



POLYURETANOVÉ PRUŽINY

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STŘÍŽNÉ A DĚROVACÍ KOMPONENTY



PRUŽINY



VODÍCÍ A KLUZNÉ KOMPONENTY
PRO NÁSTROJE A FORMY



KOMPLETNÍ RÁMY
FOREM A NÁSTROJŮ



KOMPONENTY DLE NOREM
AUTOMOBILOVÉHO PRŮMYSLU



KLÍNOVÉ JEDNOTKY



ZÁVITOVACÍ JEDNOTKY



SPECIALIZOVANÉ KOMPONENTY
PRO LISOVACÍ NÁSTROJE



HYDRAULICKÉ VÁLCE



PODKLÁDACÍ PLECHY
A PLANŽETY



PODAVAČE PLECHŮ,
ROVNAČKY, ODVÍJEČKY



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POLYURETANOVÉ ELASTICKÉ PRUŽINY

Vyrábí se ve dvou různých provedeních. Registrované pod obchodními značkami ADIPOL a ULTRAFLEX, odlišené specifickými vlastnostmi a výkonem. ADIPOL nabízí špičkové vlastnosti v poměru k ceně - životnost přibližně 400 000 zdvihů. Ultraflex představuje špičkový produkt z hlediska pružné deformace - počet zdvihů 800 000 je snadno překonatelná hranice s touto pružinou.

SPECIFIKACE

Produkt v různých tvrdostech od 70 sh.A do 60 sh.D, s následujícími vlastnostmi.

TVRDOST / HARDNESS	ref.	u.m.	A70	A80	A90	A95	A60D
	ASTM2240	sh.a.	72	80	90	95	98
		sh.D				51	60
PEVNOST V TAHU / BREAKING STRENGTH	DIN 53504	Mpa	20	25	30	43	45
PRODLOUŽENÍ PŘI PŘETRŽENÍ / ELONGATION AT BREAK	DIN 53504	%	570	750	360	350	325
300% MODUL / 300% MODULE	DIN 53504	Mpa	5,5	5,5	17	30	37
ODOLNOST PROTI PŘETRŽENÍ / TEAR RESISTANCE	DIN 53515	KN/m	11	14	54	120	134
PEVNOST V TLAKU / COMPRESSION SET	DIN 53517	%	18	25	23	33	36
OTĚRUVZDORNOST / ABRASION	DIN 53516	mm3	40	50	56	64	76
ODRAŽENÍ / REBOUND		%	65	55	52	40	38
BARVA / COLOR			černá/black	modrá/blue	oranžová/orange	medová/honey	medová/honey
HUSTOTA / DENSITY		Mg/m3	1,15	1,16	1,17	1,18	1,2

ADIPOL

POLYURETHANE ELASTOMER SPRINGS

Made with two different base mixes, registered with ADIPOL and ULTRAFLEX trademarks, differentiated by particular features and performances. ADIPOL offers top pre-forming characteristics in relation to price - with an approximate duration of about 400 000 strokes before breakage. ULTRAFLEX represents our top product in terms of spring performance - the level of 800 000 strokes is easily surpassed with this spring.

SPECIFICATIONS

Product in different hardnesses from 70 sh.A to 60 sh.D, with the following specifications.

ULTRAFLEX

Produkt ve třech barevných provedeních a třech tvrdostech (82, 92 a 94 Sh.A), s následujícími vlastnostmi.

Three different colors, available in three versions (82, 92 and 94 Sh.A. hardness) with the following specifications.

TVRDOST / HARDNESS		ShA	82	92	94
PEVNOST V TAHU / BREAKING STRENGTH	DIN 53504	MPa	48	50	55
PRODLOUŽENÍ PŘI PŘETRŽENÍ / ELONGATION AT BREAK	DIN 53504	%	560	475	500
300% MODUL / 300% MODULE	DIN 53504	MPa	8,1	17,6	25
ODOLNOST PROTI PŘETRŽENÍ / TEAR RESISTANCE	DIN 53515	KN/m	86	89	120
PEVNOST V TLAKU / COMPRESSION SET	DIN 53517	%	25	18	19
OTĚRUVZDORNOST / ABRASION	DIN 53516	mm3	58	82	65
ODRAŽENÍ / REBOUND	AL/4E	%	43	39	45
BARVA / COLOR			žlutá / yellow	červená / red	zelená / green

Odolnost vůči chemickým látkám

Resistant to chemical agents

ADIPOL

Aceton Acetone	C	Petrolej Kerosine	C	Minerální olej Mineral oil	A
20% Kyselina octová 20% Acetic acid	B	Lepidlo Glue	A	SAE olej 70°C SAE oil 70°C	A
20% Kyselina chlorovodíková 20% Hydrochloric acid	C	Ethylenglykol Ethylene glycol	B	Kysličník uhelnatý Carbon monoxide	A
Kyselina mravenčí Formic acid	C	Fenol Phenol	C	Perchlorethylen Perchloroethylene	C
10% Kyselina dusičná 10% Nitric acid	C	Freon - 11 Freon - 11	B	Kyselina boritá sol. Boric acid sol.	A
Kyselina olejová Oleic acid	B	Freon -12 +54°C Freon -12 +54°C	A	Hydrogensířičitan vápenatý sol. Calcium bisulfite sol.	A
50-80% Kyselina sírová 50-80% Sulfuric acid	C	Freon -22 Freon -22	C	Chlorid hořečnatý sol. Magnesium chloride sol.	A
10% Kyselina tříslová 10% Tannic acid	A	Glycerol Glycerol	A	Chlorid měďnatý sol. Cupric chloride sol.	A
Kyselina vinná Tartaric acid	A	46% Hydrát sodný 46% Sodium hydrate	A	Fosforečnan sodný sol. Trisodium phosphate sol.	A
Voda 50°C Water 50°C	A	Vodík Hydrogen	A	Hydroxid amonný sol. Ammonium hydroxide sol.	A
Ethylalkohol Ethyl alcohol	C	Rtuť Mercury	A	Hydroxid vápenatý sol. Calcium hydroxide sol.	A
Methylalkohol Methyl alcohol	C	Methylethylketon Methyl ethyl ketone	C	Mýdlový roztok Soap sol.	A
Oxid uhličitý Carbon dioxide	A	Nafta Naphtha	B	Síran měďnatý sol. Cupric sulfate sol.	A
Benzín Gasoline	B	Hydraulické oleje Hydraulic oils	A	Tetrachlormethan Carbon tetrachloride	C
Benzol Benzol	C	Mazací oleje Lubricating oils	B	Toluen Toluol	C
Butan Butane	A	ASTM olej 70°C ASTM oil 70°C	A	Terpentýn Turpentine	C

A - Bez vlivu
 B - Minimální účinek
 C - Silný účinek

A - No effect
 B - Minimum effect
 C - Severe effect

Odolnost proti teplotě

Maximální provozní teplota je 80°C. Vezměte v úvahu, že mechanické parametry se při těchto podmínkách snižují o 65%. Vystavení teplotám až 120°C je však na krátkou dobu povoleno.

Resistance to heat

The maximum operating temperature is 80°C. Consider that the mechanical specifications decrease by 65% under those conditions. However, exposure to temperatures of up to 120°C is permitted for brief periods.

Odolnost proti chladu

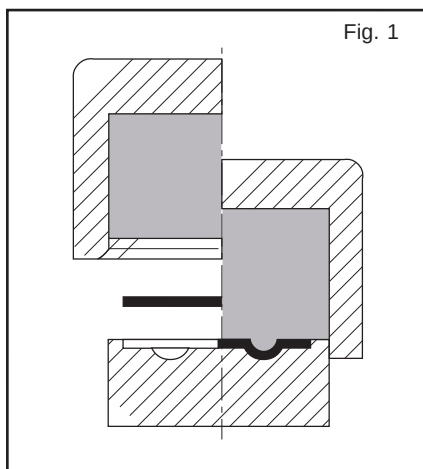
Základní složení polyuretanu ADIPOL odolává teplotě -40°C. Doporučená minimální hranice pro polyuretan ULTRAFLEX je +10°C.

Cold resistance

The base mix in ADIPOL withstands -40°C. The advisable limit for the ULTRAFLEX range is +10°C.

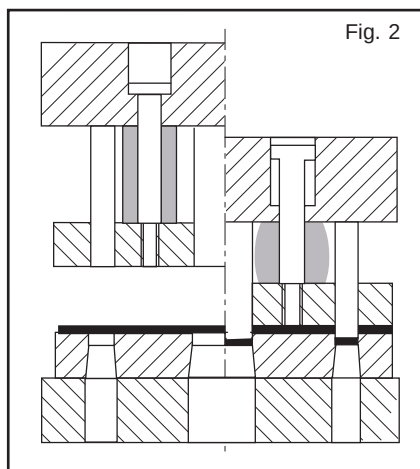
Tvarování plechů - aplikace pro naše polyuretany

Sheet forming - applications for our polyurethanes



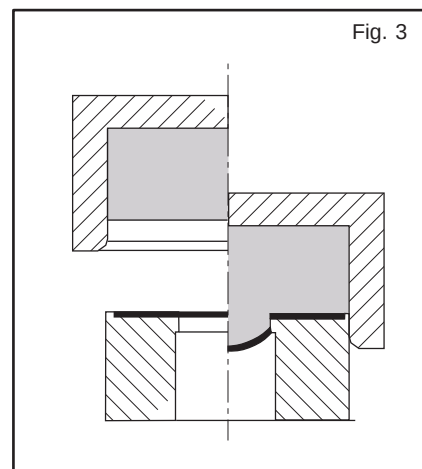
Aplikace využití ULTRAFLEXU s tvarovou maticí. Zatížení musí být uvnitř ocelové matrice. Doporučuje se používat pomalé lisy s odpovídající tonáží s ohledem na rozměry dílu.

Drawing with ULTRAFLEX matrix. The load must be contained inside a solid structure made of steel. It is advisable to use slow presses and good tonnage with respect to the dimensions of the piece.



