

力创辉煌 源自诚信
Credibility foremost People oriented

安徽力源数控刀模具制造有限公司
ANHUI LIYUAN CNC BLADE MOLD MANUFACTURING CO., LTD.

地址Add

安徽省马鞍山市博望区溪岗路410号
Address: 410 Xigang Road, Bowang
District, Ma'anshan City, Anhui Province

联系Contact

电话Tel: +86-555-6768158
邮编Postcode: 243131
邮箱Email: sales@ahliyuan.com

网址Official Website

www.ahliyuan.com
www.brakepresstools.com



力源模具 官网



力源模具 公众号



Official Website

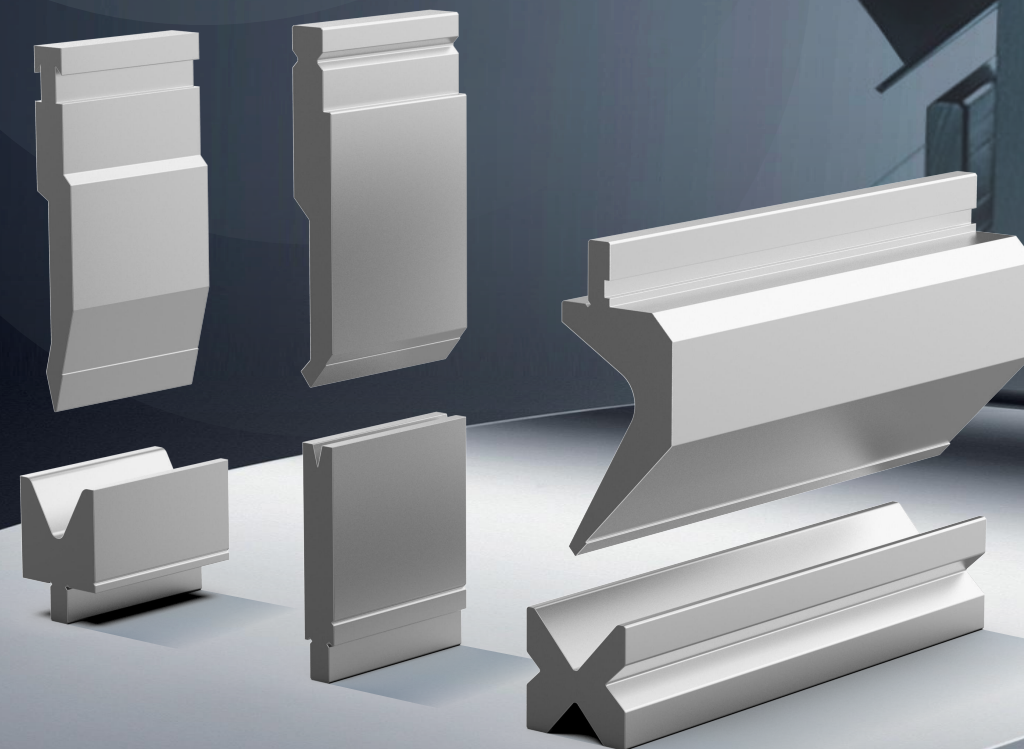
版本号: 2024-9

2003
力源模具



折弯机模具行业标准主要起草单位
中国钣金折弯模具重点骨干企业
国家知识产权示范企业
国家高新技术企业

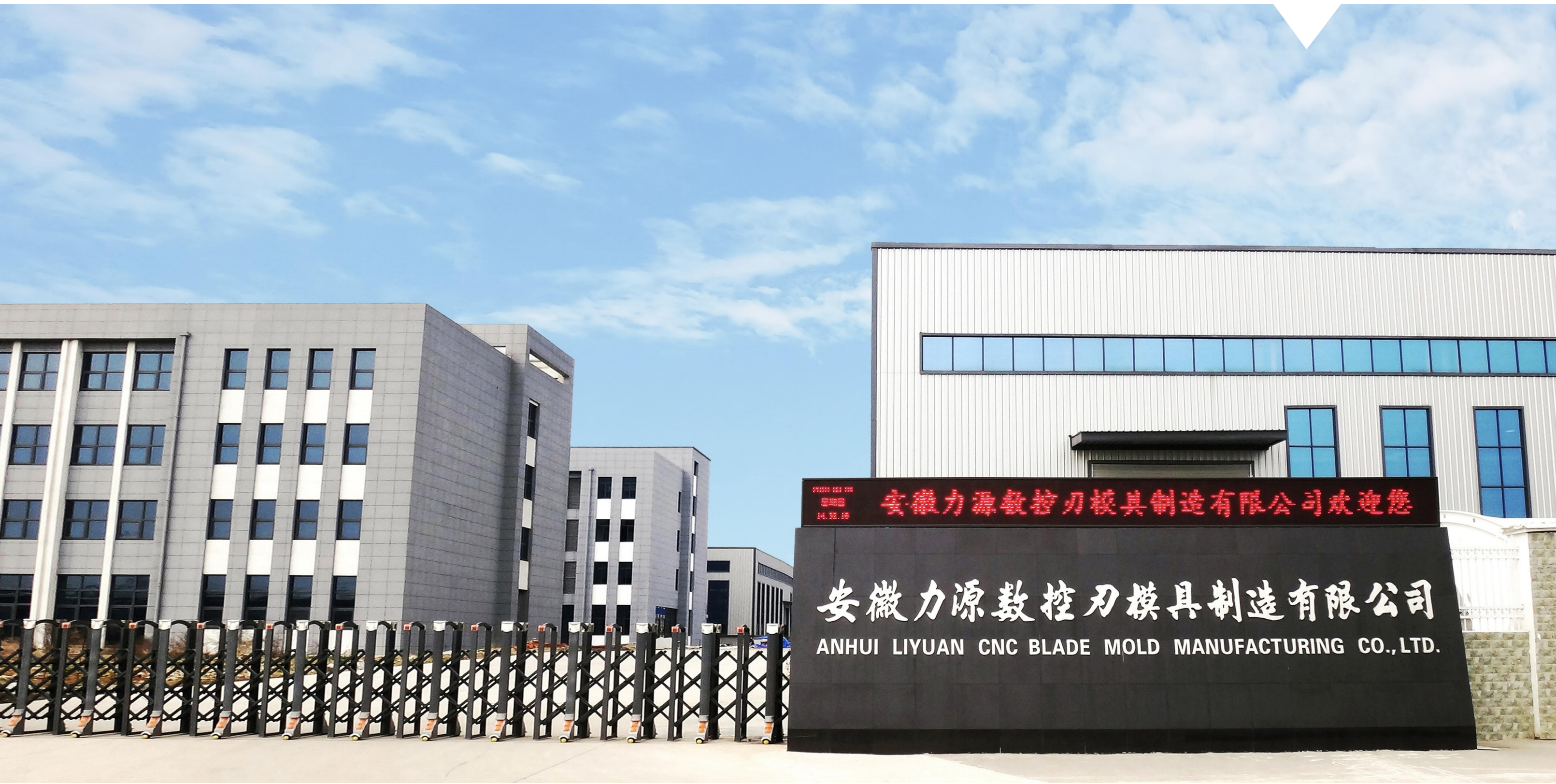
Main Drafting Unit of Industry Standard for Press Brake Tools
Key Enterprise of China Press Brake Industry
National Intellectual Property Rights Model Enterprise
National High-tech Enterprise



LYNCCN

走进力源

ENTERING LIYUAN



2022.10.18
星期日
14:52:16

安徽力源数控刀模具制造有限公司欢迎您

安徽力源数控刀模具制造有限公司

ANHUI LIYUAN CNC BLADE MOLD MANUFACTURING CO., LTD.

01 关于我们

ABOUT US



2003 年创立于安徽
Established in Anhui

9 项备案企业标准
Enterprise standards on record

8 项主持起草行业标准和团体标准
Industry standards and group standards
were hosted and drafted

70 项知识产权
Intellectual property rights

31 项发明专利
Patents for inventions

安徽力源数控刀模具制造有限公司成立于2003年, 拥有国家高新技术企业、中国重点骨干模具企业、国家知识产权示范企业、安徽省认定企业技术中心、安徽省认定工业设计中心、安徽省认定专精特新企业等荣誉和认定。

作为国内最早研发生产数控折弯机模具、机械补偿工作台和冲压设备配件的专业厂家之一, 先后主持起草行业标准和团体标准8项, 备案企业标准9项。拥有各类知识产权70余项(其中发明专利31项)。

公司建有数控智能钣金模具生产线和机床精度补偿装置生产线, 为折弯成型设备个性化定制高精度、智能化、长寿命的折弯模具和补偿工作台。

为提升生产透明化, 企业建立了集设备数据采集与监控、数据集成和共享、产品质量可追溯、产品流程可把控的5G+工业互联网平台, 为企业产品的高质量输出提供了高标准的智能化保障。

作为一个与时俱进的民营科技企业, 力源公司将以全新的经营结构和高质量的产品输出为中国刀模具及冲压设备行业的创新式发展增添新的活力。

Anhui Liyuan CNC Blade Mold Manufacturing Co., Ltd. is located in Maanshan City, Anhui Province. Founded in 2003, our achievement include: National High-tech Enterprise, Key Enterprise of Chinese Mold Industry, National Intellectual Property Demonstration Enterprise, Anhui Recognized Enterprise Technology Center, Anhui Recognized Industrial Design Center, Anhui Recognized Specialized and New Enterprise, etc.

As one of the earliest professional manufacturers in China to R&D and produce CNC press brake tooling, mechanical compensation table and punching equipment accessories, we successively presided over the drafting of 8 industry standards and group standards, and filed 9 enterprise standards. With product innovation and technical transformation, we have promoted the industrialization of the enterprise's innovation achievements. We owned more than 70 intellectual property rights (including 31 invention patents).

Our CNC intelligent sheet metal mold production line、precision compensation device production line offers customized high-precision, intelligent and high durability press brake tooling and crowning tables for bending machine.

We also set up a 5G+ industrial internet platform which integrates data collection and monitoring、integration and sharing、product quality traceability and product process control in order to increase our production transparency.

As a private technology enterprise, we believe that our new business structure and high quality products will make contribution to both domestic and international sheet metal industry.



02 车间一览

WORKSHOP OVERVIEW

精益管理 100%放心选择

Lean management , 100% comfortable choices

工匠精神 成就完美品质

Craftsmanship spirit achieves perfect quality



▲ 加工中心生产线
Milling Center Production Line



▲ 龙门加工中心生产线
Gantry Machining Center Production Line



▲ 数控磨床生产线
CNC Grinding Production Line



▲ 信息中心工作现场
Information Center Work Site



▲ 生产现场
Production Site

03企业荣誉

ENTERPRISE HONOR

2013

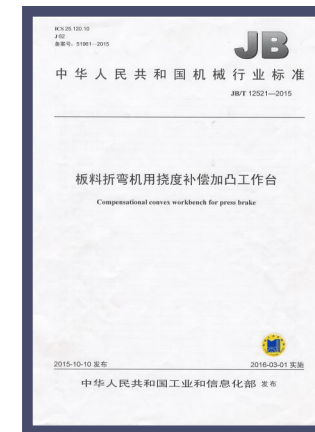
主持起草行业标准《板料折弯机用上折弯模》

2013

主持起草行业标准《板料折弯机用下折弯模》

2015

主持起草行业标准《板料折弯机用挠度补偿加凸工作台》



2017

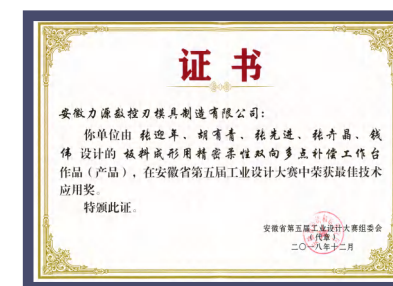
安徽省认定企业技术中心

2018

安徽省工业设计大赛应用奖

2018

中国专利优秀奖《一种带限位功能折弯模具》



2020

安徽省科学技术奖

2020

安徽省专利银奖《一体式多工位折边模具》

2023

中国专利优秀奖《一种四面包围箱体折弯模具及其使用方法》



CONTENT

目录

AMADA STYLE

PUNCHES/上模	1
Punches/上模 - 90°/88°/85°	3
Punches/上模 - 60°	6
Punches/上模 - 45°/30°/26°	7
DIES/下模	8
Die Holders/模座	9
Single V Dies/单V下模 - BASE/底座=14mm	10
Single V Dies/单V下模 - BASE/底座=60mm	11
T Dies/T型下模 - H=80mm	12
T Dies/T型下模 - H=120mm	13
2V Dies/双V同芯下模 - H=26mm	14
2V Dies/双V同芯下模 - H=46mm	15
MULTI V DIES/多V下模	16

WILA-TRUMPF STYLE

PUNCHES/上模	17
Punches/上模 - 90°/86°/80°	19
Punches/上模 - 60°	22
Punches/上模 - 28°	24
DIES/下模	26
Single V Dies/单V下模 - H=100mm	27
Single V Dies/单V下模 - H=150mm	28

BYSTRONIC-BEYELER STYLE

PUNCHES/上模	29
BYSTRONIC-BEYELER S	
Punches/上模 - 85°/30°/28°	31
BYSTRONIC-BEYELER R	
Punches/上模 - 85°/30°/28°	32
BYSTRONIC-BEYELER RF&RFA	
Punches/上模 - 88°/85°/30°/26°	33
DIES/下模	34
Single V Dies/单V下模 - H=55mm	35

RADIUS TOOLS/圆弧模具

Radius Holders/模柄	36
Radius Inserts/模头	37

SPECIAL TOOLS/成型模具

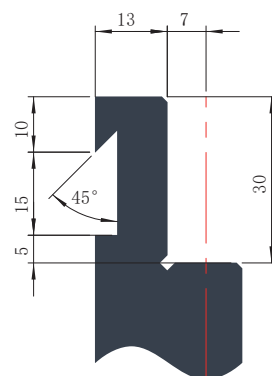
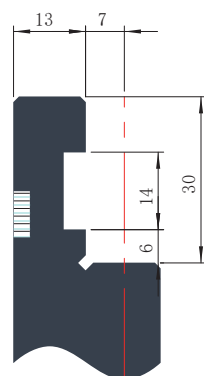
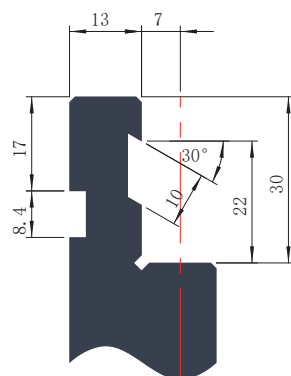
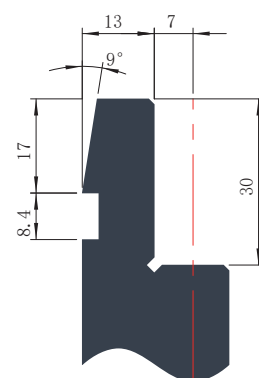
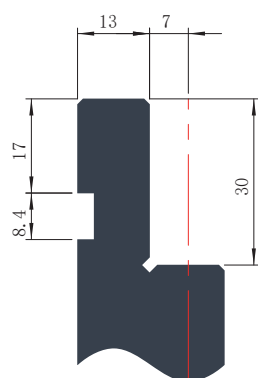
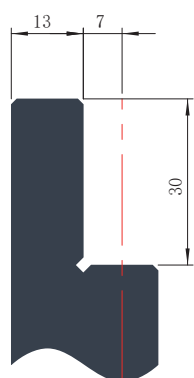
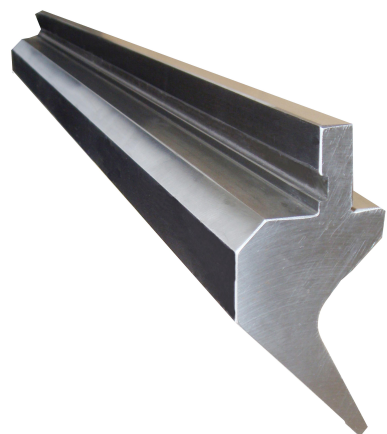
Flatting-Hemming Tools/折弯压平模具	40
Joogle Tools/段差模具	44
Scratch Resistance Die/无压痕模具	46

CROWNING TABLE/工作台

Horizontal Crowning/横向多点挠度补偿	48
Vertical Crowning/纵向挠度补偿	49
Bi-directional Crowning/双向挠度补偿	50

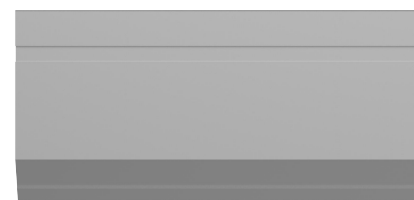
Capacity Chart Of Air Bending/折弯压力表	51
-------------------------------------	----

