Catalogo Tecnico

Il ns. ufficio tecnico è a vostra disposizione per qualsiasi informazione tecnica inerente ai particolari attualmente in produzione e in studio.

Per le modalità di ordinazione e consegna consultare il ns. listino prezzi.

Le descrizioni contenute nel presente catalogo non sono impegnative. Pertanto, per qualunque esigenza tecnica o commerciale, la ditta si riserva il diritto di apportare eventuali modifiche ai comportamenti ed accessori qui indicati.

For any technical information regarding particular pieces in current production or at the design stage please contact our technical office.

See our price list for details of how to order and of our delivery service.

The description contained in this catalugue are not binding. We reserve the rigth to modify components and accessories for technical or commercial reason.

Luglio 2016

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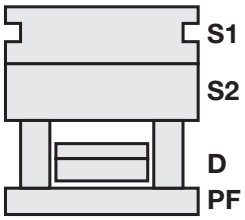
CATALOGO TECNICO

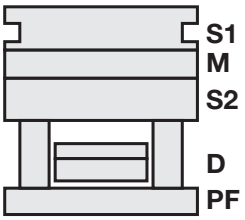
catalogo e documentazione on-line:
Web: www.ca-be.it **E-mail:** info@ca-be.it

PORTASTAMPI DI NORMALE PRODUZIONE

Serie **XE**



Serie **XE+M**



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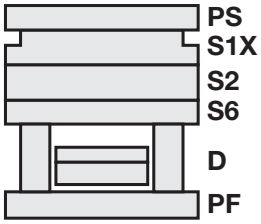

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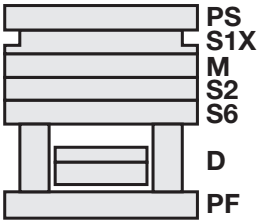
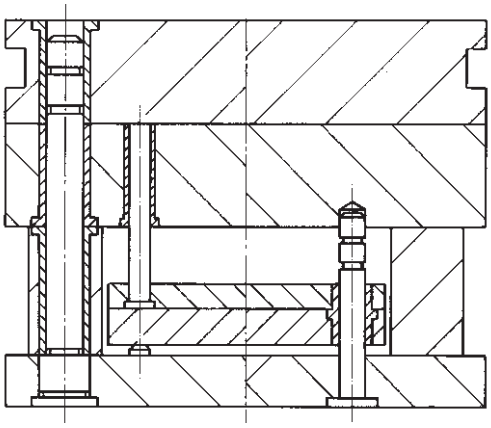
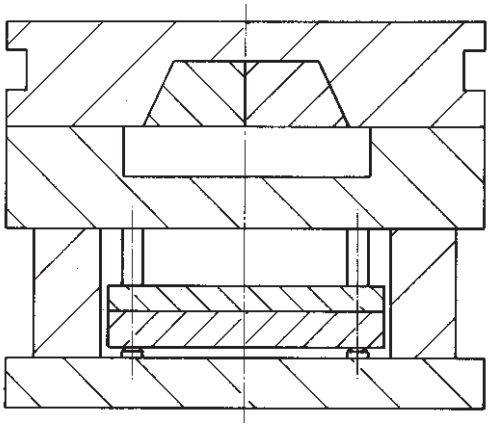
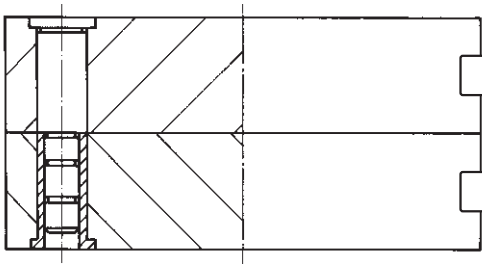


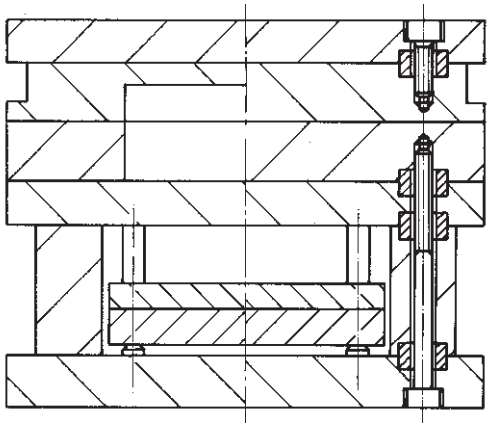
156	196	246	296	346	396	446	490	540	590
156	196	246	296	346	396	446	496	546	596
196	246	296	346	396	446	496	546	596	646
246	296	346	396	446	496	546	596	646	696
	346	396	446	496	546	596	646	696	746
							696	746	796
								796	

PORTASTAMPI IN ESECUZIONE SPECIALE A DISEGNO









ACCIAI IMPIEGATI PER LA NORMALE PRODUZIONE

DENOMINAZIONE	CORRISPONDENZA DIN	COMPOSIZIONE CHIMICA	DUREZZA MAX HB	STATO DI FORNITURA	TRATTAMENTI TERMICI	UTILIZZO
1.1730	C 45	C 0,45 Si 0,3 Mn 0,7	190	laminato/ forgiato	Ricottura: 650°C Ricottura isotermica: 800/650 °C 1 ora Tempra: 840 °C in acqua Fucinatura: 1100/850 Rinvenimento: 560/630 °C secondo esigenze Normalizzazione: 860 °C	Portastampi mediamente sollecitati,stampi per gomma. Acciaio adatto alla tempra ad induzione.
1.2738	40 CrMnNiMo 8 6 4	C 0,40 Mn 1,5 Cr 1,9 Ni 1,0 Mo 0,2	280 - 325	Bonificato	Tempra: 840 - 880 °C Raffreddamento in olio o con aria	Stampi per materie plastiche con eccellenti caratteristiche di lavorabilità. Andamento della durezza tra cuore e superficie costante. Ottima lucidabilità. Eccezionale attitudine alla fotoincisione, lucidabilità e predisposizione alla nitrurazione sia ionica che gassosa

ACCIAI A RICHIESTA

DENOMINAZIONE	CORRISPONDENZA DIN	COMPOSIZIONE CHIMICA	DUREZZA MAX HB	STATO DI FORNITURA	TRATTAMENTI TERMICI	UTILIZZO
1.2311	40 CrMnMo 7	C 0,4 Mn 1,5 Cr 1,9 Mo 0,2	280 - 325	Bonificato	Tempra: Austenitizzazione a 850/875 °C con raffreddamento in olio o aria	Stampi per materie plastiche e pressofusione
1.2312	40 CrMnMo S 8 6	C 0,4 Mn 1,5 Cr 1,9 Mo 0,2 S 0,05	280 -325	Bonificato	Ricottura: 700/730 °C Distensione: 650 °C Tempra: 840/860 °C in olio	Stampi per materie plastiche e pressofusione, elevata capacità di bonifica a cuore, ottima lavorabilità e buona lucidabilità. Cromatura e nitrurazione
1.2083	X42 CR 13	C 0,42 Cr 13,0	230	Ricotto	Ricottura: 750/820 °C durata 4 ore raffreddamento in forno. Tempra: 980/1020 °C in olio, aria, bagno di sale. Rinvenimento 200/400°C secondo esigenze	Acciaio inossidabile al Cromo per stampaggio di materie corrosive e abrasive
1.2085	X33 CrS 16	C 0,33 Cr 16,0 S 0,05 Ni 0,5	280 -325	Bonificato	Tempra 985-1020 °C raffreddamento in olio o aria	Stampi resistenti alla corrosione, inoltre l'aggiunta di zolfogarantisce un'ottima lavorabilità
1.2714	56 NiCrMoV 7	C 0,56 Cr 1,1 Ni 1,7 Mo 0,5 V0,1	250 ricotto 350 - 410 Bonificato	Ricotto - Bonificato	Ricottura di addolcimento: riscaldo a 730-750 °C, mantenimento a regime, raffreddamento in forno fino a 600 °C poi in aria calma. Ricottura di distensione: dopo sgrossatura, riscaldo a 600-650 °C, mantenimento a regime, raffreddamento in forno fino a 500°C, poi in aria calma. Tempra: preriscaldo a 600-650 °C, austenitizzazione a 850-880 °C, spegnimento in olio o in aria. Rinvenimento: riscaldo a 520-650 °C, mantenimento a regime.	Acciaio caratterizzato da un elevato livello di tenacità a caldo e resistenza alla fatica termica
1.2343	X38 CrMoV 5 1	C 0,38 Si 1,0 Cr 5,3 Mo 1,3 V 0,4	230	Ricotto	Ricottura: 800/840 °C Ricottura isotermica: 870/780 °C 20 ore Tempra 980/1020 °C in olio Fucinatura 1110/900 °C Rinvenimento: 580/650 °C secondo esigenze	Acciaio dall'ottima tenacità, buona durezza al rosso e ottima resistenza agli sbalzi di temperatura. Stampi a caldo e stampi per pressofusione di alluminio e sue leghe, ottone.

Caratteristiche di lavorazione: superfici rettificate, squadratura 0,01 mm per 100 mm di lunghezza, planarità 0,005 mm per 100 mm di lunghezza, interasse incolonnamento 0,005 mm.

Caratteristiche componenti: Colonne e bussole in acciaio, cementate, temprate, rettificate e lappate.
Rimandi tavolino di estrazione in acciaio nitrurato.
Viti di fissaggio a testa cilindrica con esagono incassato.

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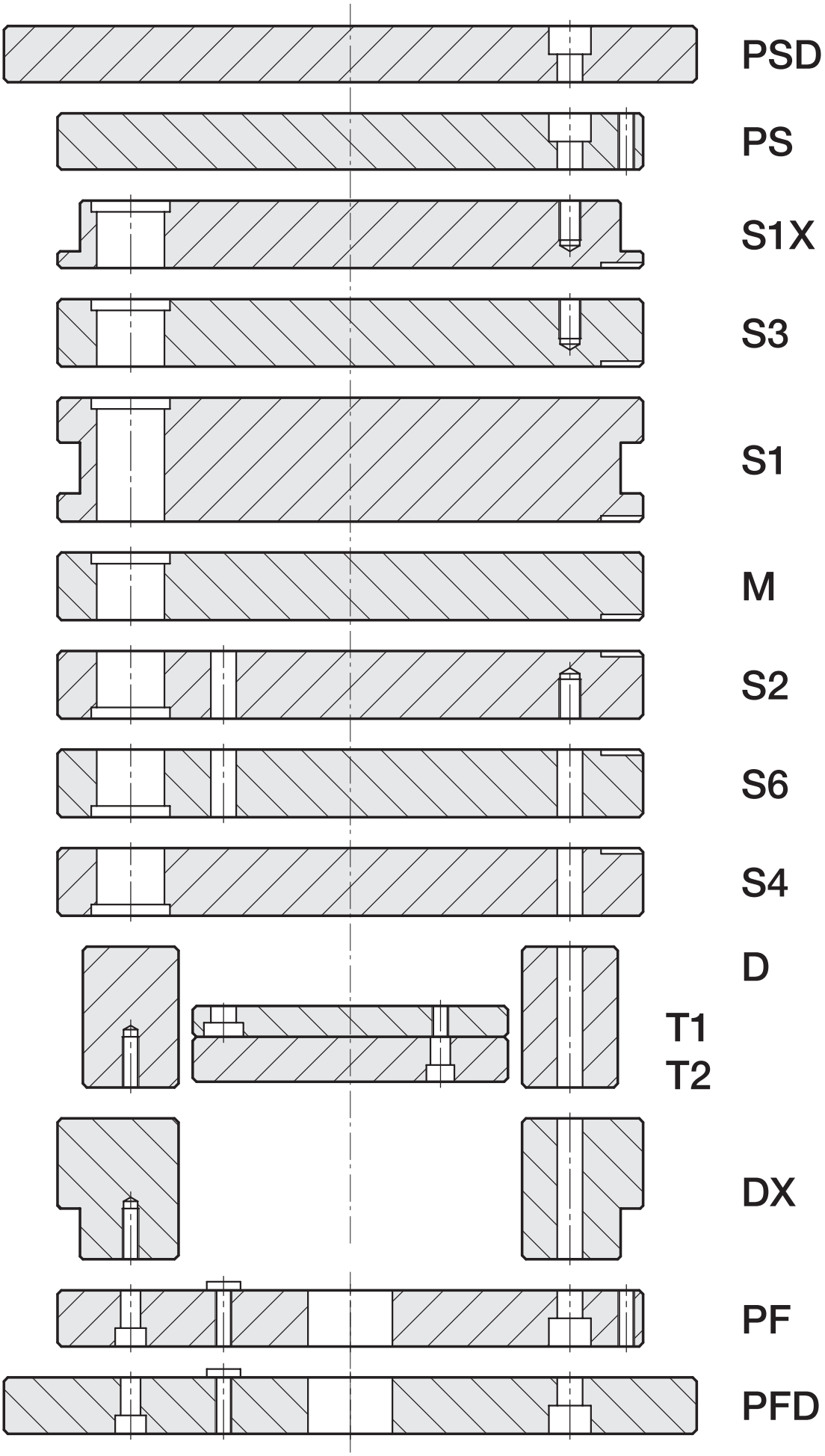
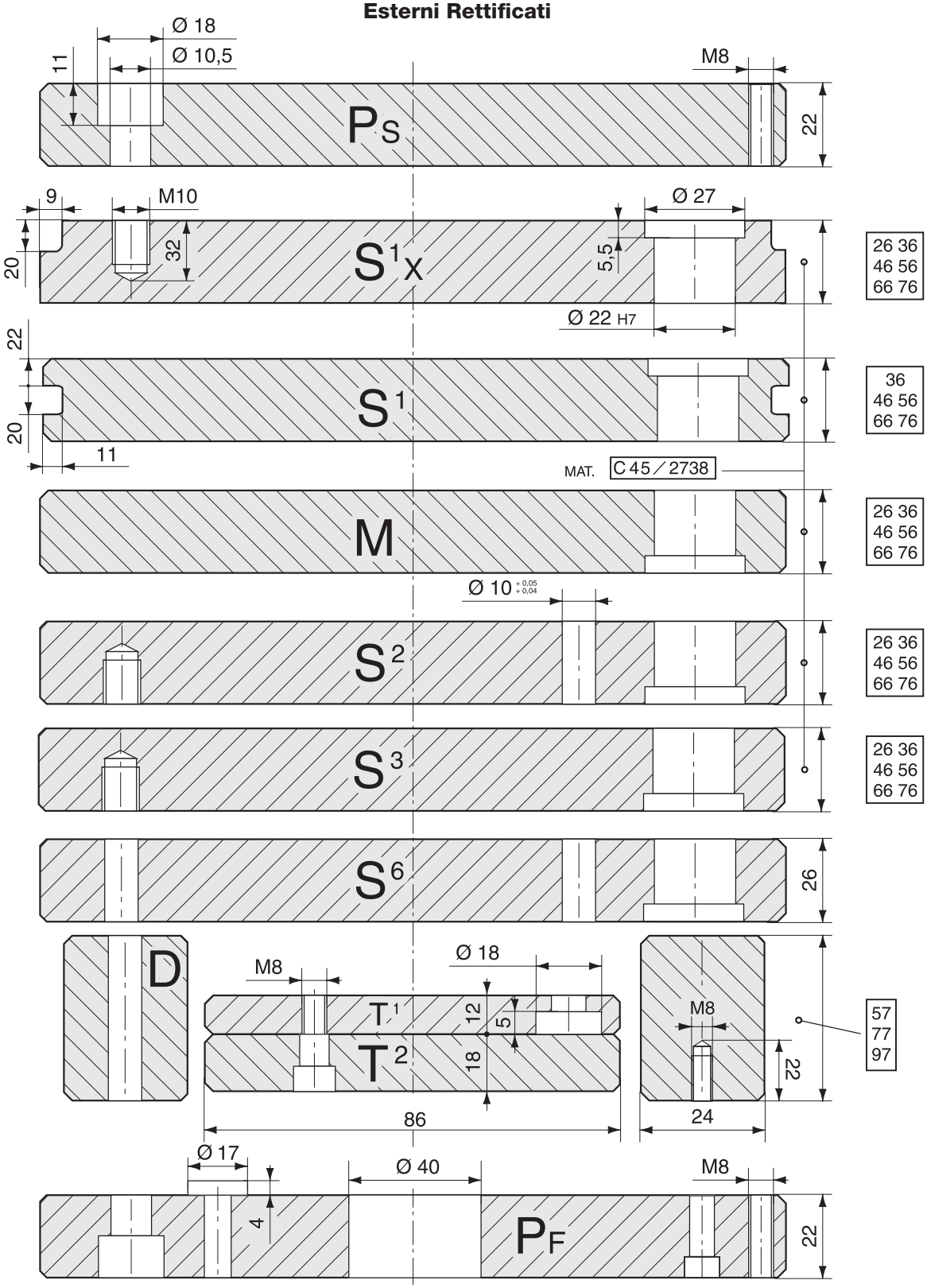
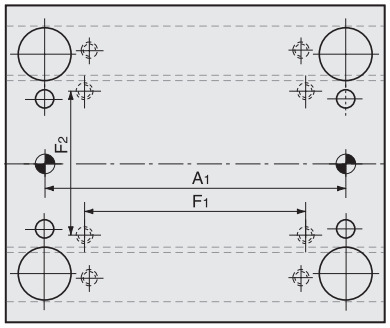
PIASTRE DI NORMALE PRODUZIONE



PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

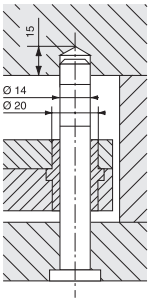
Esterni Rettificati





Tipo A

Guida Tavolino



Dimensione	A1	F1	F2
156 x 156	120	90	65
156 x 196	160	130	65
156 x 246	210	180	65

le misure sono espresse in millimetri

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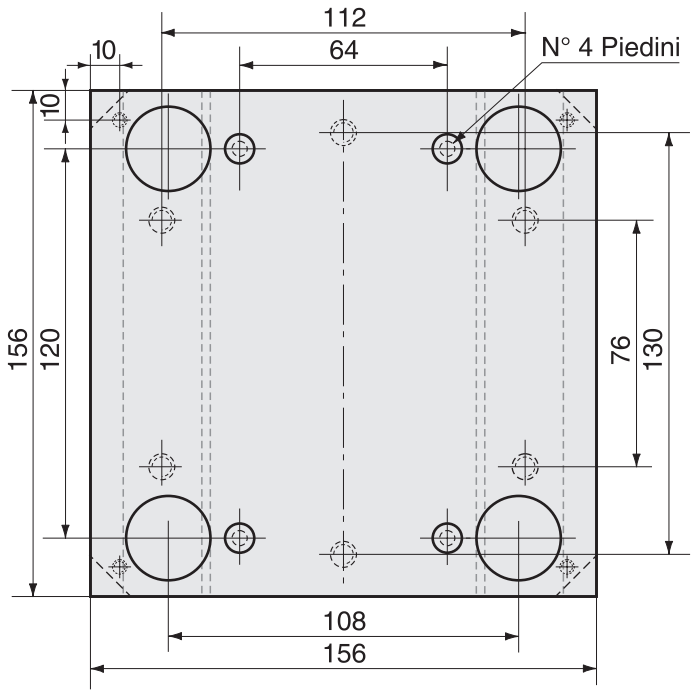
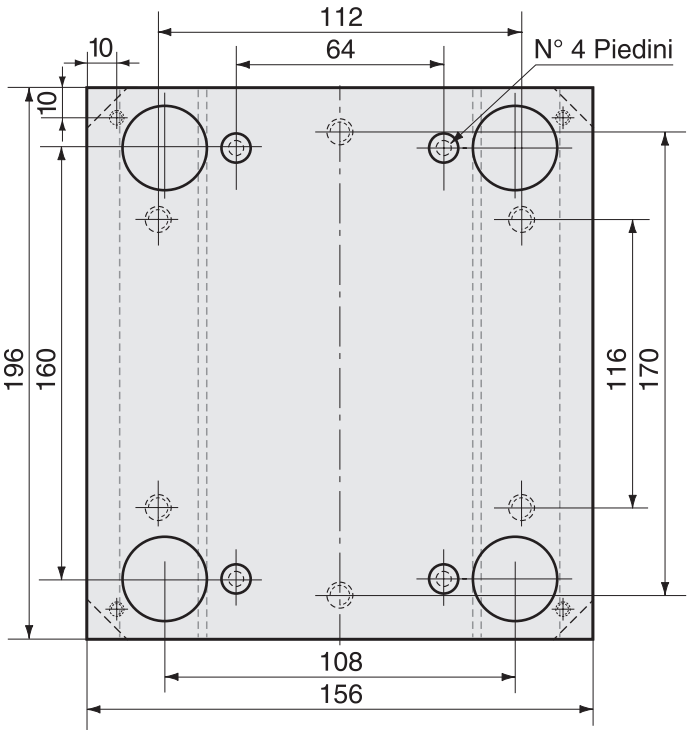
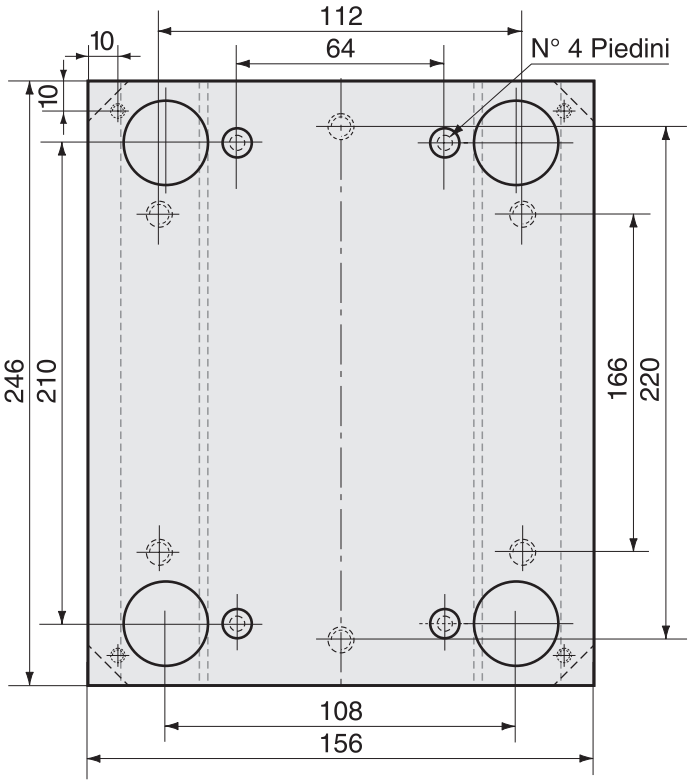
156 x 156



156 x 196



156 x 246



PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

Esterni Rettificati

Ø 18
Ø 10,5
11
M8
P_S
22

9
M10
Ø 27
20
32
S^1x
5,5
Ø 22 H7
26
36 46
56 66
76 96

22
S^1
20
11
36 46
56 66
76 96

MAT. C 45 / 2738

M
26
36 46
56 66
76 96

Ø 10 $^{+0,05}_{+0,04}$
S^2
26
36 46
56 66
76 96

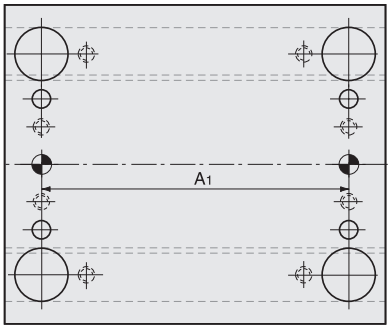
S^3
26
36 46
56 66
76 96

S^6
26

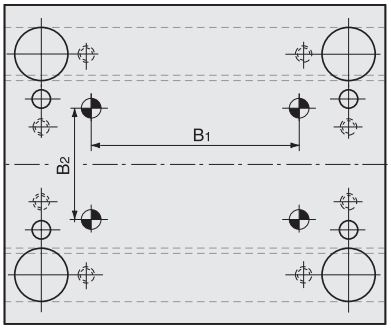
D
M8
Ø 18
T^1
T^2
12
5
18
116
M8
22
29
57
77
97
117

Ø 17
Ø 40
M8
4
P_F
22

Tipo A



Tipo B



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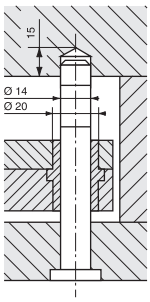

Dimensione	A_1	B_1	B_2
196 x 196	160	114	84
196 x 246	210	164	84
196 x 296	260	214	84
196 x 346	310	264	84

le misure sono espresse in millimetri

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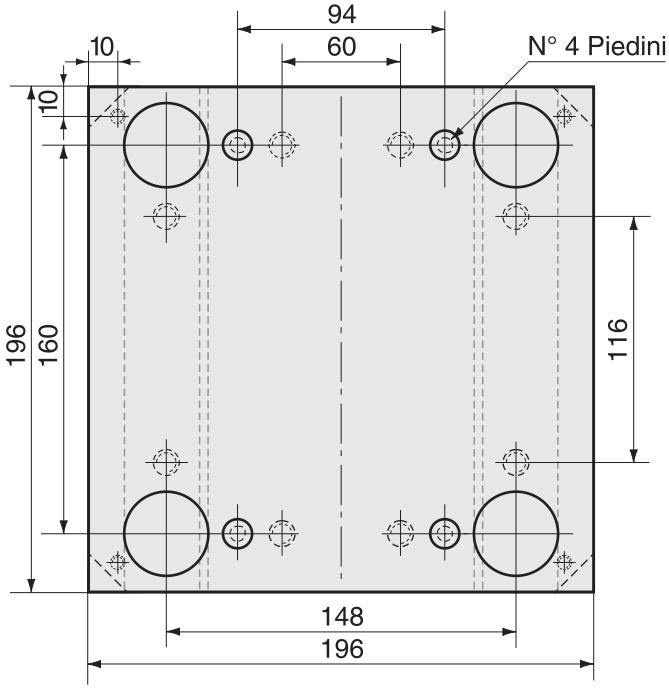
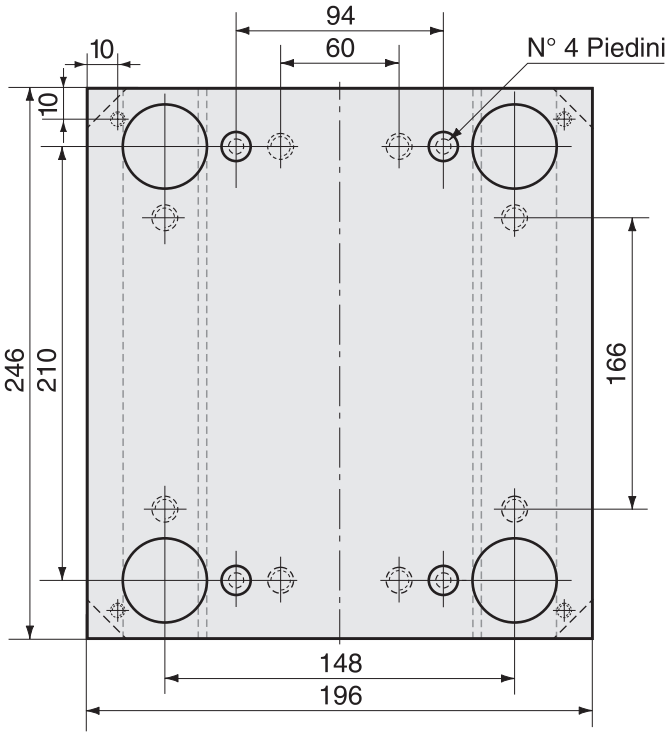
196 x 196



196 x 246



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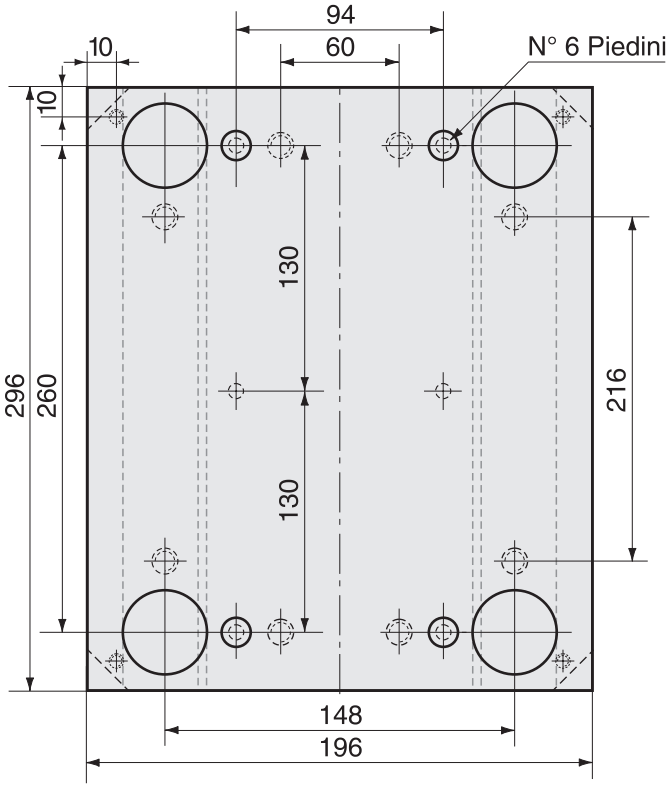
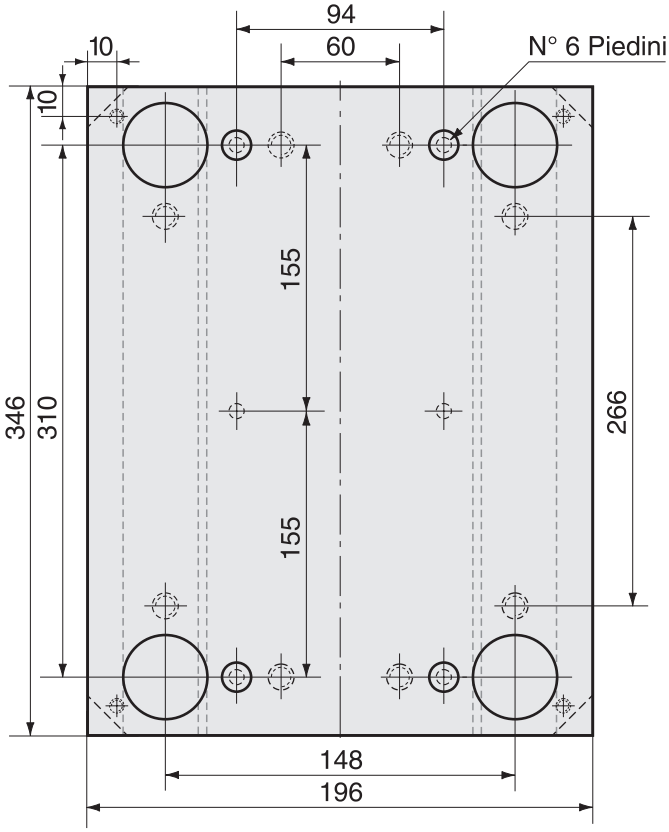
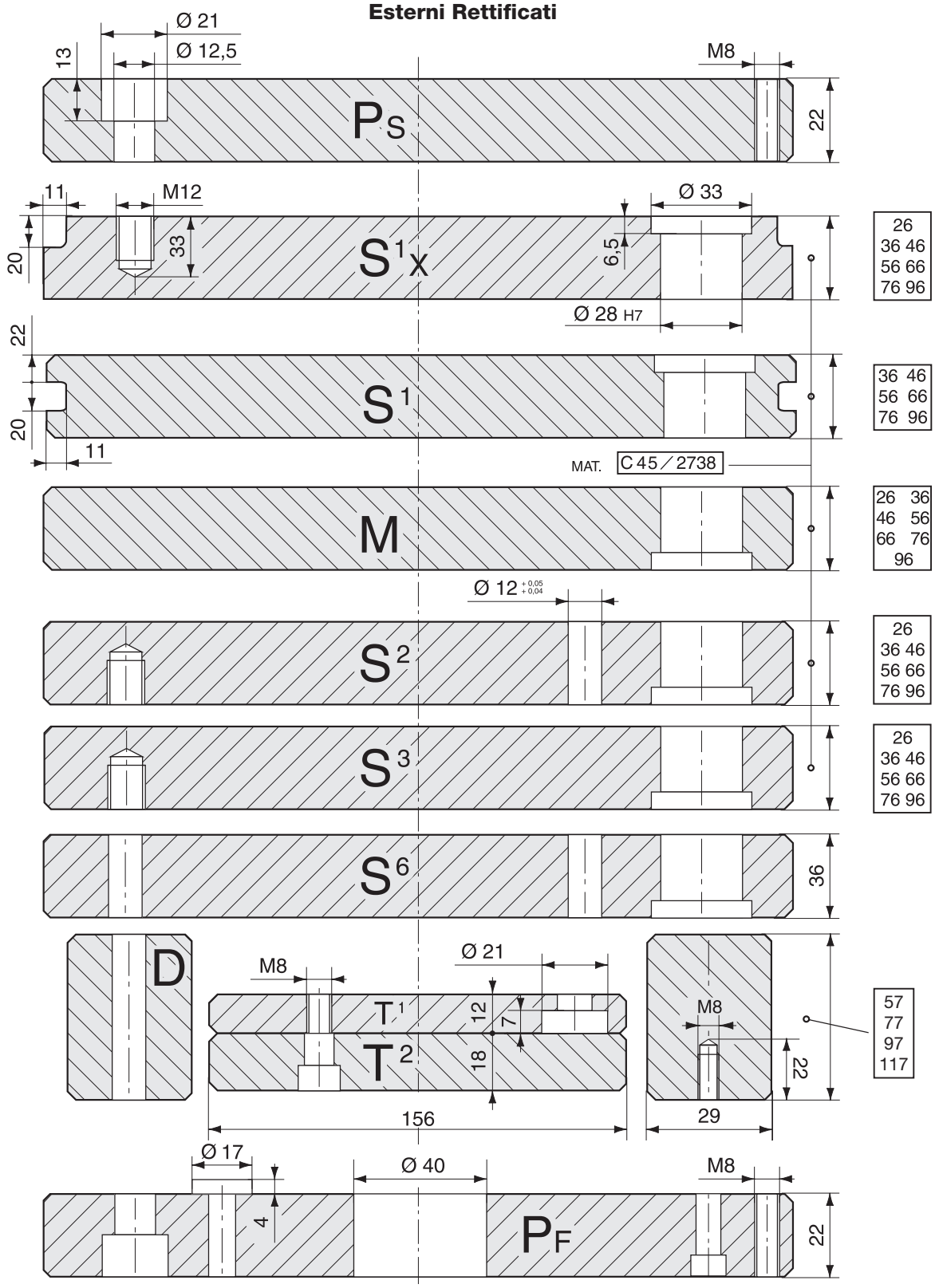