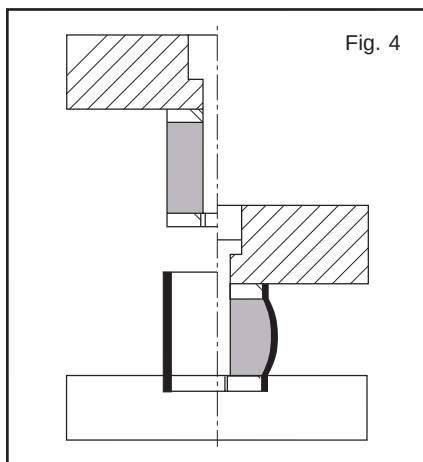
Použití polyuretanů ADIPOL a ULTRAFLEX jako pružiny nebo jako odlepovače polotovarů a průstřihů.

Applications of ADIPOL and ULTRAFLEX springs as blank holders and knockouts.



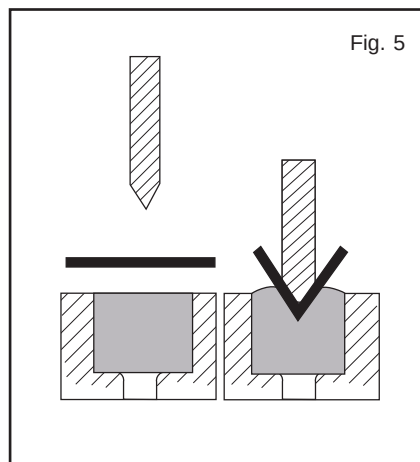
Perforace otvoru polyuretanovým blokem ADIPOL.

Perforation of a hole with the ADIPOL pad.



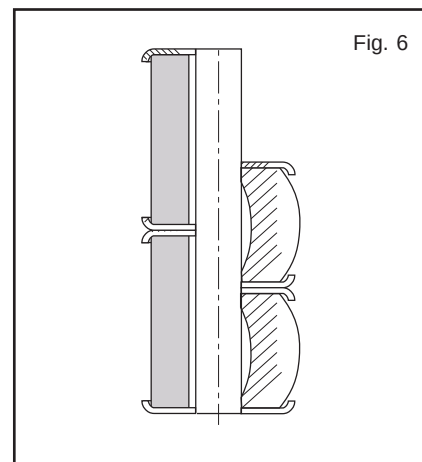
Příklad vydutí, široce používané při výrobě hrnců a pánví.

Example of belling, and application widely used in the manufacturing of pots and pans.



Příklad ohybu deskového profilu (vhodné zejména v případě, že povrch plechu nesmí být poničen). Materiály: měď, hliník, nerez ocel, atd.

Example of bending of the plate profile (particularly advisable when the sheet surface must not be ruined: copper, aluminum, stainless steel, etc.)

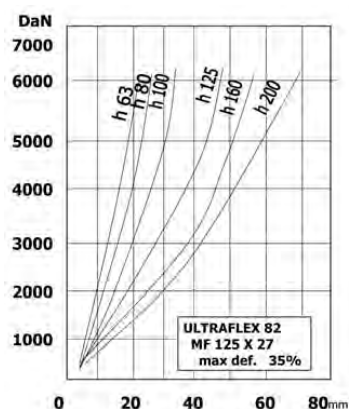
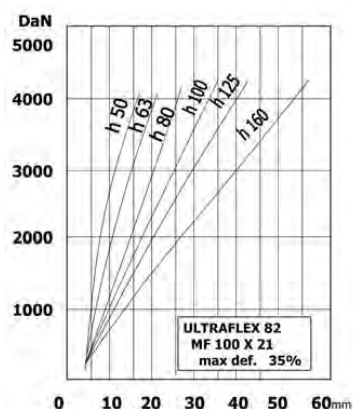
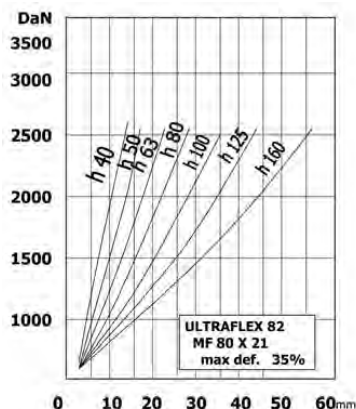
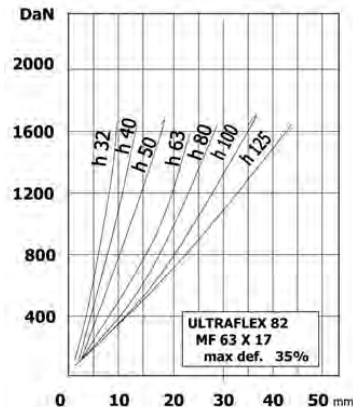
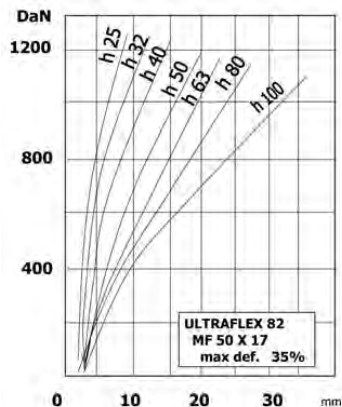
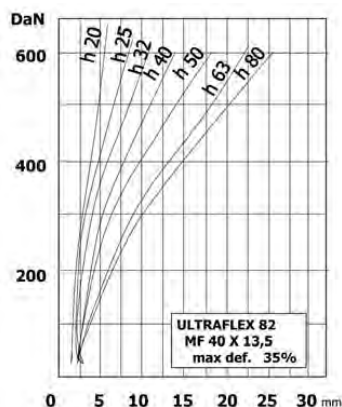
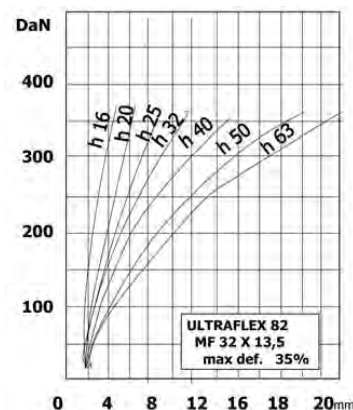
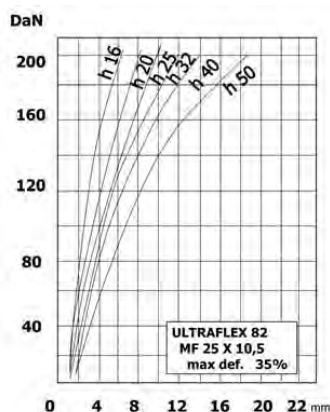
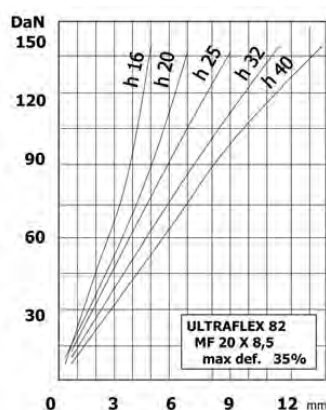
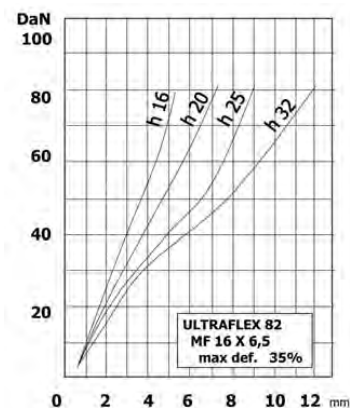


Sestava s dělenými pružinami a kovovými podložkami. ADIPOL a ULTRAFLEX.

Sequence assembly of ADIPOL and ULTRAFLEX springs with partitioned metal seats.

