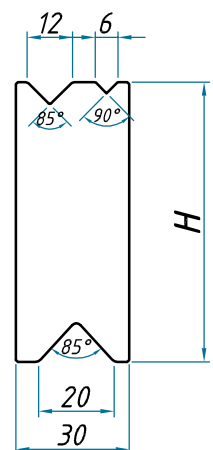
modèle	20.710/1	20.710/2
H	94	112

**20.008**



modèle	20.008/1	20.008/2	20.008/3
H	54	74	94

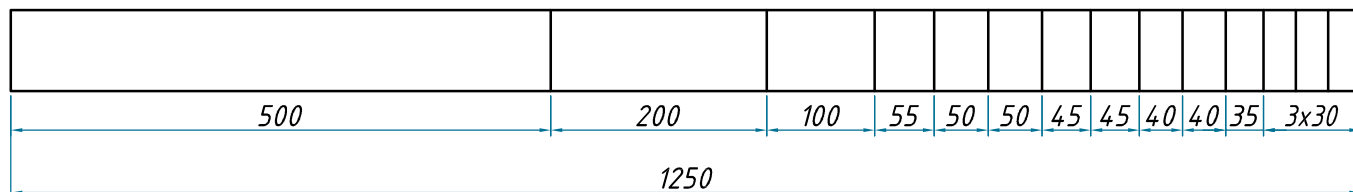
**20.008**



modèle	20.008/4	20.008/5	20.008/6
H	54	74	94

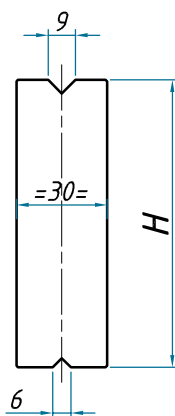
*Les matrices Colly typ sont disponibles  
en long. 1020, 1250 et 1250 fractionnée*

## Détail du fractionnement standard de matrice



**30.541**

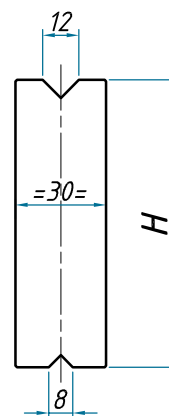
**V=90°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.601**

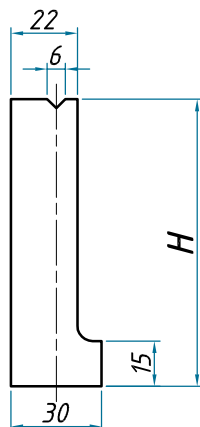
**V=90°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.661**

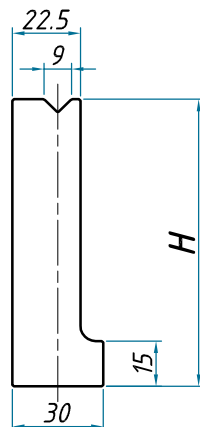
**V=90°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.721**

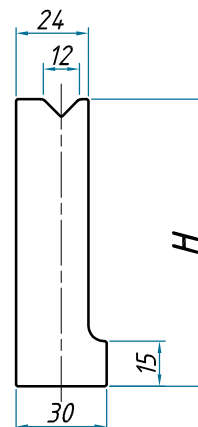
**V=90°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.781**

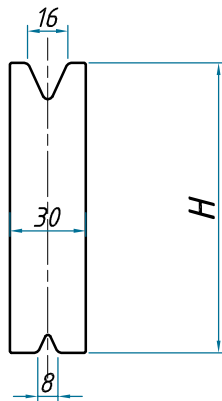
**V=90°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.181**

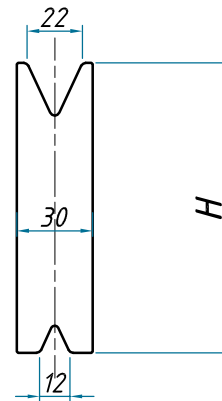
**V=50°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.241**

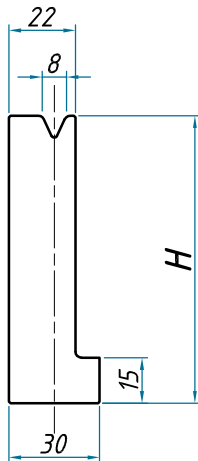
**V=50°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.001**

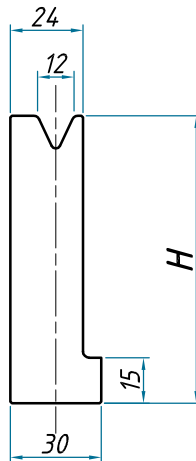
**V=50°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.061**

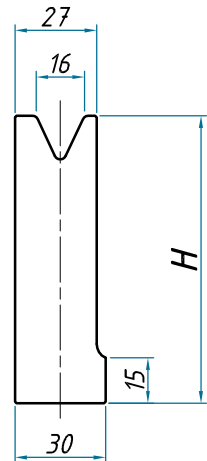
**V=50°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.121**

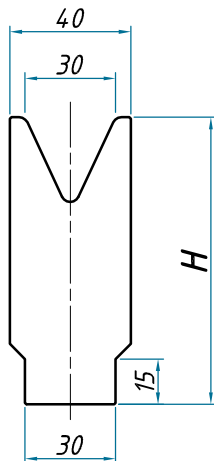
**V=50°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.301**

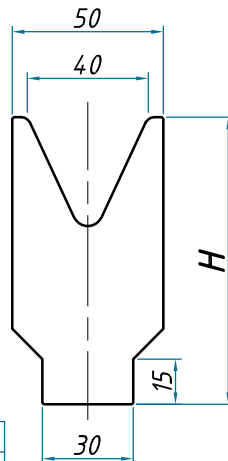
**V=50°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**30.361**

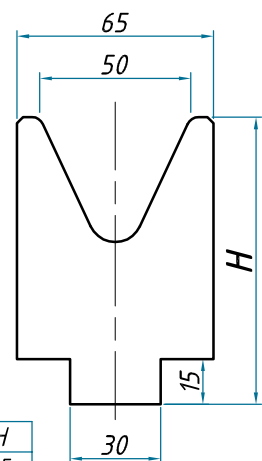
**V=50°**



Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

**31.201**

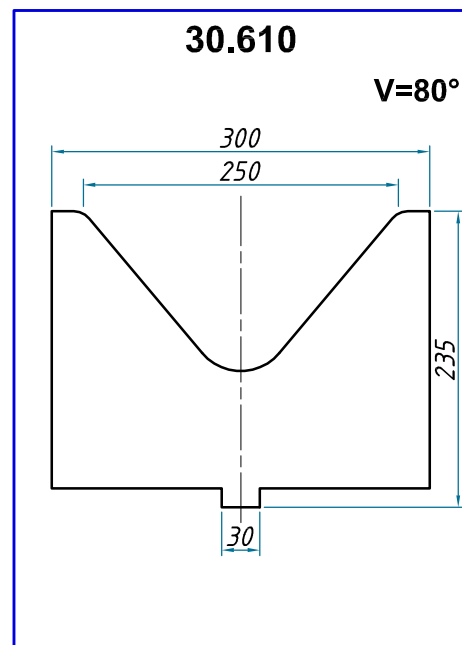
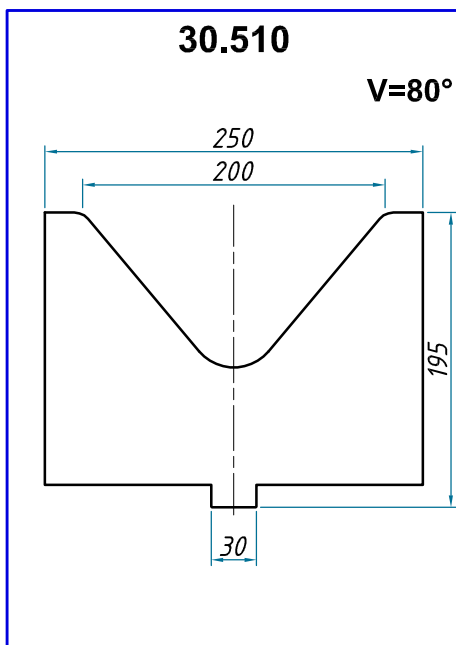
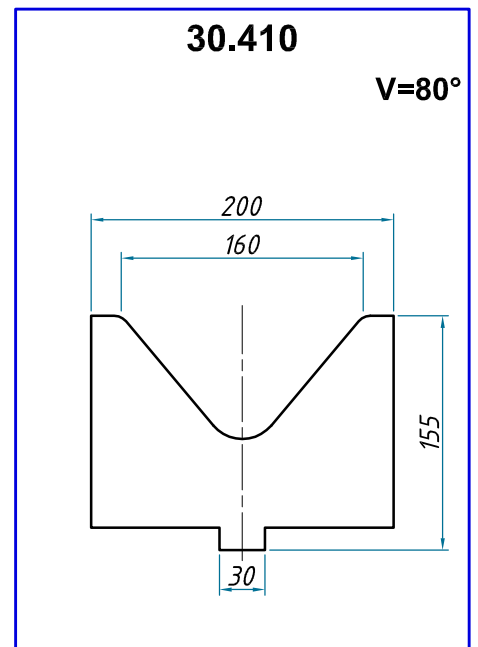
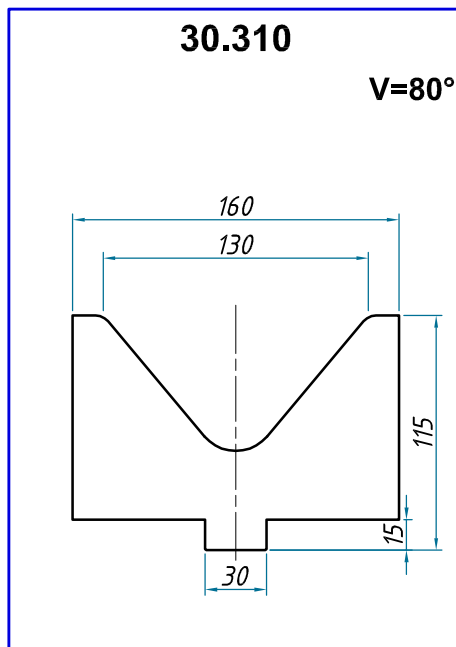
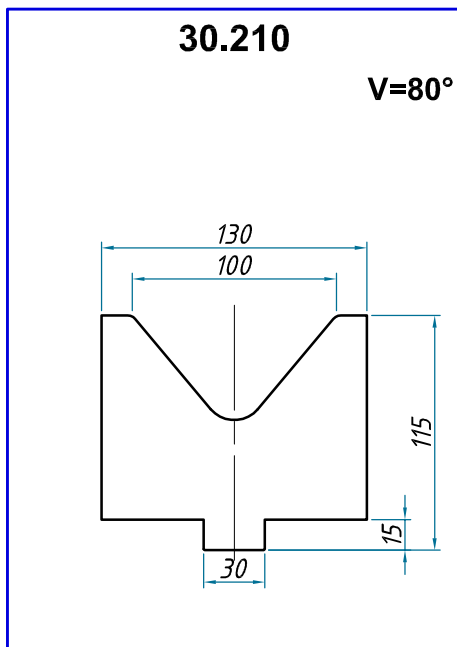
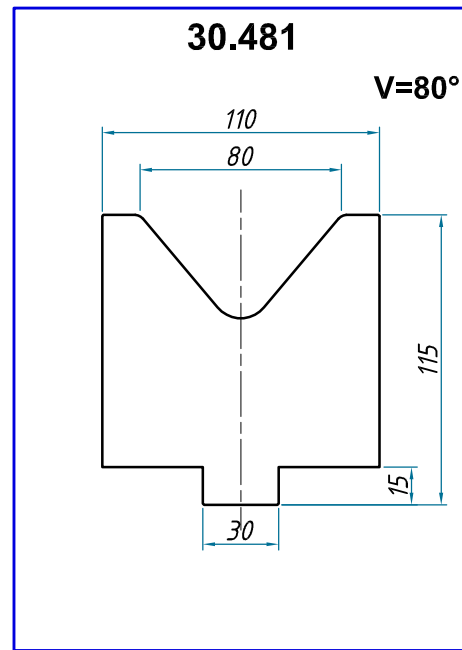
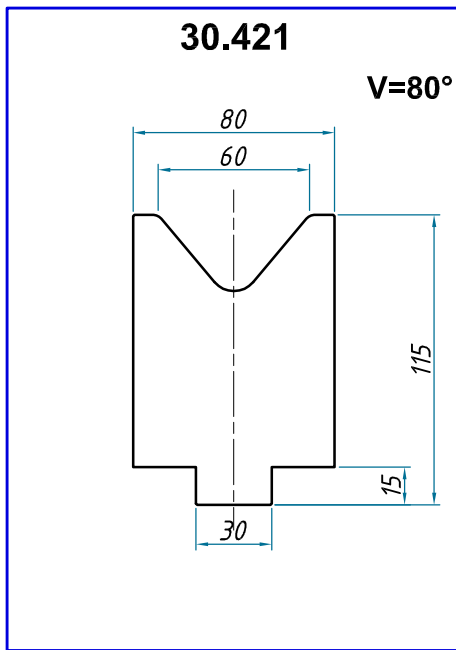
**V=50°**



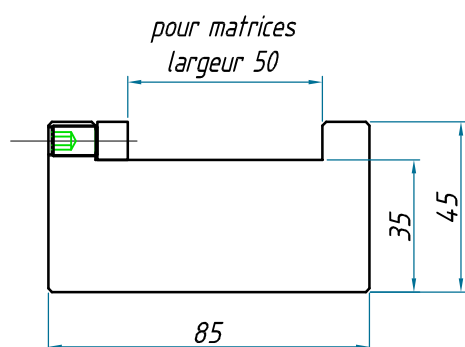
Rep.	H
Rep. 1	95
Rep. 2	115
Rep. 3	135

# COLLY Typ

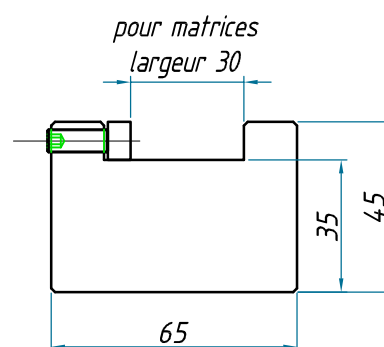
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**8.14.053**

