



## Nástroj: Tvárecí nástroj

Číslo nástroje

Razník: **S115110-224-A1**Matrice: **S115110-224-P2**

Sterac: ---

## Nástrojová data:

Použitelnost	Stroj	Korekce polohy beranu	Hodnota
<b>ano</b>	TC 240, TC 240L, TC 240R, TC 260, TC 260L, TC 260R	Kódování na kazete	<b>1</b>
<b>ne</b>	TC 120R, TC 160R, MINIMATIC 100	Délka odbroušení	<b>1,0</b>
<b>ano</b>	TC 190R, TC 200R, TC 500R		
<b>ano</b>	TC 600L, TC 2000R	UT-Offset v technologické tabulce PTT	<b>0,0</b>
<b>ano</b>	TruPunch 1000, TruPunch 2020, TruPunch 3000, TruMatic 3000		
<b>ano</b>	TruPunch 5000, TruMatic 6000, TruMatic 7000		
další nastavení		Promenná tvárecí poloha (VU)	<b>39</b>
		Délka nástroje	<b>37</b>
		Typ nástroje v TruTops Punch	<b>13</b>
		Mazání	<b>ano</b>
		Posuv	<b>--</b>

## Použití:

Tloušťka plechu: 1,5 mm

Materiál: hliník

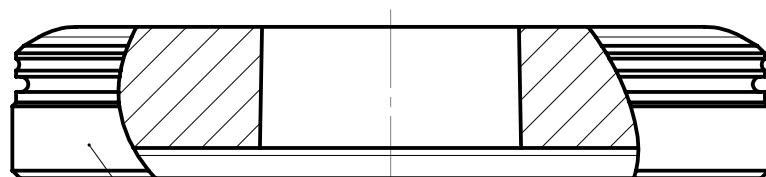
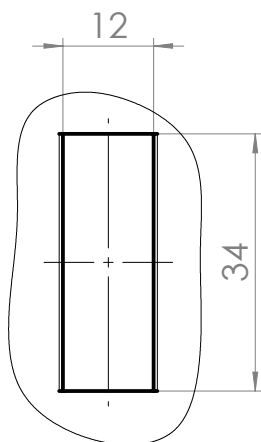
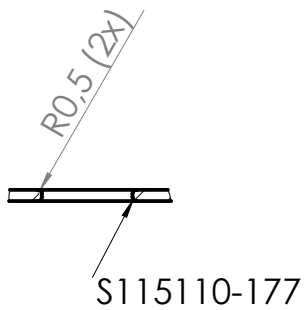
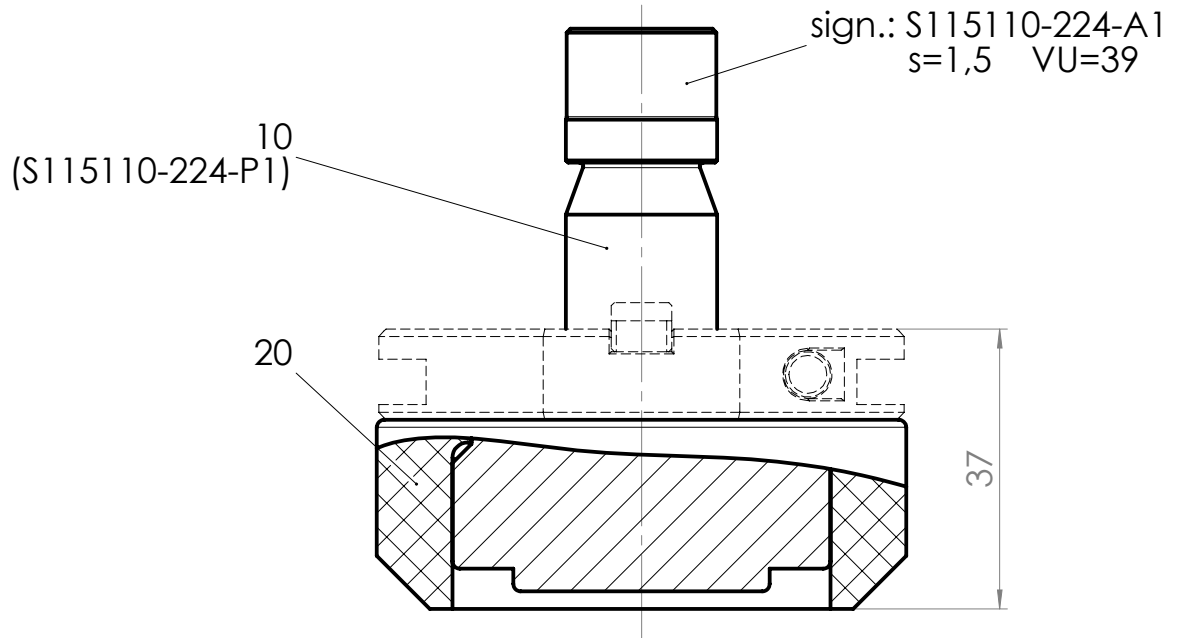
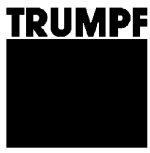
Vzdálenosti X: min. -- mm

