



EDITION 2023

OUTILS DE PLIAGE



Soclam c'est aussi

..... les machines de formage :

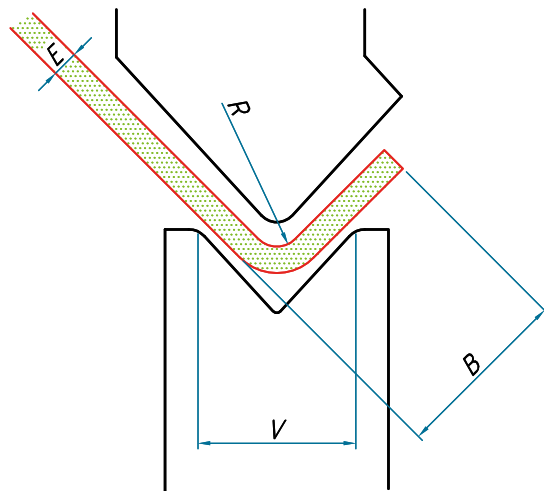


- *Presses Plieuses CNC*
- *Poinçonneuses CNC*
- *Découpe Laser*
- *Cisailles*
- *Rouleuses*
- *Cintreuses*

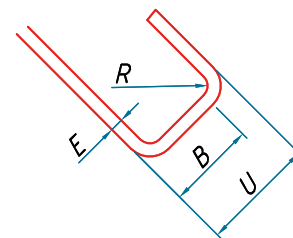
..... les outils pour poinçonneuses universelles :



- *Sunrise*
- *Geka – Durma*
- *Peddinghaus*
- *Vernet*
- *Ficep*
- *Kingsland*
- *Seg, Boutillon*
- ...



R = Rayon interieur de pliage
 B = Bord minimum



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

Epaisseur de tôle: E

V	R	B	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 Kg/mm²)

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

- Acier S355 (55 Kg/mm²) coeff. 1.3
- Inox 304 (64 Kg/mm²) coeff. 1.5
- Alu AG3 (24 Kg/mm²) 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 4 mm
 8 à 12 x l'épaisseur au delà de 4 mm

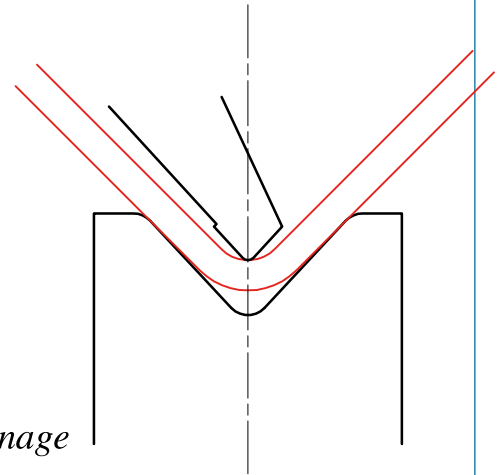
Le rayon intérieur du pli $R_i \geq$ épaisseur de tôle

les avantages:

- Puissance utile minum
- 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

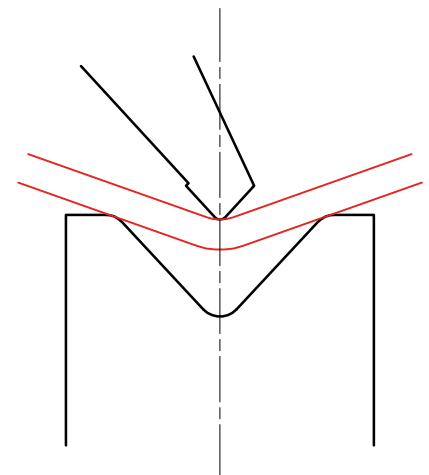
Le rayon intérieur du pli $R_i >$ épaisseur de tôle

les avantages:

- Puissance utile minum
- 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 de pli.

Choix du vé: 5 à 6 x l'épaisseur

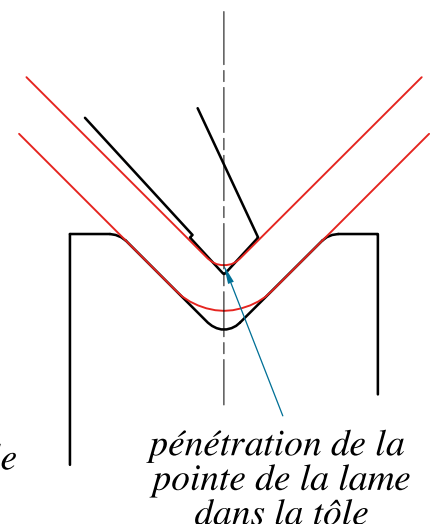
Cette méthode est utilisée pour des tôles jusqu'à 20/10

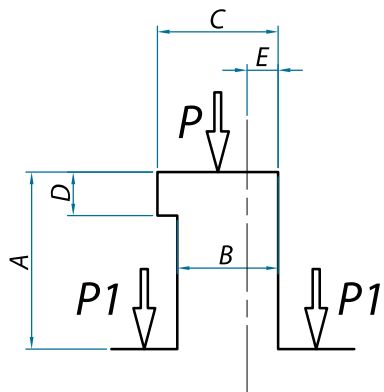
les avantages:

- Répétabilité du pli
- Précision de l'angle

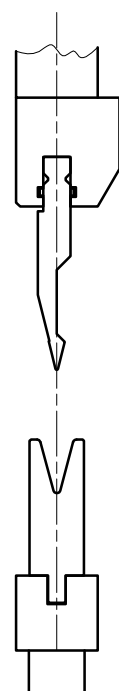
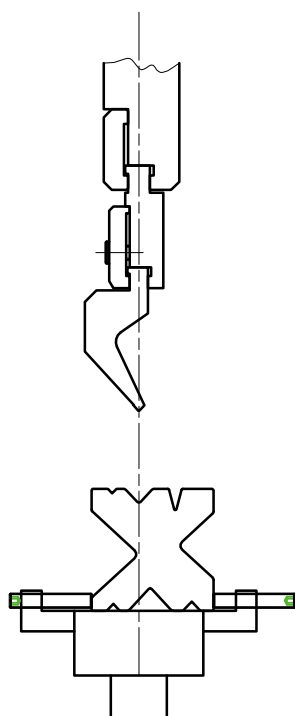
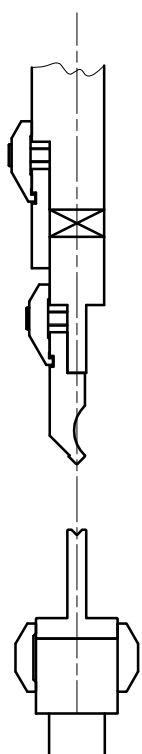
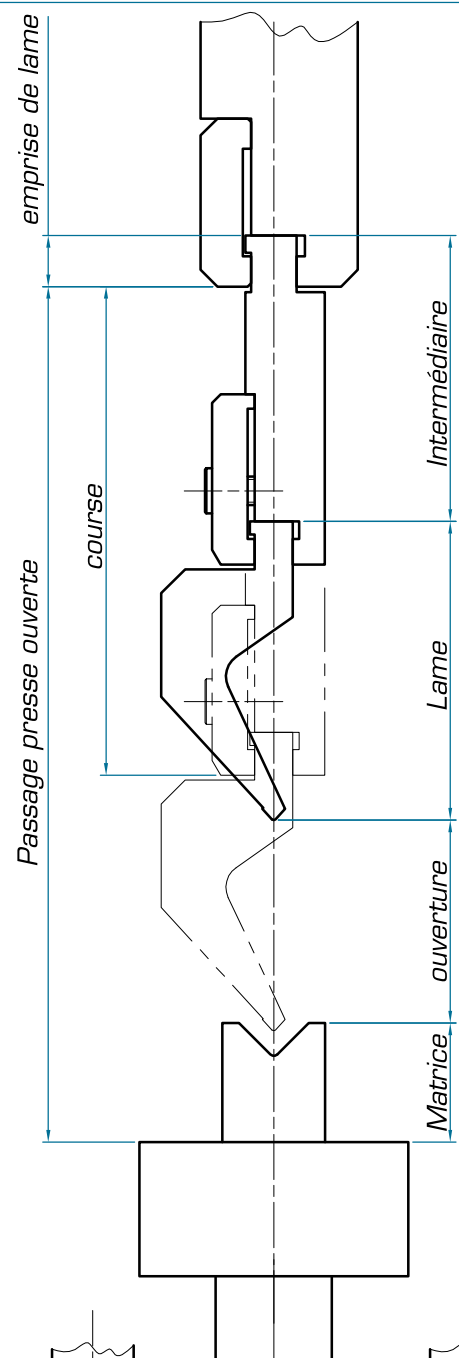
les inconvénients:

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

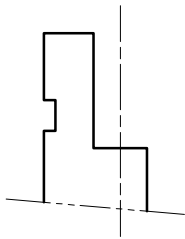




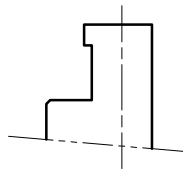
P: Simple appuis
P1: Double appuis



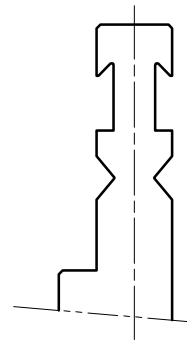
Attache AMADA



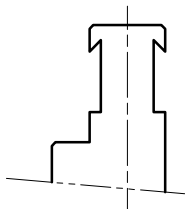
Attache COLLY



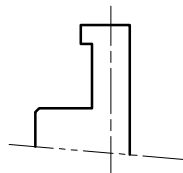
Attache BEYELER



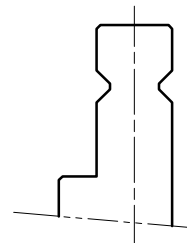
Attache PERROT



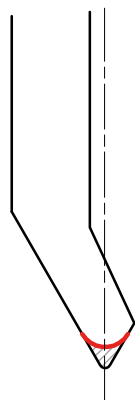
Attache LVD



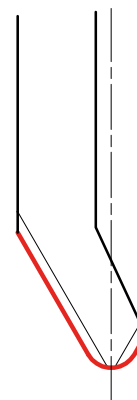
*Attache WILA,
TRUMPF*



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

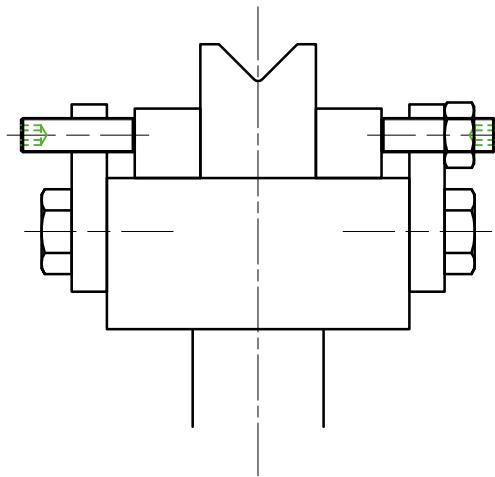
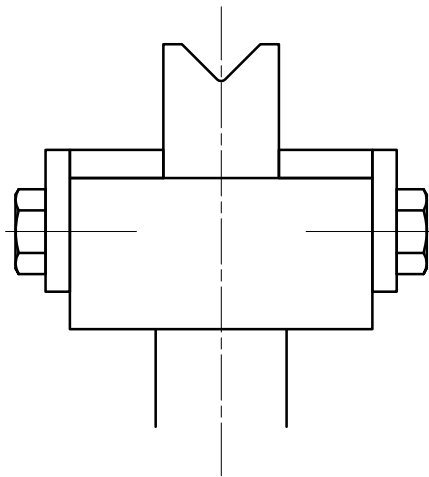


*Avec modification
de la hauteur
(standard modifié)*

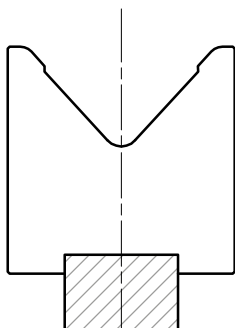


*Sans modification
de la hauteur
(fabrication spéciale)*

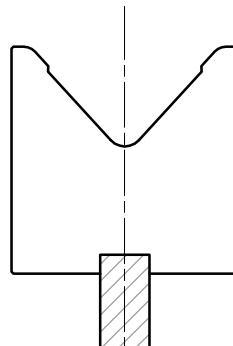
* Le bridage des matrices



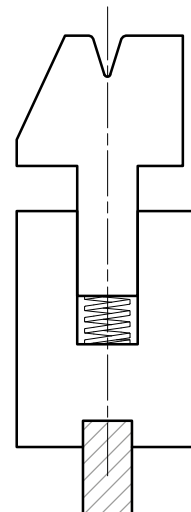
* Exemples d'adaptations de matrices standards sur différentes presses



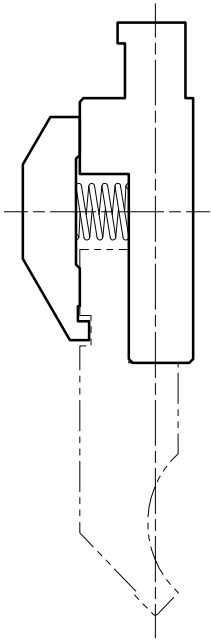
Rajout d'un talon
largeur 30 pour
adaptation sur
COLLY



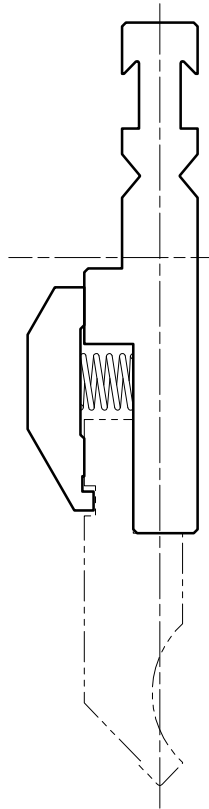
Rajout d'un talon
pour adaptation
sur BEYELER,
TRUMPF ou LVD



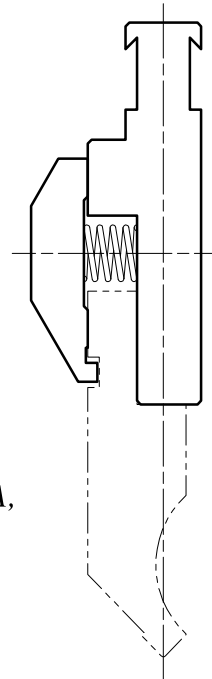
Attache COLLY
nez de 13,5, 16



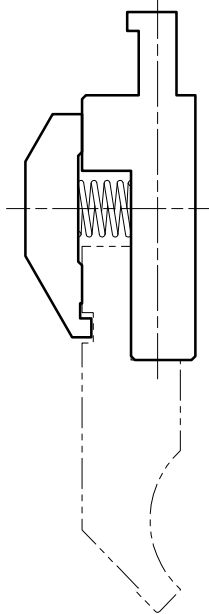
Attache BEYELER
type R, RF, RF-A, S



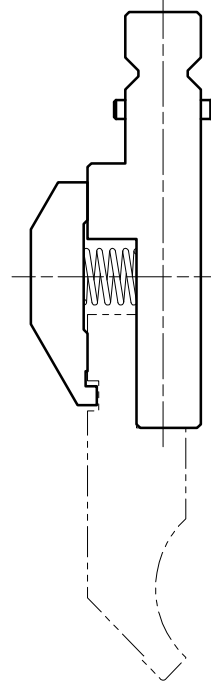
Attache PERROT



Attache LVD
nez de 10, 15

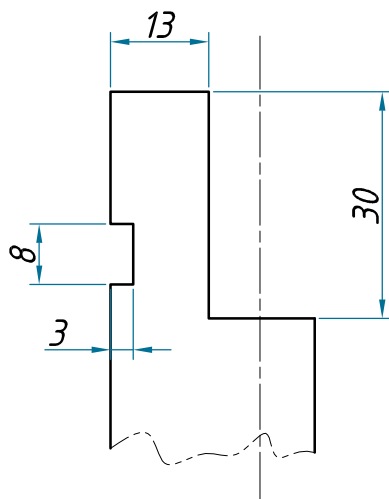


Attache WILA,
TRUMPF

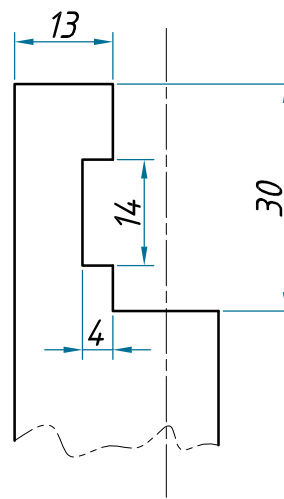


Attache

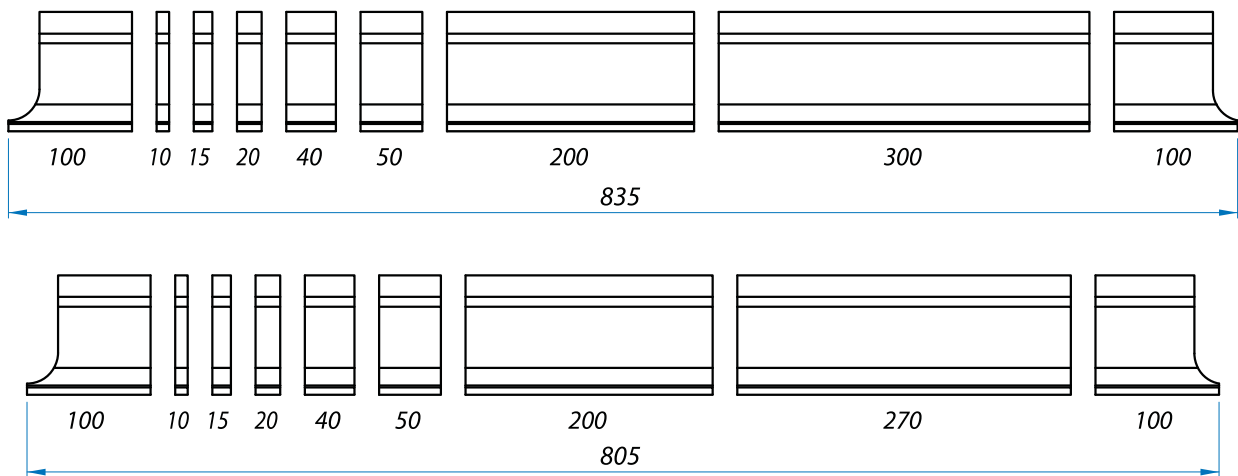
Modèle AMADA



Modèle EURO



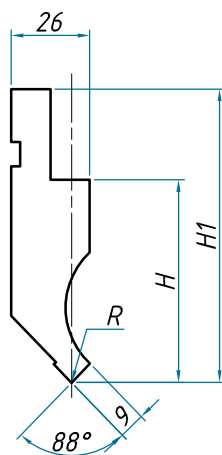
Les lames Amada typ sont disponibles en
longueur 415, 835 et 800/805/835 fractionnée



10.10/88°

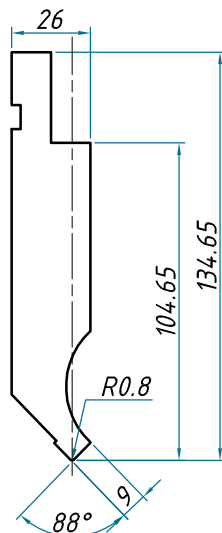
100T/m

R	H	H1
0.2	67	97
0.8	66.7	96.7
3.0	65.7	95.7



10.10 - 10.39/88°

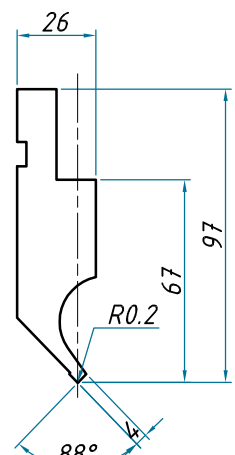
100T/m



Existe aussi en Hauteur 135 utile

10.116/88°

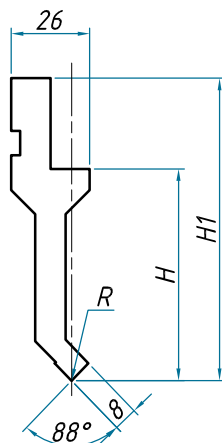
35T/m



10.200/88°

50T/m

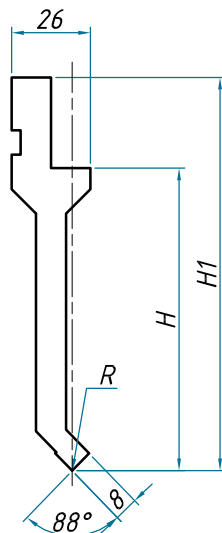
R	H	H1
0.2	70	100
0.8	69.7	99.7



10.202/88°

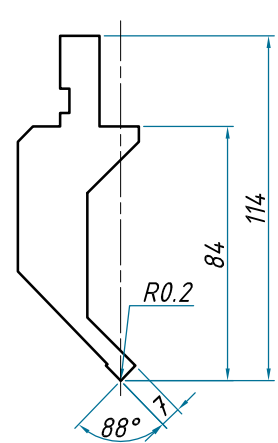
50T/m

R	H	H1
0.2	100	130
0.8	99.7	129.7



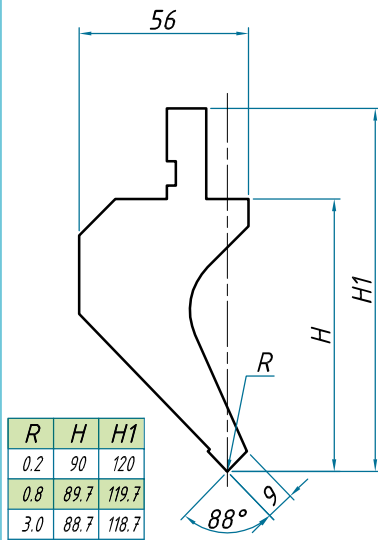
10.16/88°

15T/m



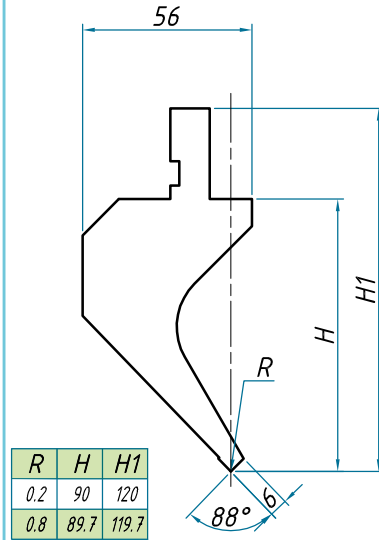
10.14/88°

70T/m



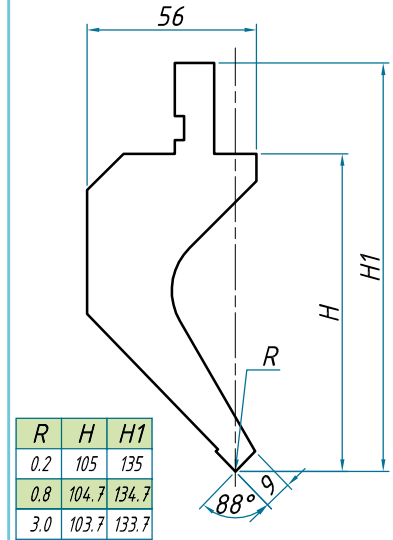
10.146/88°

50T/m



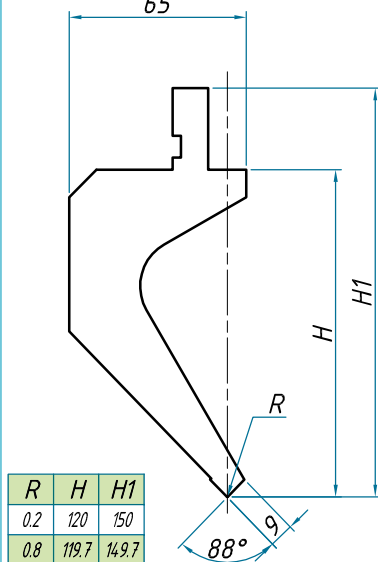
10.15/88°

50T/m



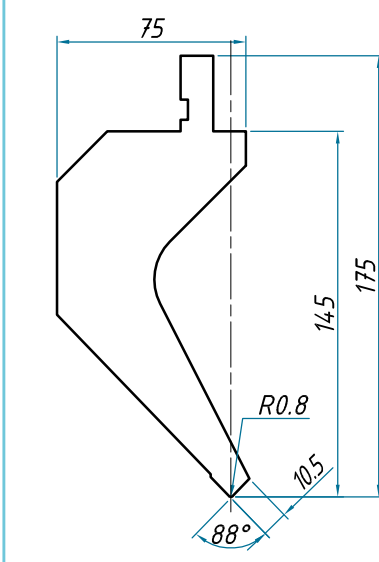
10.047/88°

50T/m



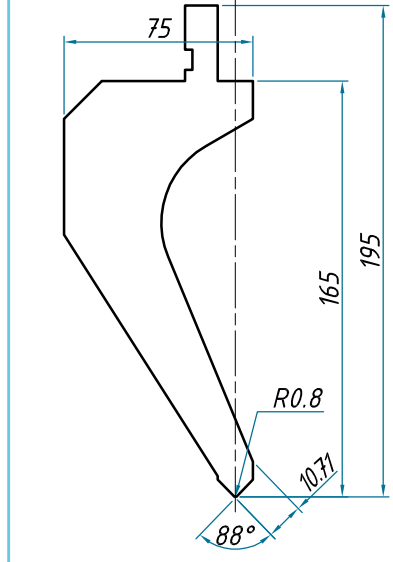
10.050/88°

80T/m



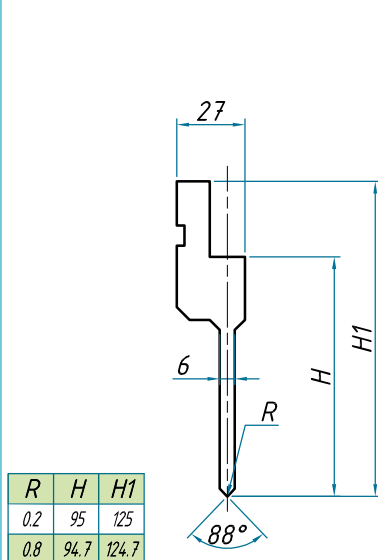
10.065/88°

60T/m



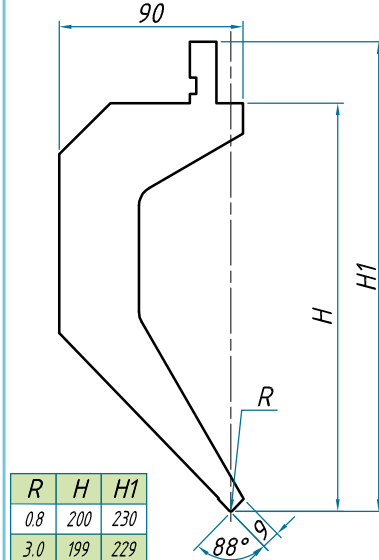
10.109/88°

50T/m



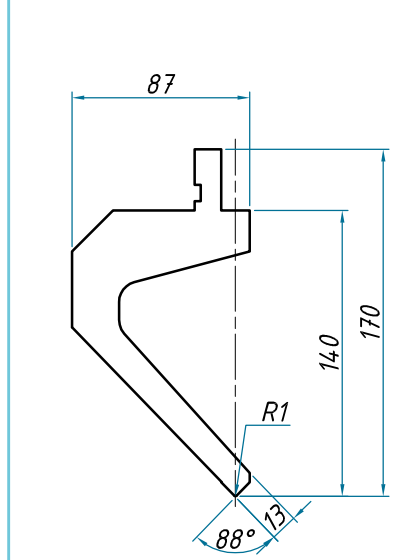
10.291/88°

85T/m



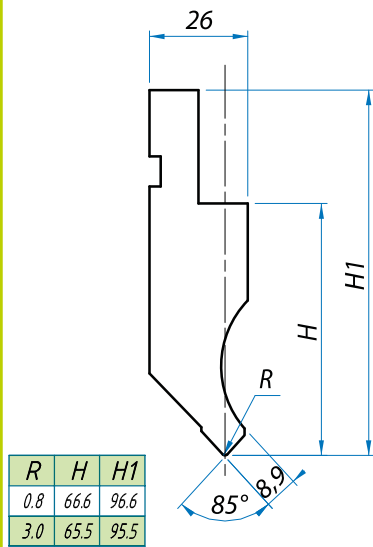
10.090/88°

18T/m



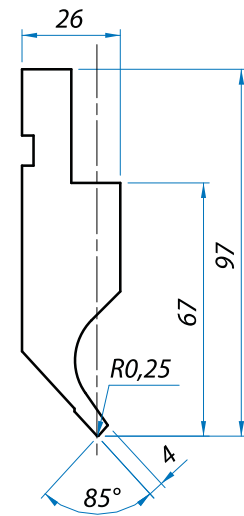
10.10/85°

100T/m



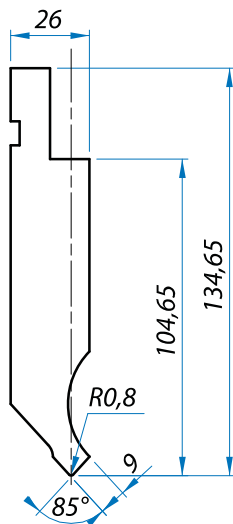
10.116/85°

35T/m



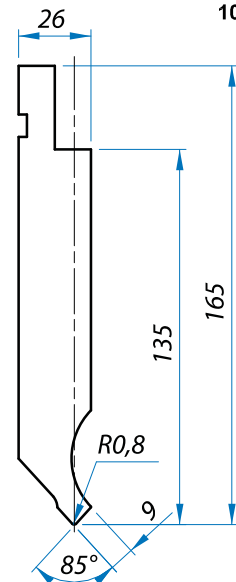
10.10-10.39/85°

100T/m



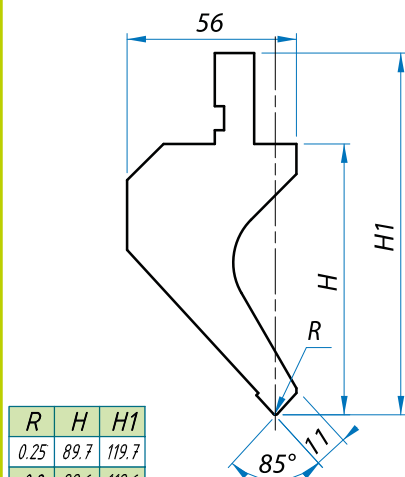
10.10-10.40/85°

100T/m



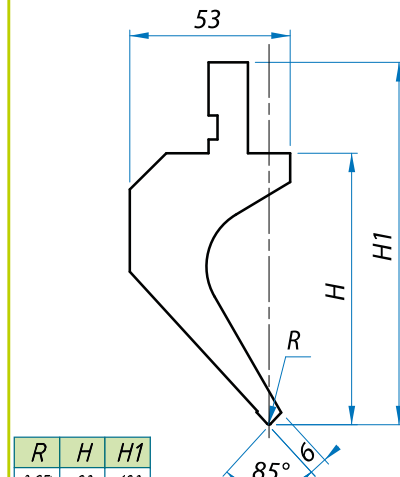
10.14/85°

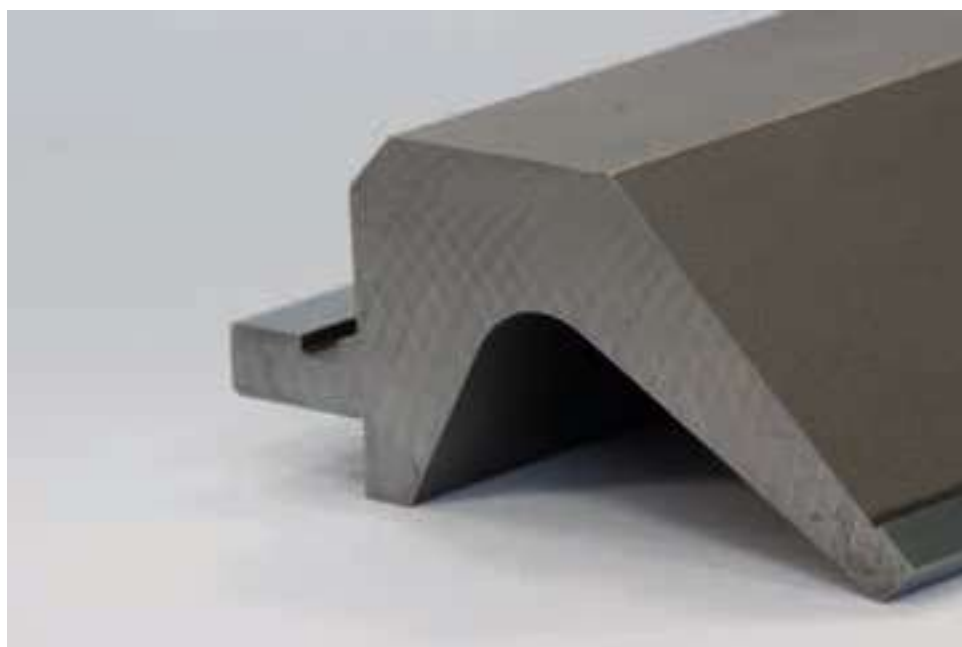
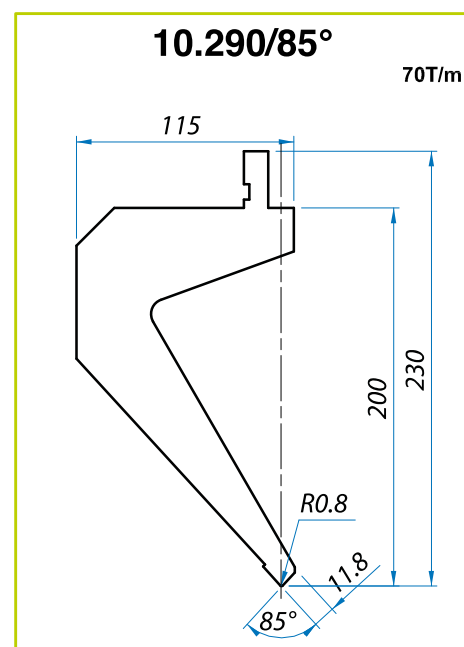
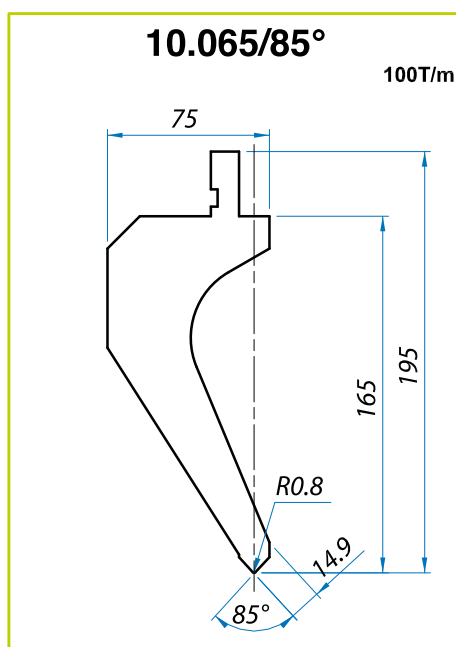
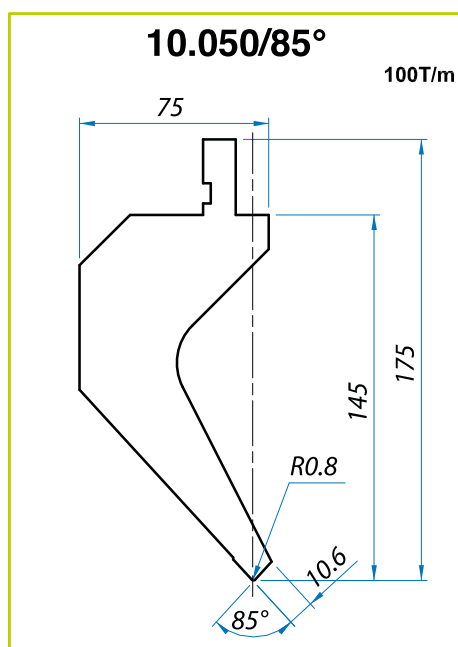
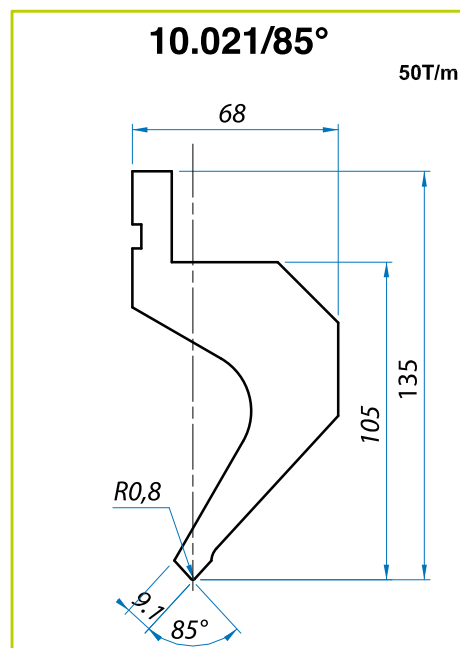
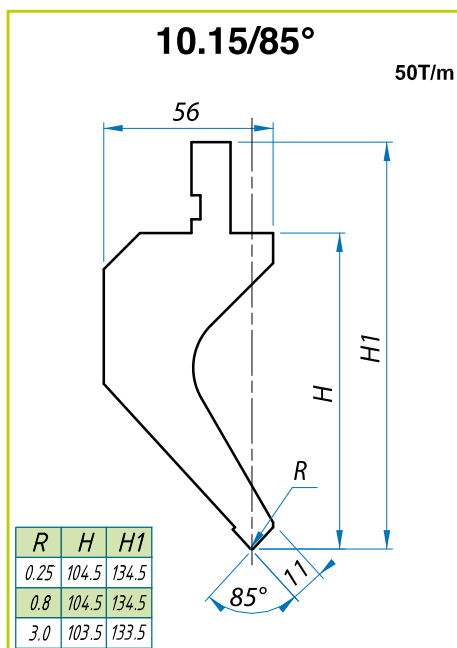
60T/m



