

PRECISION BENDING SOLUTIONS

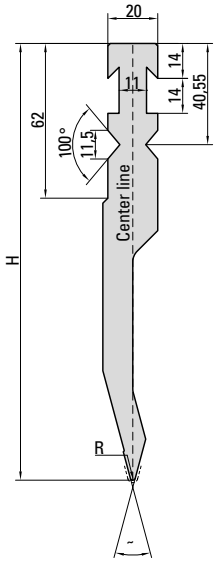
BYSTRONIC SYSTEM

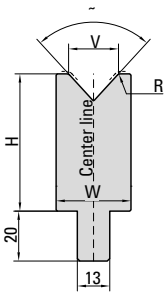
PRESS BRAKE TOOLS STE-SYSTEM BYSTRONIC

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Quality and precision

- ▶ Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, 650 – 800 N/mm²
- ▶ Bending radius/intake radii
  hardened up to 52 – 55 HRC
- ▶ Precision ground
- ▶ Guaranteed exchangeability
  and parallelism
- ▶ Tool marking
  with all technical information





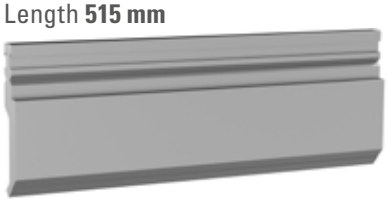
STE-CONTACT PARTNER

You will find your personal contact partner at

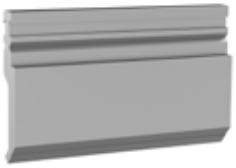
Tool lengths

PUNCHES/TOP TOOLS

Length **515 mm**



Length **300 mm**



Length **200 mm**

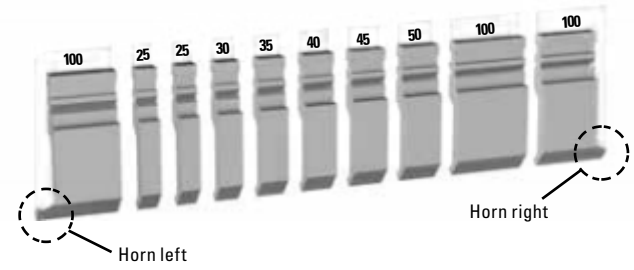


Length **100 mm**



Length **550 mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 10 Segments, with horn extension left and right



DIES

Length **515 mm**



Length **300 mm**



Length **200 mm**

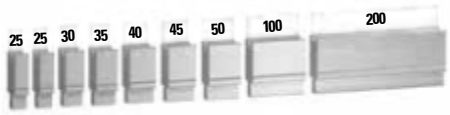


Length **100 mm**



Length **550 mm sectionalized**

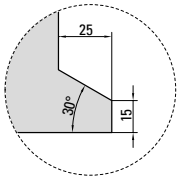
- Sectionalized dies are delivered as a complete set
- 9 Segments

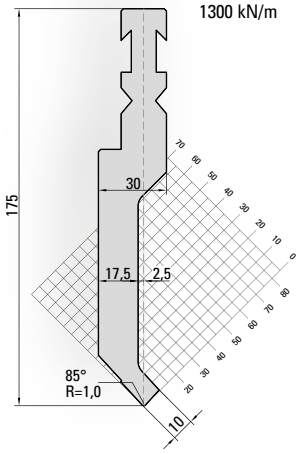


Punches/top tools H = 175 mm

14.150 24h

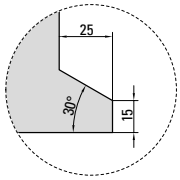
515 mm	12,5 kg
300 mm	7,2 kg
200 mm	4,8 kg
100 mm	2,4 kg
550 mm sectionalized	13,4 kg