196 x 346

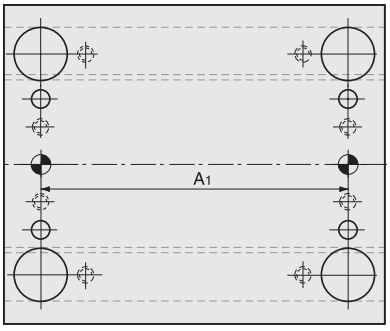


PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

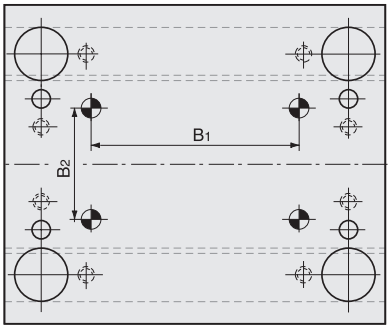
Esterni Rettificati



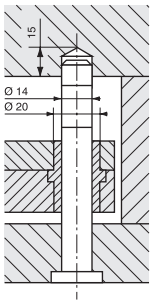
Tipo A



Tipo B



Guida Tavolino



Dimensione	A1	B1	B2
246 x 246	210	158	126
246 x 296	260	208	126
246 x 346	310	258	126
246 x 396	360	308	126

le misure sono espresse in millimetri

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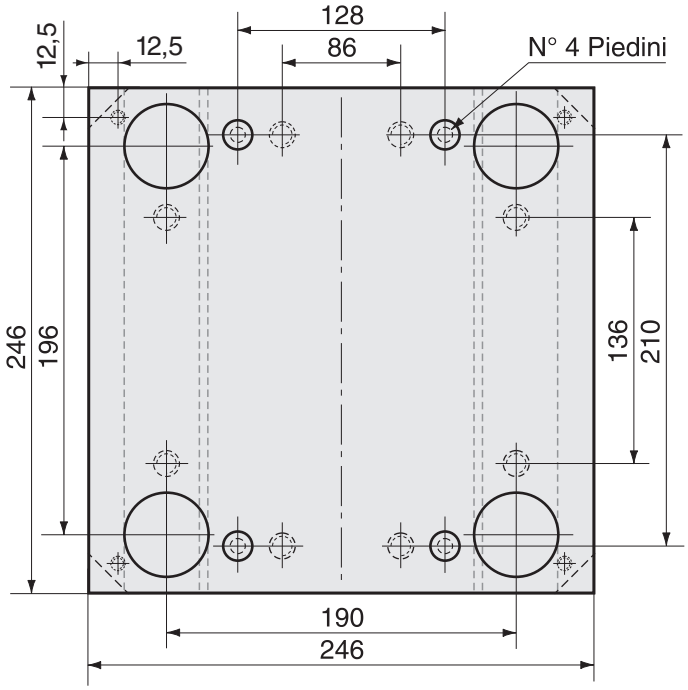
246 x 246



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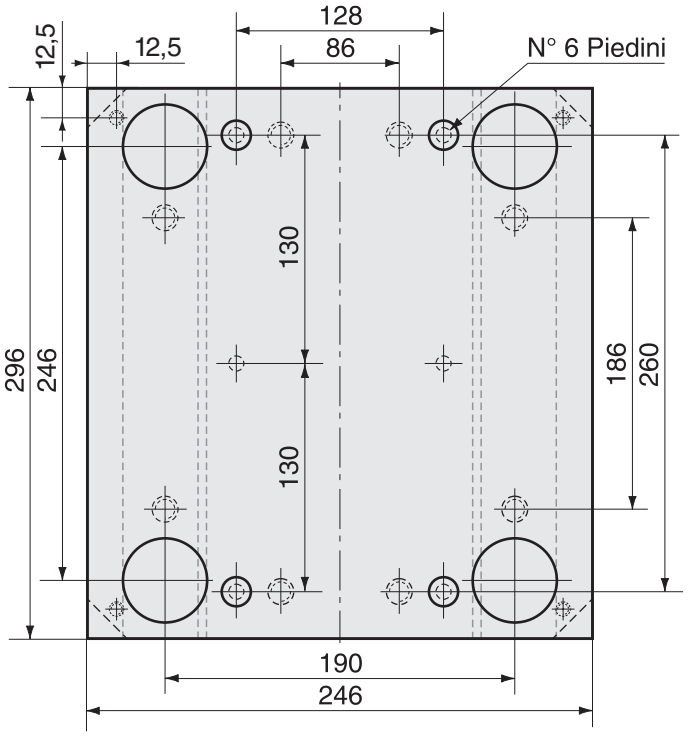

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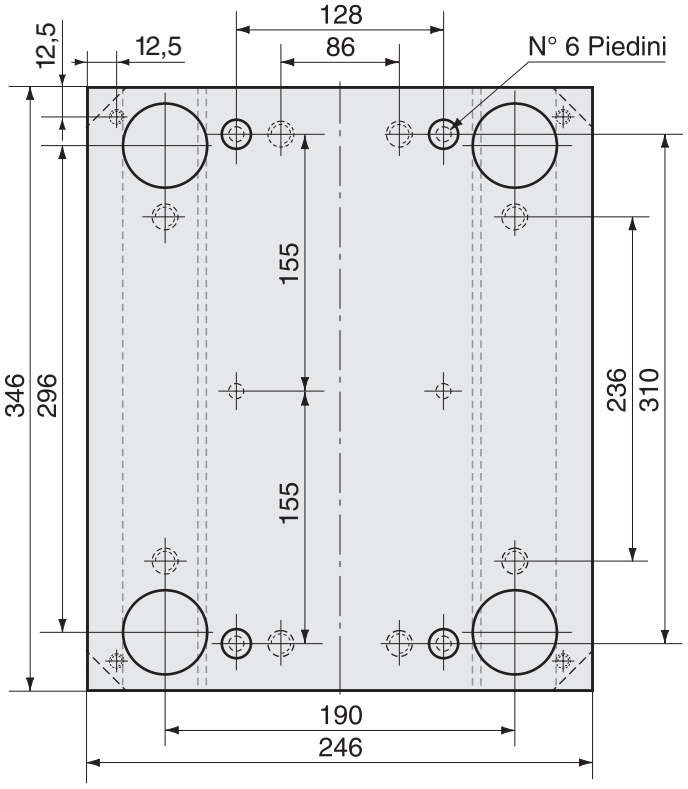

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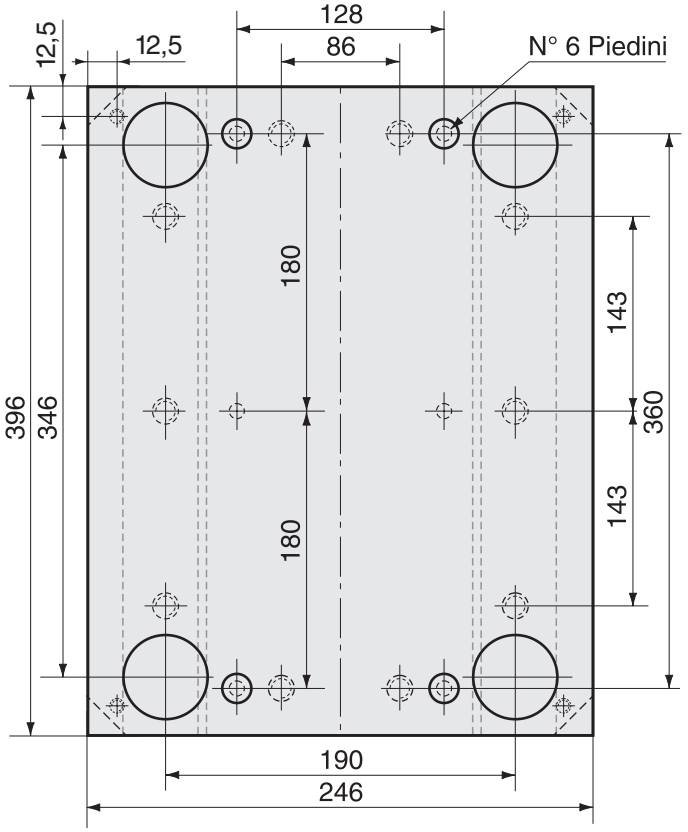
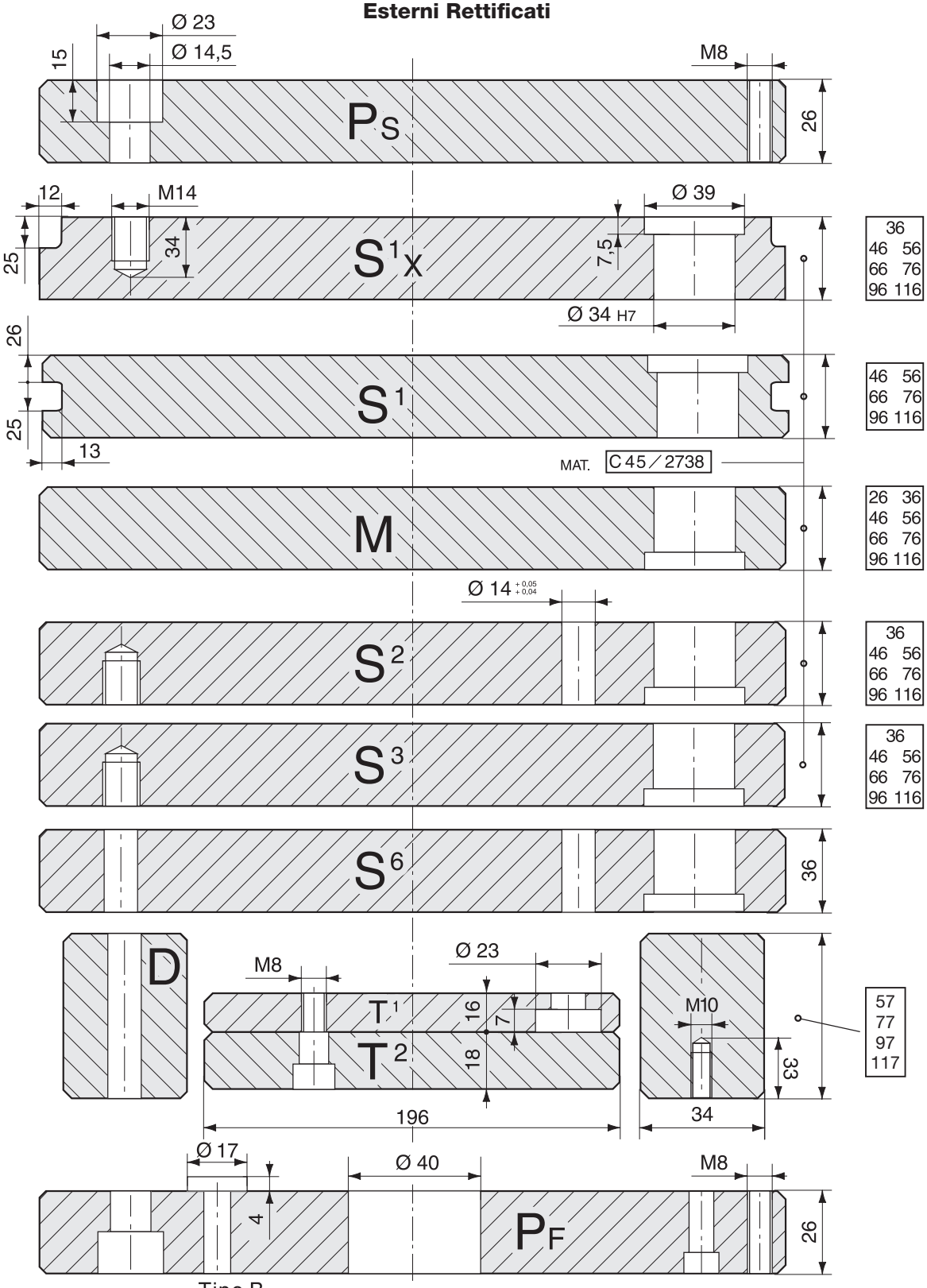
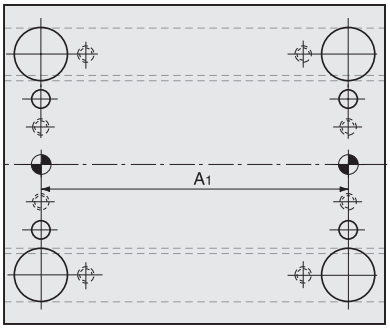


PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

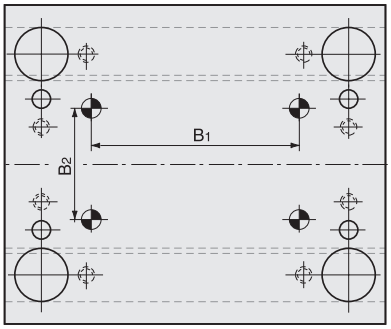
Esterni Rettificati



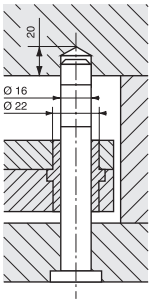
Tipo A



Tipo B



Guida Tavolino



Dimensione	A1	B1	B2
296 x 296	260	204	162
296 x 346	310	254	162
296 x 396	360	304	162
296 x 446	410	354	162

le misure sono espresse in millimetri

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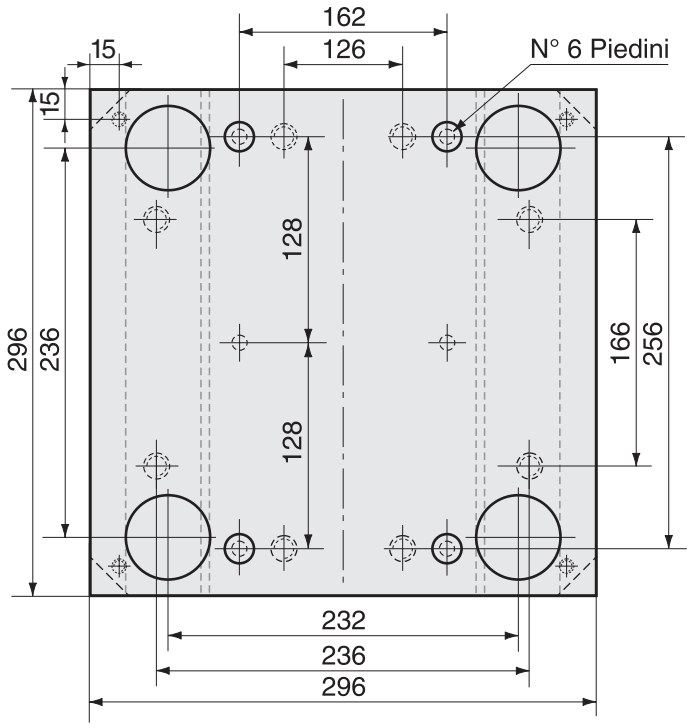
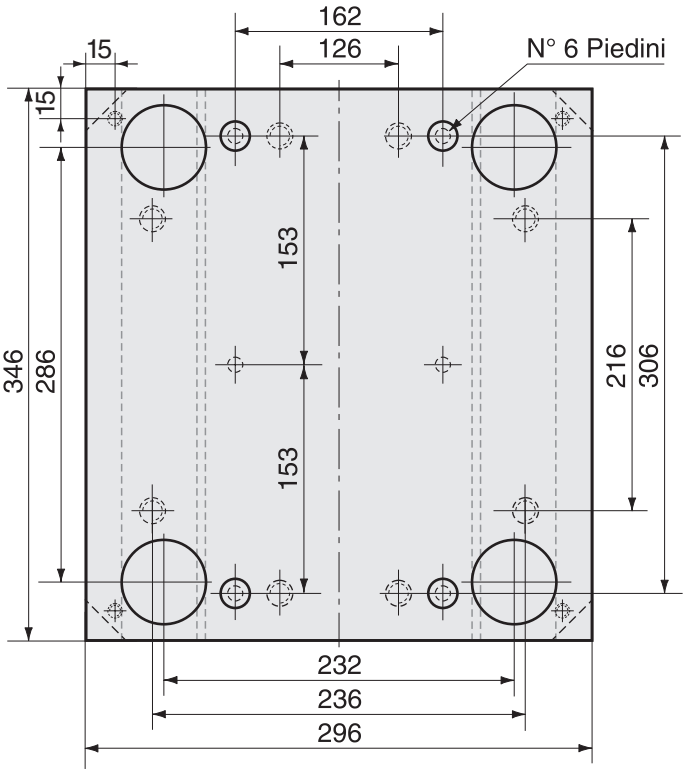
296 x 296