10.146/85°

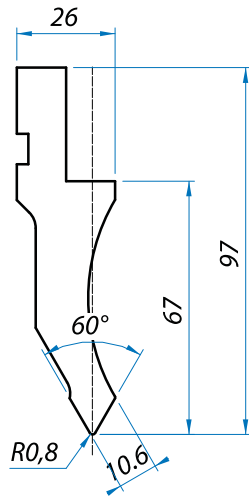
50T/m





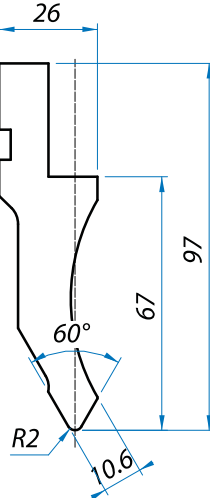
10.18/60°-R0.8

80T/m



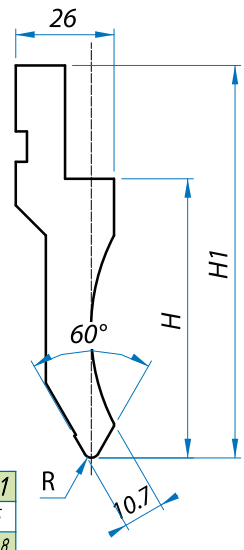
10.19/60°-R2

80T/m



10.20/60°

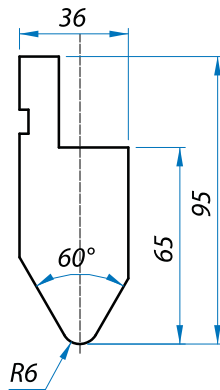
70T/m



R	H	H1
0.8	75	105
0.2	74	103.8

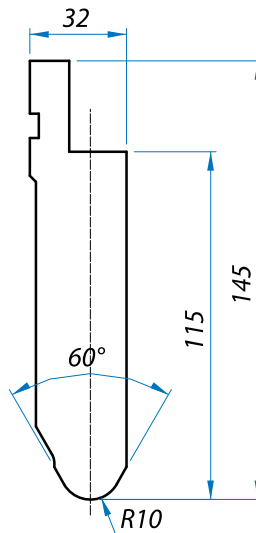
10.13/60°-R6

120T/m



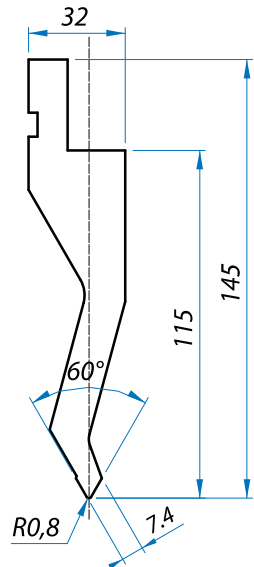
10.283/60°-R10

150T/m



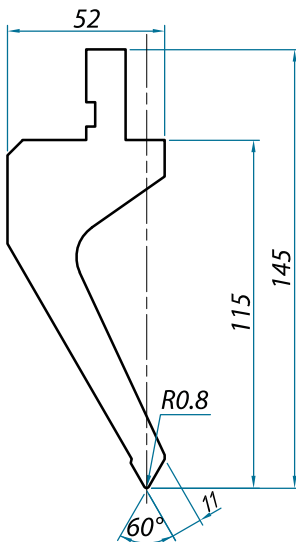
10.191/60°-R0.8

60T/m



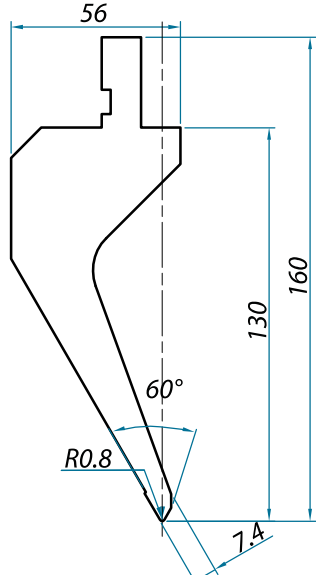
10.272/60°-R0.8

40T/m



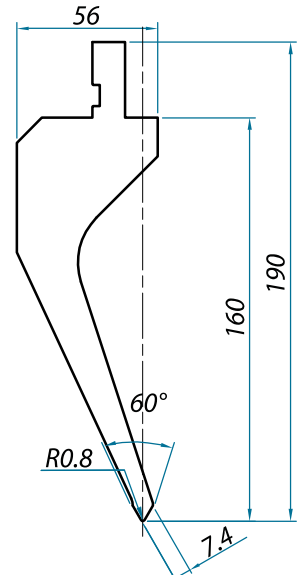
10.163/60°-R0.8

40T/m



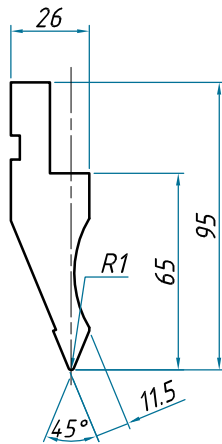
10.190/60°-R0.8

40T/m



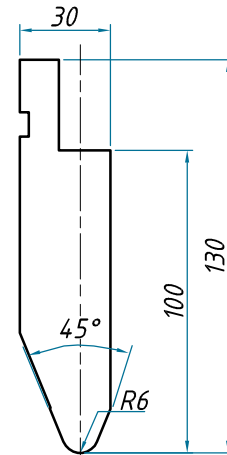
10.11/45°

70T/m



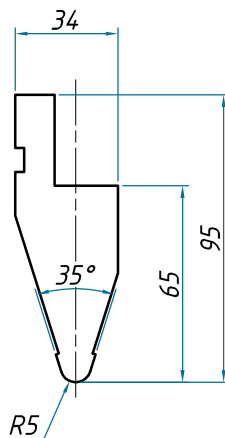
10.253/45°

100T/m



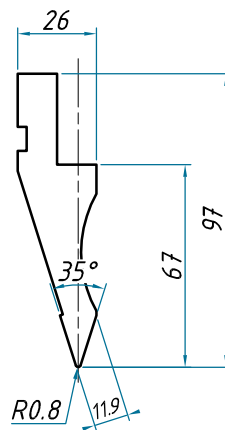
10.13/35°

100T/m



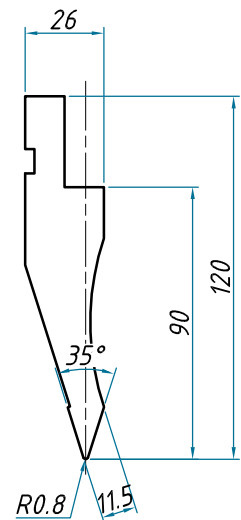
10.11/35°

50T/m



10.12/35°

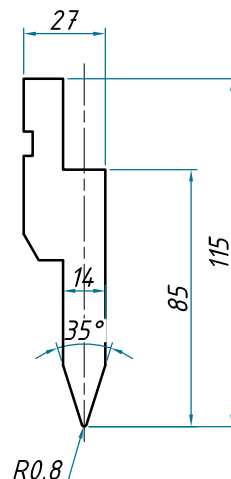
50T/m



Existe aussi en R=1.5

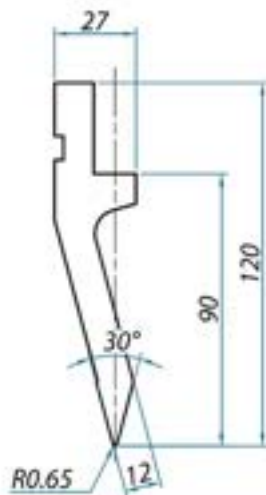
10.17/35°

50T/m



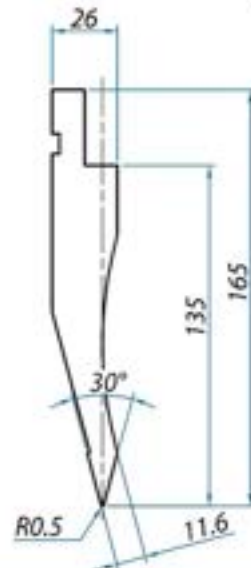
10.061/30°

40T/m



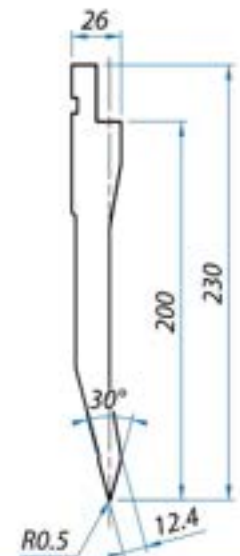
10.211/30°

50T/m



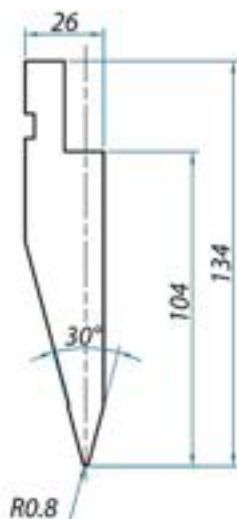
10.292/30°

50T/m



10.210/30°

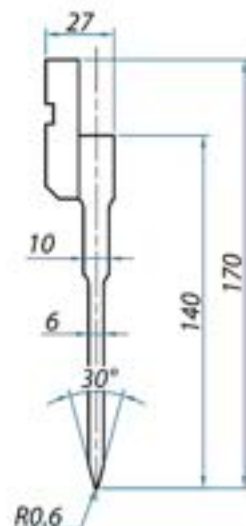
100T/m



Existe aussi en R=3 et R=5

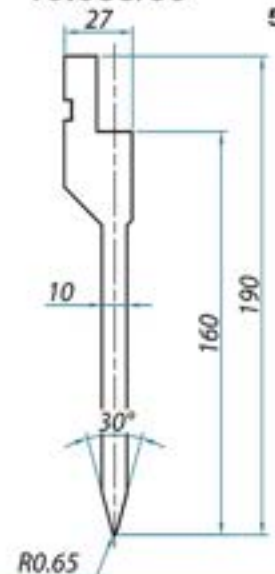
10.086/30°

40T/m



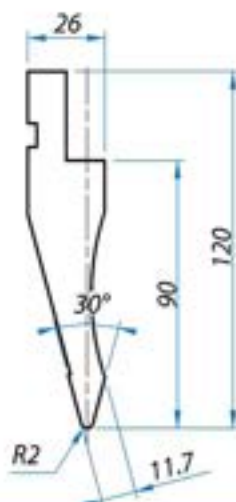
10.088/30°

50T/m



10.12/30°-R2.0

50T/m



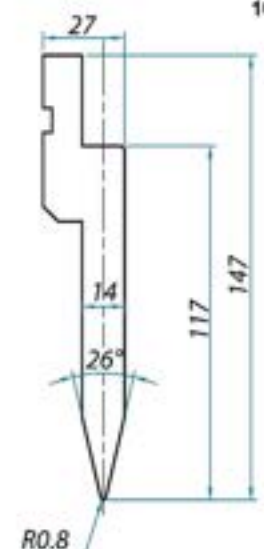
10.103/30°

50T/m

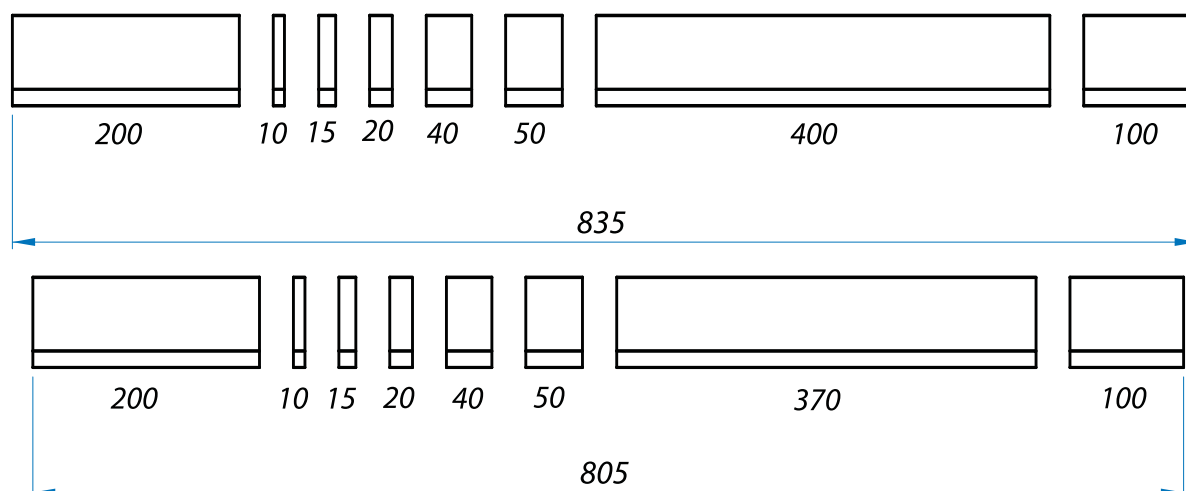


10.18/26°

100T/m



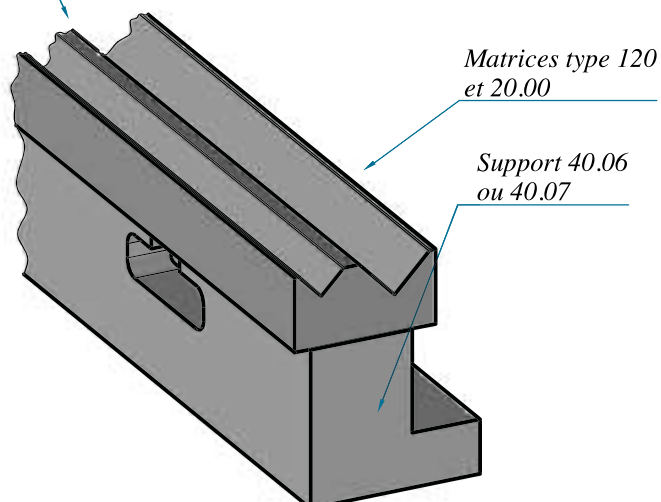
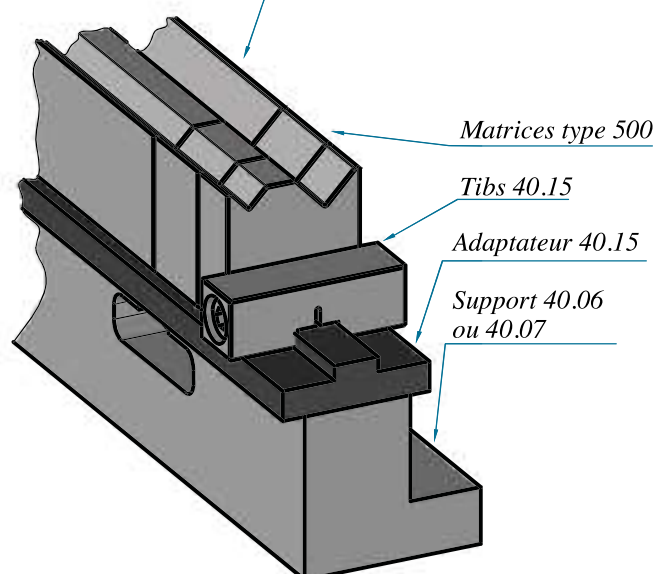
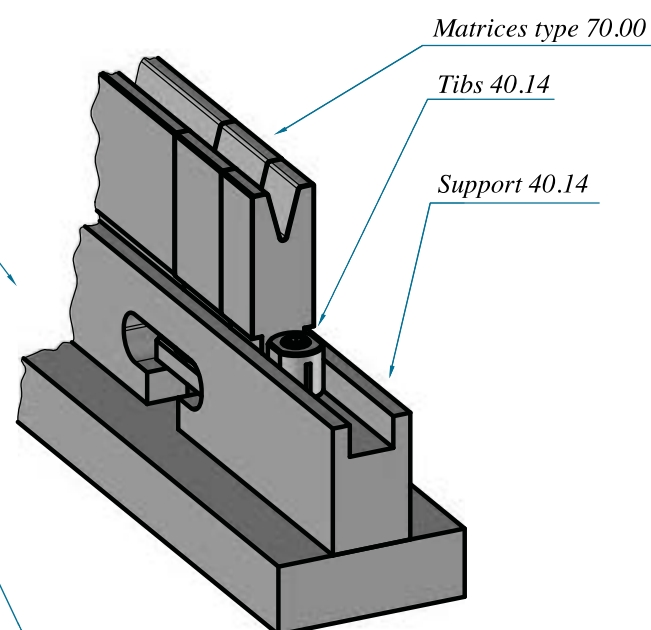
*Les matrices Amada typ sont disponibles
en long. 415, 835 et 805/835 fractionnée*



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

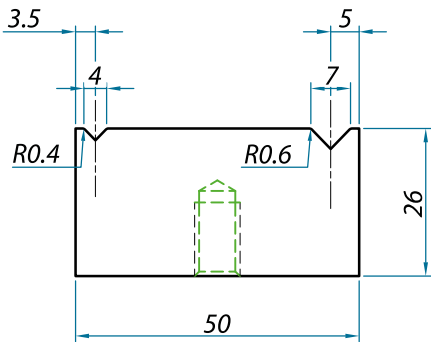
*Les matrices type 120 et 20.00 sont
vissées sur un support 40.06 ou 40.07*

*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*



121/88°

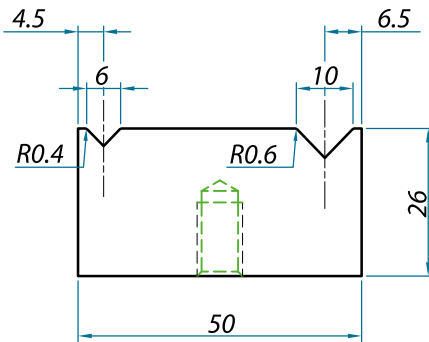
60T/m



Les vés sont à 88°

123/88°

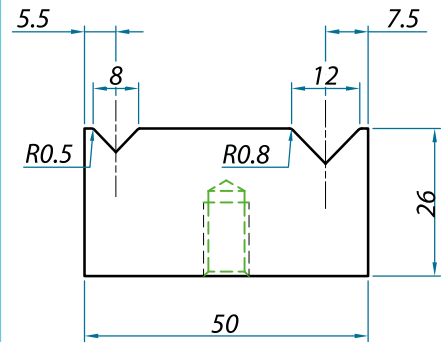
70T/m



Les vés sont à 88°

124/88°

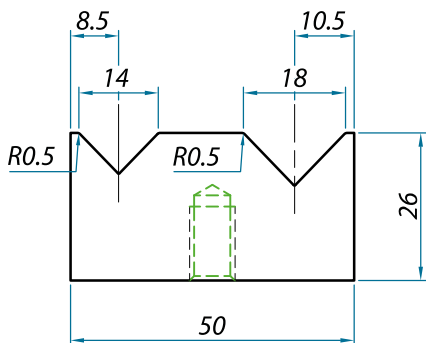
80T/m



Les vés sont à 88°

125/88°

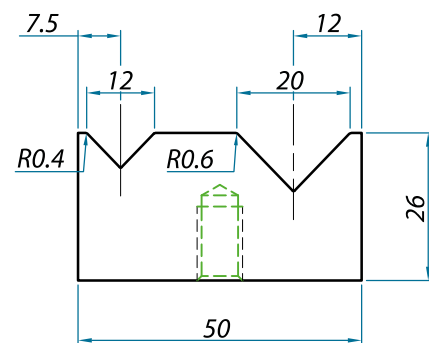
100T/m



Les vés sont à 88°

126/88°

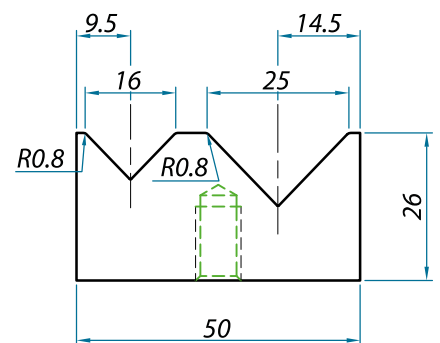
100T/m



Les vés sont à 88°

127/88°

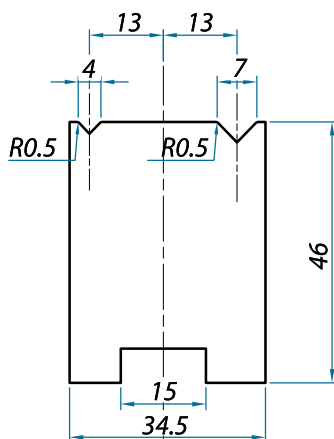
70T/m



Les vés sont à 88°

501/88°

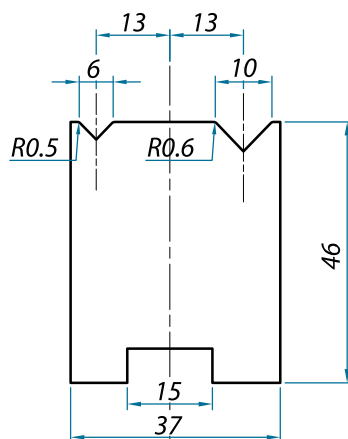
60T/m



Les vés sont à 88°

502/88°

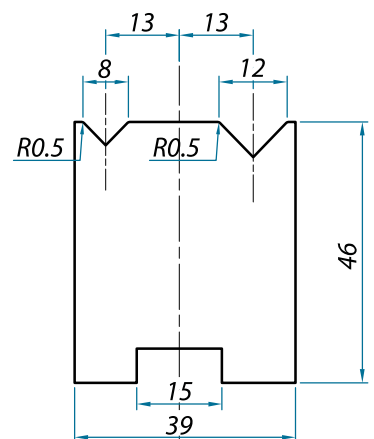
70T/m



Les vés sont à 88°

503/88°

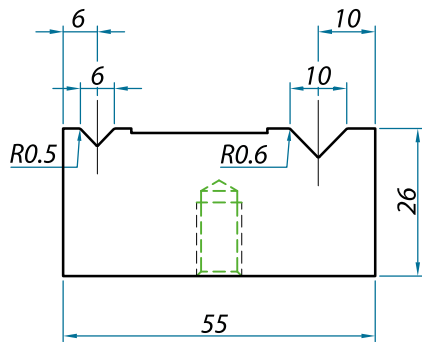
70T/m



Les vés sont à 88°

2012/88°

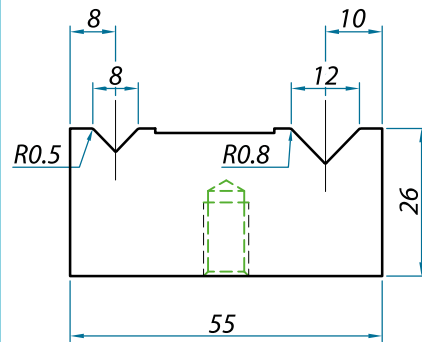
80T/m



Les vés sont à 88°

2013/88°

80T/m

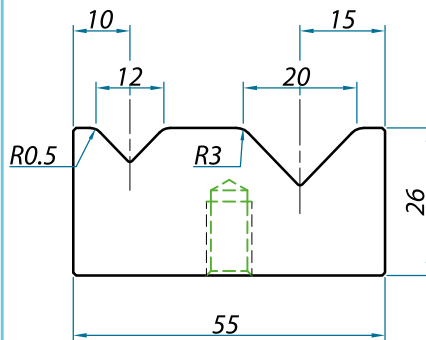


Les vés sont à 88°

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°

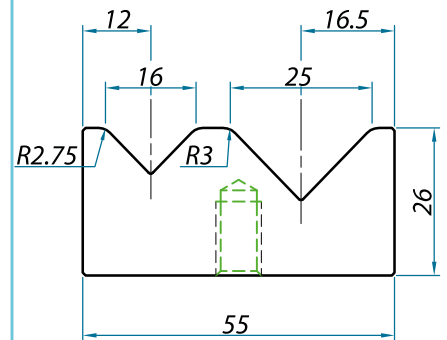
100T/m



Les vés sont à 88°

2015/88°

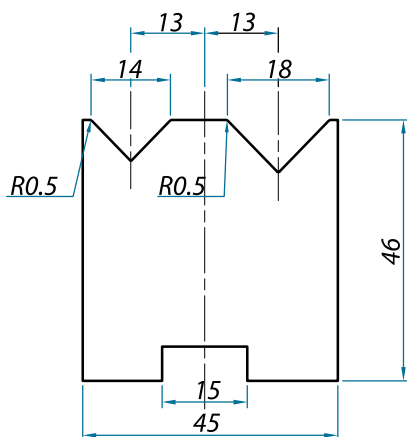
100T/m



Les vés sont à 88°

504/88°

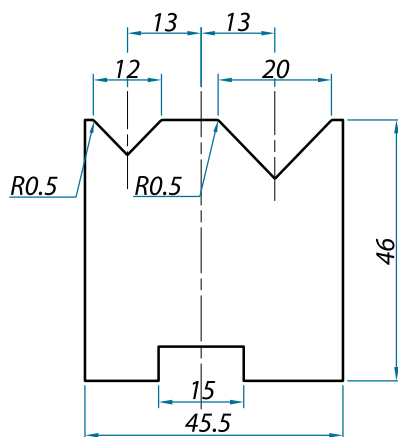
100T/m



Les vés sont à 88°

505/88°

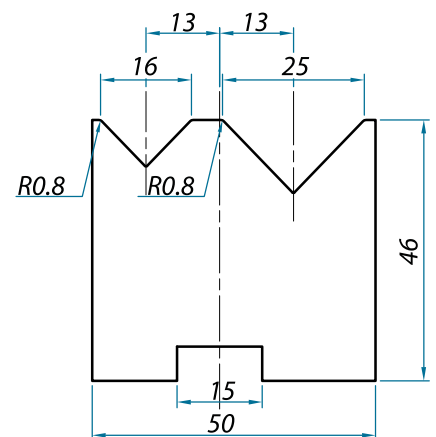
100T/m



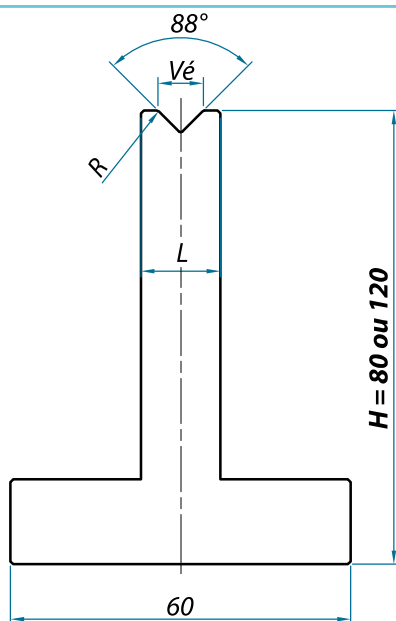
Les vés sont à 88°

506/88°

100T/m

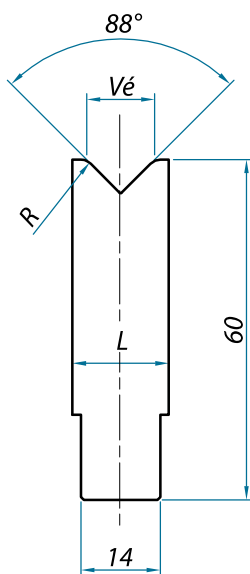


Les vés sont à 88°



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
20.47/88°	25	R3	35	100T/m

Ces matrices sont disponibles en **hauteur 80 ou 120**.

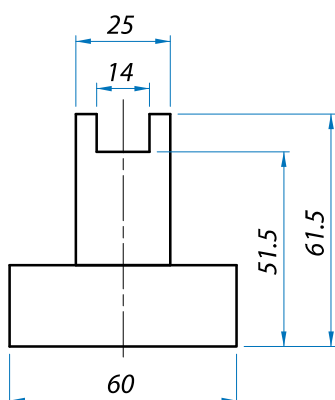


Modèle	Vé	R	L	F' maxi
70.88°	6	R1.5	14	95T/m
71.88°	8	R1.5	14	95T/m
72.88°	10	R2	15	95T/m
74.88°	12	R2.5	17	95T/m
76.88°	14	R2.5	18	95T/m
77.88°	16	R2.5	24	95T/m
78.88°	18	R2.5	28	95T/m
79.88°	20	R3	30	95T/m
80.88°	25	R3	35	95T/m

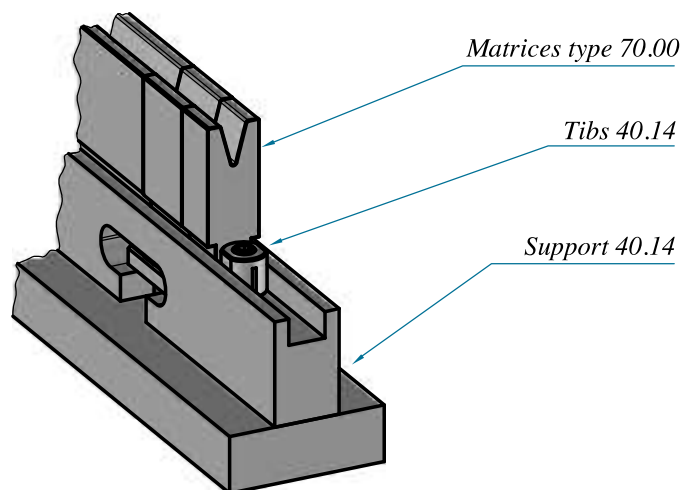
Matrices à utiliser avec support type 40.14

40.14

100T/m

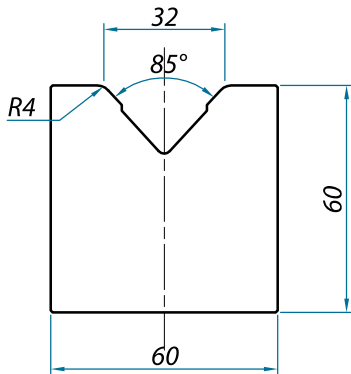


Les matrices type 70.00 sont posées dans le support 40.14,
les éléments fractionnés peuvent être maintenus à l'aide de Tibs.



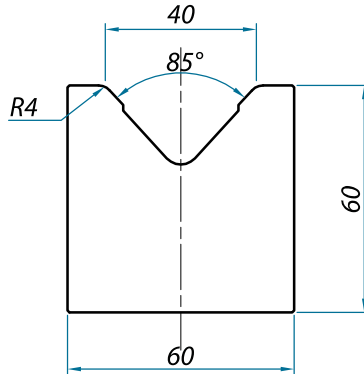
20.11/32

100T/m



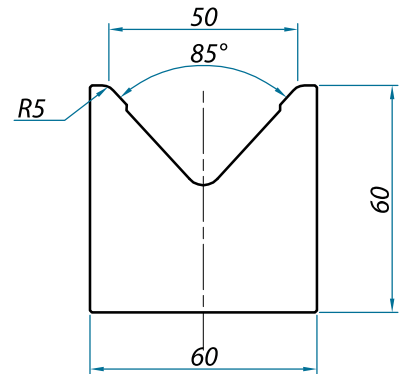
20.11/40

100T/m



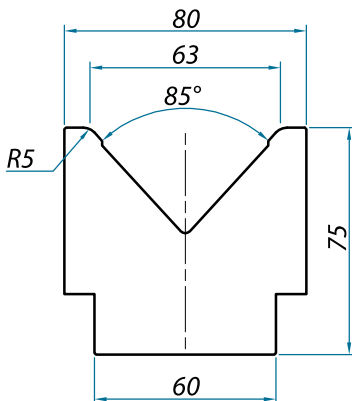
20.11/50

100T/m



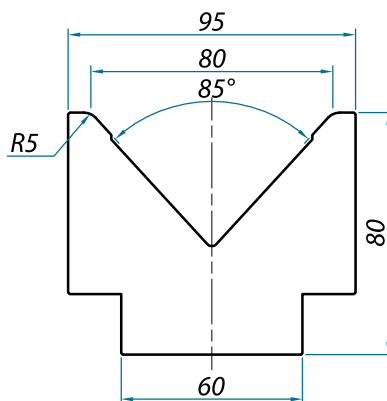
20.11/63

100T/m



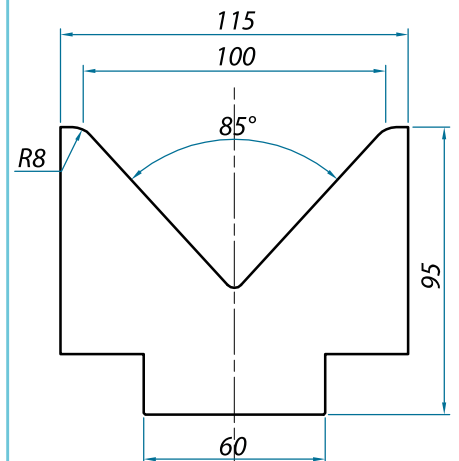
20.11/80

100T/m



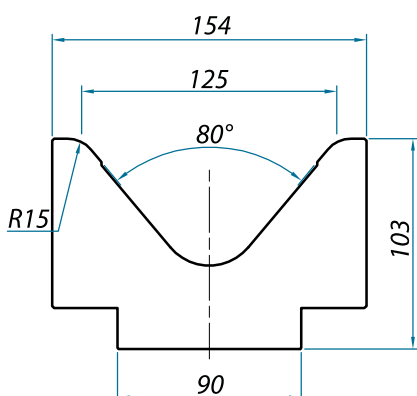
20.11/100

100T/m



20.11/125

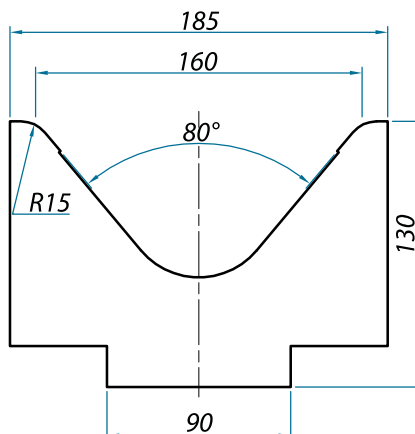
120T/m



Existe aussi en embase de 60 mm

20.11/160

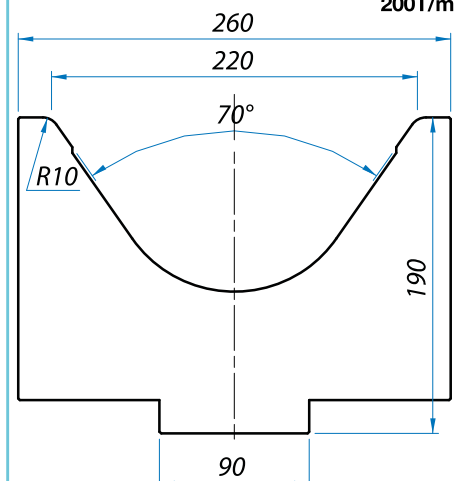
120T/m



Existe aussi en embase de 60 mm

20.11/220

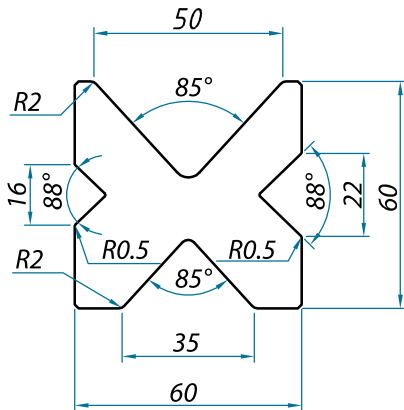
200T/m



Existe aussi en V200/70°
avec embase de 60 mm

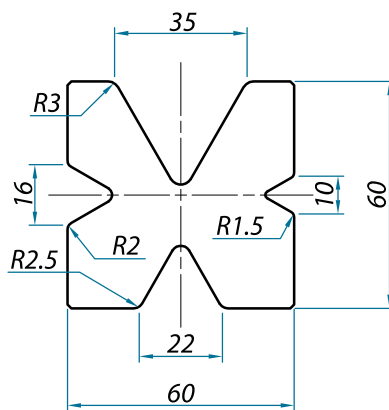
20.09

100T/m



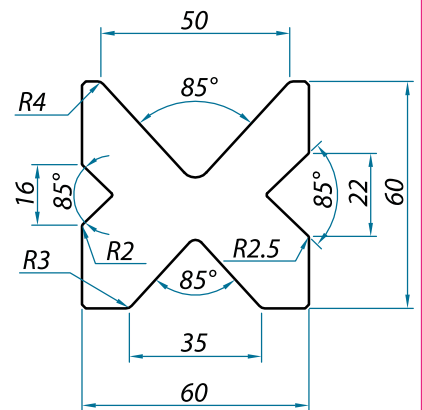
20.09/60°

70T/m



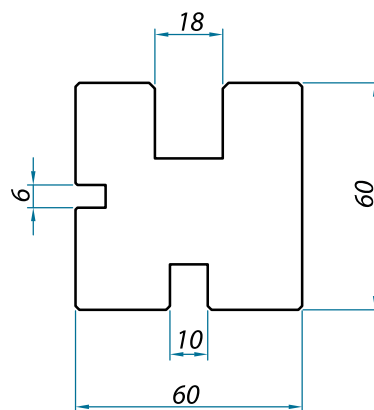
20.09/85°

80T/m



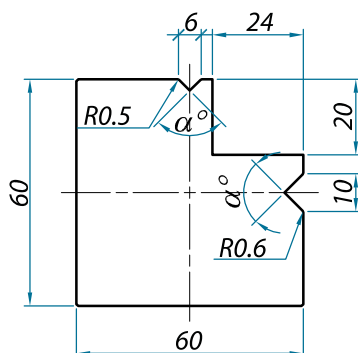
20.08

100T/m



20.16/88°
20.16/90°

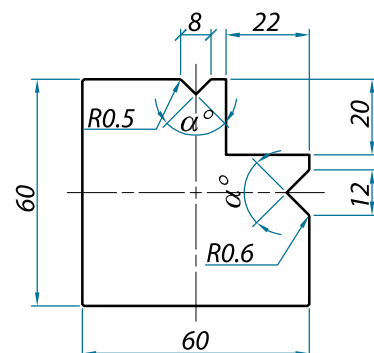
95T/m



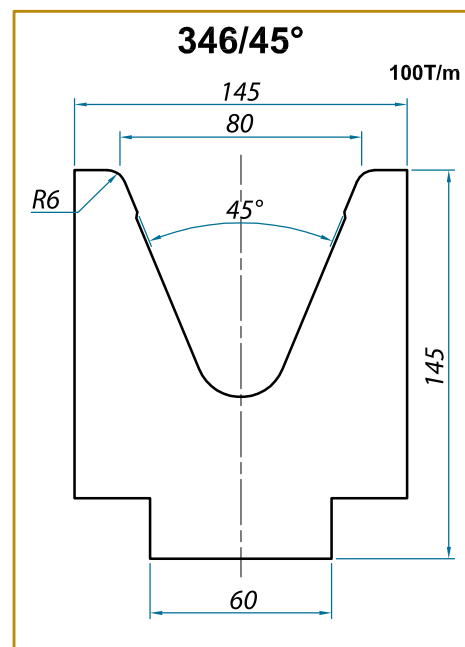
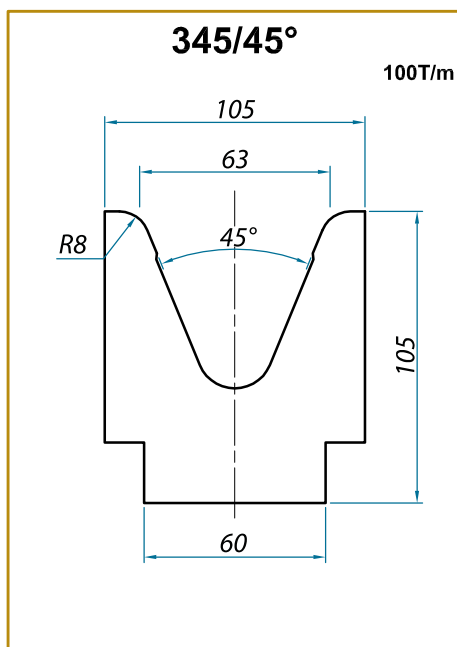
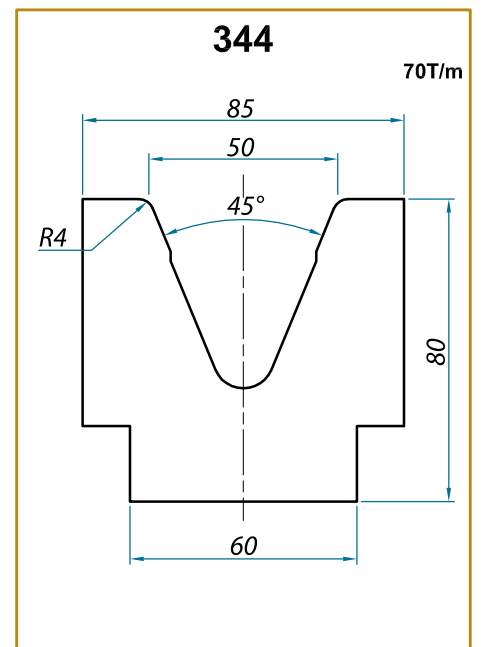
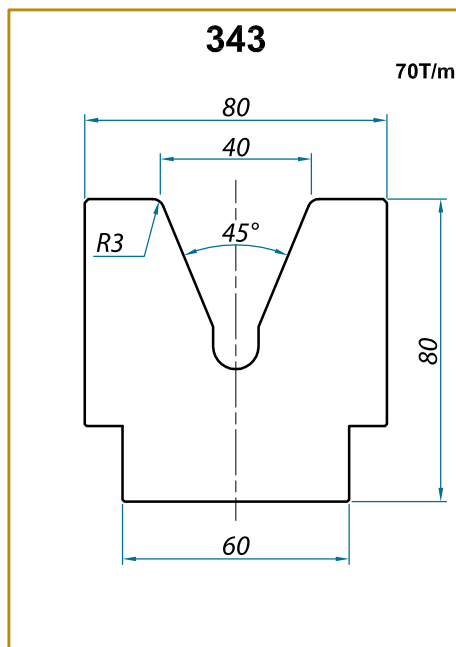
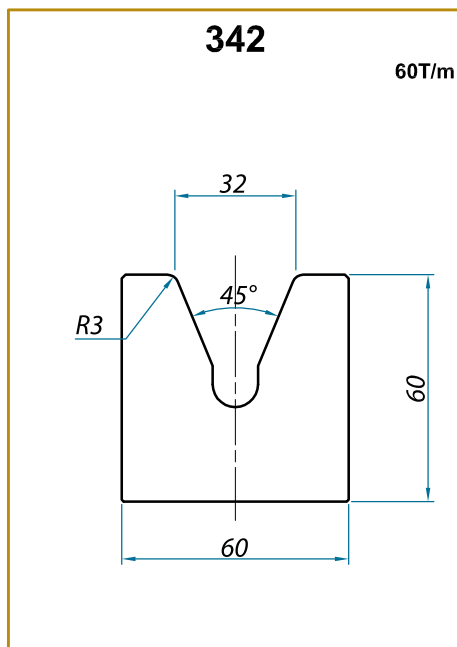
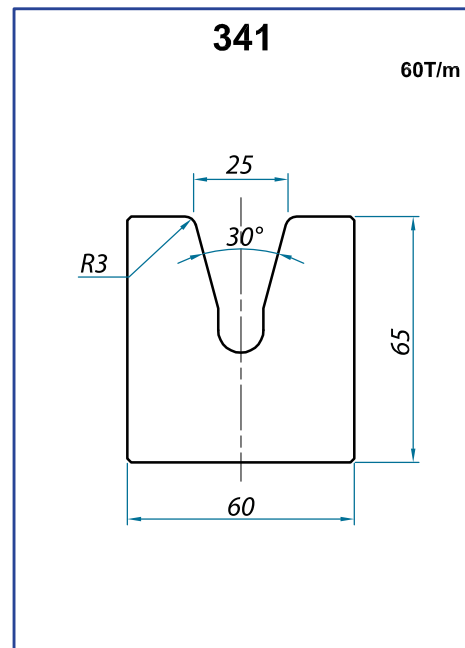
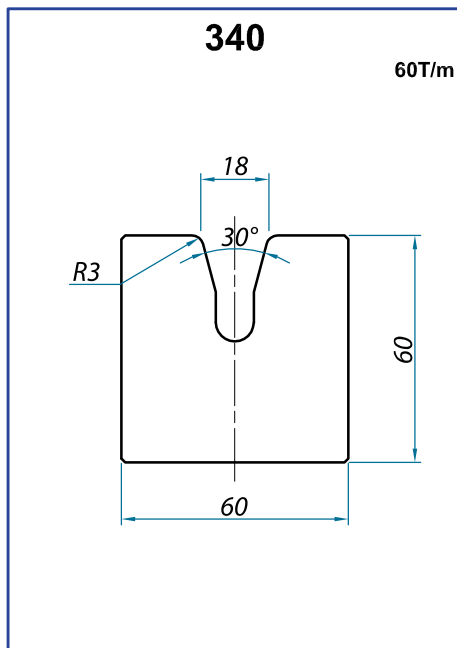
Disponible en 88° ou 90°

20.17/88°
20.17/90°

95T/m

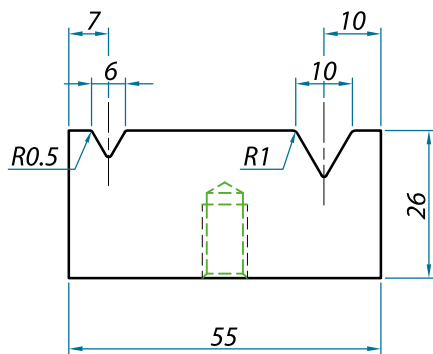


Disponible en 88° ou 90°



20.12/60°

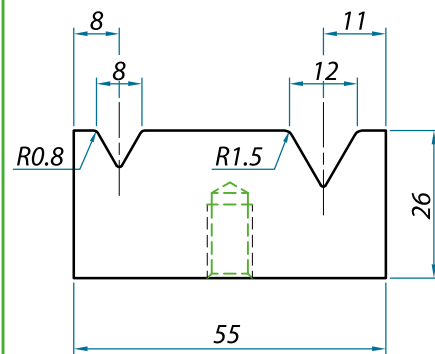
70T/m



Les vés sont à 60°

20.13/60°

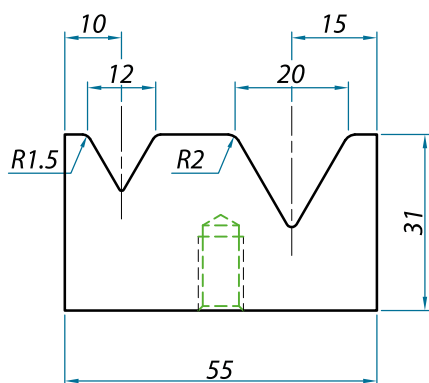
70T/m



Les vés sont à 60°

20.14/60°

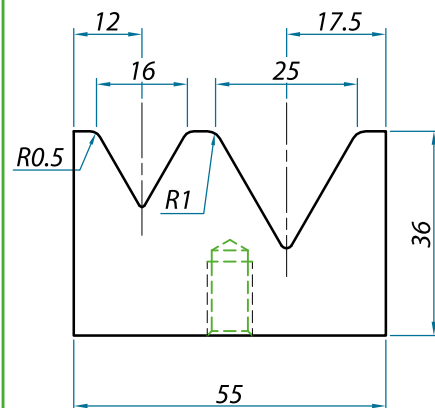
70T/m



Les vés sont à 60°

20.15/60°

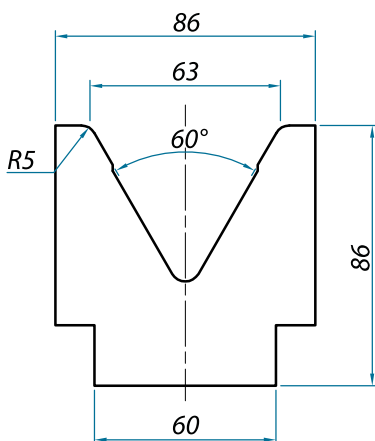
70T/m



Les vés sont à 60°

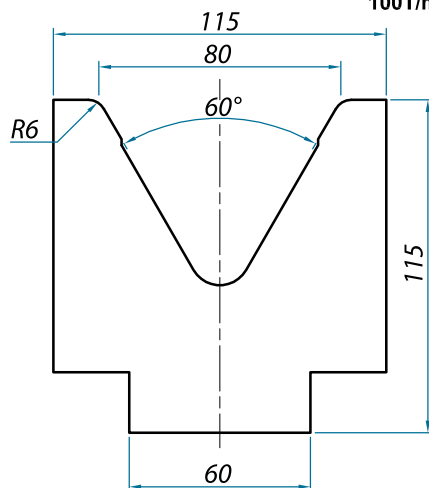
345/60°

100T/m



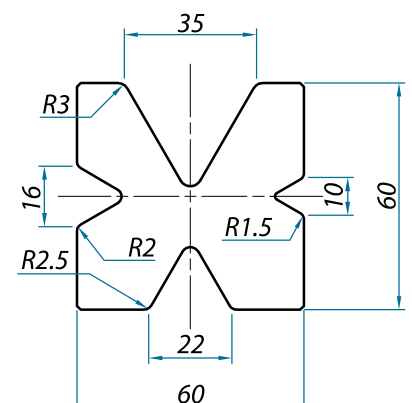
346/60°

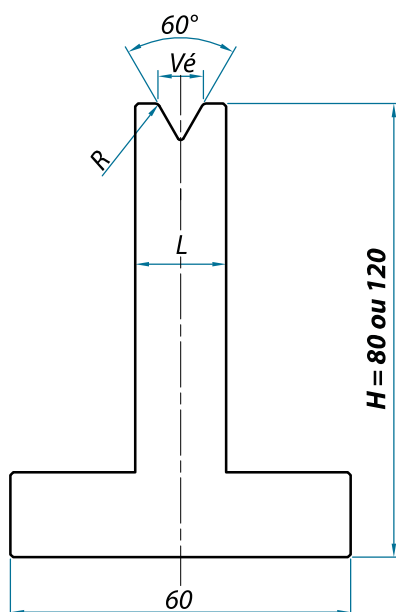
100T/m



20.09/60°

70T/m

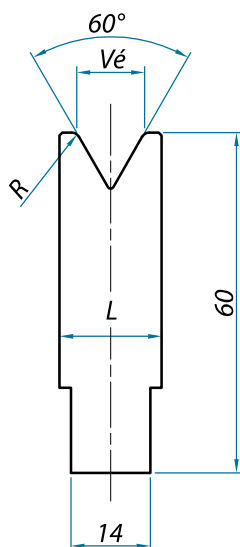




Modèle	Vé	R	L	F maxi
20.41/60°	6	R0.5	14	60T/m
20.42/60°	8	R0.8	16	70T/m
20.43/60°	10	R1	18	70T/m
20.44/60°	12	R1.5	20	70T/m
20.45/60°	16	R2	26	70T/m
20.46/60°	20	R2	30	70T/m
20.47/60°	25	R3	35	60T/m