CLAMPING TYPES/装夹形式

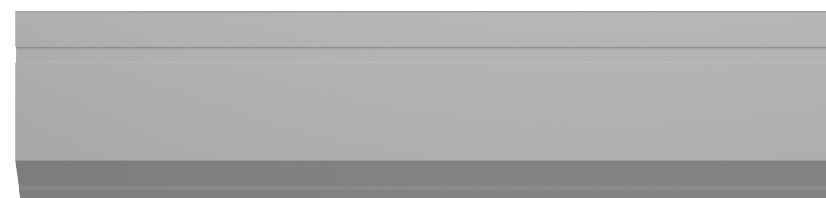


STANDARD SEGMENTATION/标准分段

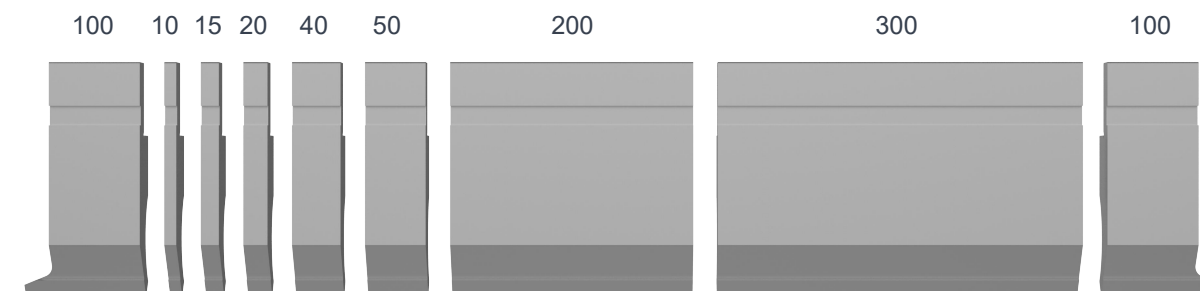
415mm



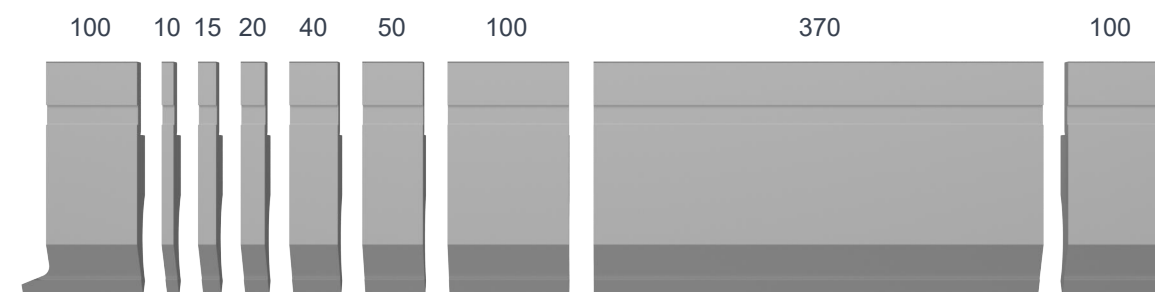
835mm



835mm Segmentaion/分段-9段



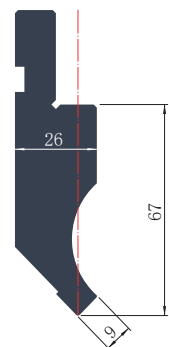
805mm Segmentaion/分段-9段



PUNCHES/上模 - 90° / 88° / 85°

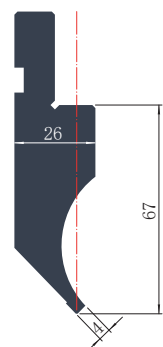
LS10.11 100T/M Max.

A	R	H
90°	0.2	67
	0.8	
88°	0.2	
	0.8	
	3	
85°	0.8	
	3	



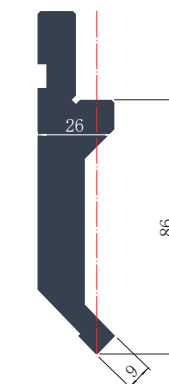
LS106 100T/M Max.

A	R	H
90°	0.2	67
	0.6	
88°	0.2	
	0.6	



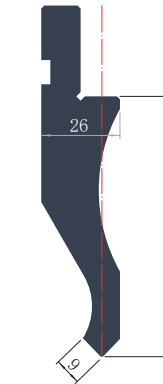
LS10.203 50T/M Max.

A	R	H
90°	0.8	86
88°	0.8	



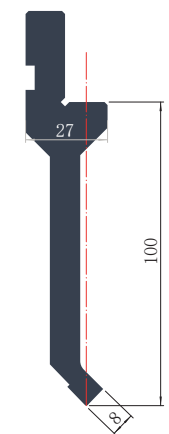
LS10.22 100T/M Max.

A	R	H
90°	0.8	86
88°	0.8	
	3	



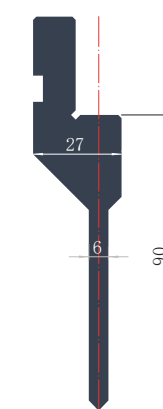
LS12.62 50T/M Max.

A	R	H
90°	0.2	100
	0.6	
88°	0.2	
	0.6	



LS10.108 50T/M Max.

A	R	H
90°	0.2	90
	0.6	
88°	0.2	
	0.6	
85°	0.3	

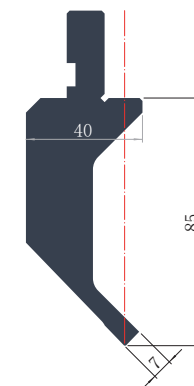


PUNCHES/上模 - 90° / 88°



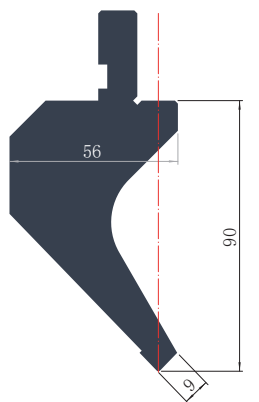
LS16 20T/M Max.

A	R	H
90°	0.6	85
88°	0.6	



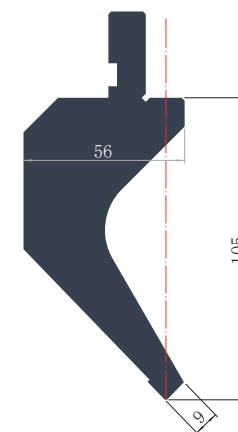
LS10.14 60T/M Max.

A	R	H
90°	0.2	90
	0.8	
88°	0.2	
	0.8	
	0.3	



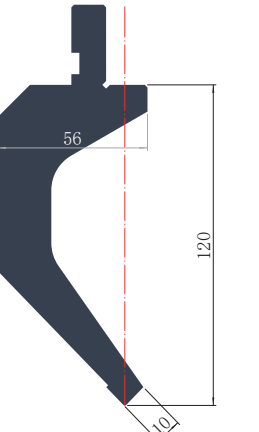
LS10.15 50T/M Max.

A	R	H
90°	0.2	105
	0.8	
88°	0.2	
	0.8	
	0.3	



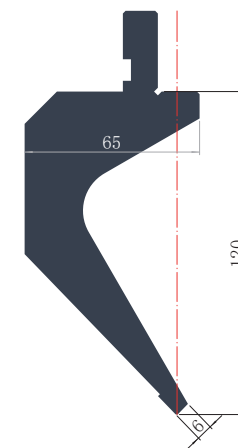
LS10.61 50T/M Max.

A	R	H
90°	0.8	120
88°	0.8	
	3	



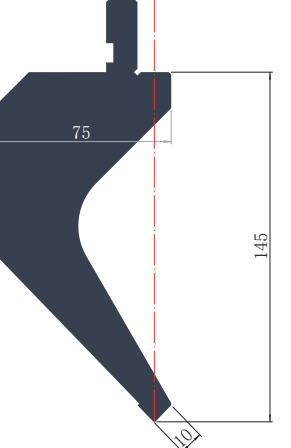
LS10.147 50T/M Max.

A	R	H
88°	0.8	120



LS10.30 50T/M Max.

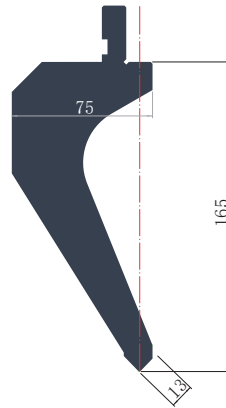
A	R	H
88°	0.8	145



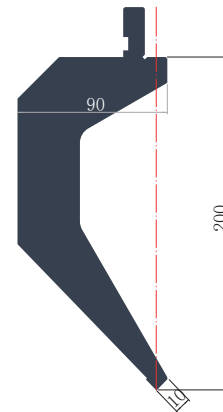
PUNCHES/上模 - 88° / 85°

LS10.31 60T/M Max.

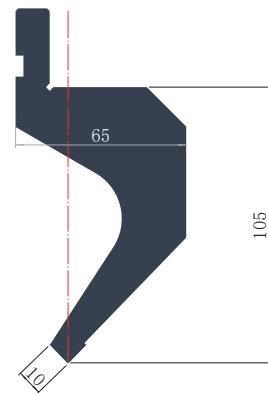
A	R	H
88°	0.8	165


LS12.91 85T/M Max.

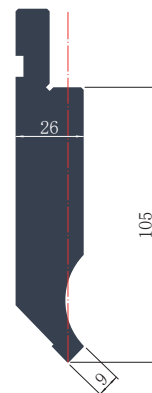
A	R	H
88°	0.8	200
	3	


LS10.82 45T/M Max.

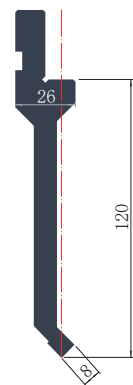
A	R	H
88°	0.8	105


LS10.63 100T/M Max.

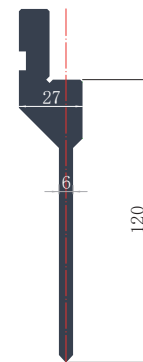
A	R	H
88°	0.8	105
85°	0.8	


LS10.20 35T/M Max.

A	R	H
88°	0.6	120


LS10.109 50T/M Max.

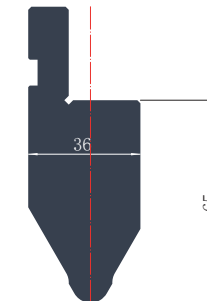
A	R	H
88°	0.2	120
85°	0.3	



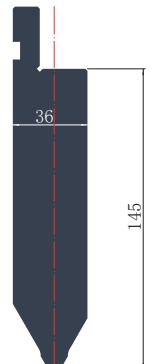
PUNCHES/上模 - 60°


LS13 100T/M Max.

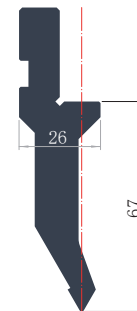
A	R	H
60°	6	65


LS12.83 100T/M Max.

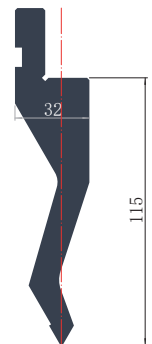
A	R	H
60°	5	145


LS20 80T/M Max.

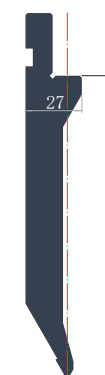
A	R	H
60°	0.8	67
	2	


LS11.91 60T/M Max.

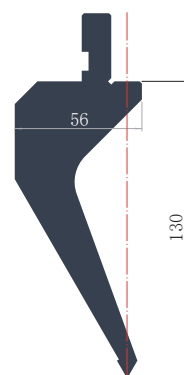
A	R	H
60°	0.8	115
	2	


LS12.84 80T/M Max.

A	R	H
60°	0.8	145
	2	


LS11.63 40T/M Max.

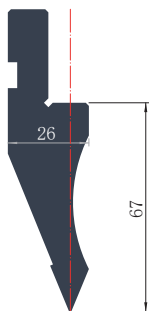
A	R	H
60°	0.8	130
	2	



PUNCHES/上模 - 45° / 30° / 26°

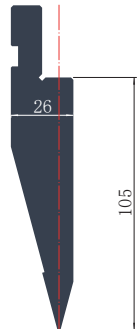
LS11 70T/M Max.

A	R	H
45°	0.5	67
	0.8	
	1.5	



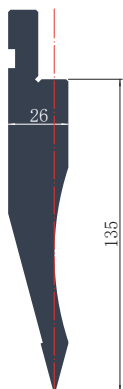
LS10.21 100T/M Max.

A	R	H
30°	0.6	105
	3	



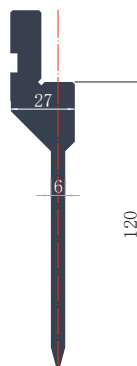
LS10.52 50T/M Max.

A	R	H
30°	0.5	135



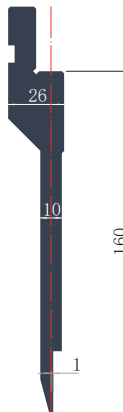
LS10.110 50T/M Max.

A	R	H
30°	0.8	120



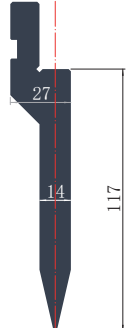
LS10.18 45T/M Max.

A	R	H
30°	0.6	160



LS10.33 100T/M Max.