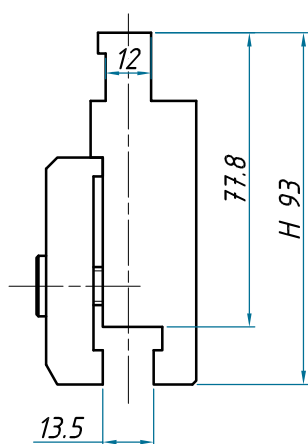


**20.936**



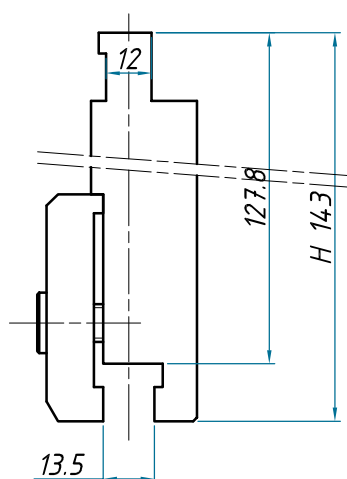
**4736**

90T/m



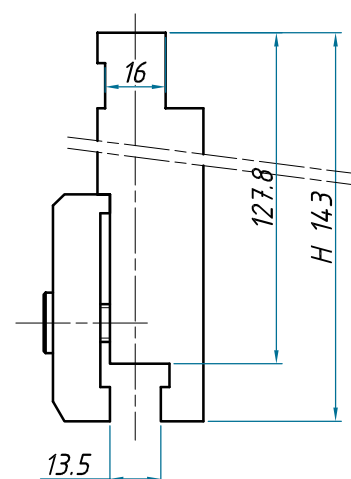
**4406**

90T/m



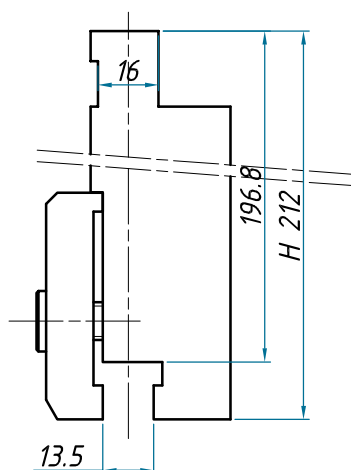
**4407**

100T/m



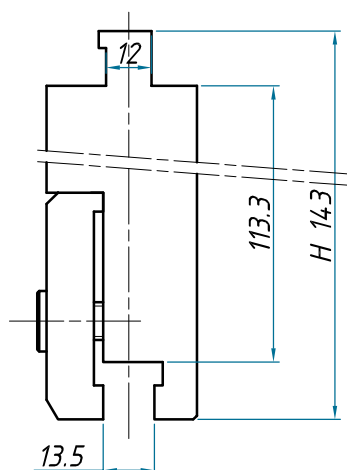
**4463**

100T/m



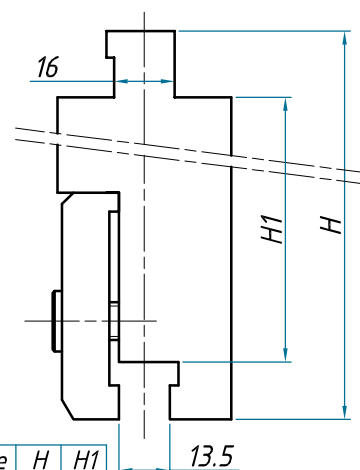
**4776**

150T/m



**4963 / 4965**

150T/m

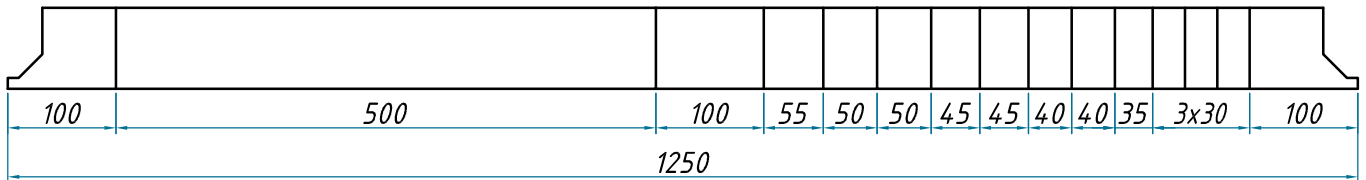


Modèle	H	H1
4963	143	110.3
4965	212	179.3



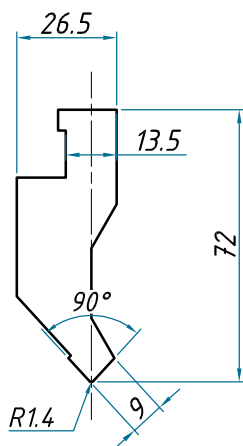
*Les lames Colly typ sont disponibles  
en long. 1020, 1250 et 1250 fractionnée*

## Détail du fractionnement standard de lame



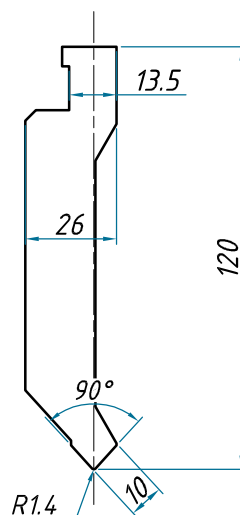
**14.411**

130T/m



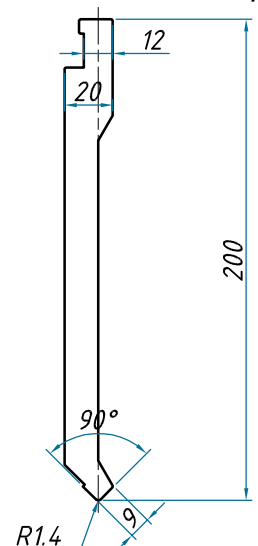
**1.14.715**

130T/m



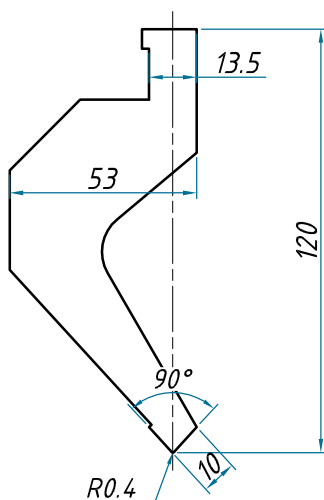
**1450**

100T/m



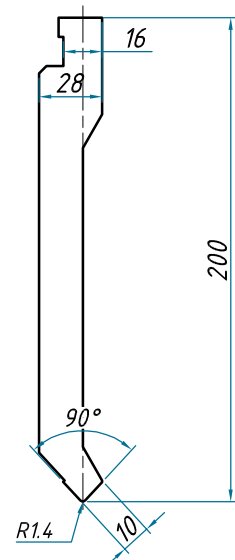
**3.14.515**

90T/m



**14.421**

130T/m

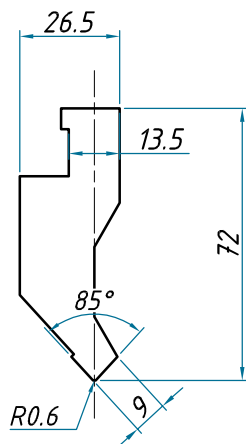


# COLLY Typ

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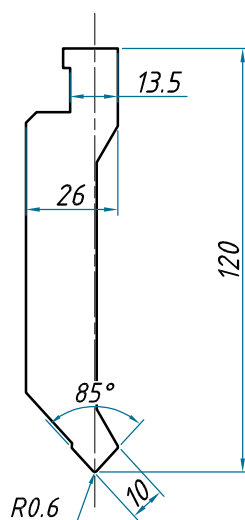
**14.412**

130T/m



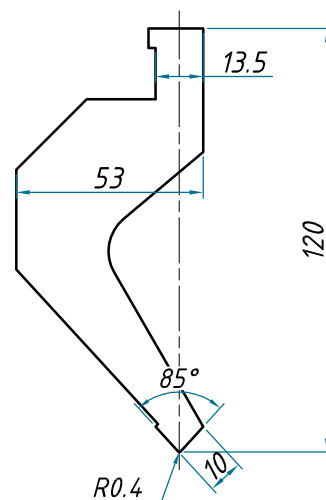
**1.14.716**

130T/m



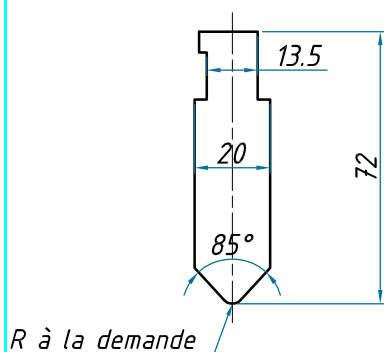
**3.14.516**

90T/m



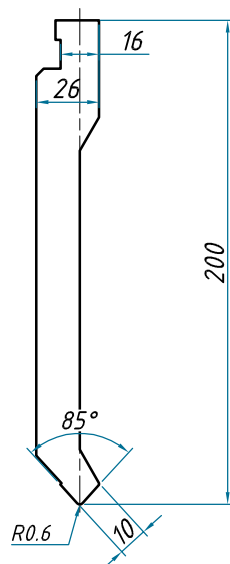
**14.420**

130T/m



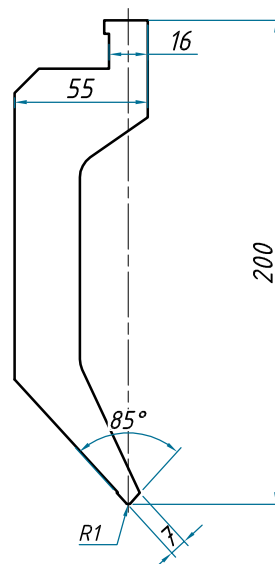
**14.422**

130T/m



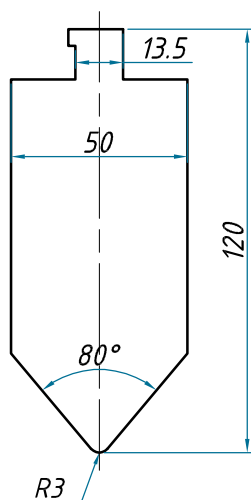
**1.14.010**

130T/m



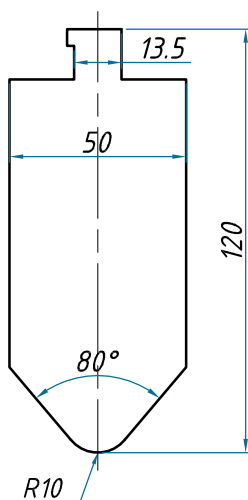
**14.758**

160T/m



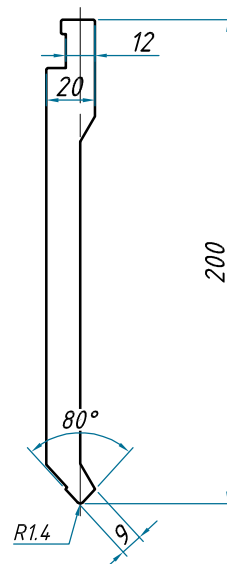
**14.705**

160T/m



**14.451**

100T/m

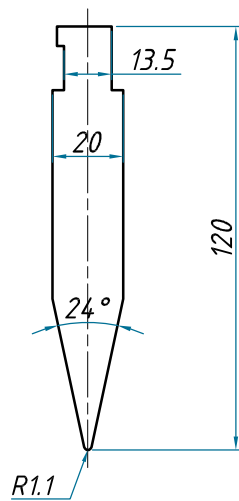


# COLLY Typ

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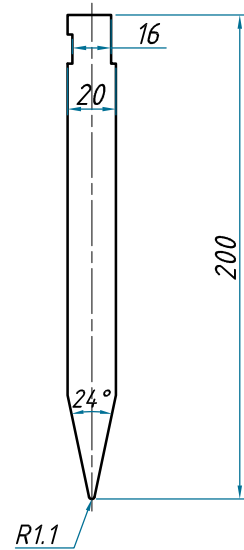
**1.14.526/24°**