Y: min. -- mm

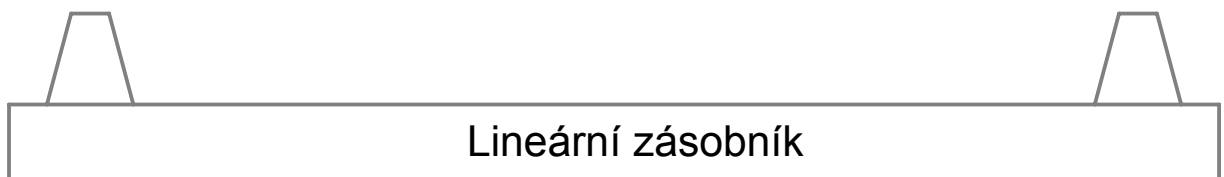
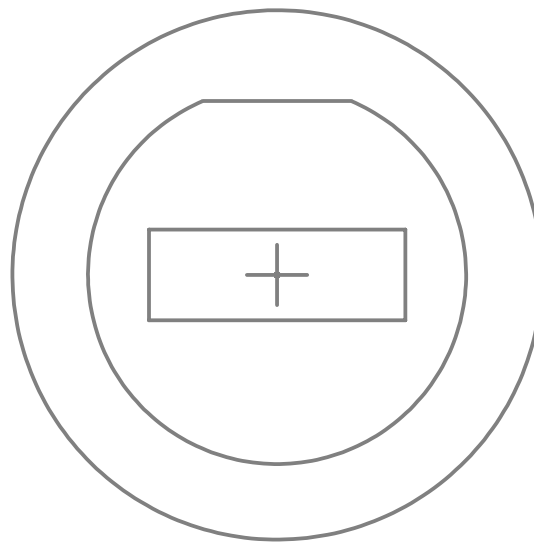
Před použitím tohoto nástroje se musí provést predderování s:  
**S115110-177**

## Upozornění / poznámky pro programátora:

- U těchto uvedených nástrojových dat se jedná o teoretické hodnoty, které se mohou lišit v závislosti na materiálu a stroji.



sign.: S115110-224-P2





## Werkzeug: Umformwerkzeug

Werkzeug-Nr.            Stempel: **S115110-224-A1**  
                                  Matrize: **S115110-224-P2**  
                                  Abstreifer: ---

## Werkzeug-Daten:

Verfügbarkeit	Maschine	Korrektur der Stößellage	Wert
<b>ja</b>	TC 240, TC 240L, TC 240R, TC 260, TC 260L, TC 260R	Codierung an der Rüstkassette	<b>1</b>
<b>nein</b>	TC 120R, TC 160R, MINIMATIC 100	Nachschleiflänge	<b>1,0</b>
<b>ja</b>	TC 190R, TC 200R, TC 500R		
<b>ja</b>	TC 600L, TC 2000R	UT-Offset in der PTT-Tabelle	<b>0,0</b>
<b>ja</b>	TruPunch 1000, TruPunch 2020, TruPunch 3000, TruMatic 3000		
<b>ja</b>	TruPunch 5000, TruMatic 6000, TruMatic 7000		
weitere Einstellwerte		Variable Umformlage (VU-Wert)	<b>39</b>
		Werkzeuglänge	<b>37</b>
		Werkzeugtyp TruTops Punch	<b>13</b>
		Schmierung	<b>ja</b>
		Vorschub	<b>--</b>

## Anwendung:

Blechdicke: 1,5 mm

Werkstoff: Aluminium

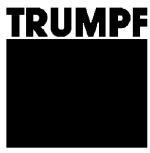
Abstände X: min. -- mm

Y: min. -- mm

Bevor dieses Werkzeug eingesetzt wird, muss vorgestanzt werden mit:  
**Werkzeug S115110-177**

## Programmier-Bedienungshinweis / Bemerkungen:

- Bei den hier angegebenen Werkzeug-Daten handelt es sich um theoretische Werte, die material- und maschinenspezifisch abweichen können.