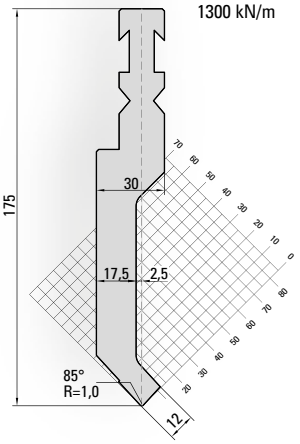




14.151

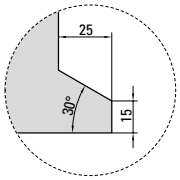
515 mm	12,6 kg
300 mm	7,3 kg
200 mm	5,0 kg
100 mm	2,4 kg
550 mm sectionalized	13,4 kg

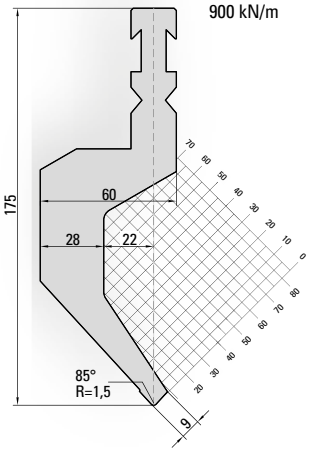




14.152 24h

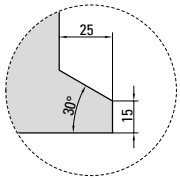
515 mm	16,6 kg
300 mm	9,7 kg
200 mm	6,5 kg
100 mm	3,2 kg
550 mm sectionalized	17,8 kg

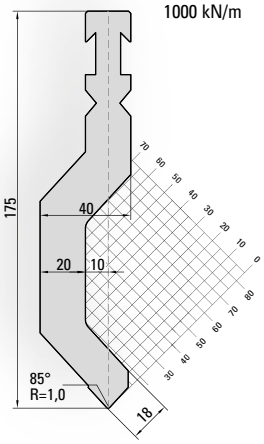




14.156 24h

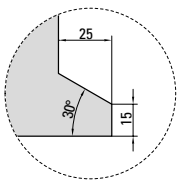
515 mm	14,0 kg
300 mm	8,2 kg
200 mm	5,0 kg
100 mm	2,7 kg
550 mm sectionalized	15,0 kg

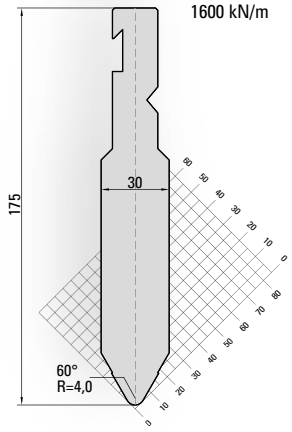




14.157 24h

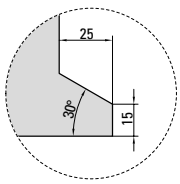
515 mm	17,0 kg
300 mm	10,0 kg
200 mm	6,6 kg
100 mm	3,3 kg
550 mm sectionalized	18,2 kg

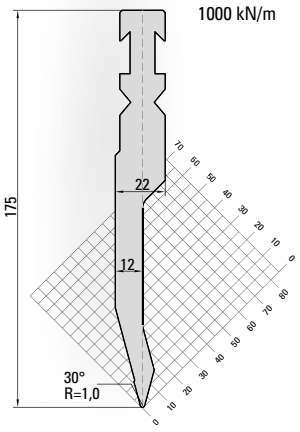




14.153 24h

515 mm	9,7 kg
300 mm	5,7 kg
200 mm	3,8 kg
100 mm	1,9 kg
550 mm sectionalized	10,4 kg

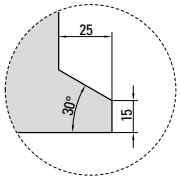


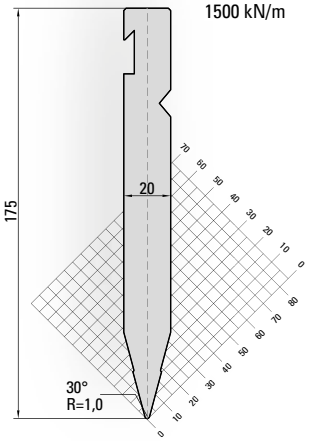


Punches/top tools H = 175 mm

14.154 24h

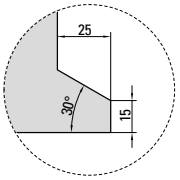
515 mm	12,4 kg
300 mm	7,2 kg
200 mm	4,8 kg
100 mm	2,4 kg
550 mm sectionalized	13,2 kg