100T/m



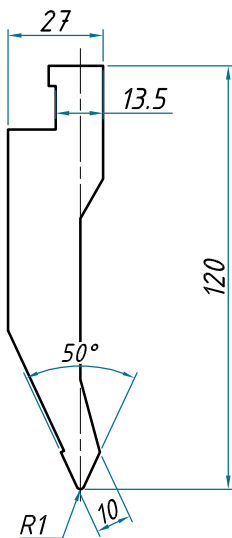
**10.001/24°**

100T/m



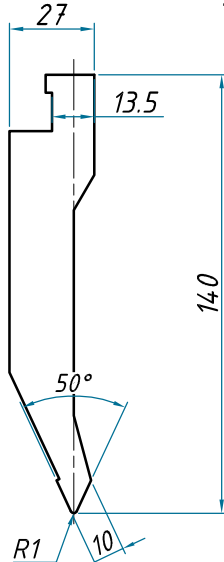
**10.697/50°**

100T/m



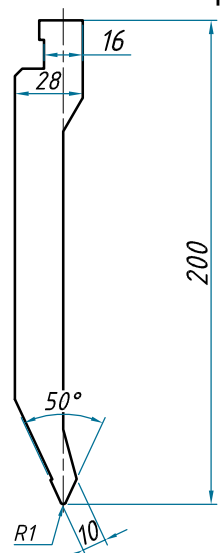
**10.593/50°**

100T/m



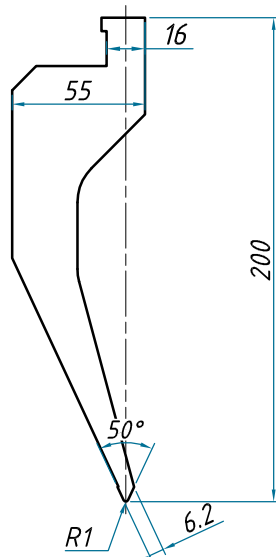
**10.700/50°**

100T/m



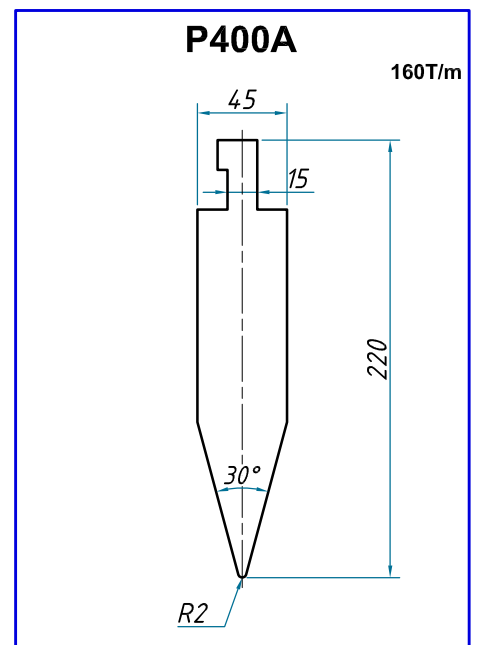
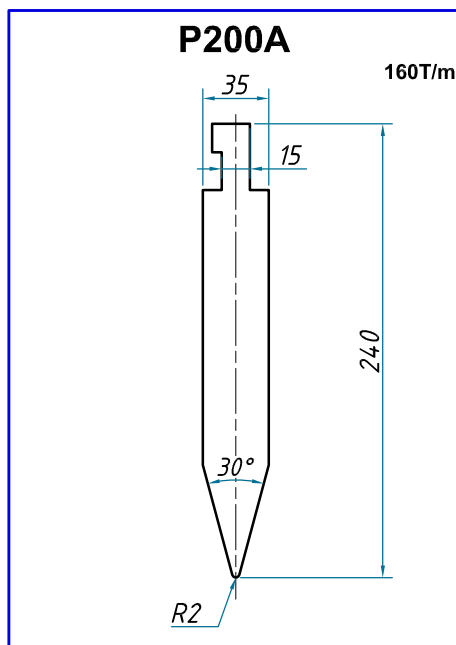
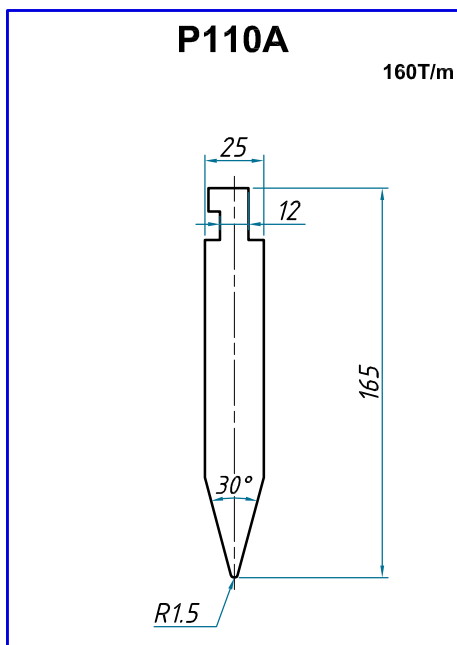
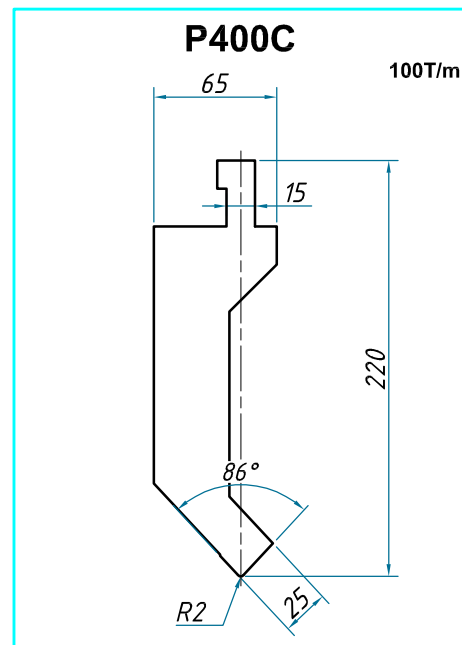
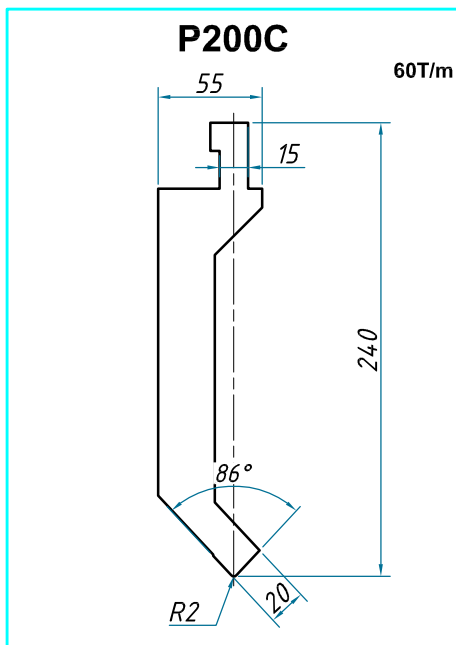
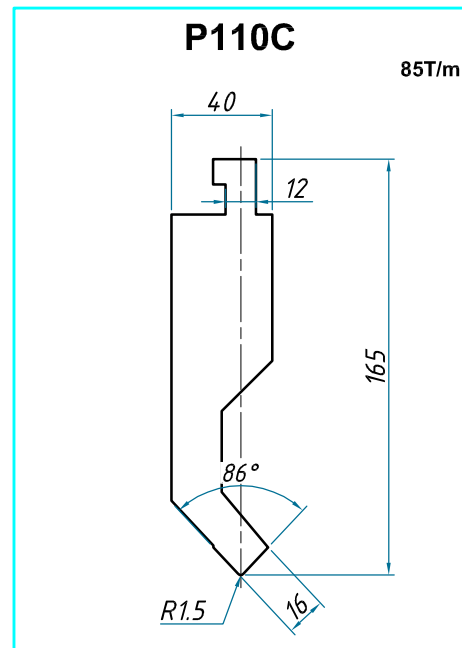
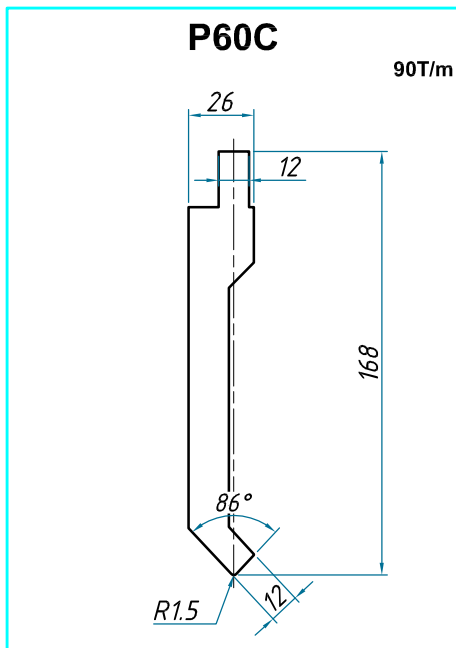
**1.14.210/50°**

60T/m



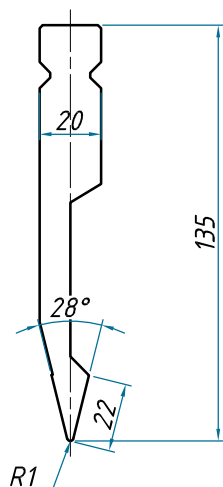
# HACO Typ

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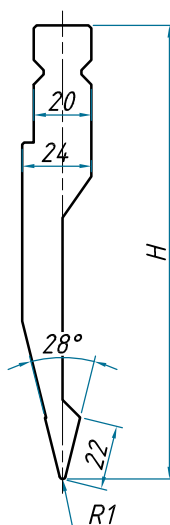
## WL-001

100T/m



## WL-0\*1

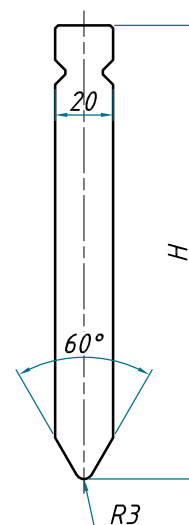
Modèle	H	T/m
WL-011	157	100
WL-021	200	70
WL-031	237	60



## WL-0\*4

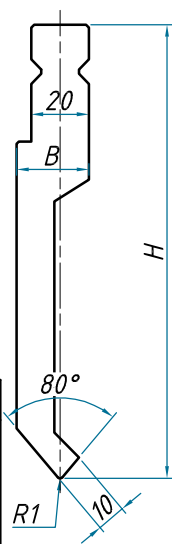
160T/m

Modèle	H
WL-004	135
WL-014	157
WL-024	200
WL-034	237



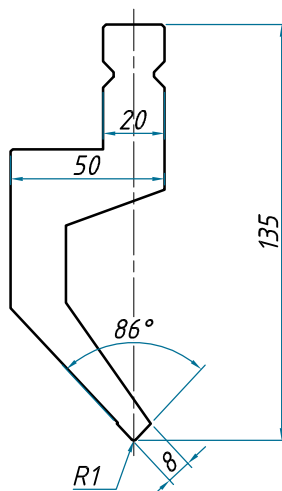
## WL-0\*2

Modèle	H	B	T/m
WL-002	135	25	100
WL-012	157	25	100
WL-022	200	30	80
WL-032	237	30	80



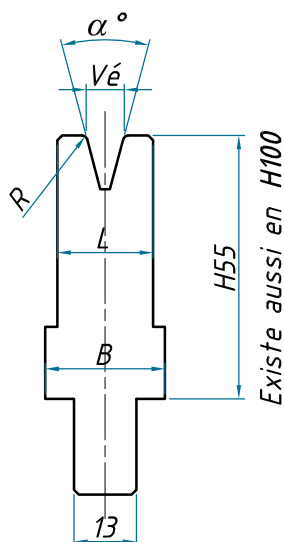
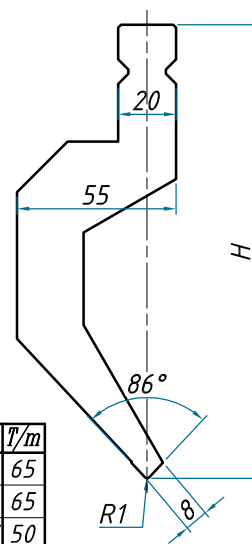
## WL-003

65T/m



## WL-0\*3

Modèle	H	T/m
WL-013	157	65
WL-023	200	65
WL-033	237	50

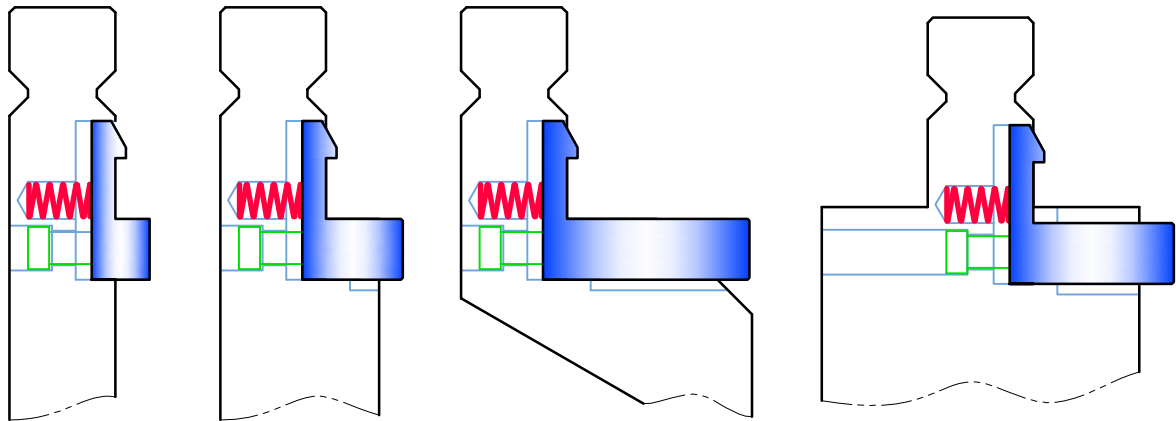


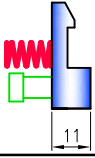
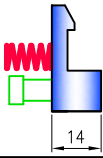
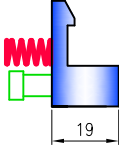
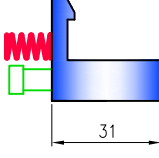
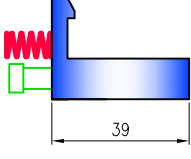
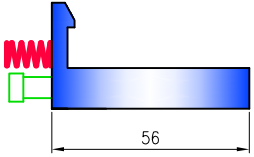
Modèle	Vé	$\alpha^\circ$	R	B	L	F maxi
WM-061	6	30°	R1	25	16	40T/m
WM-051	8	30°	R1	25	16	40T/m
WM-052	12	30°	R1	25	20	35T/m
WM-063	20	30°	R2	35	35	45T/m
WM-054	24	30°	R2.5	40	40	45T/m
WM-021	6	86°	R1	25	16	40T/m
WM-010	8	86°	R1	25	16	40T/m
WM-011	12	86°	R1	25	20	50T/m
WM-023	20	86°	R2	30	30	85T/m

D'autres angles et vés sur demande

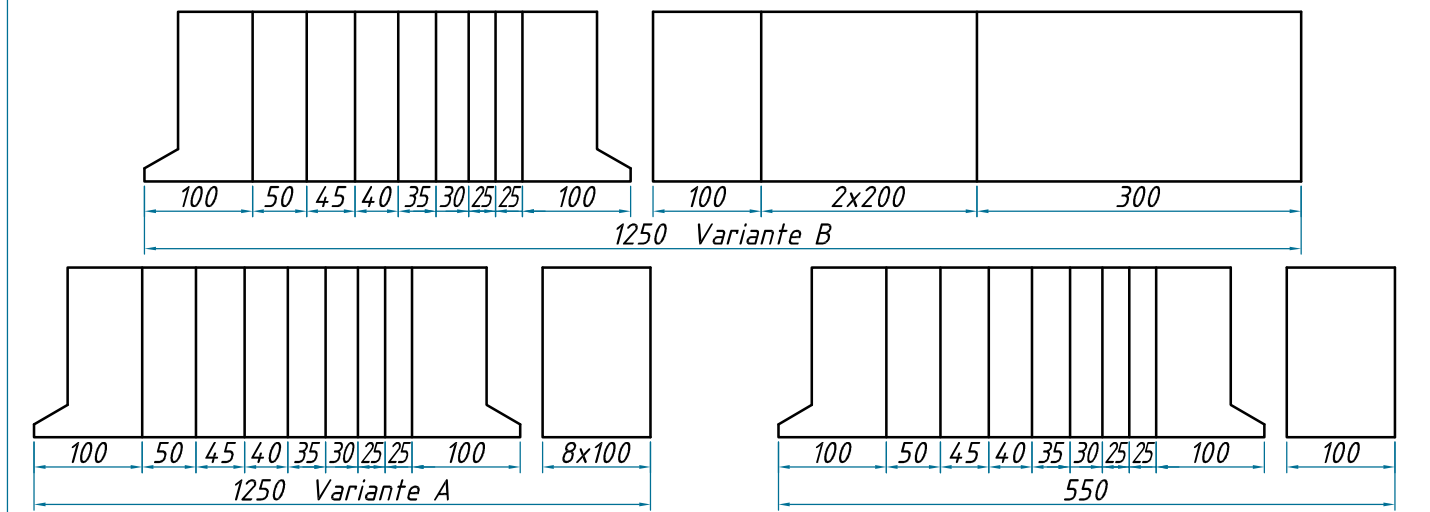
## POUSSOIRS DE SÉCURITÉ POUR POINÇONS TYPE WILA

PERMETTANT DE MONTER ET DÉMONTER LE POINÇON VERTICALEMENT  
POUR POINÇON DONT LE POIDS EST INFÉRIEUR À 12,5 KG  
ET DONT LA LONGUEUR EST DE 100 MM MAXI