# Technische Information

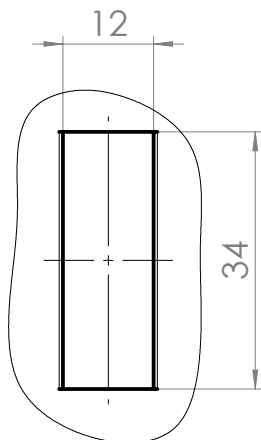
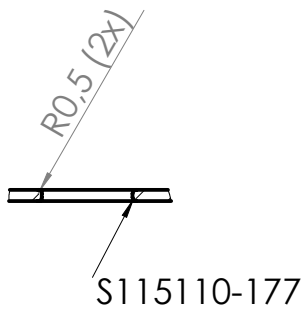
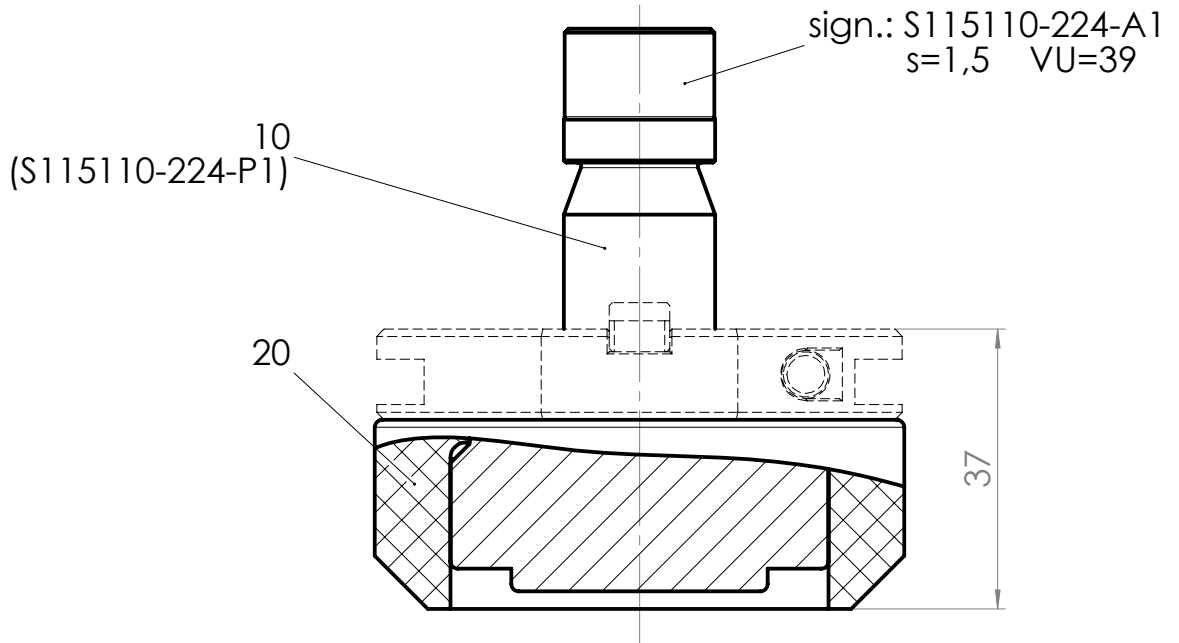
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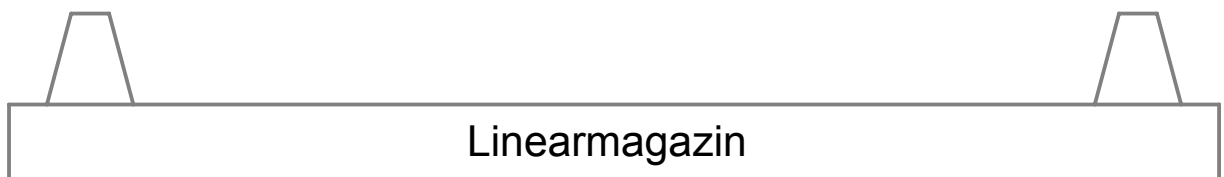
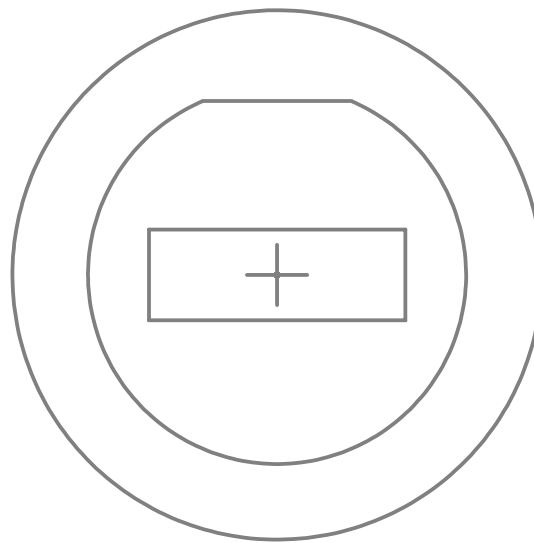
Blatt 2 / 3

Bearb.: TWS317kr

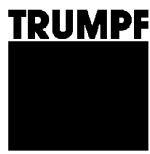
Datum: 15.02.2011



sign.: S115110-224-P2



Linearmagazin



# Technical Information

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Design.: TWS317kr

Date: 15.02.2011

## Tool: forming tool

Tool number                  punch: **S115110-224-A1**  
    die: **S115110-224-P2**  
    stripper: ---

## Tool-data:

Applicable	Machine	Correction of ram position	Value
<b>yes</b>	TC 240, TC 240L, TC 240R, TC 260, TC 260L, TC 260R	Encoding	<b>1</b>
<b>no</b>	TC 120R, TC 160R, MINIMATIC 100	Regrinding length	<b>1,0</b>
<b>yes</b>	TC 190R, TC 200R, TC 500R		
<b>yes</b>	TC 600L, TC 2000R	UT-Offset in tool technology table	<b>0,0</b>
<b>yes</b>	TruPunch 1000, TruPunch 2020, TruPunch 3000, TruMatic 3000		
<b>yes</b>	TruPunch 5000, TruMatic 6000, TruMatic 7000		
further setting values		Variable forming position (VU)	<b>39</b>
		Tool length	<b>37</b>
		Tool type TruTops Punch	<b>13</b>
		Lubrication	<b>yes</b>
		Feed	<b>--</b>