296 x 346



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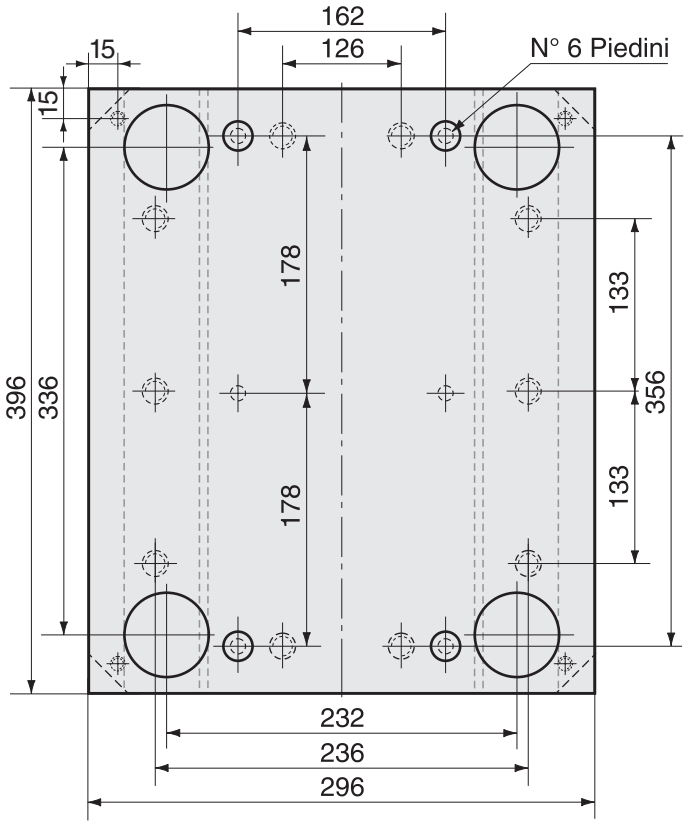
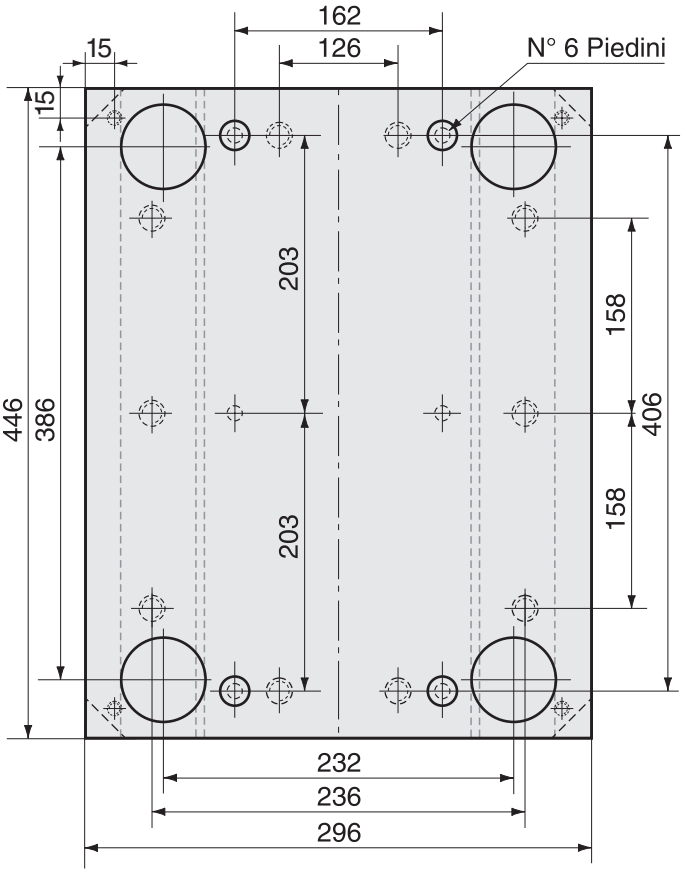
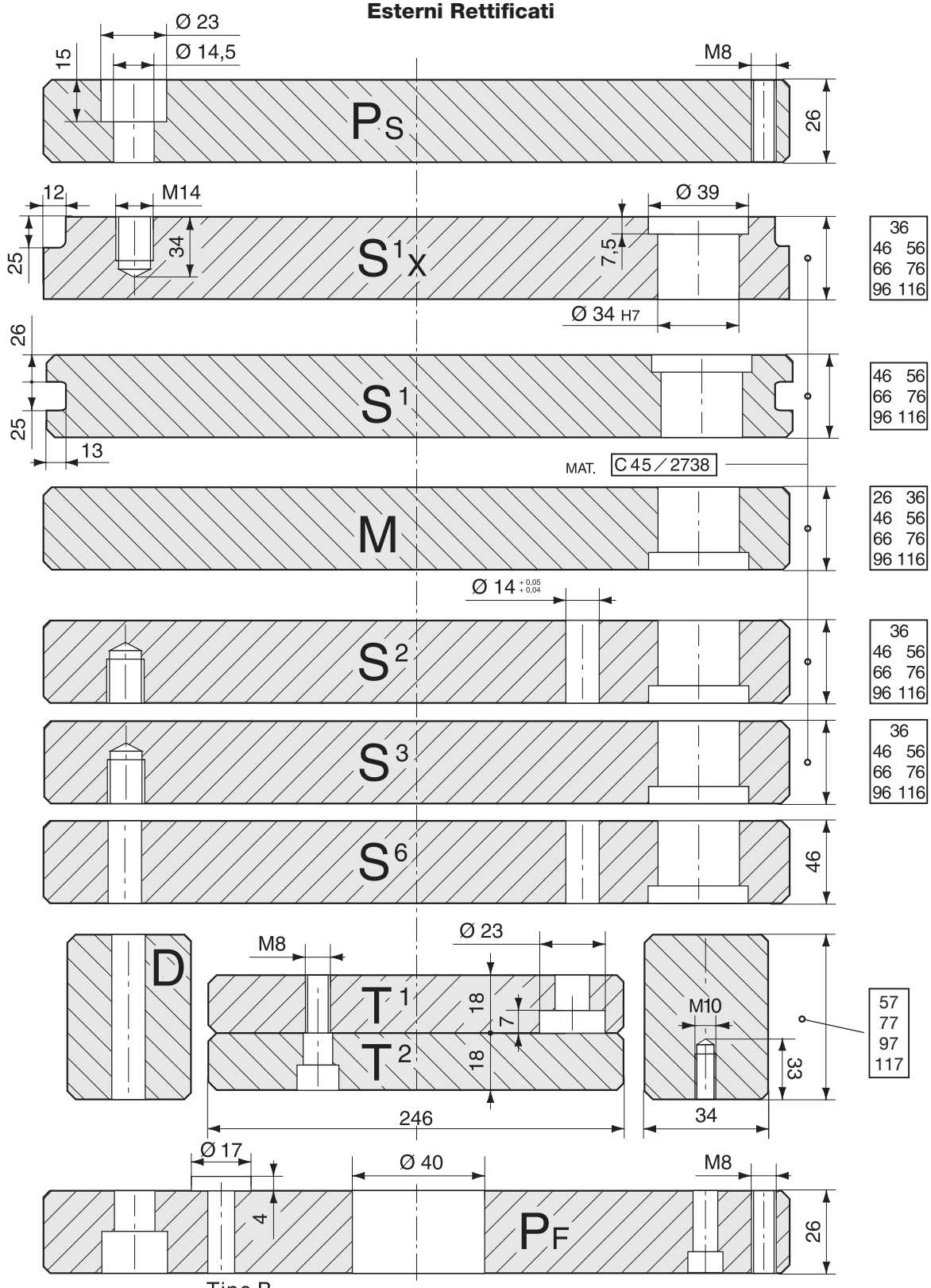


296 x 446

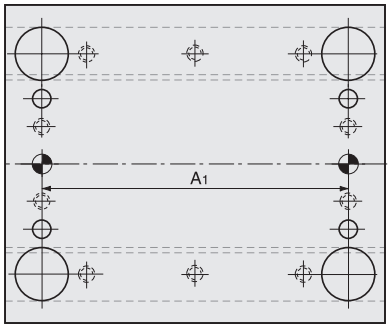


PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

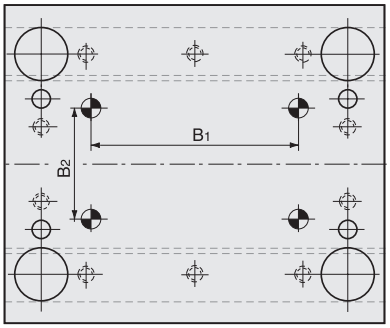
Esterni Rettificati



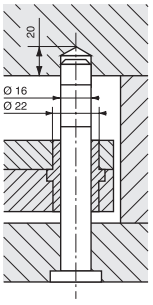
Tipo A



Tipo B



Guida Tavolino



Dimensione	A1	B1	B2
346 x 346	310	254	212
346 x 396	360	304	212
346 x 446	410	354	212
346 x 496	460	404	212

le misure sono espresse in millimetri

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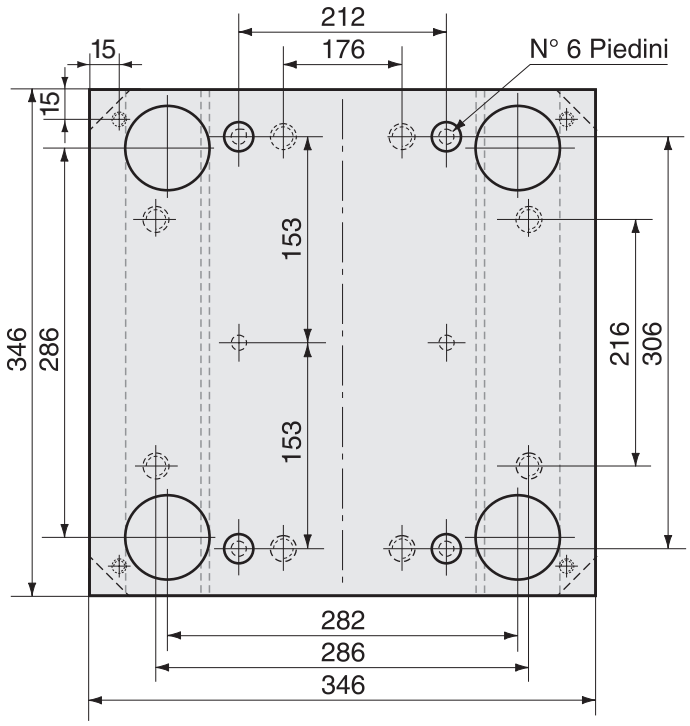
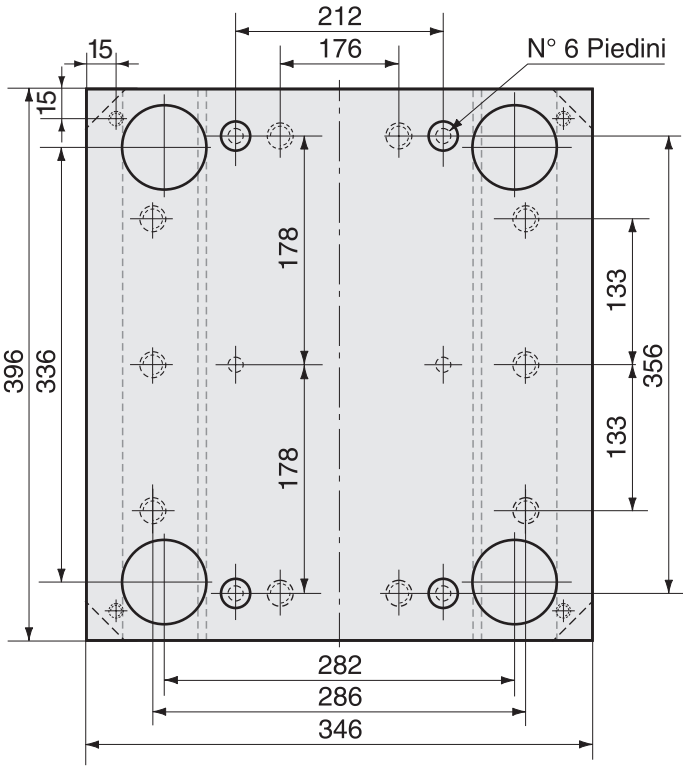
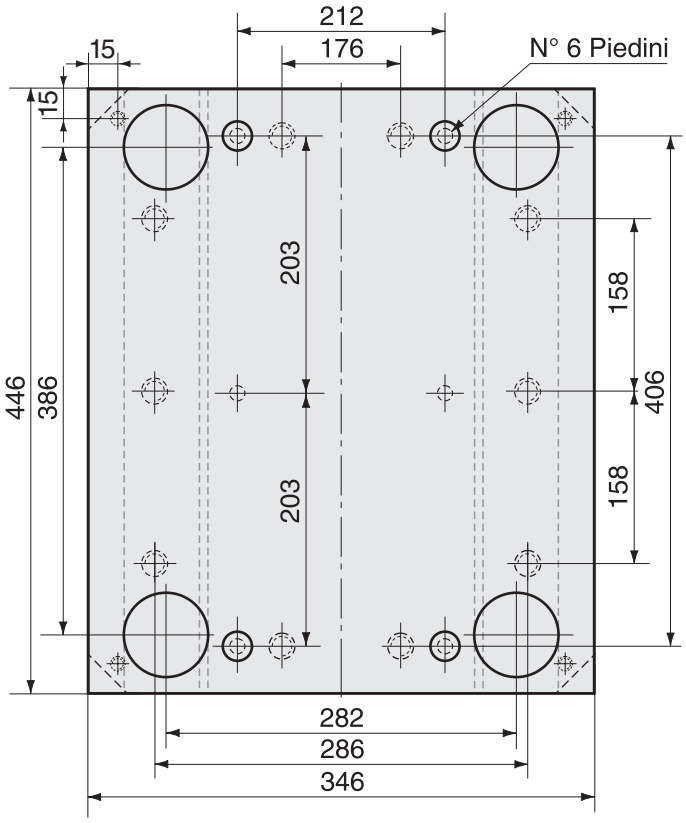
346 x 346



