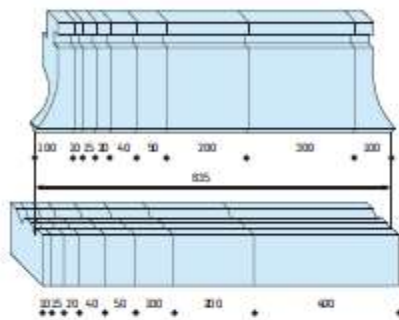


GENERAL INFORMATION

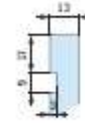
standard tools TYPE "A"

Sectionalized tool TYPE "A"

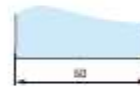
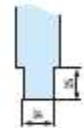


Material	Standard lengths
C45, C50, 41Cr4 or 42CrMo4	835 and 415 mm
Working edge hardened	Segment length
53-2 HRC	as shown on drawing

Punch mounting edge

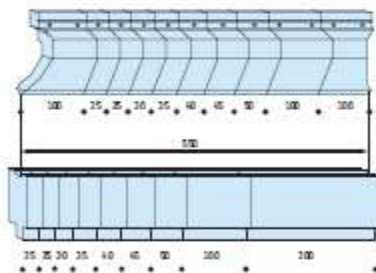


Die mounting edge



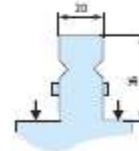
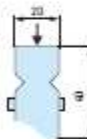
standard tools TYPE "T"

Sectionalized tool TYPE "T"



Material	Working edge hardened
C45, 42CrMo4 or 1.2312	53-2 HRC (1500 - 1600 MPa)
Thermal enhancement to*	Length
30-2 HRC (950 - 1100 MPa)	835, 600 and 550 mm segmented
* applies to 1.2312	

Punch mounting edge



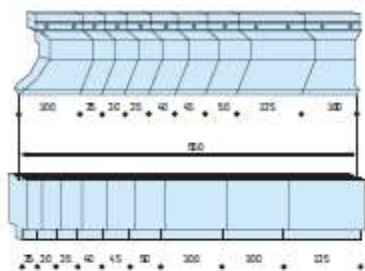
Die mounting edge



GENERAL INFORMATION

standard tools TYPE "L"

Sectionalized tool TYPE "L"



Material

C45, 42CrMo4 or 1.2312

Thermal enhancement to*

30-2 HRC (950 - 1100 MPa)

* applies to 1.2312

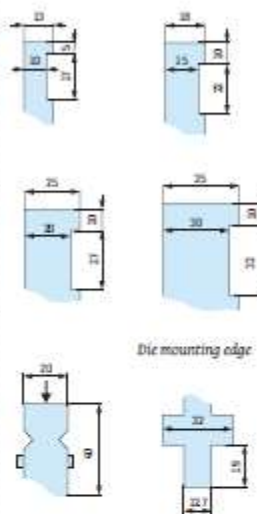
Working edge hardened

53-2 HRC (1500 - 1600 MPa)

Length

508 and 550 mm segmented

Punches type "L" have five different clampings



tool ordering code

Punches i.e 2010/88/R0.B/835

2010/88/R0.B/835 - Catalogue number

2010/88/R0.B/835 - Angle $\alpha = 30^\circ, 35^\circ, 60^\circ, 75^\circ, 80^\circ, 88^\circ, 90^\circ$

2010/88/R0.B/835 - Working edge type - thus "F" or "K" and size

2010/88/R0.B/835 - Length of tool - thus 835 mm, 415 mm, 835 mm sectionalized

Dies i.e 6112/35/835

6112/35/835 - Catalogue number

6112/35/835 - Angle $\alpha = 30^\circ, 35^\circ, 60^\circ, 85^\circ, 88^\circ, 90^\circ$

6112/35/835 - Length of tool - thus 835 mm, 415 mm, 835 mm sectionalized

special tools

Material

C45, 42CrMo4 or 1.2312

Thermal enhancement to*

30-2HRC (950 - 1100 MPa)

Working edge hardened

53-2HRC (1500 - 1600 MPa)