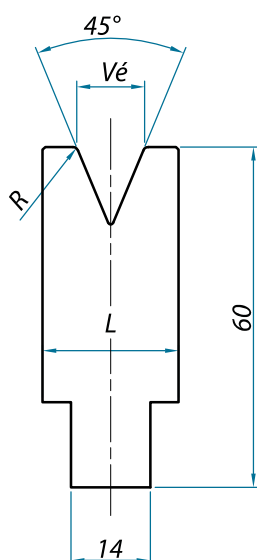
Existent aussi en 45°

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

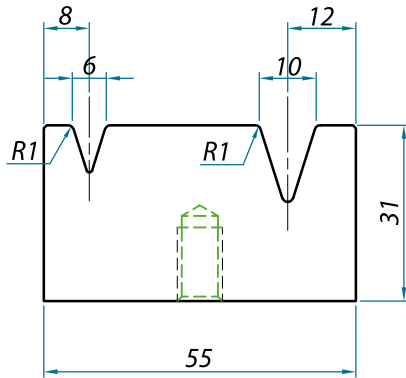


Modèle	Vé	R	L	F maxi
70.45°	6	R0.8	16	60T/m
71.45°	8	R1	18	70T/m
73.45°	10	R1	20	70T/m
75.45°	12	R1	24	70T/m
77.45°	16	R1.5	28	70T/m
79.45°	20	R2	32	70T/m
80.45°	25	R2.5	40	70T/m

Matrices à utiliser avec support type 40.14

20.12/35°

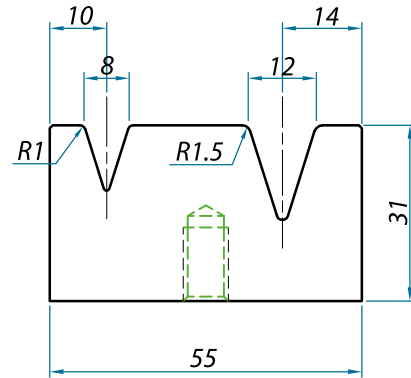
70T/m



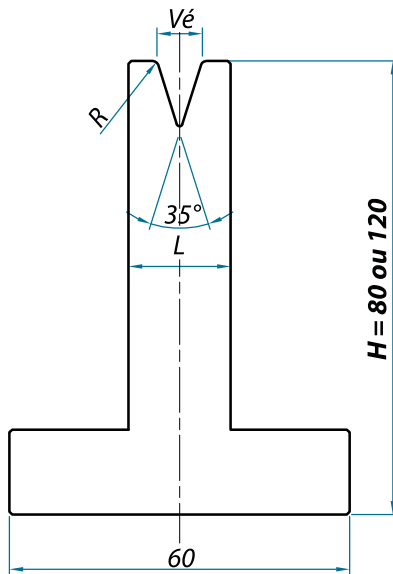
Les vés sont à 35°

20.13/35°

70T/m

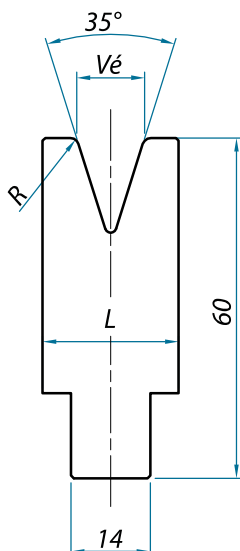


Les vés sont à 35°



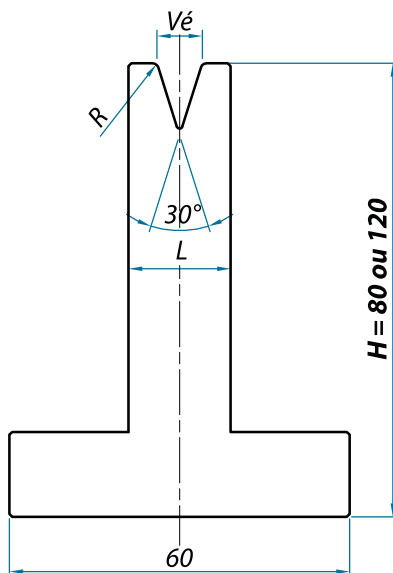
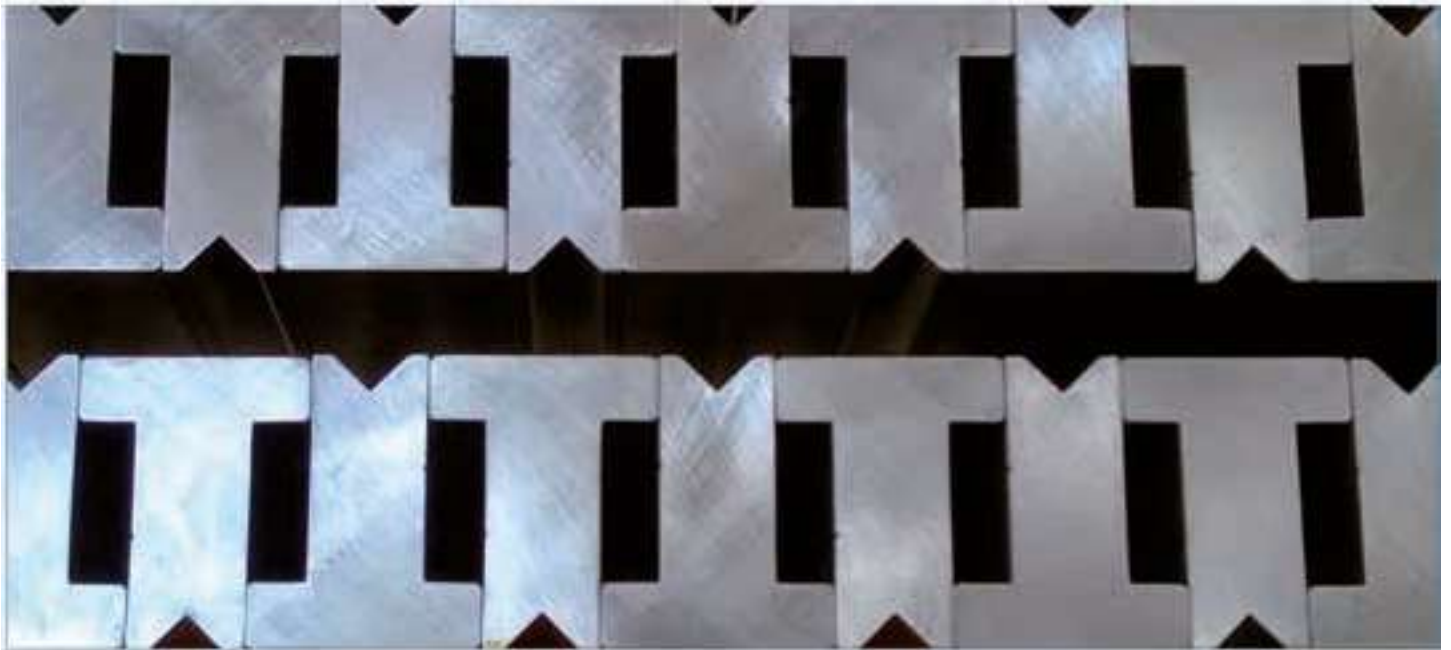
Modèle	Vé	R	L	F' maxi
20.41/35°	6	R1	16	50T/m
20.42/35°	8	R1	18	50T/m
20.43/35°	10	R1	20	50T/m
20.44/35°	12	R1.5	24	50T/m
20.45/35°	16	R2	30	50T/m
20.46/35°	20	R2	35	50T/m
20.47/35°	25	R5	40	60T/m

Ces matrices sont disponibles en **hauteur 80 ou 120**



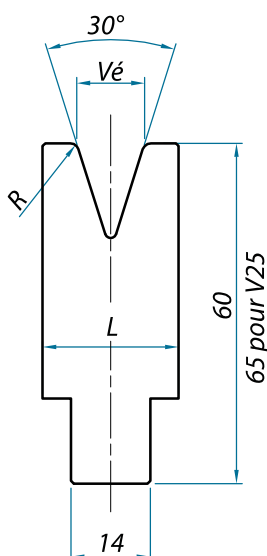
Modèle	Vé	R	L	F' maxi
70.35°	6	R1	16	50T/m
71.35°	8	R1	18	50T/m
73.35°	10	R1	20	50T/m
75.35°	12	R1.5	24	50T/m
77.35°	16	R2	30	50T/m
79.35°	20	R2	35	50T/m
80.35°	25	R3	40	60T/m

Matrices à utiliser avec support type 40.14



Modèle	Vê	R	L	F' maxi
20.41/30°	6	R0.6	14	35T/m
20.42/30°	8	R0.8	18	40T/m
20.43/30°	10	R1	24	50T/m
20.44/30°	12	R1.5	24	50T/m
20.45/30°	16	R2	30	50T/m
20.46/30°	20	R2.5	35	50T/m
20.47/30°	25	R3	40	50T/m

Ces matrices sont disponibles en **hauteur 80 ou 120**

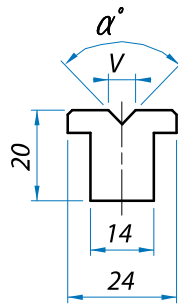
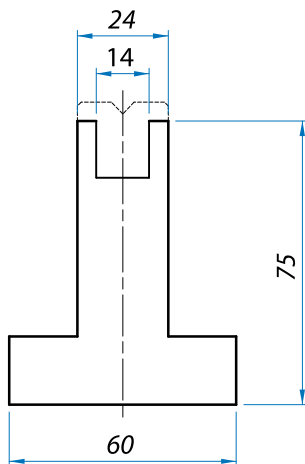


Modèle	Vê	R	L	F' maxi
70.30°	6	R1	16	35T/m
71.30°	8	R1	18	35T/m
73.30°	10	R1	20	50T/m
75.30°	12	R1.5	24	40T/m
77.30°	16	R2	30	45T/m
79.30°	20	R2	35	50T/m
80.30°	25	R3	45	50T/m

Matrices à utiliser avec support type 40.14

20.301

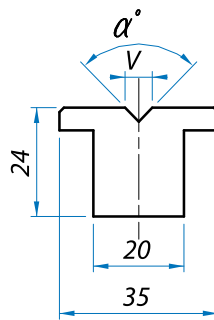
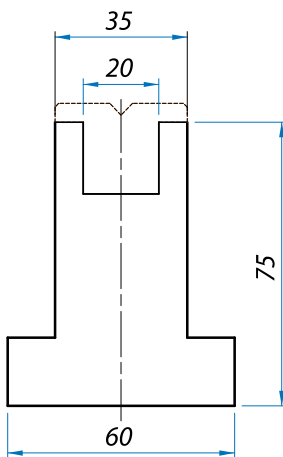
100T/m



Modèle	α°	Vé	F' maxi
31.306	30°	6	20T/m
31.308	30°	8	20T/m
31.606	60°	6	20T/m
31.608	60°	8	20T/m
31.610	60°	10	20T/m
31.806	88°	6	20T/m
31.808	88°	8	20T/m
31.810	88°	10	20T/m

20.302

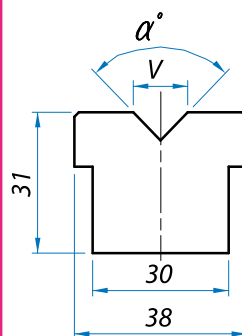
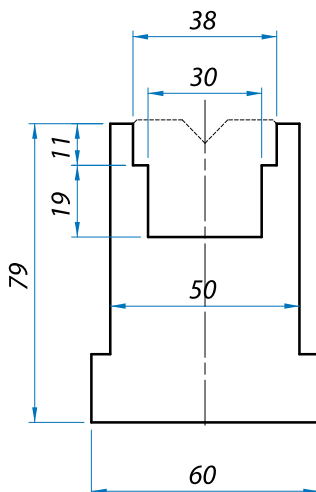
50T/m



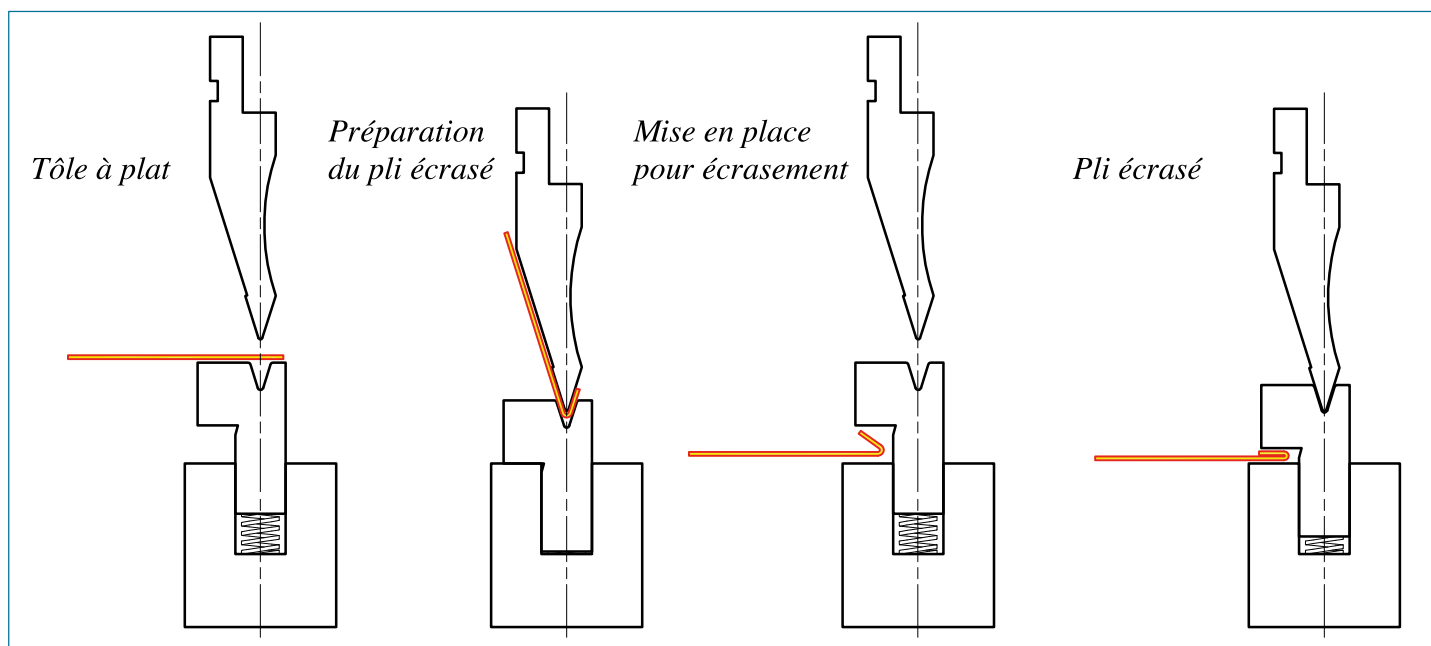
Modèle	α°	Vé	F' maxi
32.306	30°	6	20T/m
32.308	30°	8	20T/m
32.310	30°	10	20T/m
32.606	60°	6	20T/m
32.608	60°	8	20T/m
32.610	60°	10	20T/m
32.612	60°	12	20T/m
32.616	60°	16	20T/m
32.806	88°	6	20T/m
32.808	88°	8	20T/m
32.810	88°	10	20T/m
32.812	88°	12	20T/m
32.816	88°	16	20T/m

20.303

70T/m



Modèle	α°	Vé	F' maxi
33.310	30°	10	20T/m
33.312	30°	12	20T/m
33.316	30°	16	20T/m
33.610	60°	10	20T/m
33.612	60°	12	20T/m
33.616	60°	16	20T/m
33.620	60°	20	20T/m
33.810	88°	10	20T/m
33.812	88°	12	20T/m
33.816	88°	16	20T/m
33.820	88°	20	20T/m
33.825	88°	25	20T/m



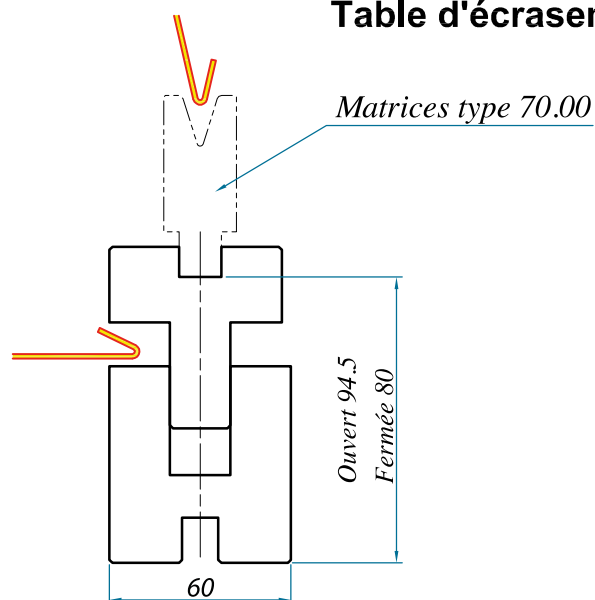
Acier ~ 40Kg/mm²

Epaisseur	 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/mm²

Epaisseur	 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

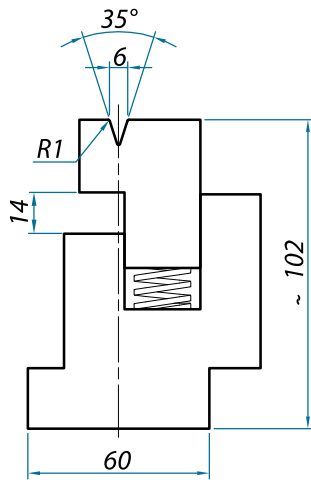
Table d'écrasement pneumatique



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.

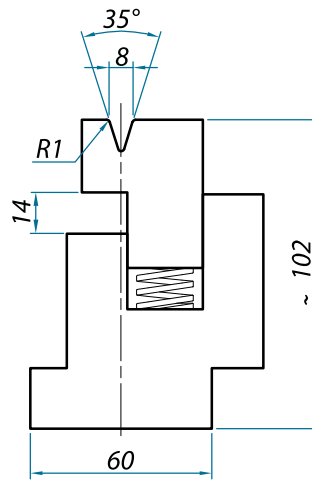
30.01 / 6-35°

60T/m



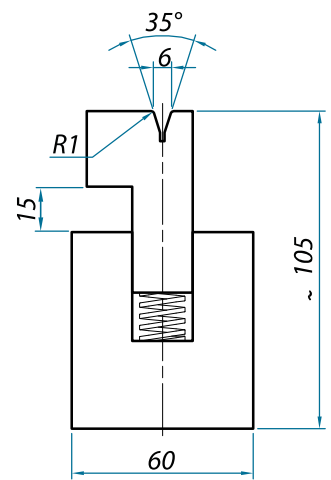
30.01 / 8-35°

50T/m



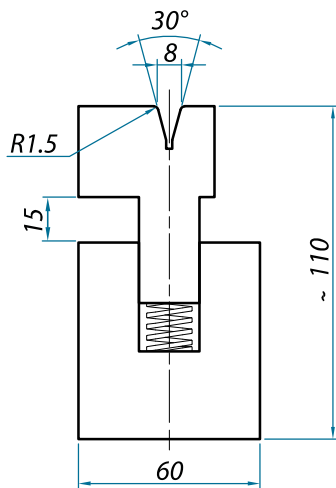
30.02 / 6-35°

80T/m



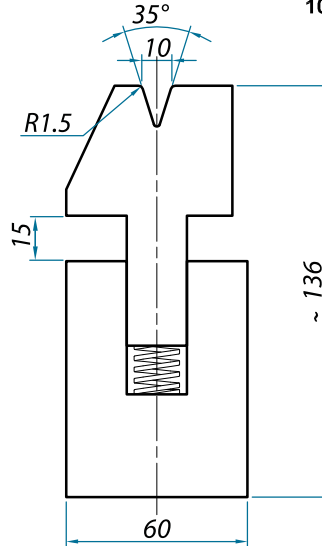
30.02 / 8-30°

80T/m



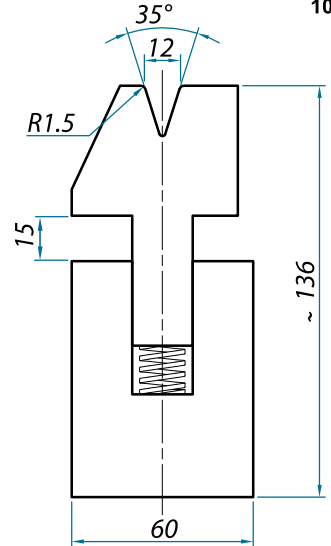
30.01 / 10-35°

100T/m



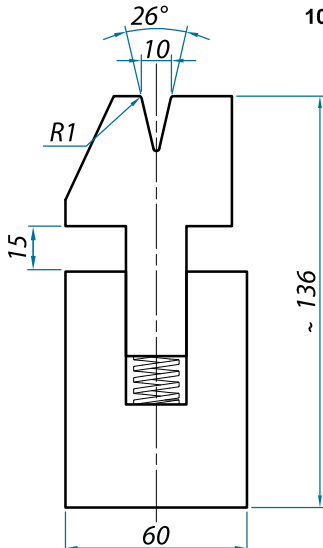
30.01 / 12-35°

100T/m



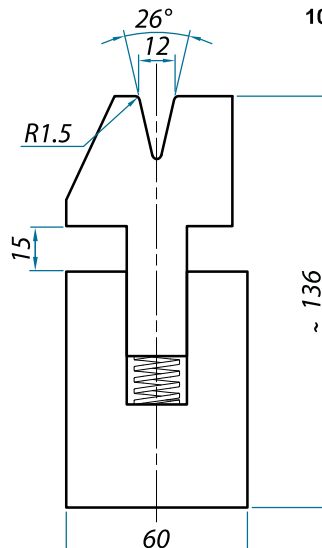
30.01 / 10-26°

100T/m



30.01 / 12-26°

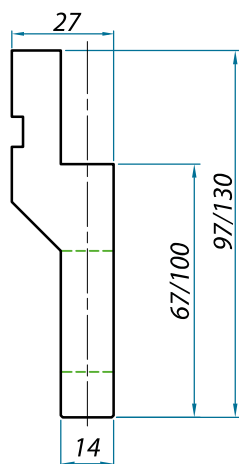
100T/m



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.

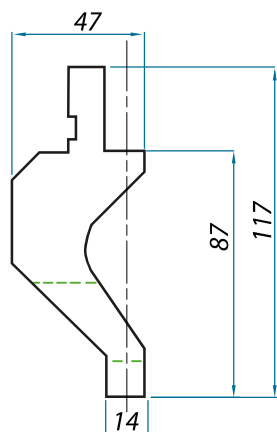
40.05 – H67 utile 40.116 – H100 utile

100T/m



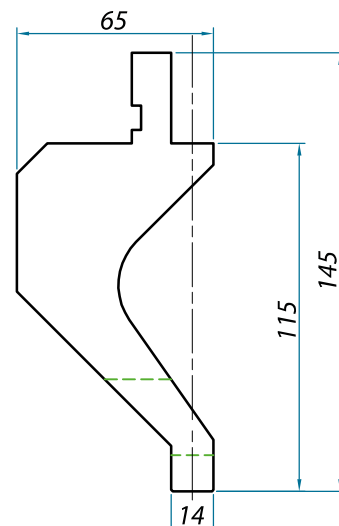
40.091

50T/m

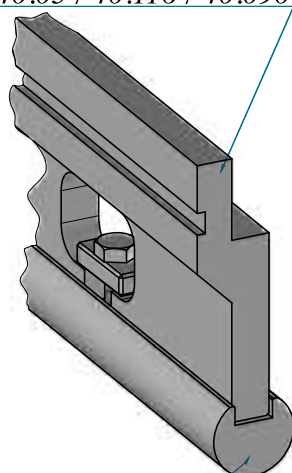


40.090

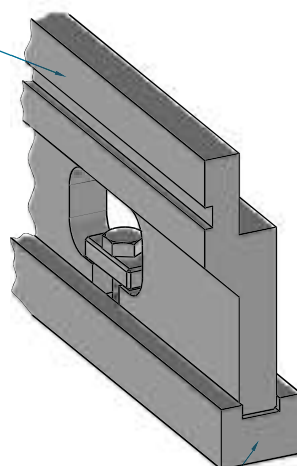
50T/m



Porte-règle
40.05 / 40.116 / 40.090



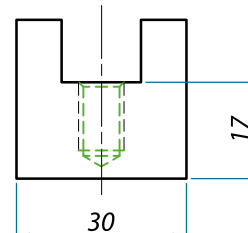
Règle à rayonner 40.09



Règle à écraser 40.02

40.02

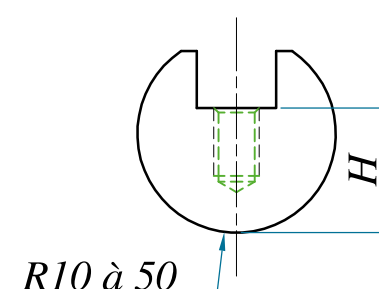
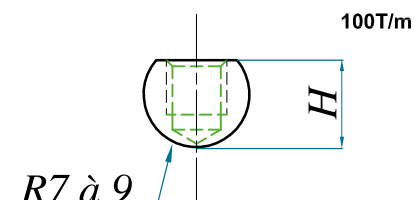
100T/m



40.09

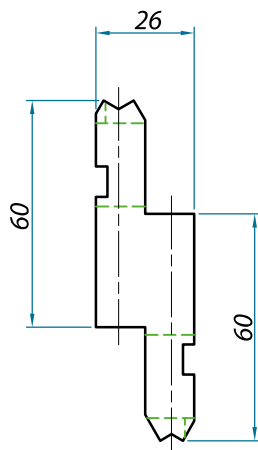
Modèle	R	H
40.09/14	7	11.5
40.09/15	7.5	11.5
40.09/16	8	13
40.09/18	9	16
40.09/20	10	12
40.09/25	12.5	17
40.09/30	15	20
40.09/35	17.5	22
40.09/40	20	24
40.09/50	25	29
40.09/60	30	34
40.09/80	40	44
40.09/100	50	70

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



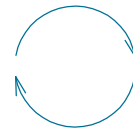
40.30

70T/m



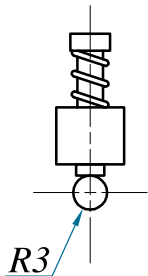
Montage coté A
pour R3 à 5

Montage coté B
pour R6 à 10

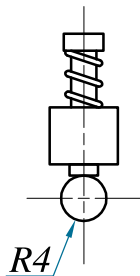


40.31

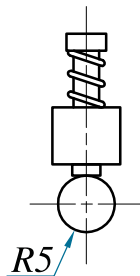
Pour coté A



40.31/06

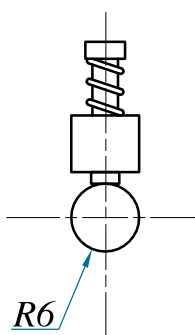


40.31/08

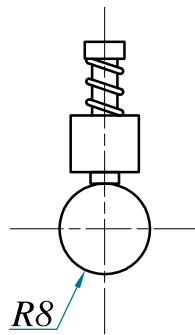


40.31/10

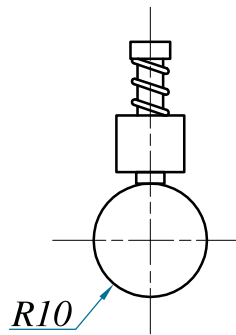
Pour coté B



40.31/12



40.31/16

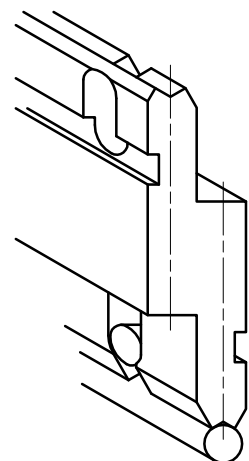


40.31/20

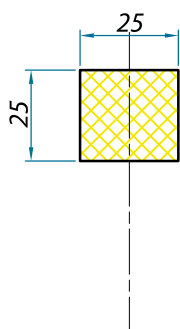
Fractionnement

Longueur 835
fractionnée en:

20 + 25 + 30 + 35 + 40
+ 50 + 70 + 165 + 200
+ 2 bigornes de 100mm

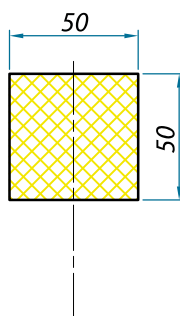


61.1



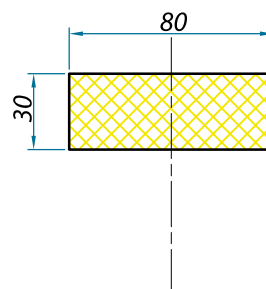
82 SHORE A

61.3



82 SHORE A

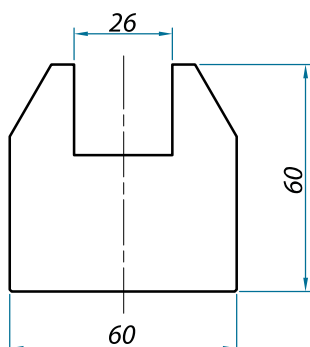
61.4



82 SHORE A

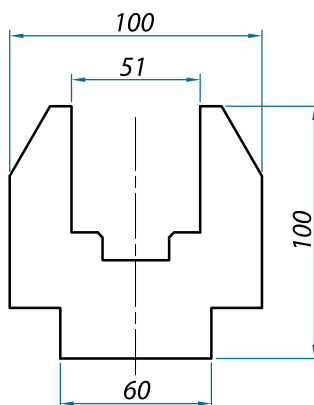
60.1

100T/m



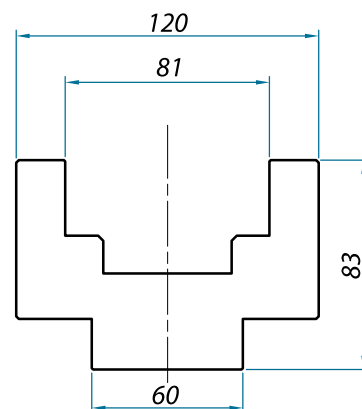
60.3

100T/m



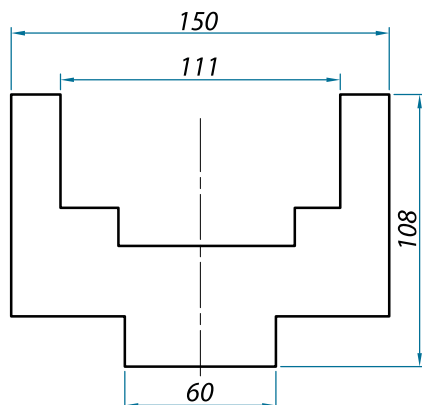
60.4

100T/m

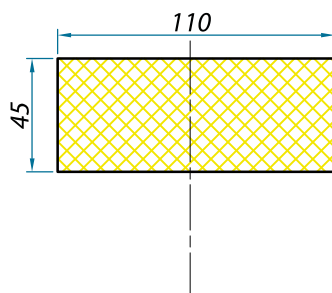


60.5

100T/m



61.5

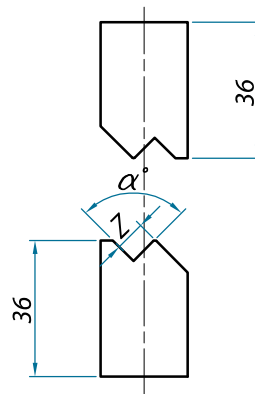
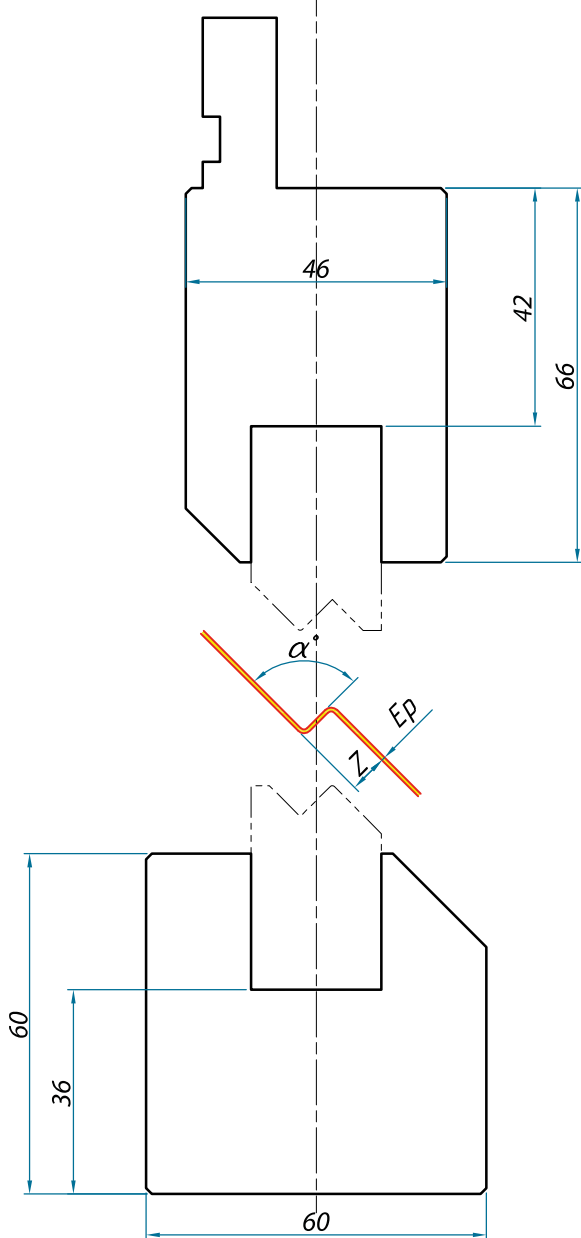


82 SHORE A

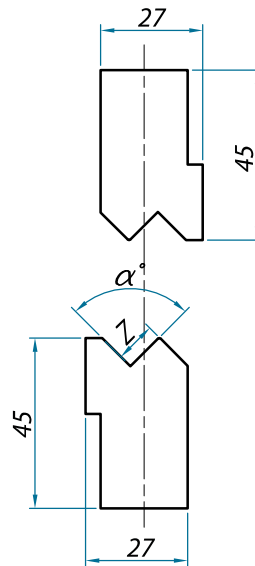
Le pliage sur élastomère permet, sur des tôles fines, de faire un pliage sans marque, un rayon en bord de tôle, un pliage avec un trou en bord de pli, etc.

AZ

100T/m

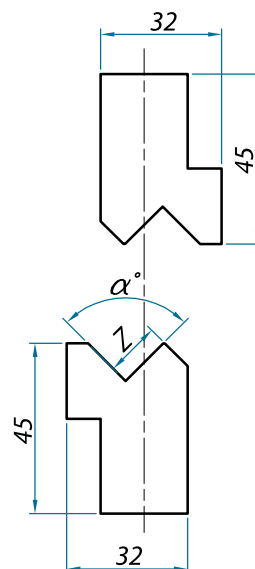
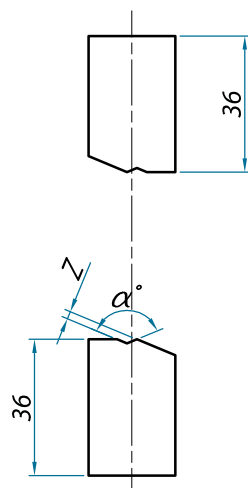


Modèle	Z	α°	Ep_{max}
Z1-90	1	90°	5/10
Z1.5-90	1.5	90°	6/10
Z2-90	2	90°	8/10
Z2.5-90	2.5	90°	10/10
Z3-90	3	90°	10/10
Z3.5-90	3.5	90°	12/10
Z4-90	4	90°	12/10
Z4.5-90	4.5	90°	15/10
Z5-90	5	90°	15/10
Z5.5-90	5.5	90°	15/10
Z6-90	6	90°	15/10
Z6.5-90	6.5	90°	15/10
Z7-90	7	90°	20/10
Z7.5-90	7.5	90°	20/10
Z8-90	8	90°	25/10



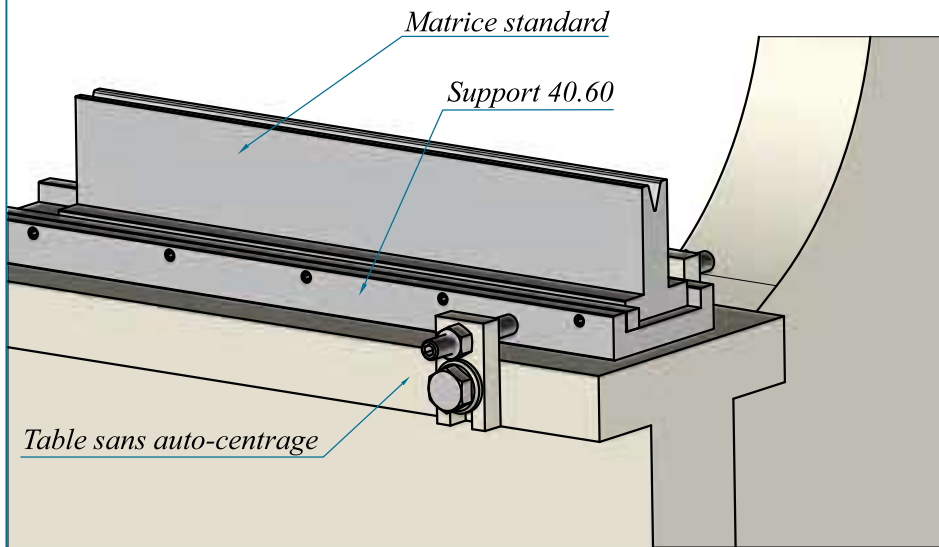
Modèle	Z	α°	Ep_{max}
Z9-90	9	90°	25/10
Z10-90	10	90°	30/10
Z11-90	11	90°	30/10
Z12-90	12	90°	30/10

Modèle	Z	α°	Ep_{max}
Z1-160	1	160°	10/10
Z1.5-160	1.5	160°	12/10
Z2-150	2	150°	15/10
Z2.5-140	2.5	140°	15/10



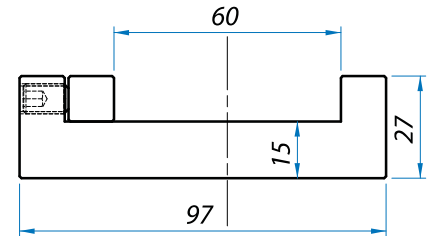
Modèle	Z	α°	Ep_{max}
Z13-90	13	90°	30/10
Z14-90	14	90°	30/10
Z15-90	15	90°	30/10