## Application:

Sheet thickness: 1,5 mm

Material: aluminium

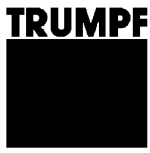
Distances X: min. -- mm

Y: min. -- mm

Before using this tool, it is necessary to prepunch with:  
**S115110-177**

## Indications for programming and handling / notes:

- Tool data that are indicated in this information are theoretic and can change by material and machine.



# Technical Information

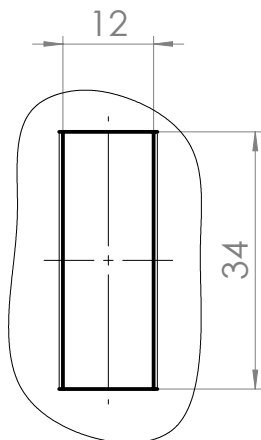
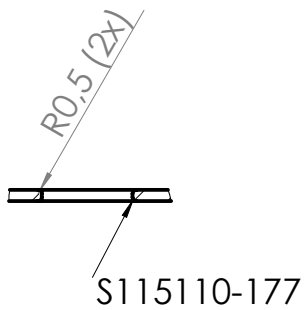
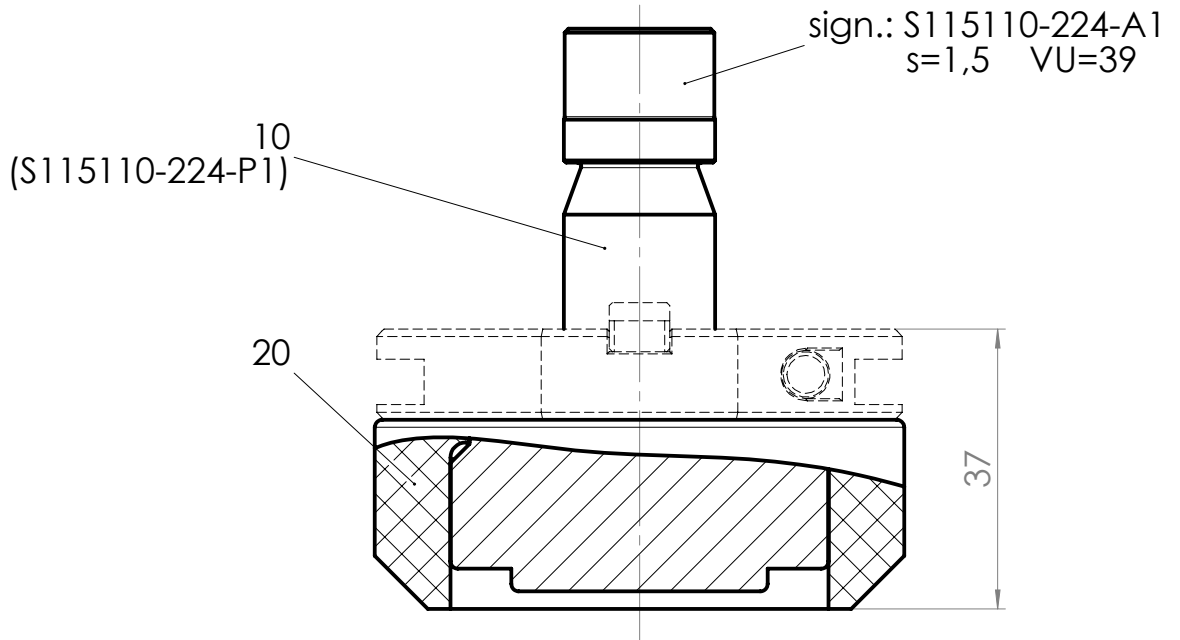
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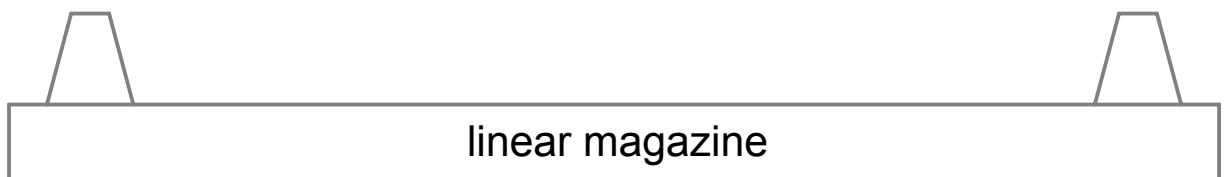
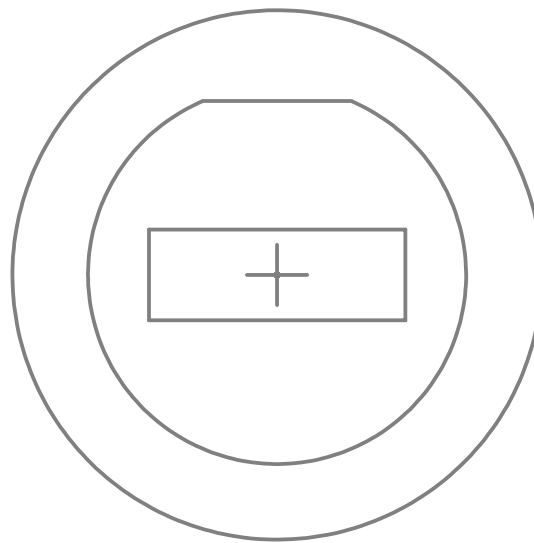
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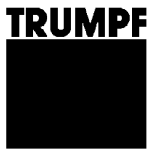
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# Información Técnica