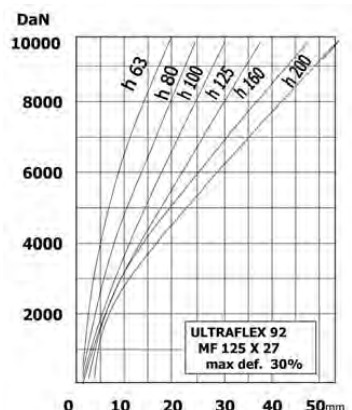
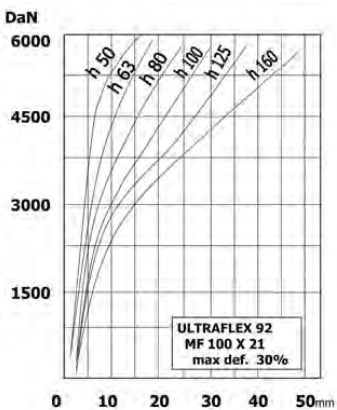
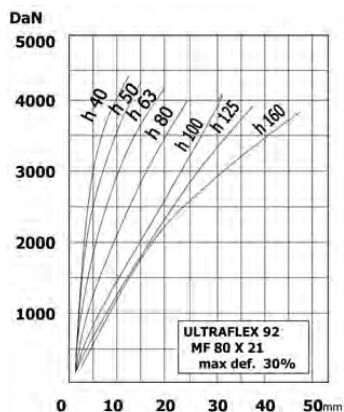
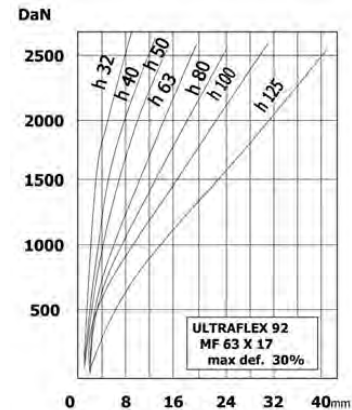
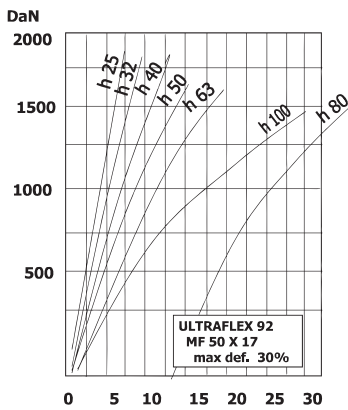
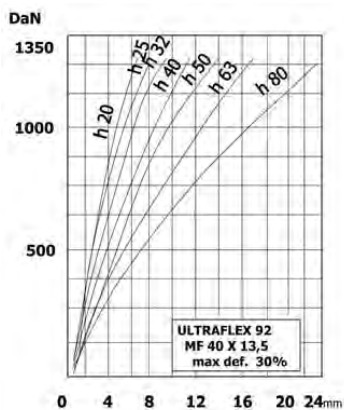
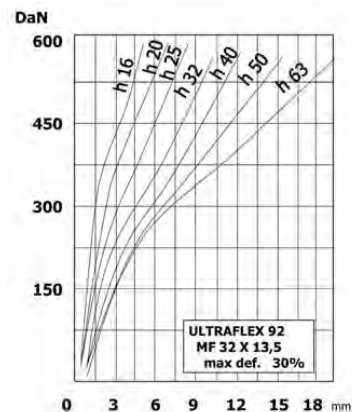
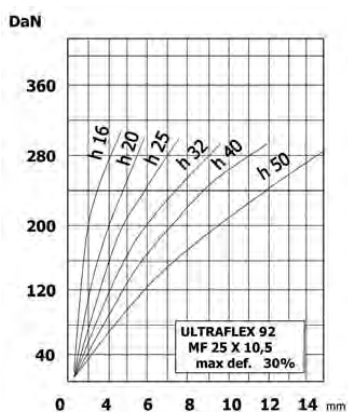
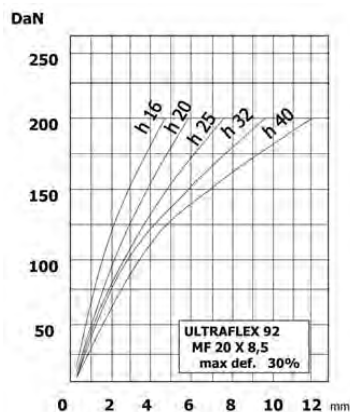
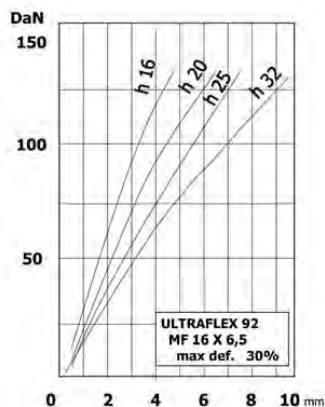
Zátěžová charakteristika pružin Ultraflex 82

Ultraflex 82 springs load curves



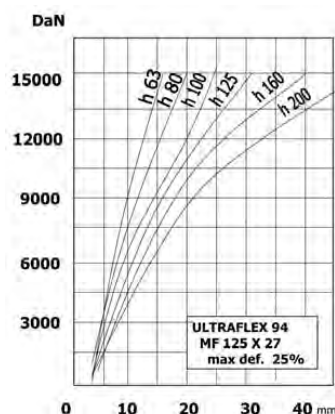
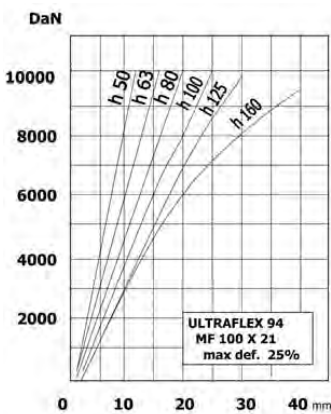
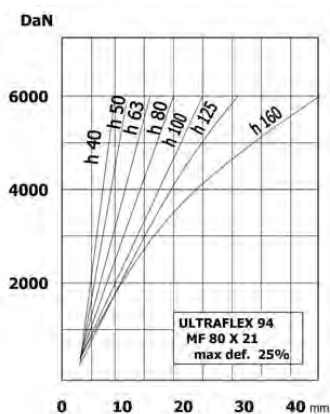
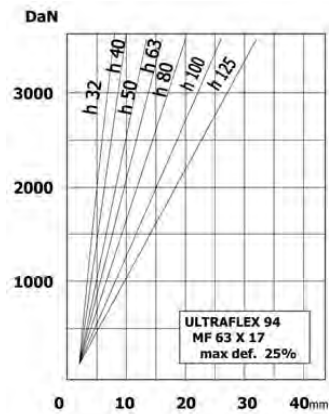
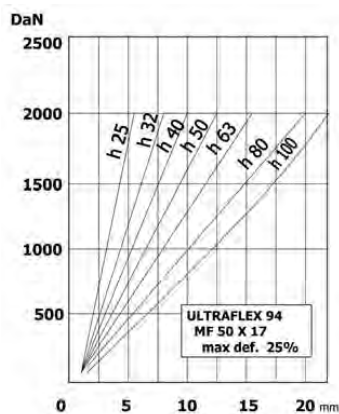
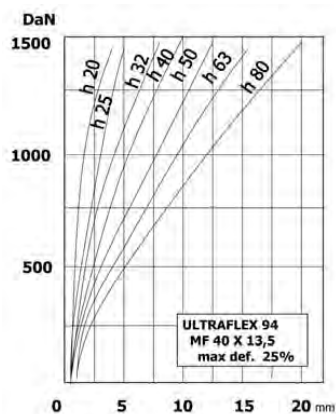
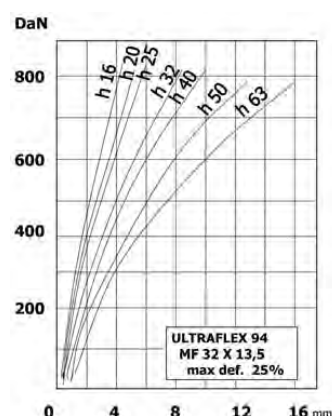
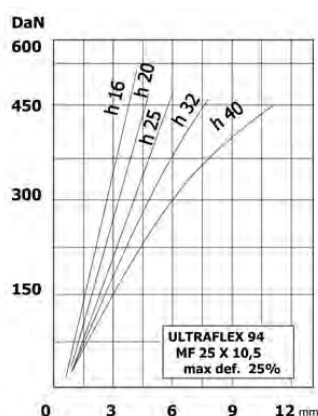
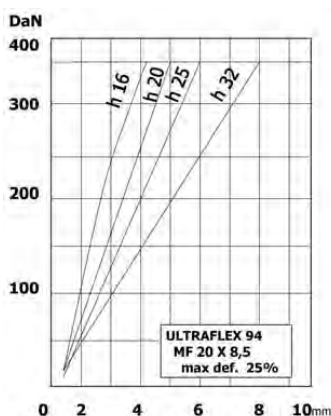
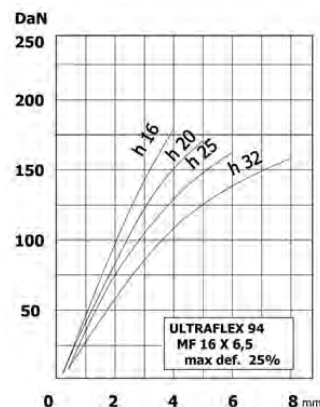
Zátěžová charakteristika pružin Ultraflex 92

Ultraflex 92 springs load curves



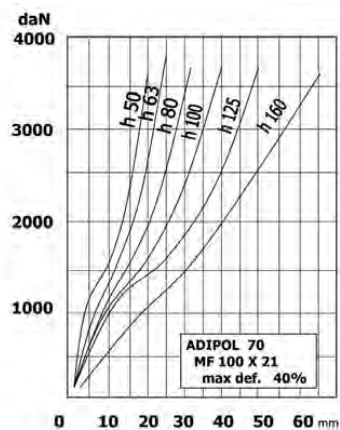
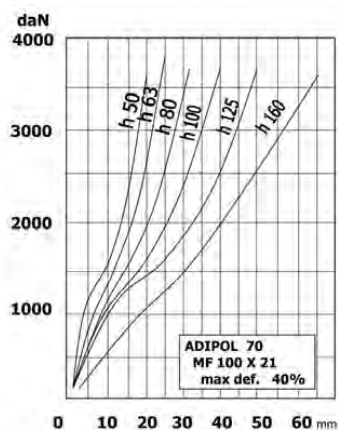
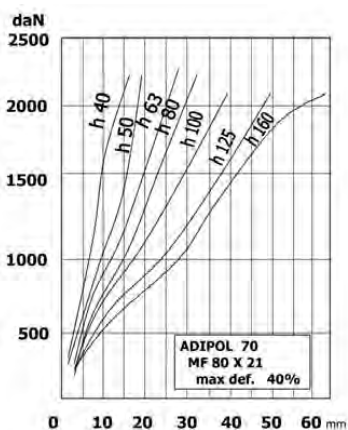
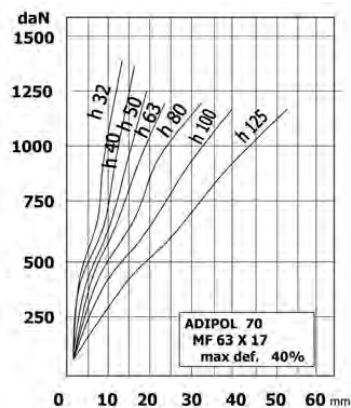
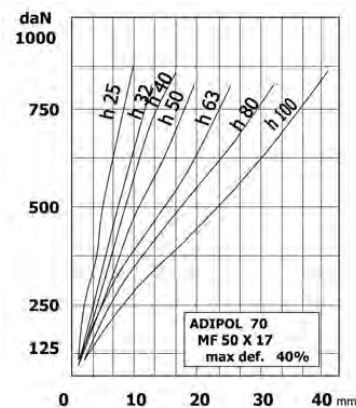
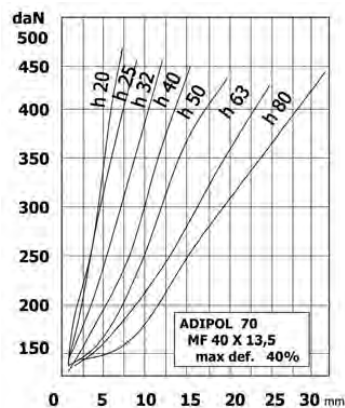
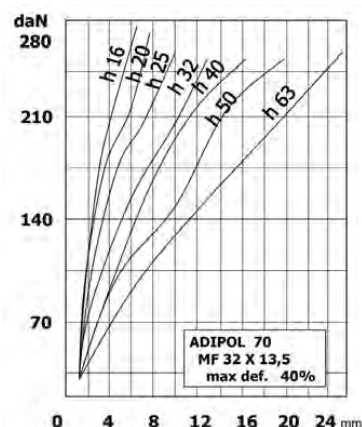
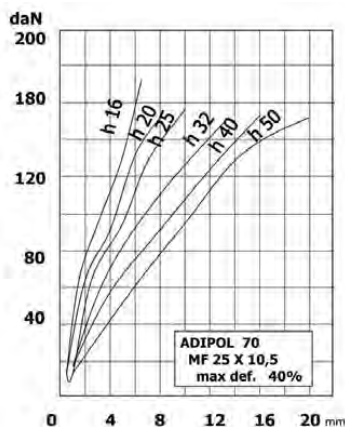
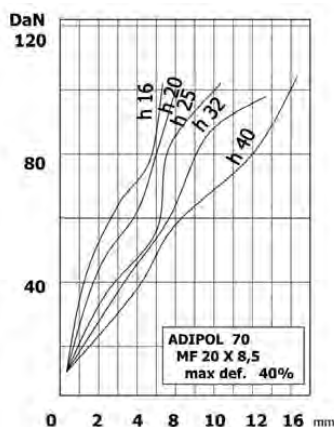
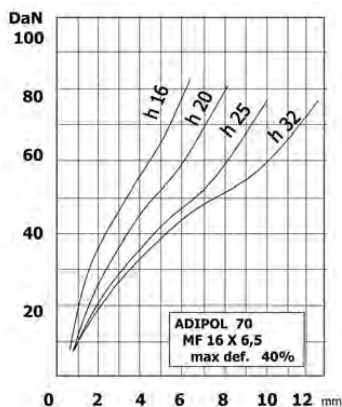
Zátěžová charakteristika pružin Ultraflex 94