Adaptation des matrices Amada sur table plate



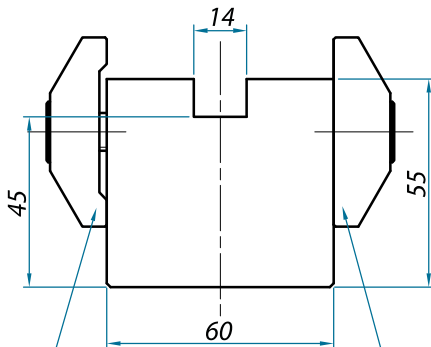
40.60

100T/m



40.58

100T/m

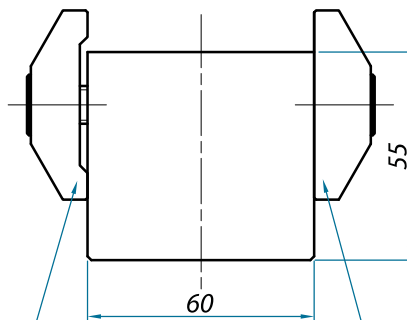


Brides de serrage
Ref. ST41

Brides fixes
Ref. ST55

40.55

100T/m

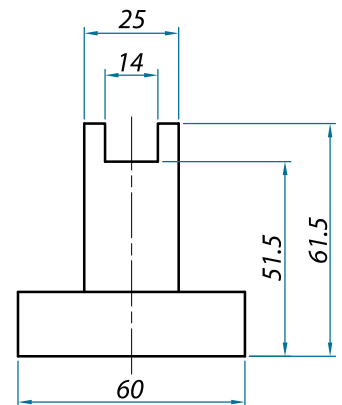


Brides de serrage
Ref. ST41

Brides fixes
Ref. ST55

40.14

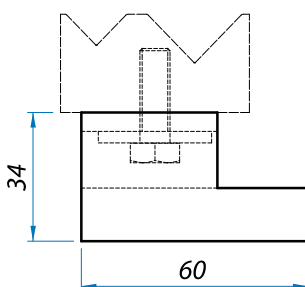
100T/m



Alignement réglable par vis

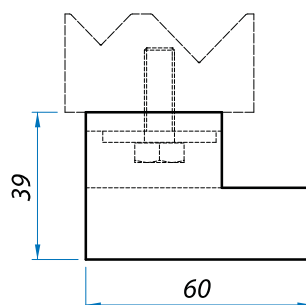
40.06/34

100T/m



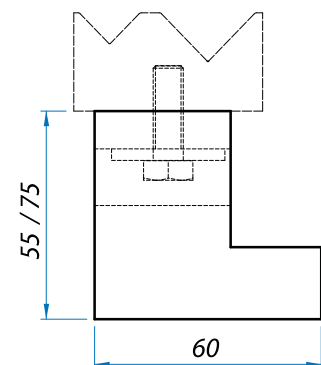
40.06/39

100T/m



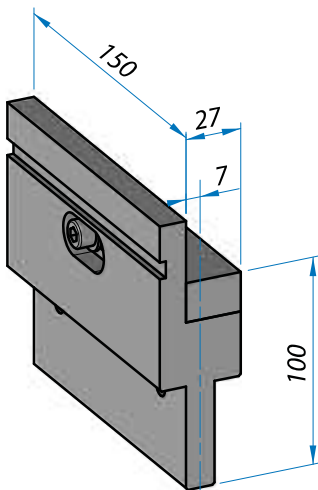
40.07/55
40.07/75

100T/m



40.03

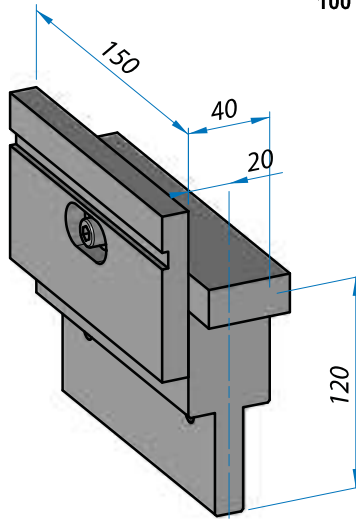
100T/m



Existe aussi en H120 et H150

40.50

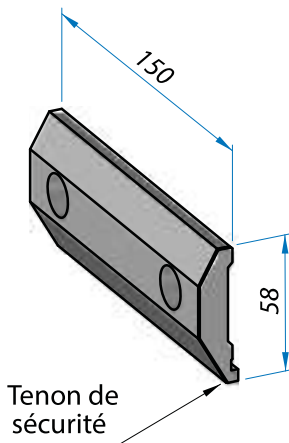
100T/m



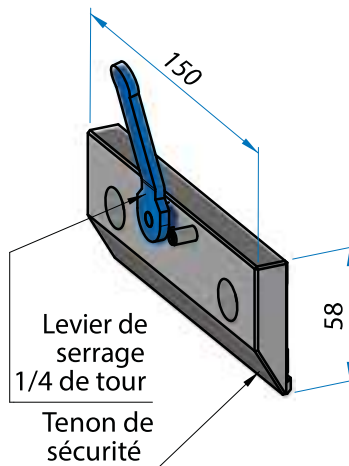
Existe aussi en H150



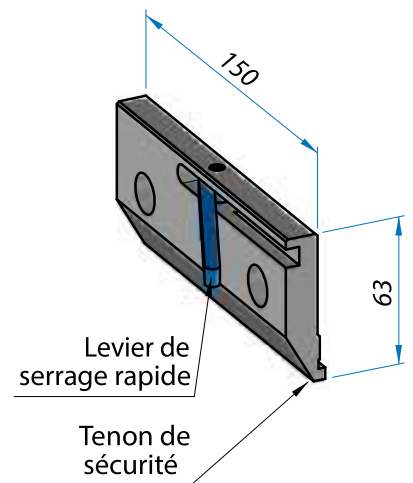
ST43



ST21

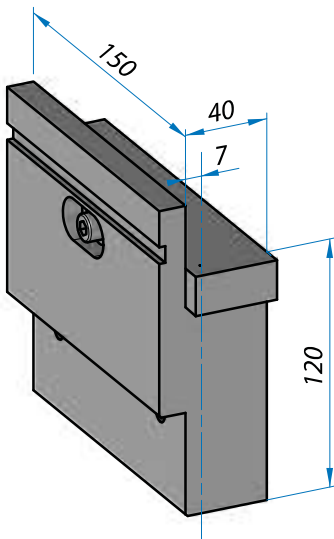


ST44



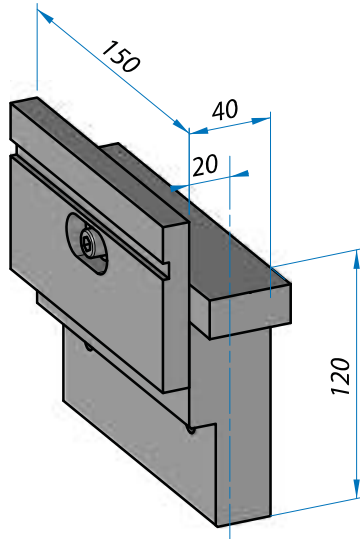
40.03 FC

160T/m

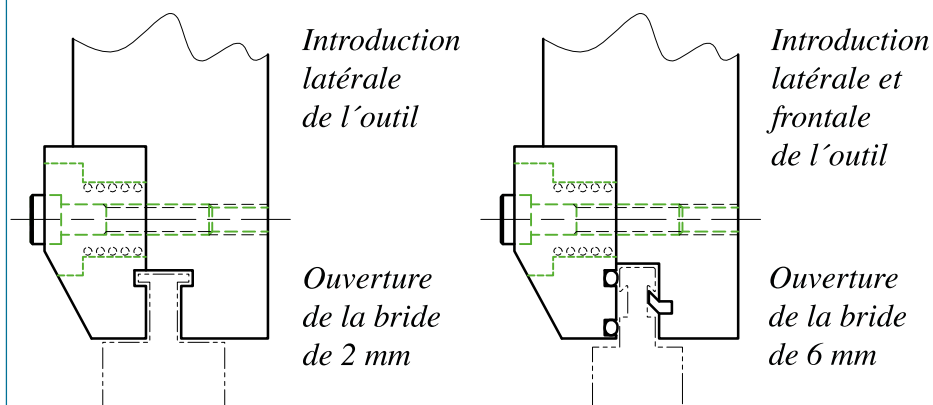


40.50 FC

160T/m



Systèmes de blocage hydrauliques



Systèmes de blocage hydrauliques

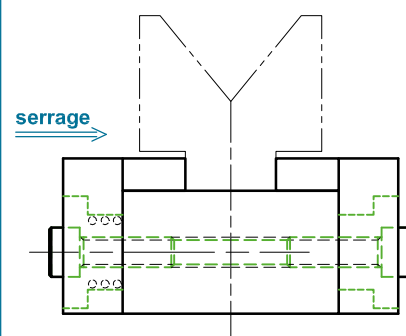
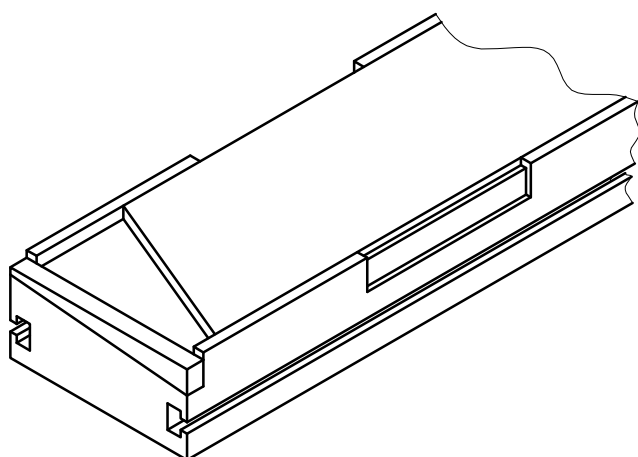


Table de bombage spéciale à l'aide de cales coniques

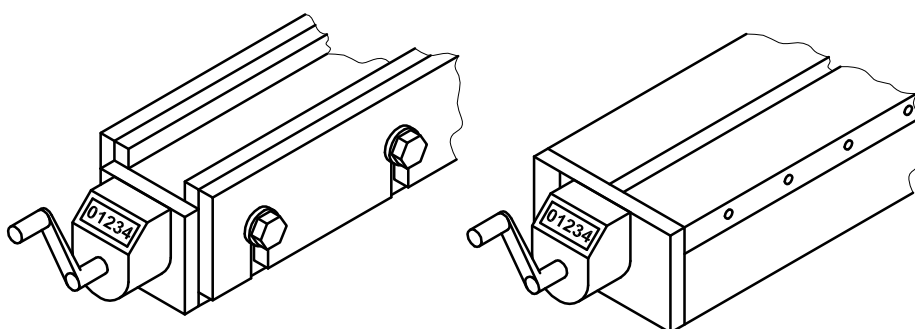


On sait que l'angle de pli n'est pas égal sur la longueur totale à cause des flexions qui se vérifient pendant le travail sur les presses.

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

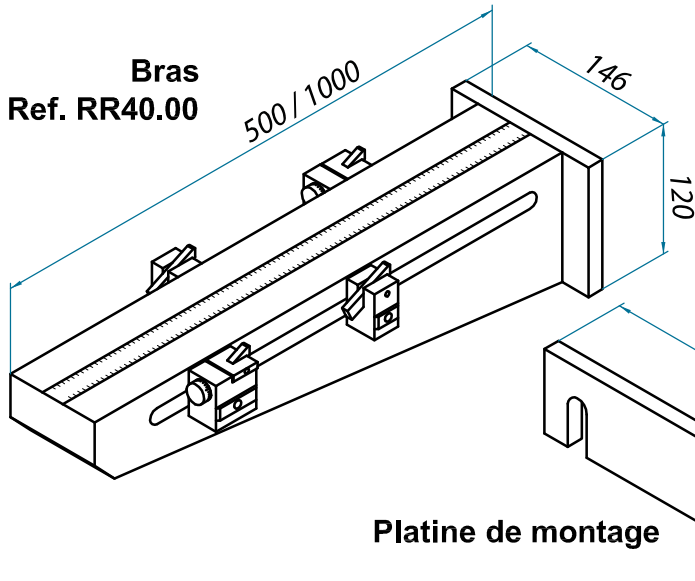
*Deux compensations possibles:
Longitudinales pour les déformations linéaires et transversale pour les déformations localisées.*

Table de bombage standard manuelle

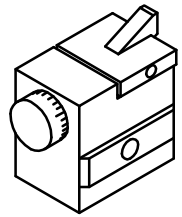


Butées avants pour presse plieuse

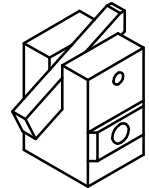
Bras
Ref. RR40.00



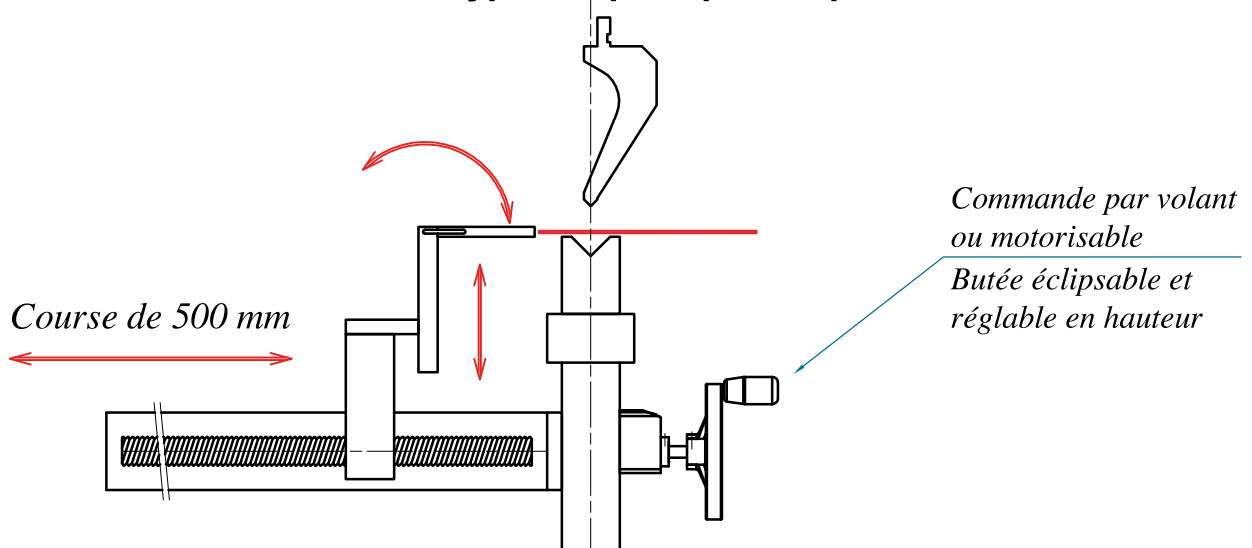
Butée micro
Ref. 6036



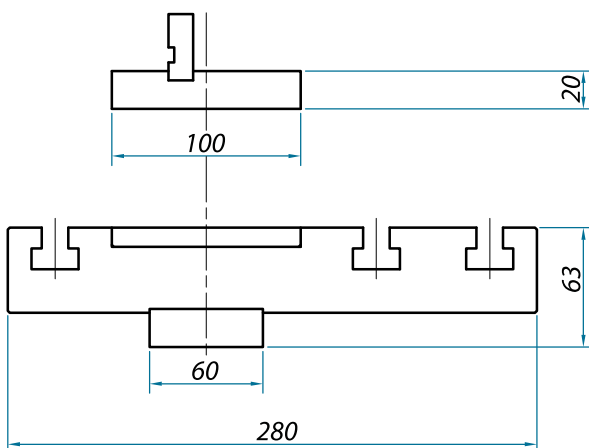
Butée escamotable
Ref. 6032



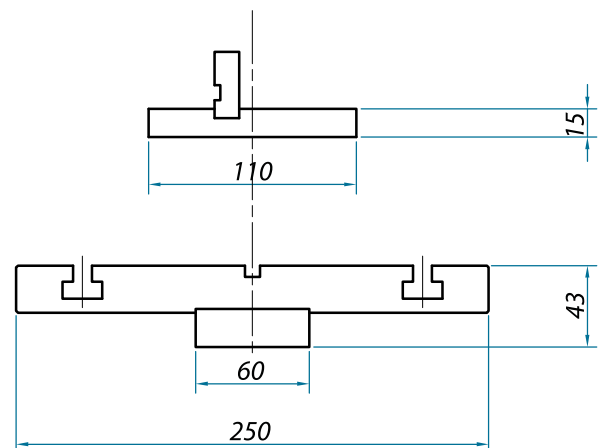
Butée arrière type BM pour presse plieuse



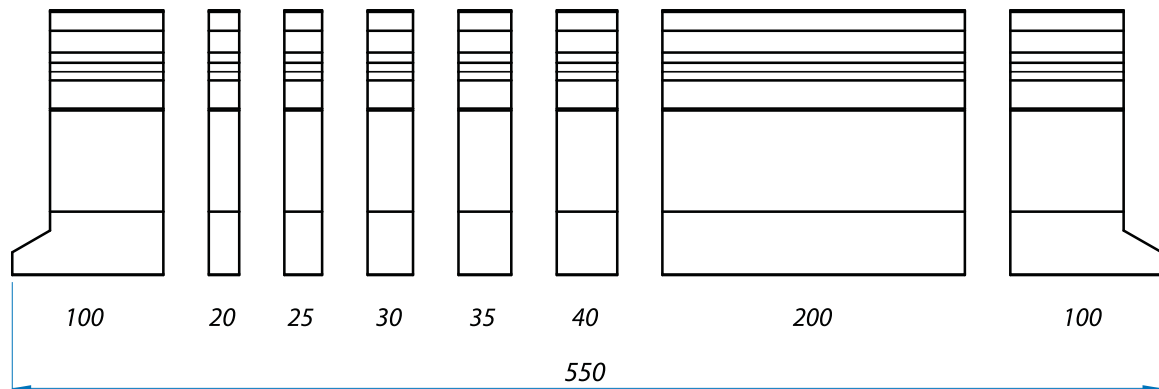
40.10 / 40.11 Montage pour unités de poinçonnage



40.20 / 40.30 Montage pour unités de poinçonnage

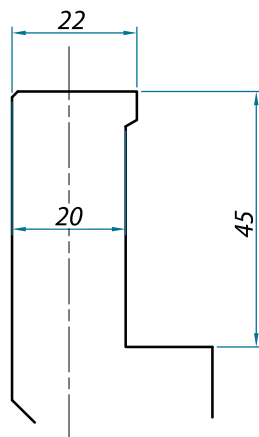


*Toutes les lames Bystronic - Beyeler typ sont disponibles
en long. 515, 550 fractionnée*

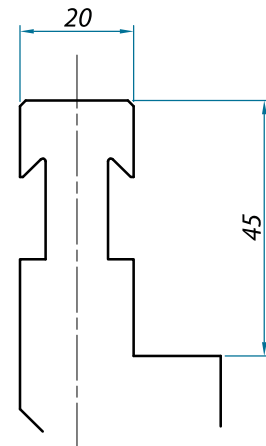


Sur demande: Long. 1000 fractionnée sans bigorne

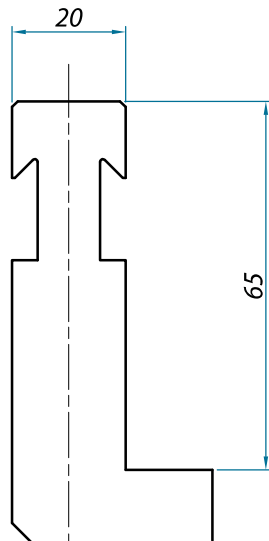
Type S



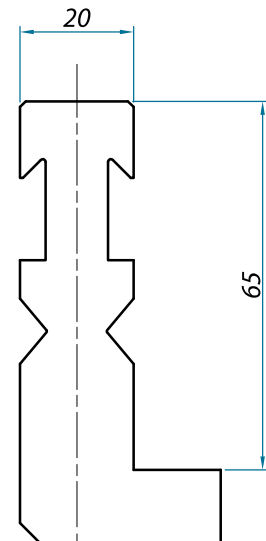
Type R



Type RF

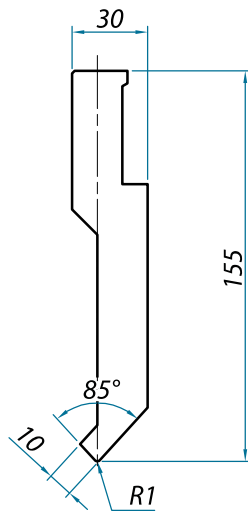


Type RF-A



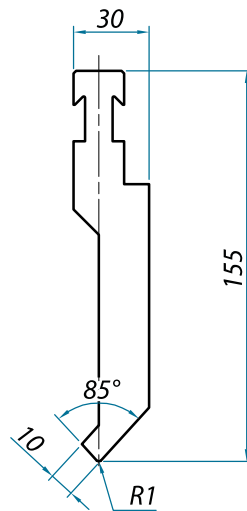
P2 S

130T/m



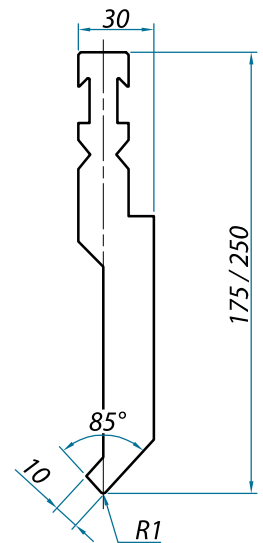
P2 R

130T/m



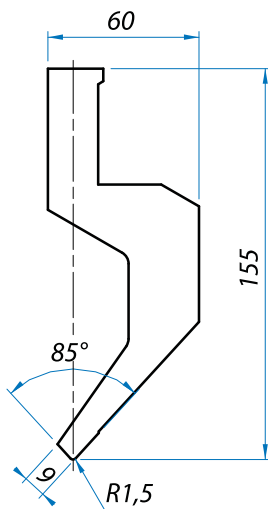
P2 RF-A

130T/m



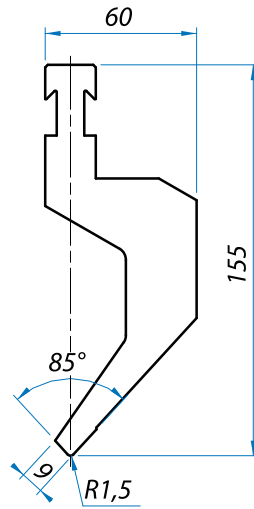
P4 S

90T/m



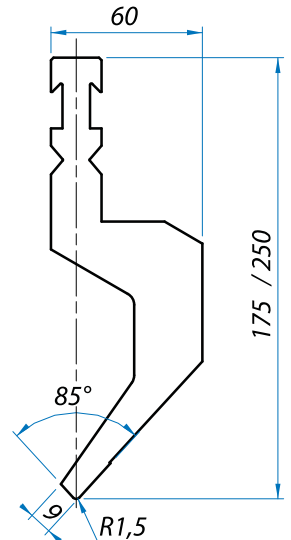
P4 R

90T/m



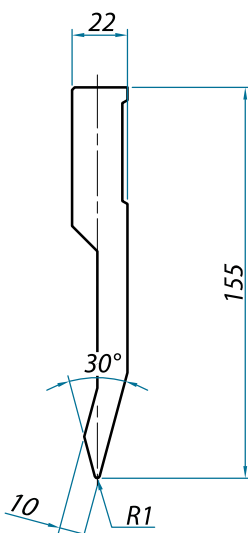
P4 RF-A

90T/m



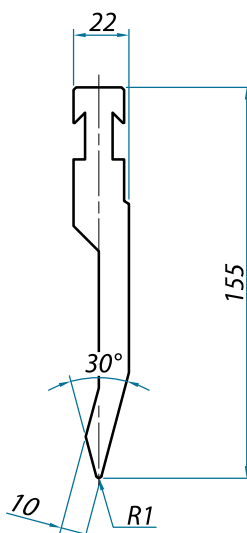
P5 S

100T/m



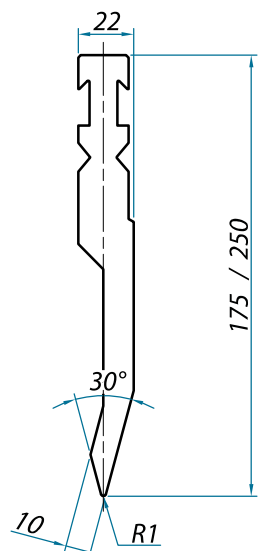
P5 R

100T/m



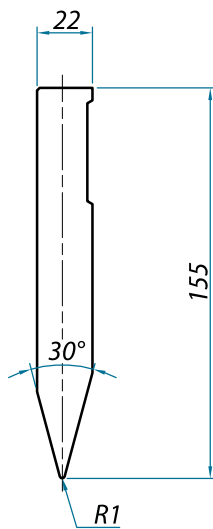
P5 RF-A

100T/m



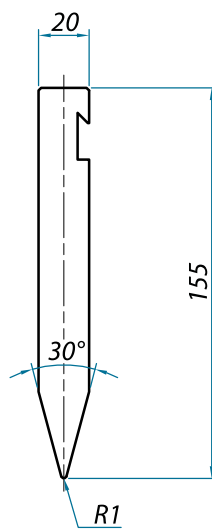
P6 S

160T/m



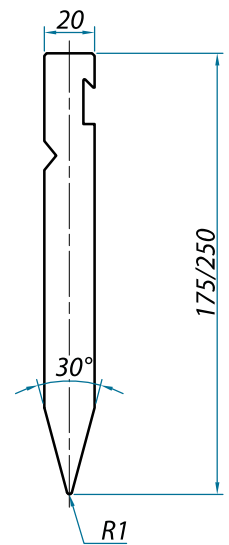
P6 R

160T/m



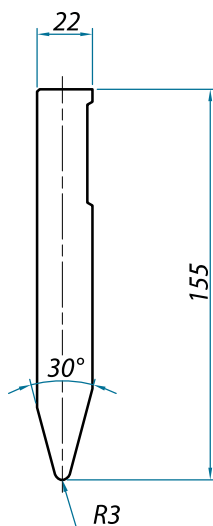
P6 RF-A

160T/m



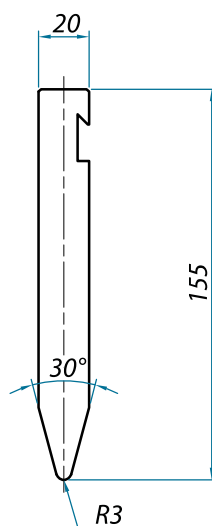
P7 S

160T/m



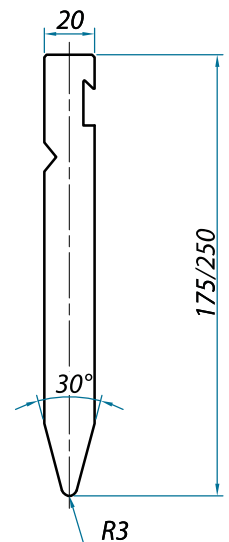
P7 R

160T/m



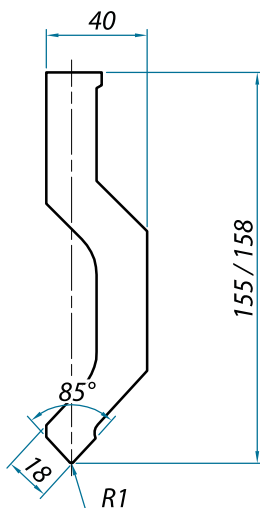
P7 RF-A

160T/m



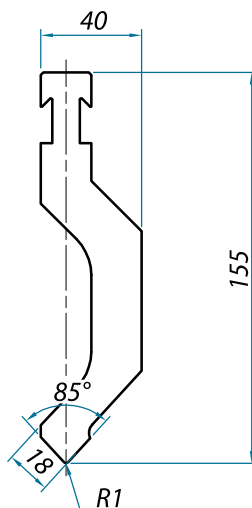
P8 S

100T/m



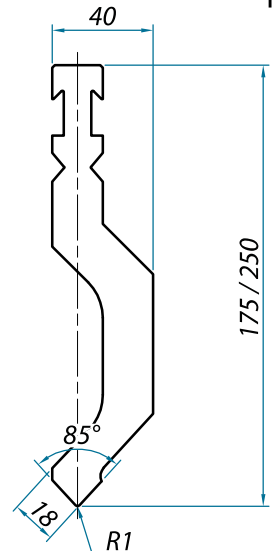
P8 R

100T/m

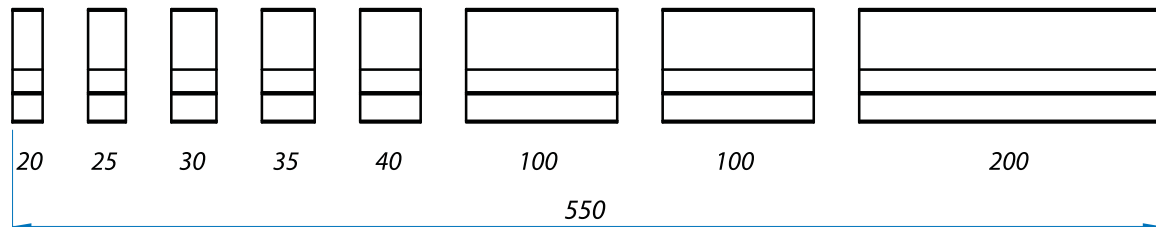


P8 RF-A

100T/m



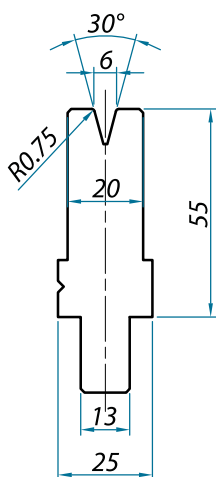
Toutes les matrices Bystronic - Beyeler typ sont disponibles
en long. 515, 550 fractionnée



Sur demande: Long. 1000 fractionnée

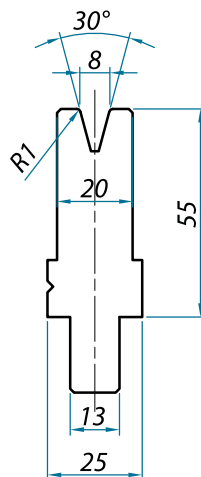
M6/30°

60T/m



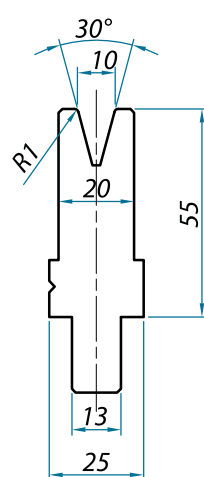
M8/30°

50T/m



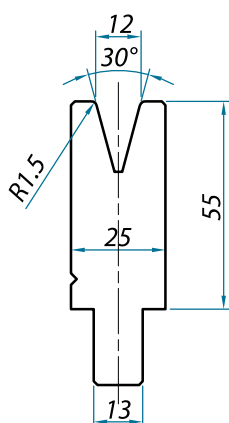
M10/30°

40T/m



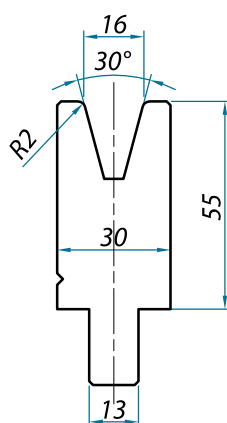
M12/30°

50T/m



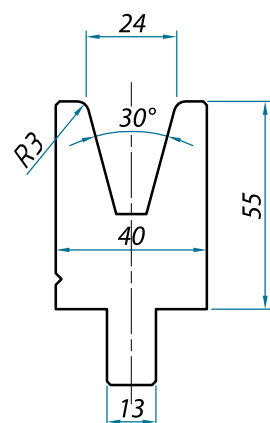
M16/30°

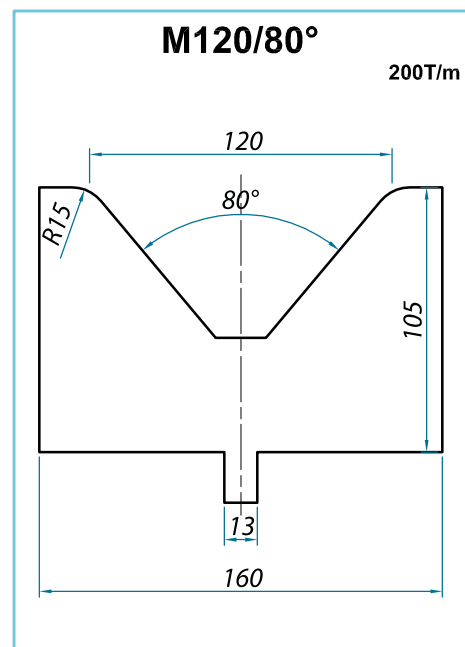
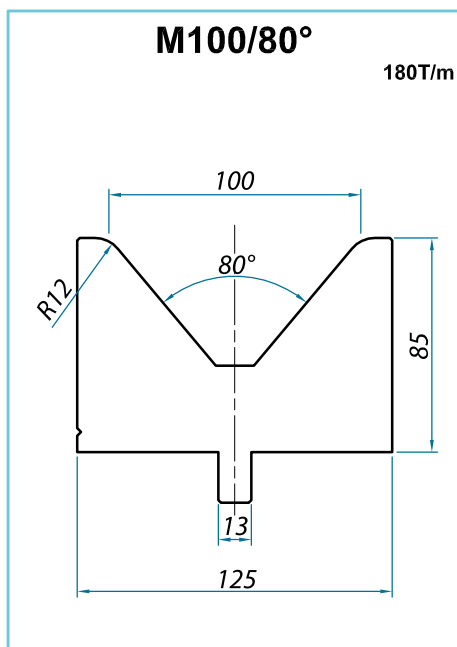
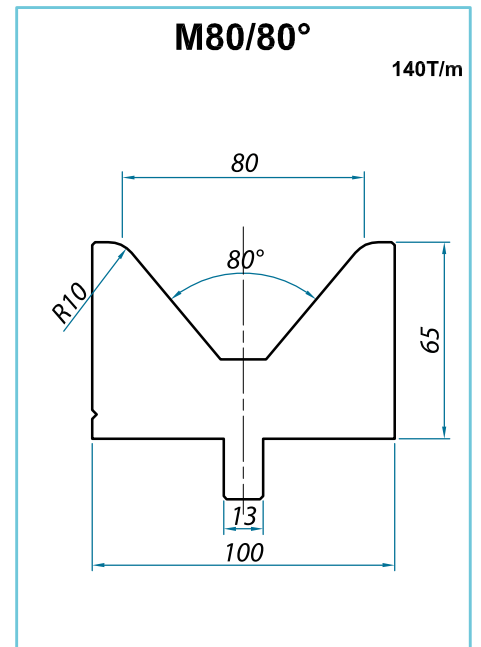
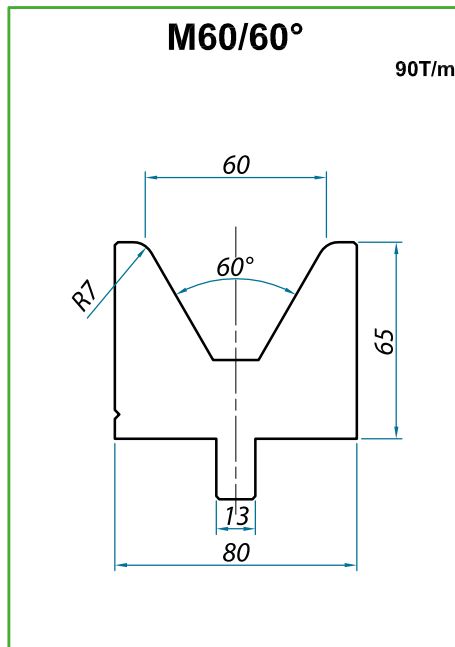
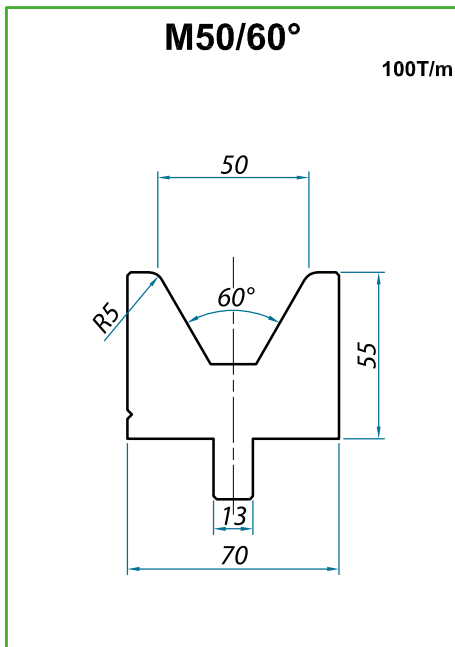
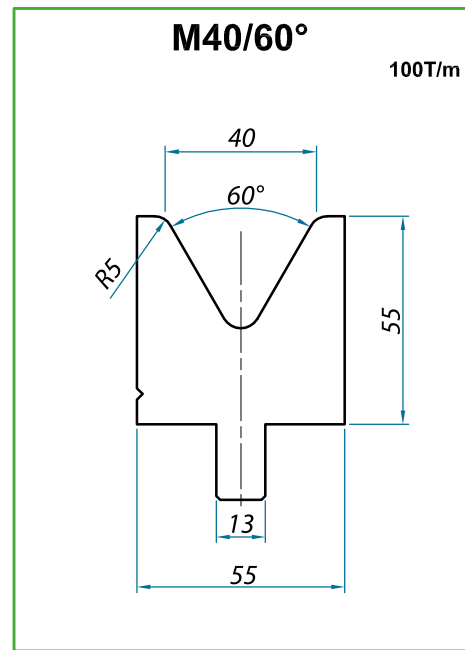
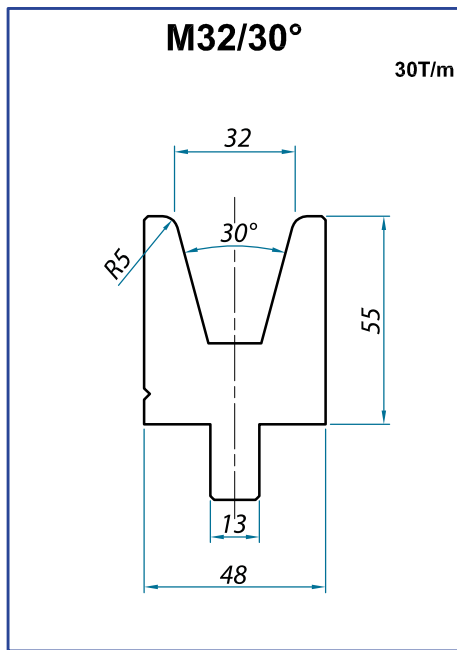
55T/m



M24/30°

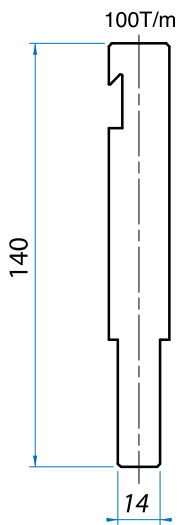
60T/m





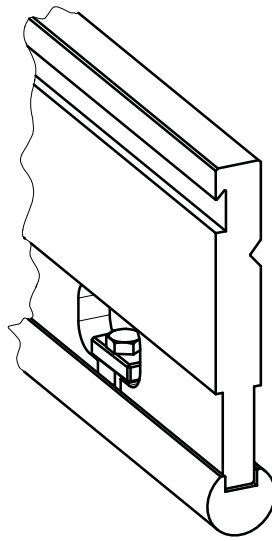
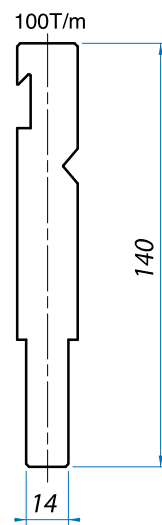
B123

Typ R

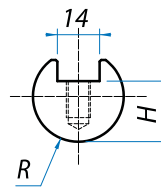


B127

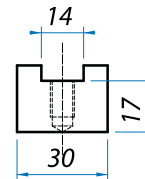
Typ RFA



40.09



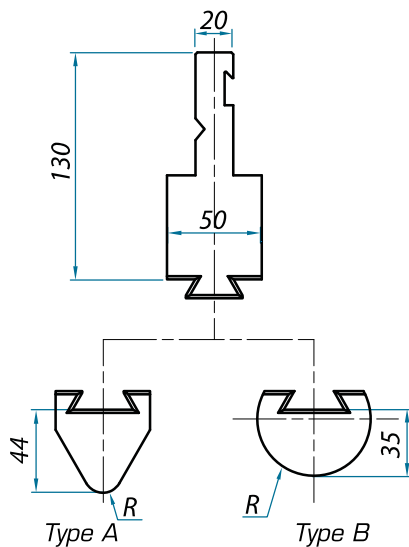
40.02



Modèle	R	H
40.09/14	7	11.5
40.09/15	7.5	11.5
40.09/16	8	13
40.09/18	9	16
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

P12 RF-A

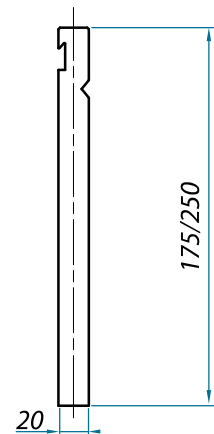
160T/m



Type	R
A	R= 5
A	R= 6
A	R= 8
A	R= 10
A	R= 12
A	R= 15
A	R=20
B	R= 25
B	R= 30
B	R= 35

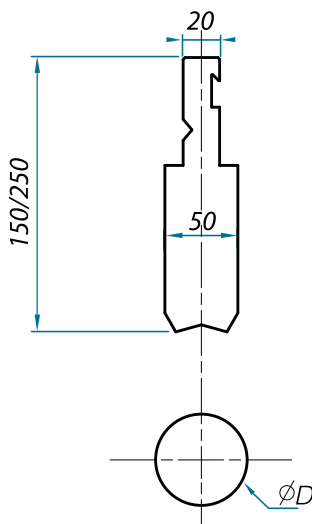
P11 RF-A

160T/m

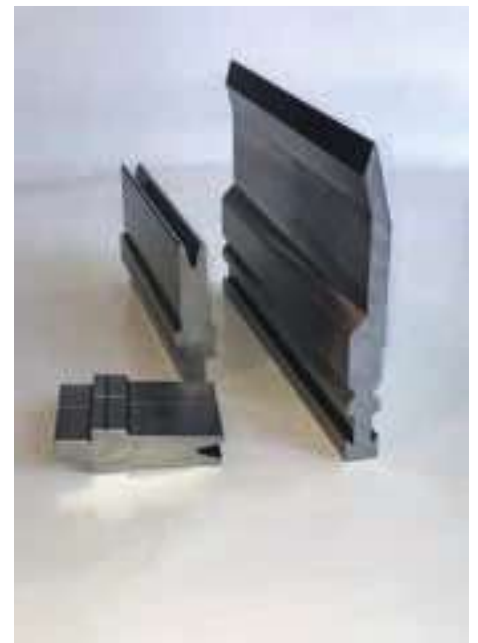


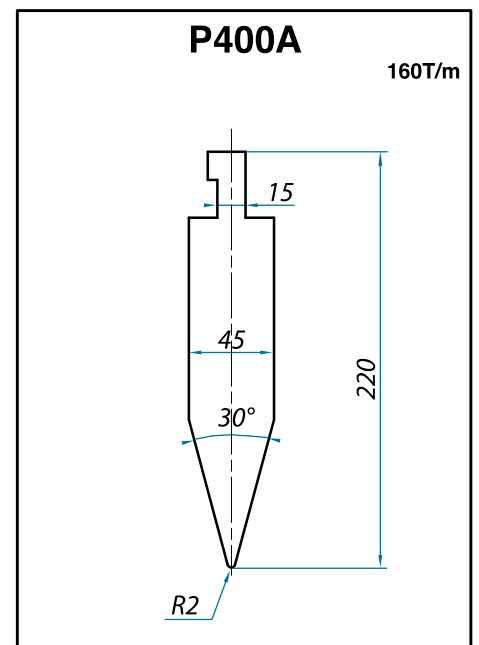
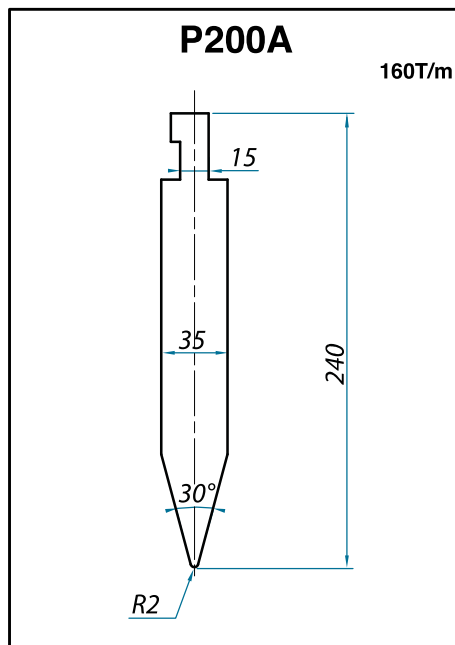
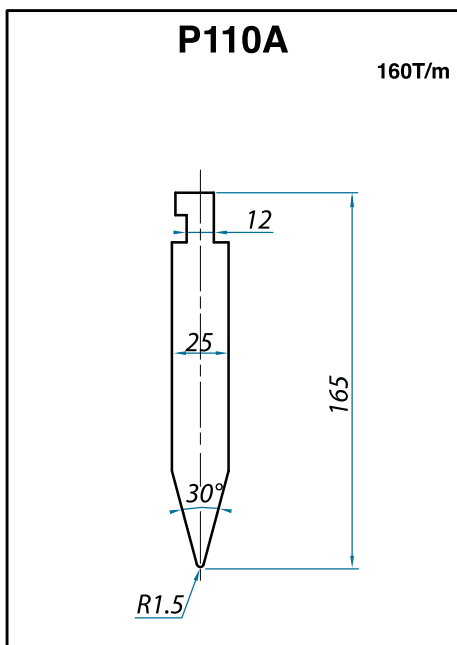
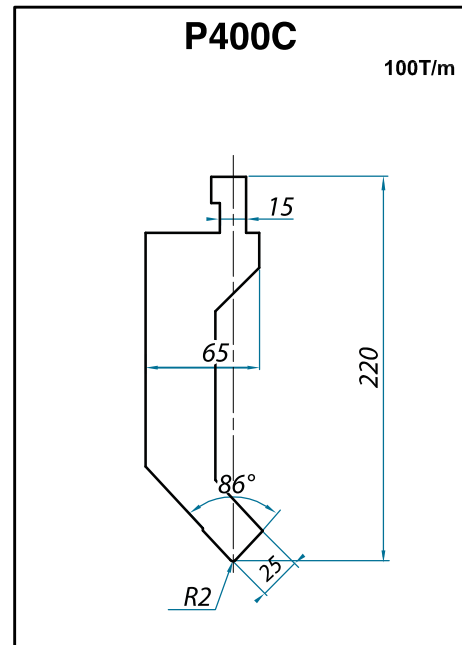
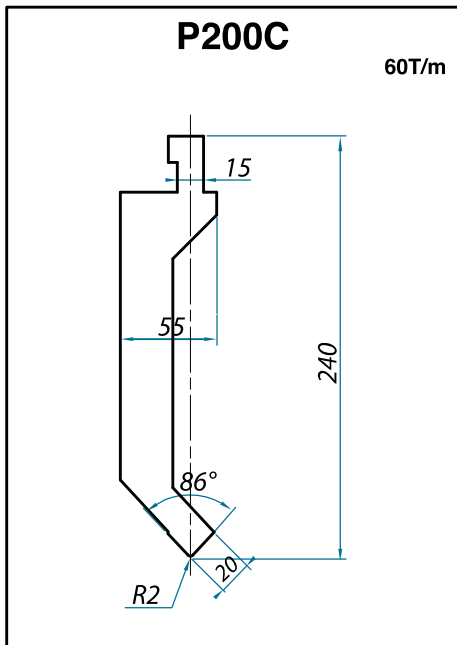
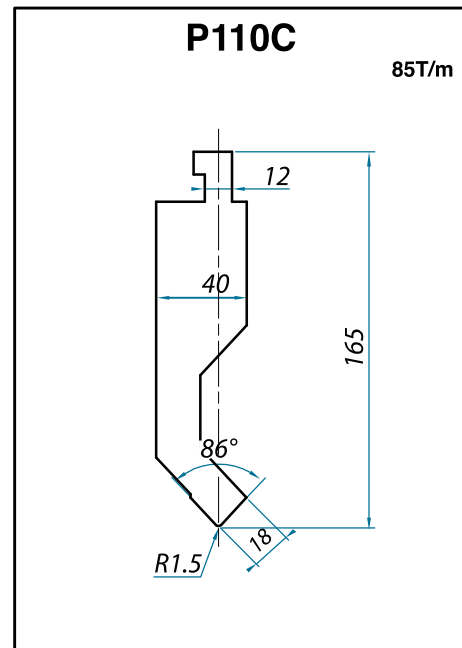
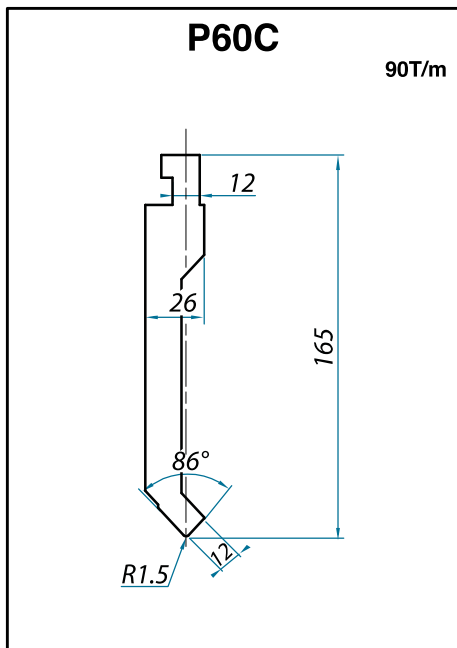
P10 RF-A