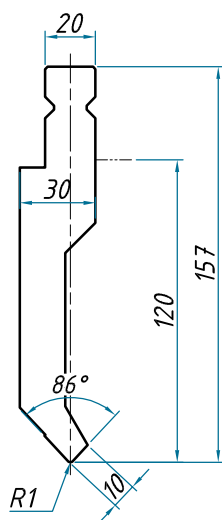
MODÈLE DE POUSOIR	MODÈLE DE LAME
<b>SK001</b> 	<b>WL-001 WL-004 WL-014</b> <b>WL-024 WL-034</b>
<b>SK002</b> 	<b>WL-002 WL-011 WL-012</b> <b>WL-021 WL-031</b>
<b>SK003</b> 	<b>WL-022 WL-032</b>
<b>SK004</b> 	-
<b>SK005</b> 	<b>WL-003 WL-013</b> <b>WL-023 WL-033</b>
<b>SK006</b> 	-

*Les lames Trumpf typ sont disponibles  
en long. 500, 550 fractionnée et 1250 fractionnée (2 variantes)*



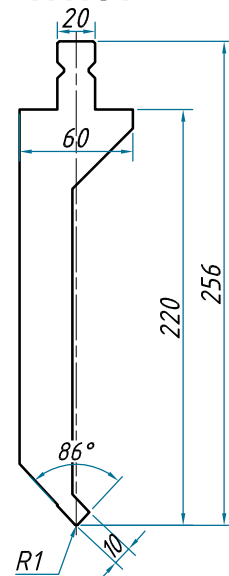
## TR101 K

100T/m



## TR101

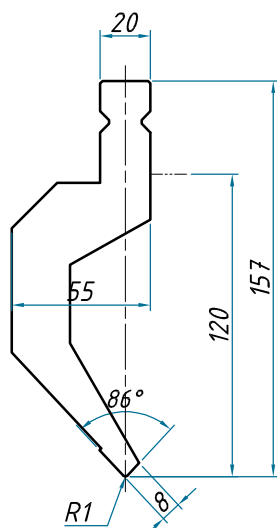
80T/m



*Toutes les lames  
n'excédant pas 12.5kg  
sont prévues pour  
recevoir les poussoirs  
de sécurité.*

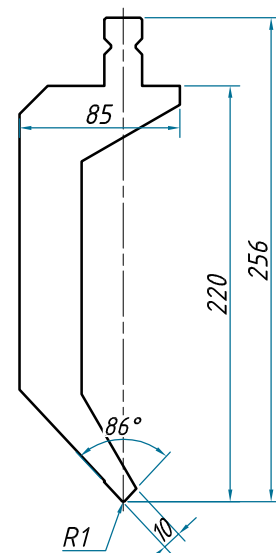
## TR100 K

60T/m

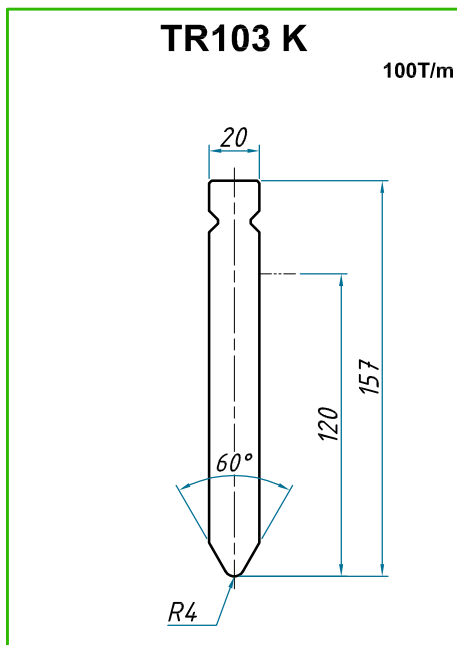
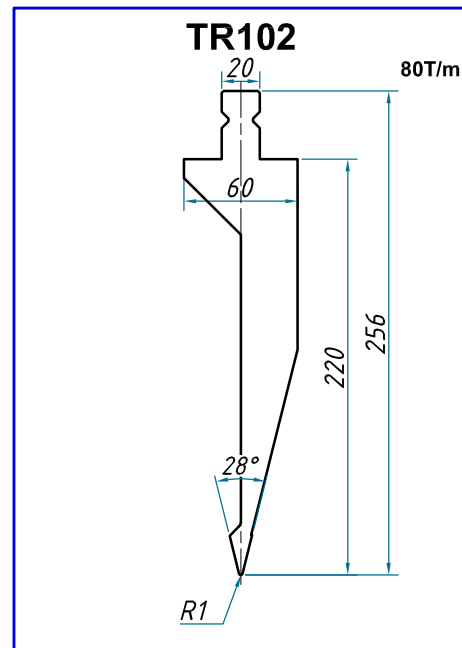
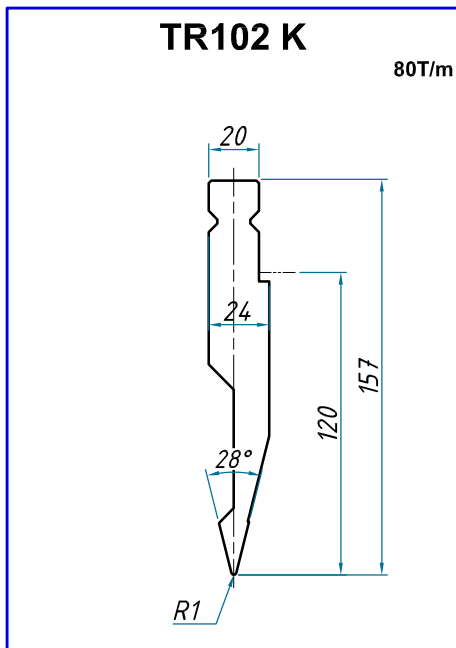


## TR100

80T/m



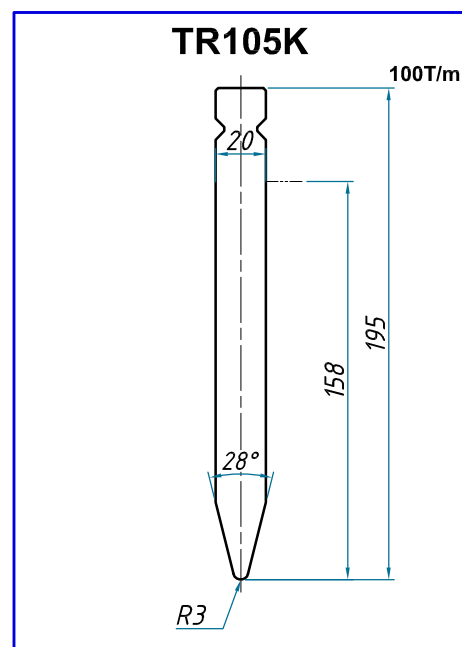
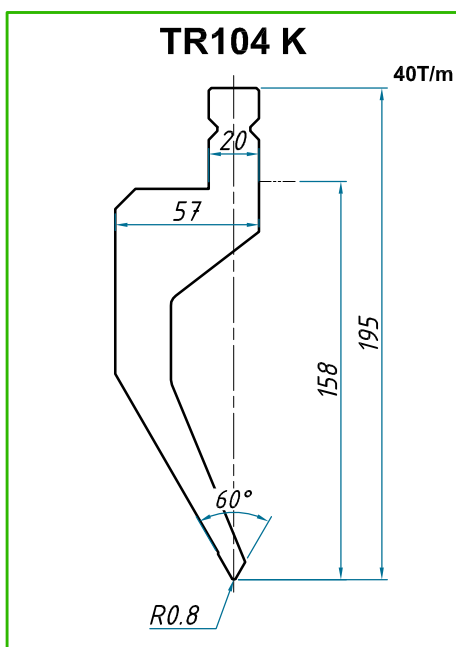
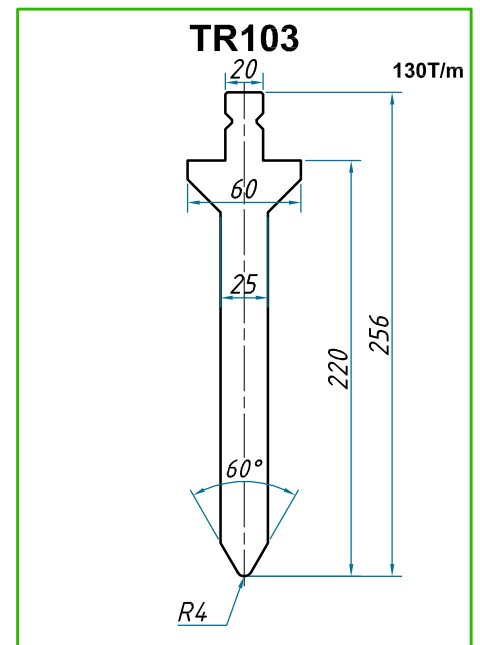
*Les poussoirs sont à  
commander séparément  
Détail des poussoirs page 71*



*Toutes les lames  
n'excédant pas 12.5kg  
sont prévues pour  
recevoir les poussoirs  
de sécurité.*

*Les poussoirs sont à  
commander séparément*

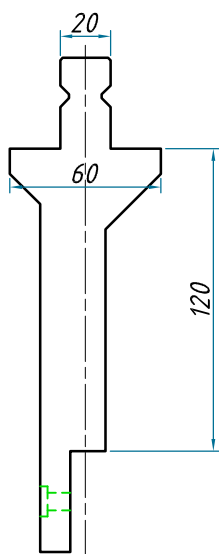
*Détail des poussoirs page 71*



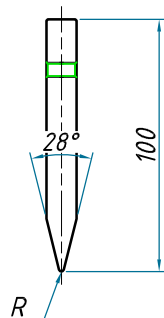


## TR109

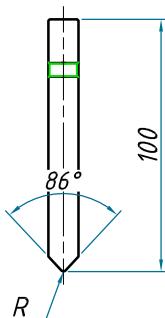
100T/m



### TR120/28°



### TR120/86°

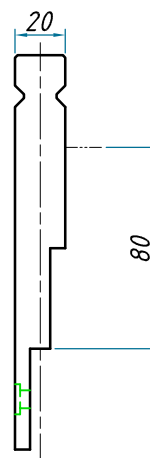


Modèle	R
TR120/28°-R0.3	<b>0.3</b>
TR120/28°-R1.0	<b>1.0</b>
TR120/28°-R1.6	<b>1.6</b>
TR120/28°-R2.0	<b>2.0</b>
TR120/28°-R3.0	<b>3.0</b>
TR120/28°-R4.0	<b>4.0</b>
TR120/28°-R5.0	<b>5.0</b>
TR120/28°-R6.0	<b>6.0</b>

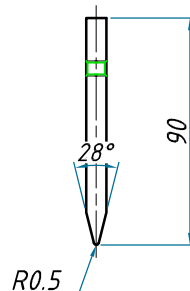
Modèle	R
TR120/86°-R1.0	<b>1.0</b>
TR120/86°-R2.0	<b>2.0</b>
TR120/86°-R3.0	<b>3.0</b>
TR120/86°-R4.0	<b>4.0</b>
TR120/86°-R5.0	<b>5.0</b>
TR120/86°-R6.0	<b>6.0</b>

## TR80

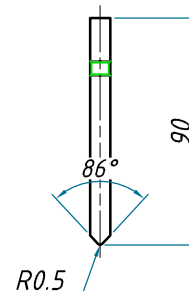
50T/m



### TR190/28°

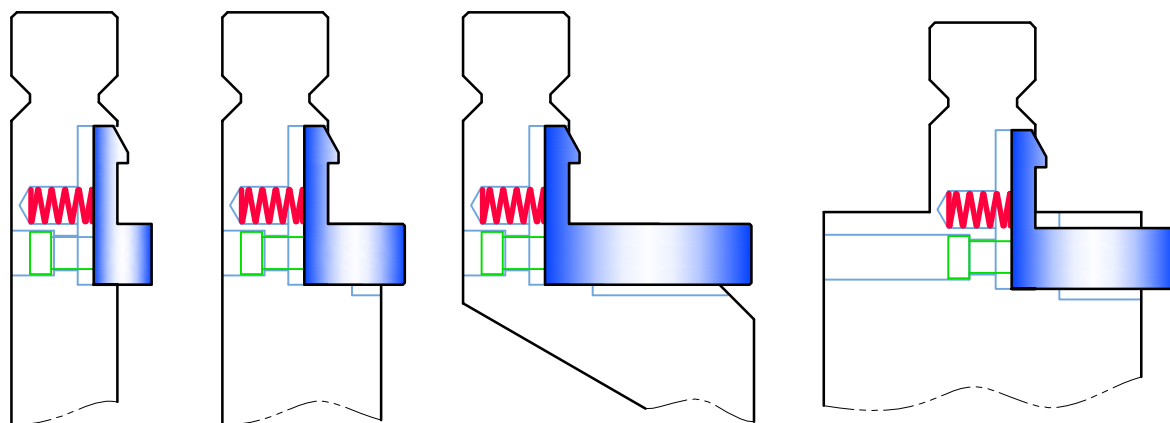


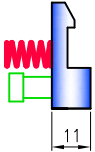
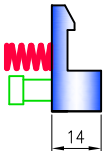
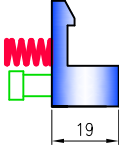
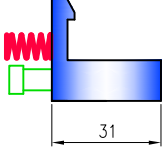
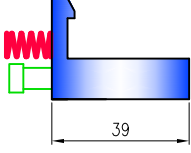
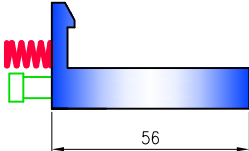
### TR191/86°