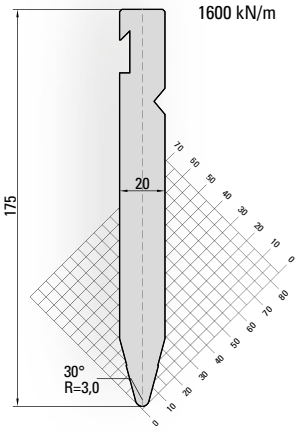




14.155 24h

515 mm	12,8 kg
300 mm	7,5 kg
200 mm	5,0 kg
100 mm	2,5 kg
550 mm sectionalized	13,7 kg

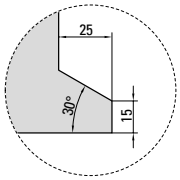


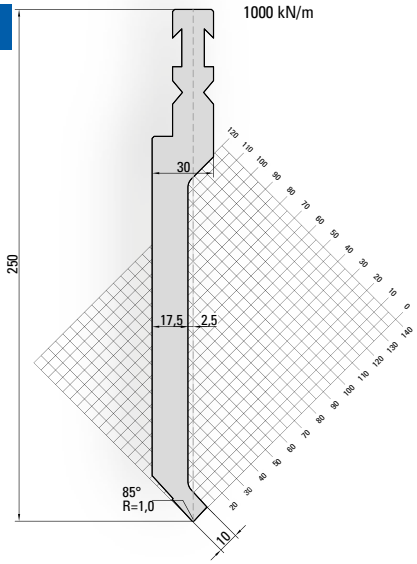


Punches/top tools H = 250 mm

14.158 24h

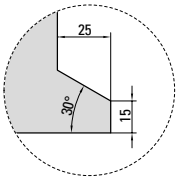
515 mm	17,8 kg
300 mm	10,4 kg
200 mm	7,0 kg
100 mm	3,5 kg
550 mm sectionalized	19,0 kg

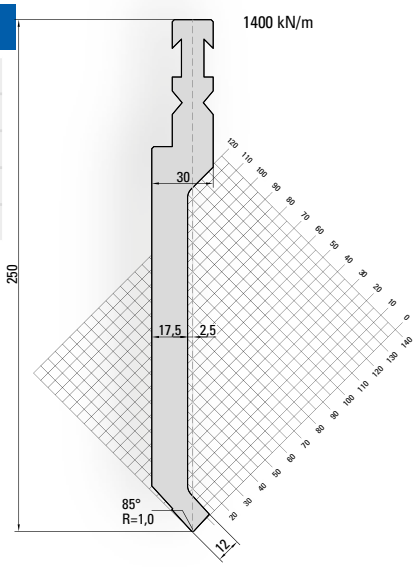




14.159 24h

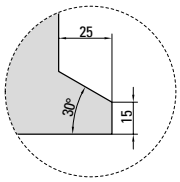
515 mm	18,0 kg
300 mm	10,4 kg
200 mm	7,0 kg
100 mm	3,5 kg
550 mm sectionalized	19,1 kg

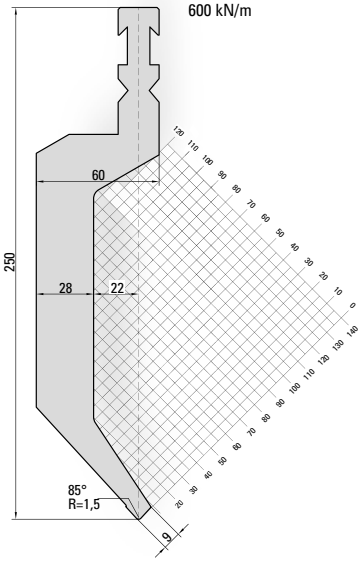




14.160 24h

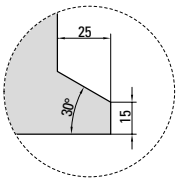
515 mm	25,0 kg
300 mm	14,6 kg
200 mm	9,8 kg
100 mm	4,9 kg
550 mm sectionalized	26,8 kg