160T/m



Ø	R
Ø28	R=14
Ø30	R=15
Ø35	R=17.5
Ø40	R=20
Ø45	R=22.5
Ø50	R=25
Ø60	R=30
Ø65	R=32.5
Ø70	R=35
Ø80	R=40

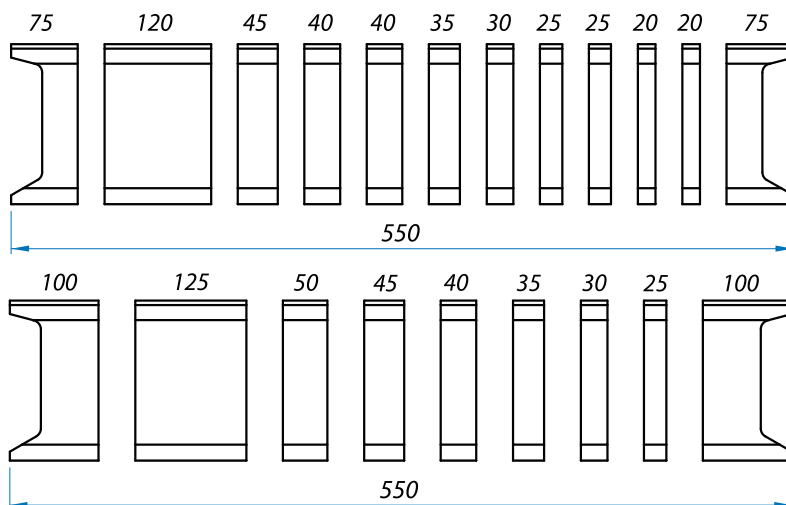




Les lames LVD Typ sont disponibles
En longueur 250, 508 ou 510 et 550 fractionnée

Fractionnement
des anciens
modèles :

$1 \times 125 + 1 \times 50 +$
 $1 \times 45 + 1 \times 40 +$
 $1 \times 35 + 1 \times 30 +$
 1×25
 $+ 2 \times \text{bigornes (100)}$

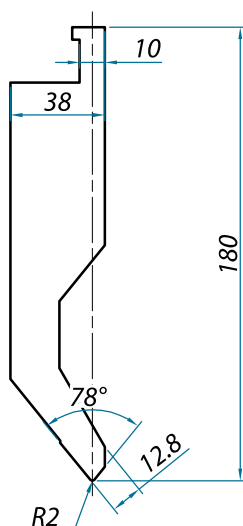


Fractionnement
des nouveaux
modèles :

$1 \times 120 + 1 \times 45 +$
 $2 \times 40 + 1 \times 35 +$
 $1 \times 30 \times 2 \times 25$
 $+ 2 \times 20$
 $+ 2 \times \text{bigornes (75)}$

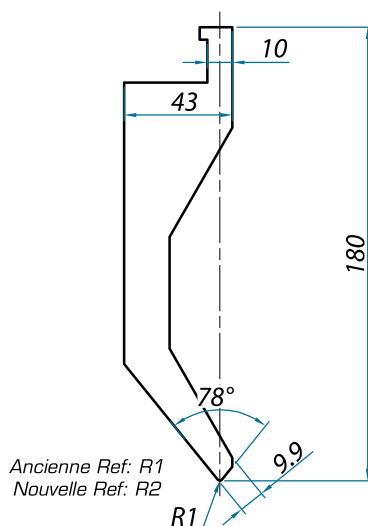
C10

70T/m



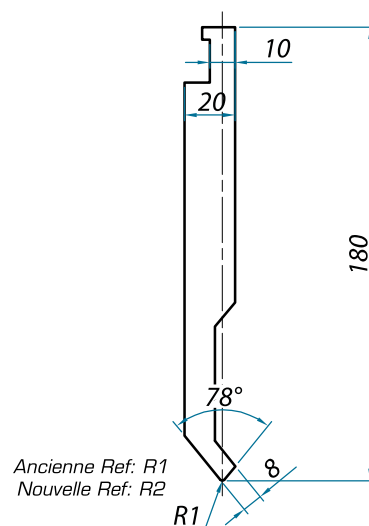
D10

45T/m



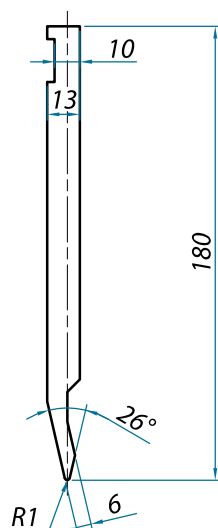
E10

40T/m



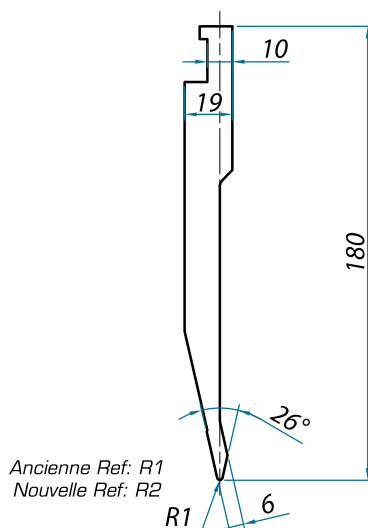
F10

50T/m



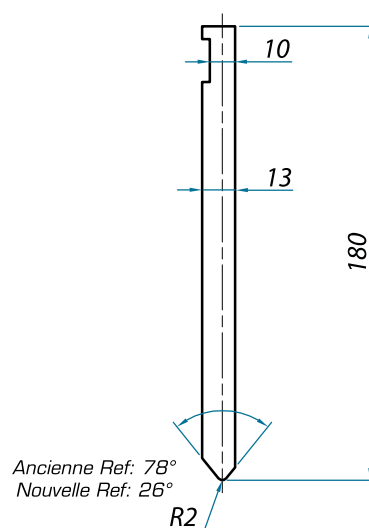
J10

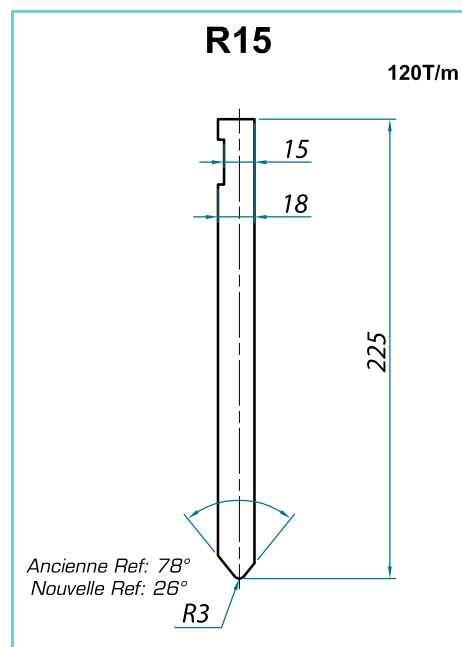
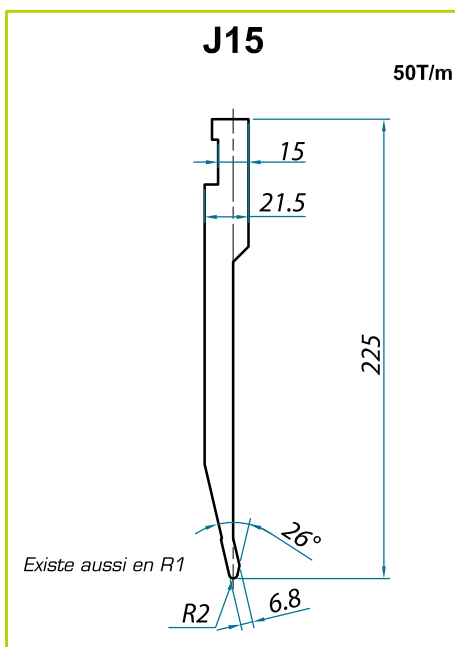
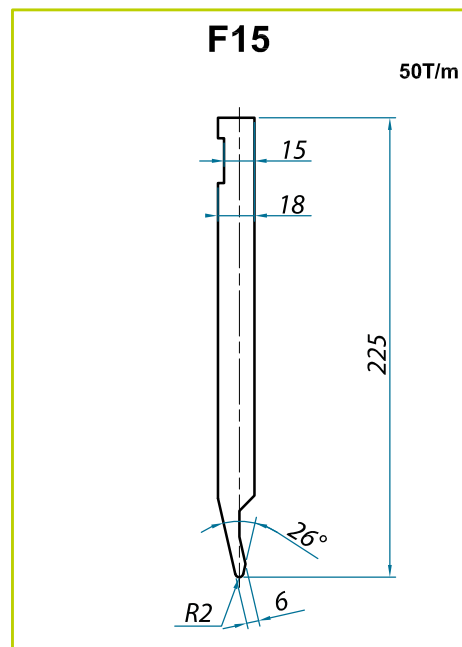
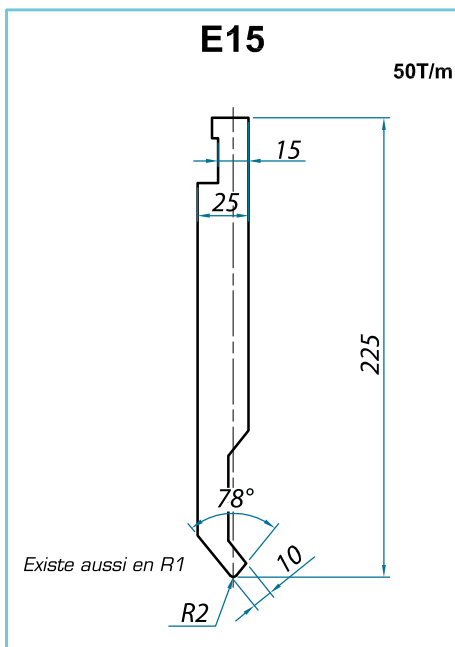
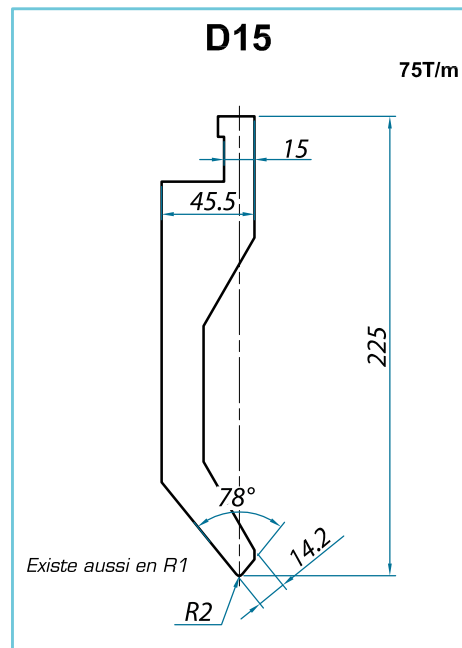
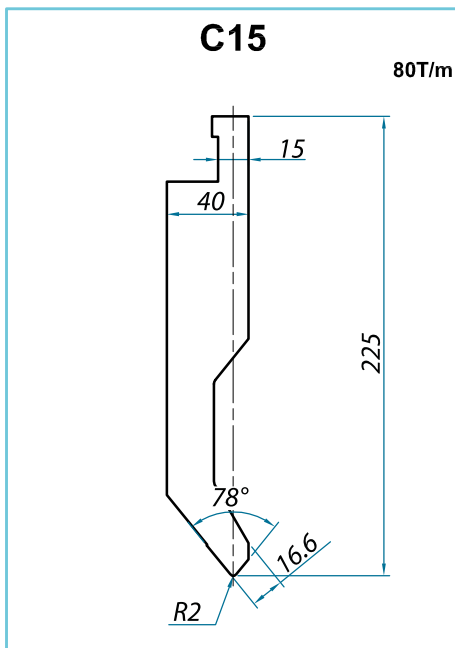
40T/m

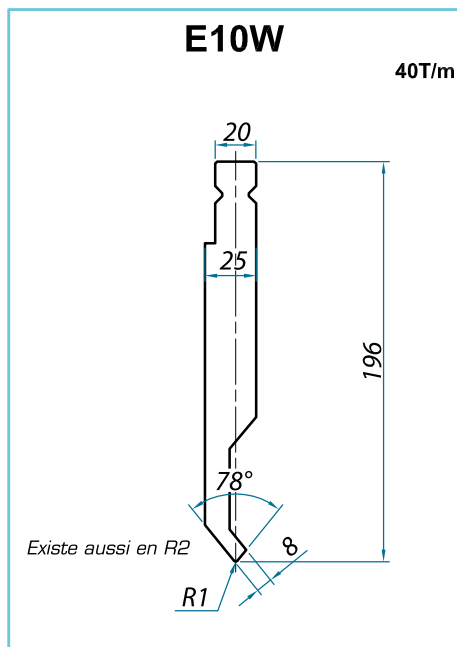
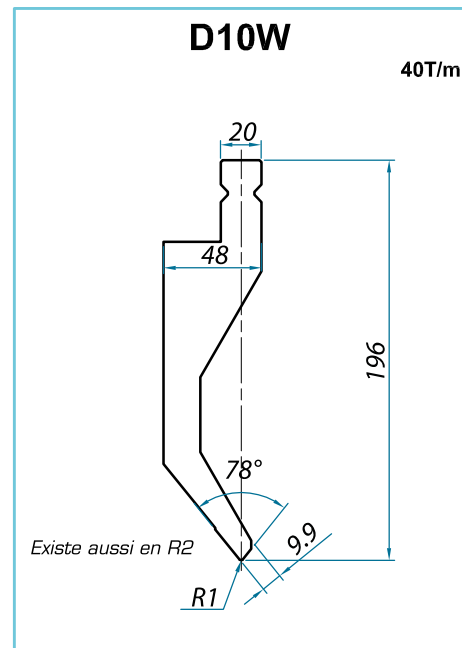
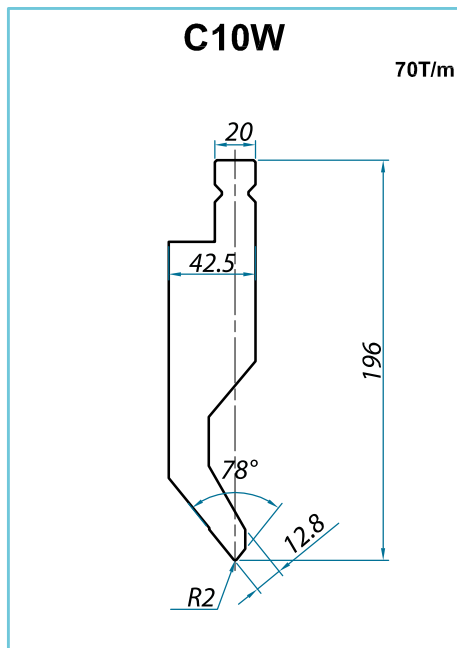


R10

100T/m



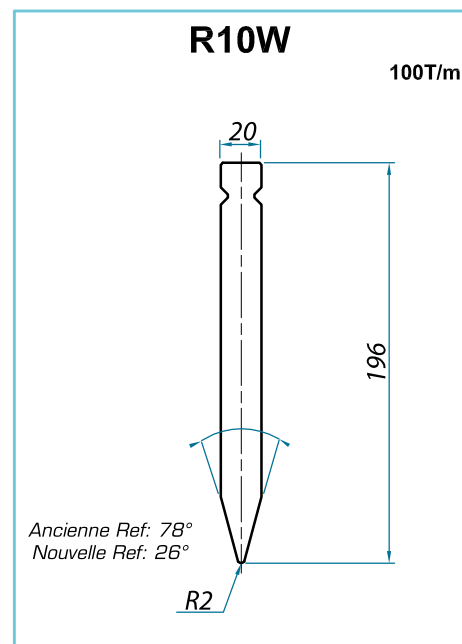
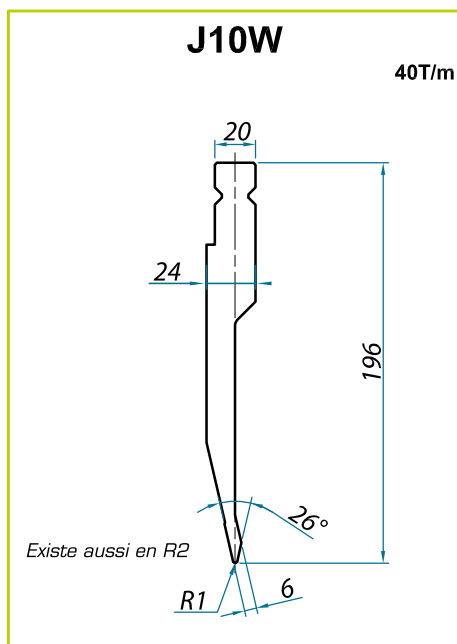
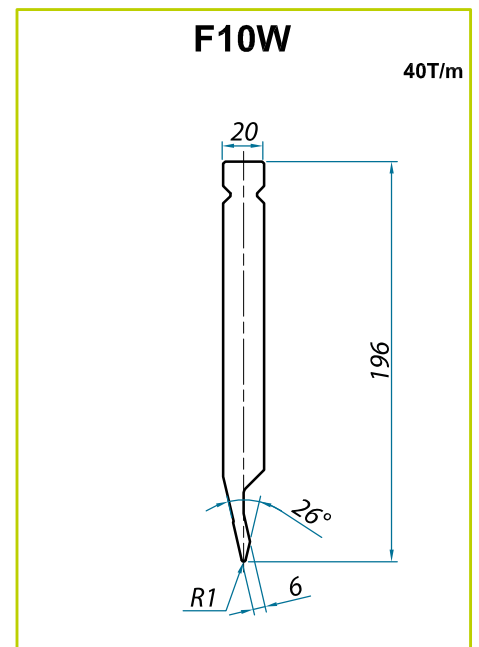


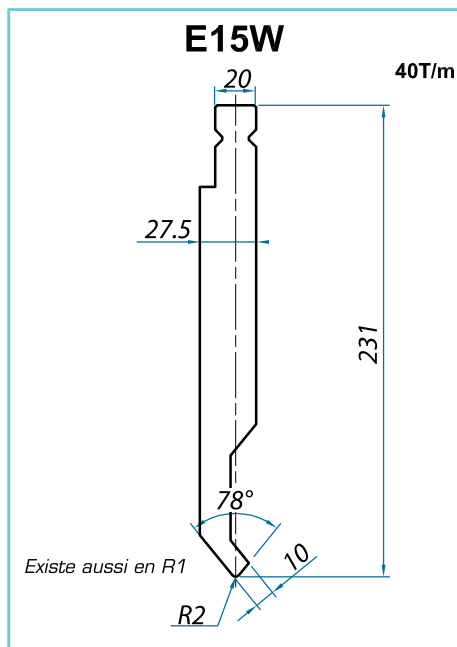
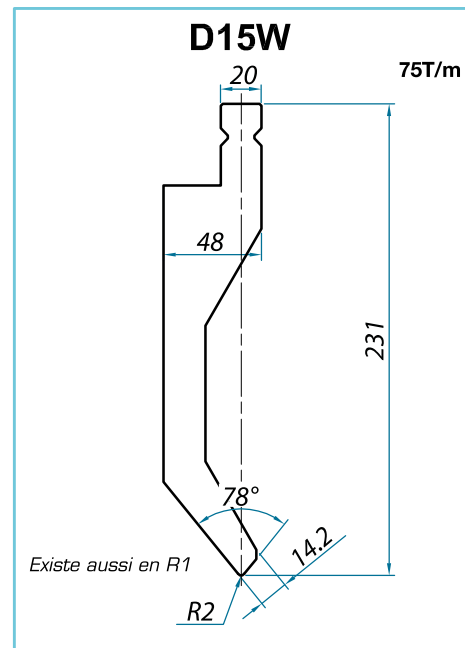
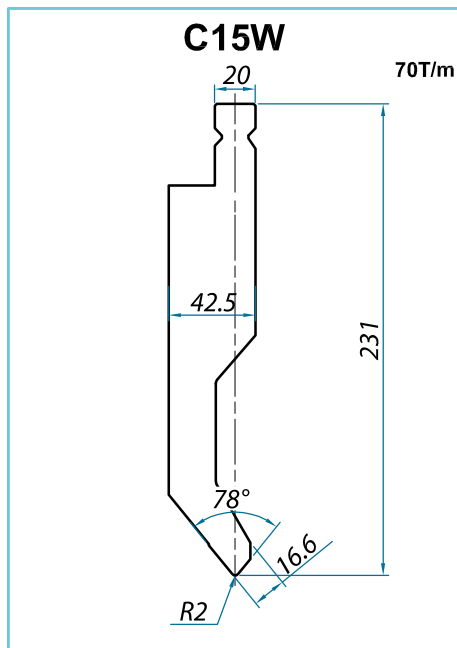


*Toutes les lames
n'exédant pas 12.5kg sont
prévues pour recevoir les
poussoirs de sécurité*

*Les poussoirs sont à
commander séparément*

*Détail des poussoirs
page 53*

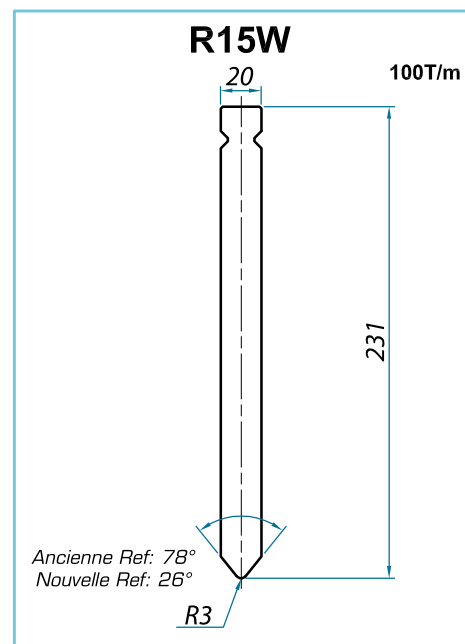
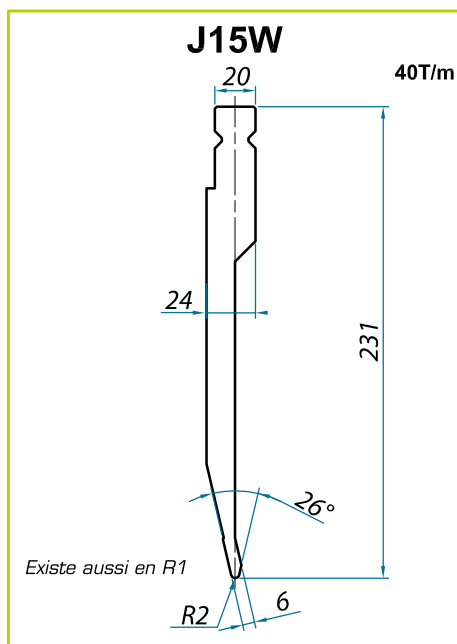
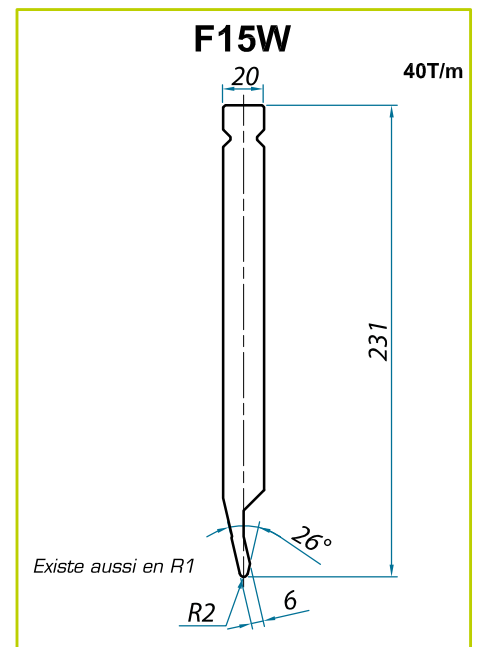




*Toutes les lames
n'exédant pas 12.5kg sont
prévues pour recevoir les
poussoirs de sécurité*

*Les poussoirs sont à
commander séparément*

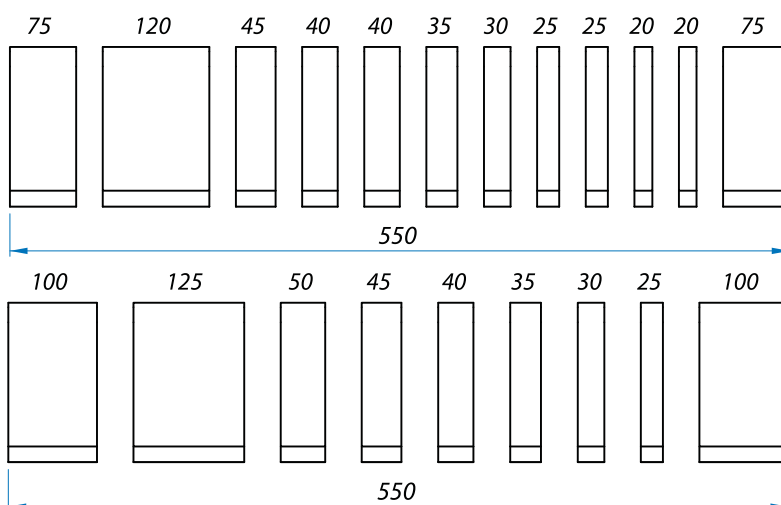
*Détail des poussoirs
page 53*



Les matrices LVD Typ sont disponibles
En longueur 250, 508 ou 510 et 550 fractionnée

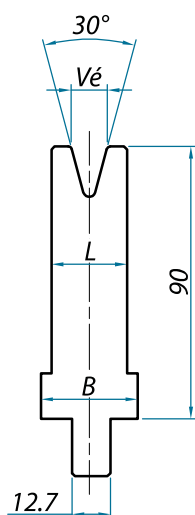
Fractionnement
des anciens
modèles :

$1 \times 125 + 2 \times 100$
 $+ 1 \times 50 + 1 \times 45$
 $+ 1 \times 40 + 1 \times 35$
 $+ 1 \times 30 + 1 \times 25$

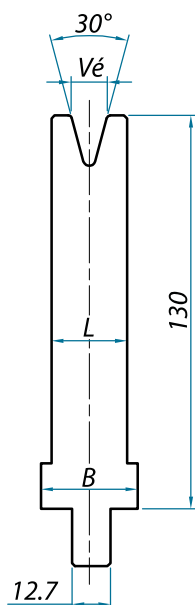


Fractionnement
des nouveaux
modèles :

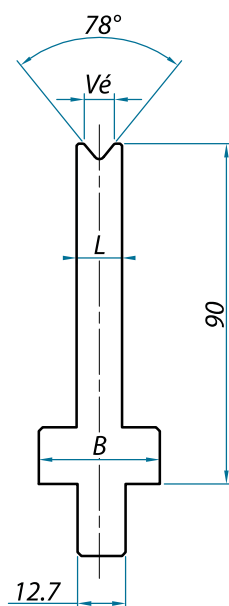
$1 \times 120 + 2 \times 75$
 $+ 1 \times 45 + 2 \times 40$
 $+ 1 \times 35 + 1 \times 30$
 $+ 2 \times 25 + 2 \times 20$



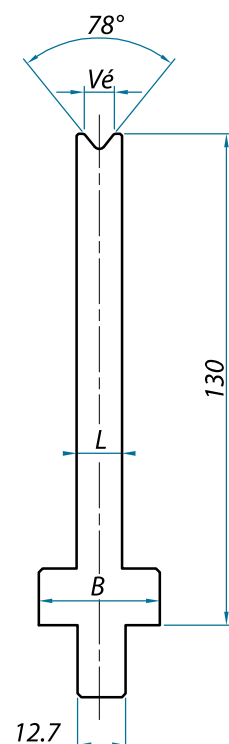
Modèle	Vé	B	L	F' maxi
V6/30°	6	32	16	20T/m
V8/30°	8	32	18	22T/m
V10/30°	10	32	25	30T/m
V12/30°	12	32	25	38T/m
V16/30°	16	32	32	38T/m
V20/30°	20	40	40	38T/m
V24/30°	24	45	45	55T/m
V30/30°	30	70	70	60T/m
V40/30°	40	75	75	60T/m
V50/30°	50	95	95	78T/m



Modèle	Vé	B	L	F' maxi
V6/30°	6	32	16	20T/m
V8/30°	8	32	18	22T/m
V10/30°	10	32	25	30T/m
V12/30°	12	32	25	38T/m
V16/30°	16	32	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



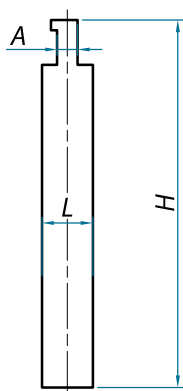
Modèle	Vé	B	L	F' maxi
V6/78°	6	32	12	40T/m
V8/78°	8	32	12	40T/m
V10/78°	10	32	14	50T/m
V12/78°	12	32	18	60T/m
V16/78°	16	32	25	80T/m
V20/78°	20	32	32	100T/m
V24/78°	24	32	32	100T/m
V30/78°	30	40	40	110T/m
V40/78°	40	50	50	130T/m
V50/78°	50	70	70	150T/m
V60/78°	60	70	70	150T/m
V80/78°	80	95	95	150T/m
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

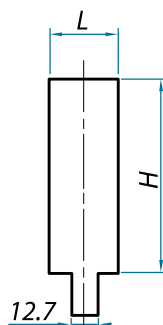
100T/m



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

H90 / H130

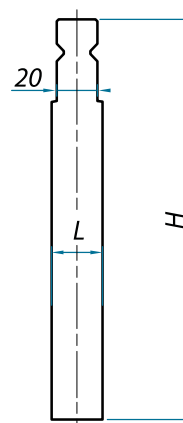
100T/m



modèle	L	H
H90	30	90
H130	35	130

H10W / H15W

150T/m

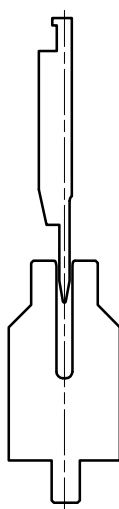


modèle	L	H
H10W	25	196
H15W	30	231

Exemples d'empilage

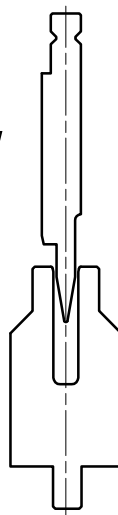
Lame
P10.08

Matrice
T08



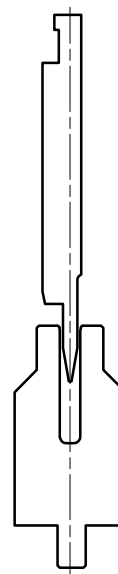
Lame
P10.12W

Matrice
T12



Lame
P15.10

Matrice
T10

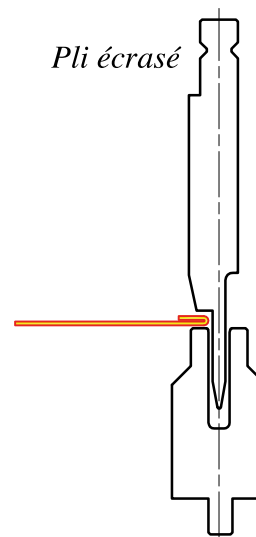
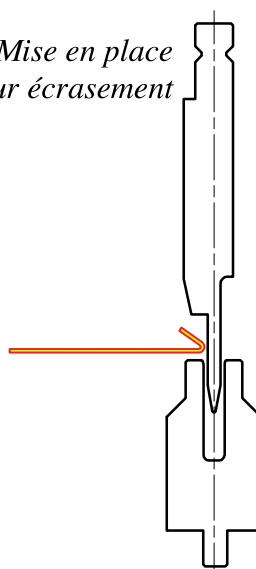
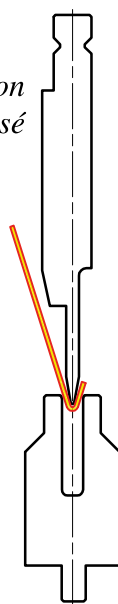
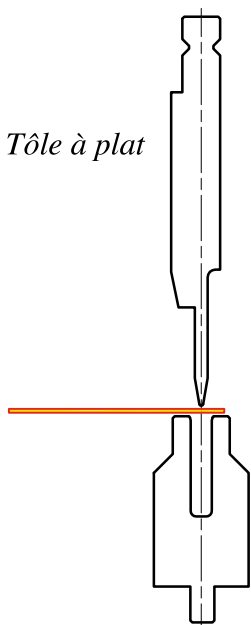


Tôle à plat

Préparation
du pli écrasé

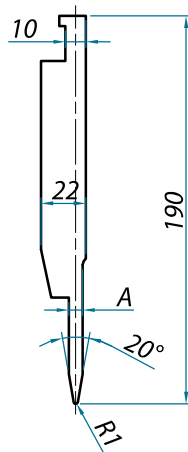
Mise en place
pour écrasement

Pli écrasé



P10.--

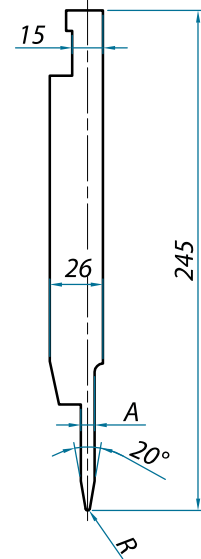
50T/m



modèle	A
P10.08	6.8
P10.10	8.8
P10.12	10.8

P15.--

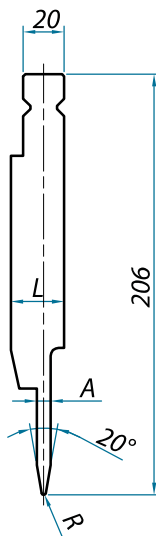
50T/m



modèle	A	R
P15.08	6.8	1
P15.10	8.8	1
P15.12	10.8	1.5

P10.--W

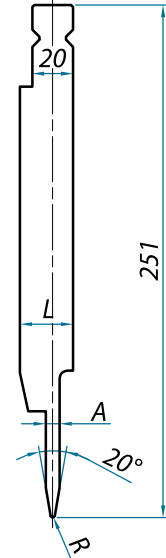
50T/m



modèle	A	L	R
P10.08W	6.8	26	1
P10.10W	8.8	27	1
P10.12W	10.8	28	1.5

P15.--W

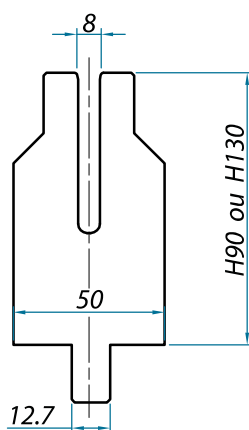
50T/m



modèle	A	L	R
P15.08W	6.8	26	1
P15.10W	8.8	27	1
P15.12W	10.8	28	1.5

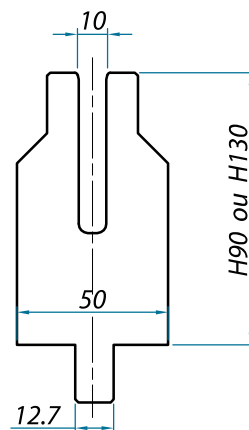
T08

35T/m



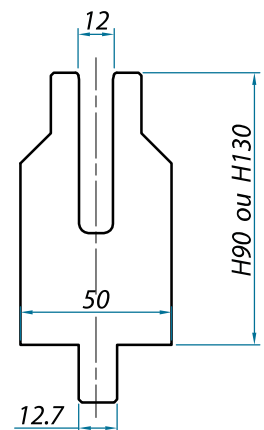
T10

35T/m

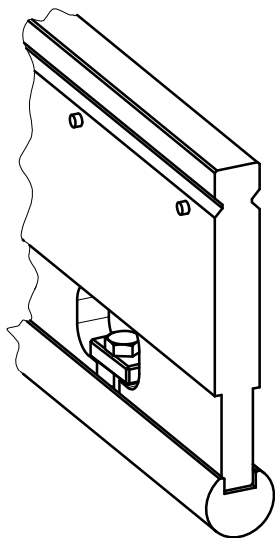
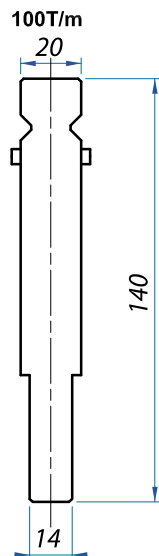


T12

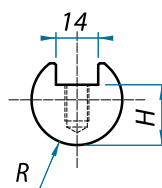
35T/m



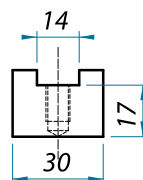
TR124



40.09



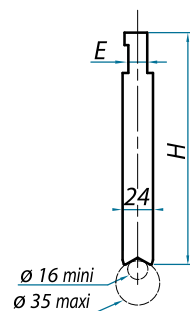
40.02



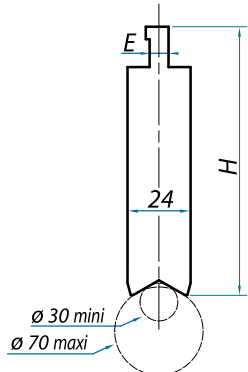
Modèle	R	H
40.09/14	7	11.5
40.09/15	7.5	11.5
40.09/16	8	13
40.09/18	9	16
40.09/20	10	12
40.09/25	12.5	17
40.09/30	15	20
40.09/35	17.5	22
40.09/40	20	24
40.09/50	25	29
40.09/60	30	34
40.09/80	40	44
40.09/100	50	70

Q10 et Q15

100T/m

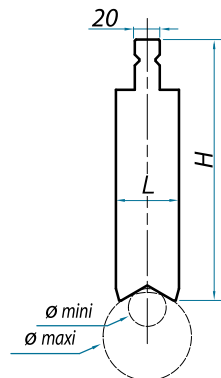


150T/m



Q15W

150T/m

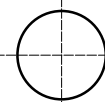


Règles

Q* -16/35



Q* -30/70

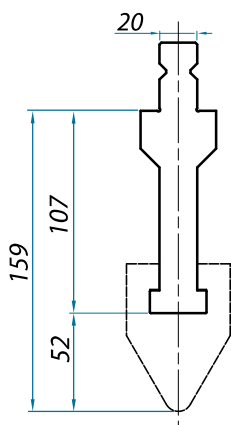


Ø	R
16	R8
18	R9
20	R10
22	R11
25	R12.5
30	R15
32	R16
35	R17.5
30	R15
32	R16
35	R17.5
40	R20
50	R25
60	R30
70	R35

Modèle	E	H	Modèle	E	H	Modèle	Ø min/max	L	H
Q10-16/35	10	174	Q10-30/70	10	191	Q15W-16/35	Ø 16 à 35	24	190
Q15-15/35	15	184	Q15-30/70	15	201	Q15W-30/70	Ø 30 à 70	50	207

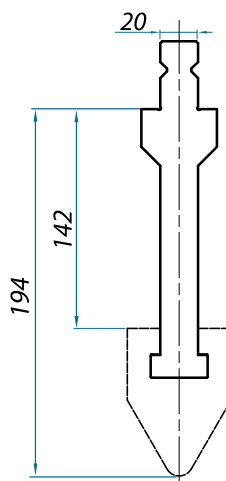
S10W

200T/m

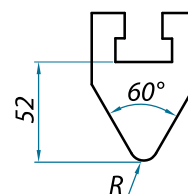


S15W

200T/m



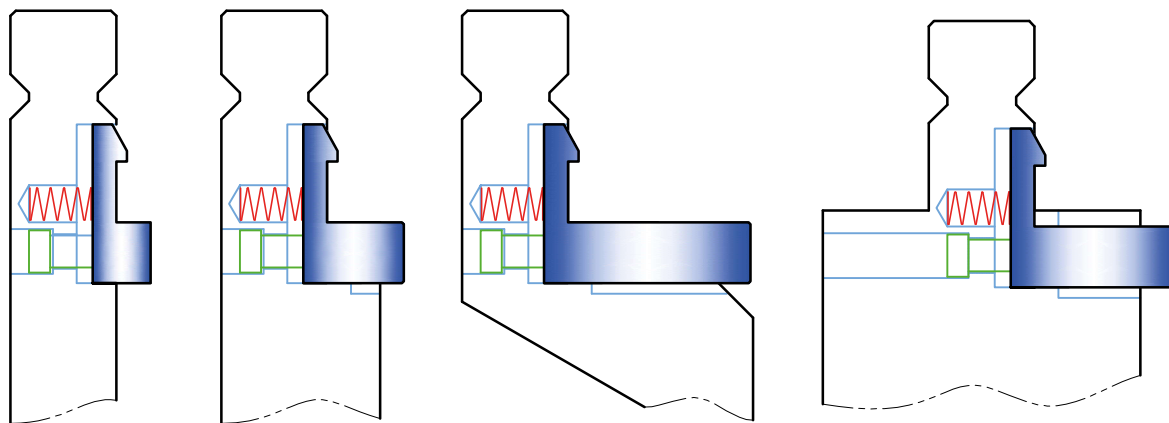
Insert

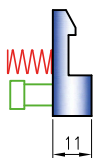
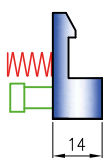
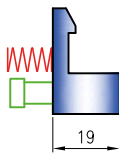
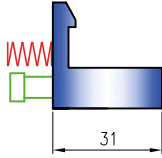
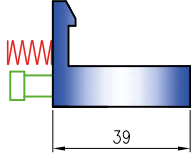
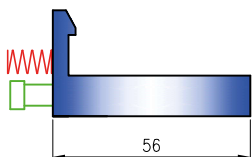