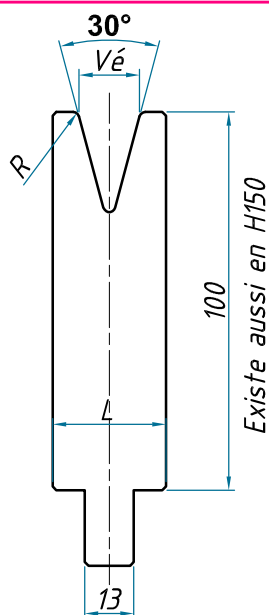
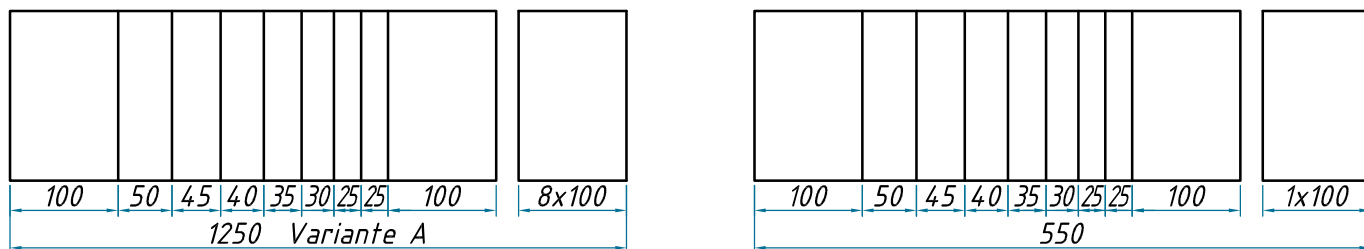
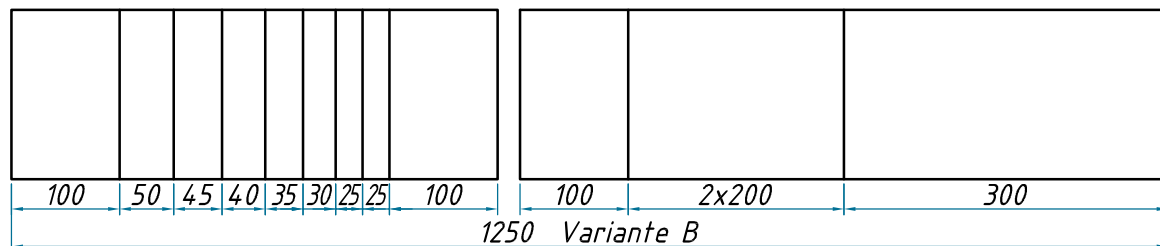
## POUSSOIRS DE SÉCURITÉ POUR POINÇONS TYPE TRUMPF

PERMETTANT DE MONTER ET DÉMONTER LE POINÇON VERTICALEMENT  
POUR POINÇON DONT LE POIDS EST INFÉRIEUR À 12,5 KG  
ET DONT LA LONGUEUR EST DE 100 MM MAXI



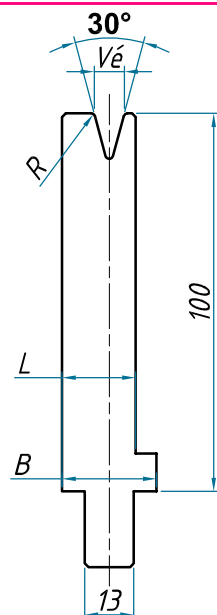
MODÈLE DE POUSSOIR	MODÈLE DE LAME
SK001 	TR103K - TR105K - TR80
SK002 	TR102K
SK003 	TR101K - TR108K
SK004 	TR101 - TR102 - TR103 TR109 - TR110-140 TR108 - TR110-240
SK005 	TR100K
SK006 	TR100 - TR104K

Les matrices Trumpf typ sont disponibles  
en long. 500, 550 fractionnée et 1250 fractionnée (2 variantes)

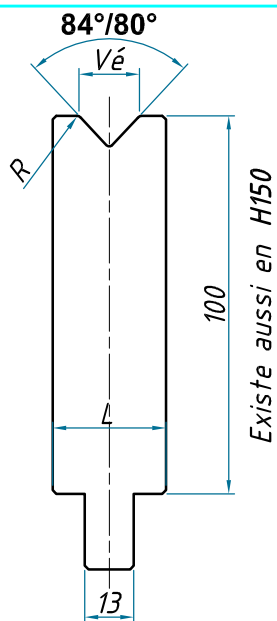


Modèle	Vé	R	L	F' maxi
TM V6/30°	6	R0.6	20	50T/m
TM V8/30°	8	R1	20	40T/m
TM V10/30°	10	R1	20	40T/m
TM V12/30°	12	R1	25	40T/m
TM V16/30°	16	R1.6	30	45T/m
TM V20/30°	20	R2	35	50T/m
TM V24/30°	24	R2.5	40	50T/m
TM V30/30°	30	R3	55	50T/m

Autres rayons sur demande

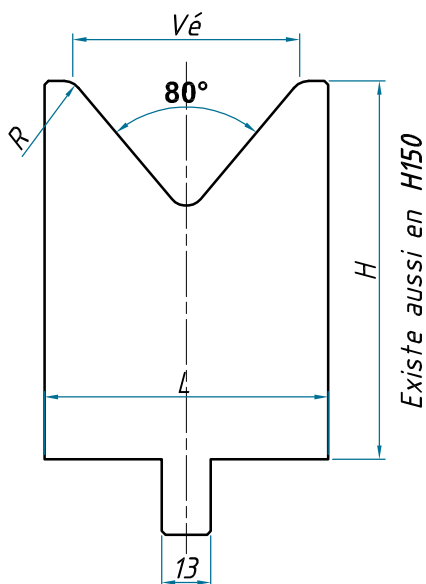


Modèle	Vé	R	B	L	F' maxi
TM V4S/30°	4	R0.6	20	15	20T/m
TM V5S/30°	5	R0.6	20	15	20T/m
TM V6S/30°	6	R0.6	20	16	30T/m
TM V8S/30°	8	R1	20	17	30T/m
TM V10S/30°	10	R1	20	18	30T/m
TM V12S/30°	12	R1	25	21.5	30T/m



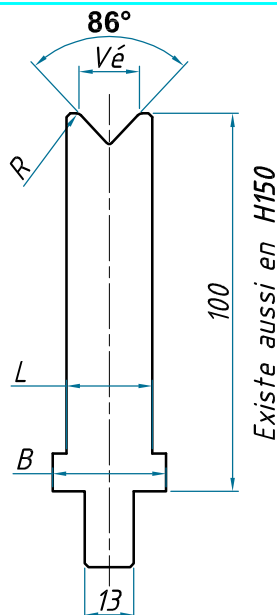
Modèle	Vé	R	L	F' maxi
TM V6/84°	6	R0.6	20	100T/m
TM V8/84°	8	R0.8	20	100T/m
TM V10/84°	10	R1	20	100T/m
TM V12/84°	12	R1	25	100T/m
TM V16/84°	16	R1.6	30	100T/m
TM V20/84°	20	R2	30	100T/m

Existe aussi en 86°



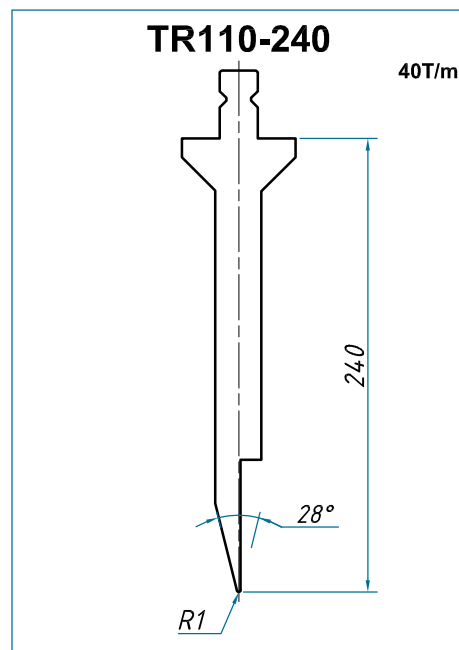
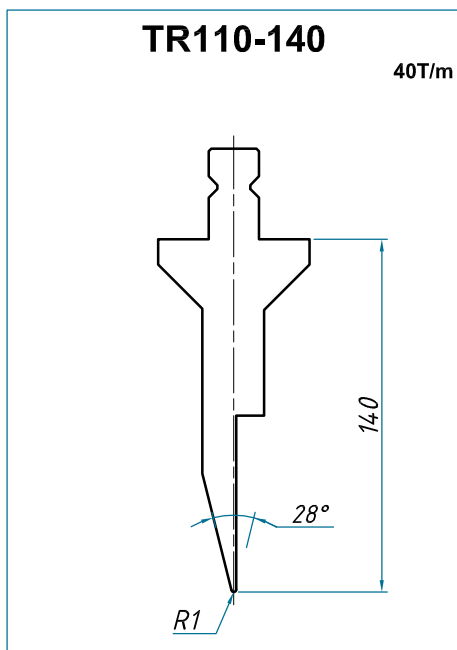
Modèle	Vé	R	L	H	F' maxi
TM V24/80°	24	R2.5	35	100	100T/m
TM V30/80°	30	R5	45	100	100T/m
TM V40/80°	40	R5	55	100	100T/m
TM V50/80°	50	R5	65	100	100T/m
TM V60/80°	60	R5	75	100	100T/m
TM V70/80°	70	R5	85	100	100T/m
TM V80/80°	80	R5	100	100	100T/m
TM V90/80°	90	R8	110	120	100T/m
TM V100/80°	100	R8	120	120	100T/m
TM V120/60°	120	R8	145	120	100T/m

Existe aussi en 86° jusqu'au Vé de 50



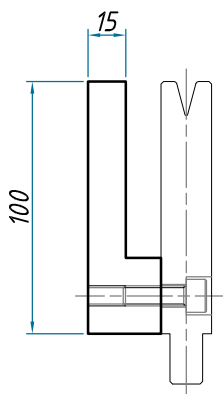
Modèle	Vé	R	B	L	F' maxi
TM V4S/84°	4	R0.6	20	8	25T/m
TM V5S/84°	5	R0.6	20	8	25T/m
TM V6S/84°	6	R0.6	20	10	25T/m
TM V8S/84°	8	R0.8	20	12	35T/m
TM V10S/84°	10	R1	20	14	40T/m
TM V12S/84°	12	R1	20	16	40T/m

Existe aussi en 86°

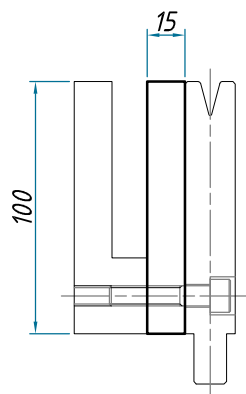


## Réactions pour matrices préperçées pour pli écrasé

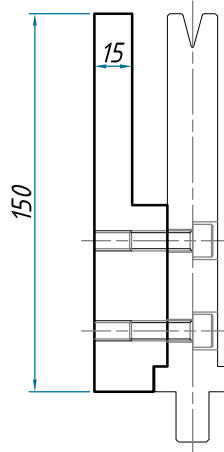
**Type A**



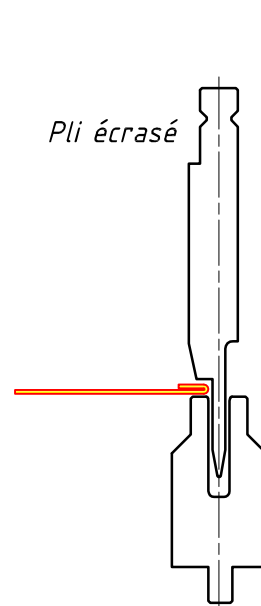
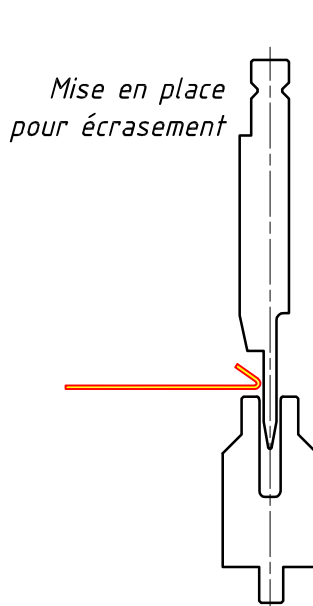
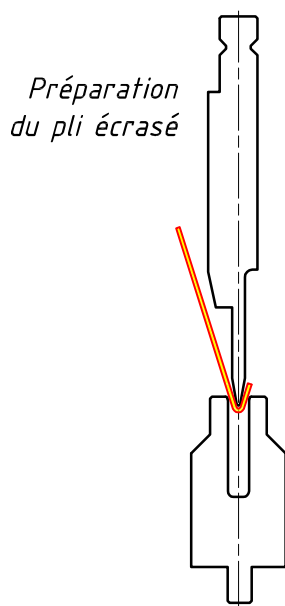
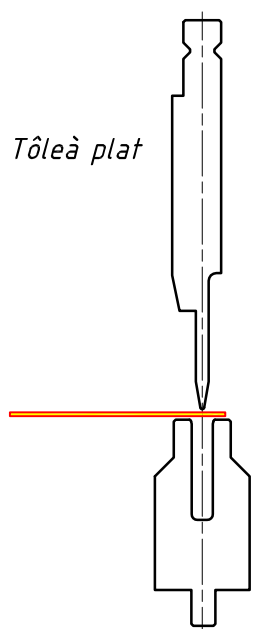
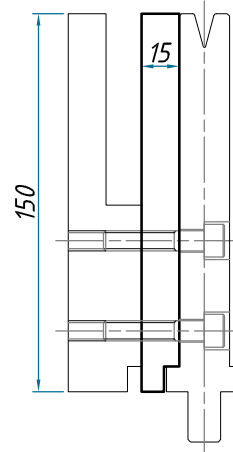
**Type B**