Ultraflex 94 springs load curves



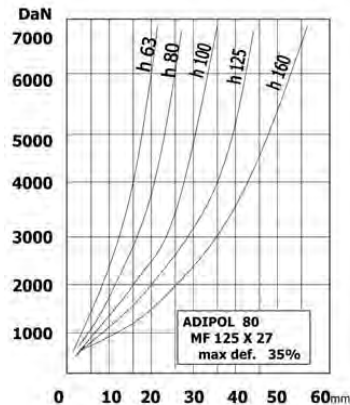
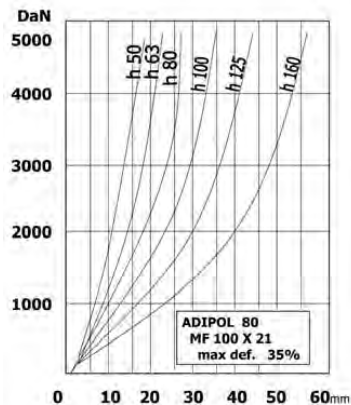
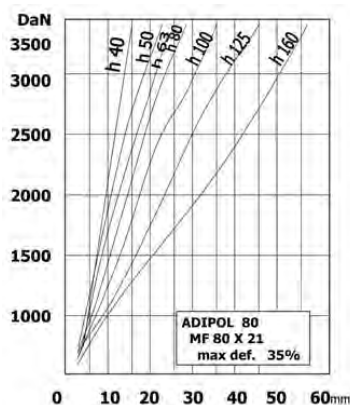
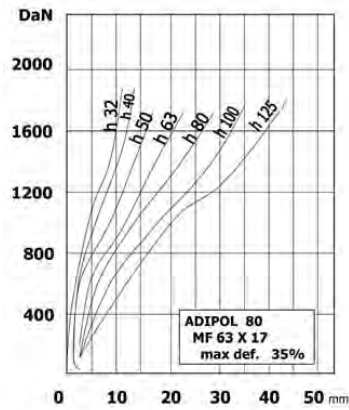
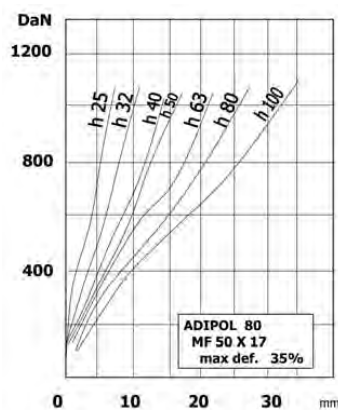
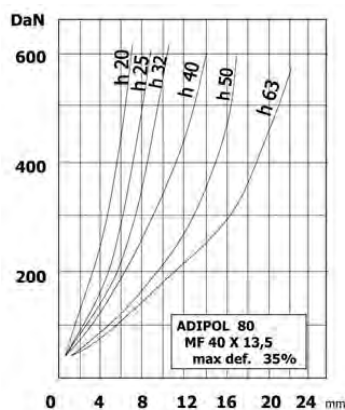
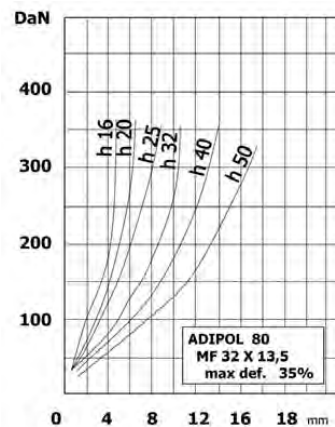
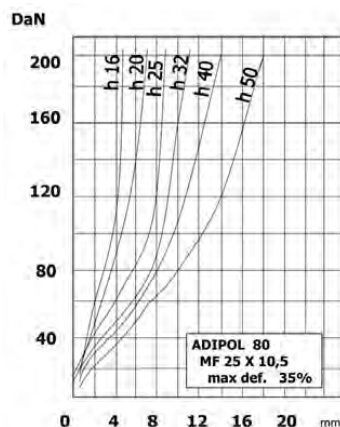
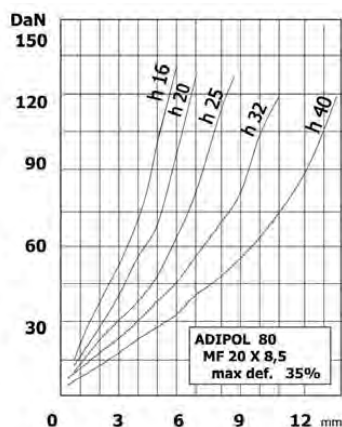
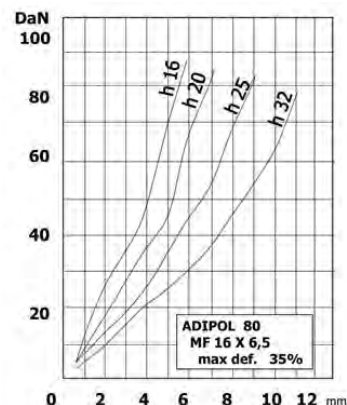
Zátěžová charakteristika pružin Adipol 70

Adipol 70 springs load curves



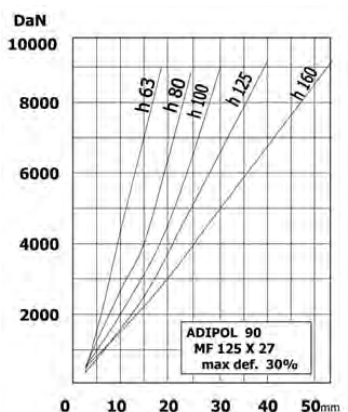
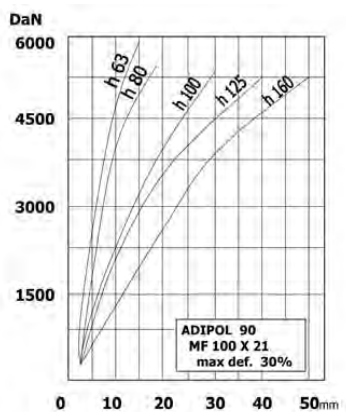
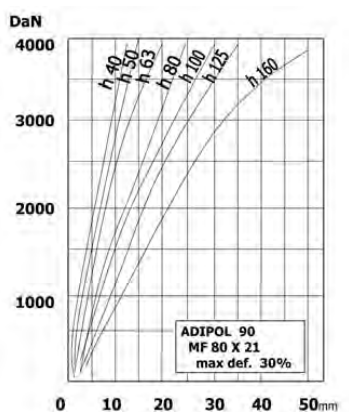
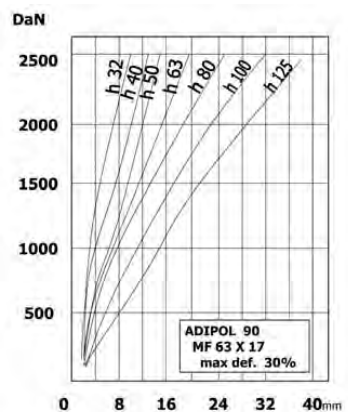
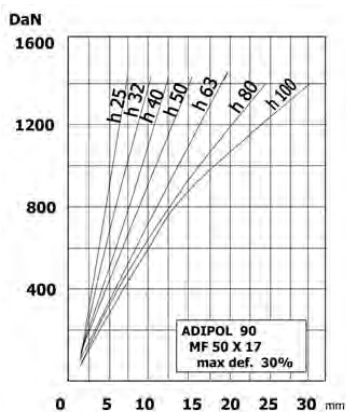
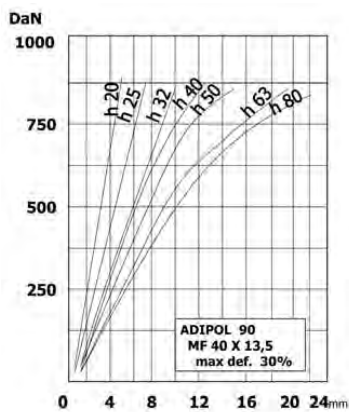
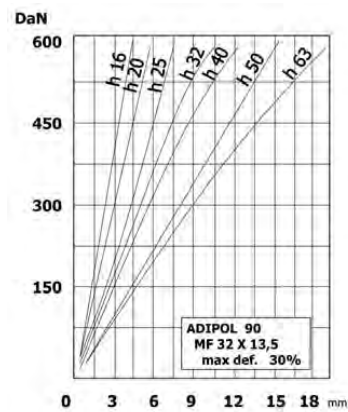
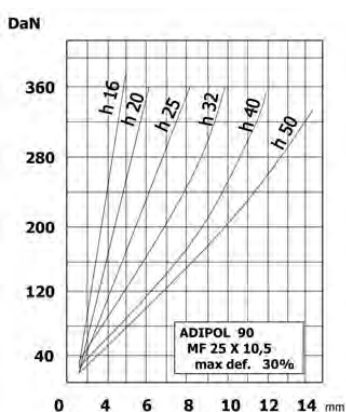
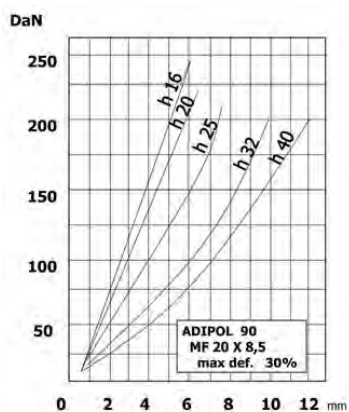
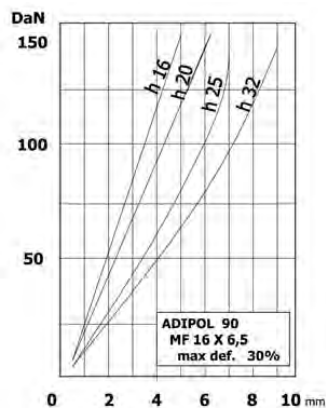
Zátěžová charakteristika pružin Adipol 80