R
R5
R6
R8
R10
R12
R15
R20
R25
R30
R35
R40
R50

Poussoirs de sécurité

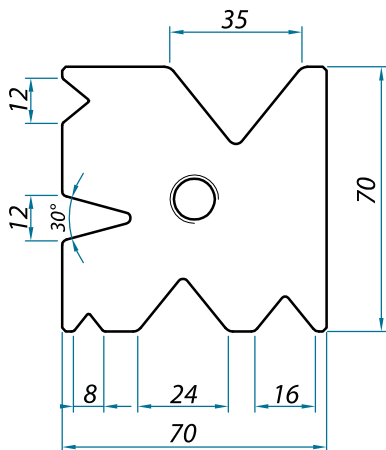
Permettant de monter et démonter la lame verticalement
Pour les lames dont le poids est inférieur à 12,5 Kg
et dont la longueur est de 200 mm maxi



MODÈLE DE POUSSOIR	MODÈLE DE LAME
SK001 	F10W - R10W - H10W F15W - R15W - TR124
SK002 	E10W - J10W H15W - J15W Q10W 16/35 - Q15W 16/35
SK003 	P10W E15W - P15W S10W - S15W
SK004 	C10W - C15W Q10W 30/70 - Q15W 30/70
SK005 	D10W - D15W
SK006 	

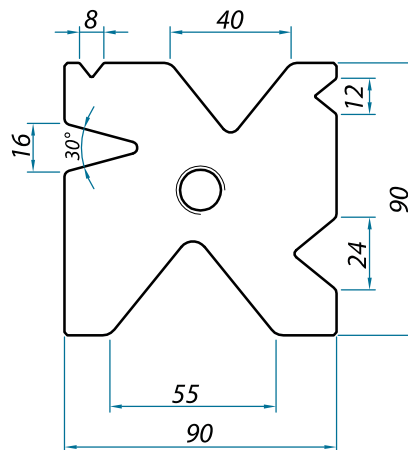
M70

V=78°



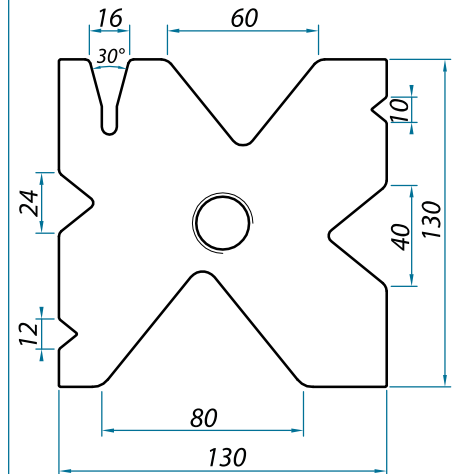
M90

V=78°



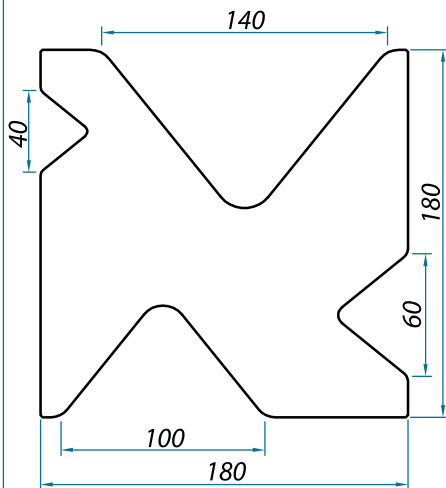
M13

V=78°



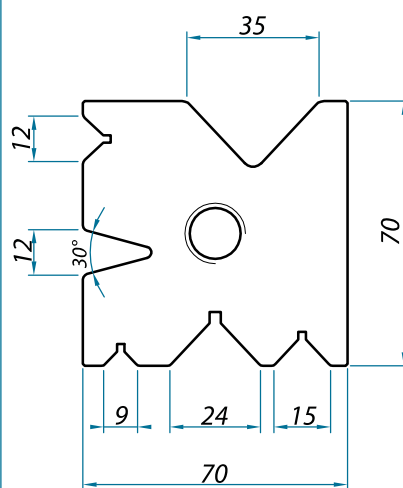
M18

V=78°



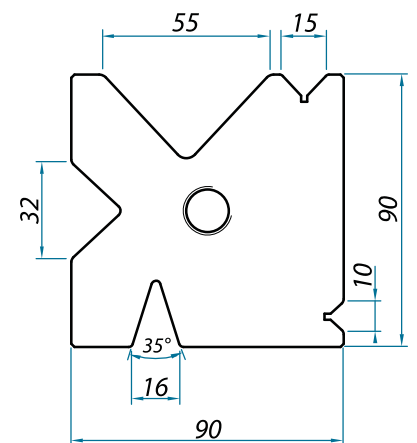
PV70

V=86°



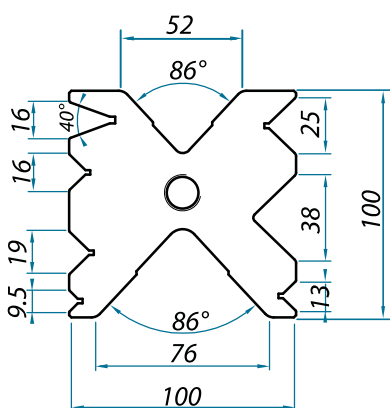
PV90

V=86°



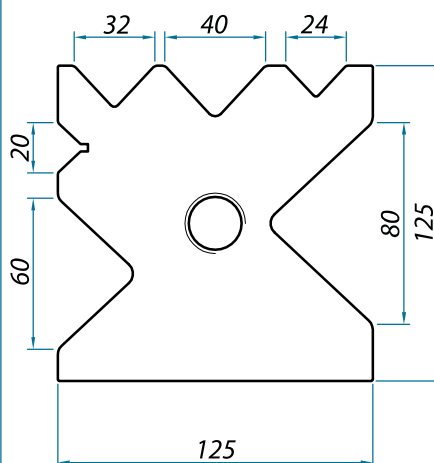
PV100

V=88°



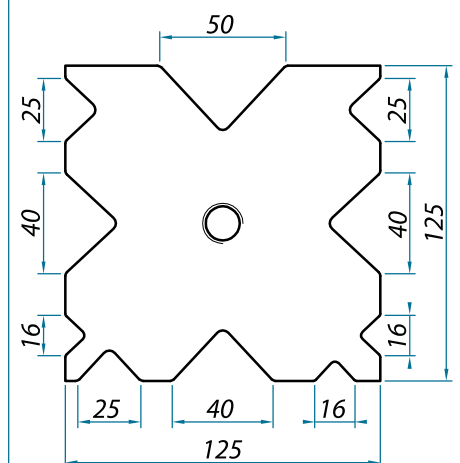
PV125

V=86°



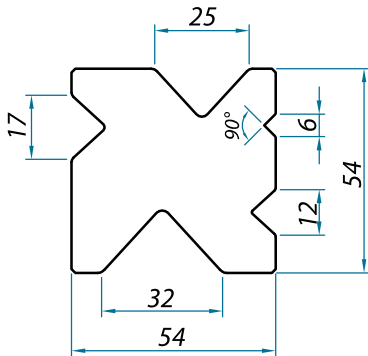
PV125M

V=86°



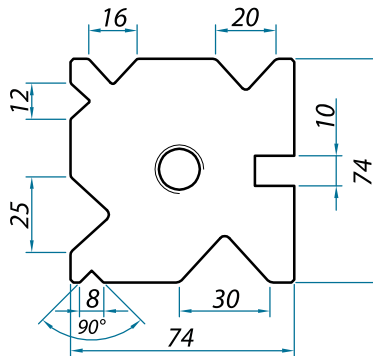
14.355

V=85°



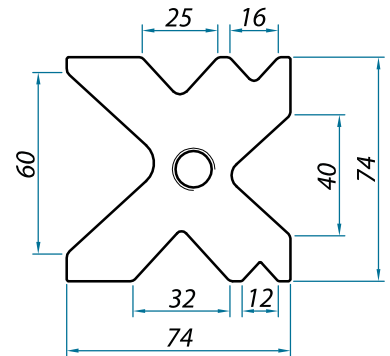
14.414

V=85°



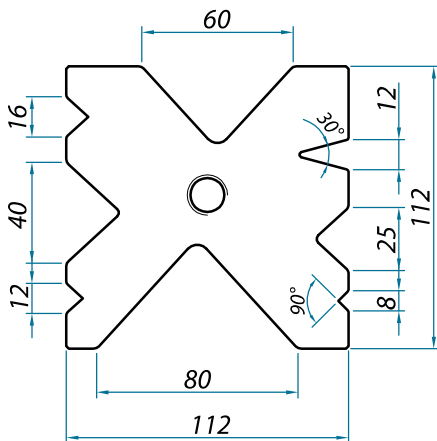
8.11.14.130

V=85°



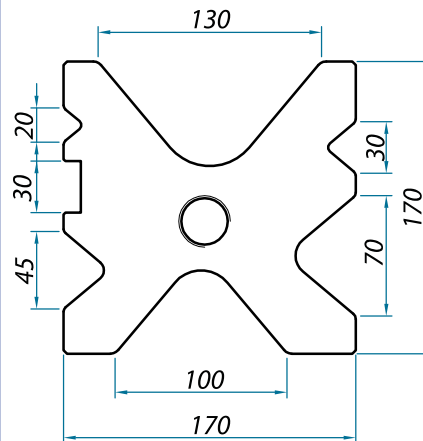
14.518

V=85°



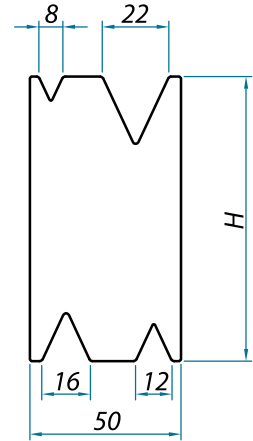
14.707

V=80°



6.14.767

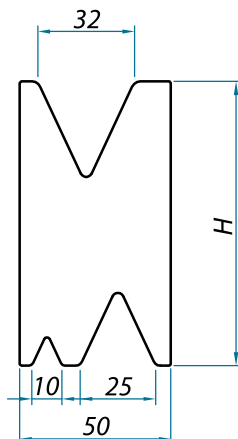
V=50°



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

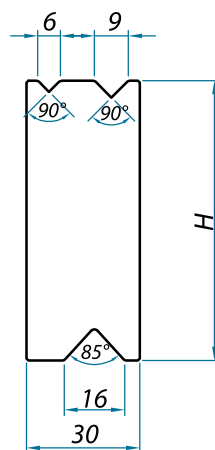
20.710

V=50°



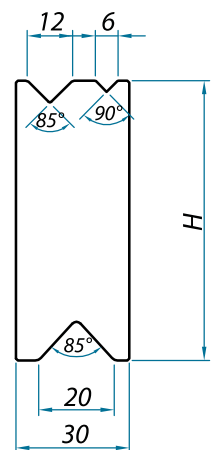
modèle	20.710/1	20.710/2
H	94	112

20.008



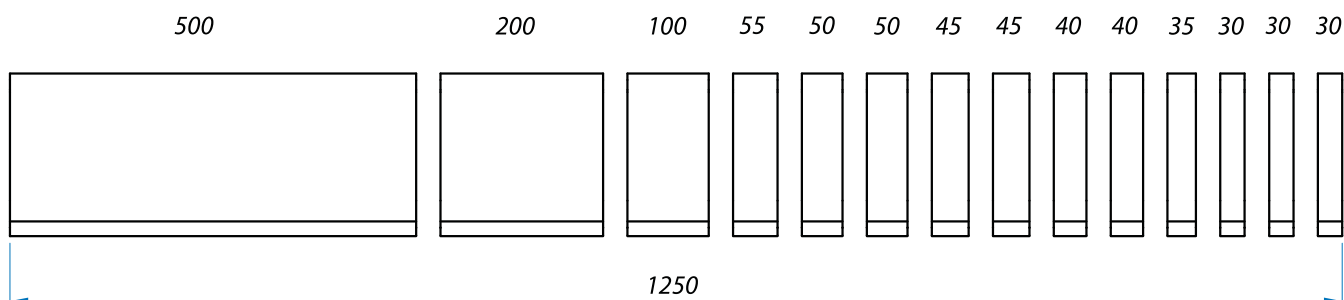
modèle	20.008/1	20.008/2	20.008/3
H	54	74	94

20.008



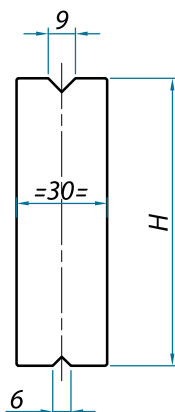
modèle	20.008/4	20.008/5	20.008/6
H	54	74	94

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



30.541

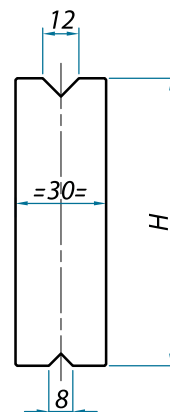
V=90°



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

30.601

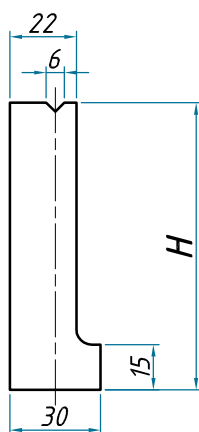
V=90°



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

30.661

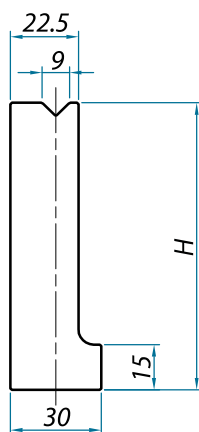
V=90°



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

30.721

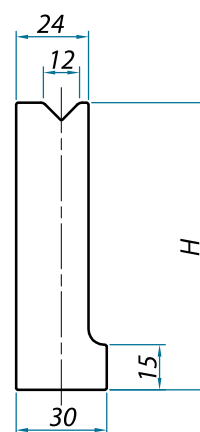
V=90°



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

30.781

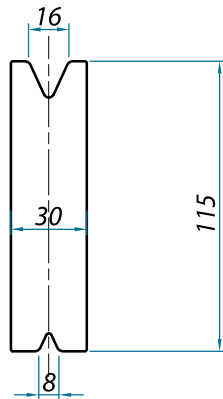
V=90°



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

30.181

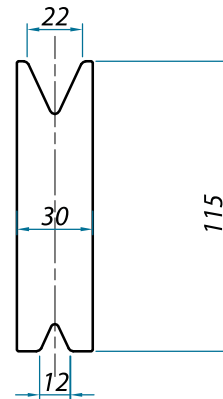
V=50°



Existe aussi en 24°

30.241

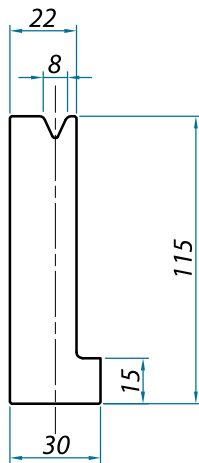
V=50°



Existe aussi en 24°

30.001

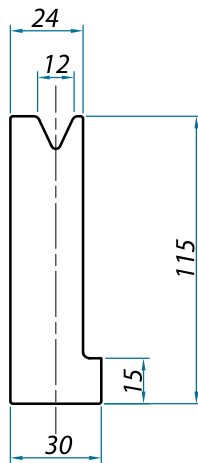
V=50°



Existe aussi en 24°

30.061

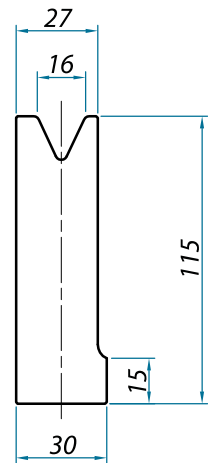
V=50°



Existe aussi en 24°

30.121

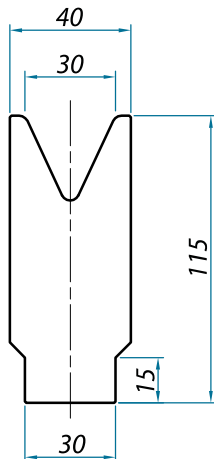
V=50°



Existe aussi en 24°

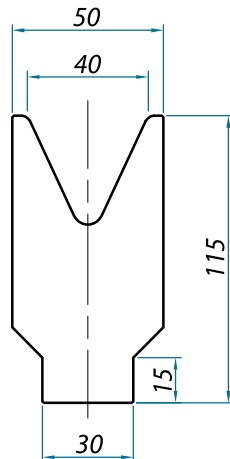
30.301

V=50°



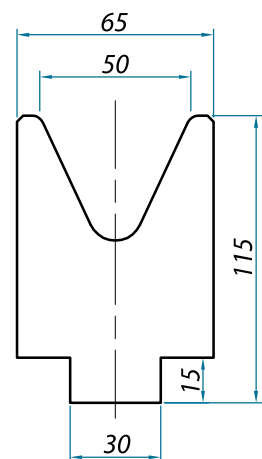
30.361

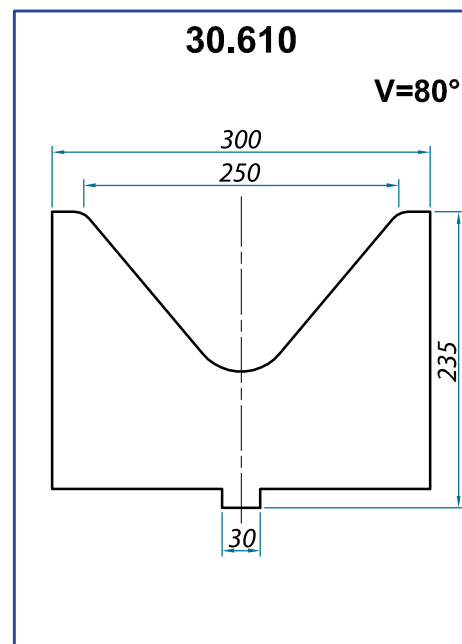
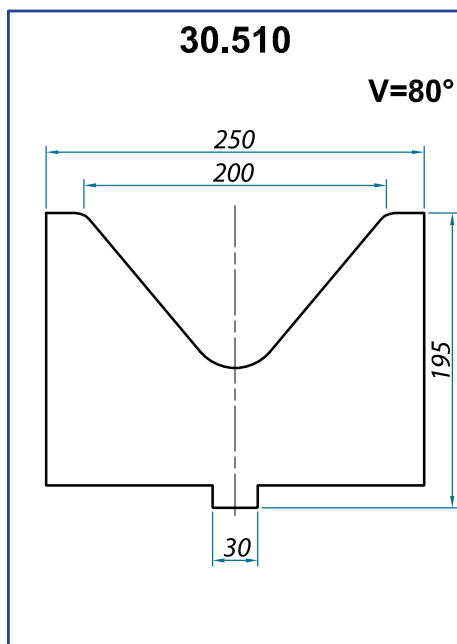
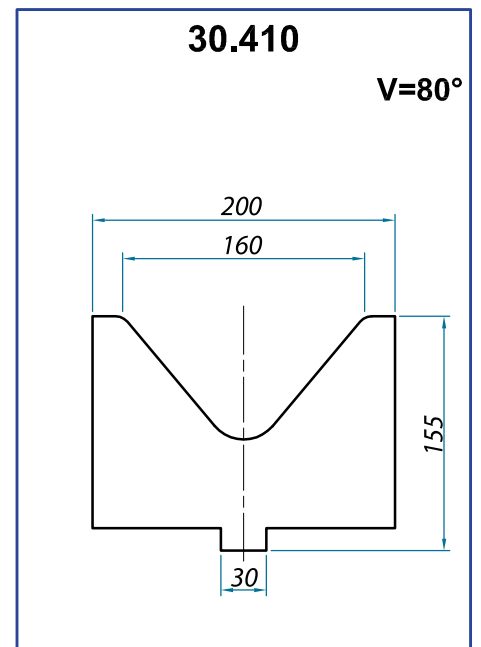
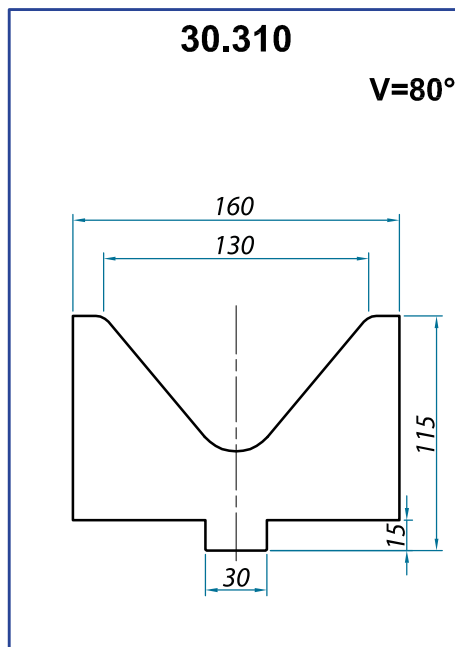
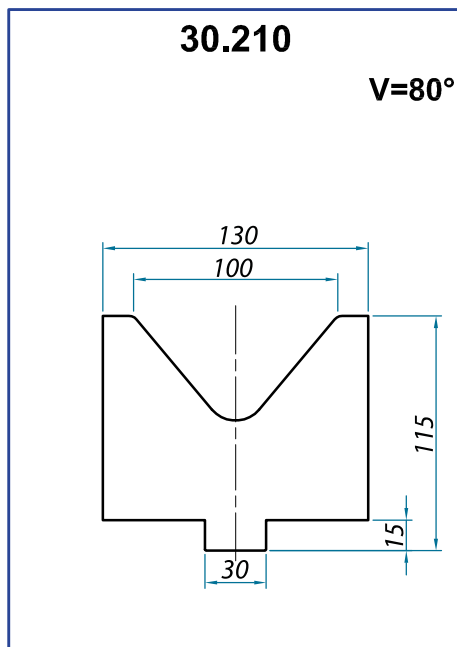
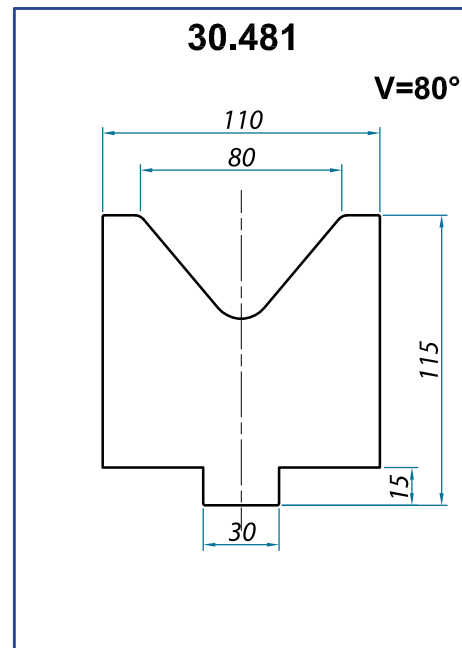
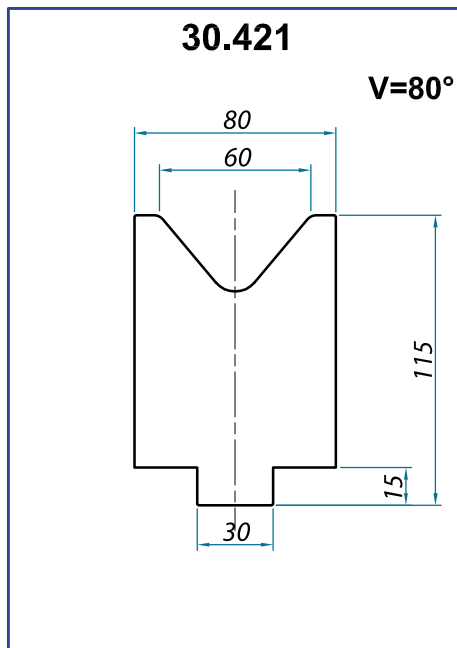
V=50°



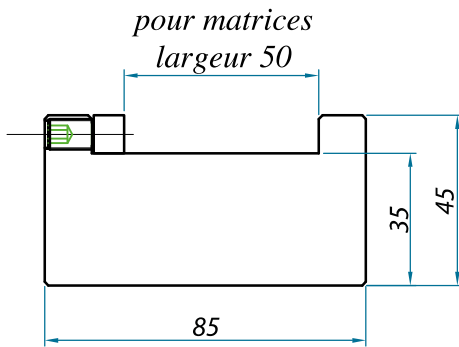
31.201

V=50°

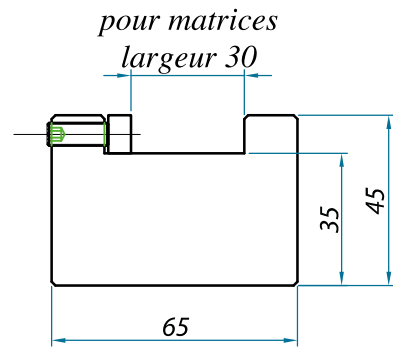




8.14.053

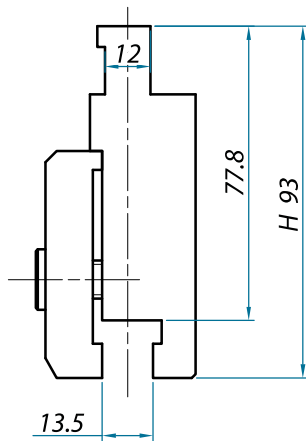


20.936



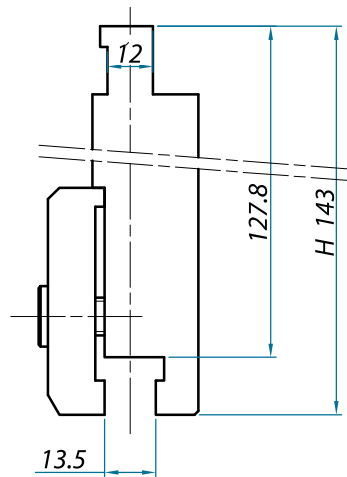
4736

90T/m



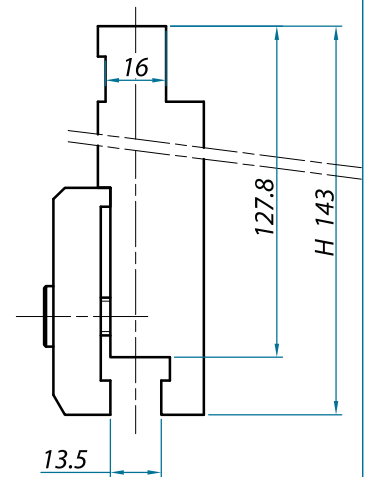
4406

90T/m



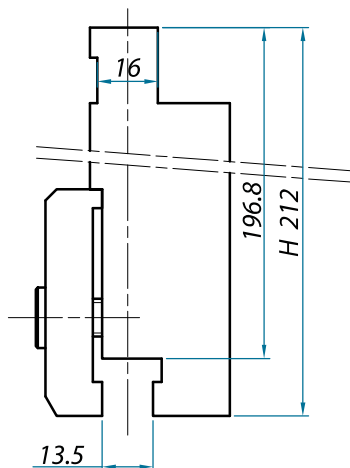
4407

100T/m



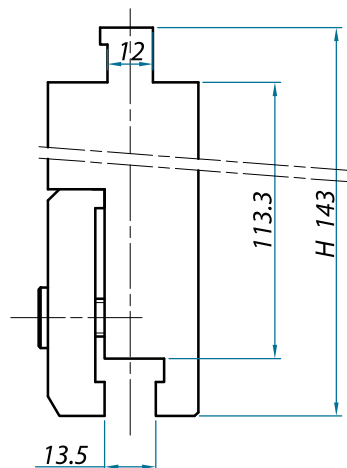
4463

100T/m



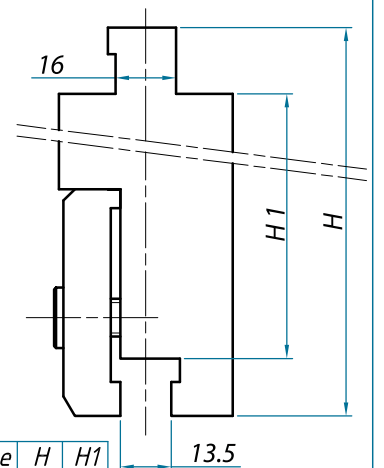
4776

150T/m



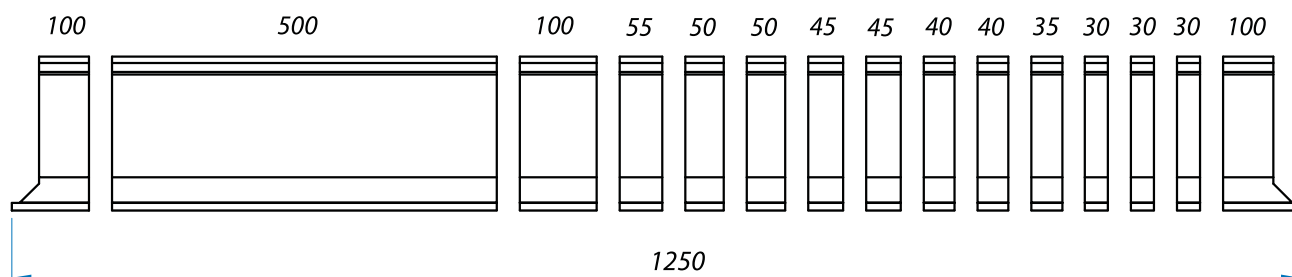
4963 / 4965

150T/m



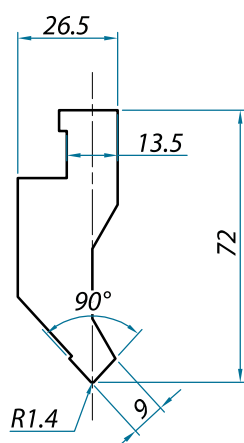
Modèle	H	H1
4963	143	110.3
4965	212	179.3

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



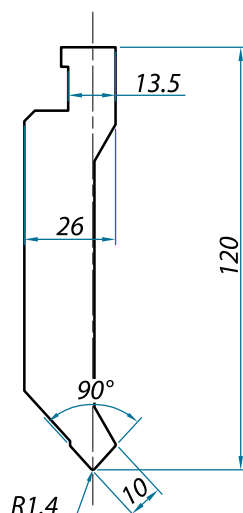
14.411

130T/m



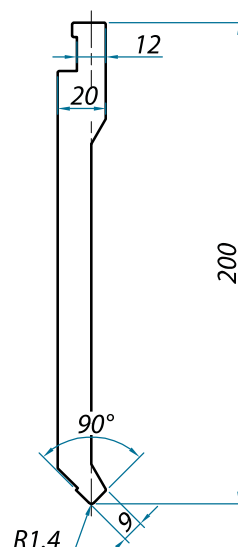
1.14.715

130T/m



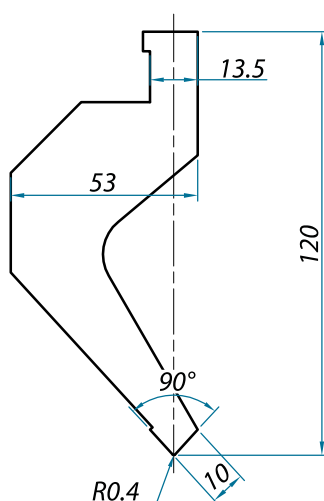
1450

100T/m



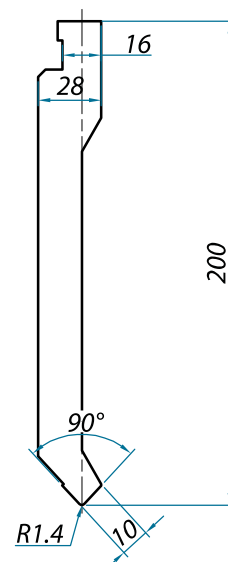
3.14.515

90T/m



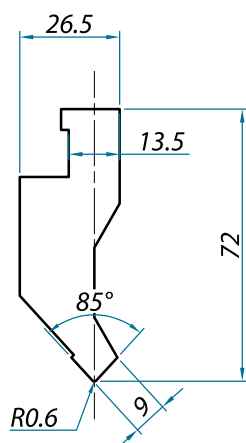
14.421

130T/m



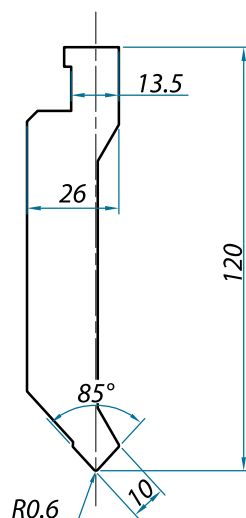
14.412

130T/m



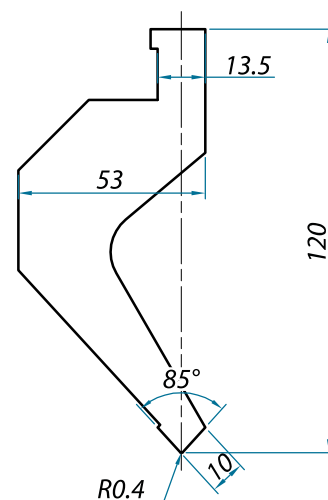
1.14.716

130T/m



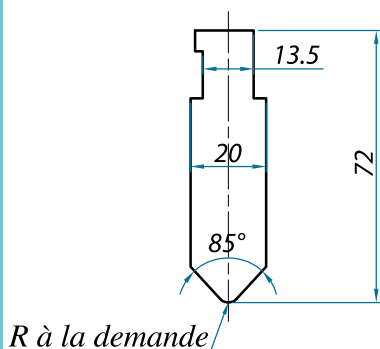
3.14.516

90T/m



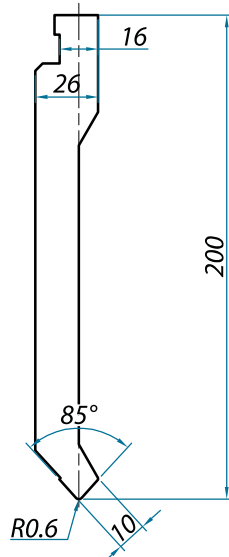
14.420

130T/m



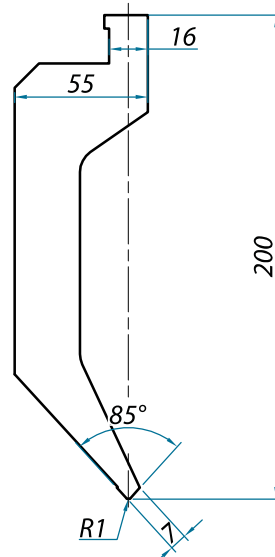
14.422

130T/m



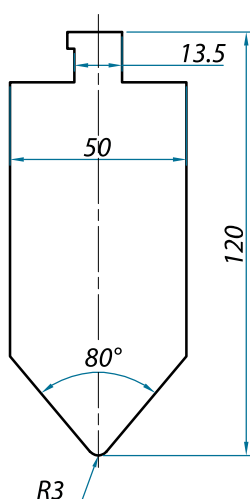
1.14.010

130T/m



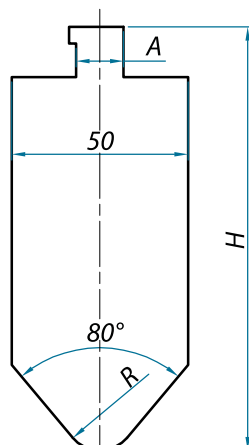
14.758

160T/m



14.705 / 14.131

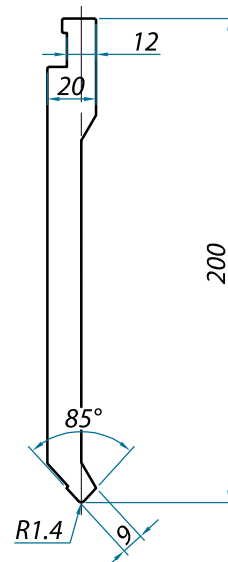
160T/m



Modèle	H	R	A
14.705	120	10	13.5
14.131	200	12	16

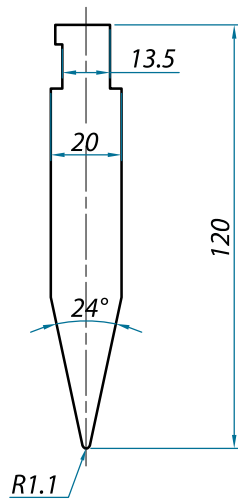
14.451

100T/m



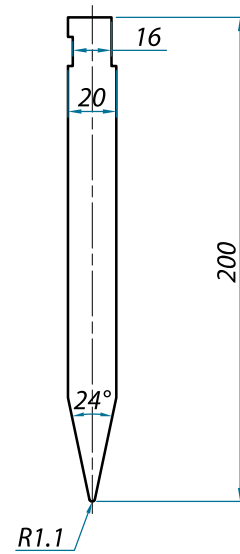
1.14.526/24°

100T/m



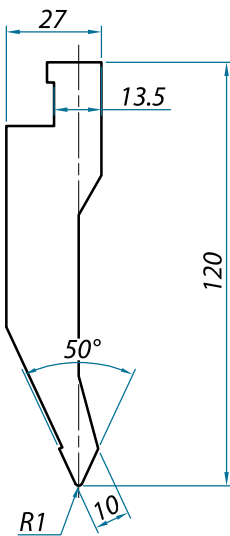
10.001/24°

100T/m



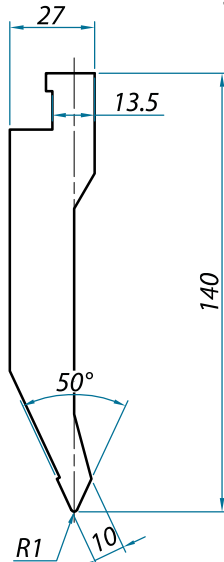
10.697/50°

100T/m



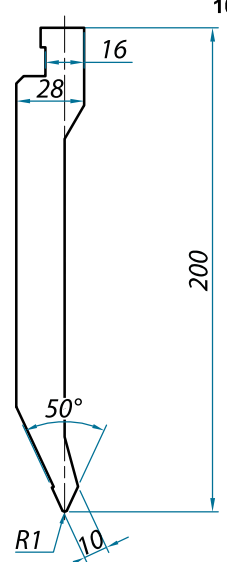
10.593/50°

100T/m



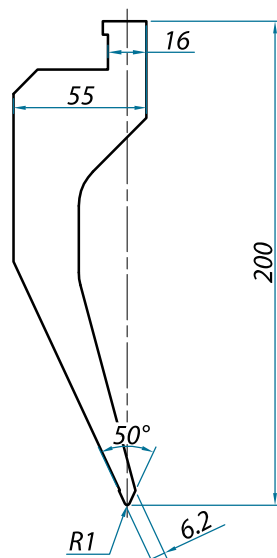
10.700/50°

100T/m

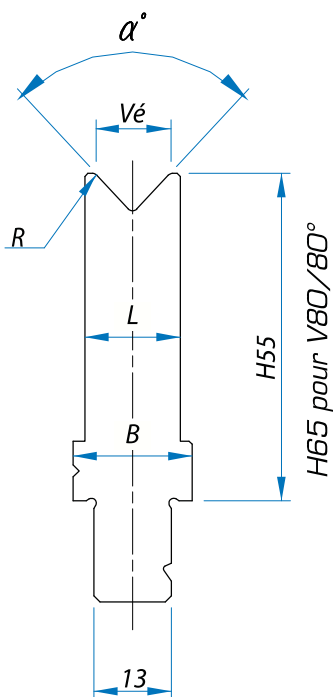
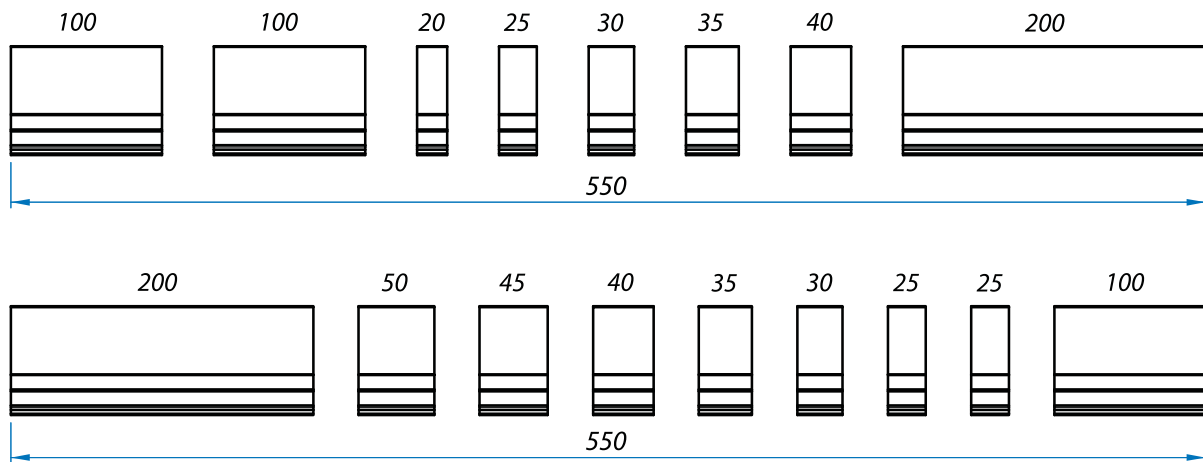


1.14.210/50°

60T/m



Les lames Wila Typ sont disponibles
En longueur 515 et 550 fractionnée



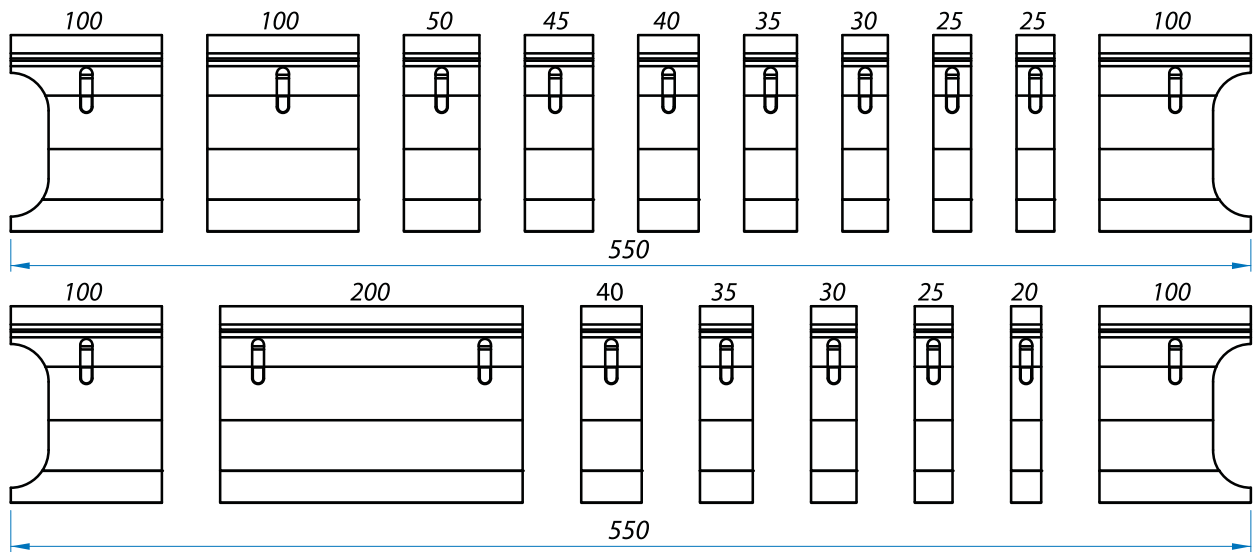
Existe aussi en H 100

Modèle	V _e	α°	R	B	L	F _{maxi}
WM-061	6	30°	R1	25	16	80T/m
WM-051	8	30°	R1	25	16	80T/m
WM-062	10	30°	R1	25	20	80T/m
WM-052	12	30°	R1	25	20	80T/m
WM-053	16	30°	R1.5	30	30	80T/m
WM-063	20	30°	R2	35	35	80T/m
WM-054	24	30°	R2.5	40	40	80T/m