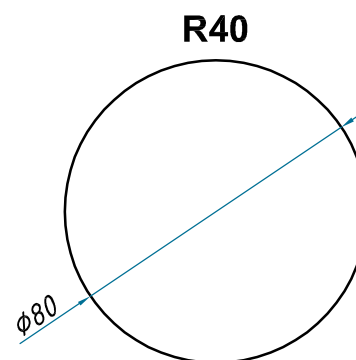
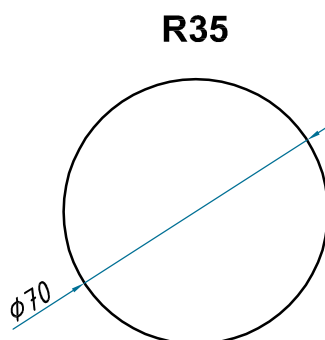
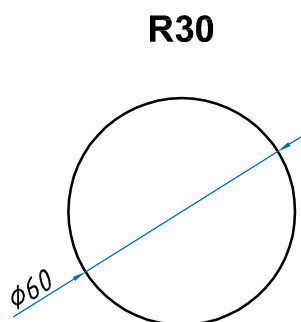
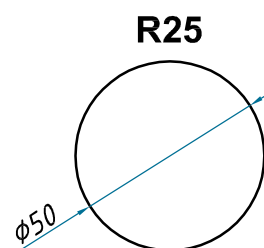
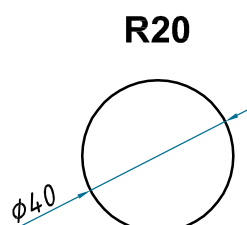
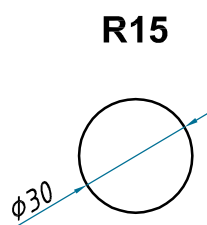
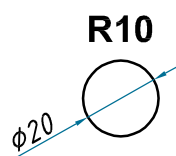
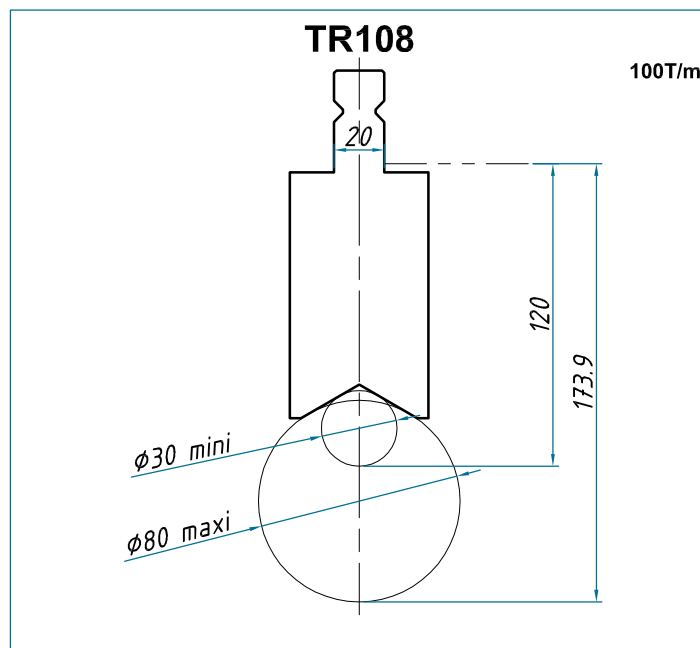
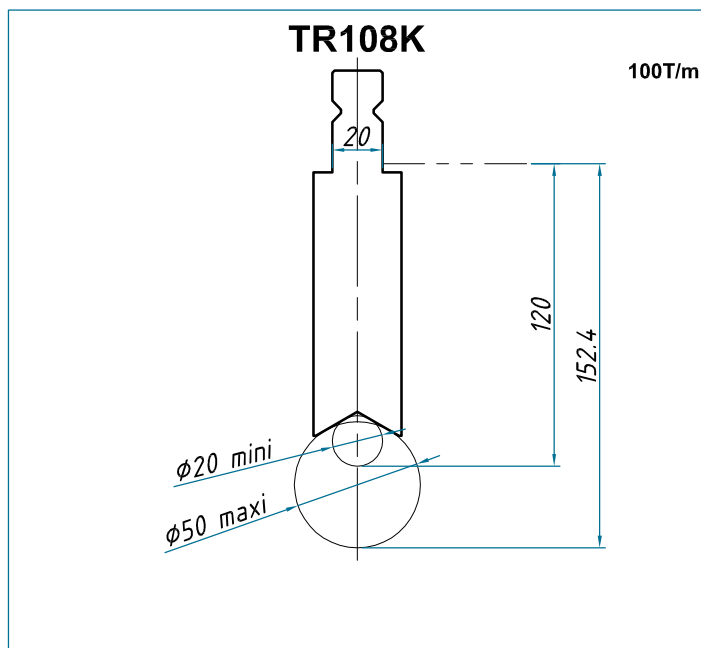


**Type C**



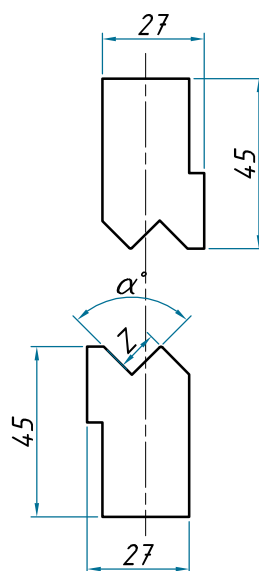
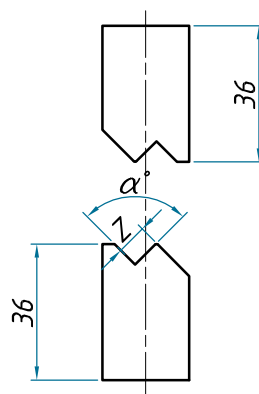
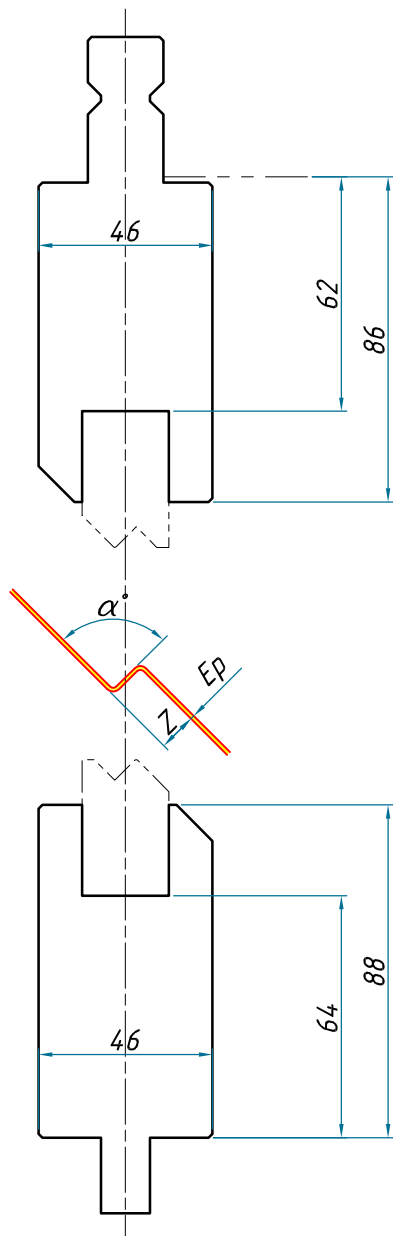
**Type D**





TRZ

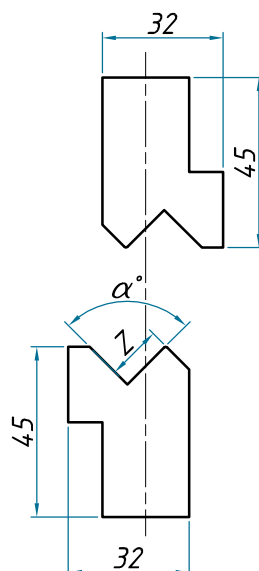
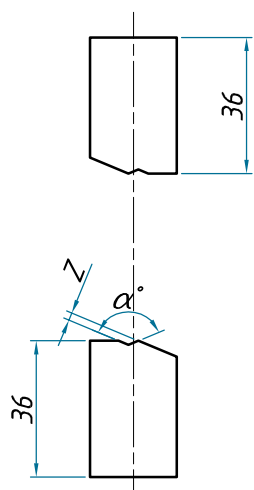
100T/m



Modèle	Z	$\alpha^\circ$
Z1-90	1	90°
Z1.5-90	1.5	90°
Z2-90	2	90°
Z2.5-90	2.5	90°
Z3-90	3	90°
Z3.5-90	3.5	90°
Z4-90	4	90°
Z4.5-90	4.5	90°
Z5-90	5	90°
Z5.5-90	5.5	90°
Z6-90	6	90°
Z6.5-90	6.5	90°
Z7-90	7	90°
Z7.5-90	5	90°
Z8-90	8	90°

Modèle	Z	$\alpha^\circ$
Z9-90	9	90°
Z10-90	10	90°
Z11-90	11	90°
Z12-90	12	90°

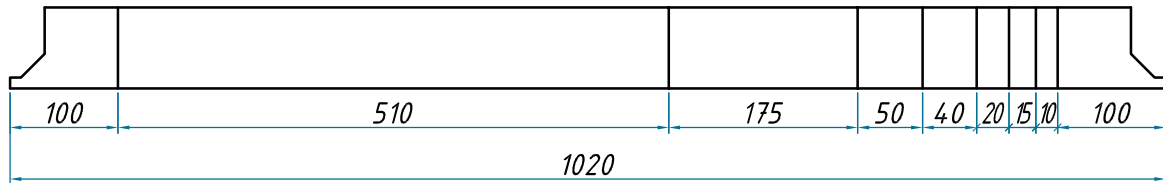
Modèle	Z	$\alpha^\circ$
Z1-160	1	160°
Z1.5-160	1.5	160°
Z2-150	2	150°
Z2.5-140	2.5	140°



Modèle	Z	$\alpha^\circ$
Z13-90	13	90°
Z14-90	14	90°
Z15-90	15	90°

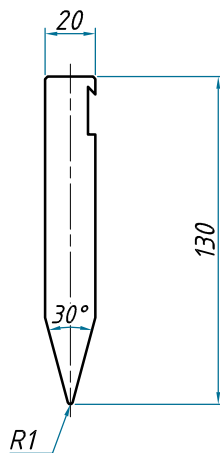
*Les lames Perrot typ sont disponibles  
en long. 1020 et 1020 fractionnée*

## Détail du fractionnement standard de lame



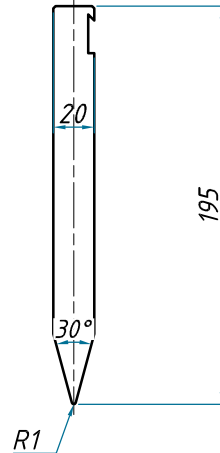
**502034**

100T/m



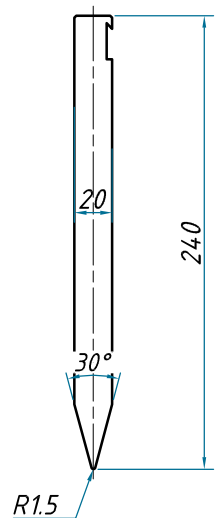
**502034**

100T/m



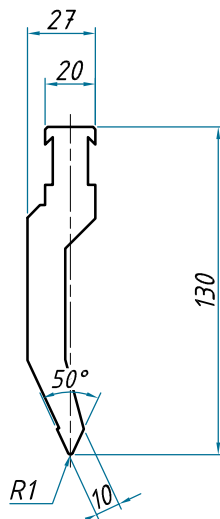
**502189**

100T/m



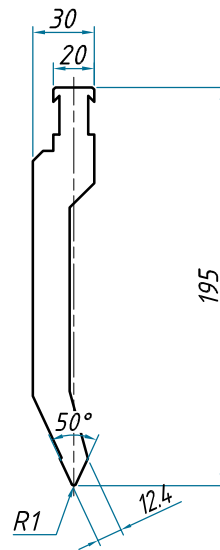
**502001**

100T/m



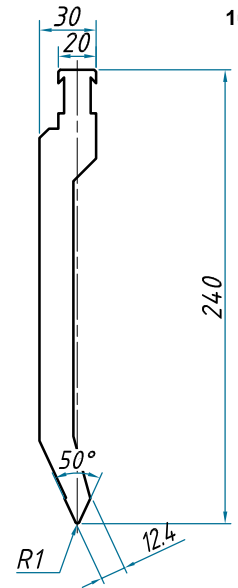
**502067**

100T/m



**502145**

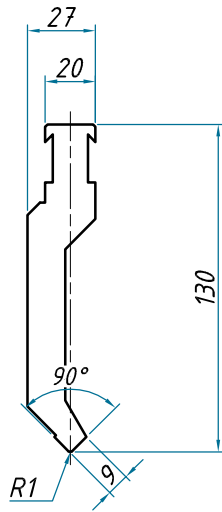
100T/m





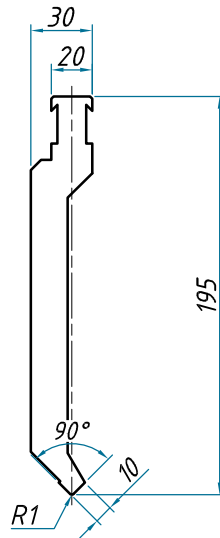
**502012**

100T/m



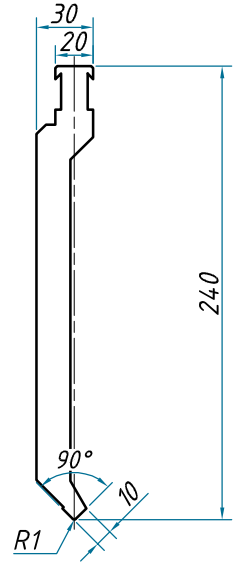
**502078**

100T/m



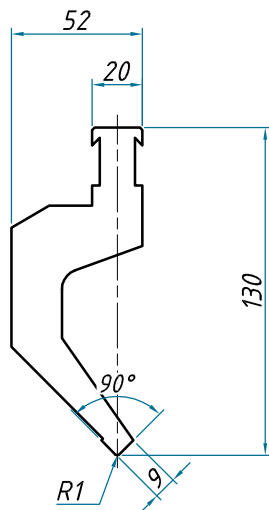
**502156**

100T/m



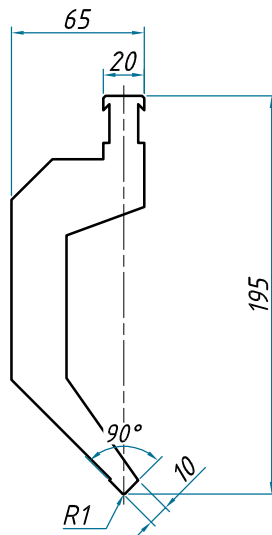
**502023**

40T/m



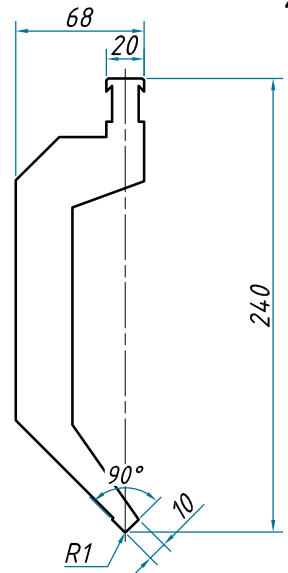
**502089**

40T/m



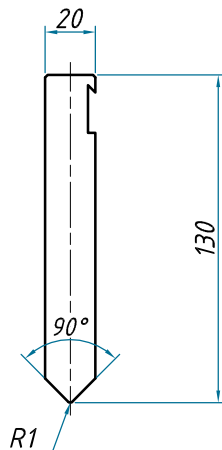
**502167**

40T/m



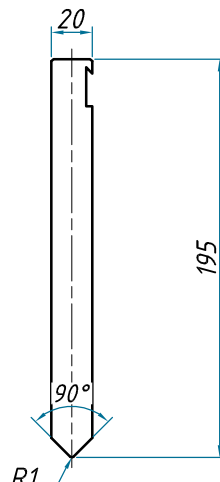
**502045**

100T/m



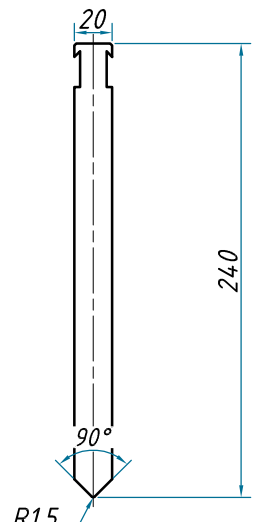
**502131**

100T/m



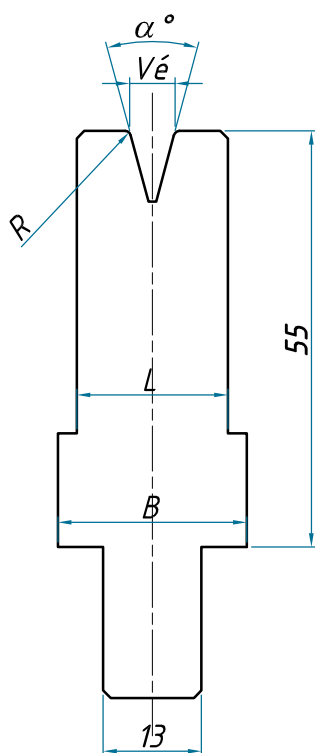
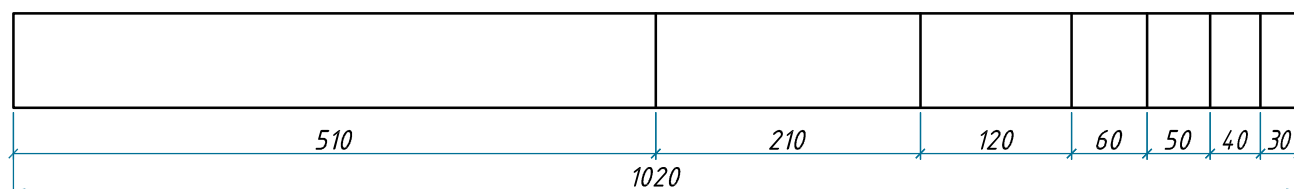
**502201**