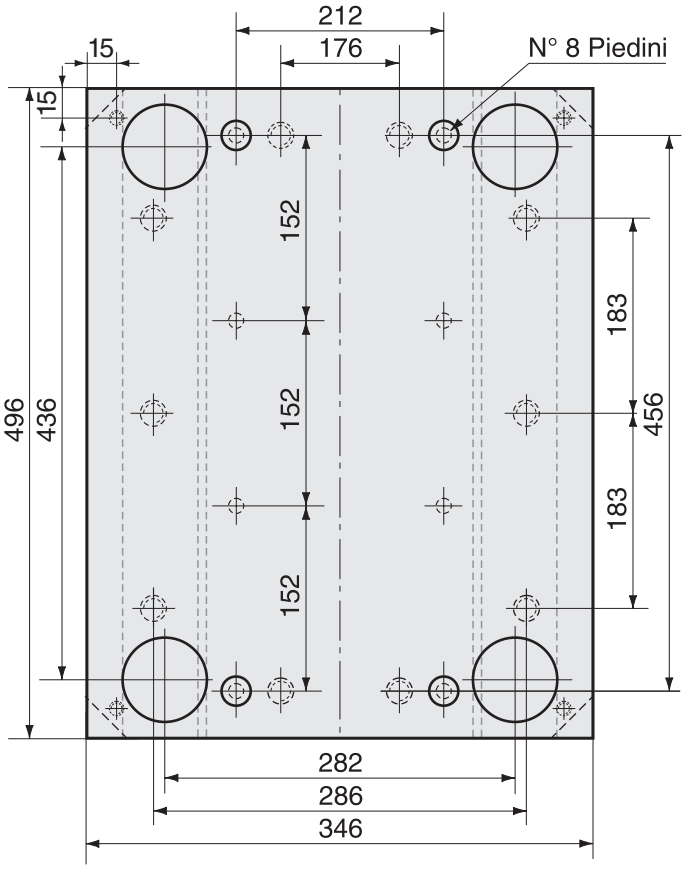
346 x 396



346 x 446

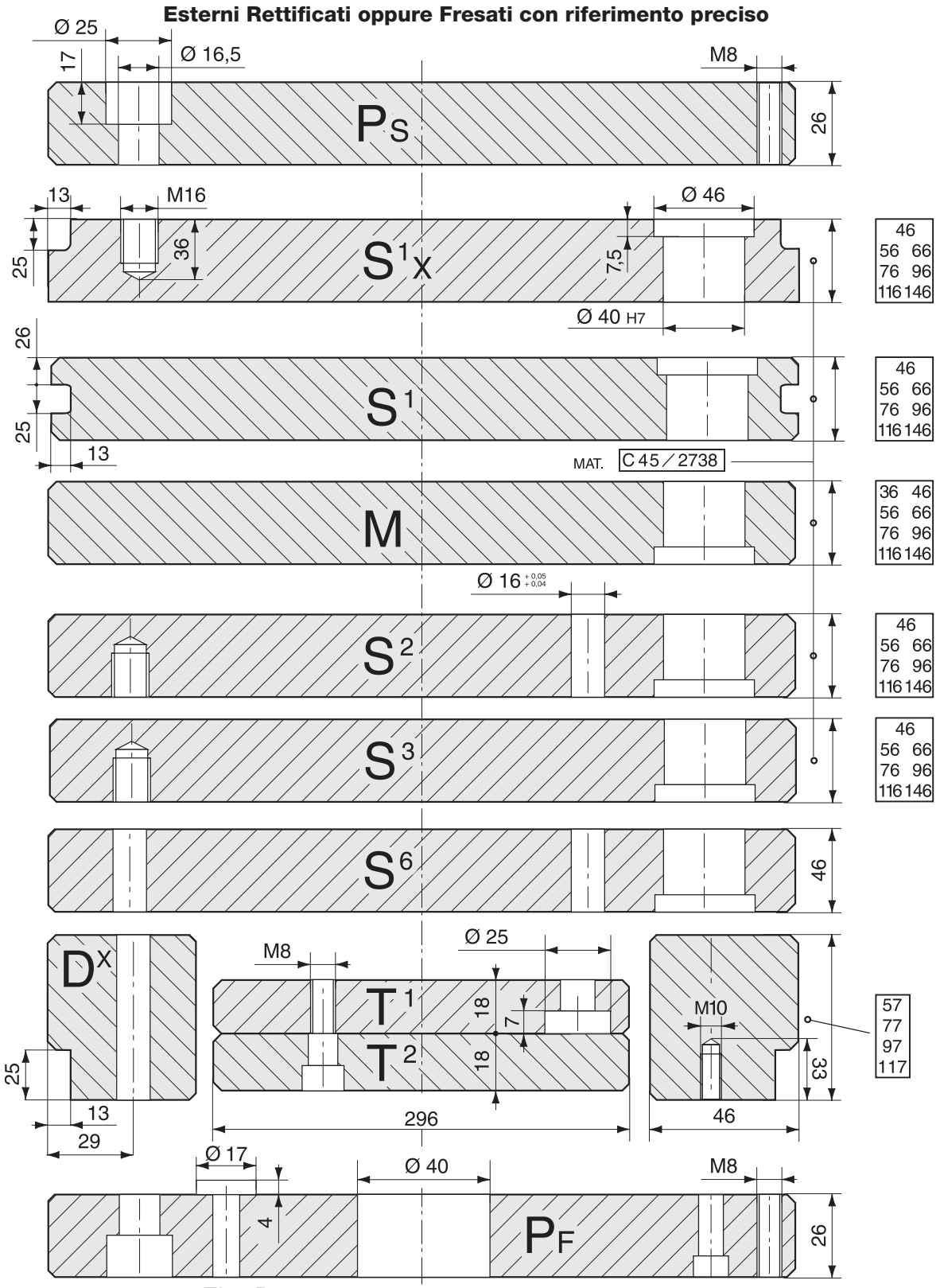


346 x 496

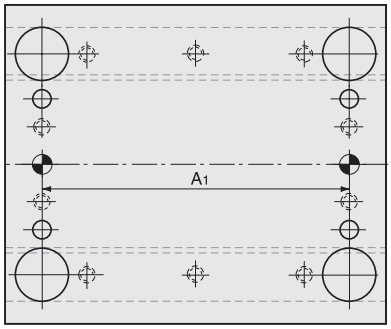


PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

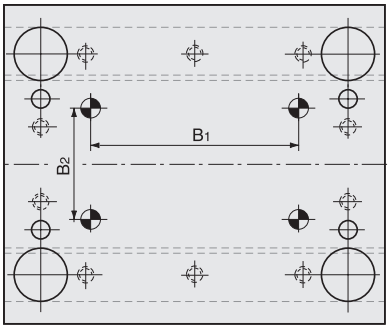
Esterni Rettificati oppure Fresati con riferimento preciso



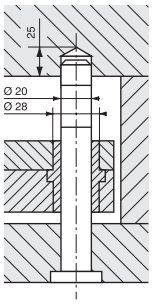
Tipo A



Tipo B



Guida Tavolino



Dimensione	A1	B1	B2
396 x 396	354	280	250
396 x 446	404	330	250
396 x 496	454	380	250
396 x 546	504	430	250

le misure sono espresse in millimetri

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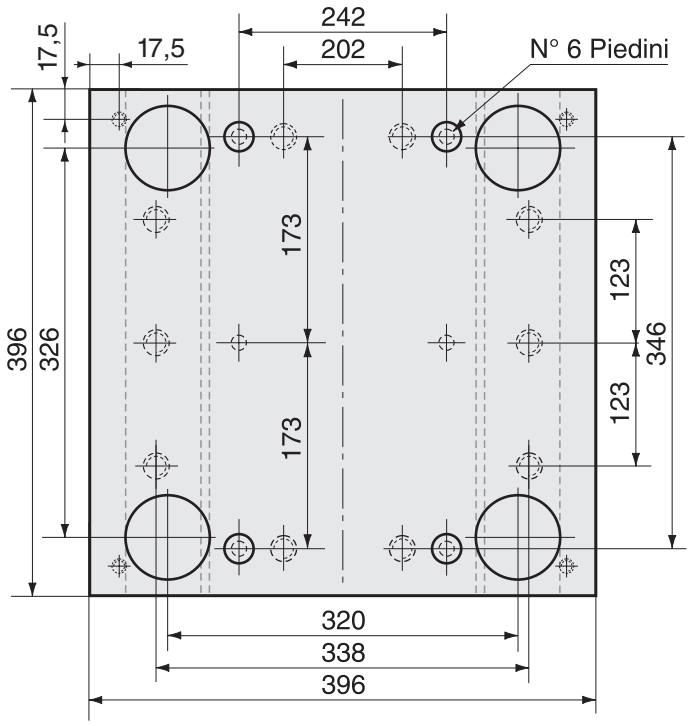
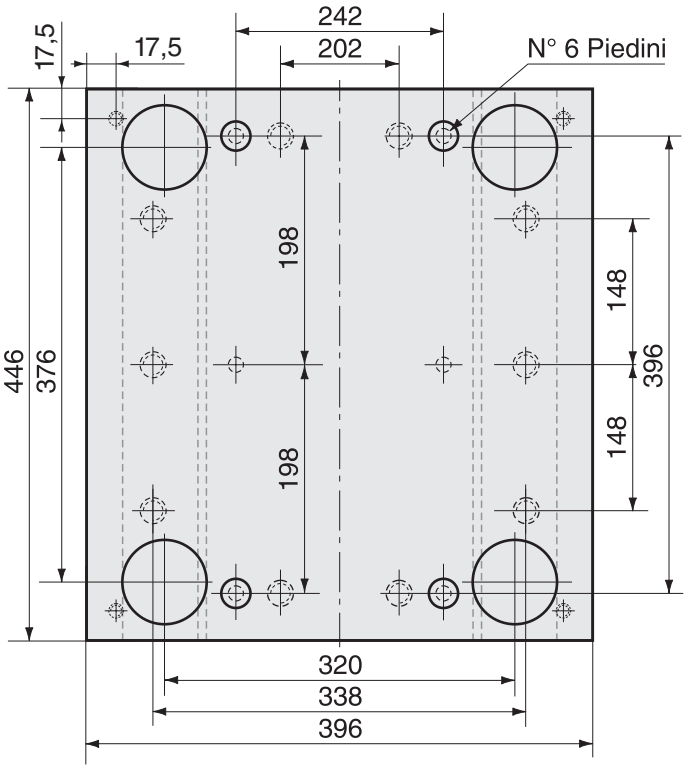
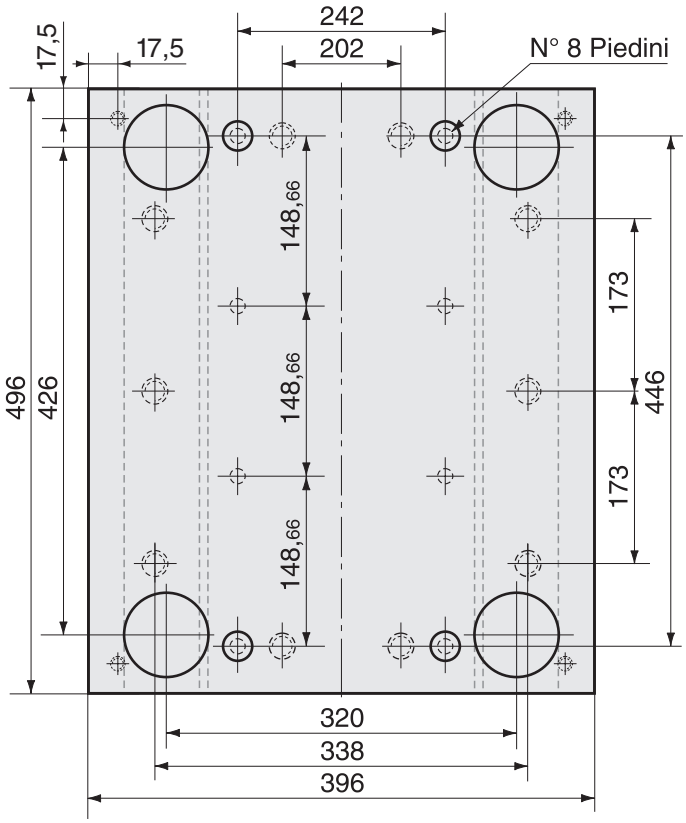
396 x 396



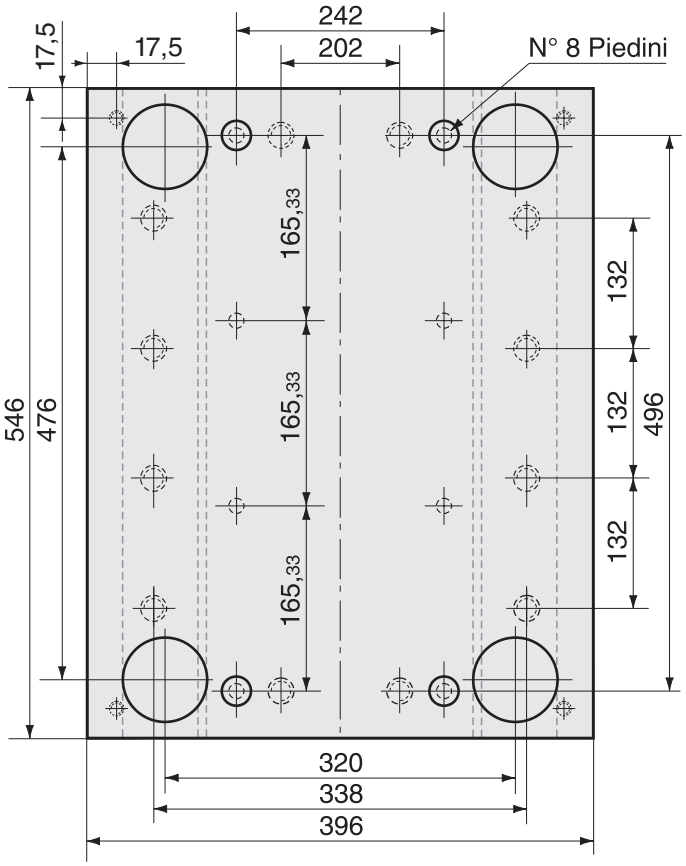
396 x 446



396 x 496



396 x 546



PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

Esterni Rettificati oppure Fresati con riferimento preciso

Ø 25 · 17 · Ø 16,5 · M8 · P_S · 26

13 · M16 · 25 · 36 · $S^1{}_X$ · Ø 46 · 7,5 · Ø 40 H7 · 46 / 56 66 / 76 96 / 116 146

26 · 25 · 13 · S^1 · 46 / 56 66 / 76 96 / 116 146

MAT. C 45 / 2738

M · 36 46 / 56 66 / 76 96 / 116 146

Ø 16 $^{+0,05}_{+0,04}$

S^2 · 46 / 56 66 / 76 96 / 116 146

S^3 · 46 / 56 66 / 76 96 / 116 146

S^6 · 46

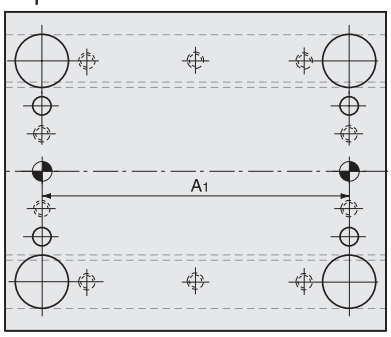
D^X · 25 · 13 · 29

M8 · Ø 25 · T^1 · T^2 · 22 · 7 · 22 · 346

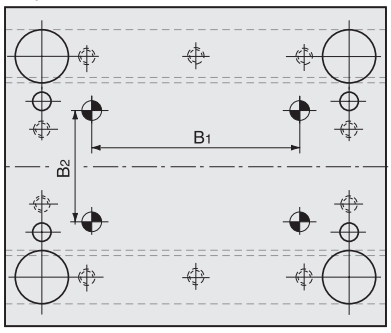
M10 · 33 · 46 · 57 / 77 / 97 / 117

Ø 17 · Ø 40 · M8 · 4 · P_F · 26

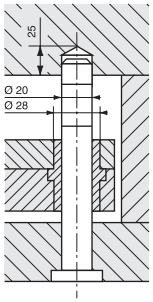
Tipo A



Tipo B



Guida Tavolino



Dimensione	A1	B1	B2
446 x 446	404	330	300
446 x 496	454	380	300
446 x 546	504	430	300
446 x 596	554	480	300

le misure sono espresse in millimetri

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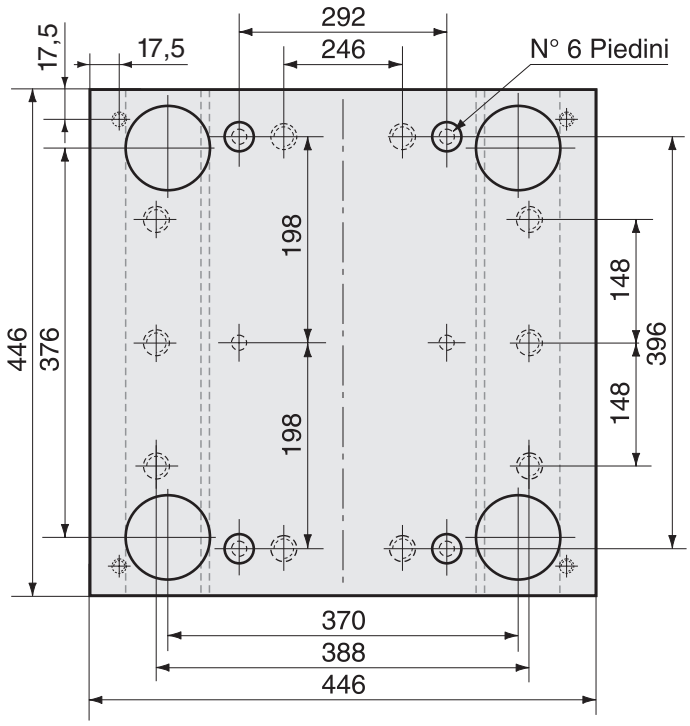
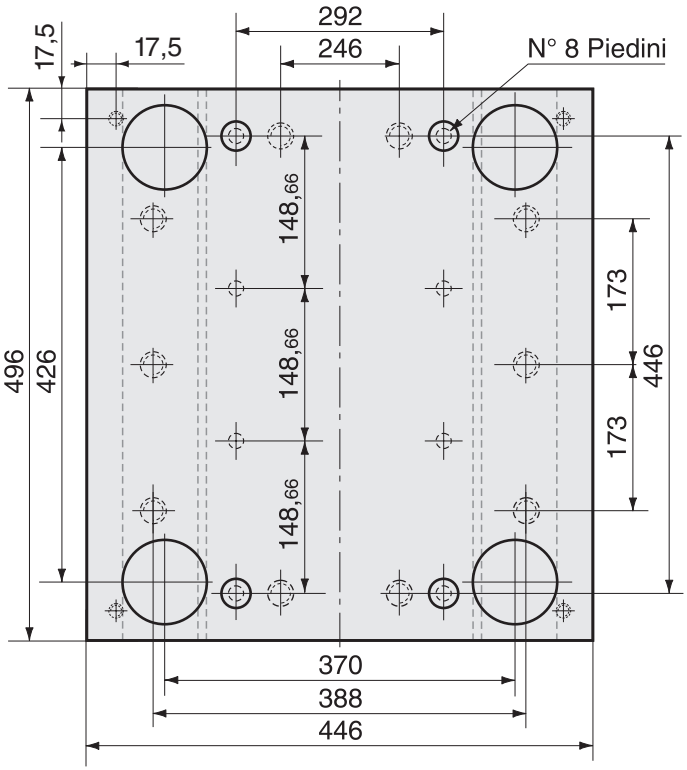
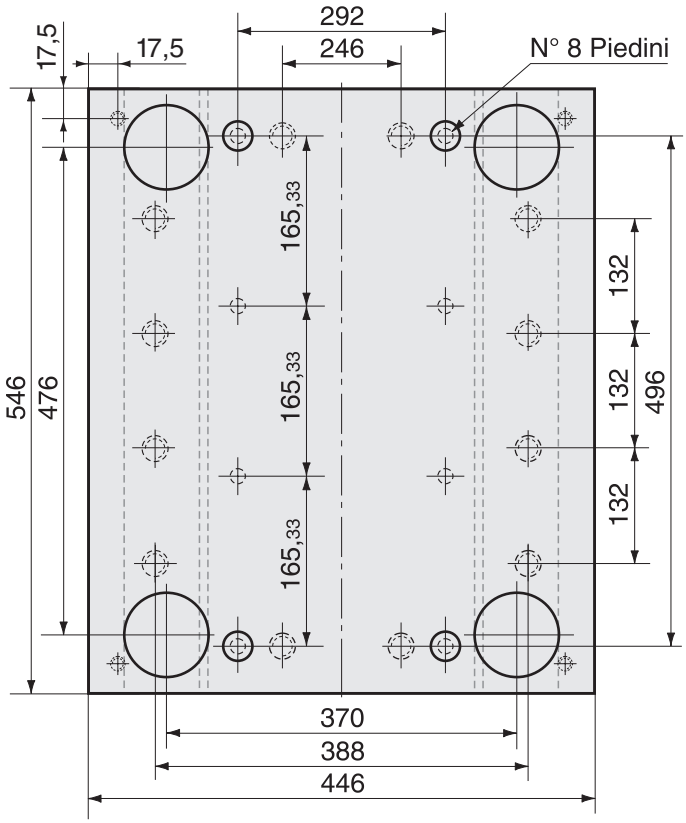
446 x 446