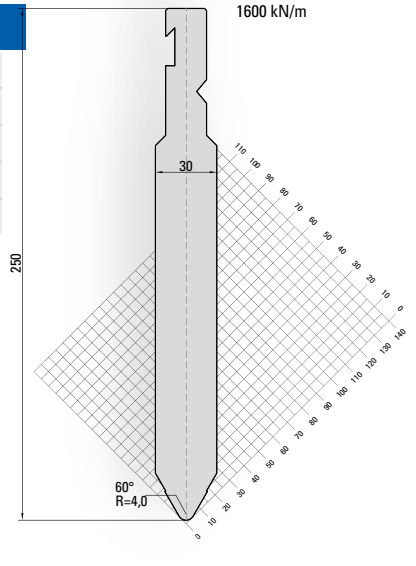




14.165 24h

515 mm	26,1 kg
300 mm	
200 mm	
100 mm	5,0 kg
550 mm sectionalized	27,9 kg

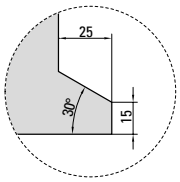


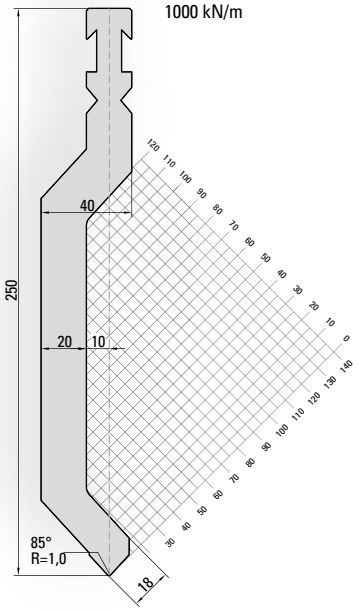


Punches/top tools H = 250 mm

14.164 24h

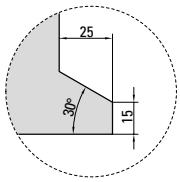
515 mm	20,1 kg
300 mm	11,7 kg
200 mm	7,8 kg
100 mm	3,9 kg
550 mm sectionalized	21,5 kg

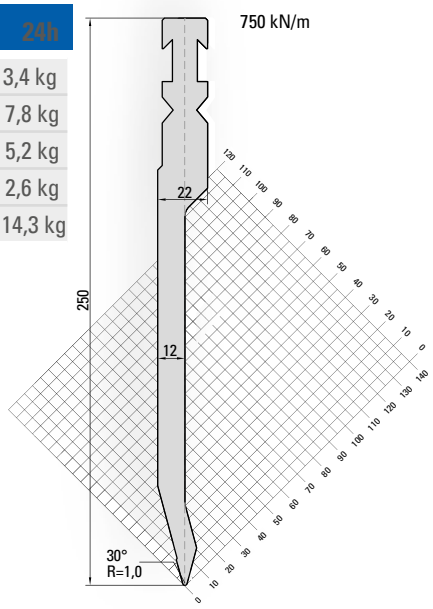




14.161 24h

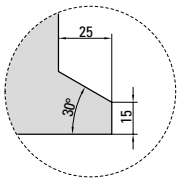
515 mm	13,4 kg
300 mm	7,8 kg
200 mm	5,2 kg
100 mm	2,6 kg
550 mm sectionalized	14,3 kg