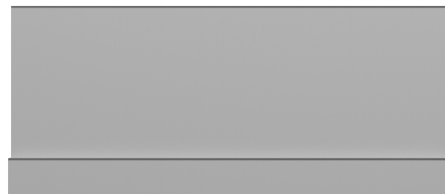
A	R	H
26°	0.8	117
	3	



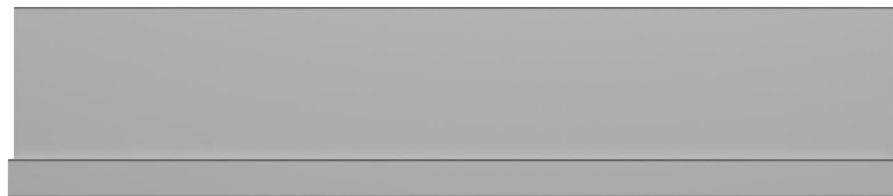
STANDARD SEGMENTATION/标准分段



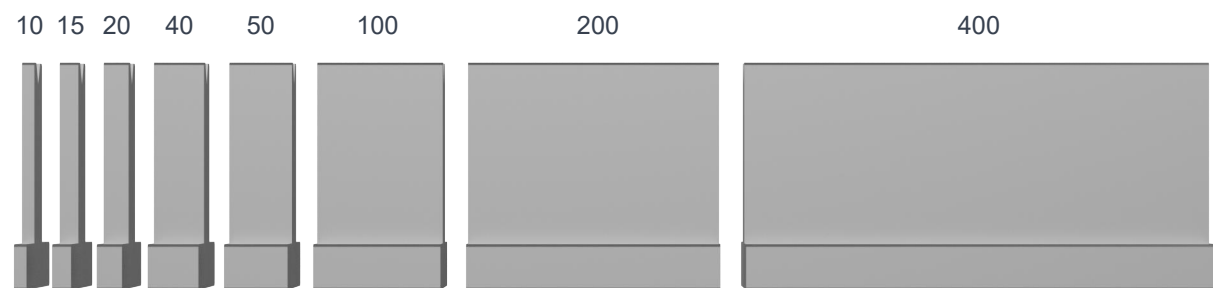
415mm



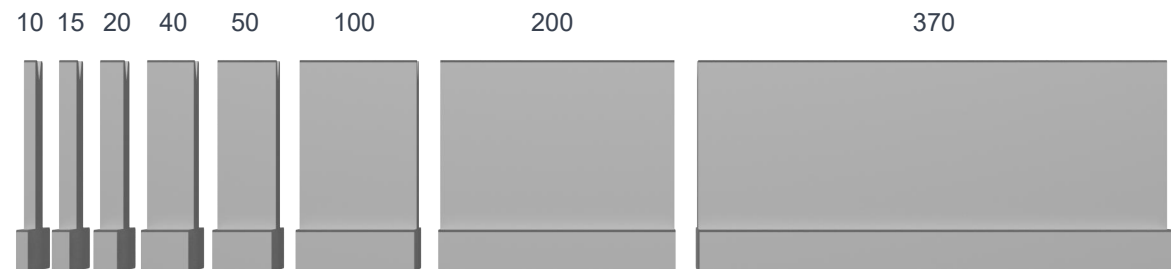
835mm



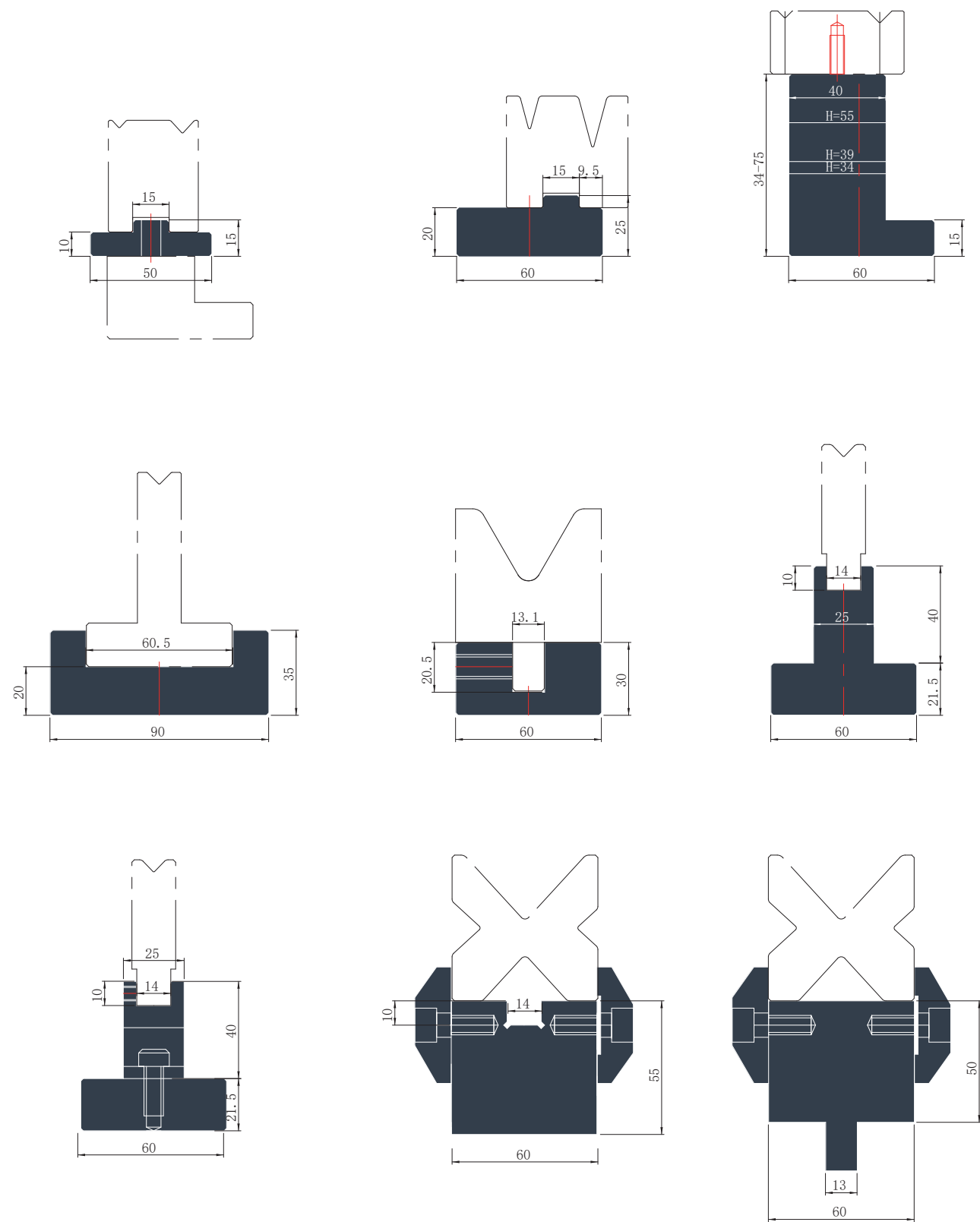
835mm Segmentaion/分段-8段



805mm Segmentaion/分段-8段



DIE HOLDERS/模座

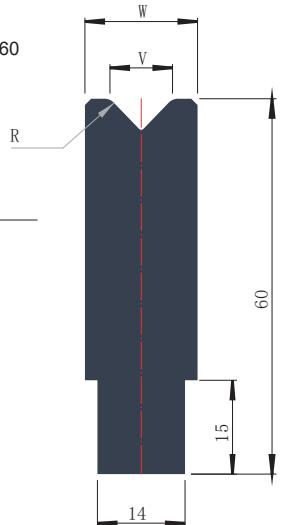


SINGLE V DIES/单V下模 - BASE/底座=14mm



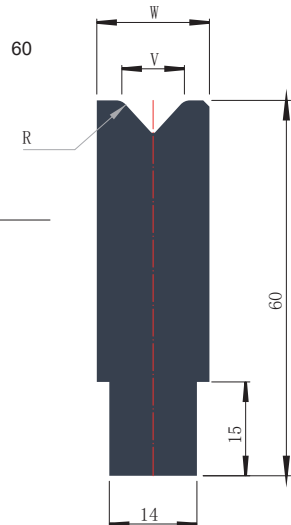
YS70.88 100T/M Max.

A	V	R	W	H
90°/88°	4	1	14	60
	6	1.5	14	
	8	1.5	14	
	10	2	18	
88°	12	2.5	18	60
	14	2.5	18	
	16	2.5	20	
	18	2.5	22	
	20	3	25	
	25	3	30	



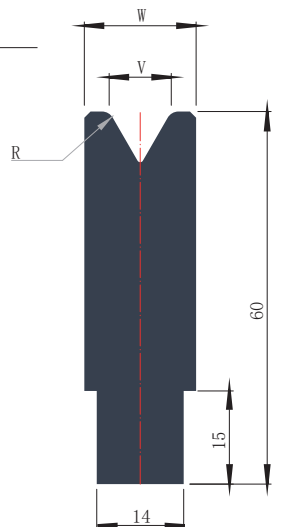
YS70.85 100T/M Max.

A	V	R	W	H
85°	4	1	14	60
	6	1.5	14	
	8	1.5	14	
	10	2	18	
85°	12	2.5	18	60
	14	2.5	18	
	16	2.5	20	
	18	2.5	22	
	20	3	25	
	25	3	30	



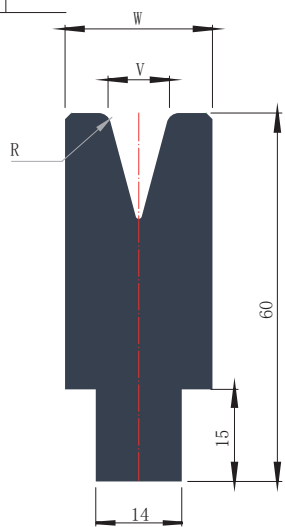
YS70.60 100T/M Max.

A	V	R	W	H
60°	6	1.5	14	60
	8	1.5	14	
	10	2	18	
	12	2.5	18	
	14	2.5	18	
	16	2.5	24	
	20	3	30	
	25	3	33	



YS70.30 100T/M Max.

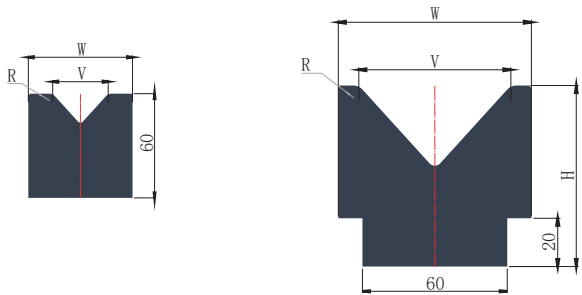
A	V	R	W	H
30°	6	1	16	60
	8	1	20	
	10	2	24	
	12	2.5	28	
	16	3	33	
	20	4	40	
	25	4	42	



SINGLE V DIES/单V下模 - BASE/底座=60mm

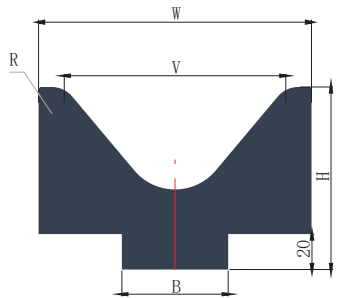
YS20.85 100T/M Max.

A	V	R	W	H
85°	32	4	60	60
	40	4	60	60
	50	4	60	60
	63	5	80	75
	80	6	95	80



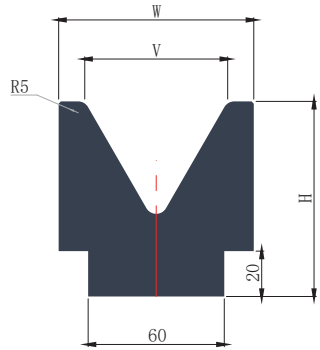
YS20.80 100T/M Max.

A	V	B	R	W	H
80°	100	60	8	120	95
	125	60	15	154	103
	125	90*	15	154	103
	160	60	10	185	130
	160	90*	10	185	130



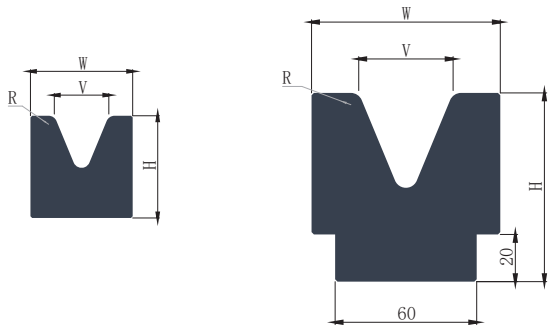
YS20.60 100T/M Max.

A	V	R	W	H
60°	63	5	86	86
	80	6	110	110



YS20.45 100T/M Max.

A	V	R	W	H
45°	32	4	60	80
	40	4	80	80
	50	6	95	95
	63	8	105	105

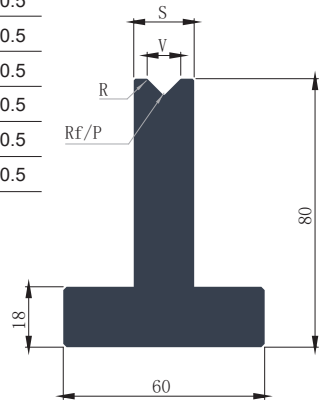


T DIES/T型下模 - H=80mm



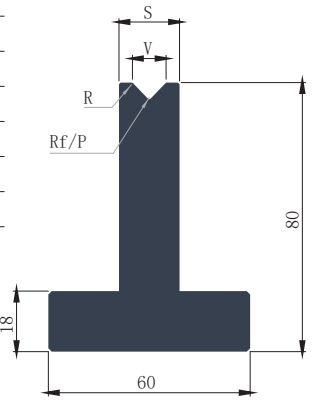
YS10.90 100T/M Max.

A	V	R	W	Rf/P
90°	6	0.4	14	0.5
	8	0.5	14	0.5
	10	0.6	18	0.5
	12	0.8	18	0.5
	16	1	24	0.5
	20	3	30	0.5



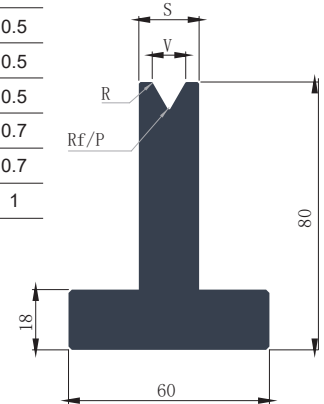
YS10.88 100T/M Max.

A	V	R	W	Rf/P
88°	6	0.4	14	0.5
	8	0.5	14	0.5
	10	0.6	18	0.5
	12	2.75	18	0.5
	16	2.75	24	0.5
	20	3	30	0.5
	25	3	35	0.5



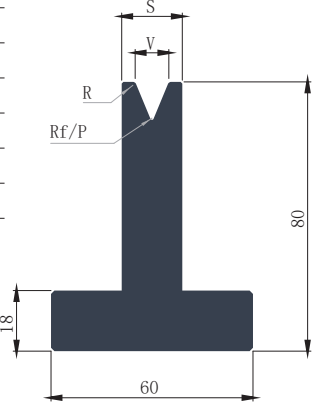
YS10.60 60T/M Max.

A	V	R	W	Rf/P
60°	6	0.4	14	0.5
	8	0.5	14	0.5
	10	0.6	18	0.5
	12	0.8	18	0.5
	16	3	24	0.7
	20	3	30	0.7
	25	3	35	1



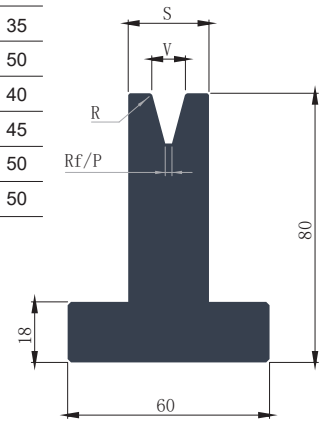
YS10.45 50T/M Max.

A	V	R	W	Rf/P
45°	6	0.6	14	0.5
	8	0.8	18	0.5
	10	1	18	0.7
	12	1.5	24	0.7
	16	2	24	1
	20	2.5	30	1
	25	3	35	1



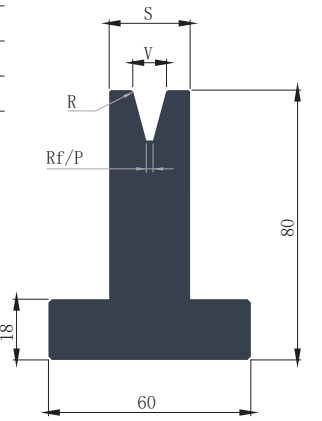
YS10.30

A	V	R	W	Rf/P	T/M Max
30°	6	0.6	14	1	35
	8	0.8	18	2	35
	10	1	24	2	50
	12	1.5	24	2	40
	16	2	30	5	45
	20	2.5	35	5	50
	25	3	40	5	50



YS10.26 20T/M Max.

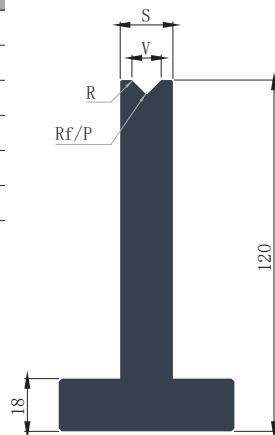
A	V	R	W	Rf/P
26°	6	0.6	16	1
	8	0.8	20	2
	10	1	24	2
	12	1.5	26	2



T DIES/T型下模 - H=120mm

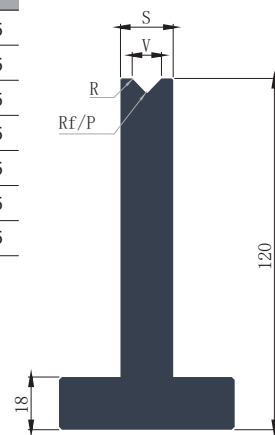
YS12.90 100T/M Max.

A	V	R	W	Rf/P
6	0.4	14	0.5	
8	0.5	14	0.5	
10	0.6	18	0.5	
12	0.8	18	0.5	
16	1	24	0.5	
20	3	30	0.5	



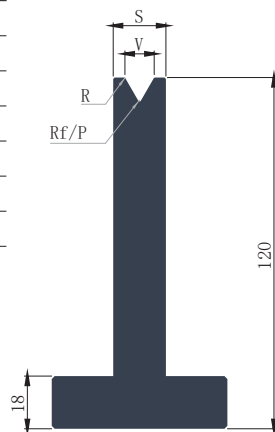
YS12.88 100T/M Max.

A	V	R	W	Rf/P
6	0.4	14	0.5	
8	0.5	14	0.5	
10	0.6	18	0.5	
12	2.75	18	0.5	
16	2.75	24	0.5	
20	3	30	0.5	
25	3	35	0.5	



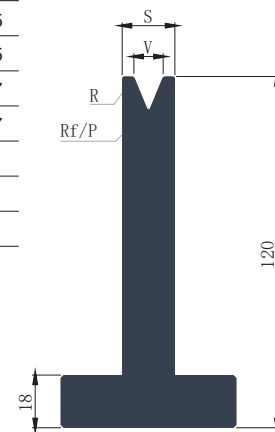
YS12.60 60T/M Max.

A	V	R	W	Rf/P
6	0.4	14	0.5	
8	0.5	14	0.5	
10	0.6	18	0.5	
12	0.8	18	0.5	
16	3	24	0.7	
20	3	30	0.7	
25	3	35	1	



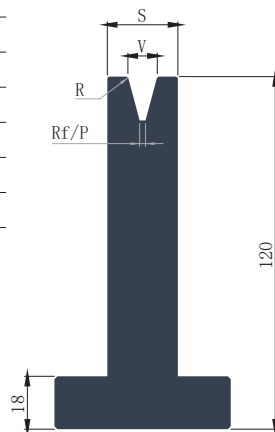
YS12.45 50T/M Max.

A	V	R	W	Rf/P
6	0.6	14	0.5	
8	0.8	18	0.5	
10	1	18	0.7	
12	1.5	24	0.7	
16	2	24	1	
20	2.5	30	1	
25	3	35	1	



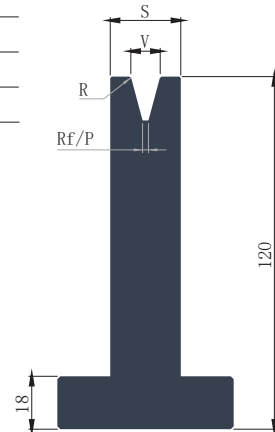
YS12.30

A	V	R	W	Rf/P	T/M Max
6	0.6	14	1	35	
8	0.8	18	2	35	
10	1	24	2	50	
12	1.5	24	2	40	
16	2	30	5	45	
20	2.5	35	5	50	
25	3	40	5	50	



YS12.26 20T/M Max.