Length

up to 4100 mm

* applies to 1.2312

additional information



In stock



fast delivery possible

REC-MO 42CrMo4 steel as standard

GP-MO

39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE A PUNCHES



S 2010 70 t/m

$\alpha = 75^\circ$, R = 0,8 mm

$\alpha = 85^\circ$, R = 0,8 mm

$\alpha = 88^\circ$, R = 0,2 mm, 0,8 mm, 1,5 mm, 3 mm

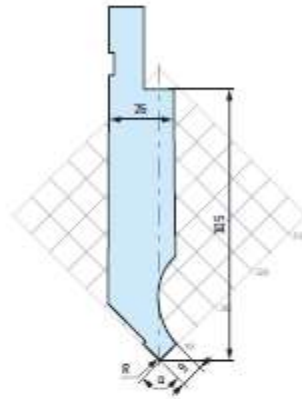
$\alpha = 90^\circ$, R = 0,2 mm, 0,8 mm



S 2010/105 100 t/m

$\alpha = 75^\circ, 85^\circ, 88^\circ$

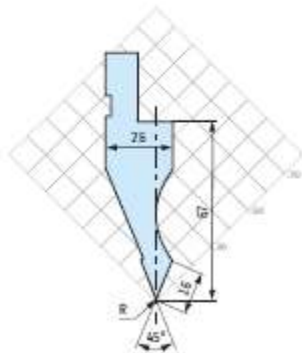
R = 0,8 mm



S 2011 80 t/m

$\alpha = 45^\circ$

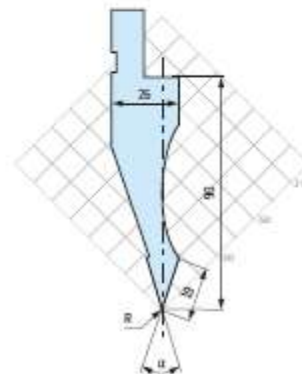
R = 0,4 mm, 0,8 mm, 1,5 mm



S 2012 70 t/m

$\alpha = 30^\circ, 35^\circ$

R = 1 mm



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39 rte du Hohwald 67140 BARR (France)

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Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "A" PUNCHES