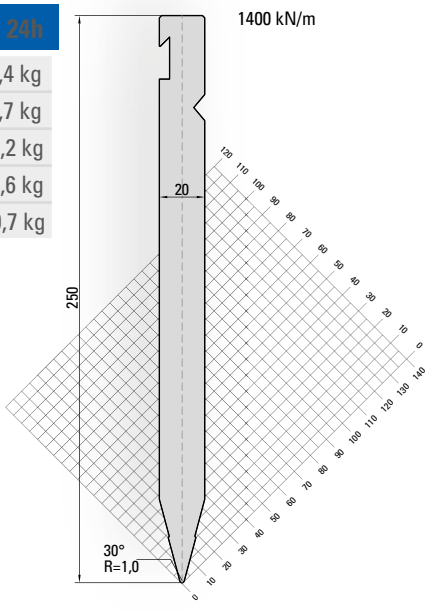




14.162 24h

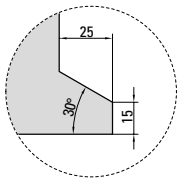
515 mm	18,4 kg
300 mm	10,7 kg
200 mm	7,2 kg
100 mm	3,6 kg
550 mm sectionalized	19,7 kg

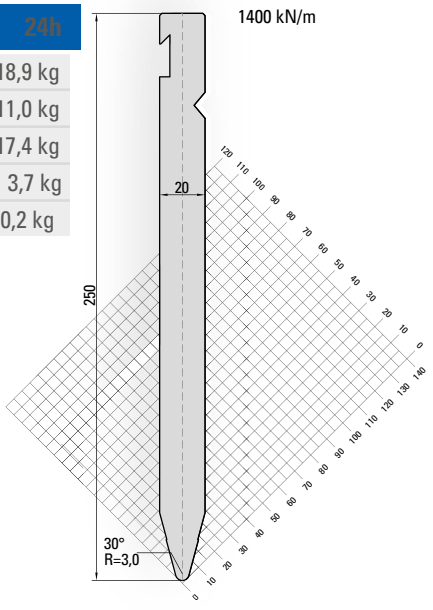




14.163 24h

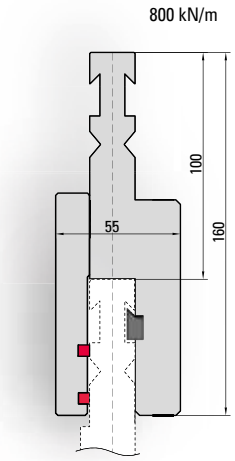
515 mm	18,9 kg
300 mm	11,0 kg
200 mm	17,4 kg
100 mm	3,7 kg
550 mm sectionalized	20,2 kg



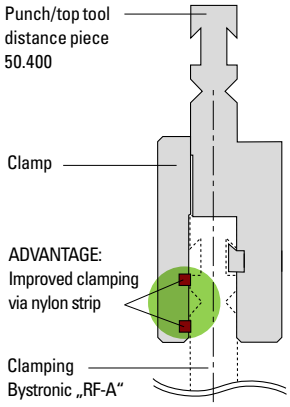


Punch/top tool distance piece

50.400		4h
150 mm	231,– $	6,0 kg



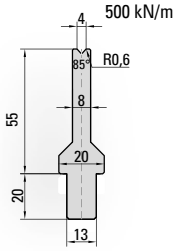
EXAMPLE OF USE



85° Dies, H = 55 mm

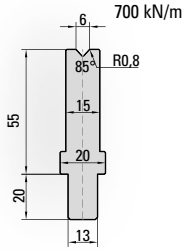
24.100

515 mm	3,6 kg
300 mm	2,1 kg
200 mm	1,4 kg
100 mm	0,7 kg
550 mm sectionalized	3,8 kg



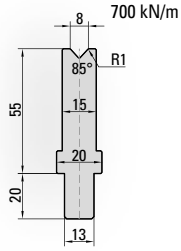
24.101 24h

515 mm	4,6 kg
300 mm	2,7 kg
200 mm	1,8 kg
100 mm	0,9 kg
550 mm sectionalized	5,0 kg