A	V	R	W	Rf/P
6	0.6	16	1	
8	0.8	20	2	
10	1	24	2	
12	1.5	26	2	

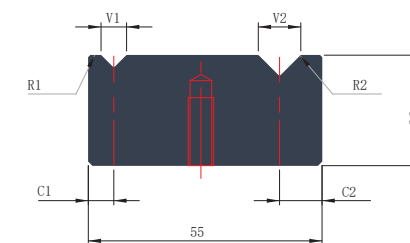


2V DIES/双V同芯下模 - H=26mm



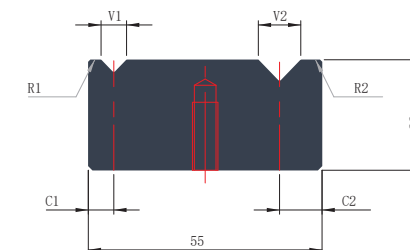
YS60.90 100T/M Max.

A	V1	V12	R1	R2	C1	C2	W	H
90°	4	7	0.3	0.5	4	7	55	26
	6	10	0.4	0.6	6	10		
	8	12	0.5	0.8	8	10		



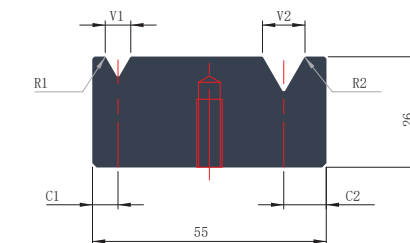
YS60.88 100T/M Max.

A	V1	V12	R1	R2	C1	C2	W	H
88°	6	10	0.4	0.6	6	10	55	26
	8	12	0.5	0.8	8	10		
	12	20	2.75	3	10	15		
	14	18	2.75	3	11	13		
	16	25	2.75	3	12	16.5		



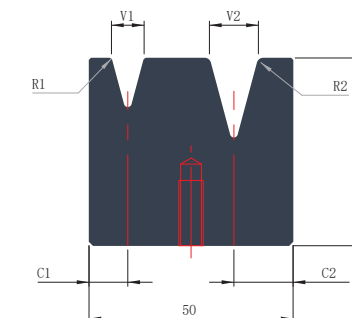
YS60.60 60T/M Max.

A	V1	V12	R1	R2	C1	C2	W	H
60°	6	10	0.5	0.8	6	10	55	26
	8	12	0.5	0.8	8	10		
	12	20	0.8	3	10	15		
	16	25	3	3	12	16.5		



YS60.30 40T/M Max.

A	V1	V12	R1	R2	C1	C2	W	H
30°	8	12	0.8	1.5	9.5	14.5	50*	46*

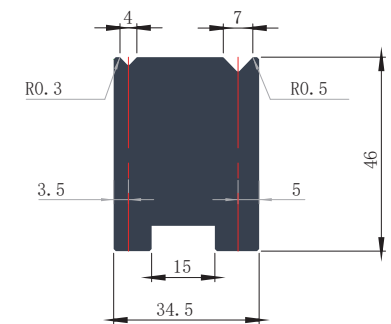


2V DIES/双V同芯下模 - H=46mm

YS501 100T/M Max.

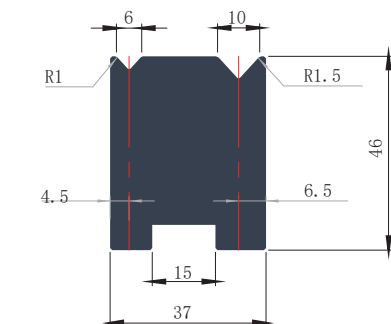
A

90°/88°


YS502 100T/M Max.

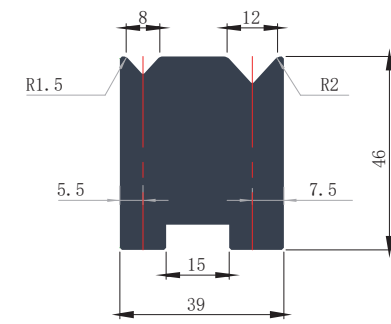
A

90°/88°


YS503 100T/M Max.

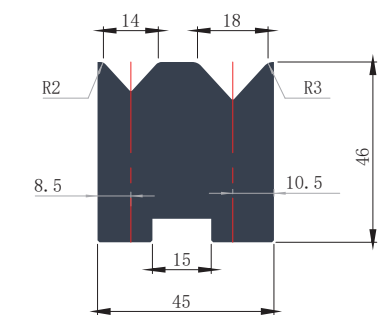
A

90°/88°


YS504 100T/M Max.

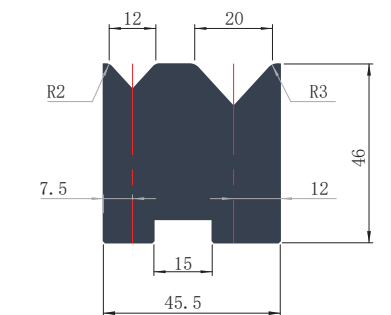
A

90°/88°


YS505 100T/M Max.

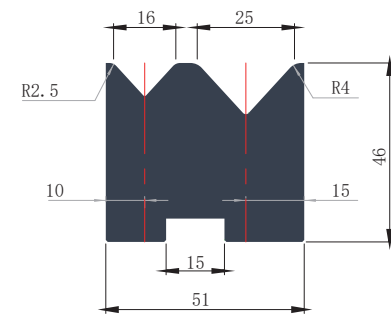
A

90°/88°


YS506 100T/M Max.

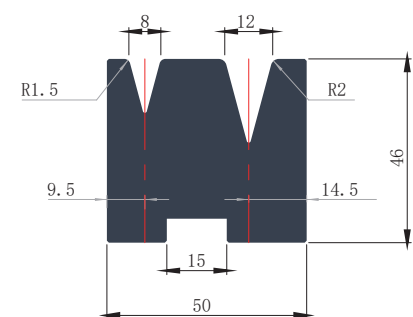
A

90°/88°


YS507 40T/M Max.

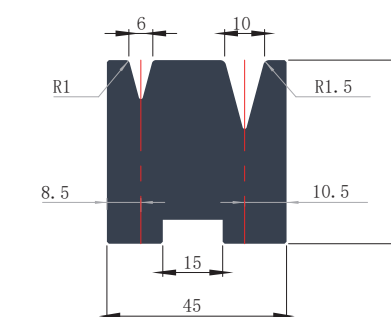
A

30°


YS508 40T/M Max.

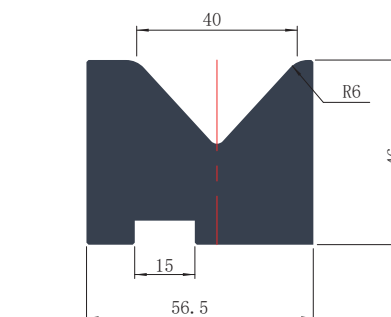
A

30°


YS509 100T/M Max.

A

85°

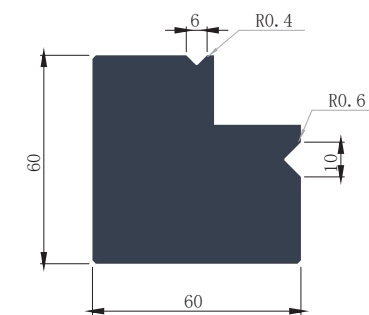


MULTI V DIES/多V下模


YS206 100T/M Max.

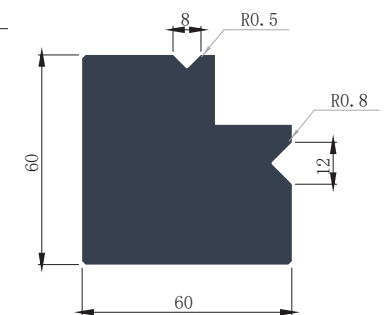
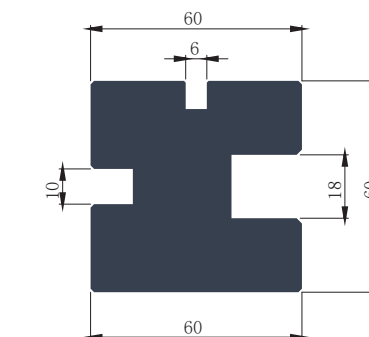
A

90°


YS207 100T/M Max.

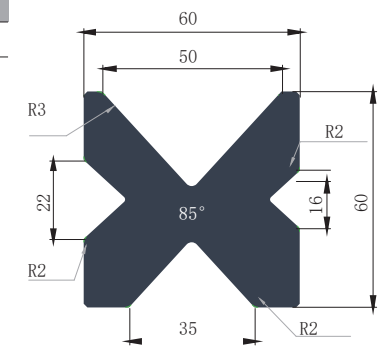
A

90°


YS208 100T/M Max.

YS209 80T/M Max.

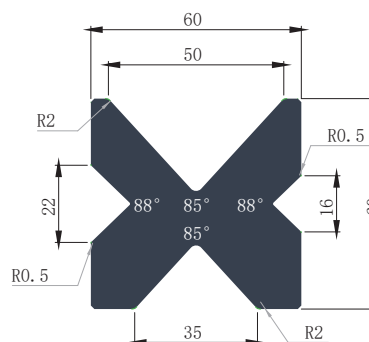
A

85°


YS209.85 80T/M Max.

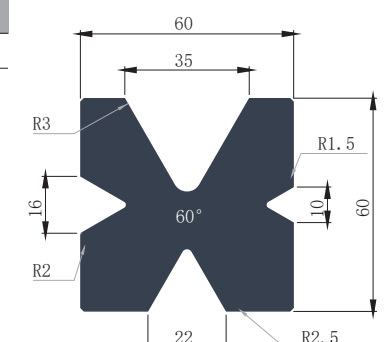
A

85°-88°


YS209.60 80T/M Max.

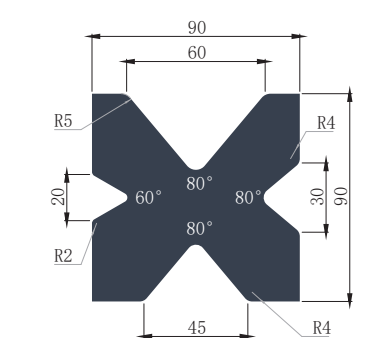
A

60°


YS210.60 80T/M Max.

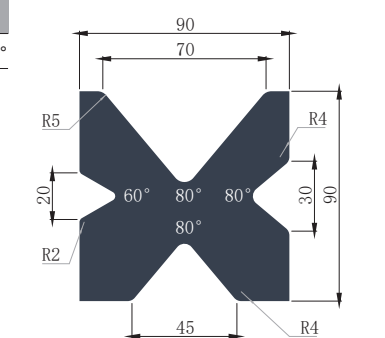
A

60°-80°


YS210.70 80T/M Max.

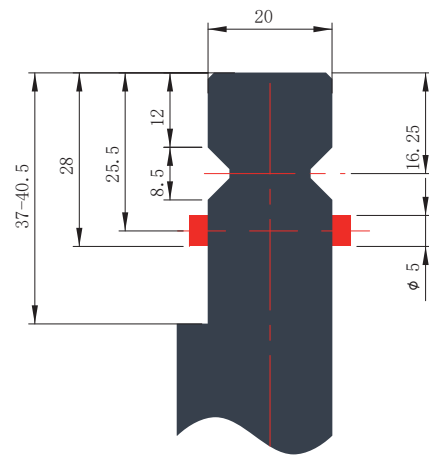
A

60°-80°



CLAMPING TYPES/装夹形式

Pressure bearing surface at top
承压面在顶部

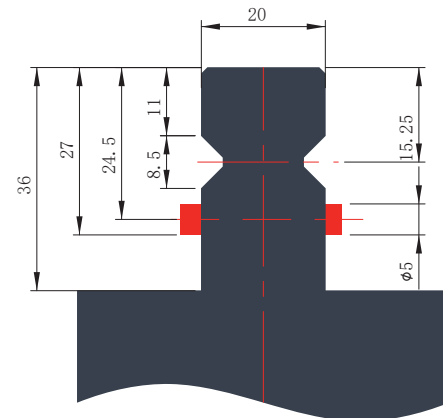


Safty Button/按钮

- Easy to install, can installed directly from below
便于安装, 可直接从下方安装
- Reducing install time
减少安装时间成本
- Suitable for punch with weight < 12.5kg
适用于重量<12.5kg的上模



Pressure bearing surface at shoulder
承压面在肩膀



Safty Pin/插销

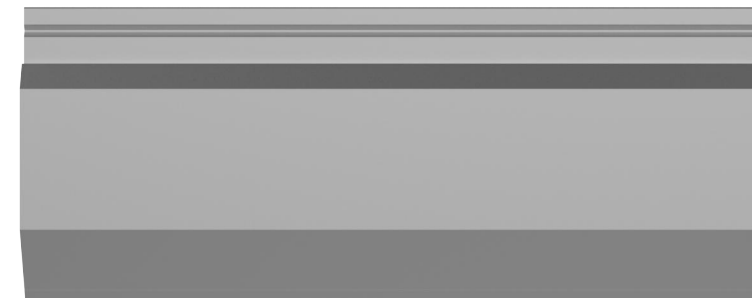
- Install from side
从侧面安装
- Suitable for all punches
适用于所有上模



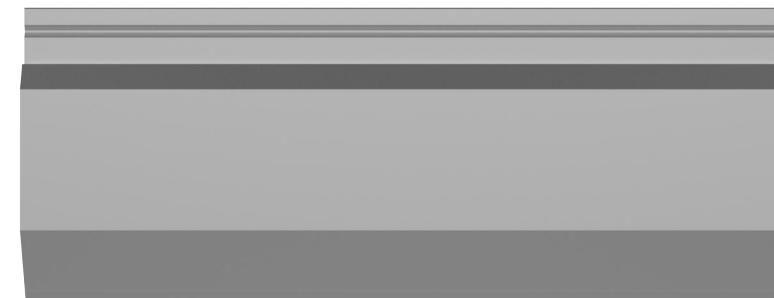
STANDARD SEGMENTATION/标准分段



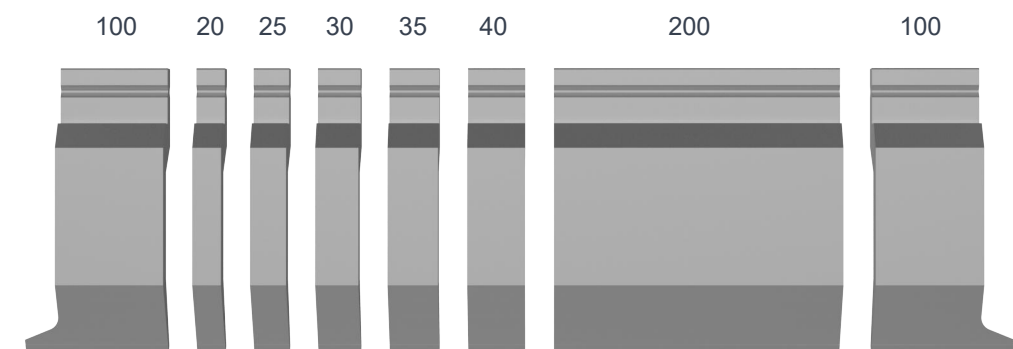
500mm



505mm

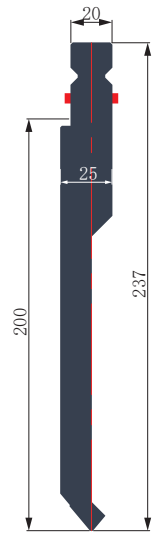


550mm Segmentation/分段-8段

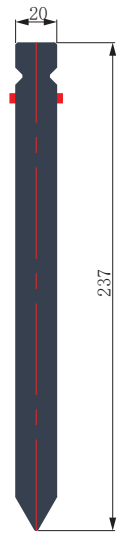


PUNCHES/上模 - 90°/86°

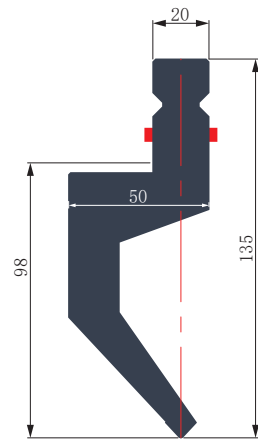
WAL237.90.R0660T/M Max.			
A	R	H	
90°	0.6	237	



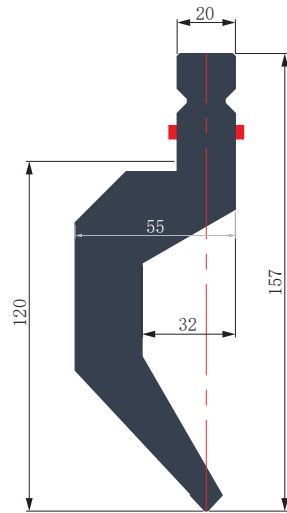
WAL237.90.R1100T/M Max.			
A	R	H	
90°	1	237	



WAL135.86.R165T/M Max.			
A	R	H	
86°	1	135	



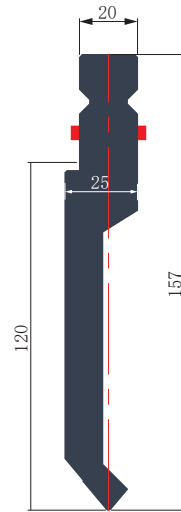
WAL157.86.R180T/M Max.			
A	R	H	
86°	1	157	