100T/m

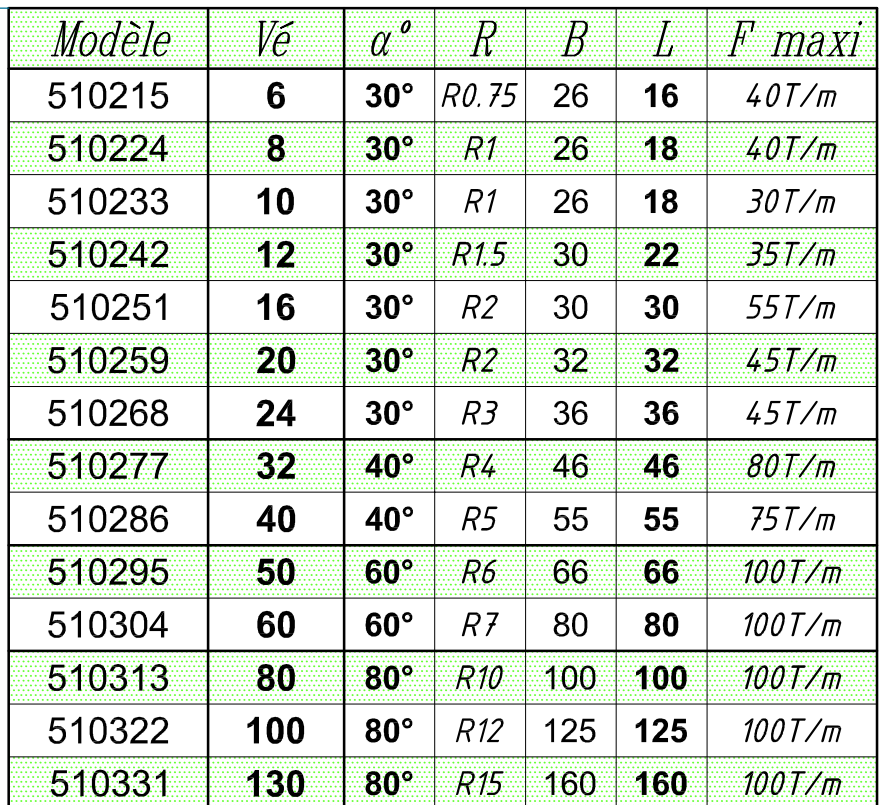
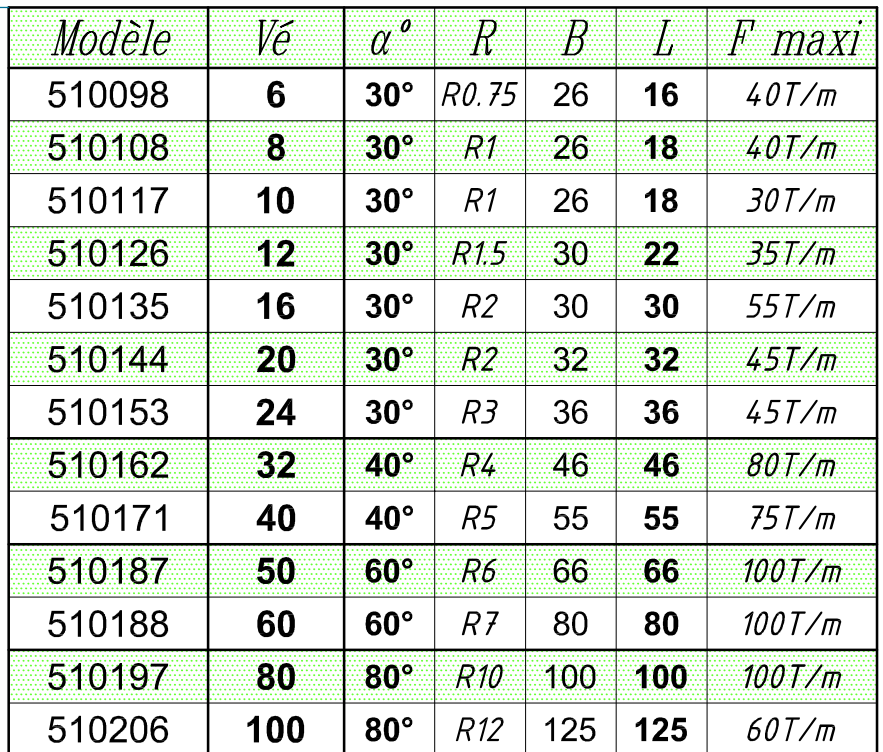


*Les matrices Perrot typ sont disponibles  
en long. 1020 et 1020 fractionnée*

## Détail du fractionnement standard de matrice



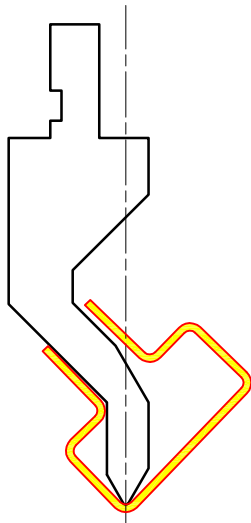
Modèle	Vé	$\alpha^\circ$	R	B	L	F maxi
510009	6	30°	R0.75	26	16	40T/m
510018	8	30°	R1	26	18	40T/m
510017	10	30°	R1	26	18	30T/m
510027	12	30°	R1.5	30	22	35T/m
510036	16	30°	R2	30	30	55T/m
510045	20	30°	R2	32	32	45T/m
510054	24	30°	R3	36	36	45T/m
510063	32	40°	R4	46	46	80T/m
510072	40	40°	R5	55	55	75T/m
510081	50	60°	R6	66	66	100T/m
510083	60	60°	R7	80	80	45T/m



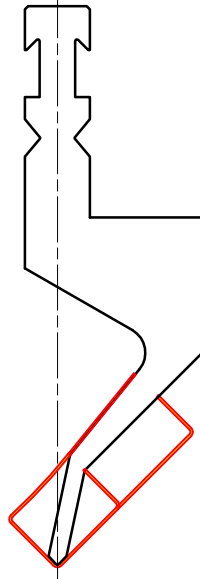
# Outillages spéciaux

notre catalogue en ligne  
sur [www.soclam.com](http://www.soclam.com)

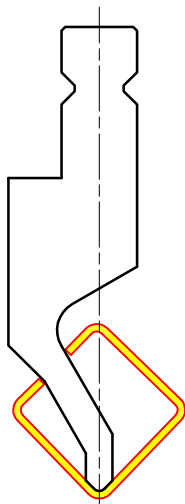
10.04-1



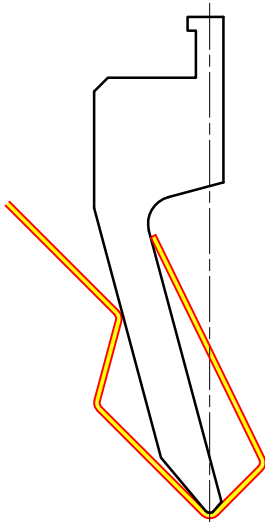
10.04-2



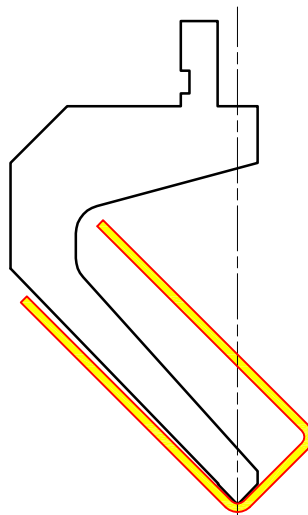
10.04-3



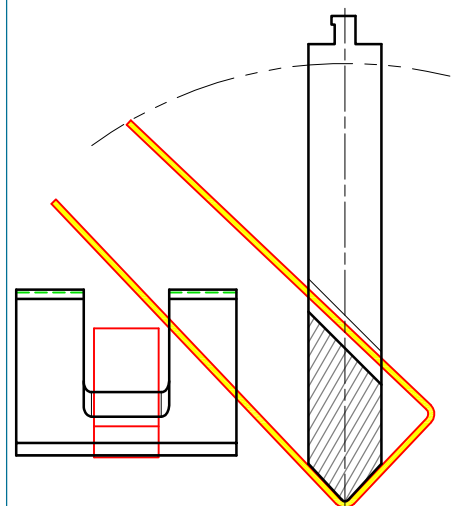
10.06



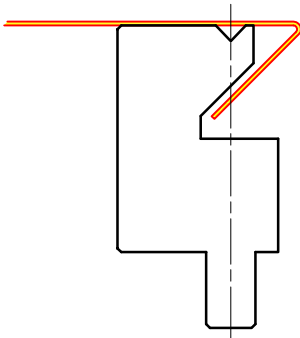
10.08



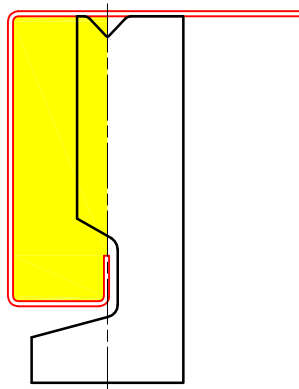
10.09



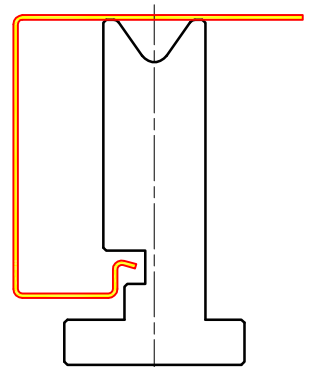
20.81



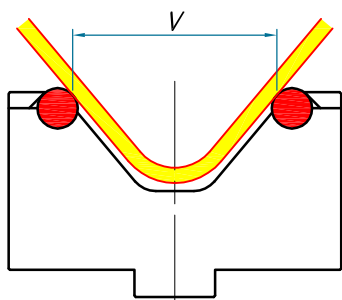
20.82



20.83

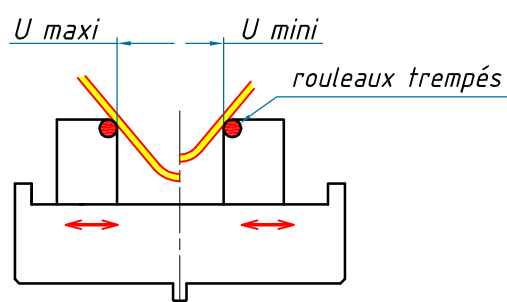
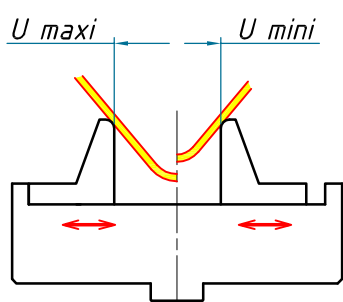


## 20.51 Matrice à rouleaux trempés



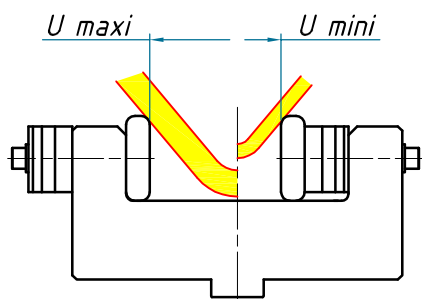
*Cette matrice permet un meilleur glissement de la tôle pendant le pliage. Elle peut être réalisée en différentes versions, en fonction des épaisseurs et du type de matériau à plier.*

## 20.61 Matrices à U réglable



*Réglage simple, rapide  
et précis par manivelle*

## 20.71 Matrice à U réglable avec inserts

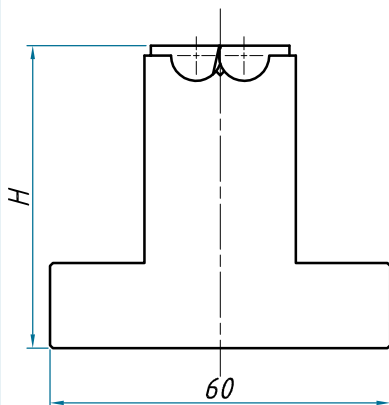


*Réglage par  
déplacement de cales  
à l'arrière des inserts*

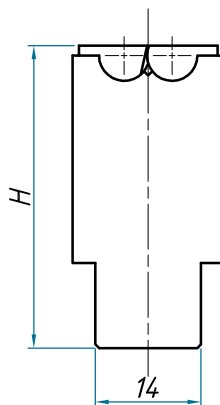
PHOTO

*Préconisées pour le pliage d'inox ou d'aluminium sans marquage ou légère trace de marquage.  
Prévues pour le pliage de petites pièces, le pliage sans déformation de tôles perforées et/ou le pliage sans polluer l'outil  
(calamine, glava, etc.)*