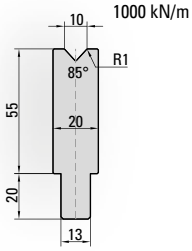
24.102 24h

515 mm	4,6 kg
300 mm	2,7 kg
200 mm	1,8 kg
100 mm	0,9 kg
550 mm sectionalized	5,0 kg



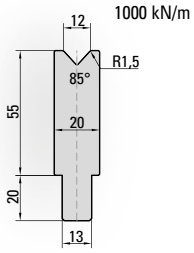
24.104 24h

515 mm	5,7 kg
300 mm	3,3 kg
200 mm	2,2 kg
100 mm	1,1 kg
550 mm sectionalized	6,1 kg



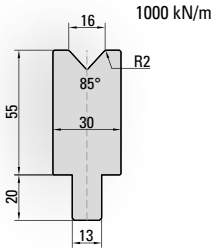
24.106 24h

515 mm	5,7 kg
300 mm	3,3 kg
200 mm	2,2 kg
100 mm	1,1 kg
550 mm sectionalized	6,1 kg



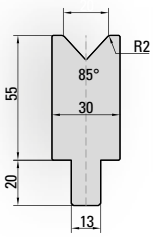
24.108 24h

515 mm	
300 mm	
200 mm	
100 mm	
550 mm sectionalized	



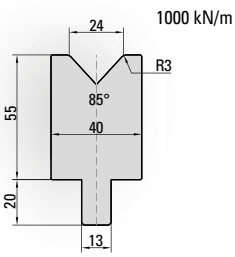
24.109 24h

515 mm	7,7 kg
300 mm	4,5 kg
200 mm	3,0 kg
100 mm	1,5 kg
550 mm sectionalized	8,3 kg



24.110 24h

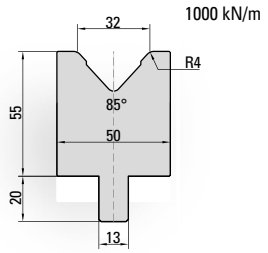
515 mm	9,8 kg
300 mm	5,7 kg
200 mm	3,8 kg
100 mm	1,9 kg
550 mm sectionalized	10,5 kg



85° Dies, H = 55 mm

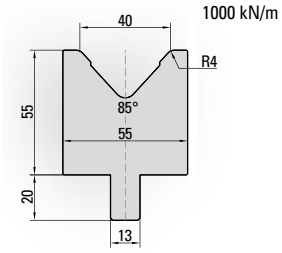
24.011	24h
515 mm	10,8 kg
300 mm	6,3 kg
200 mm	4,2 kg
100 mm	2,1 kg
550 mm sectionalized	11,5 kg

1200 kN/m if the tool clamping has the corresponding load



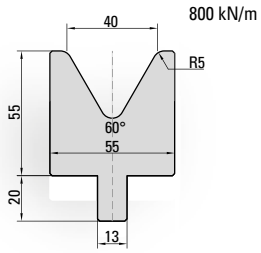
24.012	24h
515 mm	11,1 kg
300 mm	6,6 kg
200 mm	4,4 kg
100 mm	2,2 kg
550 mm sectionalized	12,1 kg

1200 kN/m if the tool clamping has the corresponding load



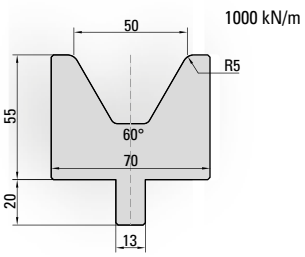
60° Dies, H = 55 mm

24.040	24h
515 mm	10,3 kg
300 mm	6,0 kg
200 mm	4,0 kg
100 mm	2,0 kg
550 mm sectionalized	11,0 kg



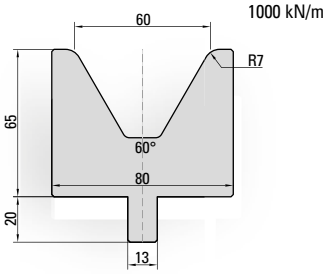
24.050	24h
515 mm	
300 mm	7,5 kg
200 mm	5,0 kg
100 mm	2,5 kg
550 mm sectionalized	13,8 kg