Adipol 80 springs load curves



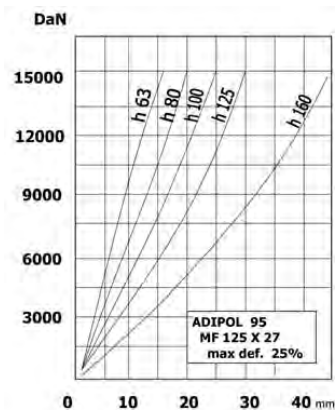
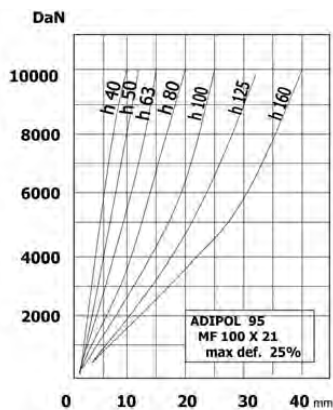
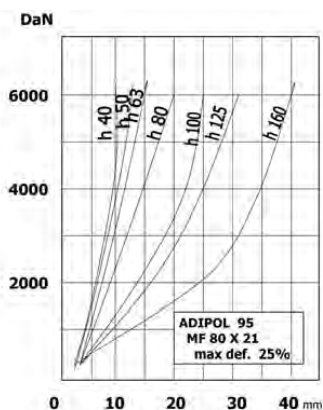
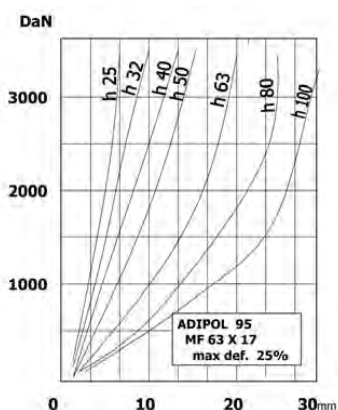
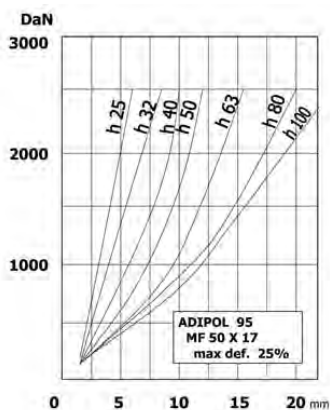
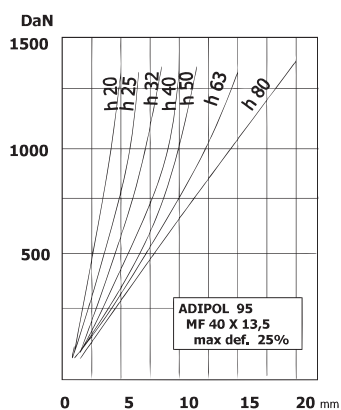
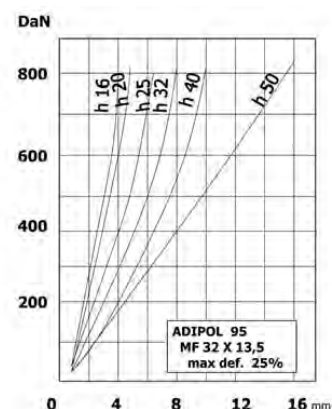
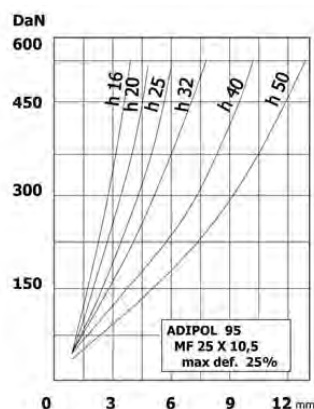
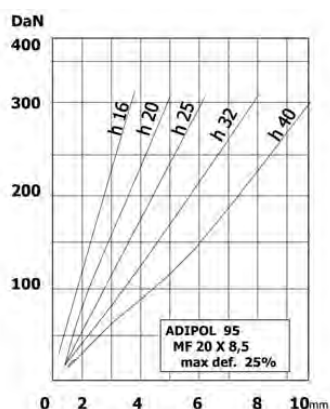
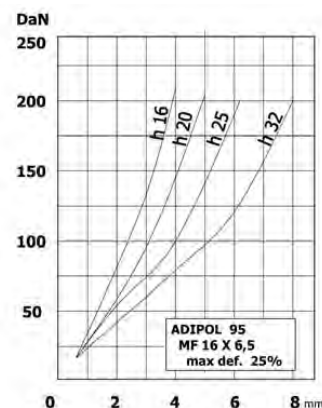
Zátěžová charakteristika pružin Adipol 90

Adipol 90 springs load curves



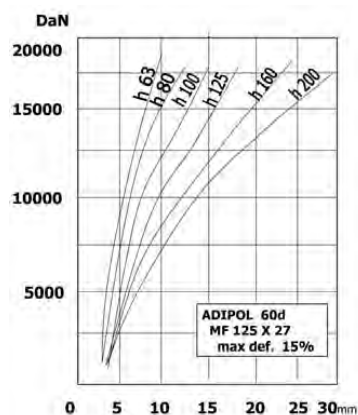
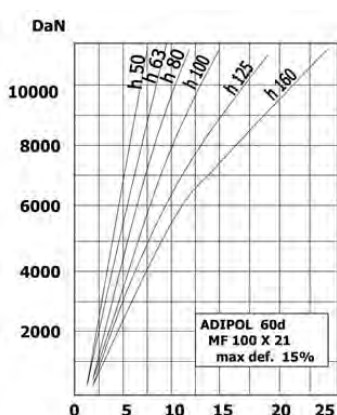
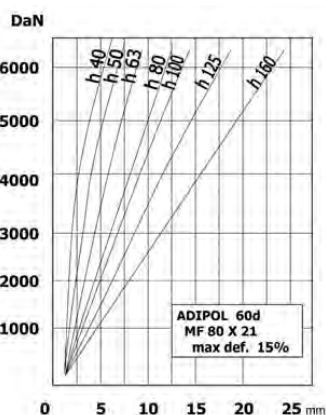
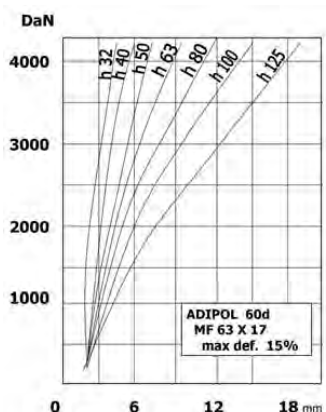
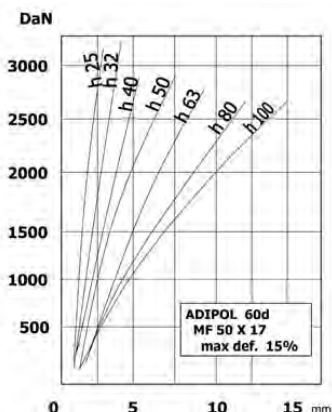
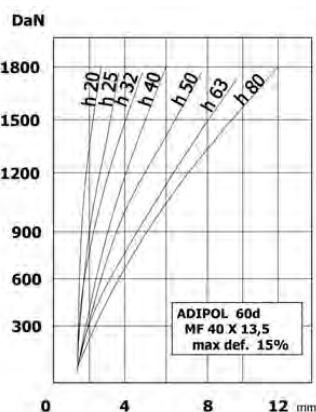
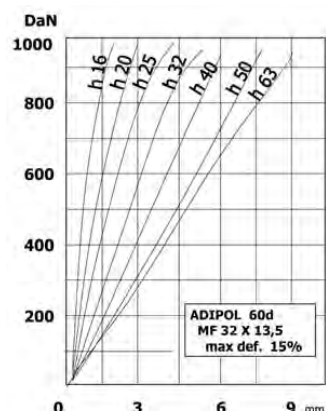
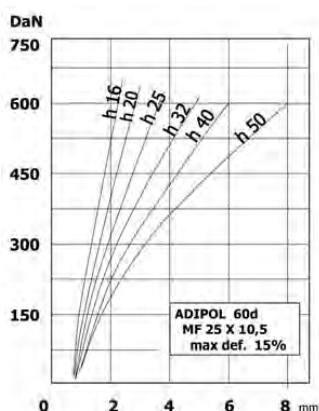
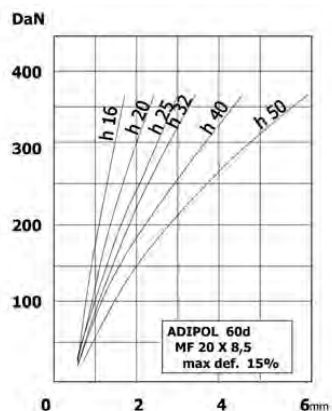
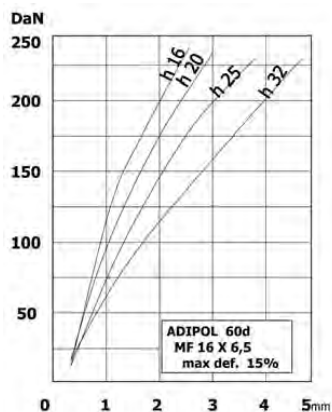
Zátěžová charakteristika pružin Adipol 95