Modèle	V _e	α°	R	B	L	F _{maxi}
WM-021	6	86°	R1	25	16	120T/m
WM-010	8	86°	R1	25	16	120T/m
WM-022	10	86°	R1	25	20	120T/m
WM-011	12	86°	R1	25	20	120T/m
WM-012	16	86°	R1.5	25	25	120T/m
WM-023	20	86°	R2	30	30	120T/m

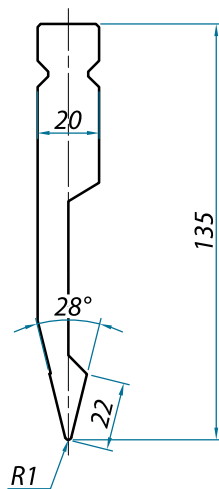
Modèle	V _e	α°	R	B	L	F _{maxi}
WM-013	24	80°	R2.5	35	35	125T/m
WM-014	30	80°	R3	40	40	125T/m
WM-015	40	80°	R4	50	50	125T/m
WM-035	50	80°	R5	75	75	150T/m
WM-017	80	80°	R8	100	100	150T/m

Les lames Wila Typ sont disponibles en longueur 515 et 550 fractionnée



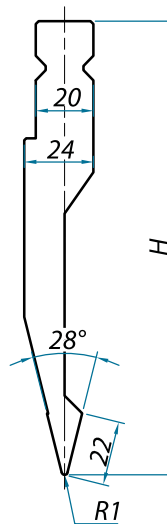
WL-001

100T/m



WL-0*1

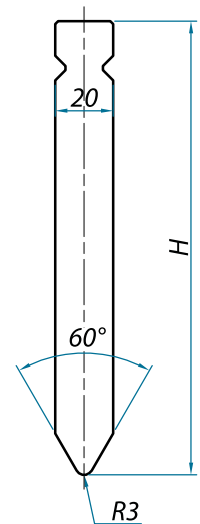
Modèle	H	T/m
WL-011	157	100
WL-021	200	70
WL-031	237	60



WL-0*4

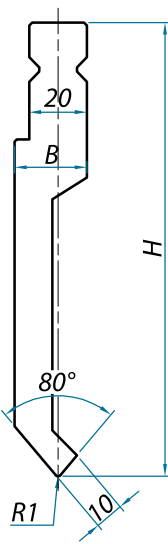
160T/m

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



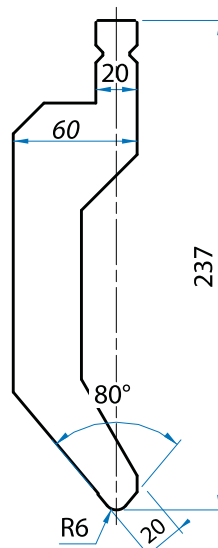
WL-0*2

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



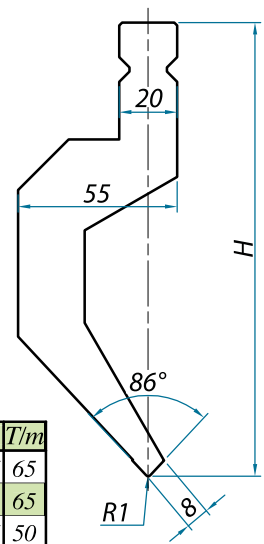
WL-235

130T/m



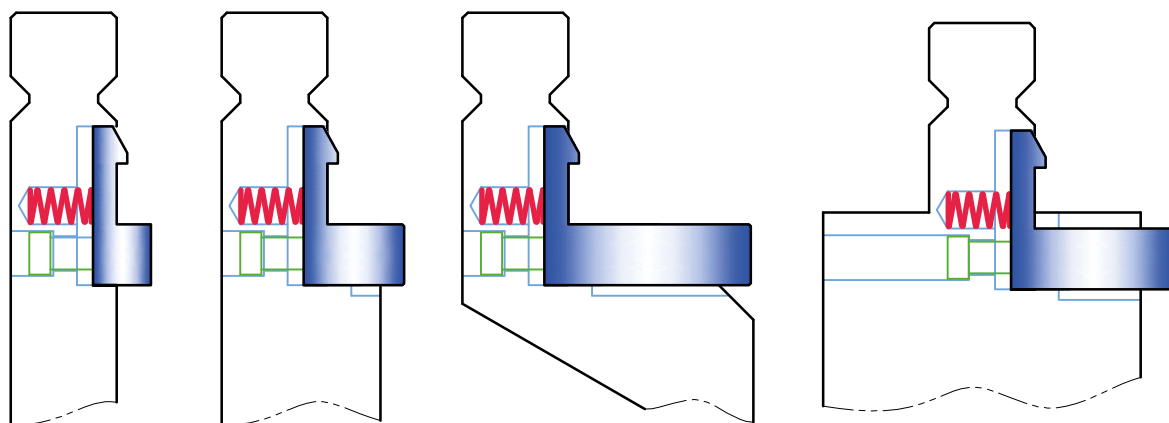
WL-0*3

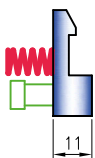
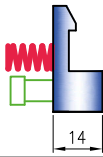
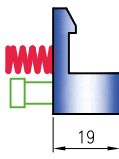
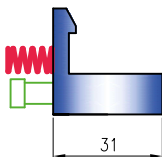
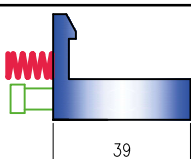
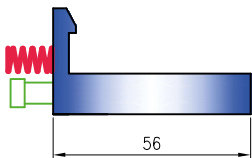
Modèle	H	T/m
WL-013	157	65
WL-023	200	65
WL-033	237	50



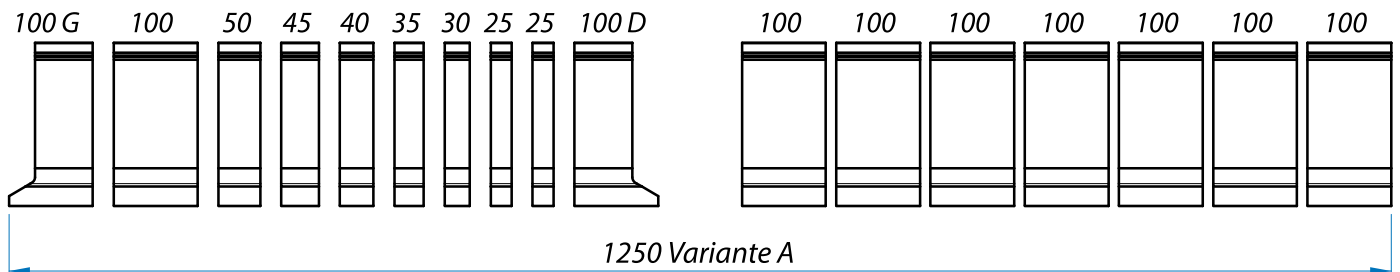
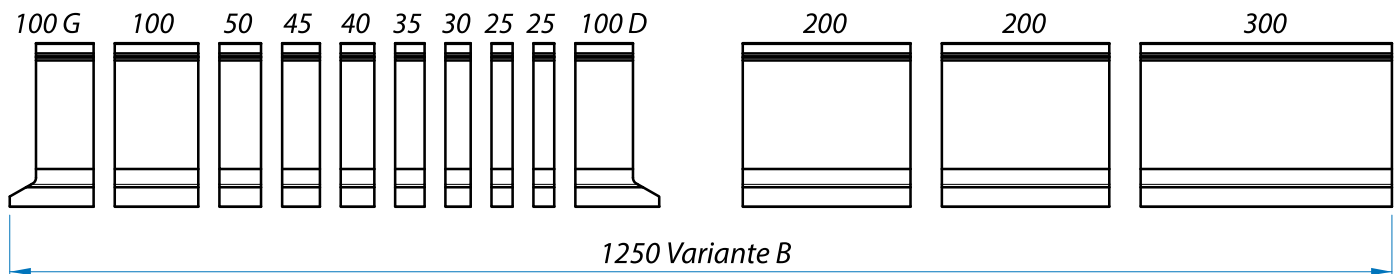
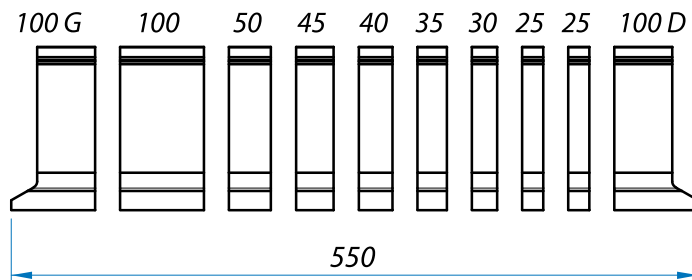
Poussoirs de sécurité

Permettant de monter et démonter la lame verticalement
Pour les lames dont le poids est inférieur à 12,5 Kg
et dont la longueur est de 200 mm maxi



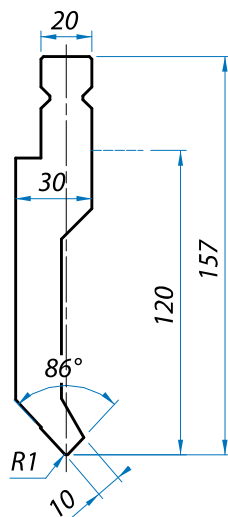
Modèle de poussoir	Modèle de lame
SK001 	WL-001 WL-014 WL-024 WL-034
SK002 	WL-011 WL-012 WL-021 WL-031
SK003 	WL-022 WL-032
SK004 	
SK005 	WL-013 WL-023 WL-033
SK006 	WL-235

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



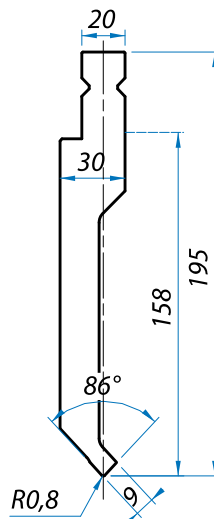
TR101 K

100T/m



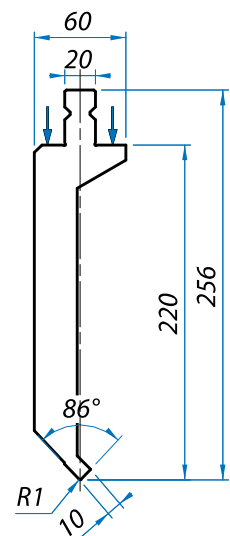
TR101 KH

100T/m



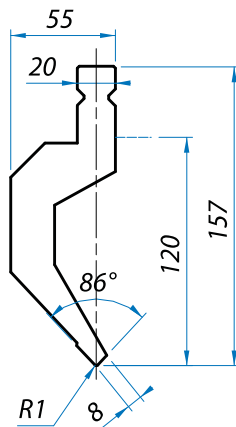
TR101

80T/m



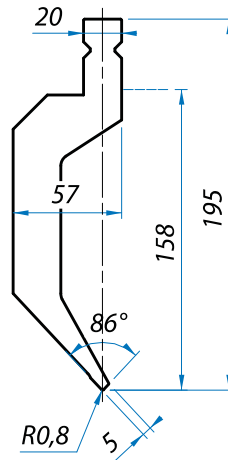
TR100 K

80T/m



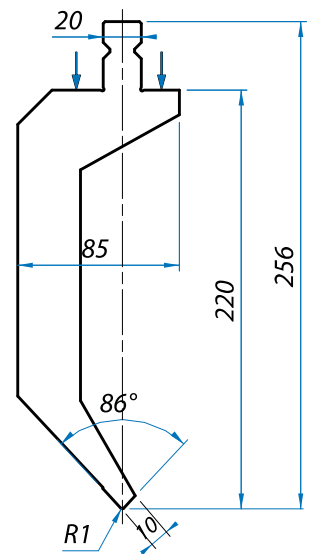
TR100 KH

100T/m



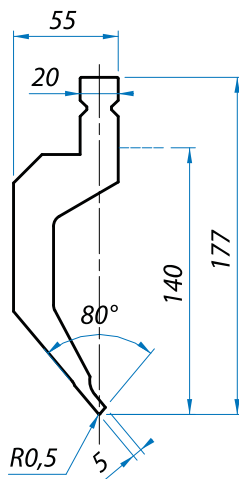
TR100

85T/m



TR180 K

40T/m



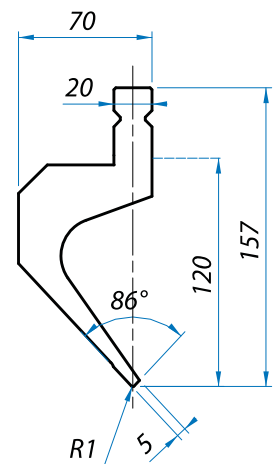
*Toutes les lames
n'exédant pas 12.5kg sont
prévues pour recevoir les
poussoirs de sécurité*

*Les poussoirs sont à
commander séparément*

*Détail des poussoirs
page 70*

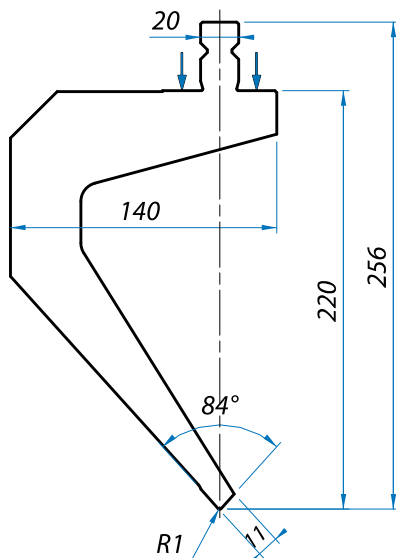
TR106 K

25T/m



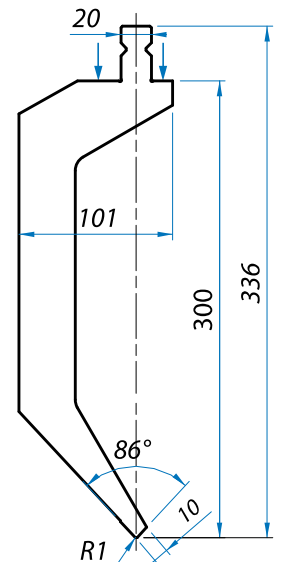
TR107

60T/m



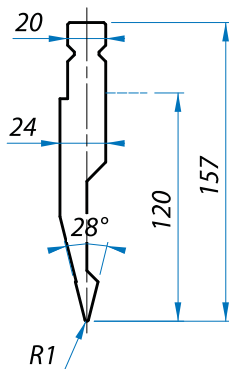
TR300 S

80T/m



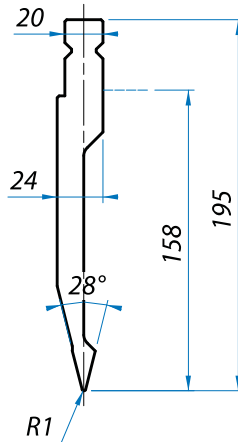
TR102 K

80T/m



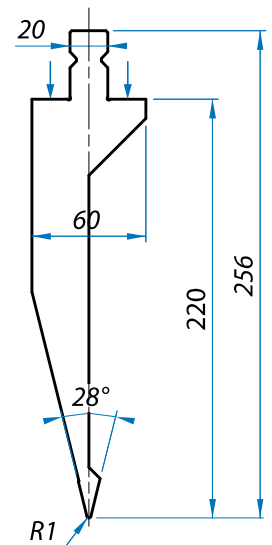
TR102 KH

80T/m



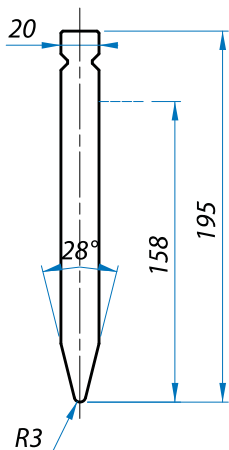
TR102

80T/m



TR105 KH

100T/m



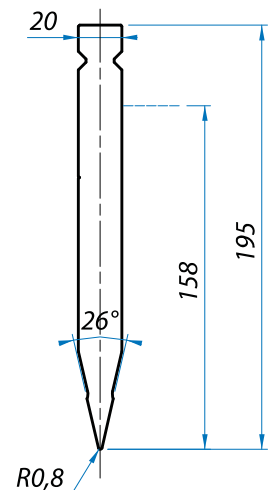
*Toutes les lames
n'exédant pas 12.5kg sont
prévues pour recevoir les
poussoirs de sécurité*

*Les poussoirs sont à
commander séparément*

*Détail des poussoirs
page 70*

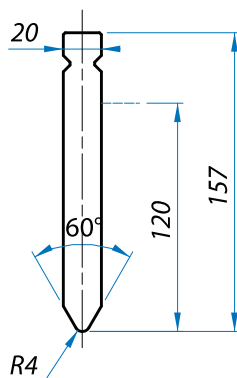
TR159 KH

100T/m



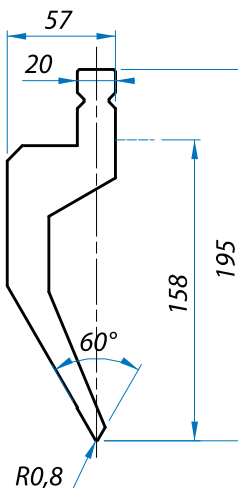
TR103 K

100T/m



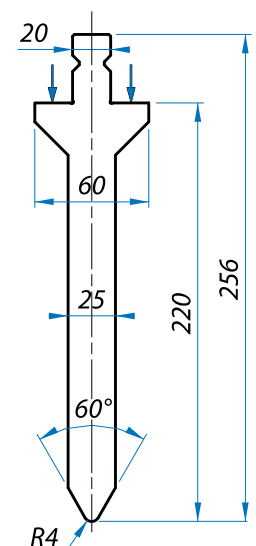
TR104 KH

40T/m



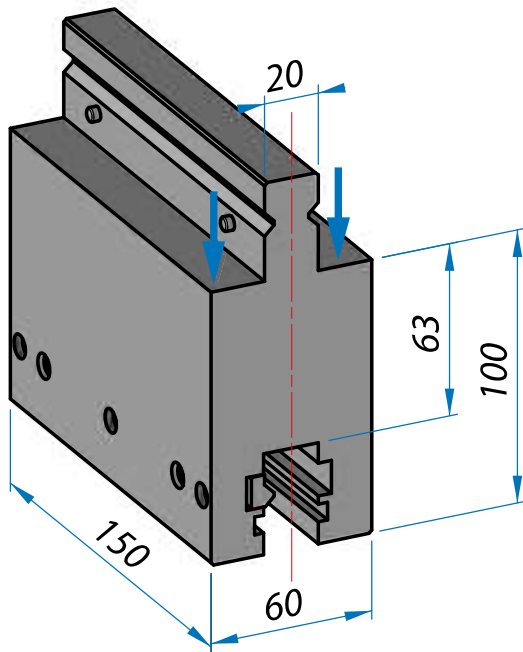
TR103

130T/m



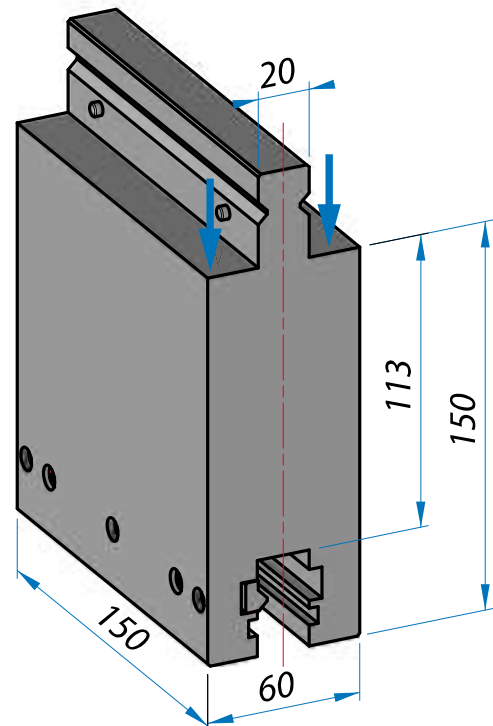
Ref. WW 4361 WW
WILA / WILA

Avec goupilles



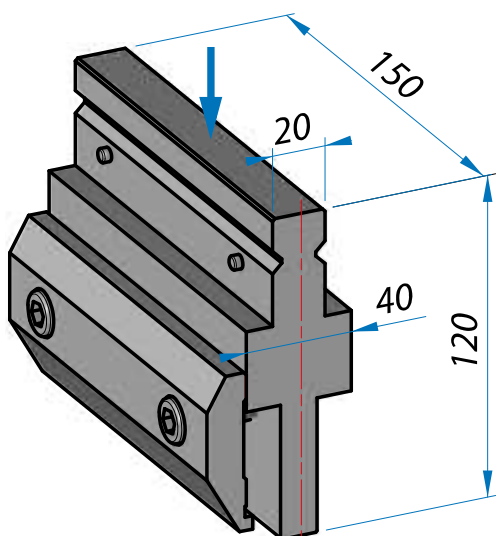
Ref. WW 4400 TRTR
WILA / TRUMPF

Avec goupilles

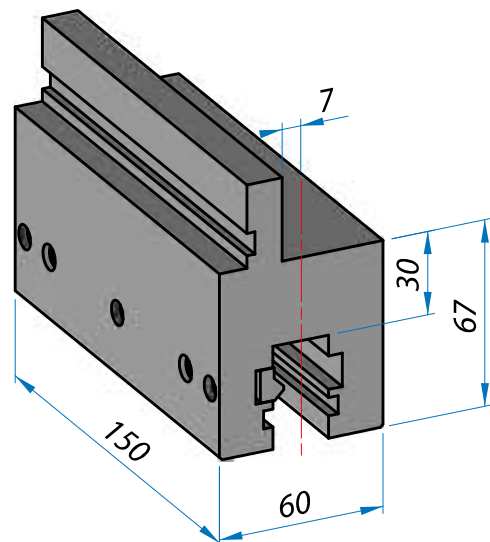


Ref. WW 4191 WA
WILA / AMADA

Avec goupilles



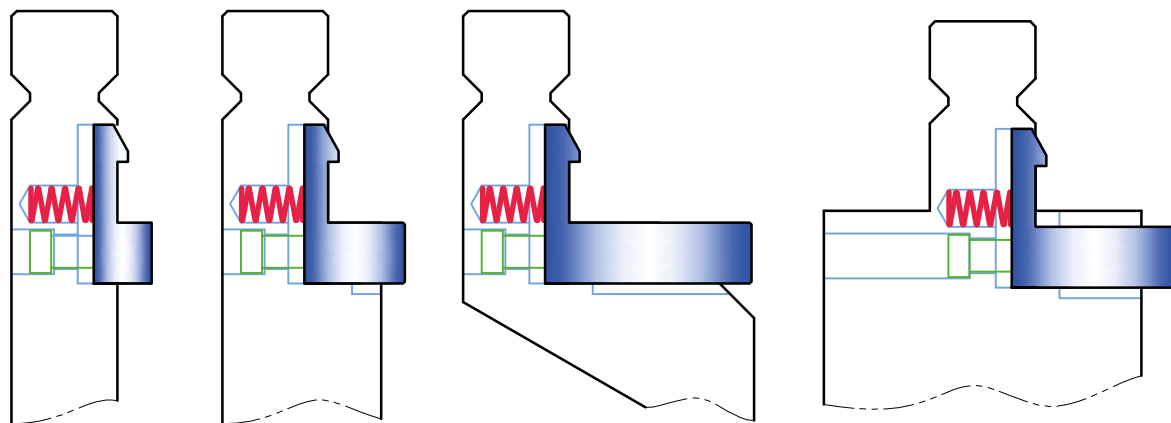
Ref. WW4362 AW
AMADA / WILA

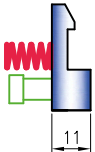
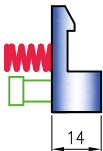
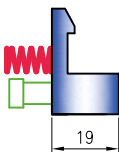
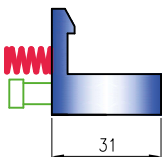
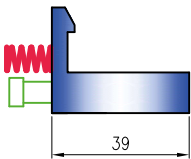
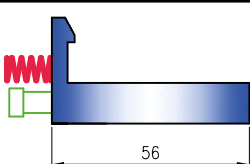


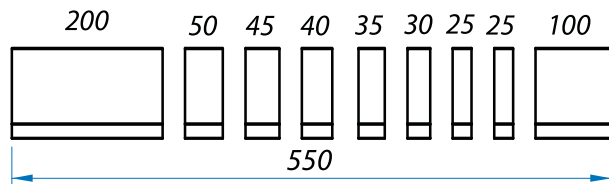
Vendu sans bride, voir les brides page 34

Poussoirs de sécurité

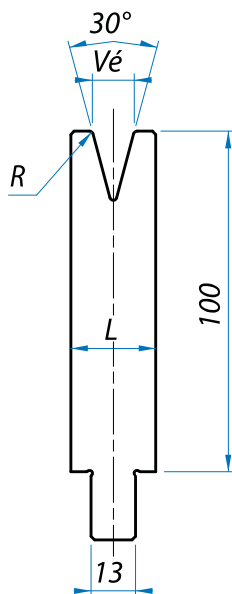
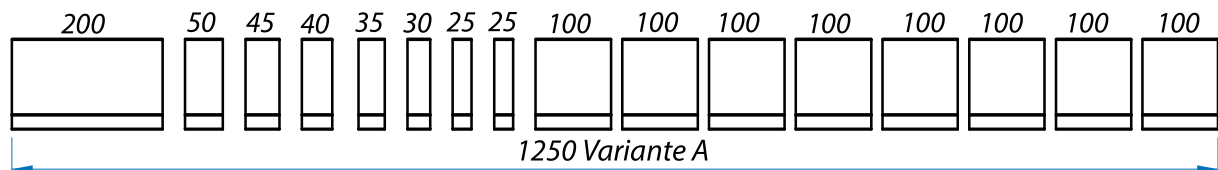
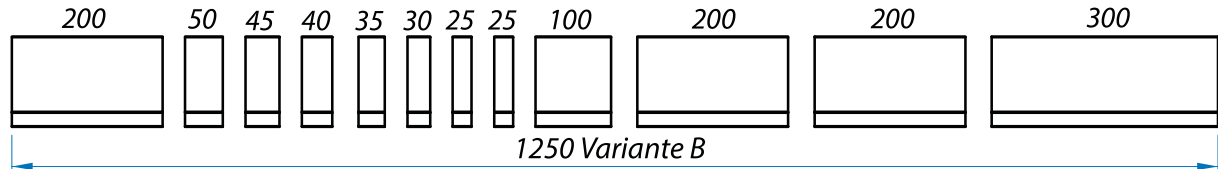
Permettant de monter et démonter la lame verticalement
Pour les lames dont le poids est inférieur à 12,5 Kg
et dont la longueur est de 200 mm maxi



Modèle de poussoir	Modèle de lame
SK001 	TR103K - TR105 KH TR159 KH - TR124
SK002 	TR102 K TR102 KH
SK003 	TR101 K - TR108 K TR101 KH
SK004 	TR101 - TR102 TR103
SK005 	TR100K - TR180 K TR100 KH - TR104 KH
SK006 	TR106 K - TR100 TR300 S

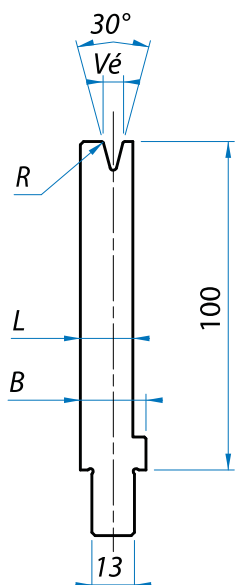


Les matrices Trumpf typ
sont disponibles en longueur
500, 550 fractionnée et
1250 fractionnée (2 variantes)

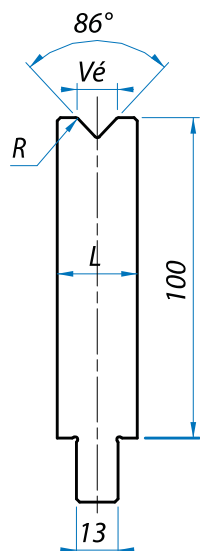


Modèle	Vé	R	L	F maxi
TM V6/30°	6	R0.6	20	60T/m
TM V8/30°	8	R1	20	50T/m
TM V10/30°	10	R1	20	50T/m
TM V12/30°	12	R1	25	56T/m
TM V16/30°	16	R1.6	30	68T/m
TM V20/30°	20	R2	35	50T/m
TM V24/30°	24	R2.5	40	55T/m
TM V30/30°	30	R3	55	85T/m
TM V40/30°	40	R5	60	73T/m
TM V50/30°	50	R5	75	100T/m

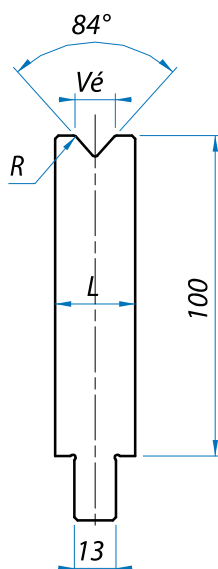
Existe aussi en R3 jusqu'au V16



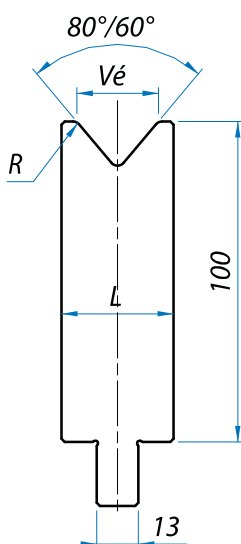
Modèle	Vé	R	B	L	F maxi
TM V4S/30°	4	R0.6	20	15	20T/m
TM V5S/30°	5	R0.6	20	15	15T/m
TM V6S/30°	6	R0.6	20	16	17T/m
TM V8S/30°	8	R1	20	17	20T/m
TM V10S/30°	10	R1	20	18	20T/m
TM V12S/30°	12	R1	25	21.5	25T/m



Modèle	Vé	R	L	F maxi
TM V6/86°	6	R0.6	20	100T/m
TM V8/86°	8	R0.8	20	100T/m
TM V10/86°	10	R1	20	100T/m
TM V12/86°	12	R1	25	100T/m
TM V16/86°	16	R1.6	30	100T/m
TM V20/86°	20	R2	30	100T/m
TM V24/86°	24	R2.5	35	100T/m
TM V30/86°	30	R3	45	100T/m
TM V40/86°	40	R3	55	120T/m
TM V50/86°	50	R3	75	150T/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



Modèle	Vé	R	L	F maxi
TM V24/80°	24	R2.5	35	100T/m
TM V30/80°	30	R5	45	120T/m
TM V40/80°	40	R5	55	150T/m
TM V50/80°	50	R5	65	150T/m
TM V60/80°	60	R5	75	150T/m
TM V70/80°	70	R5	85	150T/m
TM V80/80°	80	R5	100	150T/m
TM V90/80°	90	R8	110	150T/m
TM V100/80°	100	R8	120	150T/m
TM V120/60°	120	R8	145	160T/m

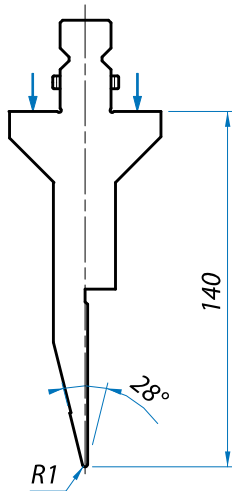
(H120)

(H120)

(H120)

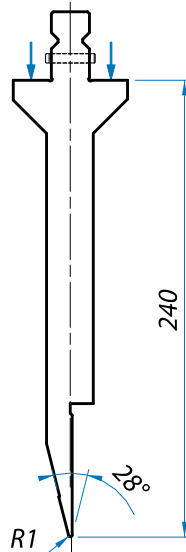
TR110.140

40T/m



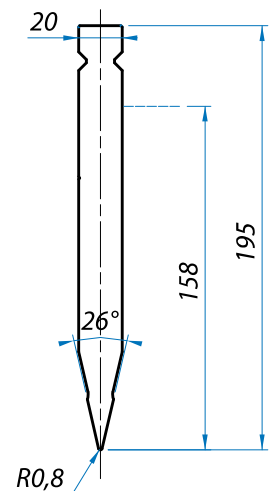
TR110.240

40T/m

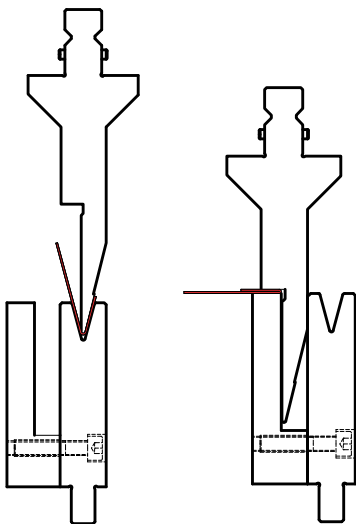


TR159 KH

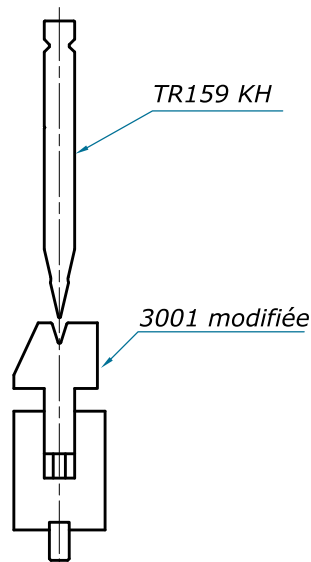
15T/m



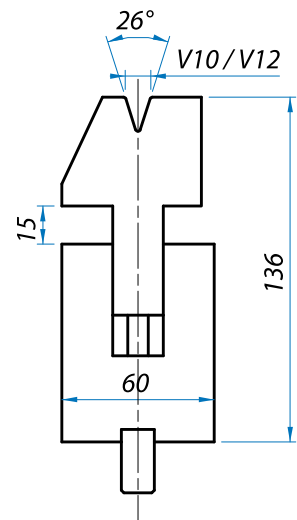
Réaction pour matrices pré-percées



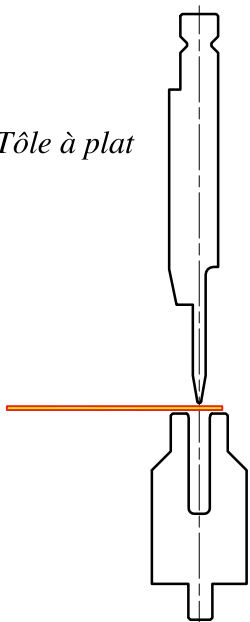
Avec 3001 modifiée



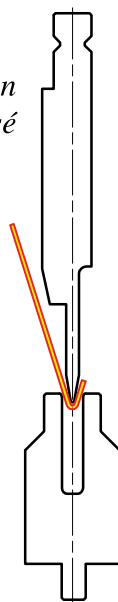
3001 modifiée



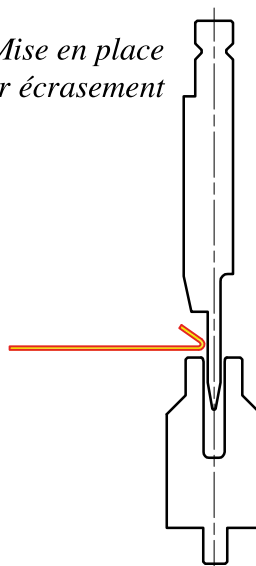
Tôle à plat



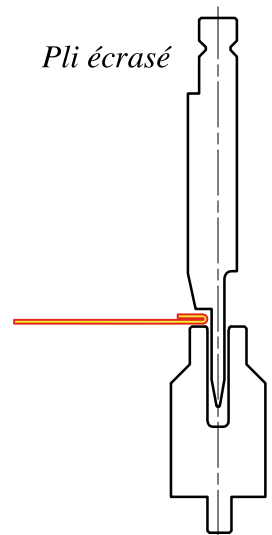
Préparation du pli écrasé



Mise en place pour écrasement

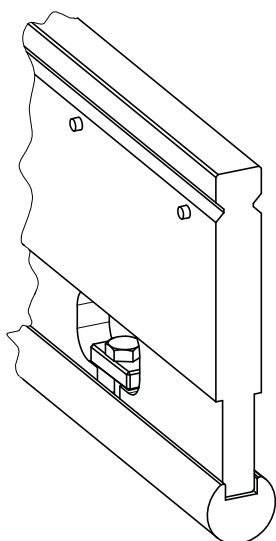
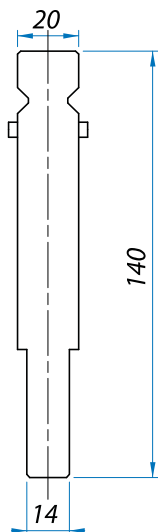


Pli écrasé

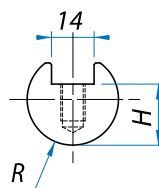


TR124

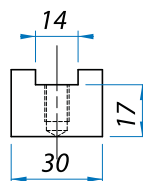
100T/m



40.09



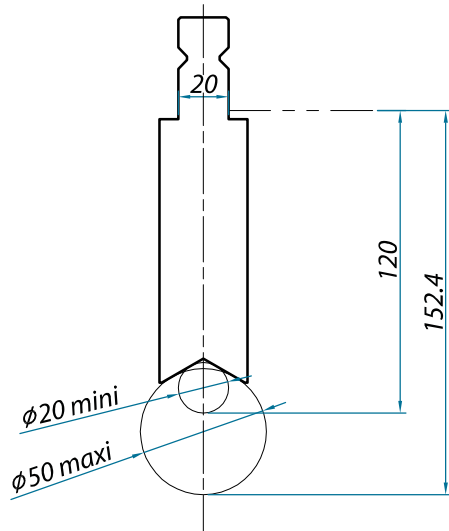
40.02



Modèle	R	H
40.09/14	7	11.5
40.09/15	7.5	11.5
40.09/16	8	13
40.09/18	9	16
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

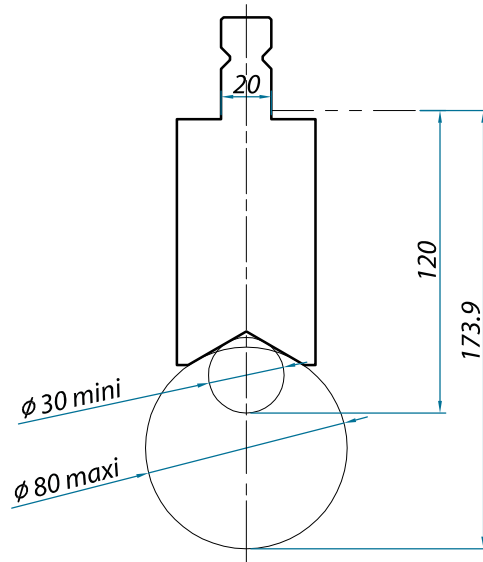
TR108K

130T/m



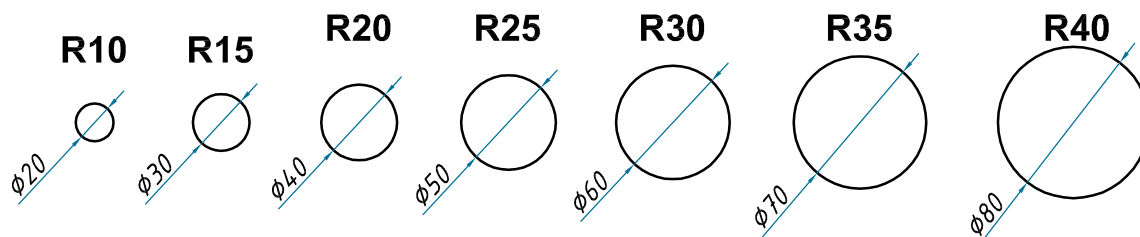
TR108

150T/m



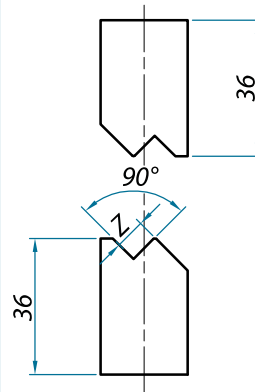
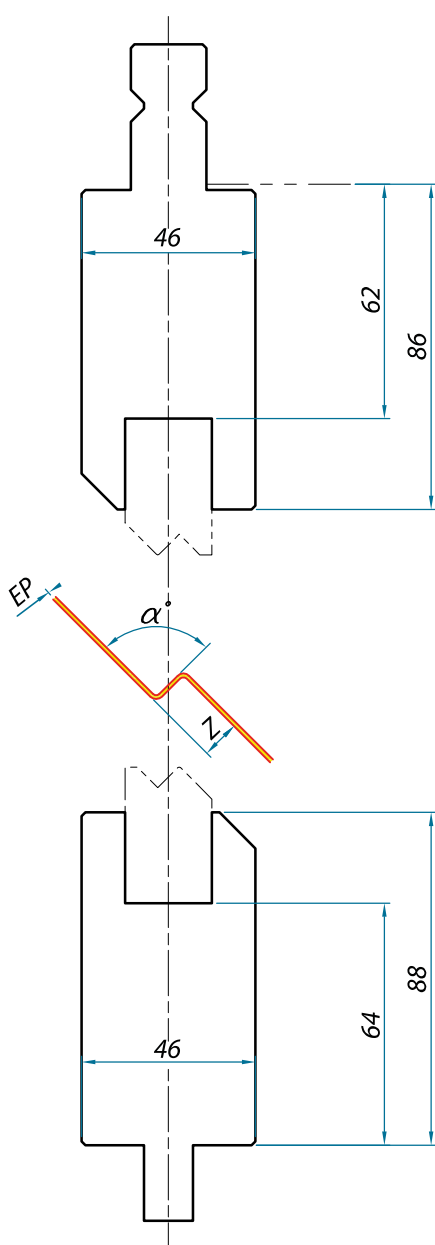
Règles à rayonner

100T/m

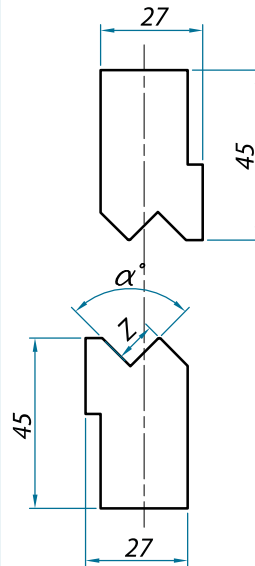


TRZ

100T/m

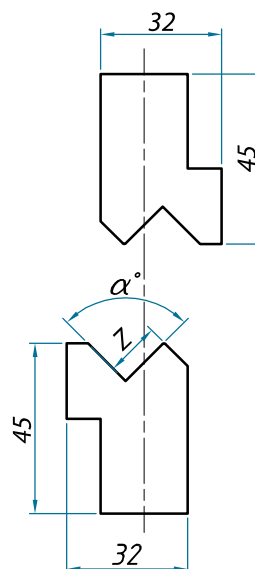
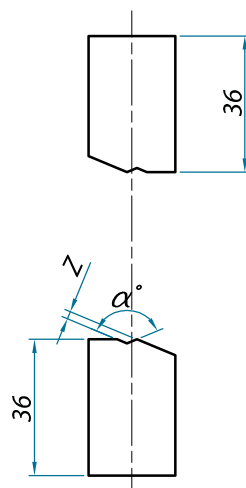