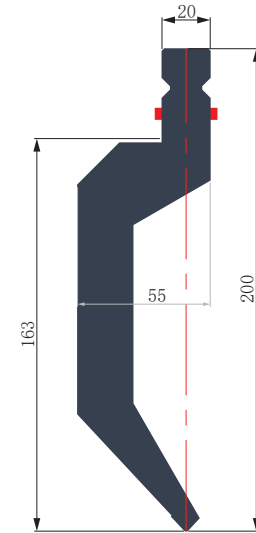
PUNCHES/上模 - 86°



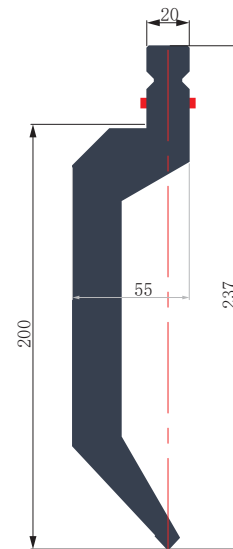
WAL157.86.R1A80T/M Max.			
A	R	H	
86°	1	157	



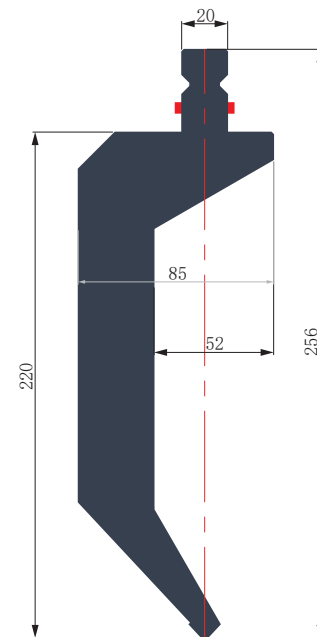
WAL200.86.R150T/M Max.			
A	R	H	
86°	1	200	



WAL237.86.R150T/M Max.			
A	R	H	
86°	1	237	

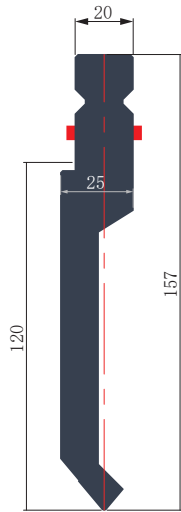


WAL256.86.R180T/M Max.			
A	R	H	
86°	1	256	

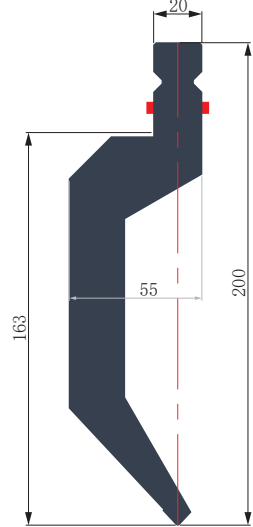


PUNCHES/上模 - 86°

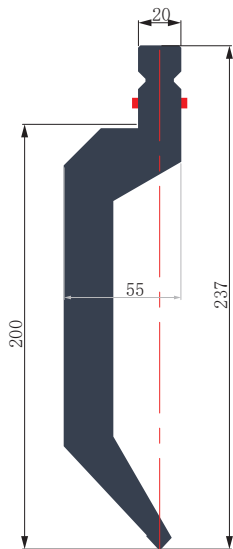
WAL157.86.R1A			80T/M Max.
A	R	H	
86°	1	157	



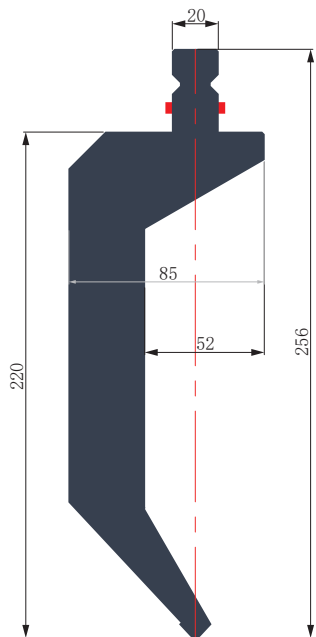
WAL200.86.R1			50T/M Max.
A	R	H	
86°	1	200	



WAL237.86.R1			50T/M Max.
A	R	H	
86°	1	237	



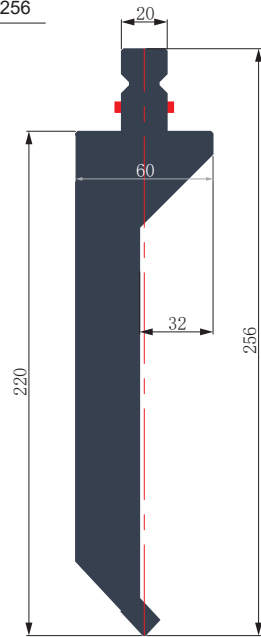
WAL256.86.R1			80T/M Max.
A	R	H	
86°	1	256	



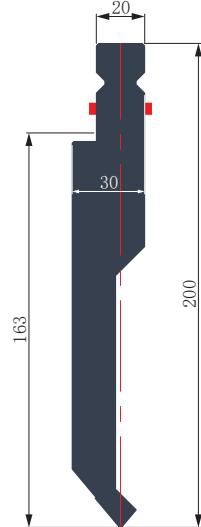
PUNCHES/上模 - 86°/80°/60°



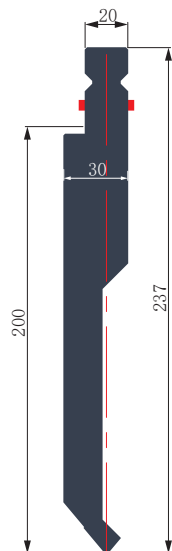
WAL256.86.R1A			80T/M Max.
A	R	H	
86°	0.6	256	



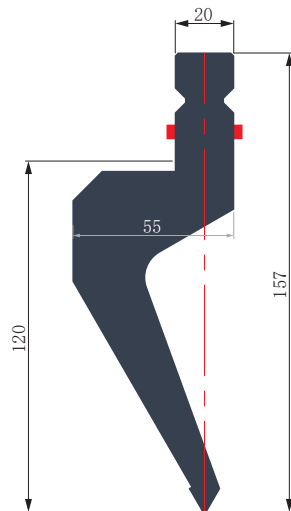
WAL200.80.R1			80T/M Max.
A	R	H	
80°	1	200	



WAL237.80.R1			80T/M Max.
A	R	H	
80°	1	237	



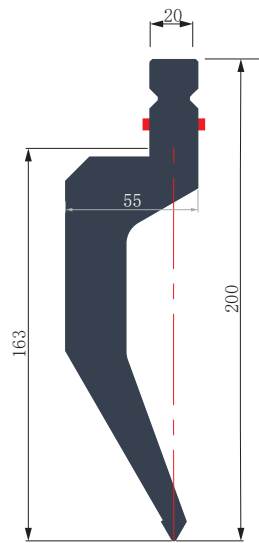
WAL157.60.R1			70T/M Max.
A	R	H	
60°	1	157	



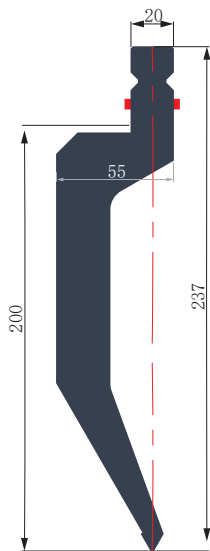
PUNCHES/上模 - 60°



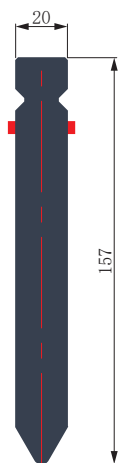
WAL200.60.R1			70T/M Max.
A	R	H	
60°	1	200	



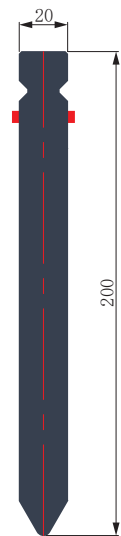
WAL237.60.R1			70T/M Max.
A	R	H	
60°	1	237	



WAL157.60.R4			100T/M Max.
A	R	H	
60°	4	157	

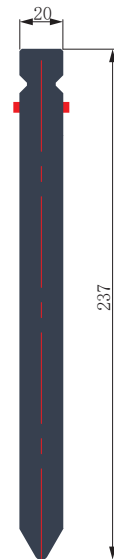


WAL200.60.R3			100T/M Max.
A	R	H	
60°	3	200	

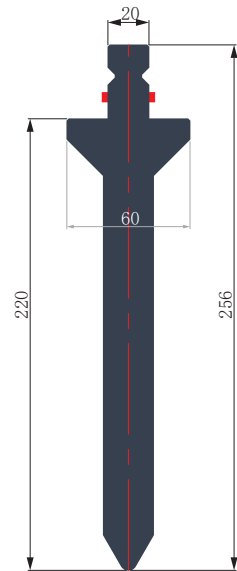


PUNCHES/上模 - 60°/28°

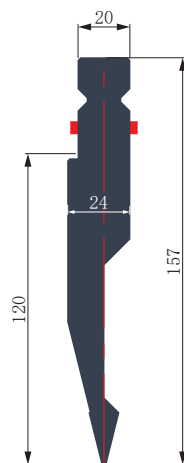
WAL237.60.R3			100T/M Max.
A	R	H	
60°	3	237	



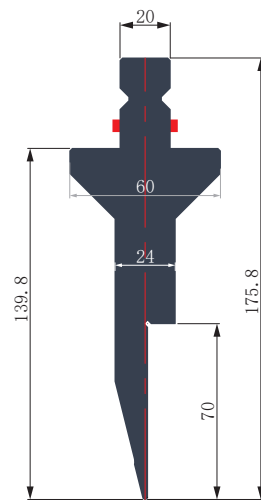
WAL256.60.R4			100T/M Max.
A	R	H	
60°	4	256	



WAL157.28.R1			60T/M Max.
A	R	H	
28°	1	157	

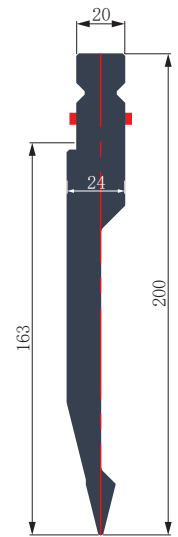


WAL176.28.R1			40T/M Max.
A	R	H	
28°	1	175.8	

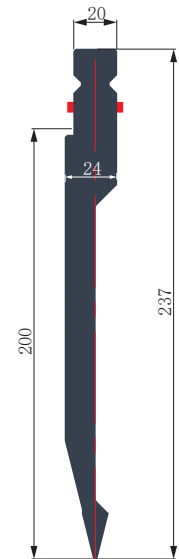


PUNCHES/上模 - 28°

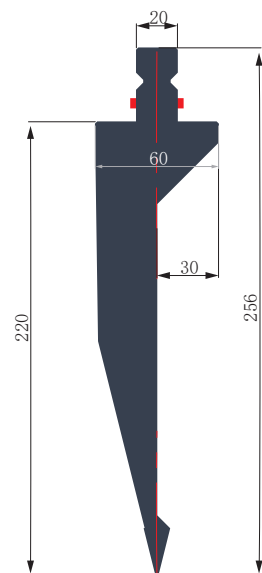
WAL200.28.R1			60T/M Max.
A	R	H	
28°	1	200	



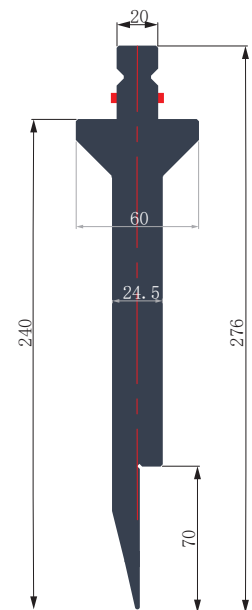
WAL237.28.R1			60T/M Max.
A	R	H	
28°	1	237	



WAL256.28.R1			60T/M Max.
A	R	H	
28°	1	256	



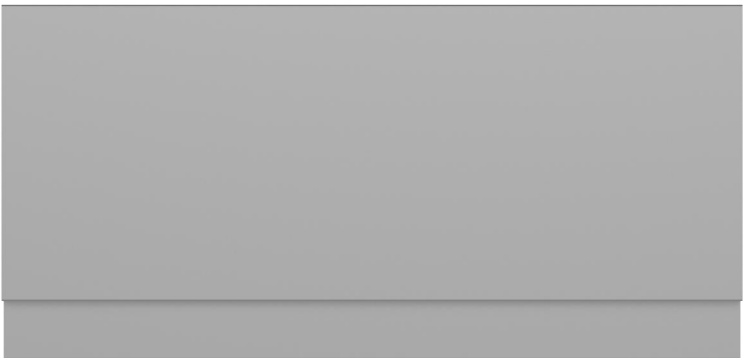
WAL276.28.R1			40T/M Max.
A	R	H	
28°	1	276	



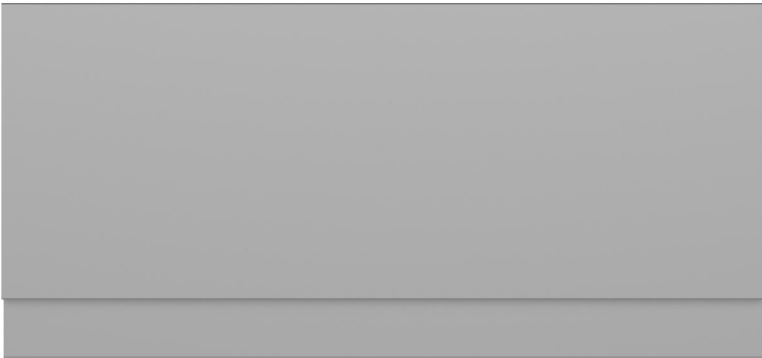
STANDARD SEGMENTATION/标准分段



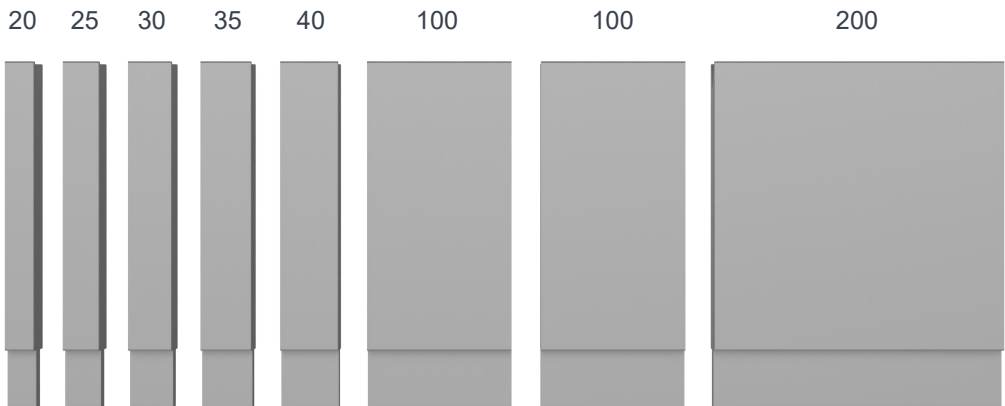
500mm



505mm



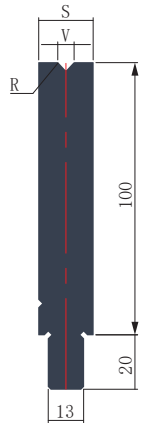
550mm Segmentaion/分段-8段



SINGLE V DIES/单V下模 - H=100mm

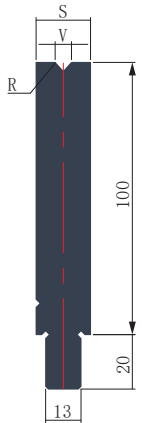
WAY100.86 100T/M Max.

A	V	R	S
86°	6	0.6	20
	8	0.8	20
	10	1	20
	12	1	25
	16	1.6	30
	20	2	30
	24	2.5	35
	30	3	45
	40	3	55
	50	3	75



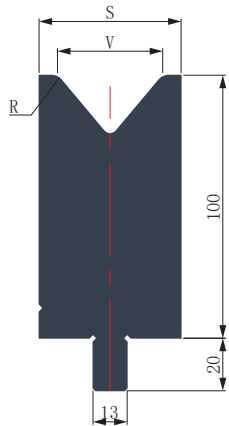
WAY100.84 100T/M Max.

A	V	R	S
84°	6	0.6	20
	8	0.8	20
	10	1	20
	12	1	25
	16	1.6	30
	20	2	30



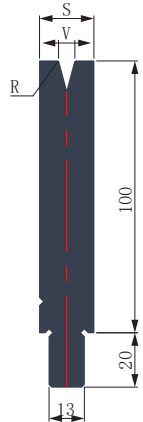
WAY100.80 100T/M Max.

A	V	R	S
80°	24	2.5	35
	30	5	45
	40	5	55
	50	5	65
	60	5	75
	70	5	85
	80	5	100
	90	8	110
	100	8	120



WAY100.30 40T/M Max.