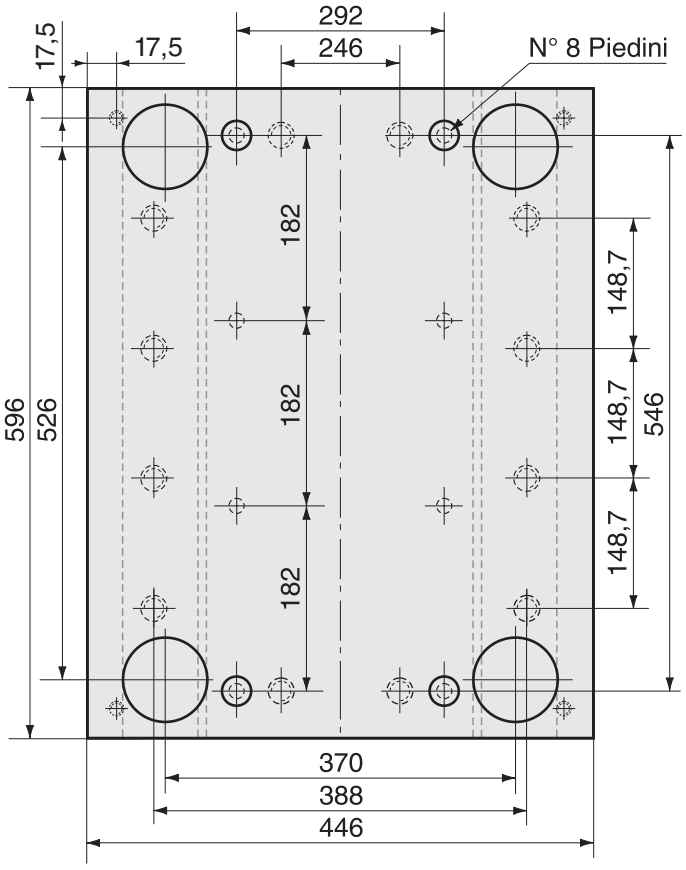
446 x 496



446 x 546

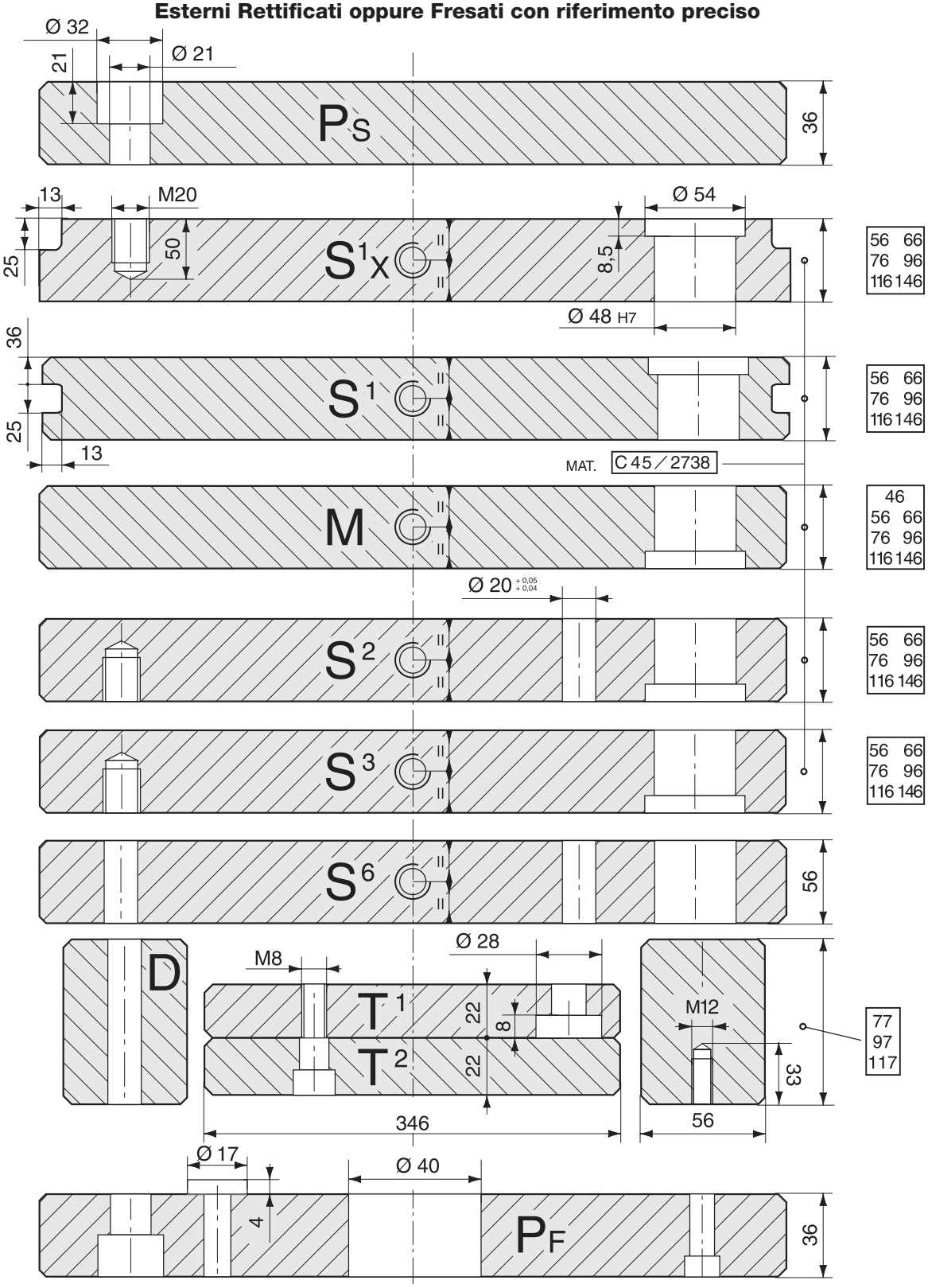


446 x 596

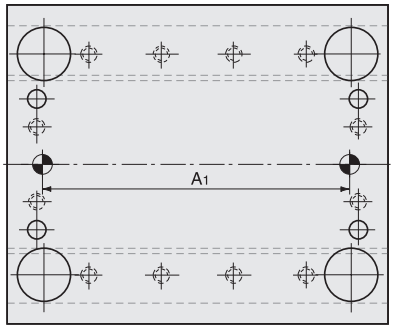


PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

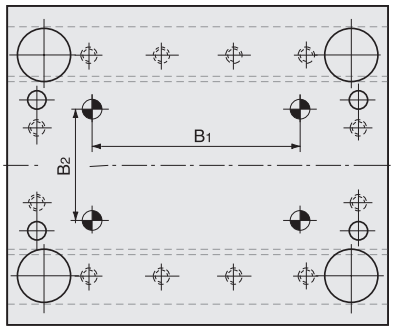
Esterni Rettificati oppure Fresati con riferimento preciso



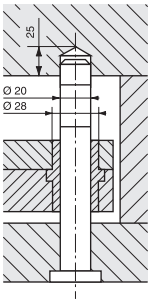
Tipo A



Tipo B



Guida Tavolino



Dimensione	A1	B1	B2
490 x 496	454	370	306
490 x 546	504	420	306
490 x 596	554	470	306
490 x 646	604	520	306
490 x 696	654	570	306

le misure sono espresse in millimetri

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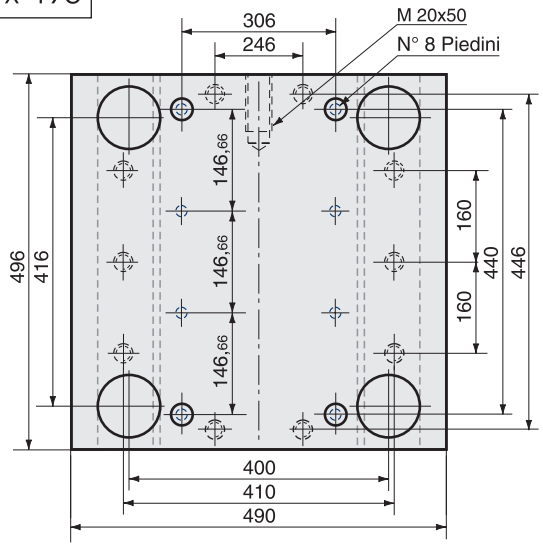
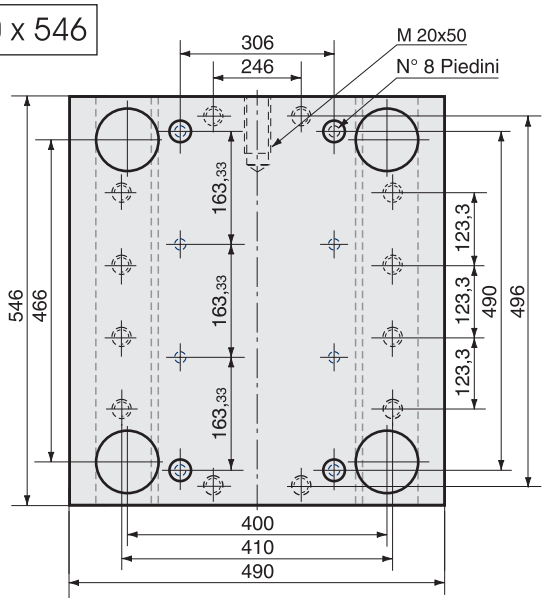
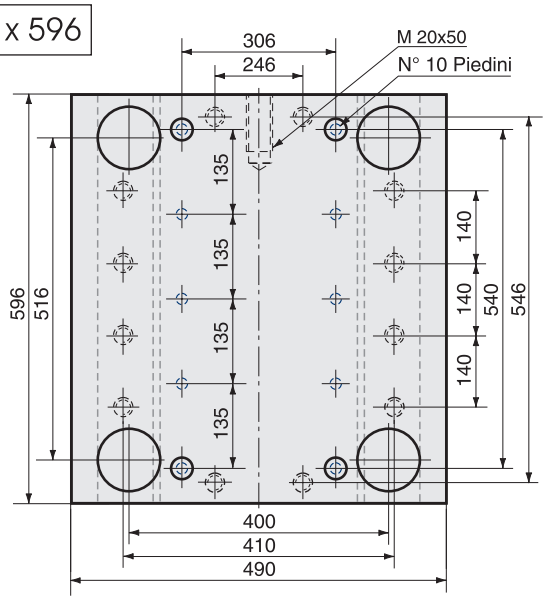
490 x 496



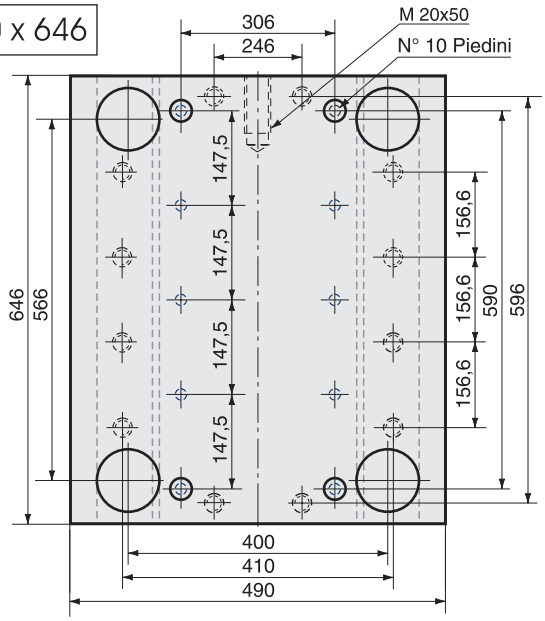
490 x 546



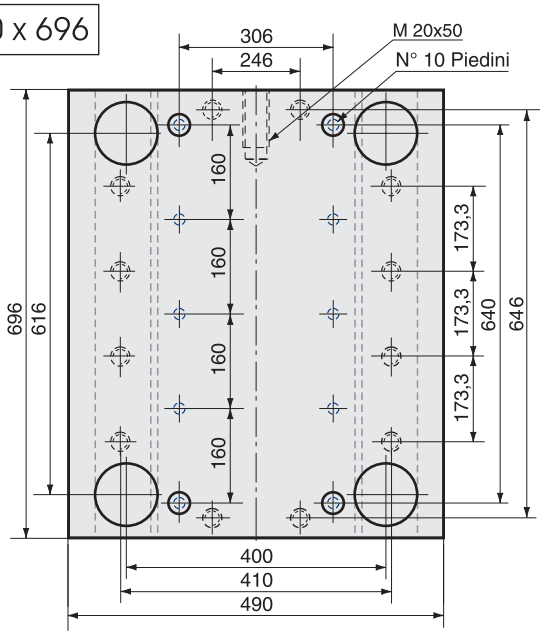
490 x 596



490 x 646



490 x 696



PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

Esterni Rettificati oppure Fresati con riferimento preciso

Ø 32
Ø 21
21
P_S
36

13
M20
Ø 54
25
50
S^1_X
8,5
Ø 48 H7
56 66
76 96
116 146

36
S^1
25
13
MAT. C 45 / 2738
56 66
76 96
116 146

M
46
56 66
76 96
116 146

Ø 20 +0,05 +0,04
S^2
56 66
76 96
116 146

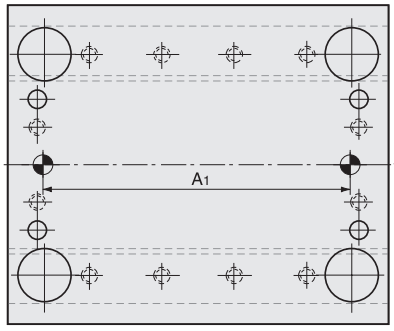
S^3
56 66
76 96
116 146

S^6
56

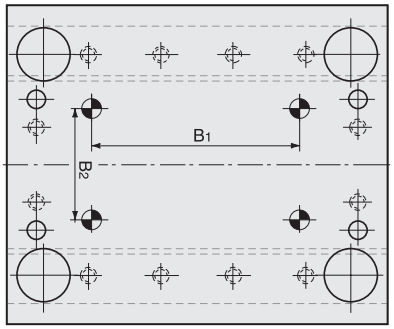
D
M10
Ø 28
T^1
22
8
T^2
22
M12
33
77
97
117
396
56