Modèle	Z	α°	$E_p \text{ max}$
Z1-90	1	90°	5/10
Z1.5-90	1.5	90°	6/10
Z2-90	2	90°	8/10
Z2.5-90	2.5	90°	10/10
Z3-90	3	90°	10/10
Z3.5-90	3.5	90°	12/10
Z4-90	4	90°	12/10
Z4.5-90	4.5	90°	15/10
Z5-90	5	90°	15/10
Z5.5-90	5.5	90°	15/10
Z6-90	6	90°	15/10
Z6.5-90	6.5	90°	15/10
Z7-90	7	90°	20/10
Z7.5-90	7.5	90°	20/10
Z8-90	8	90°	25/10



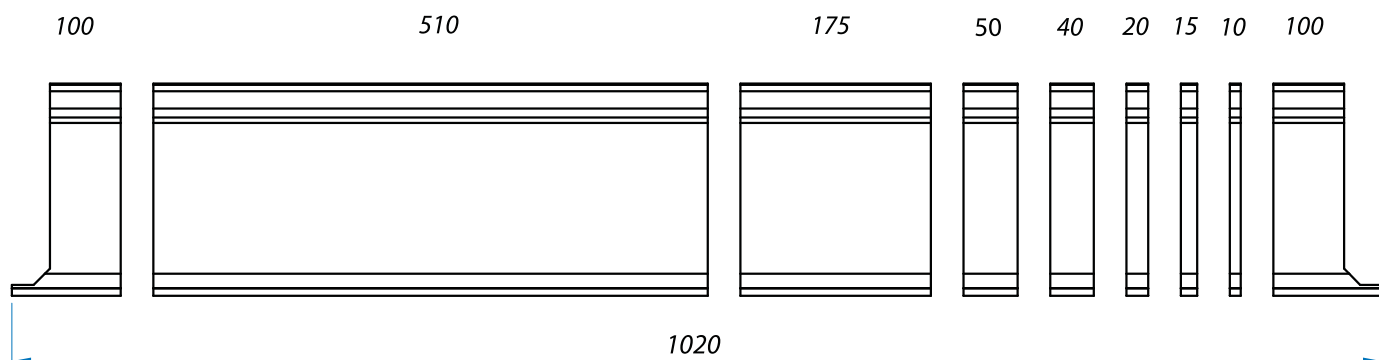
Modèle	Z	α°	$E_p \text{ max}$
Z9-90	9	90°	25/10
Z10-90	10	90°	30/10
Z11-90	11	90°	30/10
Z12-90	12	90°	30/10

Modèle	Z	α°	$E_p \text{ max}$
Z1-160	1	160°	10/10
Z1.5-160	1.5	160°	12/10
Z2-150	2	150°	15/10
Z2.5-140	2.5	140°	15/10



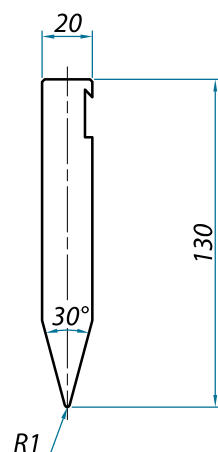
Modèle	Z	α°	$E_p \text{ max}$
Z13-90	13	90°	30/10
Z14-90	14	90°	30/10
Z15-90	15	90°	30/10

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



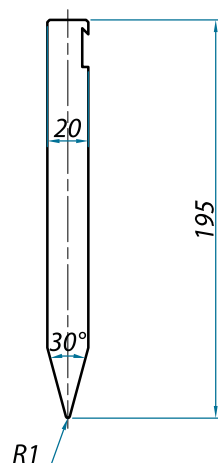
502034

100T/m



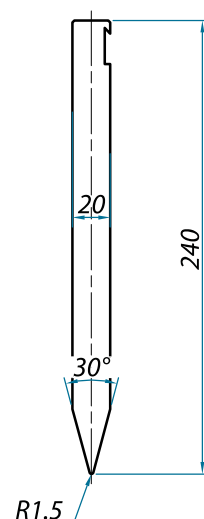
502112

100T/m



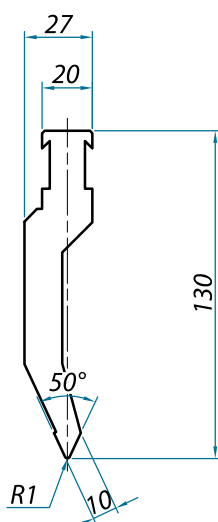
502189

100T/m



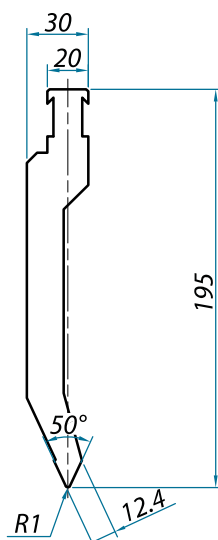
502001

100T/m



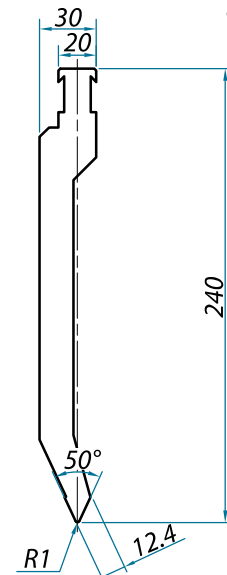
502067

100T/m



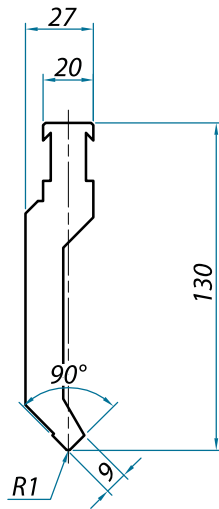
502145

100T/m



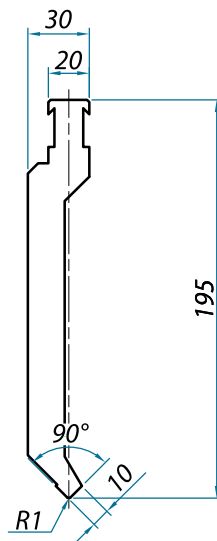
502012

100T/m



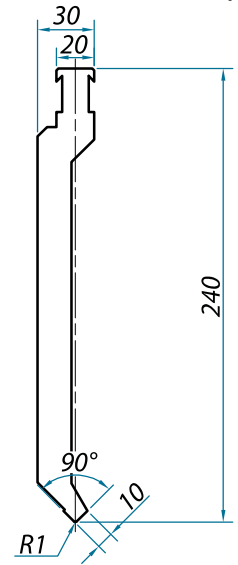
502078

100T/m



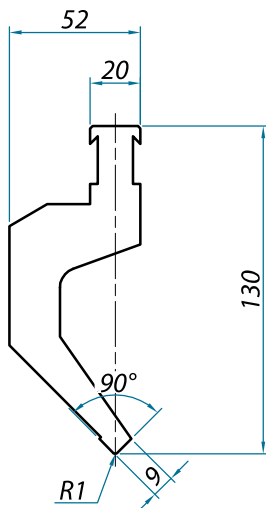
502156

100T/m



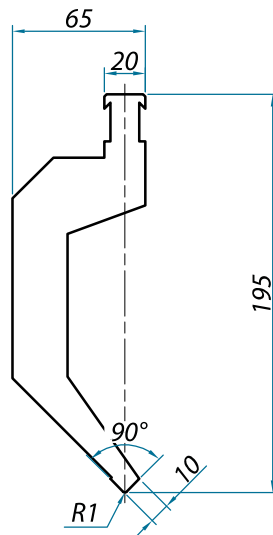
502023

40T/m



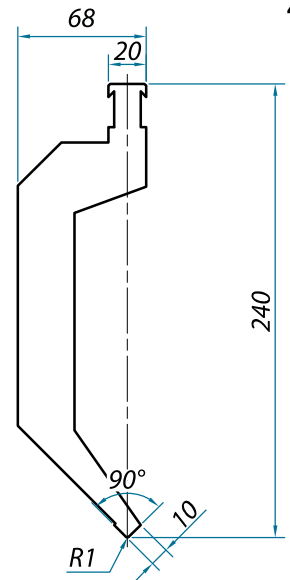
502089

40T/m



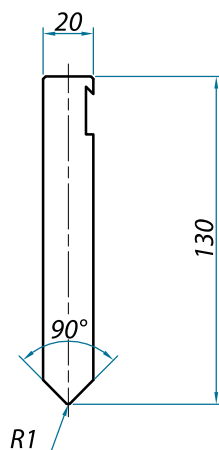
502167

40T/m



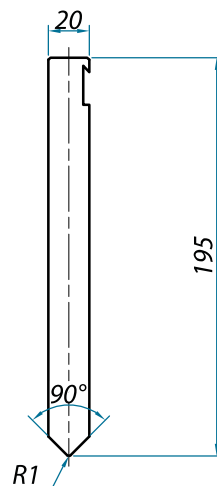
502045

100T/m



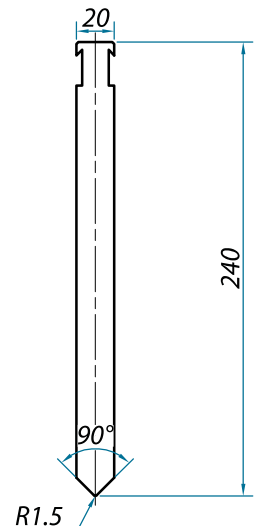
502131

100T/m

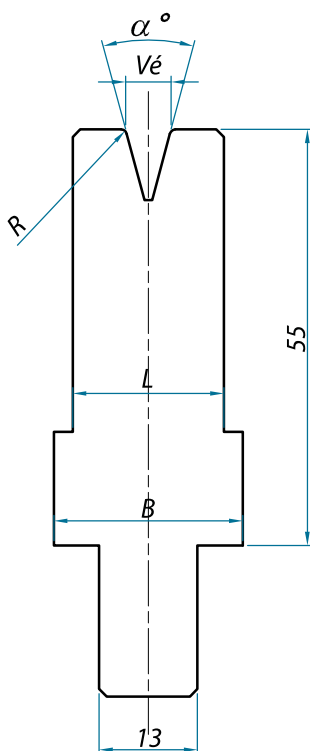
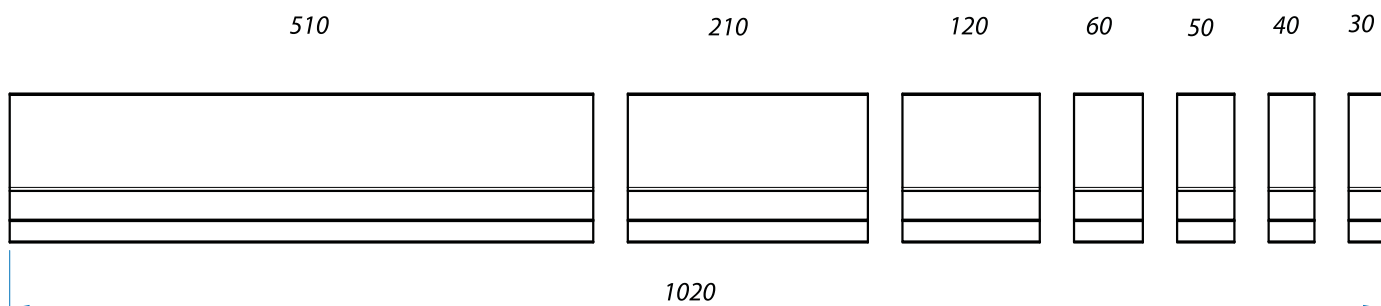


502201

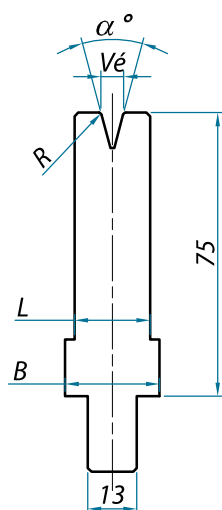
100T/m



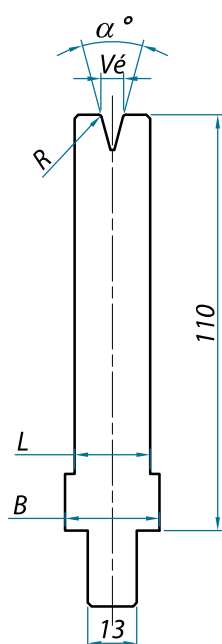
*Les matrices Perrot typ sont disponibles
en long. 1020 et 1020 fractionnée*



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

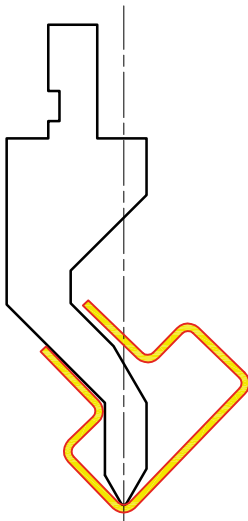


Modèle	Vé	α°	R	B	L	F maxi
510098	6	30°	R0.75	26	16	40T/m
510108	8	30°	R1	26	18	40T/m
510117	10	30°	R1	26	18	30T/m
510126	12	30°	R1.5	30	22	35T/m
510135	16	30°	R2	30	30	55T/m
510144	20	30°	R2	32	32	45T/m
510153	24	30°	R3	36	36	45T/m
510162	32	40°	R4	46	46	80T/m
510171	40	40°	R5	55	55	75T/m
510187	50	60°	R6	66	66	100T/m
510188	60	60°	R7	80	80	100T/m
510197	80	80°	R10	100	100	100T/m
510206	100	80°	R12	125	125	60T/m

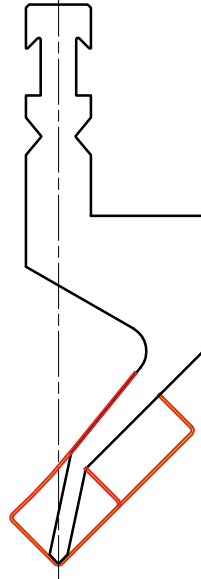


Modèle	Vé	α°	R	B	L	F maxi
510215	6	30°	R0.75	26	16	40T/m
510224	8	30°	R1	26	18	40T/m
510233	10	30°	R1	26	18	30T/m
510242	12	30°	R1.5	30	22	35T/m
510251	16	30°	R2	30	30	55T/m
510259	20	30°	R2	32	32	45T/m
510268	24	30°	R3	36	36	45T/m
510277	32	40°	R4	46	46	80T/m
510286	40	40°	R5	55	55	75T/m
510295	50	60°	R6	66	66	100T/m
510304	60	60°	R7	80	80	100T/m
510313	80	80°	R10	100	100	100T/m
510322	100	80°	R12	125	125	100T/m
510331	130	80°	R15	160	160	100T/m

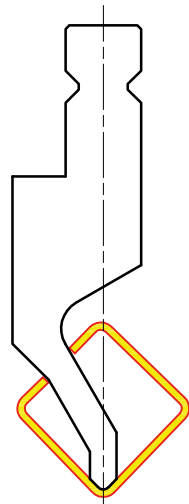
10.04-1



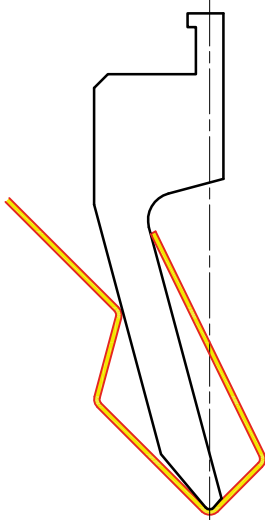
10.04-2



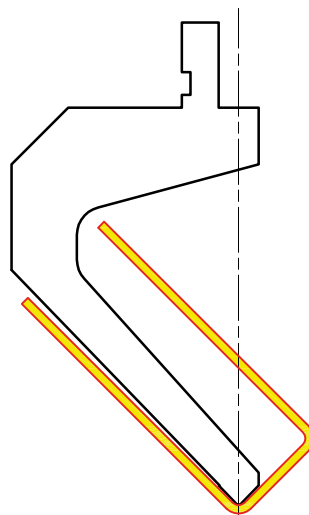
10.04-3



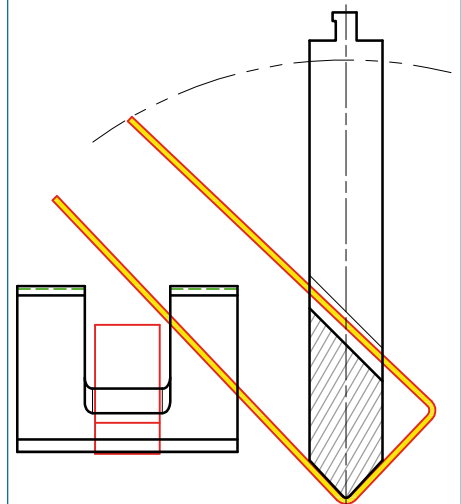
10.06



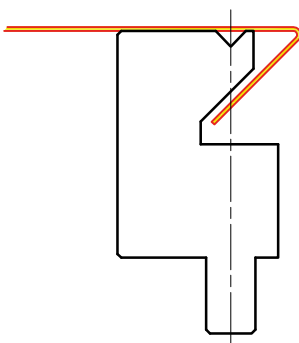
10.08



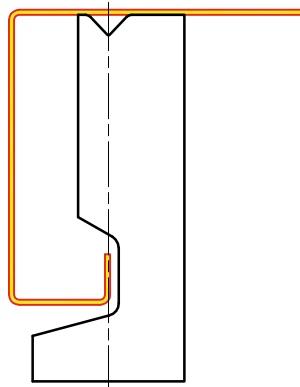
10.09



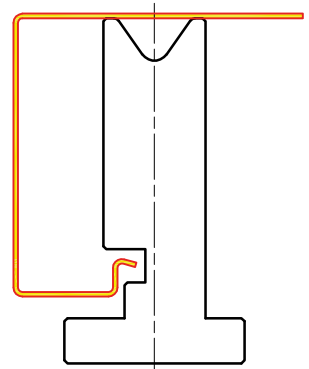
20.81



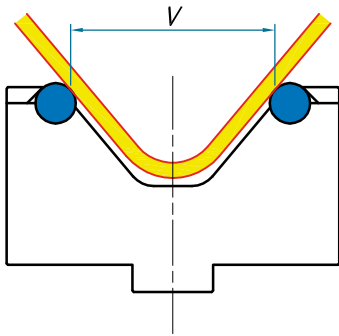
20.82



20.83

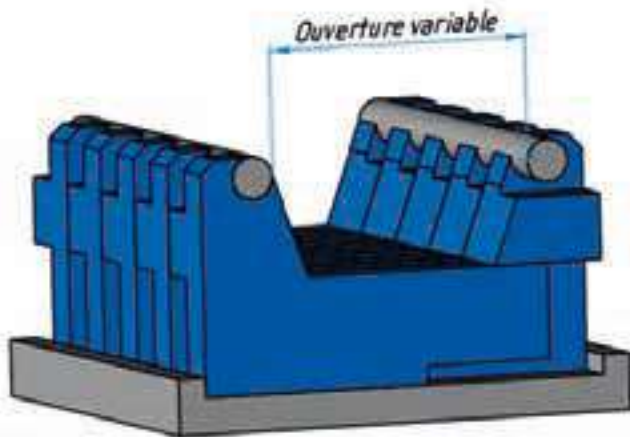


20.51 Matrice à rouleaux trempés



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.

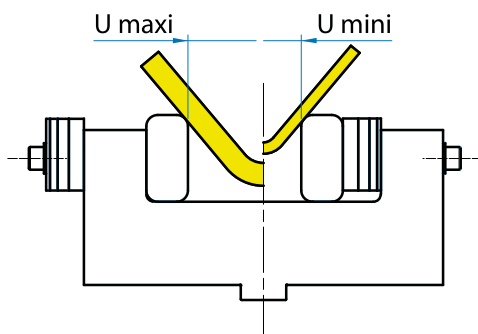
Matrice à vé variable



Cette matrice permet un meilleur glissement de la tôle pendant le pliage. L'ouverture du vé est réglable, selon les modèles de:

- Vé de 25 à 125
- Vé de 65 à 185
- Vé de 120 à 300
- Vé de 150 à 400

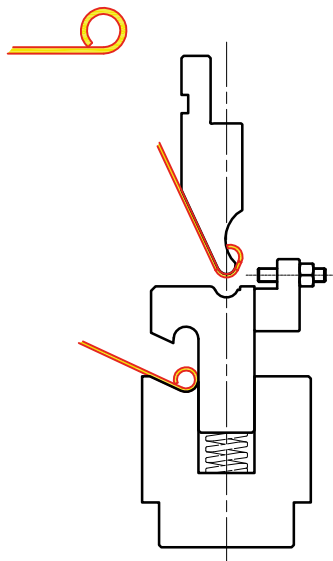
20.71 Matrice à U réglable



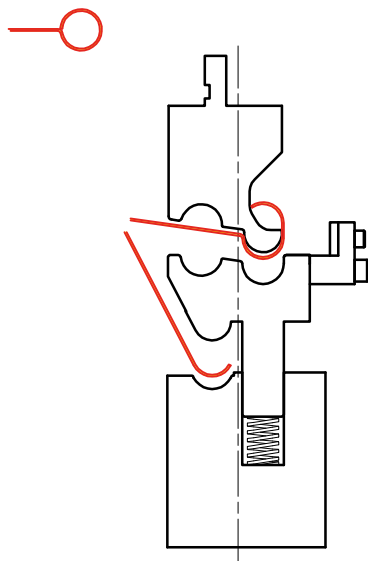
*L'ouverture du U est réglable
en déplaçant les cales*



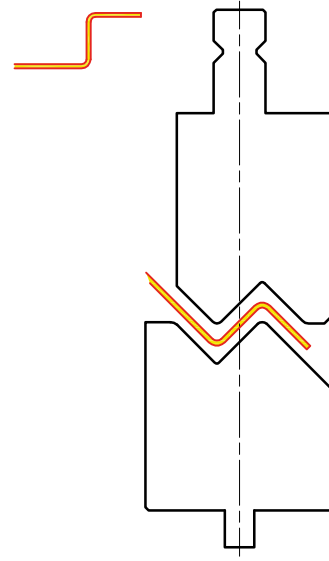
30.03



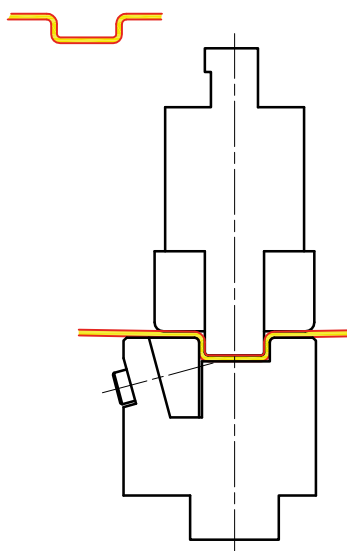
30.04



30.05



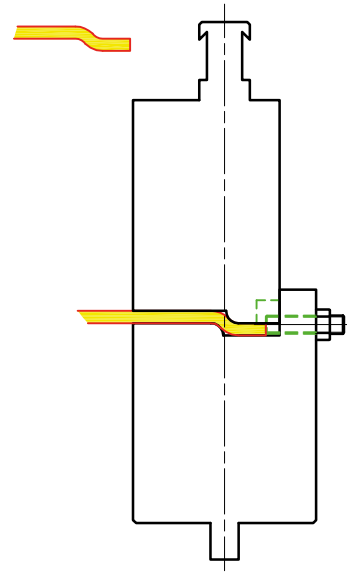
30.06



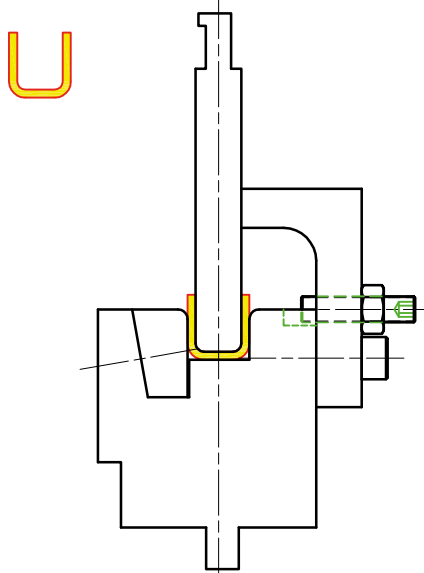
Pour toute demande, veuillez nous indiquer:

- 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

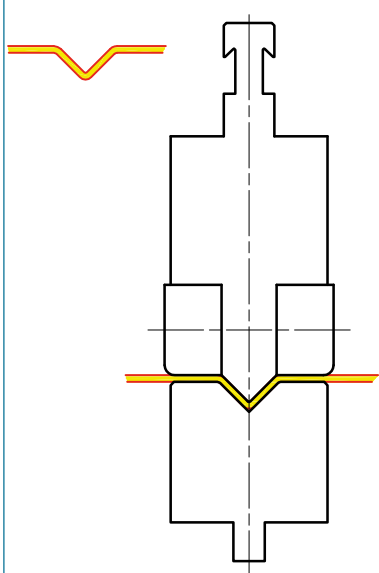
30.08



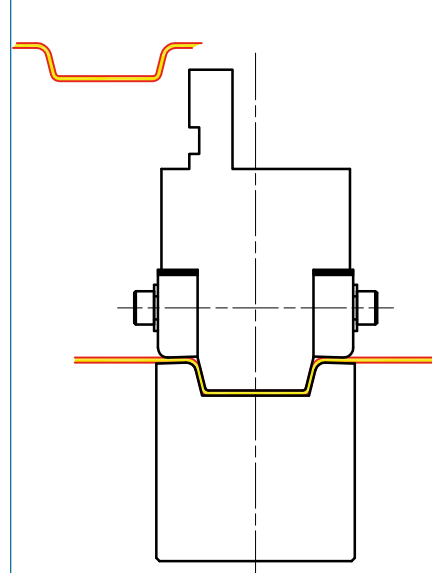
30.09



30.10

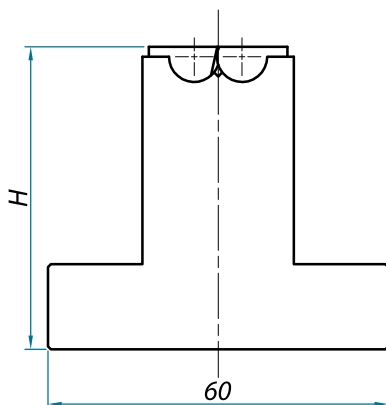


30.11

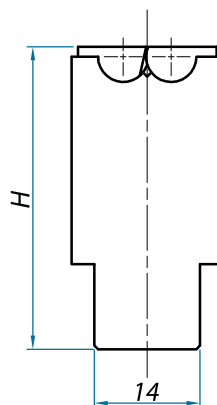


*Préconisées pour le pliage d'inox ou d'aluminium sans marquage ou légère trace de marquage.
Prévues pour le pliage de petites pièces, le pliage sans déformation de tôles perforées et/ou le pliage sans polluer l'outil (calamine, galva, etc.)*

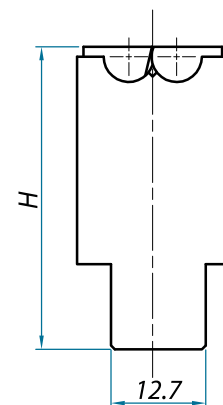
Amada Typ



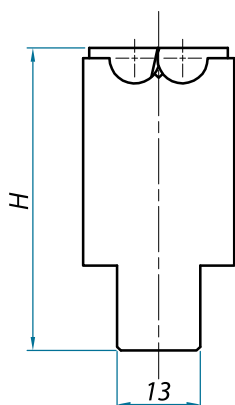
Amada Typ



LVD Typ

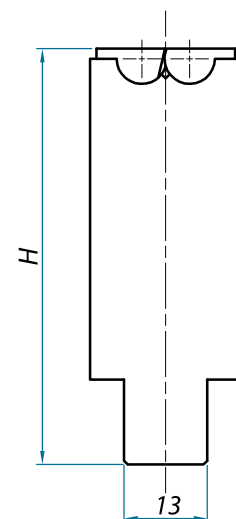


Beyeler Typ

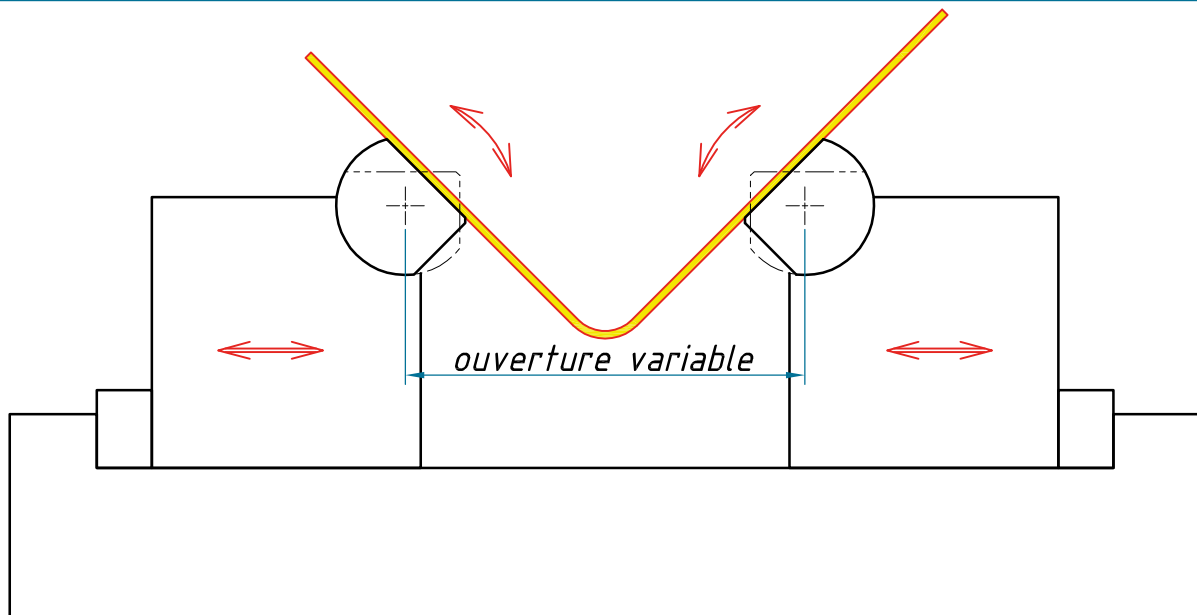
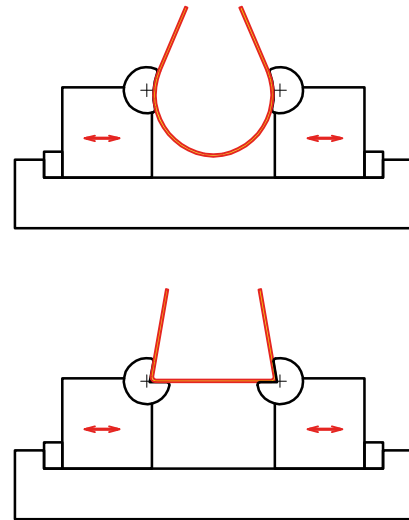


*Ces matrices sont
prévues pour des
épaisseurs de 0.7 à 6mm
et jusqu'à 16mm
en hors standard*

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

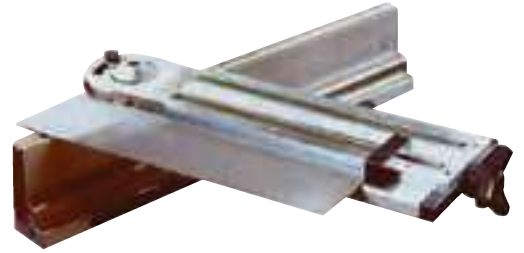




*Film de protection
anti-rayure*



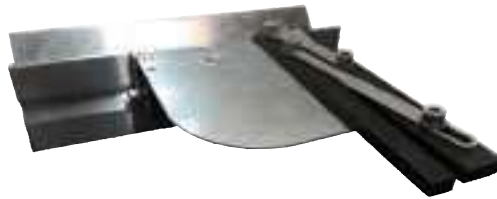
*Bande de protection
en toile enduite (ép. 0,2)*



*Butée avec rapporteur
d'angle*



*Système positionneur
de film de protection*



*Équerre magnétique
orientable*



Butée avec équerre fixe

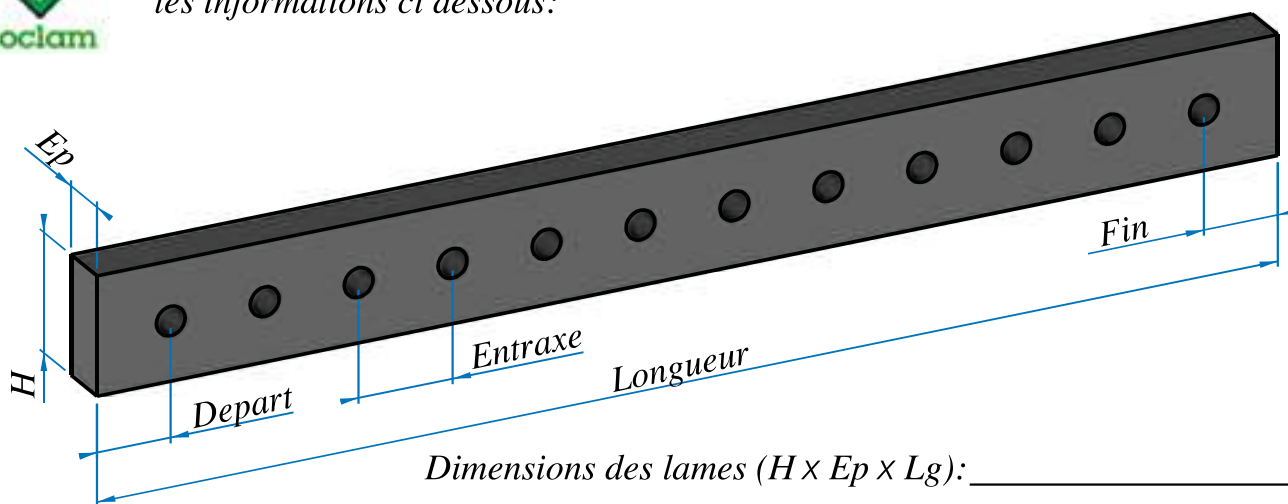


*Armoire de rangement d'outillage pour:
Amada, Beyeler, Colly, EHT, Trumf...*





Pour toutes demandes de lames de cisailles, merci de compléter les informations ci dessous:



Dimensions des lames ($H \times Ep \times Lg$): _____

Nombres de lames supérieures: _____

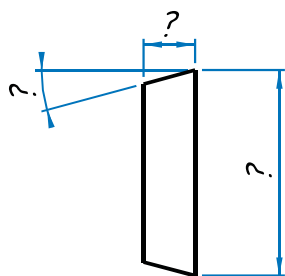
Nombres de lames inférieures: _____

Nombres de trous: _____

Attention: En cas d'entraxes irréguliers, veuillez nous communiquer tous les entraxes

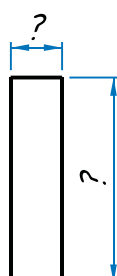
2 Coupes Trapèze:

Sup. / Inf.
☐ ☐



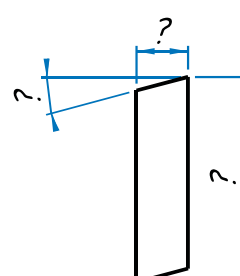
4 Coupes:

Sup. / Inf.
☐ ☐



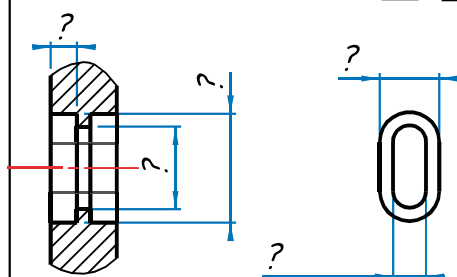
2 Coupes:

Sup. / Inf.
☐ ☐



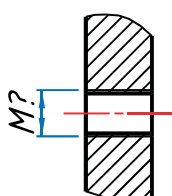
Boutonnière:

Sup. / Inf.
☐ ☐



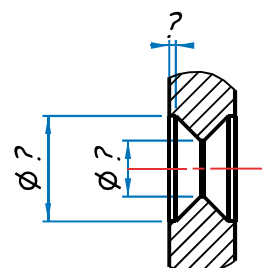
Trou Taraudé:

Sup. / Inf.
☐ ☐



Double Fraisure:

Sup. / Inf.
☐ ☐



Si trous spéciaux, veuillez envoyer une photo et des cotes

Cisaille:

Marque: _____

Modèle: _____

Matière et Epaisseur à cisailer:

Ep maxi Acier: _____

Ep maxi Inox: _____

Ep maxi Tôle larmée: _____



Site internet: soclam.com

Tel 01 60 05 25 15

mail: soclam@wanadoo.fr



www.soclam.com

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

soclam

Nos outils sont fabriqués avec des aciers et traitements correspondants aux normes standard des constructeurs.

Dans le cas de pliage de tôles INOX et/ou DECOUPEES AU LASER, nous pouvons réaliser **sur votre demande** un traitement spécifique telle que la nitruration.

Nous rappelons également que toute bavure (créée par découpes – laser, cisailage, poinçonnage) endommage l'acier : il est **IMPERATIF** de plier des tôles **SANS** bavure.

Photos et plans non contractuels, modifications possibles sans préavis.

CONDITIONS GENERALES DE VENTE

1 - Commandes

Le fait de passer une commande implique l'acceptation formelle de nos conditions générales de vente, toute dérogation devant faire l'objet d'un accord écrit préalable. En cas d'annulation de la commande du fait de l'acheteur, l'acompte versé restera à la société SOCLAM au titre de dédommagement.

2 - Délais

Les délais sont fixés sans aucun engagement. Aucune pénalité de retard ou de dommage et intérêt ne seront acceptées. Les retards ne peuvent en aucun cas justifier l'annulation d'une commande.

3 - Prix

Nos prix sont donnés à titre indicatif HT, départ de nos produits et hors emballage. La validité de nos devis est de 1 mois.

4 - Factures – Délai de paiement

Nos livraisons d'outillages se référant à notre catalogue, sont payables :

- * Pour un montant inférieur ou égal à 100,00 € H.T. par chèque à réception de la facture (sans escompte).
- * Pour un montant compris entre 100,00 et 1 500,00 € H.T. : Traite à 45 jours fin de mois
- * Pour un montant supérieur à 1 500,00 € H.T. : 30% par chèque à la commande, solde p/ traite à 45 jours FDM
- * Les machines-outils se paient comptant par chèque ou crédit bancaire.

Nos factures sont payables à Collégien, nos traites ne constituant ni dérogation ni novation à la clause attributive de juridiction.

L'acceptation des marchandises livrées vaudra reconnaissance de la clause ci-après de convention expresse et report accordé par nous. Le défaut de paiement de nos marchandises ou fournitures à l'échéance fixée sur chaque facture entraînera, que soit le mode de règlement prévu, une intervention contentieuse.

5 - Pénalités de retard (loi du 31/12/1992)

En cas d'allongement du délai de paiement par rapport à la date figurant sur la facture, nous appliquerons des pénalités de 1,5 % par mois de retard.

6 - Réserve de propriété

Selon la loi N°80-335 du 12 Mai 1980, notre société restera la propriétaire jusqu'au paiement intégral du prix de nos marchandises ou machines livrées. Cette clause est acceptée lors de la commande

avec extension de dommage et intérêts en cas de reprise du matériel ayant subi des dégradations lors de la mise en service.

7 - Réparation – Garantie – Reprise

Les reprises doivent faire l'objet d'un accord préalable verbal ou écrit de notre part et porter sur des marchandises neuves. Elles devront être faites dans les quinze jours qui suivent la livraison, en franco de port et d'emballage avec indication du bon de livraison. La garantie sur l'outillage ne pourra être accordée qu'après retour en franco de port et d'emballage en nos magasins et examen par une personne compétente. La garantie sur les machines neuves vendues par notre société se limite au remplacement ou à la fourniture de la pièce constructeur. Celle-ci ne s'étend pas aux appareillages électriques.

Les frais de main d'œuvre, déplacement et d'hébergement ne sont couverts en aucun cas et restent à la charge du client.

En aucun cas, notre responsabilité ne peut être substituée à celle du constructeur pour des défauts ou vices de fabrication et leurs conséquences possibles.

8 - Juridiction

En cas de contestation, le tribunal de commerce de MEAUX est seul compétent.

9 - Expédition

Les expéditions d'outillage sont faites en port avancé, selon les modes de transport Poste, SNCF ou route. Nous déclinons toutes responsabilités pour les opérations de transport, douane, octroi, manutention, amené à pied d'œuvre, dès que notre matériel a quitté nos ateliers ou magasins et cela même dans le cas d'expédition franco.

Les marchandises même en cas de franco, voyagent aux risques et périls du destinataire. Afin d'éviter toutes contestations, les clients sont priés de faire vérifier l'état des colis ou marchandises à leur arrivée, par le transporteur et procéder et procéder aux réserves d'usage légales. Le déchargement du matériel lourd nécessitant un moyen de manutention reste à la charge et sous la responsabilité du destinataire.

10 - Réception de marchandises

Nous avons l'avantage de vous rappeler que toutes nos expéditions marchandises, effectuées par notre transporteur, sont couvertes par notre assureur. Ceci implique, en cas de réclamations, des réserves

précises et caractérisées. En effet, notre transporteur nous informe que tous les dossiers « Assurance » doivent être en conformité avec l'article 105 du Code Civil.

IL NOUS RECOMMANDE DE PROCEDER DE LA FACON SUIVANTE :

Il convient d'émettre des réserves précises et caractéristiques :

- * Colis ouvert OU colis déchiré.
- * Nombre de pièces reçues (non manquantes)
- * Traces de chocs
- * Colis ou palette renversé(e)
- * Palette défilée
- * Emballage pas d'origine

Réserves non recevables juridiquement :

- * Sous réserve de déballage
- * Sous réserve de comptage
- * Sous réserve de casse, ainsi que formules pré-cachetées

Toutes ces réserves doivent être confirmées dans les 48 heures suivant la réception de l'expédition, en lettre recommandée AR, au transporteur et en adressant une copie à notre Service Commercial.

Ne peuvent être prises en compte les lettres recommandées n'ayant pas fait l'objet de réserves préalables sur le réceptionné de livraison.

Nous vous précisons que le législateur, sans douter de la bonne foi de chacun, émet des doutes sur des réserves à posteriori, car ces mêmes problèmes peuvent se produire après le départ du transporteur.

Nous comptons sur votre vigilance, les assureurs, comme vous le savez, deviennent intransigeants en la matière.

11 - Conformités - Visites

Toutes ces machines sont livrées avec auto certification CE, conforme à la réglementation. Toute demande de vérification complémentaire par un organisme, entraîne le passage de la machine en nos locaux, et une facturation de l'ensemble de la prestation. Après livraison de la machine chez l'utilisateur, pour toute notification réclamant des protections complémentaires, le contrôle devra justifier précisément dans son rapport, la norme à laquelle il fait référence. Ces modifications seront à votre charge. Seul l'INRS, organisme d'état, pourrait homologuer, mais par volonté ministérielle, une grande partie de la machine est exclue