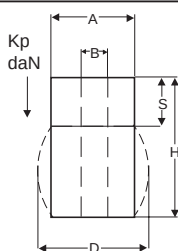
Adipol 95 springs load curves



Zátěžová charakteristika pružin Adipol 60d

Adipol 60d springs load curves



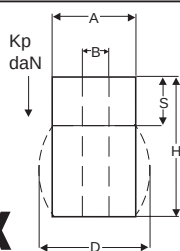


Pružiny s otvorem pro nástroje

Hollow springs for dies

ADIPOL

max. stlač. 40% ADIPOL 70 černá / black							max. stlač. 35% ADIPOL 80 modrá / blue			max. stlač. 30% ADIPOL 90 oranžová / orange			max. stlač. 25% ADIPOL 95 medová / honey			max. defl. 15% ADIPOL 60/d medová / honey		
KÓD / CODE	A mm	B mm	H mm	S mm	D mm	Kp daN	S mm	D mm	Kp daN	S mm	D mm	Kp mm	S mm	D mm	Kp mm	S mm	D mm	Kp mm
MF 16 x 16	16	6,5	16	6,4	22	60	5,6	22	100	4,8	21	140	4	20	200	2,4	18	240
MF 16 x 20	16	6,5	20	8			7			6			5			3		
MF 16 x 25	16	6,5	25	10			9			8			6			3,7		
MF 16 x 32	16	6,5	32	12,8			11			9,6			8			4,8		
MF 20 x 16	20	9	16	6,4	27	100	6	27	1250	5	27	150	4	25	250	2,4	23	360
MF 20 x 20	20	9	20	8			7			6			5			3		
MF 20 x 25	20	9	25	10			9			8			6			3,7		
MF 20 x 32	20	9	32	12,8			11			10			9			4,8		
MF 20 x 40	20	9	40	16			14			12			10			6,0		
MF 25 x 16	25	11	16	6,4	34	125	6	34	250	5	33	400	4	31	500	2,4	29	590
MF 25 x 20	25	11	20	8			7			6			5			3		
MF 25 x 25	25	11	25	10			9			8			6,2			3,7		
MF 25 x 32	25	11	32	12,8			11			10			8			4,8		
MF 25 x 41	25	11	40	16			14			12			10			6,0		
MF 25 x 50	25	11	50	20			18			15			13			7,5		
MF 32 x 16	32	14	16	6,4	43	240	6	43	400	5	42	580	4	40	810	2,4	37	980
MF 32 x 20	32	14	20	8			7			6			5			3,0		
MF 32 x 25	32	14	25	10			9			8			6			3,7		
MF 32 x 32	32	14	32	12,8			11			10			8			4,8		
MF 32 x 40	32	14	40	16			14			12			10			6,0		
MF 32 x 50	32	14	50	20			18			15			12,5			7,5		
MF 32 x 63	32	14	63	25,2			22			18,9			16			9,4		
MF 40 x 20	40	14	20	8	54	450	7	54	700	6	52	900	5	50	1400	3,0	46	1700
MF 40 x 25	40	14	25	10			9			8			6			3,7		
MF 40 x 32	40	14	32	12,8			11			10			8			4,8		
MF 40 x 40	40	14	40	16			14			12			10			6,0		
MF 40 x 50	40	14	50	20			18			15			13			7,5		
MF 40 x 63	40	14	63	25,2			22			18,9			16			9,4		
MF 40 x 80	40	14	80	32			28			24			20			12		
MF 50 x 25	50	17	25	10	68	900	9	68	1200	8	65	1800	6	62	2200	3,7	57	2600
MF 50 x 32	50	17	32	12,8			11			10			8			4,8		
MF 50 x 40	50	17	40	16			14			12			10			6,0		
MF 50 x 50	50	17	50	20			18			15			13			7,5		
MF 50 x 63	50	17	63	25,2			22			18,9			16			9,4		
MF 50 x 80	50	17	80	32			28			24			20			12,0		
MF 50 x 100	50	17	100	40			35			30			25			15,0		
MF 63 x 32	63	17	32	12,8	85	1100	3	85	1850	10	76	2500	8	78	3600	4,8	72	4300
MF 63 x 40	63	17	40	16			14			12			10			6,0		
MF 63 x 50	63	17	50	20			18			15			13			7,5		
MF 63 x 63	63	17	63	25,2			22			18,9			16			9,4		
MF 63 x 80	63	17	80	32			28			24			20			12,0		
MF 63 x 100	63	17	100	40			35			30			25			15,0		
MF 63 x 125	63	17	125	50			43,7			37,5			31,2			18,7		
MF 80 x 40	80	21	40	16	108	1900	14	108	2800	12	104	4000	10	99	6000	6,0	91	7000
MF 80 x 50	80	21	50	20			18			15			13			7,5		
MF 80 x 63	80	21	63	25,2			22			18,9			16			9,4		
MF 80 x 80	80	21	80	32			28			24			20			12,0		
MF 80 x 100	80	21	100	40			35			30			25			15,0		
MF 80 x 125	80	21	125	50			43,7			37,5			31,2			18,7		
MF 80 x 160	80	21	160	64			56			48			40			24,0		
MF 100 x 50	100	27	50	20	126	3300	18	135	4600	20	130	5600	13	124	10000	7,5	114	12000
MF 100 x 63	100	27	63	25,2			22			18,9			16			9,4		
MF 100 x 80	100	27	80	32			26			24			20			12,0		
MF 100 x 100	100	27	100	40			35			30			25			15,0		
MF 100 x 125	100	27	125	50			43,7			37,5			31,2			18,7		
MF 100 x 160	100	27	160	64			56			48			40			24,0		
MF 125 x 63	125	27	63	25,2	160	5500	22	160	7000	18,9	163	9000	16	155	15000	9,4	143	18000
MF 125 x 80	125	27	80	32			28			24			20			12,0		
MF 125 x 100	125	27	100	40			35			30			25			15,0		
MF 125 x 125	125	27	125	50			43,7			37,5			31,2			18,7		
MF 125 x 160	125	27	160	64			56			48			40			24,0		
MF 125 x 200	125	27	200	80			70			60			50			30,0		



Pružiny s otvorem pro nástroje

Hollow springs for dies

ULTRAFLEX

max. stlač. 35%
ULTRAFLEX 82
žlutá / yellow

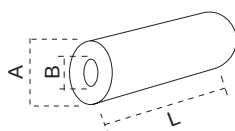
max. stlač. 30%
ULTRAFLEX 92
červená / red