A	V	R	S
30°	6	0.6	20
	8	1	20
	10	1	20
	12	1	25
	16	1.6	30
	20	2	35
	24	2.5	40
	30	3	55
	40	5	60
	50	5	75

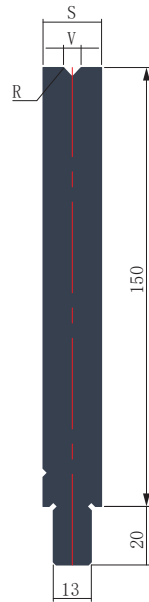


SINGLE V DIES/单V下模 - H=150mm



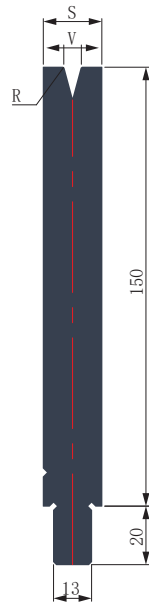
WAY150.86 100T/M Max.

A	V	R	S
86°	6	0.6	20
	8	0.8	20
	10	1	20
	12	1	25
	16	1.6	30
	20	2	30
	24	2.5	35



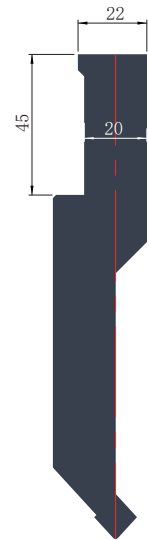
WAY150.30 50T/M Max.

A	V	R	S
30°	6	0.6	20
	8	1	20
	10	1	20
	12	1	25
	16	1.6	30
	20	2	35
	24	2.5	40



CLAMPING TYPES/装夹形式

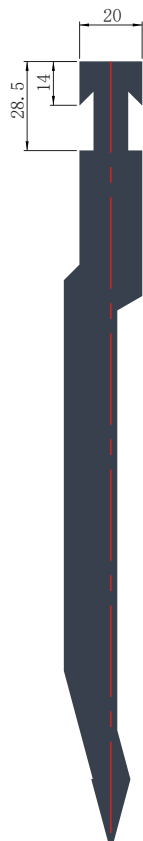
S



R



RF



RFA



STANDARD SEGMENTATION/标准分段



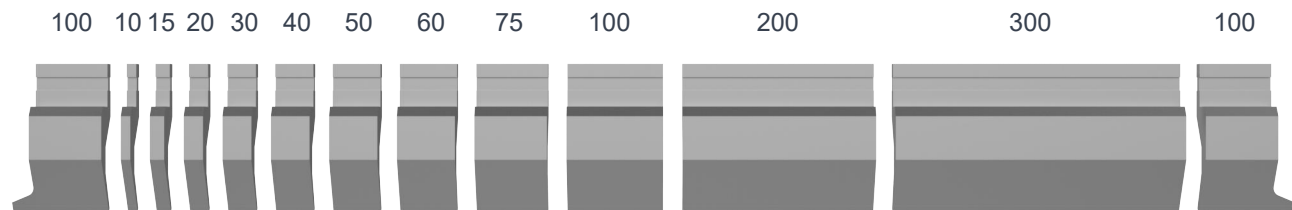
500mm



1000mm



1100mm Segmentation/分段-13段

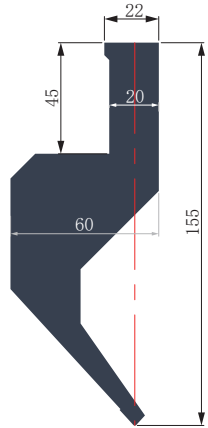


PUNCHES/上模 - 85°/30°/28°



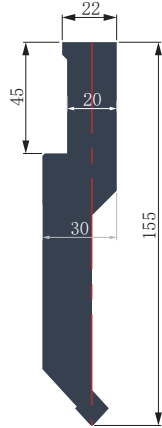
BCL155.85.R08-S 50T/M Max.

A	R	H
85°	0.8	155



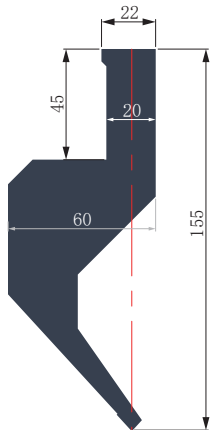
BCL155.85.R1-S 100T/M Max.

A	R	H
85°	1	155



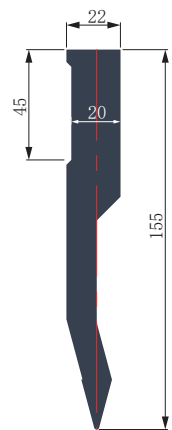
BCL155.85.R15-S 50T/M Max.

A	R	H
85°	1.5	155



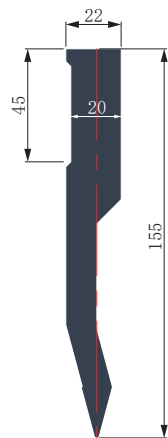
BCL155.30.R1-S 80T/M Max.

A	R	H
30°	1	155



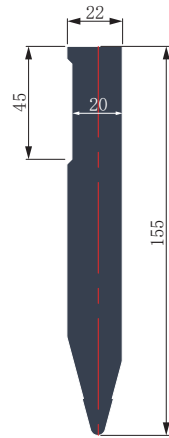
BCL155.28.R1-S 50T/M Max.

A	R	H
28°	1	155



BCL155.28.R3-S 100T/M Max.

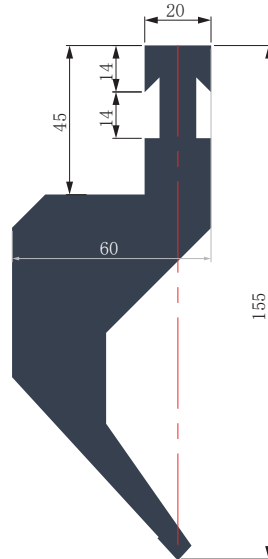
A	R	H
28°	3	155



PUNCHES/上模 - 85°/30°/28°

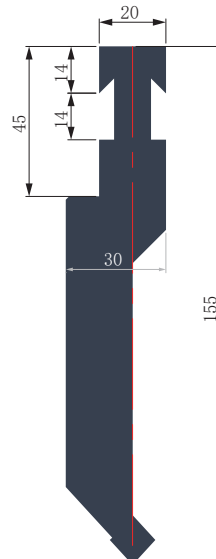
BCL155.85.R08-R 50T/M Max.

A	R	H
85°	0.8	155
	1.5	



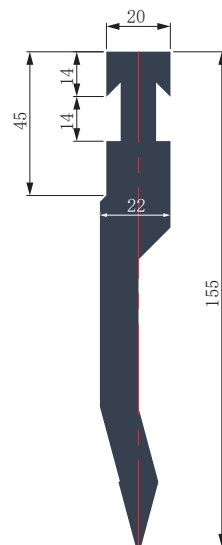
BCL155.85.R1-R 100T/M Max.

A	R	H
85°	1	155



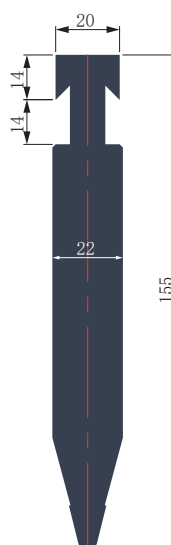
BCL155.30.R1-R 80T/M Max.

A	R	H
30°	1	155
28°		



BCL155.28.R3-R 100T/M Max.

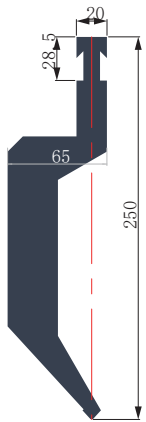
A	R	H
28°	3	155



PUNCHES/上模 - 88°/85°/30°/26°

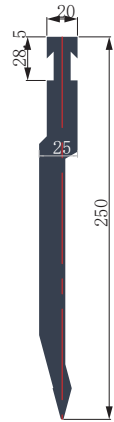
BCL250.85.R15-RF 100T/M Max.

A	R	H
85°	1.5	250



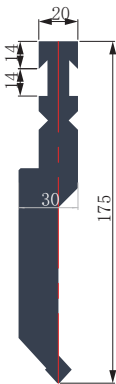
BCL250.26.R1-RF 90T/M Max.

A	R	H
26°	1	250



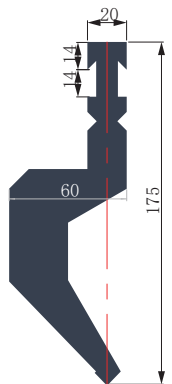
BCL175.88.R1-RFA 100T/M Max.

A	R	H
88°	1	175



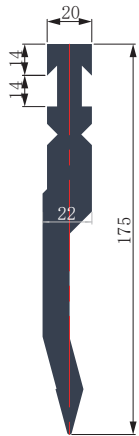
BCL175.88.R15-RFA 50T/M Max.

A	R	H
88°	1.5	175



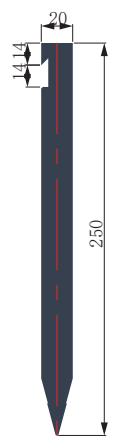
BCL175.30.R1-RFA 90T/M Max.

A	R	H
30°	1	175



BCL250.30.R1-RFA 100T/M Max.

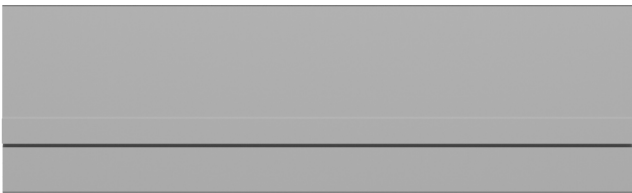
A	R	H
30°	1	250



STANDARD SEGMENTATION/标准分段



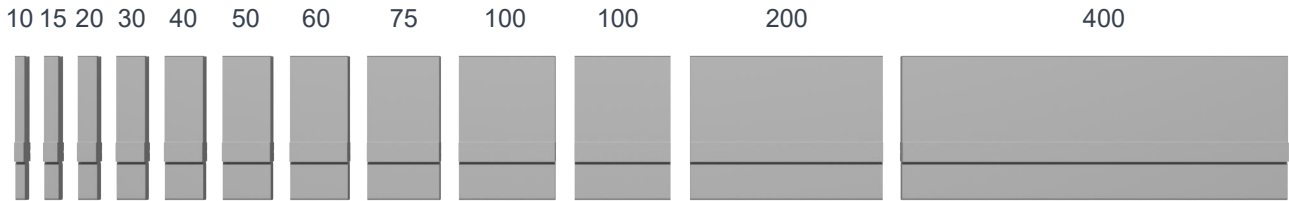
500mm



1000mm



1100mm Segmentaion/分段-12段



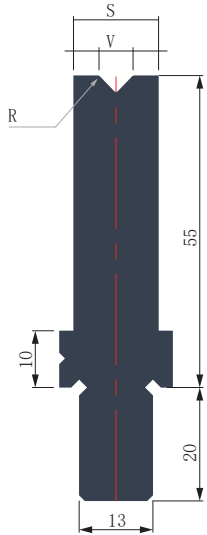
SINGLE V DIES/单V下模 - H=55mm

RADIUS HOLDERS/模柄



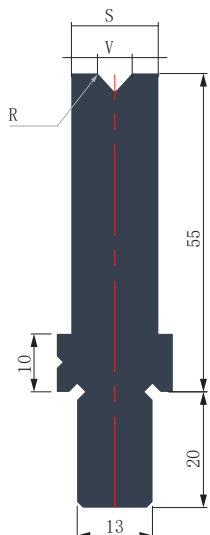
BCY55.88 100T/M Max.

A	V	R	S
90°/88°	6	0.4	15
	8	0.5	15
	10	1	20
	12	1.5	20
88°	16	2	30
	20	2	30
	24	3	40



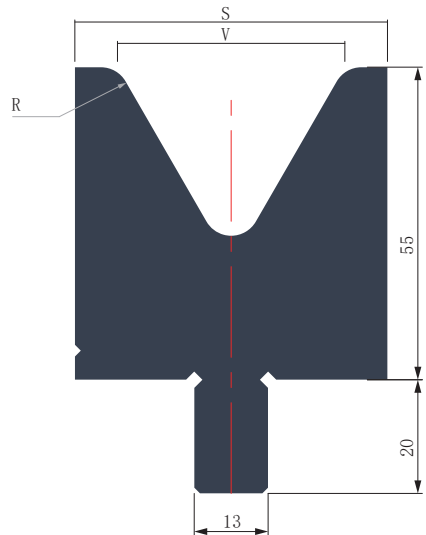
BCY55.85 100T/M Max.

A	V	R	S
85°	6	0.4	15
	8	0.5	15
	10	1	20
	12	1.5	20
	16	2	30
	20	2	30
	24	3	40
	32	4	50
	40	4	55



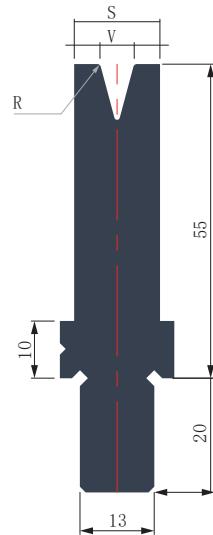
BCY55.60 100T/M Max.

A	V	R	S
60°	40	5	55
	50	5	70
	60	7	80



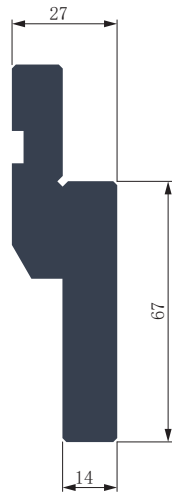
BCY55.30 100T/M Max.

A	V	R	S	T/M Max
30°	6	0.6	15	35
	8	0.8	15	40
	10	1	20	50
	12	1.5	20	40
	16	2	30	50
	20	2.5	35	55
	24	3	40	65
	32	4	60	65



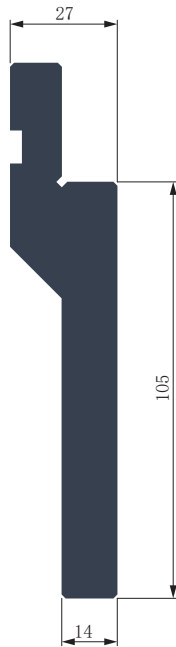
LB01 100T/M Max.

F	H
14	67



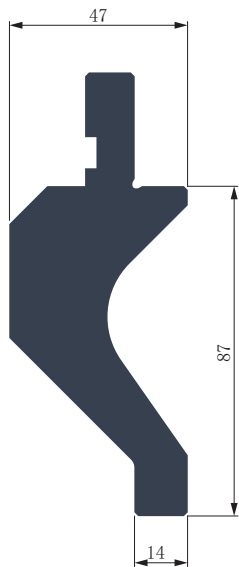
LB02 100T/M Max.

F	H
14	105



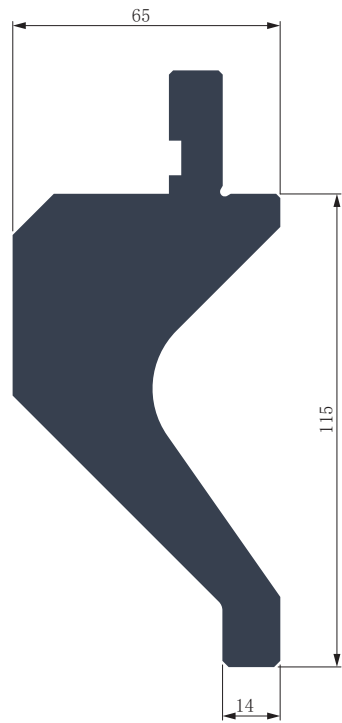
LB03 50T/M Max.

F	H
14	87



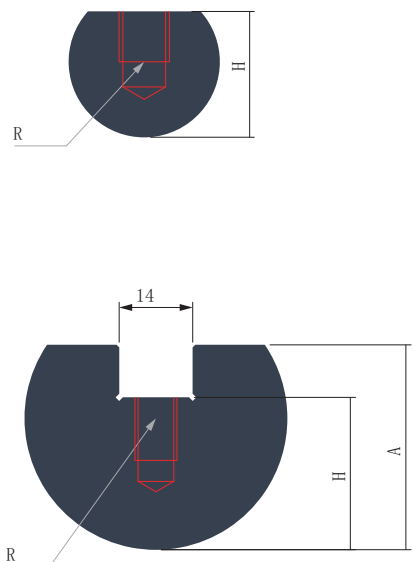
LB04 50T/M Max.