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Constr.: TWS317kr

Fecha: 15.02.2011

## Útil: útil de conformado

Número útil punzón: **S115110-224-A1**  
matriz: **S115110-224-P2**  
separador: ---

## Datos del útil:

Disponibilidad	Máquina	Correcciones posición de la colisa	Valor
<b>si</b>	TC 240, TC 240L, TC 240R, TC 260, TC 260L, TC 260R	Reafilado	<b>1</b>
<b>no</b>	TC 120R, TC 160R, MINIMATIC 100	Longitud de reafilado	<b>1,0</b>
<b>si</b>	TC 190R, TC 200R, TC 500R		
<b>si</b>	TC 600L, TC 2000R	UT-offset en tabla tecnológica de útiles	<b>0,0</b>
<b>si</b>	TruPunch 1000, TruPunch 2020, TruPunch 3000, TruMatic 3000		
<b>si</b>	TruPunch 5000, TruMatic 6000, TruMatic 7000		
otros valores de ajuste		Posición conformado variable (VU)	<b>39</b>
		Longitud del útil	<b>37</b>
		Tipo de útil TruTops Punch	<b>13</b>
		Lubricación	<b>si</b>
		Avance	<b>--</b>

## Aplicación:

Espesor de la chapa: 1,5 mm

Material: aluminio

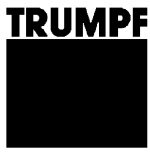
Distancia X: min. -- mm

Y: min. -- mm

Antes de utilizar este útil hay que prepunzonar con:  
**S115110-177**

## Indicaciones de programación y manipulación / notas:

- Los valores de útil aquí indicados son medidas teóricas que pueden variar dependiendo del tipo de máquina y material.