max. stlač. 25%
ULTRAFLEX 94
zelená / green

KÓD / CODE	A mm	B mm	H mm	S mm	D mm	Kp daN	S mm	D mm	Kp daN	S mm	D mm	Kp daN
MF 16 x 16	16	6,5	16	5,6	22	80	4,8	19	130	4,0	19	160
MF 16 x 20	16	6,5	20	7			6			5		
MF 16 x 25	16	6,5	25	9			8			6		
MF 16 x 32	16	6,5	32	11,2			10			8,0		
MF 20 x 16	20	9	16	6	28	150	5	26	200	4	25	325
MF 20 x 20	20	9	20	7			6			5		
MF 20 x 25	20	9	25	9			8			6		
MF 20 x 32	20	9	32	11,2			10			8		
MF 20 x 40	20	9	40	14	33	210	12	30	300	10	29	450
MF 25 x 16	25	11	16	6			5			4		
MF 25 x 20	25	11	20	7			6			5		
MF 25 x 25	25	11	25	9			8			6		
MF 25 x 32	25	11	32	11	43	360	10	41	580	8	38	800
MF 25 x 41	25	11	40	14			12			10		
MF 25 x 50	25	11	50	17,5			15			13		
MF 32 x 16	32	14	16	6			5			4		
MF 32 x 20	32	14	20	7	54	650	6	50	1200	5	47	1500
MF 32 x 25	32	14	25	9			8			6		
MF 32 x 32	32	14	32	11			10			8		
MF 32 x 40	32	14	40	14			12			10		
MF 32 x 50	32	14	50	18	65	1100	15	62	1700	13	60	2000
MF 32 x 63	32	14	63	22			19			16		
MF 40 x 20	40	14	20	7			24			20		
MF 40 x 25	40	14	25	9			8			6		
MF 40 x 32	40	14	32	11	81	1600	10	78	2500	8	74	3500
MF 40 x 40	40	14	40	14			12			10		
MF 40 x 50	40	14	50	18			15			13		
MF 40 x 63	40	14	63	22			19			16		
MF 40 x 80	40	14	80	28	103	2600	24	98	4300	20	95	6000
MF 50 x 25	50	17	25	9			30			25		
MF 50 x 32	50	17	32	11			38			31		
MF 50 x 40	50	17	40	14			48			40		
MF 50 x 50	50	17	50	18	126	4300	12	120	6500	10	120	10000
MF 50 x 63	50	17	63	22			15			13		
MF 50 x 80	50	17	80	28			19			16		
MF 50 x 100	50	17	100	35			24			20		
MF 63 x 32	63	17	32	11	160	6400	30	152	10500	25	150	15000
MF 63 x 40	63	17	40	14			38			31		
MF 63 x 50	63	17	50	18			48			40		
MF 63 x 63	63	17	63	22			60			50		
MF 63 x 80	63	17	80	28	160	6400	19	152	10500	15,7	150	15000
MF 63 x 100	63	17	100	35			24			20		
MF 63 x 125	63	17	125	44			30			25		
MF 80 x 40	80	21	40	14			37,5			31,2		
MF 80 x 50	80	21	50	18	160	6400	48	152	10500	40	150	15000
MF 80 x 63	80	21	63	22			60			50		
MF 80 x 80	80	21	80	28								
MF 80 x 100	80	21	100	35								
MF 80 x 125	80	21	125	44	160	6400						
MF 80 x 160	80	21	160	56								
MF 100 x 50	100	27	50	18								
MF 100 x 63	100	27	63	22								
MF 100 x 80	100	27	80	28								
MF 100 x 100	100	27	100	35								
MF 100 x 125	100	27	125	44								
MF 100 x 160	100	27	160	56								
MF 125 x 63	125	27	63	22	160	6400						
MF 125 x 80	125	27	80	28								
MF 125 x 100	125	27	100	35								
MF 125 x 125	125	27	125	43,7								
MF 125 x 160	125	27	160	56								
MF 125 x 200	125	27	200	70								

Tyče s otvorem

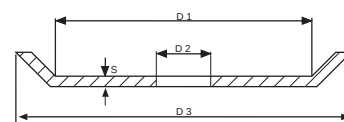
Hollow bars for dies



Kód	A mm.	B mm.	L mm.
BF-16	16	6,5	250
BF-20	20	8,5	250
BF-25	25	10,5	250
BF-32	32	13,5	500
BF-40	40	13,5	500
BF-50	50	17	500
BF-63	63	17	500
BF-80	80	21	500
BF-100	100	21	500
BF-125	125	27	500

Taliřové podložky

Metal seats



Kód	D mm.	D1 mm.	D2 mm.	D3 mm.	s mm.
000-SE-16	16	17	6,5	22	1,2
000-SE-20	20	21	8,5	27	1,2
000-SE-25	25	26	10,5	31	1,8
000-SE-32	32	34	13,5	42	2
000-SE-40	40	42	13,5	52	2
000-SE-50	50	52	17	64	2
000-SE-63	63	65	17	77	2
000-SE-80	80	82	20,5	95	2,5
000-SE-100	100	103	20,5	118	2,5

Odlepovače

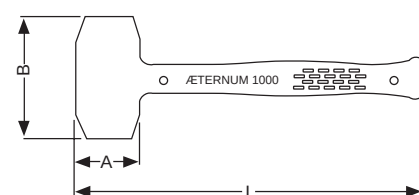
Push-rods



Kód	mm. D	mm. H
U92-PU-2X15	2	15
U92-PU-3X15	3	15
U92-PU-4,5X15	4,5	15
U92-PU-6X15	6	20

Polyuretanové kladívko

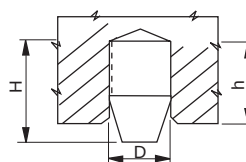
Mallets



Kód	Peso gr.	A mm.	B mm.	L mm.
U92-MZ-600	600	50	100	270
U92-MZ-1000	1000	60	115	300
U92-MZ-1500	1500	65	130	350

Odlepovače s kónickým tvarem

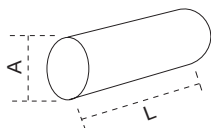
Cone-shaped push-rods



Kód	mm. D	mm. H	mm. h
U92-PU-6X10	6	10	8
U92-PU-10X15	10,3	15	13
U92-PU-16X25	16,4	25	21
U92-PU-24X25	24,7	25	20
U92-PU-40X40	40,8	40	35

Tyče plné
délka 250 mm±5

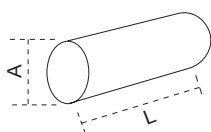
Solid bars
length 250mm±5



Kód Code	A
BP-8	8
BP-10	10
BP-12	12
BP-15	15
BP-16	16
BP-20	20
BP-25	25

Tyče plné
délka 500 mm±5

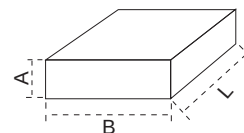
Solid bars
length 500 mm±5



Kód Code	A
BP-28	28
BP-30	30
BP-32	32
BP-35	35
BP-40	40
BP-45	45
BP-50	50
BP-60	60
BP-63	63
BP-70	70
BP-80	80
BP-90	90
BP-100	100
BP-110	110
BP-125	125
BP-140	140
BP-150	150
BP-160	160
BP-200	200

Pásky
délka 1000 mm±5

Strips
length 1000 mm±5



Kód Code	A	B
LI-10X10	10	10
LI-10X20	10	20
LI-10X30	10	30
LI-10X50	10	50
LI-10X100	10	100
LI-15X15	15	15
LI-15X30	15	30
LI-15X50	15	50
LI-15X100	15	100
LI-20X20	20	20
LI-20X30	20	30
LI-20X50	20	50
LI-20X100	20	100
LI-25X25	25	25
LI-25X50	25	50
LI-25X100	25	100
LI-30X30	30	30
LI-30X50	30	50
LI-30X100	30	100
LI-40X40	40	40
LI-40X50	40	50
LI-40X100	40	100
LI-50X50	50	50
LI-50X100	50	100
LI-60X60	60	60
LI-80X80	80	80
LI-100X100	100	100

NÁSTROJ-NŮŽ / TOOLING



ŘEZÁNÍ provádí se bez odřezků s HSS nástroji naostřenými (hrot R=5-10)

SOUSTRUŽENÍ radiální nástroj HSS s úhlem záběru 12-15°. Doporučuje se dokončit soustružení pomocí diamantu. Rychlost: 100 m/min

VRTÁNÍ s dobře nabroušeným vrtákem. Povrchová rychlost: 60 m/minutu

BROUŠENÍ použijte korundové brusné kotouče, průměrná tvrdost, hrubá struktura. Rychlost: 40 m/min.

CUT performed without off-cuts with HSS tools with lance sharpening (point R=5-10)

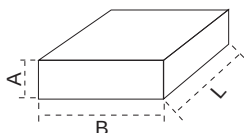
TURNING HSS radial tool with rake of 12-15°. It is advisable to finish the cutting point with a jewel. Speed: 100 m/minute

DRILLING with a well-sharpened bit. Surface speed: 60 m/minute

GRINDING use corundum grinders, average hardness, coarse texture. Speed: 40 m/minute.

DESKY

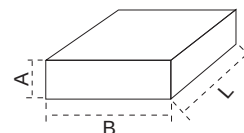
SLABS



Kód Code	A	B	L
LA-10X1000X1000	10	1000	1000
LA-12X1000X1000	12	1000	1000
LA-15X1000X1000	15	1000	1000
LA-20X1000X1000	20	1000	1000
LA-25X1000X1000	25	1000	1000
LA-30X1000X1000	30	1000	1000
LA-35X1000X1000	35	1000	1000
LA-40X1000X1000	40	1000	1000
LA-45X1000X1000	45	1000	1000
LA-50X1000X1000	50	1000	1000
LA-12X500X1000	12	500	1000
LA-15X500X1000	15	500	1000
LA-20X500X1000	20	500	1000
LA-25X500X1000	25	500	1000
LA-30X500X1000	30	500	1000
LA-40X500X1000	40	500	1000
LA-45X500X1000	45	500	1000
LA-50X500X1000	50	500	1000
LA-10X500X500	12	500	500
LA-10X500X500	15	500	500
LA-10X500X500	20	500	500
LA-10X500X500	25	500	500
LA-10X500X500	30	500	500
LA-10X500X500	40	500	500
LA-10X500X500	45	500	500
LA-10X500X500	50	500	500

ODSTŘEDĚNÉ DESKY

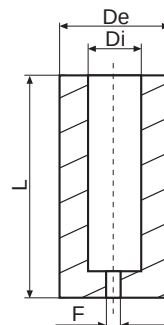
CENTRIFUGED SLABS



Kód Code	A	B	L
LA-1X500X2000	1	500	2000
LA-2X500X2000	2	500	2000
LA-3X500X2000	3	500	2000
LA-4X500X2000	4	500	2000
LA-5X500X2000	5	500	2000
LA-6X500X2000	6	500	2000
LA-8X500X2000	8	500	2000
LA-10X500X2000	10	500	2000

Stěrače pro střížníky do nástrojů / Knockouts for punching presses

Kód Code	Di	De	L	F
U92-ES-5	5	18	55	1,5
U92-ES-6	6	19	65	1,5
U92-ES-8	8	21	75	1,5
U92-ES-10	10	23	75	2,5
U92-ES-13	13	26	75	3
U92-ES-16	16	30	75	3
U92-ES-20	20	38	75	3
U92-ES-25	25	50	75	3

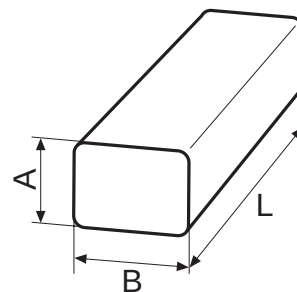


Hranoly pro tváření / Pad for forming press

Pevné hranoly / Solid pads

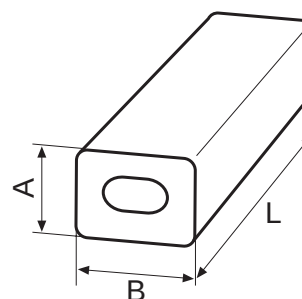
L = 835 mm

Kód Code	A	B
U92-LI-25x25x835	25	25
U92-LI-50x50x835	50	50
U92-LI-50x75x835	50	75
U92-LI-50x100x835	50	100