Ø 17
Ø 40
4
P_F
36

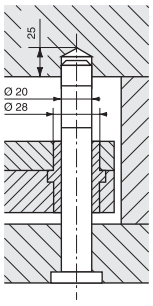
Tipo A



Tipo B



Guida Tavolino



Dimensione	A_1	B_1	B_2
540 x 546	504	420	356
540 x 596	554	470	356
540 x 646	604	520	356
540 x 696	654	570	356
540 x 746	704	620	356
540 x 796	754	670	356

le misure sono espresse in millimetri

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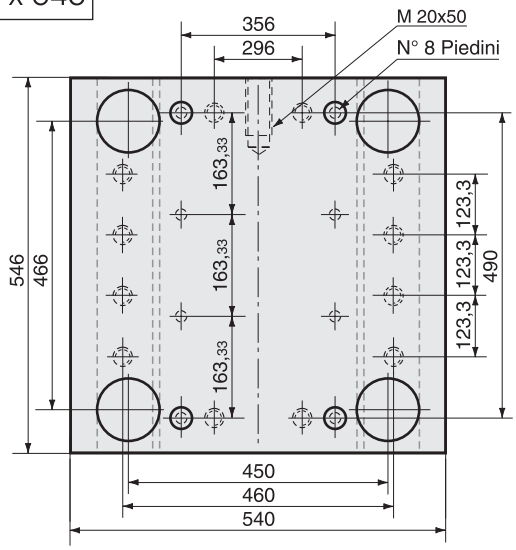
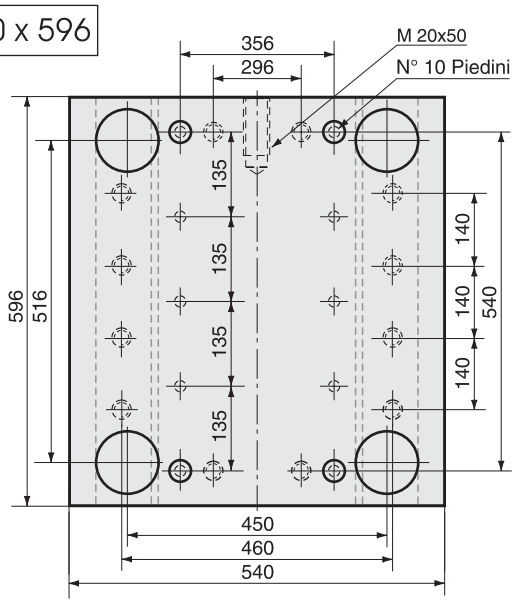
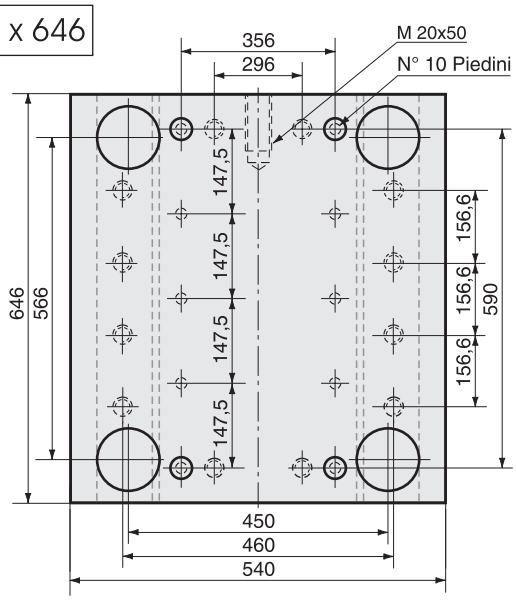
540 x 546



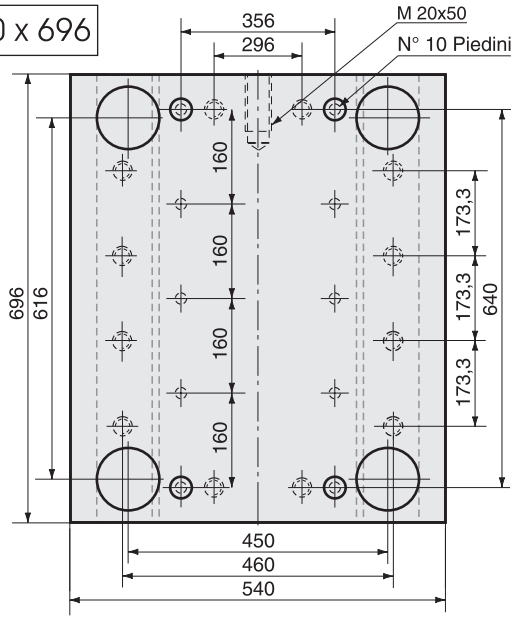
540 x 596



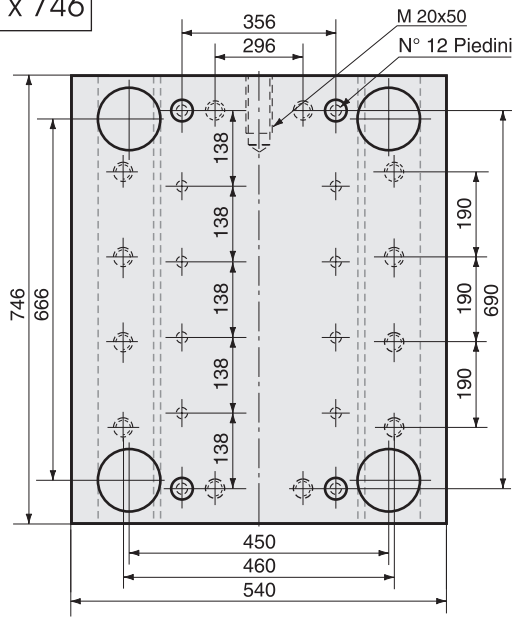
540 x 646



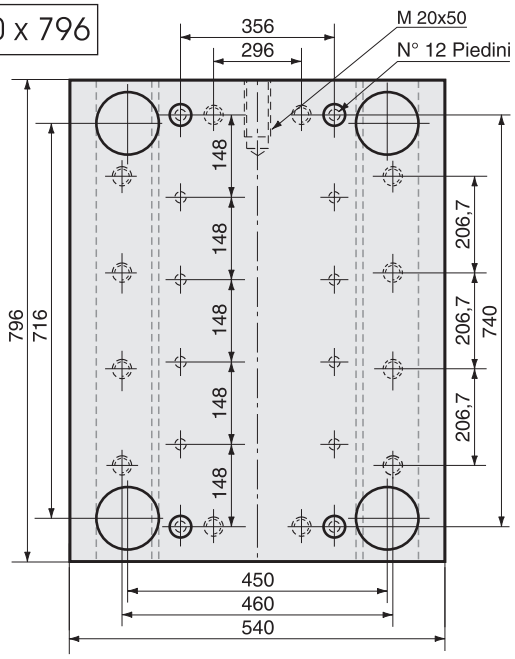
540 x 696



540 x 746



540 x 796



PIASTRE DI NORMALE PRODUZIONE CON PIANI RETTIFICATI

Esterni Rettificati oppure Fresati con riferimento preciso

Ø 32
Ø 21
21
P_S
36

13
M20
Ø 54
25
50
S^1x
8,5
Ø 48 H7
56 66
76 96
116 146

36
S^1
25
13
MAT. C 45 / 2738
56 66
76 96
116 146

M
46
56 66
76 96
116 146

Ø 20 +0,05 +0,04
S^2
56 66
76 96
116 146

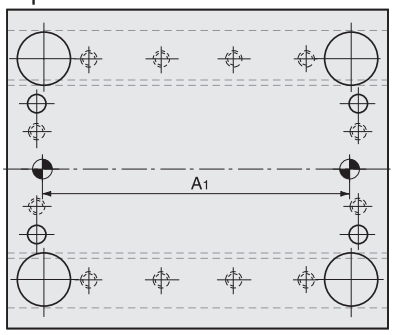
S^3
56 66
76 96
116 146

S^6
56

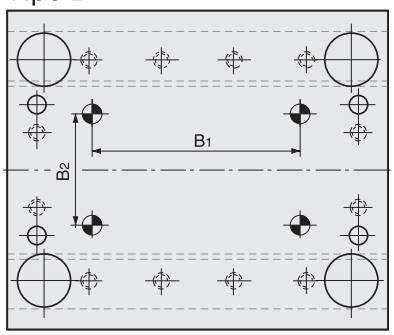
D
M10
Ø 28
T^1
26
8
T^2
26
M12
33
77
97
117
446
56

Ø 17
Ø 40
4
P_F
36

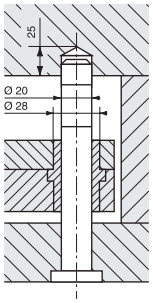
Tipo A



Tipo B



Guida Tavolino



Dimensione	A_1	B_1	B_2
590 x 596	554	470	406
590 x 646	604	520	406
590 x 696	654	570	406
590 x 746	704	620	406
590 x 796	754	670	406

le misure sono espresse in millimetri

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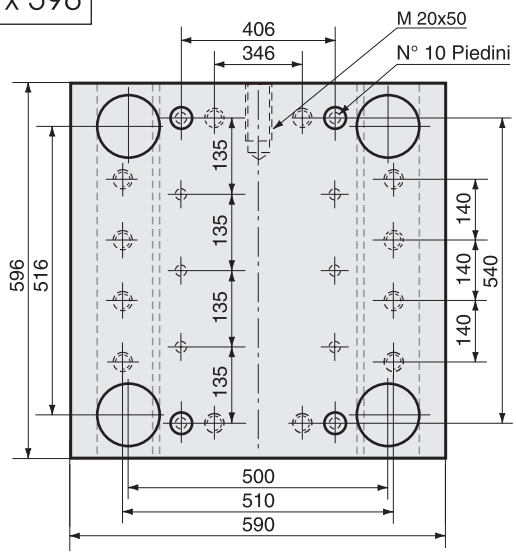
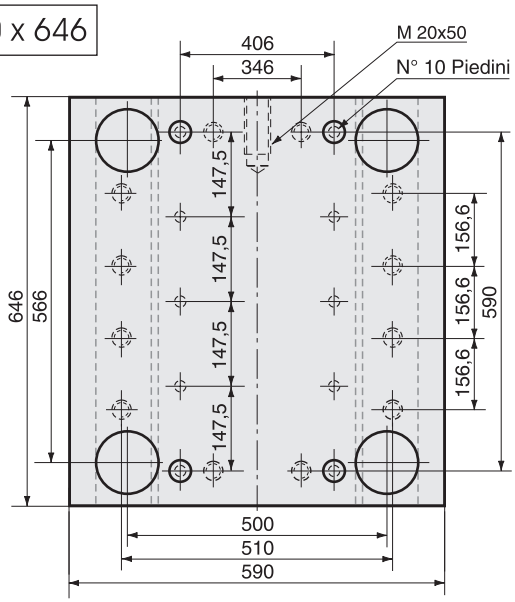
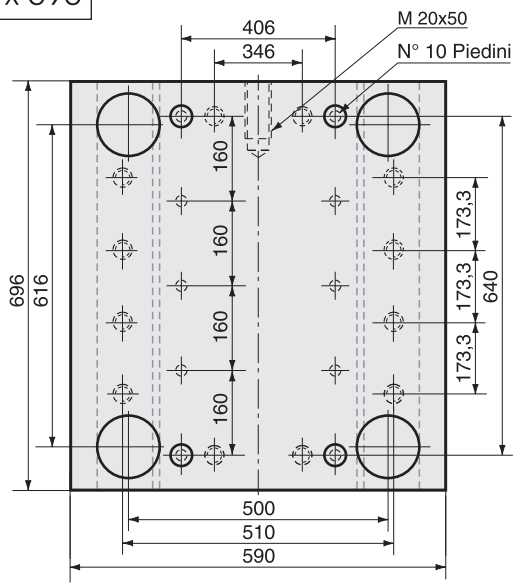
590 x 596



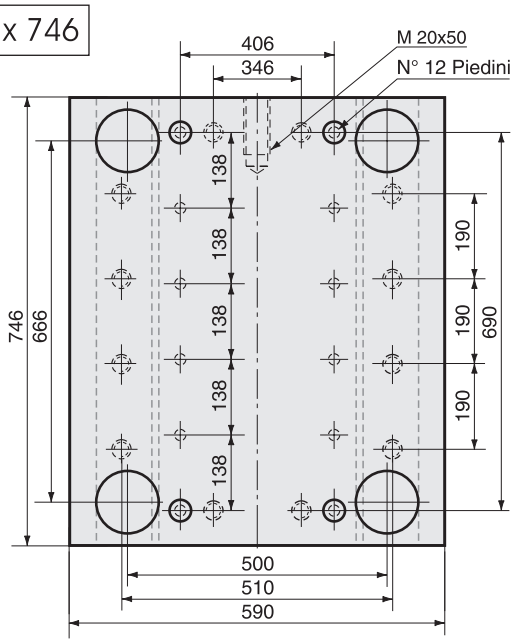
590 x 646



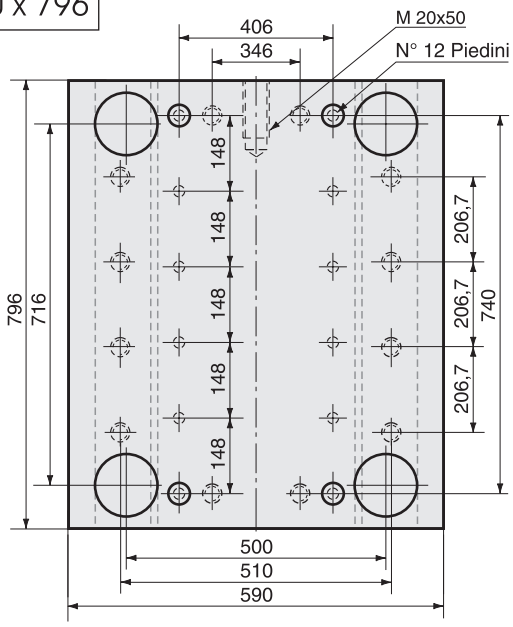
590 x 696



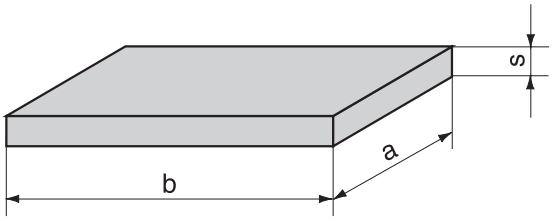
590 x 746



590 x 796



PIASTRE LISCE
Piani Rettificati



a	b	s									
		22	26	36	46	56	66	76	96	116	146
156	156	•	•	•	•	•	•	•			
	196	•	•	•	•	•	•	•			
	246	•	•	•	•	•	•	•			
196	196	•	•	•	•	•	•	•	•		
	246	•	•	•	•	•	•	•	•		
	296	•	•	•	•	•	•	•	•		
	346	•	•	•	•	•	•	•	•		
246	246	•	•	•	•	•	•	•	•		
	296	•	•	•	•	•	•	•	•		
	346	•	•	•	•	•	•	•	•		
	396	•	•	•	•	•	•	•	•		
296	296		•	•	•	•	•	•	•	•	
	346		•	•	•	•	•	•	•	•	
	396		•	•	•	•	•	•	•	•	
	446		•	•	•	•	•	•	•	•	
346	346		•	•	•	•	•	•	•	•	
	396		•	•	•	•	•	•	•	•	
	446		•	•	•	•	•	•	•	•	
	496		•	•	•	•	•	•	•	•	
396	396		•	•	•	•	•	•	•	•	•
	446		•	•	•	•	•	•	•	•	•
	496		•	•	•	•	•	•	•	•	•
	546		•	•	•	•	•	•	•	•	•
446	446		•	•	•	•	•	•	•	•	•
	496		•	•	•	•	•	•	•	•	•
	546		•	•	•	•	•	•	•	•	•
	596		•	•	•	•	•	•	•	•	•
490	496			•	•	•	•	•	•	•	•
	546			•	•	•	•	•	•	•	•
	596			•	•	•	•	•	•	•	•
	646			•	•	•	•	•	•	•	•
	696			•	•	•	•	•	•	•	•
540	546			•	•	•	•	•	•	•	•
	596			•	•	•	•	•	•	•	•
	646			•	•	•	•	•	•	•	•
	696			•	•	•	•	•	•	•	•
	746			•	•	•	•	•	•	•	•
	796			•	•	•	•	•	•	•	•
590	596			•	•	•	•	•	•	•	•
	646			•	•	•	•	•	•	•	•
	696			•	•	•	•	•	•	•	•
	746			•	•	•	•	•	•	•	•
	796			•	•	•	•	•	•	•	•

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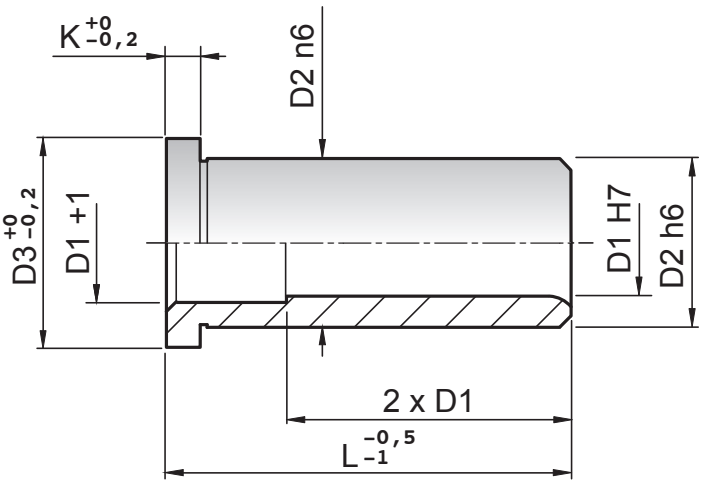
BUSSOLA GUIDA CON COLLARE B1