# Información Técnica

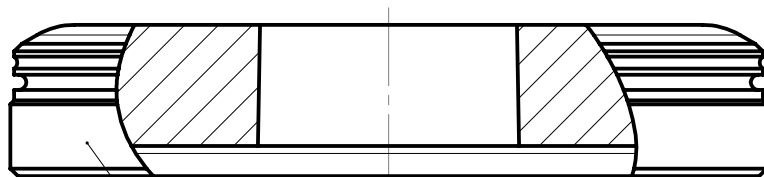
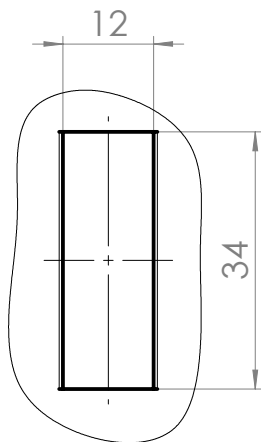
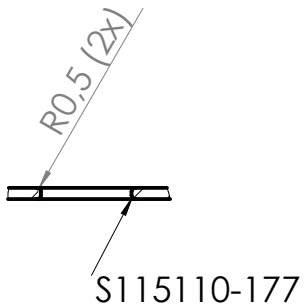
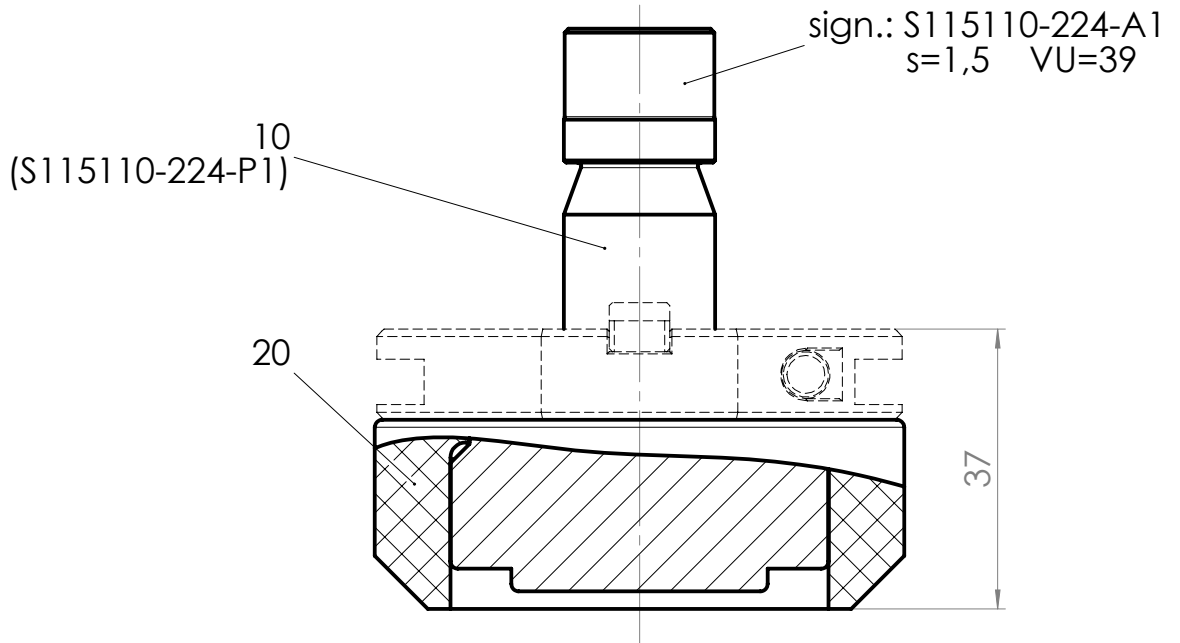
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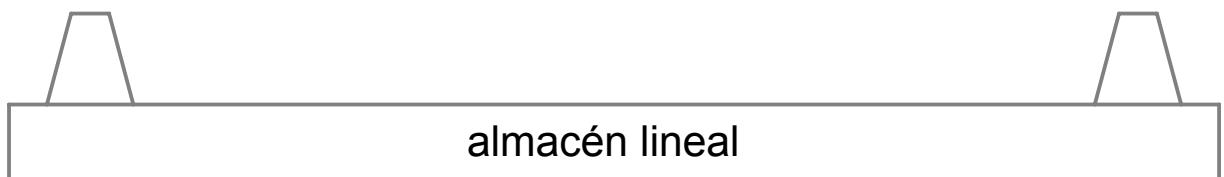
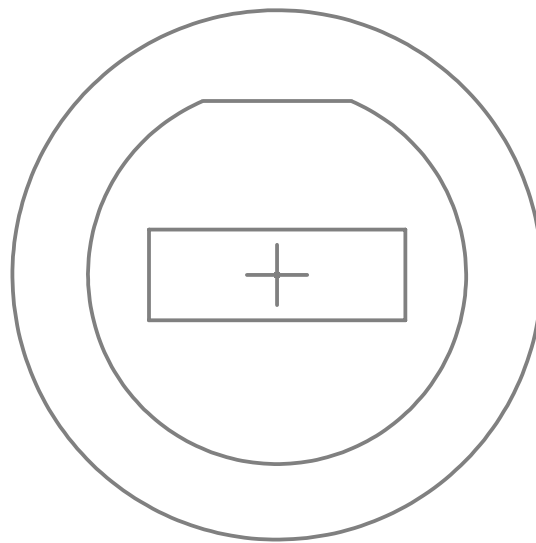
Constr.: TWS317kr

Fecha: 15.02.2011



sign.: S115110-224-P2

General Tolerances ISO 2768 -mK




**Outil: outil de formage**

 Numéro d'outil poinçon: **S115110-224-A1**

 matrice: **S115110-224-P2**

dévêtisseur: ---

**Paramètres d'outil:**

Disponibilité	Machine	Correction de la pos. du coulisseau	Valeur
<b>oui</b>	TC 240, TC 240L, TC 240R, TC 260, TC 260L, TC 260R	Codage sur la cassette de montage	<b>1</b>
<b>non</b>	TC 120R, TC 160R, MINIMATIC 100	Longueur d'affûtage	<b>1,0</b>
<b>oui</b>	TC 190R, TC 200R, TC 500R		
<b>oui</b>	TC 600L, TC 2000R	Offset Point Mort Bas UT dans le tableau technologique d'outils	<b>0,0</b>
<b>oui</b>	TruPunch 1000, TruPunch 2020, TruPunch 3000, TruMatic 3000		
<b>oui</b>	TruPunch 5000, TruMatic 6000, TruMatic 7000		
autres valeurs de réglage		Position Déformation Variable (VU)	<b>39</b>
		Longueur d'outil	<b>37</b>
		Type d'outil dans TruTops Punch	<b>13</b>
		Lubrification	<b>oui</b>
		Avance	<b>--</b>

**Application:**

Epaisseur de tôle: 1,5 mm

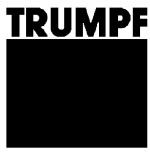
Matériau tôle: aluminium

Entre axes X: min. -- mm

Y: min. -- mm

 Avant de mettre en œuvre cet outil, il est nécessaire de poinçonner avec:  
**S115110-177**
**Indications de programmation et d'utilisation / Remarques:**

- Les paramètres d'outil indiqués ici sont des côtes théoriques qui peuvent varier en fonction du matériau et de la machine.