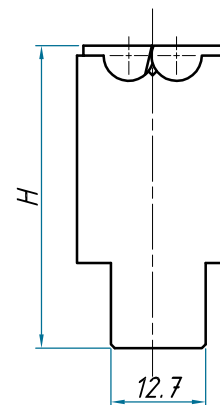
**Amada Typ**



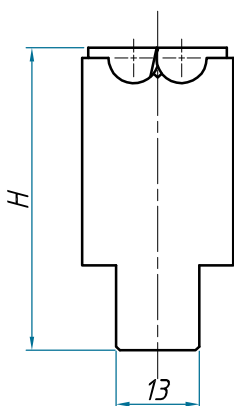
**Amada Typ**



**LVD Typ**

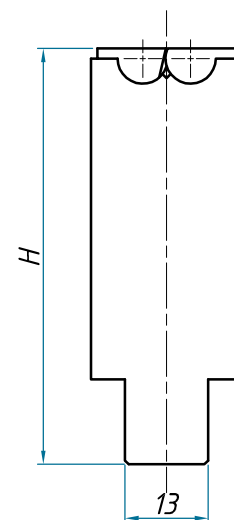


**Beyeler Typ**



*Ces matrices sont  
prévues pour des  
épaisseurs de 0.7 à 6mm  
et jusqu'à 16mm  
en hors standard*

**Trumpf Typ**



*Sur demande, il est possible de réaliser des matrices à ouverture variable avec des inserts pour le formage de grand rayon, le formage de U en 1 coup de presse à fond plat ou fond rayonné*

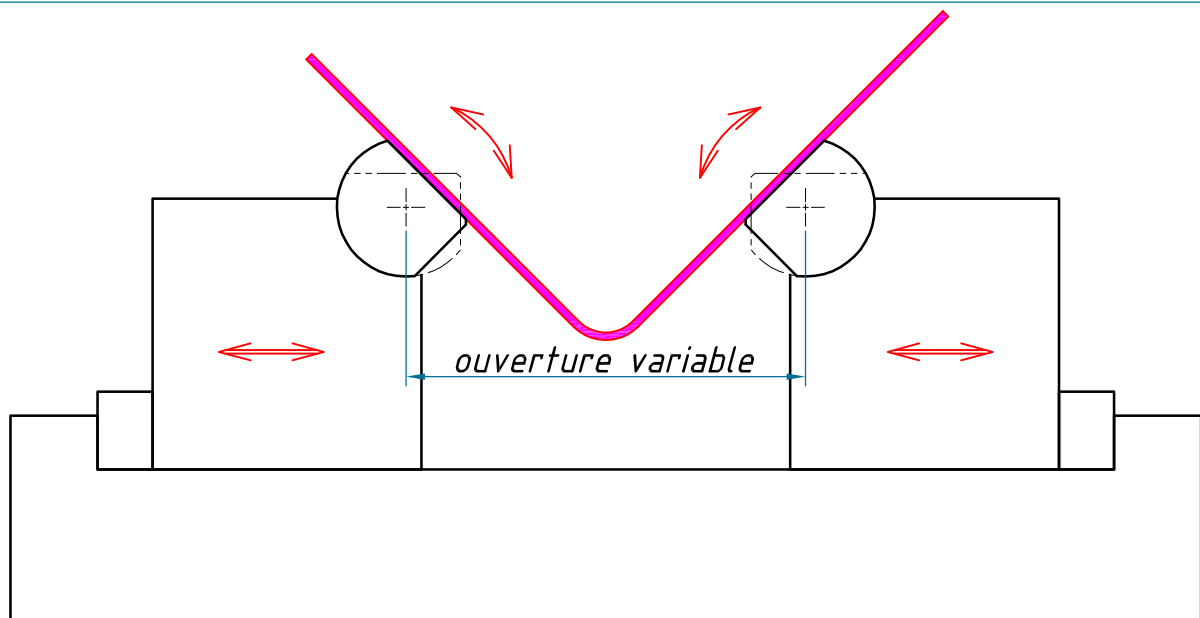
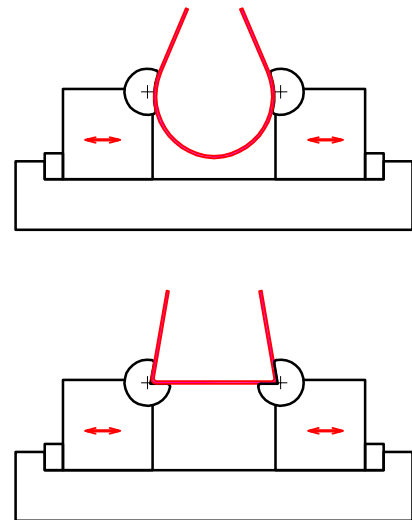
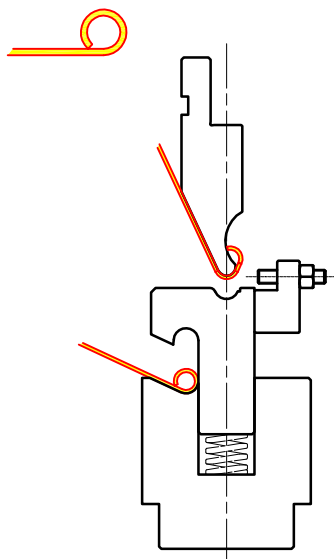


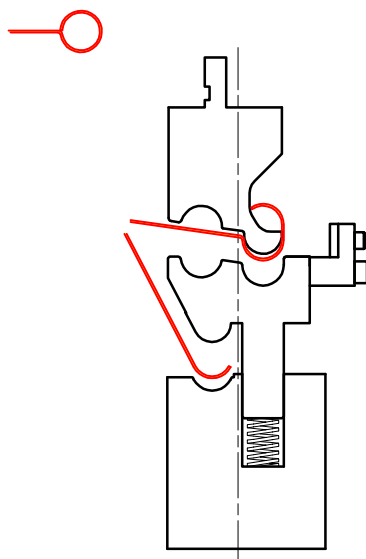
PHOTO  
84-1

PHOTO  
84-2

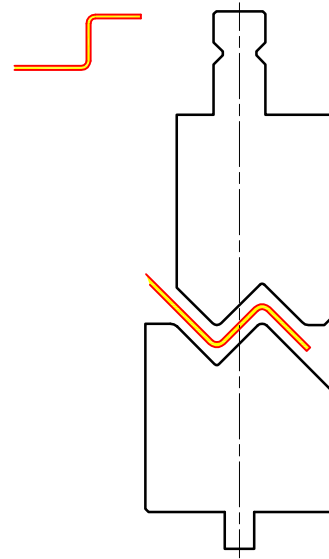
30.03



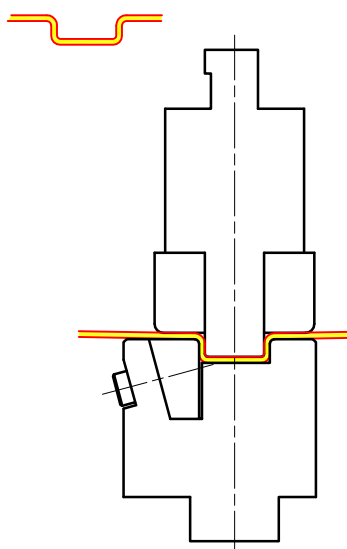
30.04



30.05



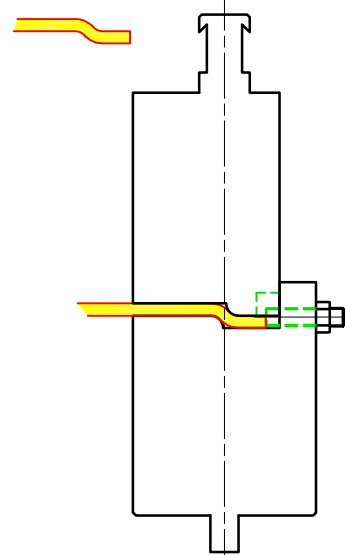
30.06



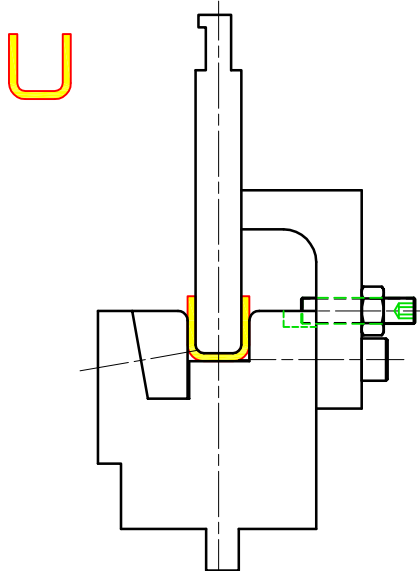
*Pour toute demande, veuillez nous indiquer :*

- Le plan de pièce pliée avec longueur, quantité et tolérances
- Type de matériel (acier, inox, alu...) et son épaisseur
- Présence éventuelle d'un film de protection sur la tôle
- Le type de fixation sur la presse
- Puissance et longueur de la presse
- Ouverture et course de la presse

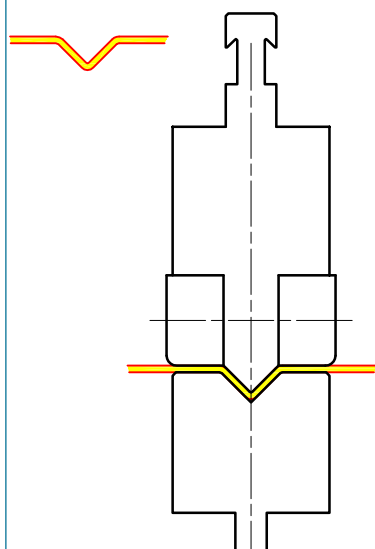
30.08



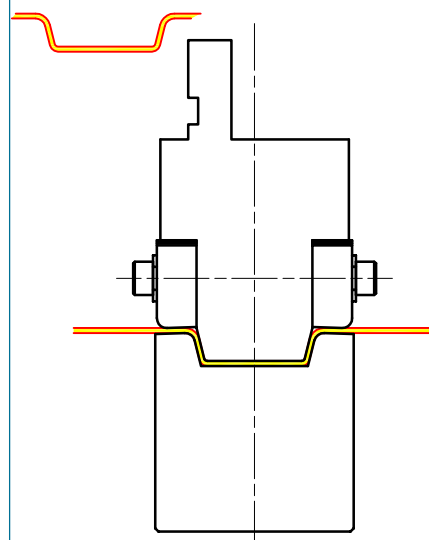
30.09



30.10



30.11





Pour toutes demandes de lames de cisailles, merci de nous indiquer :

– Marque et modèle de la cisaille :

– Matière et épaisseur à cisailer :

Acier épaisseur mini : maxi :

Inox épaisseur mini : maxi :

Tôle larmée épaisseur mini : maxi :

– Dimensions des lames :

Nombre de trous :

Trous taraudés : ☐ ou double fraisure : ☐

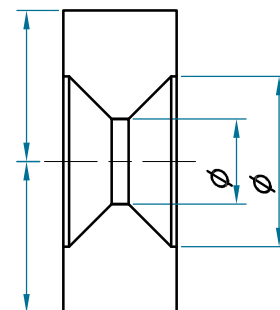
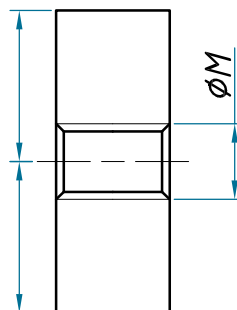
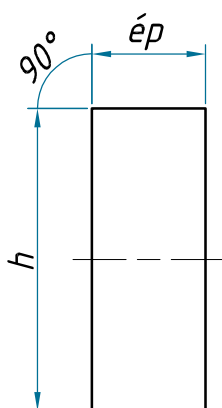
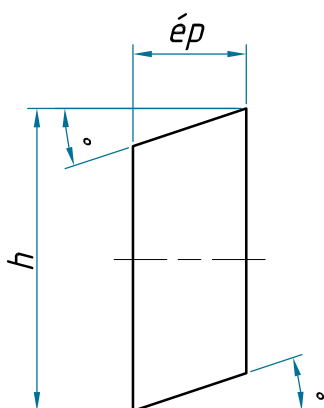
Compléter les schémas correspondant à la section et au nombre d'arêtes de coupe désiré :

2 arêtes de coupe

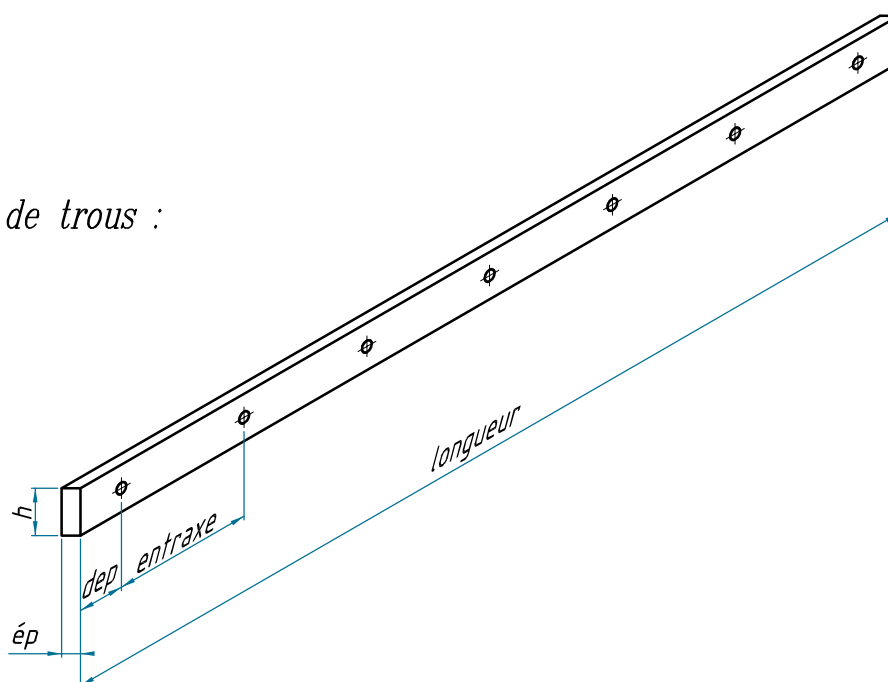
4 arêtes de coupe

Trou taraudé

Double fraisure



Nombre de trous :



*soclam c'est aussi.....*



*..... les machines  
de formages :*

- *Poinçonneuses CNC*
- *Presses Plieuses CNC*
- *Cisailles*
- *Rouleuses*
- *Cintreuses*
- *Découpe Plasma*



*..... les outils pour  
poinçonneuses  
universelles :*

- *SUNRISE*
- *GEKA – DURMA*
- *PEDDINGHAUS*
- *VERNET*
- *FICEP*
- *KINGSLAND*
- *SEG, BOUTILLON...*