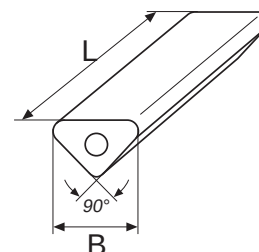
Pevné hranoly s otvorem / Solid pads L = 835 mm

Kód Code	A	B	SLOT/SLOT
U92-LF-25x25x835	25	25	día. 10
U92-LF-50x50x835	50	50	día. 25
U92-LF-50x75x835	50	75	20x45
U92-LF-50x100x835	50	100	20x60



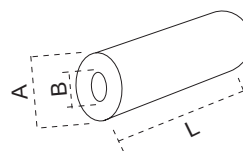
Trojúhelníková tyč / Triangular pad L = 835 mm

Kód Code	B	SLOT/SLOT
U92-LT-35x50x835	50	día. 10



Tyče s otvorem / Sleeves

Tyče L = 250 mm / Sleeves L = 250 mm



Kód Code	A	B
MA-11x7	11	7
MA-12x6,5	12	6,5
MA-13x5	13	5
MA-13x6,5	13	6,5
MA-13x8	13	8
MA-15x7	15	7
MA-16x9	16	9
MA-16x10	16	10
MA-16x11	16	11
MA-16x12	16	12
MA-18x6	18	6
MA-18x8	18	8
MA-18x11	18	11
MA-18x12	18	12
MA-19x5	19	5
MA-20x9	20	9
MA-20x10,5	20	10,5
MA-20x12	20	12
MA-20x14	20	14
MA-20x15	20	15
MA-21x8	21	8
MA-21x11	21	11
MA-21x12	21	12
MA-23,5x10,5	23,5	10
MA-23,5x15	23,5	15
MA-23,5x18	23,5	18
MA-24x11	24	11
MA-25x8,5	25	8,5
MA-25x12	25	12
MA-25x14	25	14
MA-25x15	25	15
MA-25x16,5	25	16,5
MA-25x19	25	19
MA-30,5x10,5	30,5	10,5

**Tyče L = 500 mm
Sleeves L = 500 mm**

Kód Code	A	B
MA-28x11	28	11
MA-28x15	28	15
MA-28x20	28	20
MA-28x22	28	22
MA-30x11	30	11

Kód Code	A	B
MA-30x15	30	15
MA-30x17	30	17
MA-30x20	30	20
MA-30x23	30	23
MA-30x24	30	24
MA-30x25	30	25
MA-32x10,5	32	10,5
MA-32x15	32	15
MA-32x16	32	16
MA-32x18	32	18
MA-32x20	32	20
MA-32x23	32	23
MA-32x24	32	24
MA-32x25	32	25
MA-35x11	35	11
MA-35x13,5	35	13,5
MA-35x15	35	15
MA-35x18	35	18
MA-35x20	35	20
MA-35x23	35	23
MA-35x24	35	24
MA-35x25	35	25
MA-35x26	35	26
MA-35x27	35	27
MA-35x28	35	28
MA-35x30	35	30
MA-37x14	37	14
MA-37x16	37	16
MA-37x17	37	17
MA-37x30	37	30
MA-38x10,5	38	10,5
MA-38x13,5	38	13,5
MA-38x15	38	15
MA-38x17	38	17
MA-38x20	38	20
MA-38x25	38	25
MA-38x28	38	28
MA-38x30	38	30
MA-40x11,5	40	11,5
MA-40x15	40	15
MA-40x18	40	18
MA-40x20	40	20
MA-40x21	40	21
MA-40x22	40	22
MA-40x23	40	23

Kód Code	A	B
MA-40x25	40	25
MA-40x27	40	27
MA-40x30	40	30
MA-40x32	40	32
MA-45x11	45	11
MA-45x15	45	15
MA-45x17	45	17
MA-45x20	45	20
MA-45x25	45	25
MA-45x27	45	27
MA-45x30	45	30
MA-45x35	45	35
MA-50x10	50	10
MA-50x19	50	19
MA-50x20	50	20
MA-50x22	50	22
MA-50x25	50	25
MA-50x27	50	27
MA-50x30	50	30
MA-50x32	50	32
MA-50x35	50	35
MA-50x38	50	38
MA-50x40	50	40
MA-55x17	55	17
MA-55x20	55	20
MA-55x21	55	21
MA-55x25	55	25
MA-55x28	55	28
MA-55x30	55	30
MA-55x31,5	55	31,5
MA-55x35	55	35
MA-55x38	55	38
MA-55x40	55	40
MA-55x43	55	43
MA-60x13,5	60	1,5
MA-60x17	60	17
MA-60x20	60	20
MA-60x23	60	23
MA-60x25	60	25
MA-60x28	60	28
MA-60x30	60	30
MA-60x32	60	32
MA-60x35	60	35
MA-60x37	60	37
MA-60x40	60	40
MA-60x43	60	43

**Pro malé množství lze vyrobit formy na přání.
For minimum lots, sleeves can be made as for request.**

Kód Code	A	B
MA-60x50	60	50
MA-63x13,5	63	13,5
MA-63x20	63	20
MA-63x22	63	22
MA-63x25	63	25
MA-63x26	63	26
MA-63x28	63	28
MA-63x30	63	30
MA-63x32	63	32
MA-63x35	63	35
MA-63x36	63	36
MA-63x38	63	38
MA-63x39,5	63	39,5
MA-63x40	63	40
MA-63x45	63	45
MA-70x21	70	21
MA-70x25	70	25
MA-70x30	70	30
MA-70x40	70	40
MA-70x45	70	45
MA-70x50	70	50
MA-70x56	70	56
MA-70x60	70	60
MA-74x55	74	55
MA-74x62	74	62
MA-80x25	80	25
MA-80x27	80	27
MA-80x30	80	30
MA-80x32	80	32
MA-80x35	80	35
MA-80x36	80	36
MA-80x39	80	39
MA-80x40	80	40
MA-80x42	80	42
MA-80x44	80	44
MA-80x46	80	46
MA-80x49,5	80	49,5
MA-80x50	80	50
MA-80x51	80	51
MA-80x55	80	55
MA-80x56	80	56
MA-80x59	80	59
MA-80x60	80	60
MA-80x64	80	64
MA-80x70	80	70
MA-90x21	90	21
MA-90x25	90	25
MA-90x30	90	30
MA-90x40	90	40
MA-90x50	90	50
MA-90x60	90	60
MA-90x65	90	65
MA-90x70	90	70
MA-90x75	90	75
MA-100x27	100	27

Kód Code	A	B
MA-100x29	100	29
MA-100x30	100	30
MA-100x31	100	31
MA-100x34	100	34
MA-100x35	100	35
MA-100x40	100	40
MA-100x45	100	45
MA-100x50	100	50
MA-100x55	100	55
MA-100x56	100	56
MA-100x60	100	60
MA-100x65	100	65
MA-100x70	100	70
MA-100x75	100	75
MA-100x80	100	80
MA-100x87	100	87
MA-110x27	110	27
MA-110x30	110	30
MA-110x40	110	40
MA-110x50	110	50
MA-110x60	110	60
MA-110x70	110	70
MA-110x80	110	80
MA-110x90	110	90
MA-120x21	120	21
MA-120x30	120	30
MA-120x50	120	50
MA-120x70	120	70
MA-120x90	120	90
MA-120x100	120	100
MA-125x29	125	29
MA-125x30	125	30
MA-125x31	125	31
MA-125x34	125	34
MA-125x35	125	35
MA-125x36	125	36
MA-125x39	125	39
MA-125x40	125	40
MA-125x42	125	42
MA-125x43	125	43
MA-125x44	125	44
MA-125x45	125	45
MA-125x46	125	46
MA-125x48	125	48
MA-125x50	125	50
MA-125x54	125	54
MA-125x56	125	56
MA-125x58	125	58
MA-125x60	125	60
MA-125x65	125	65
MA-125x70	125	70
MA-125x75	125	75
MA-125x80	125	80
MA-125x90	125	90
MA-125x100	125	100

Kód Code	A	B
MA-130x27	130	27
MA-130x30	130	30
MA-130x39	130	39
MA-130x40	130	40
MA-130x50	130	50
MA-130x54	130	54
MA-130x60	130	60
MA-130x70	130	70
MA-130x80	130	80
MA-130x90	130	90
MA-130x100	130	100
MA-130x110	130	110
MA-140x27	140	27
MA-140x30	140	30
MA-140x40	140	40
MA-140x50	140	50
MA-140x60	140	60
MA-140x70	140	70
MA-140x80	140	80
MA-140x90	140	90
MA-140x100	140	100
MA-140x110	140	110
MA-140x120	140	120
MA-150x30	150	30
MA-150x40	150	40
MA-150x50	150	50
MA-150x60	150	60
MA-150x65	150	65
MA-150x70	150	70
MA-150x80	150	80
MA-150x90	150	90
MA-150x100	150	100
MA-150x110	150	110
MA-150x120	150	120
MA-150x130	150	130
MA-160x27	160	27
MA-160x30	160	30
MA-160x36	160	36
MA-160x40	160	40
MA-160x50	160	50
MA-160x65	160	65
MA-160x70	160	70
MA-160x80	160	80
MA-160x90	160	90
MA-160x100	160	100
MA-160x110	160	110
MA-200x27	200	27
MA-200x30	200	30
MA-200x40	200	40
MA-200x50	200	50
MA-200x60	200	60
MA-200x70	200	70
MA-200x80	200	80
MA-200x100	200	100
MA-200x150	200	150



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- **EXPRESNÍ VÝROBA střížníků a střížnic do 24 hodin**



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