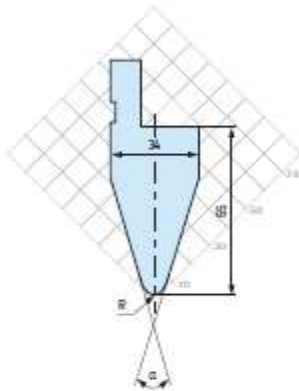


S 2013 100 t/m

$\alpha = 35^\circ$, R = 5 mm

$\alpha = 60^\circ$, R = 6 mm

$\alpha = 80^\circ$, R = 6 mm



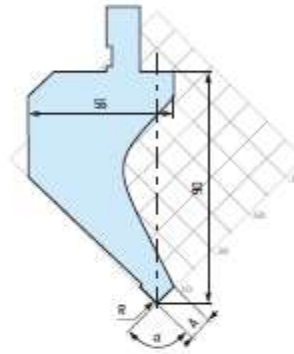
S 2014 60 t/m*

$\alpha = 75^\circ$, A = 9 mm, R = 0.8 mm, *30 t/m

$\alpha = 88^\circ$, A = 6 mm, R = 0.2 mm, 0.8 mm *50 t/m

$\alpha = 88^\circ$, A = 9 mm, R = 0.2 mm, 0.8 mm

$\alpha = 90^\circ$, A = 9 mm, R = 0.8 mm

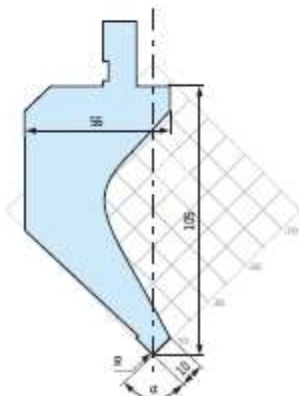


S 2015 50 t/m

$\alpha = 75^\circ$, R = 0.8 mm

$\alpha = 88^\circ$, R = 0.2 mm, 0.8 mm, 1.5 mm, 3 mm

$\alpha = 90^\circ$, R = 0.8 mm



S 2016 10 t/m

$\alpha = 88^\circ, 90^\circ$

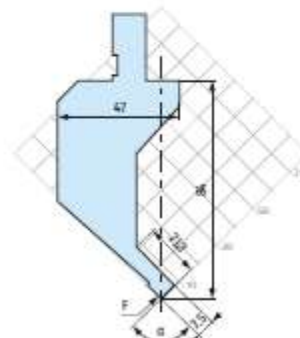
F = 0.6 mm



S 2016 20 t/m

$\alpha = 88^\circ, 90^\circ$

F = 0.6 mm



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

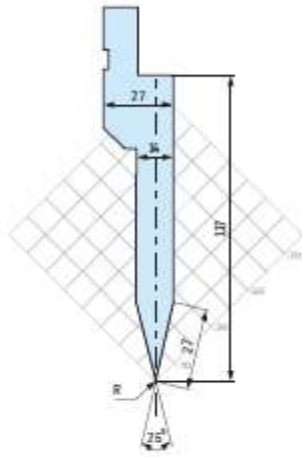
TYPE "A" PUNCHES



S 2017/26 100 t/m

$\alpha = 20^\circ$

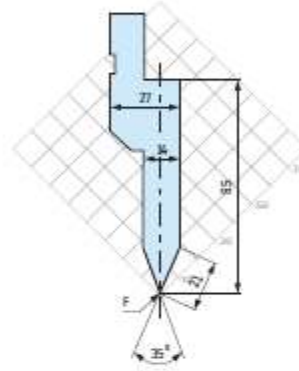
R = 0.8 mm



S 2017/35 100 t/m

$\alpha = 35^\circ$

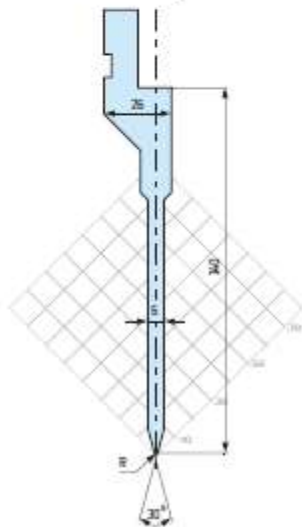
F = 0.8 mm



S 2017/30 40 t/m

$\alpha = 30^\circ$

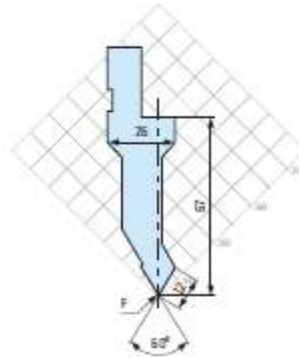
R = 0.8 mm



S 2018 60 t/m

$\alpha = 40^\circ$

F = 0.8 mm



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "A" PUNCHES



S 2019 70 t/m

$\alpha = 88^\circ$

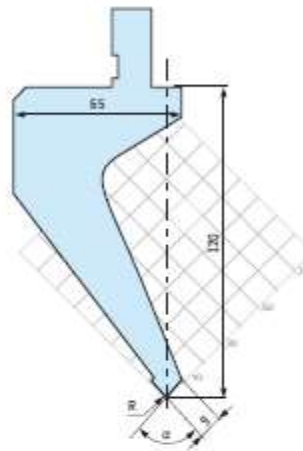
R = 0.8 mm



S 2020 50 t/m

$\alpha = 75^\circ$, R = 0.8 mm

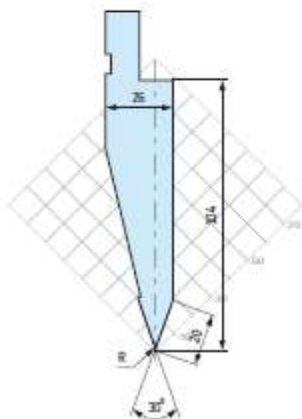
$\alpha = 88^\circ$, R = 0.2 mm



S 2021 100 t/m

$\alpha = 30^\circ$

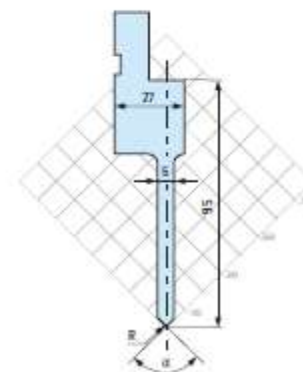
R = 0.8 mm



S 2022 50 t/m

$\alpha = 75^\circ$, R = 0.8 mm

$\alpha = 88^\circ$, 90° , R = 0.2 mm



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Fax (33) 3 69 20 14 97

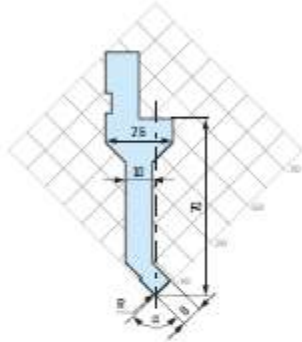
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Email : gp-mo@wanadoo.fr