Materiale: 1.7131

Trattamento Termico:
Cementazione + Tempra

Durezza: Hrc 61÷63



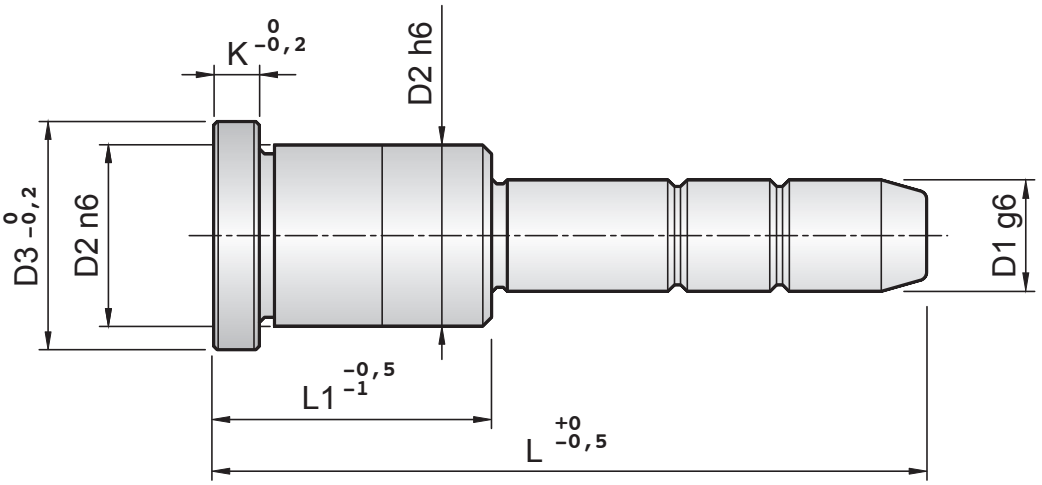
D1		12	14	16	18	20	25	32	40	50	60
D2		18	20	22	26	28	36	40	48	60	74
D3		22	24	26	30	32	38	45	52	65	84
K		5	5	5	5	6	7	7	8	10	12
L	22	★	★	★	★	★					
	26	★	★	★	★	★	★	★			
	36	★	★	★	★	★	★	★	★		
	46	★	★	★	★	★	★	★	★		
	56	★	★	★	★	★	★	★	★		
	66		★	★	★	★	★	★	★		
	76			★	★	★	★	★	★	★	
	86			★	★	★	★	★	★	★	
	96			★	★	★	★	★	★	★	★
	106					★	★	★	★	★	★
	116					★	★	★	★	★	★
	126					★	★	★	★	★	★
	136							★	★	★	
	146							★	★	★	★
	156									★	★
	176										★
	196										★

COLONNA GUIDA A DUE DIAMETRI C1

Materiale: 1.7131

Trattamento Termico:
Cementazione + Tempra

Durezza: Hrc 61÷63



D1	D2	D3	K	L1	50	60	70	80	90	100	120	140	160	180	200	220	240	260	280	300	340
12	18	22	5	22	★	★	★	★	★	★											
				26	★	★	★	★	★	★											
				36	★	★	★	★	★	★	★										
				46			★	★	★	★	★										
				56					★	★	★										
14	20	24	5	22	★	★	★	★	★	★											
				26		★	★	★	★	★	★										
				36			★	★	★	★	★										
				46			★	★	★	★	★										
				56					★	★	★										
16	22	26	5	22	★	★	★	★	★	★	★										
				26	★	★	★	★	★	★	★	★									
				36		★	★	★	★	★	★	★									
				46			★	★	★	★	★	★	★								
				56				★	★	★	★	★	★	★	★						
				66						★	★	★	★	★	★						
				76						★	★	★	★	★	★						
				96								★	★	★	★						
18	26	30	5	26		★	★	★	★	★											
				36		★	★	★	★	★	★	★									
				46			★	★	★	★	★	★	★								
				56				★	★	★	★	★	★	★							
				66						★	★	★	★	★							
				76							★	★	★	★							
20	28	32	6	26		★	★	★	★	★	★	★									
				36		★	★	★	★	★	★	★	★								
				46			★	★	★	★	★	★	★								
				56				★	★	★	★	★	★	★	★						
				66						★	★	★	★	★	★						
				76							★	★	★	★	★						
				86								★	★	★	★						
				96								★	★	★	★						

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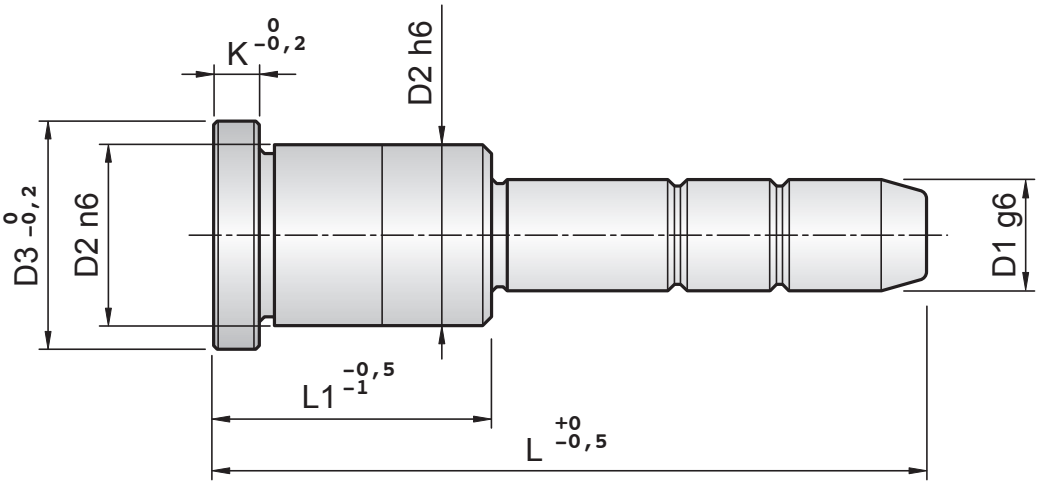
COLONNA GUIDA A DUE DIAMETRI C1

Materiale: 1.7131

Trattamento Termico:
Cementazione + Tempra

Durezza: Hrc 61÷63



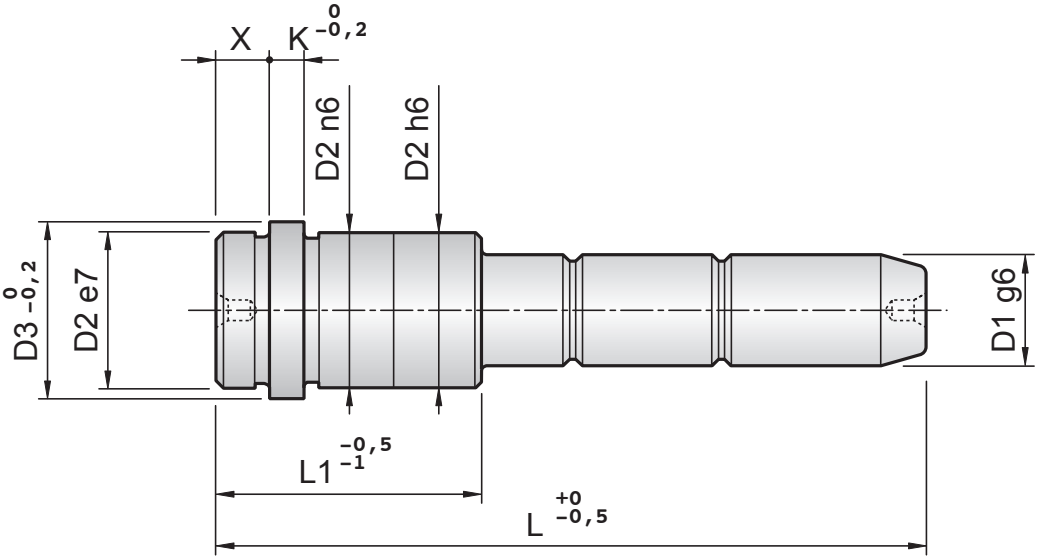
D1	D2	D3	K	L1	60	70	80	90	100	120	140	160	180	200	220	240	260	280	300	340	400
25	34	38	7	26			★	★	★												
				36			★	★	★	★	★	★	★								
				46				★	★	★	★	★	★	★							
				56					★	★	★	★	★	★	★	★					
				66						★	★	★	★	★	★	★	★	★			
				76						★	★	★	★	★	★	★	★	★			
				86							★	★	★	★	★	★	★	★			
				96							★	★	★	★	★	★	★	★			
				116								★	★	★	★	★	★	★			
32	40	45	7	36					★	★											
				46					★	★	★	★									
				56					★	★	★	★	★	★	★	★					
				66						★	★	★	★	★	★	★	★	★			
				76							★	★	★	★	★	★	★	★			
				86								★	★	★	★	★	★	★			
				96								★	★	★	★	★	★	★	★	★	
				106								★	★	★	★	★	★	★	★	★	
				116								★	★	★	★	★	★	★	★	★	★
				126									★	★	★	★	★	★	★	★	★
				146										★	★	★	★	★	★	★	★
40	48	52	8	46						★	★	★	★	★							
				56						★	★	★	★	★	★						
				66								★	★	★	★	★					
				76								★	★	★	★	★	★				
				86								★	★	★	★	★	★	★			
				96								★	★	★	★	★	★	★	★	★	
				106									★	★	★	★	★	★	★	★	
				116									★	★	★	★	★	★	★	★	★
				126									★	★	★	★	★	★	★	★	★
				146												★	★	★	★	★	★
50	60	65	10	96									★	★	★	★	★	★	★	★	
				126											★	★	★	★	★	★	★
				146												★	★	★	★	★	★

COLONNA GUIDA SPALLATA C1S

Materiale: 1.7131

Trattamento Termico:
Cementazione + Tempra

Durezza: Hrc 61÷63



D1	D2	D3	K	X	L1	L=lunghezza totale							
						80	90	110	130	150	170	190	210
16	22	26	5	10	36	★	★	★	★				
					46		★	★	★	★			
					56			★	★	★	★		
					66			★	★	★	★		
					76				★	★	★	★	
					86					★	★	★	
20	28	32	6	10	46	★	★	★	★	★			
					56		★	★	★	★	★		
					66			★	★	★	★		
					76				★	★	★		
					86					★	★	★	
					106					★	★	★	★
25	34	38	7	10	46		★	★	★	★			
					56		★	★	★	★	★		
					66			★	★	★	★		
					76				★	★	★	★	
					86					★	★	★	
					106					★	★	★	★
32	40	45	7	10	46			★	★	★			
					56			★	★	★	★		
					66			★	★	★	★	★	
					76				★	★	★	★	
					86					★	★	★	
					106						★	★	★
40	48	52	8	10	56				★	★			
					66				★	★	★		
					76					★	★	★	★
					86					★	★	★	★
					106						★	★	★

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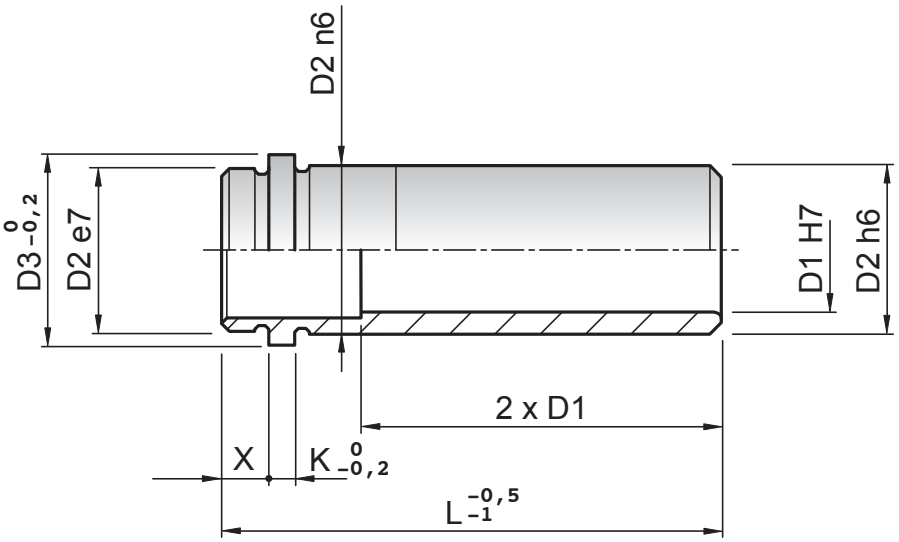
BUSSOLA SPALLATA B1S

Materiale: 1.7131

Trattamento Termico:
Cementazione + Tempra

Durezza: Hrc 61÷63



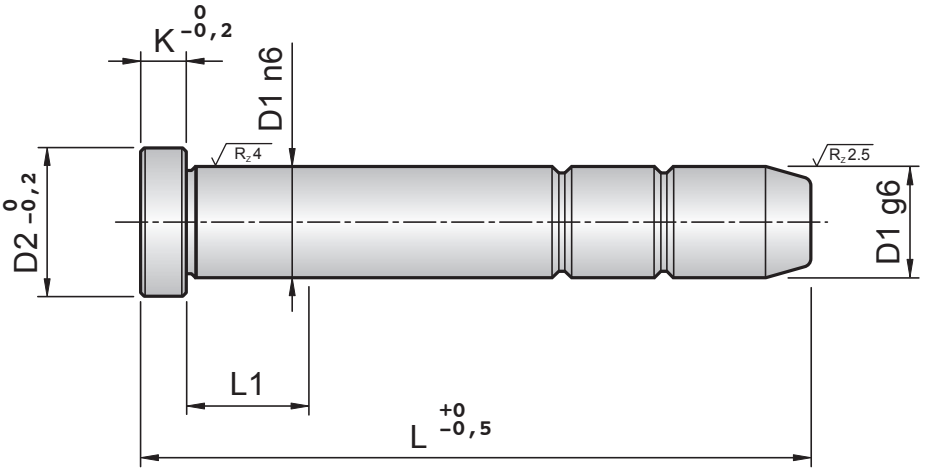
D1	D2	D3	K	X	L=lunghezza totale									
					26	36	46	56	66	76	86	96	106	126
16	22	26	5	10	★	★	★	★	★	★	★	★	★	
20	28	32	6	10	★	★	★	★	★	★	★	★	★	
25	34	38	7	10		★	★	★	★	★	★	★	★	
32	40	45	7	10			★	★	★	★	★	★	★	★
40	48	52	8	10				★	★	★	★	★	★	★

COLONNA GUIDA A UN DIAMETRO C2

Materiale: 1.7131

Trattamento Termico:
Cementazione + Tempra

Durezza: Hrc 61÷63



D1		12	14	16	18	20	25	32	40	50	60
D2		16	18	20	22	24	30	37	45	55	68
K		5	5	5	5	6	7	7	8	10	12
L	L1										
50	8	★	★	★	★						
60	8	★	★	★	★	★					
70	8	★	★	★	★	★					
80	15	★	★	★	★	★	★				
90	15	★	★	★	★	★	★				
100	20	★	★	★	★	★	★				
110	20		★	★	★	★					
120	20	★	★	★	★	★	★	★	★		
130	20		★	★	★	★					
140	20	★	★	★	★	★	★	★	★		
150	20		★	★	★	★					
160	20	★	★	★	★	★	★	★	★		
180	25		★	★	★	★	★	★	★		
200	25			★	★	★	★	★	★		
220	25			★	★	★	★	★	★		
240	35					★	★	★	★	★	
260	35					★	★	★	★	★	
280	35					★	★	★	★	★	
300	45					★	★	★	★	★	
350	55						★	★	★	★	★
400	55						★	★	★	★	★
450	65							★	★	★	★
500	65								★	★	★
600	75									★	★
800	75										★

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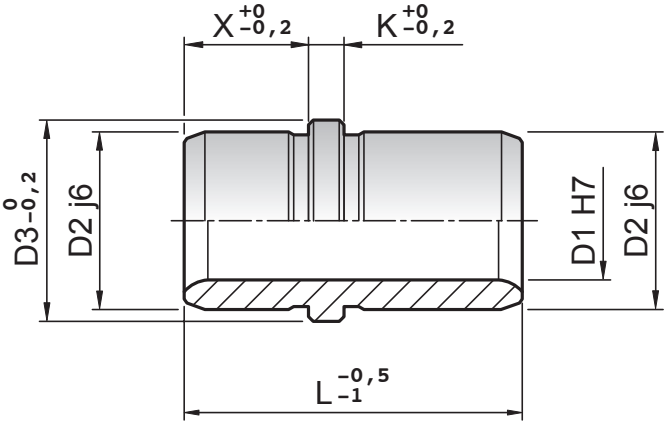
BUSSOLA SPALLATA B3

Materiale: 1.7131

Trattamento Termico:
Cementazione + Tempra

Durezza: Hrc 61÷ 63



D1	D2	D3	X	K	L	
12	18	22	16	5	32	40
14	20	24	12	5	29	40
16	22	26	16	5	32	40
18	26	30	16	5	32	40
20	28	32	16	6	32	40
25	34	38	16	7	32	40
32	40	45	25	7	50	65
40	48	52	32	8	65	80
50	60	65	32	10	70	90

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