F	H
14	115

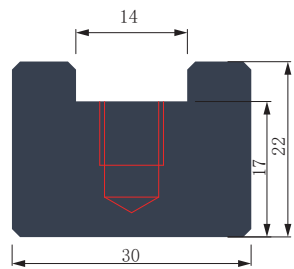


RADIUS INSERTS/模头

LT01 100T/M Max.			
D	R	H	A
14	7	11.5	-
15	7.5	11.5	-
16	8	13	-
18	9	16	-
20	10	16	-
22	11	16	-
23	11.5	16	-
24	12	20	-
25	12.5	17	21
30	15	20	27
35	17.5	22	32
40	20	24	34
45	22.5	25	35
50	25	29	39
55	27.5	34	44
60	30	34	44
70	35	45	55
80	40	45	55
90	45	60	70
100	50	70	80



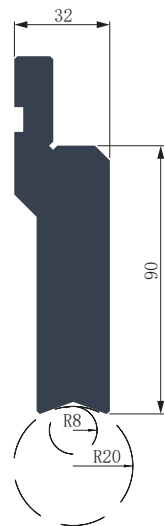
LT02 100T/M Max.	
F	H
30	17



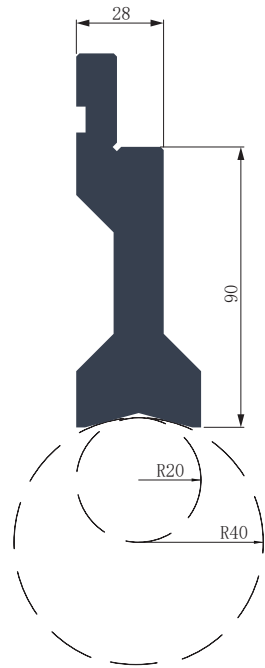
RADIUS HOLDERS/模柄



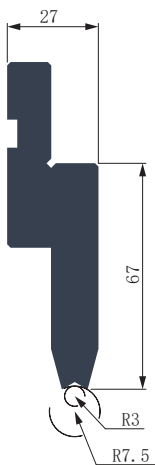
LB05 100T/M Max.	
H	
67	



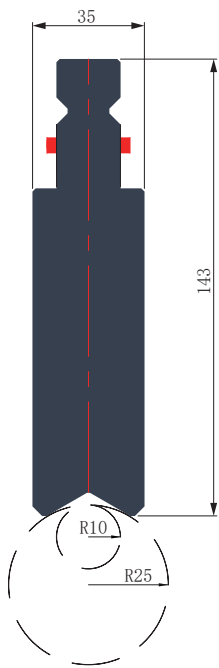
LB06 100T/M Max.	
H	
90	



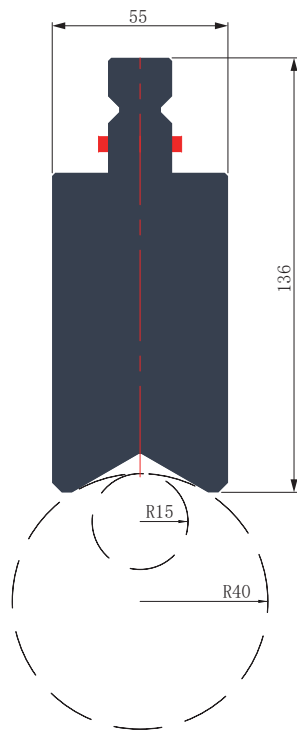
LB07 100T/M Max.	
H	
90	



LB08 50T/M Max.	
H	
106	



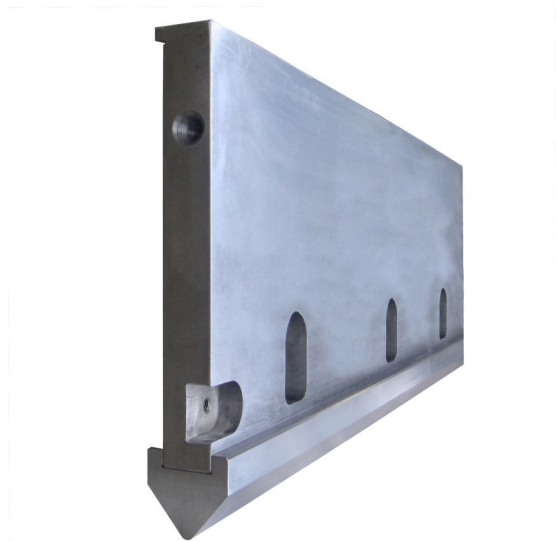
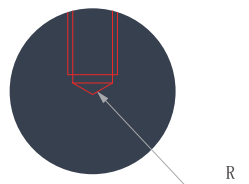
LB09 100T/M Max.	
H	
100	



RADIUS INSERTS/模头

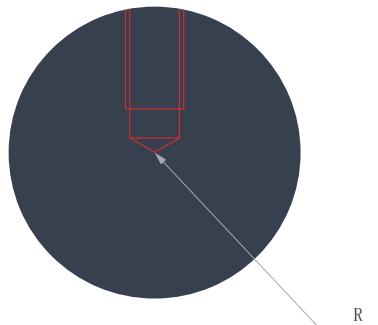
LT03 100T/M Max.

D	R
6	3
7	3.5
8	4
9	4.5
10	5
11	5.5
12	6
13	6.5
14	7
15	7.5



LT04 100T/M Max.

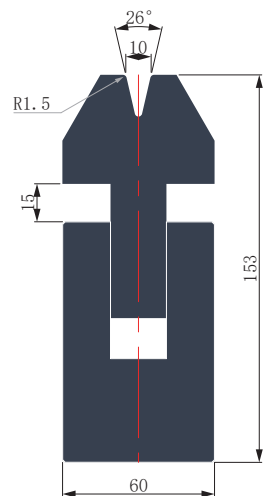
D	R
16	8
20	10
25	12.5
30	15
35	17.5
40	20
45	22.5
50	25
55	27.5
60	30
70	35
80	40



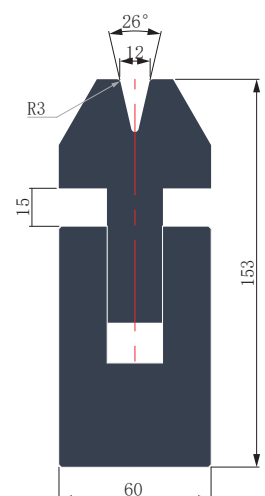
FLATTING - HEMMING TOOLS/折弯压平模具



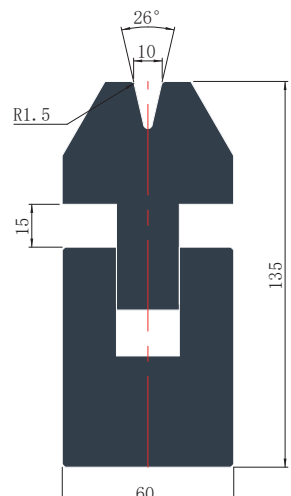
PSS31 26° 100T/M Max.



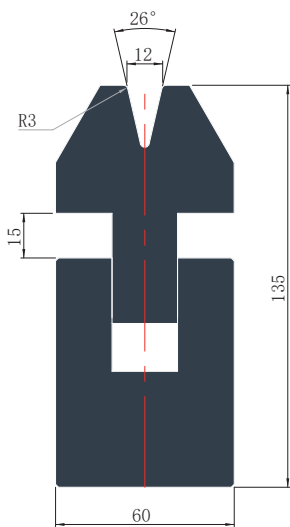
PSS32 26° 100T/M Max.



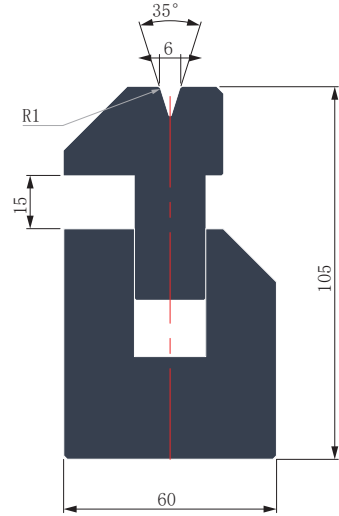
PSS33 26° 100T/M Max.



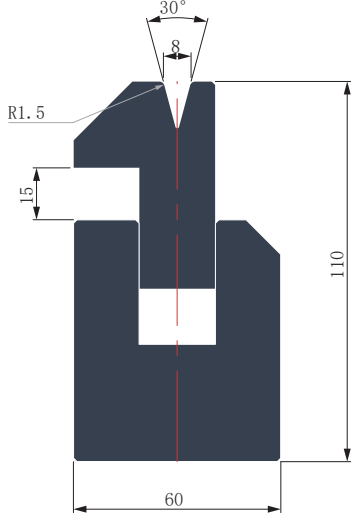
PSS34 26° 100T/M Max.



PSS35 35° 100T/M Max.



PSS36 30° 100T/M Max.



Acc. R. 45kg/mm^q

S(mm)	A(mm)	Ton/M	2×S	Ton/M
0.6	3	9	1.2	23
0.8	3	12	1.6	32
1	3.5	15	2	40
1.25	3.5	17	2.5	50
1.5	4.6	22	3	63
2	5.5	30	4	80
2.5	6.5	55	5	90
3	8	70	6	100

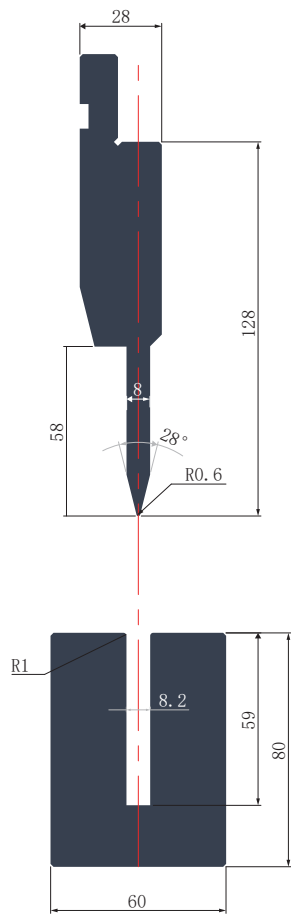
Acc. R. 70kg/mm^q

S(mm)	A(mm)	Ton/M	2×S	Ton/M
0.6	3	15	1.2	35
0.8	3	20	1.6	50
1	3.5	25	2	60
1.25	3.5	26	2.5	80
1.5	4.6	38	3	95
2	5.5	50	4	130

FLATTING - HEMMING TOOLS/折弯压平模具

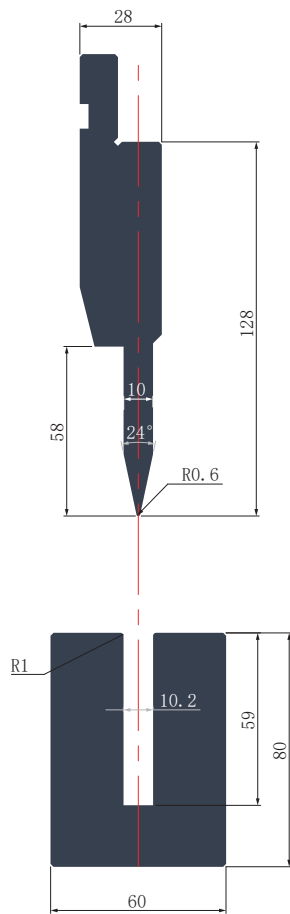


PSS37-L 28° 80T/M Max.



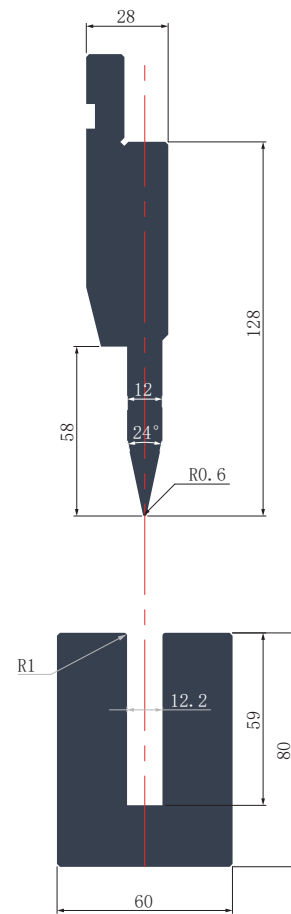
PSS37-Y 80T/M Max.

PSS38-L 24° 80T/M Max.

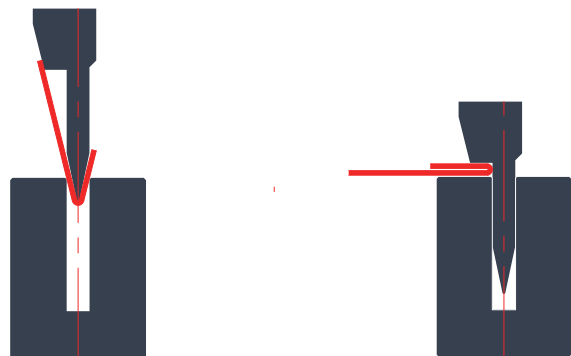


PSS38-Y 80T/M Max.

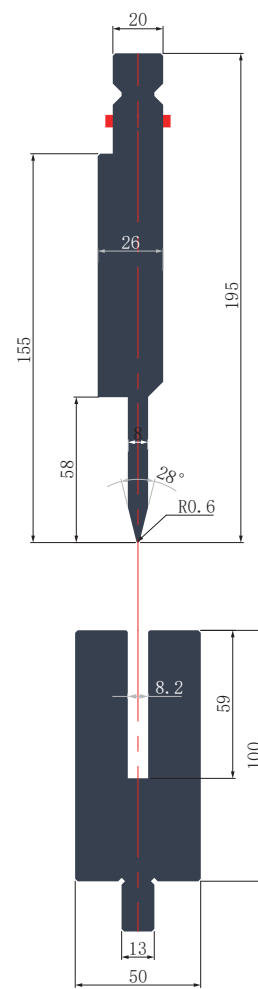
PSS39-L 24° 80T/M Max.



PSS39-Y 80T/M Max.

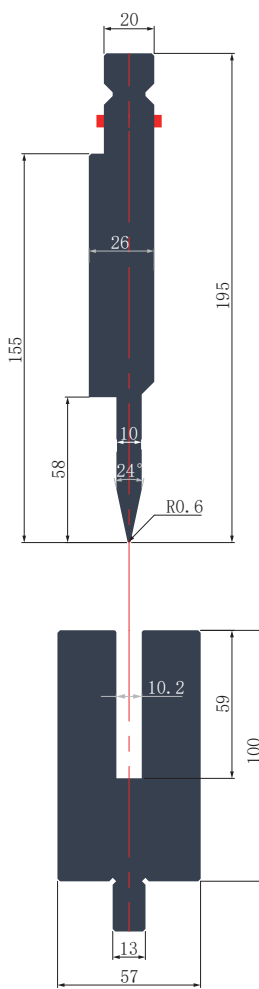


PSS40-L 28° 80T/M Max.



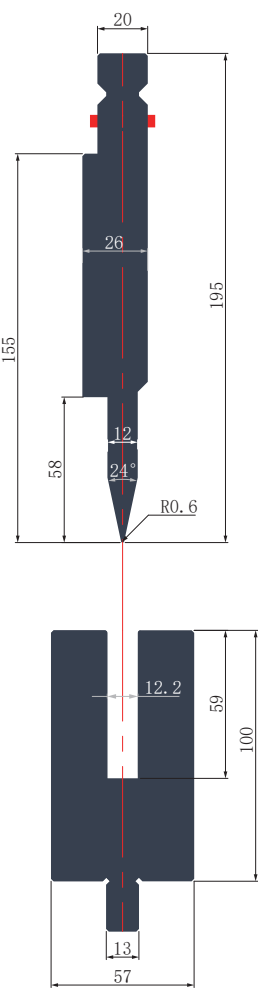
PSS40-Y 80T/M Max.

PSS41-L 24° 80T/M Max.

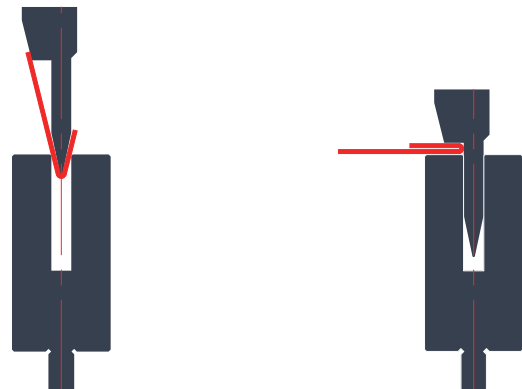


PSS41-Y 80T/M Max.

PSS42-L 24° 80T/M Max.



PSS42-Y 80T/M Max.