1200 kN/m if the tool clamping has the corresponding load



60° Die, H = 65 mm

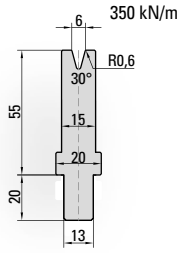
24.060	24h
515 mm	16,0 kg
300 mm	9,3 kg
200 mm	6,2 kg
100 mm	3,1 kg
550 mm sectionalized	17,0 kg



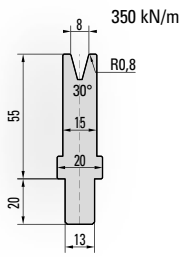


30° Dies, H = 55 mm

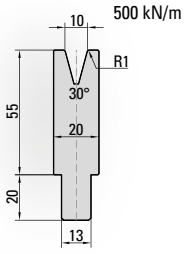
24.013	24h
515 mm	4,1 kg
300 mm	2,4 kg
200 mm	1,6 kg
100 mm	0,8 kg
550 mm sectionalized	4,4 kg



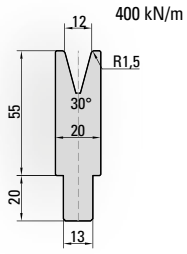
24.014	24h
515 mm	4,1 kg
300 mm	2,4 kg
200 mm	1,6 kg
100 mm	0,8 kg
550 mm sectionalized	4,4 kg



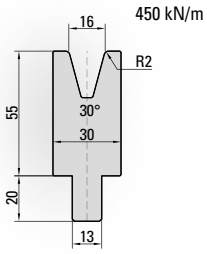
24.015	24h
515 mm	5,1 kg
300 mm	3,0 kg
200 mm	2,0 kg
100 mm	1,0 kg
550 mm sectionalized	5,5 kg



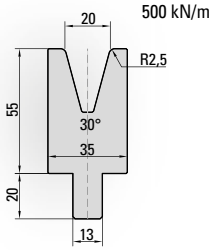
24.016	24h
515 mm	5,1 kg
300 mm	3,0 kg
200 mm	2,0 kg
100 mm	1,0 kg
550 mm sectionalized	5,5 kg



24.017	24h
515 mm	7,0 kg
300 mm	4,2 kg
200 mm	2,8 kg
100 mm	1,4 kg
550 mm sectionalized	7,7 kg

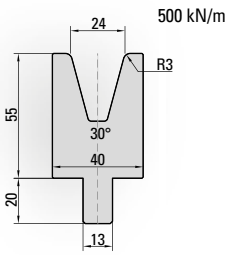


24.019	24h
515 mm	7,2 kg
300 mm	4,2 kg
200 mm	2,8 kg
100 mm	1,4 kg
550 mm sectionalized	7,7 kg

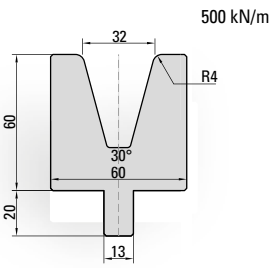


30° Die, H = 60 mm

24.018	24h
515 mm	8,0 kg
300 mm	4,8 kg
200 mm	3,2 kg
100 mm	1,6 kg
550 mm sectionalized	8,8 kg



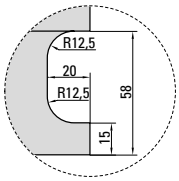
24.035	24h
515 mm	11,8 kg
300 mm	6,9 kg
200 mm	4,6 kg
100 mm	2,3 kg
550 mm sectionalized	12,7 kg