# Information Technique

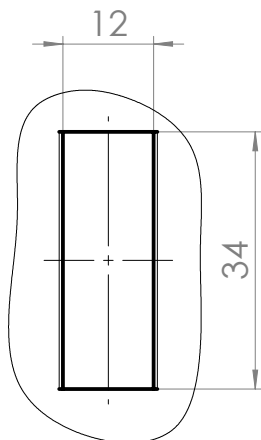
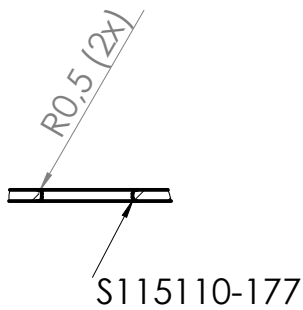
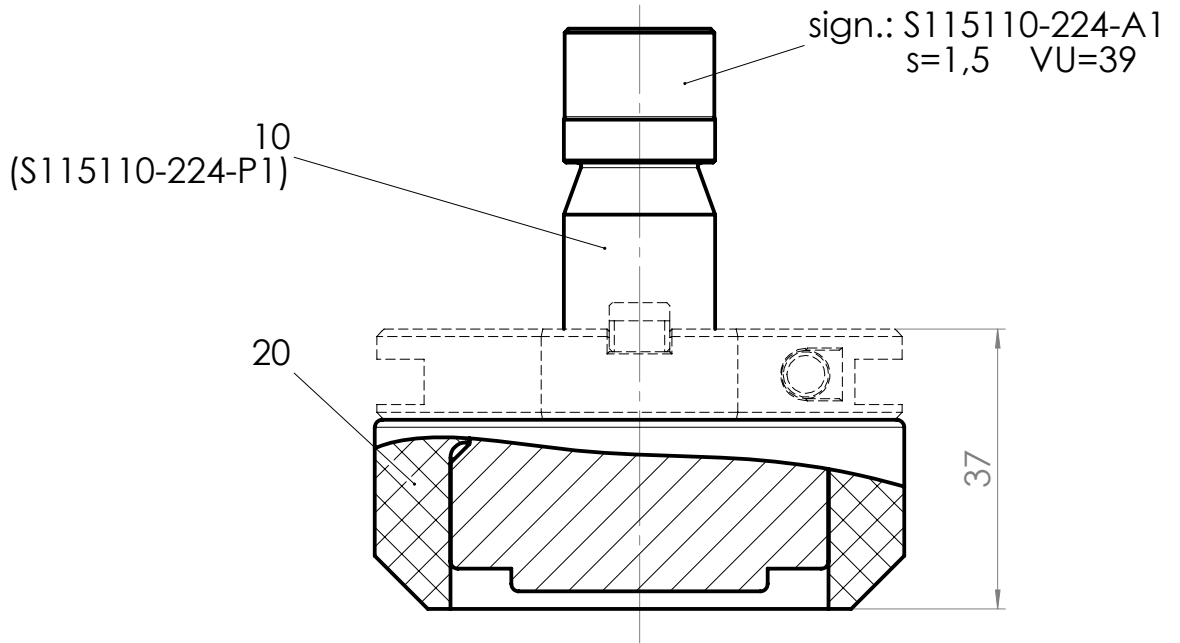
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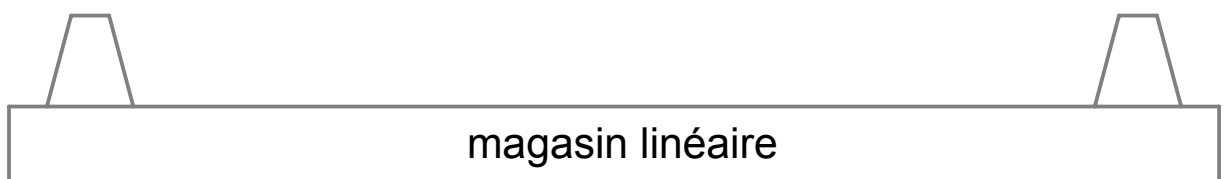
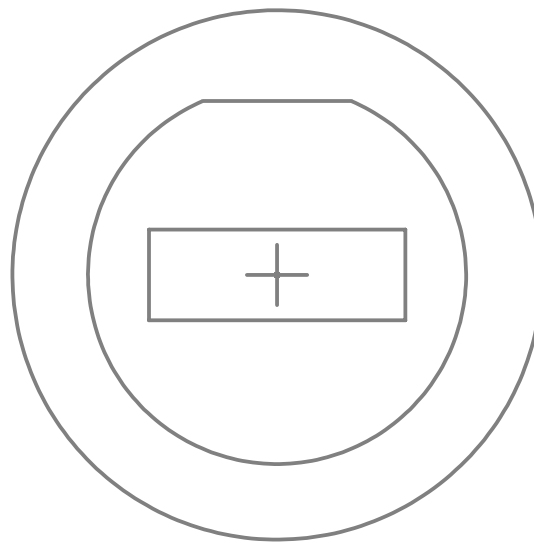
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Rédac.: TWS317kr