SPECIAL TOOLS

SPECIAL TOOLS

FLATTING - HEMMING TOOLS/折弯压平模具

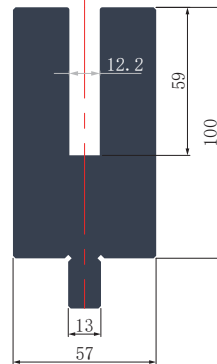
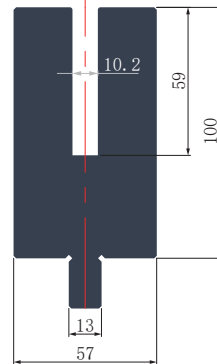
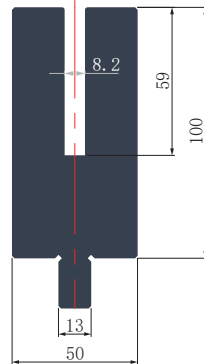
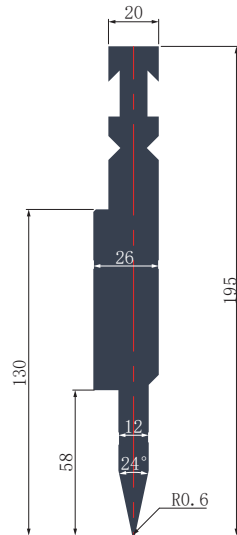
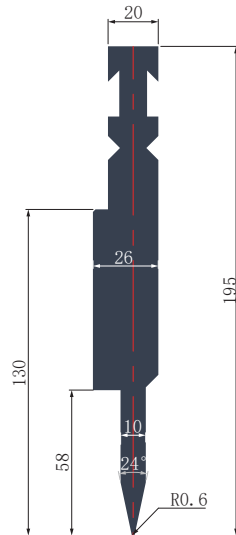
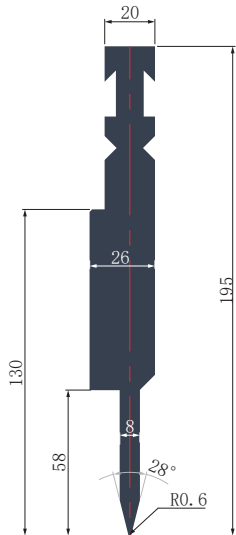
JOOGLE TOOLS/段差模具



PSS43-L 28° 80T/M Max.

PSS44-L 24° 80T/M Max.

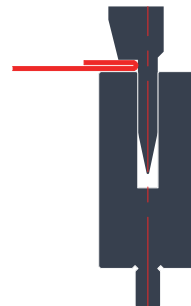
PSS45-L 24° 80T/M Max.



PSS43-Y 80T/M Max.

PSS44-Y 80T/M Max.

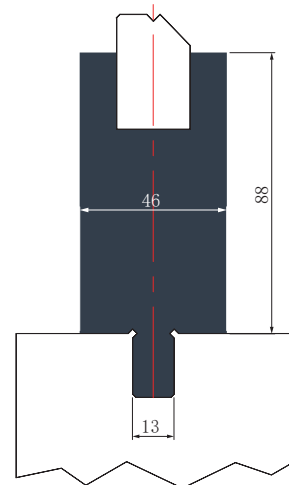
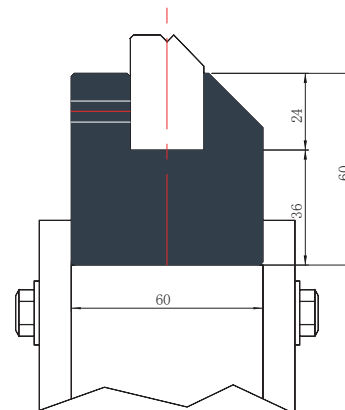
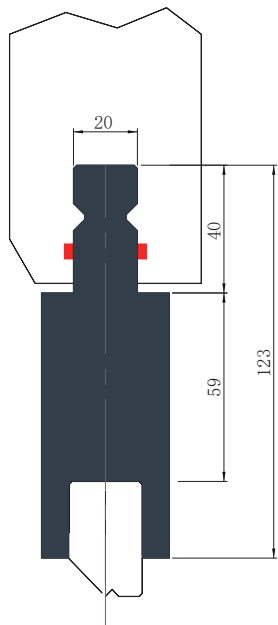
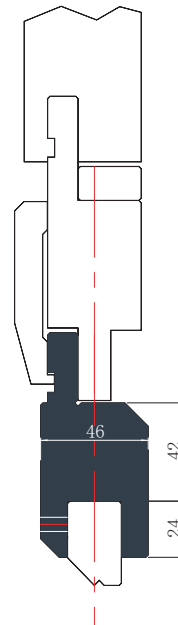
PSS45-Y 80T/M Max.



DC01

DC02

100T/M Max.



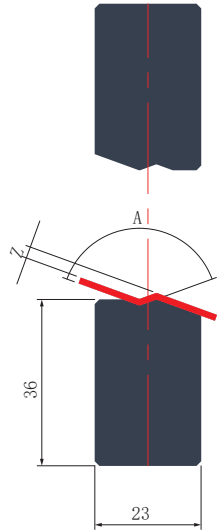
SPECIAL TOOLS

SPECIAL TOOLS



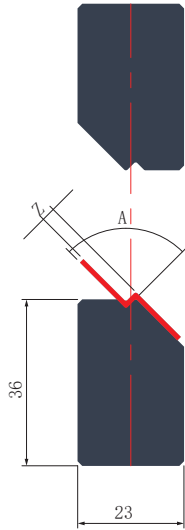
DC-Z 01

A	Z	S
160°	1	1.2
160°	1.5	1.5
150°	2	1.4
140°	2.5	1.3



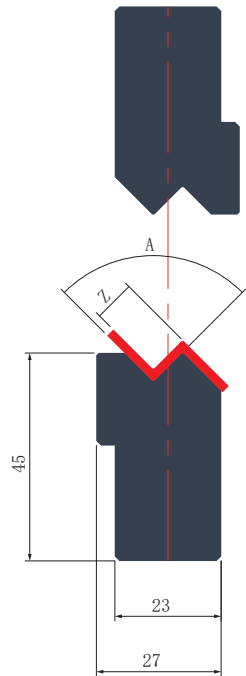
DC-Z 02

A	Z	S
90°	1	0.3
90°	1.5	0.3
90°	2	0.4
90°	2.5	0.5
90°	3	1
90°	3.5	1
90°	4	1.2
90°	4.5	1.2
90°	5	1.3
90°	5.5	1.4
90°	6	1.5
90°	6.5	1.5
90°	7	1.5
90°	7.5	1.6
90°	8	1.6



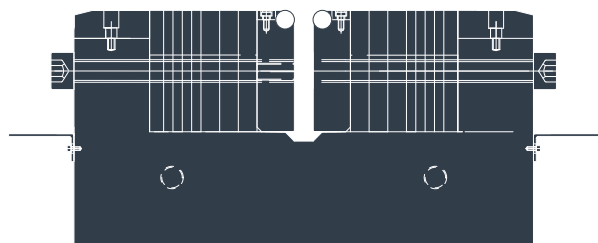
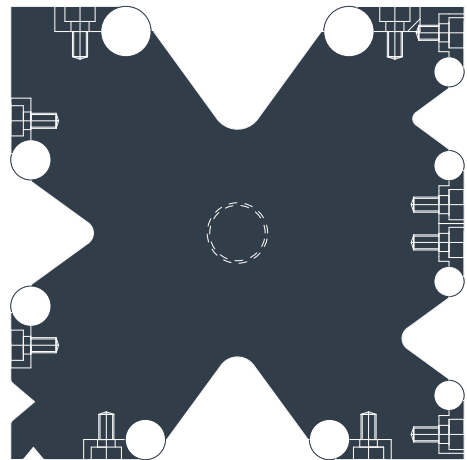
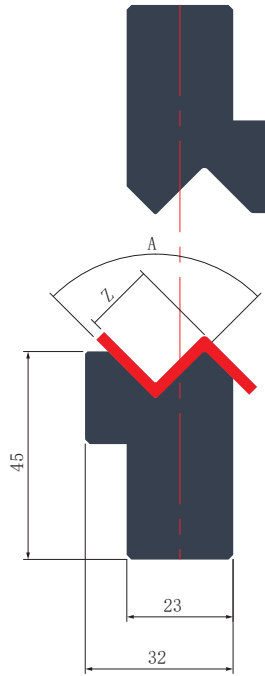
DC-Z 03

A	Z	S
90°	9	1.8
90°	10	1.8
90°	11	2
90°	12	2



DC-Z 04

A	Z	S
90°	13	2
90°	14	2
90°	15	2.3

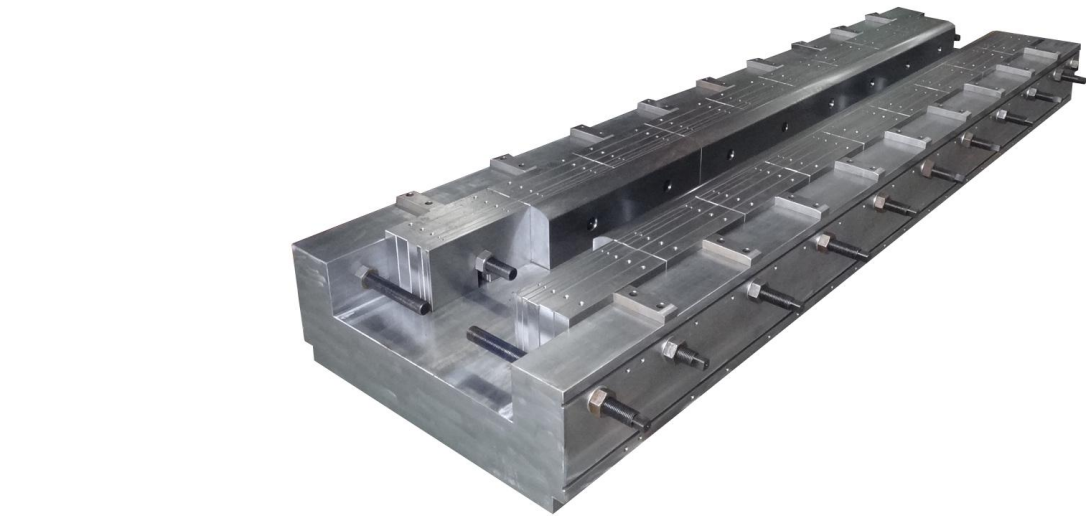
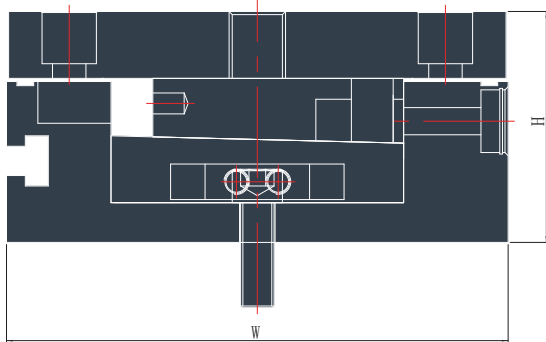


SCRATCH RESISTANCE DIE/无压痕模具

HORIZONTAL CROWNING/横向多点挠度补偿

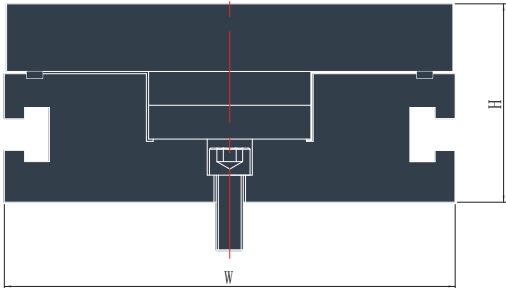


BGT-A1						
L (mm)	W (mm)	H (mm)	Max. Compensation 最大补偿值	Adjustment 调节方式		
2500	180	95	1.0	Manual/手动		
3200						
4100						
6000						
2500	200				1.0	
3200						
4100						
6000						
2500	220					1.0
3200						
4100						
6000						
3200	240		1.2			
4100			2.0			
6000						
3200	280	100	1.2			
4100			2.0			
6000						

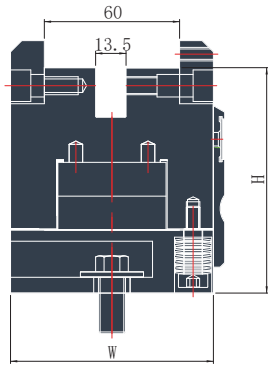


VERTICAL CROWNING/纵向挠度补偿

BGT-B1				
L (mm)	W (mm)	H (mm)	Max. Compensation 最大补偿值	Adjustment 调节方式
2500	180	95	2.0	Manual/Motor 手动/电动
3200				
4100				
2500	200			
3200				
4100				
2500	220			
3200				
4100				
3200	240			
4100				
6000				
3200	280	100		
4100				
6000				



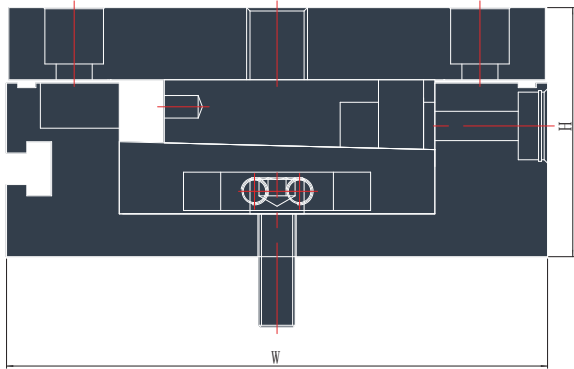
BGT-B2				
L (mm)	W (mm)	H (mm)	Max. Compensation 最大补偿值	Adjustment 调节方式
1250	100	95	2.0	Manual/Motor 手动/电动
1500				
2050				
2500				
3200				
4100				
6000				



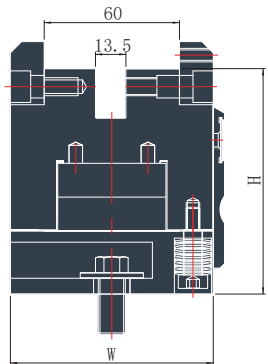
BI - DIRECTIONAL CROWNING/双向挠度补偿



BGT-C1					
L (mm)	W (mm)	H (mm)	Max. Compensation 最大补偿值		Adjustment 调节方式
			Horizontal 横向	Vertical 纵向	
2500	180	100	2.0	0.5	Manual+Manual / Manual+Motor 手动+手动 / 手动+电动
3200					
4100					
2500					
3200					
4100					
2500					
3200					
4100					
3200					
4100					
6000					
3200					
4100					
6000					



BGT-C1					
L (mm)	W (mm)	H (mm)	Max. Compensation 最大补偿值		Adjustment 调节方式
			Horizontal 横向	Vertical 纵向	
1500	100	95	2.0	0.5	Manual+Manual / Manual+Motor 手动+手动 / 手动+电动
2050					
2500					
3200					
4100					
6000					

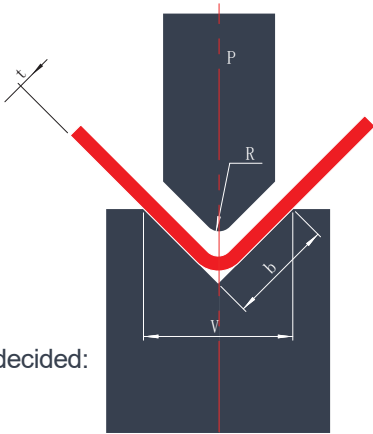


CAPACITY CHART OF AIR BENDING/折弯压力表

材料的板厚及折弯的内侧半径决定后, 请参阅下表:

- 1.由表可看出折弯材料时每米所需的压力;
- 2.折弯时所使用的下模的V槽宽度(V);
- 3.折弯后所得的最短边长度(b)。

注:下表所示为一般板厚所对应的模具V槽宽度。



Please check the chart after plate thickness and bending inner radius being decided:

- 1. It can be seen that the pressure at every meter during bending;
- 2. The V-groove width(V) of bottom die during bending;
- 3. The shortest-length(b) arising during bengding.

Note: The following chart shows the corresponding V general width of the tooling with general thickness.

T	0.5-2.6mm	3.0-8mm	9-10mm	>12mm
V	6xt	8xt	10xt	12xt

V	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250								
b	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175								
R	0.7	1.0	1.1	1.3	1.6	2.0	2.3	2.6	3.0	3.3	4.0	5.0	6.5	8.0	10	13	16	20	26	33	41								
0.5	4	3																											
0.6	6	4	4	4									t - 板材料厚度 (抗拉强度=45-50kg/mm²) t - Plate material thickness (Tensile strength=45-50kg/mm²) P - 每米所需压力 (Ton/m) P - Necessary pressure per meter (Ton/m) R - 折弯内侧半径 R - Bending inner radius b - 最短边长度 b - Shortest-length V - 下模V槽的宽度 V - The V-groove width of bottom die																
0.8		7	7	5	4																								
1.0		11	10	8	7	6																							
1.2			14	12	10	8	7	6																					
1.4				15	13	11	10	9	8																				
1.6					17	15	13	11	10	9																			
2.0						22	19	17	15	13	11																		
2.3							25	23	29	17	15	12																	
2.6								28	25	22	18	14																	
3.0									34	30	24	19	15																
3.2										34	27	22	17	14															
3.5											33	26	20	16	13														
4.0											43	34	27	21	17														
4.5	铝/Aluminium: 30kg/mm² - P=P (表/Chart)×0.65												44	34	27	21													
5.0	碳钢/Mild Steel: 42kg/mm² - P=P (表/Chart)												52	42	33	26	21												
6.0	不锈钢/Stainless Steel: 70kg/mm² - P=P (表/Chart)×1.6													60	48	38	30	24											
7.0															52	41	33	26											
9.0																67	54	43											
10																85	67	53	42										
12																	96	78	60	55									
16																		136	107	86									
19																			150	125	100								
22																				160	130								
25																				210	170								
30																					240								