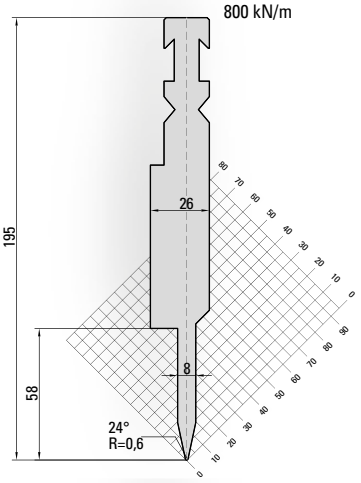


Flattening punches/top tools and flattening dies

14.908 24h

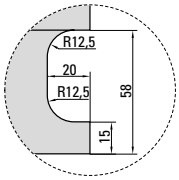
500 mm	13,0 kg
300 mm	7,8 kg
200 mm	5,2 kg
100 mm	2,6 kg
550 mm sectionalized	14,3 kg

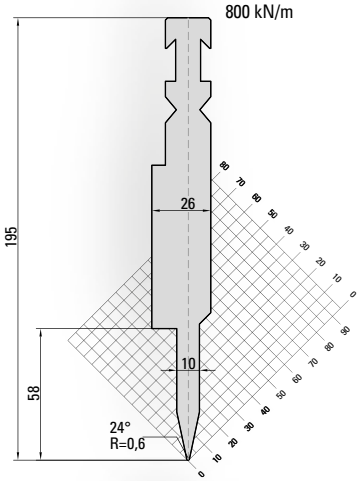




14.910 24h

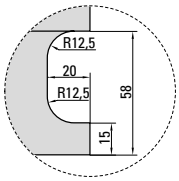
500 mm	13,5 kg
300 mm	8,1 kg
200 mm	5,4 kg
100 mm	2,7 kg
550 mm sectionalized	14,9 kg

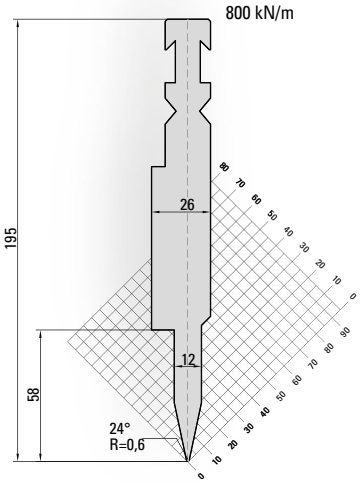




14.912

500 mm	14,0 kg
300 mm	8,4 kg
200 mm	5,6 kg
100 mm	2,8 kg
550 mm sectionalized	15,4 kg

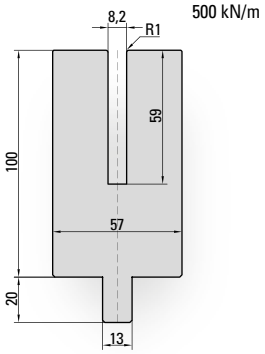




25.992 24h

500 mm	21,5 kg
300 mm	12,9 kg
200 mm	8,6 kg
100 mm	4,3 kg
550 mm sectionalized	23,6 kg

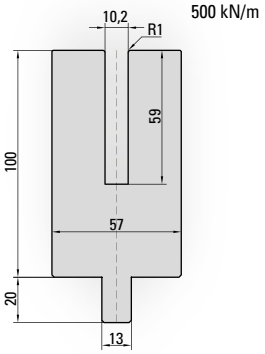
Max. 1,2 mm material thickness
R_m = 400 N/mm²



25.994 24h

500 mm	21,0 kg
300 mm	12,6 kg
200 mm	8,4 kg
100 mm	4,2 kg
550 mm sectionalized	23,1 kg

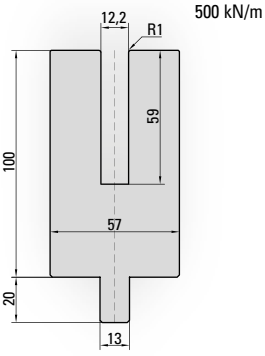
Max. 1,8 mm material thickness
R_m = 400 N/mm²



25.995 24h

500 mm	
300 mm	12,3 kg
200 mm	8,2 kg
100 mm	4,1 kg
550 mm sectionalized	22,6 kg

Max. 2,5 mm material thickness
R_m = 400 N/mm²



EXAMPLE OF USE