Date: 15.02.2011





magasin linéaire



## Utensile: utensile a deformare

Numero utensile punzone: **S115110-224-A1**

matrice: **S115110-224-P2**

premilamiera: ---

## Dati utensili:

Disponibilità	Macchina	Correzioni posizionamento slitta	Valore
<b>si</b>	TC 240, TC 240L, TC 240R, TC 260, TC 260L, TC 260R	Codifica	<b>1</b>
<b>no</b>	TC 120R, TC 160R, MINIMATIC 100	Lunghezza di riaffilatura	<b>1,0</b>
<b>si</b>	TC 190R, TC 200R, TC 500R		
<b>si</b>	TC 600L, TC 2000R	UT-offset in tabella tecnologica utensili	<b>0,0</b>
<b>si</b>	TruPunch 1000, TruPunch 2020, TruPunch 3000, TruMatic 3000		
<b>si</b>	TruPunch 5000, TruMatic 6000, TruMatic 7000		
parametri ulteriori		Posizione di deformazione variable (VU)	<b>39</b>
		Lungh. utensile	<b>37</b>
		Tipo utensile TruTops Punch	<b>13</b>
		Lubrificazione	<b>si</b>
		Avanzamento	<b>--</b>

## Applicazione:

Spessore della lamiera: 1,5 mm

Materiale: alluminio

Distanza X: min. -- mm

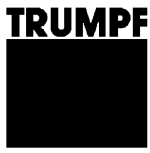
Y: min. -- mm

Prima di utilizzare quest'utensile occorre eseguire un preforo da:  
**S115110-177**

## Istruzioni per l'uso e la programmazione / annotazioni:

- I valori relativi ai dati qui indicati si riferiscono a misure teoriche, che possono variare leggermente in funzione del materiale e della specifica macchina.





# Informazioni Tecniche

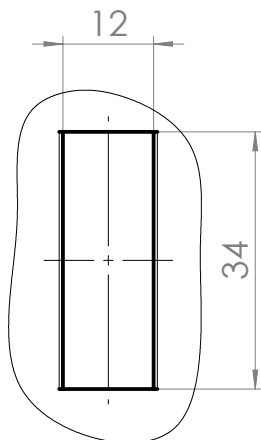
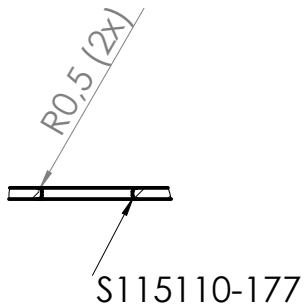
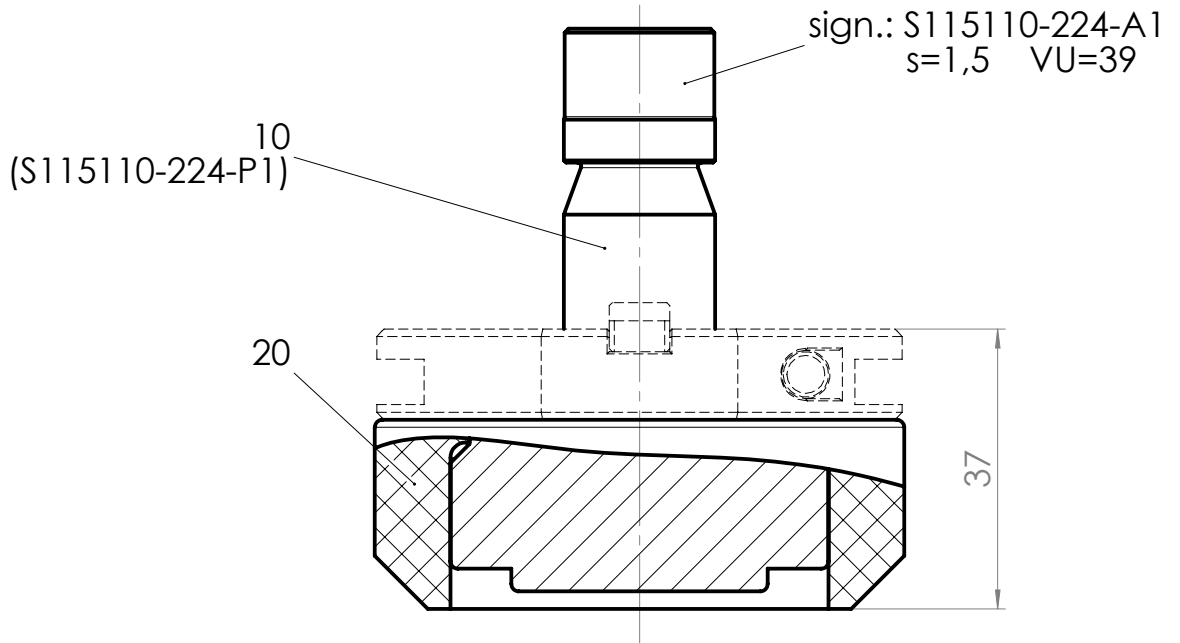
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Data: 15.02.2011



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