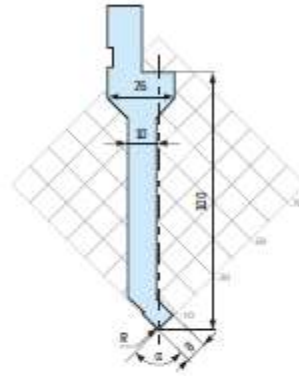
Site : gp-mo.com

TITRE A FORCEES

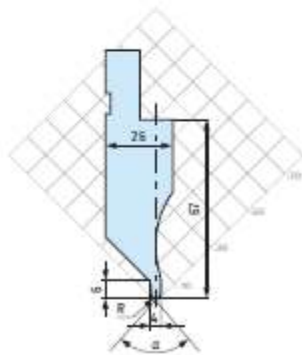

S 2023 50 t/m
$\alpha = 88^\circ, 90^\circ$
R = 0,2 mm



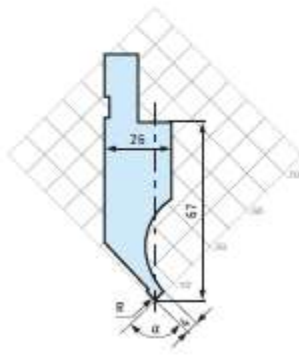

S 2024 50 t/m
$\alpha = 88^\circ, 90^\circ$
R = 0,2 mm




S 2025 40 t/m
$\alpha = 88^\circ, 90^\circ$
R = 0,2 mm




S 2026 35 t/m
$\alpha = 88^\circ, 90^\circ$
R = 0,2 mm



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Tél : (33) 3 88 08 39 35

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Site : gp-mo.com

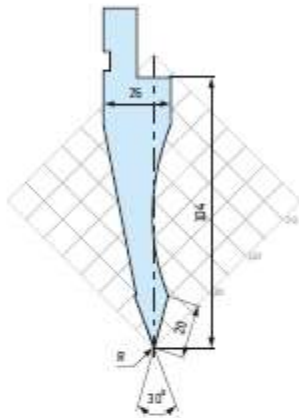
TYPE "A" PUNCHES



S 2027 70 t/m

$\alpha = 30^\circ$

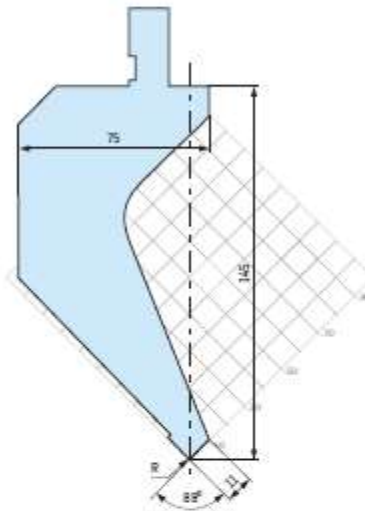
R = 0,8 mm



S 2028 80 t/m

$\alpha = 80^\circ$

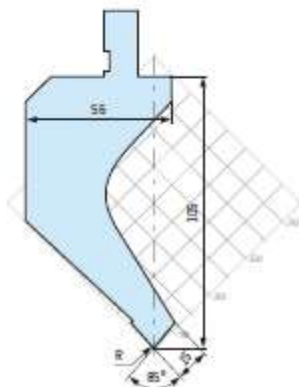
R = 0,8 mm



S 2029 60 t/m

$\alpha = 85^\circ$

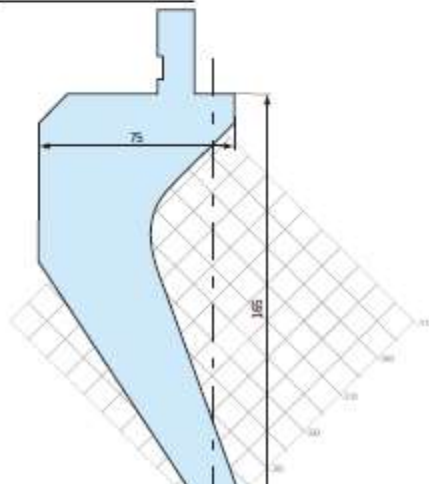
R = 5 mm, 6,5 mm



S 2030 60 t/m

$\alpha = 80^\circ$

R = 0,8 mm



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

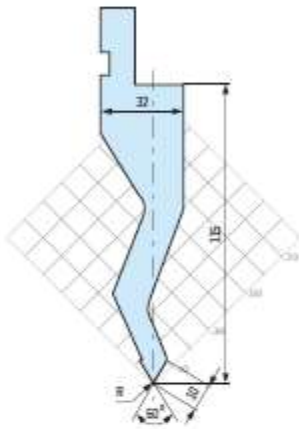
TYPE "A" PUNCHES



S 2031 60 t/m

$\alpha = 80^\circ$

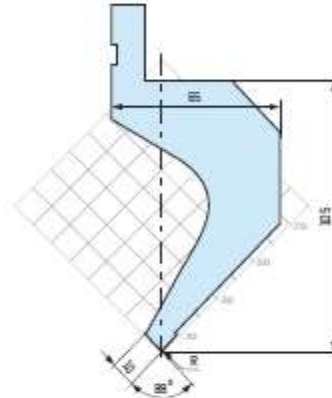
R = 0,8 mm



S 2032 45 t/m

$\alpha = 80^\circ$

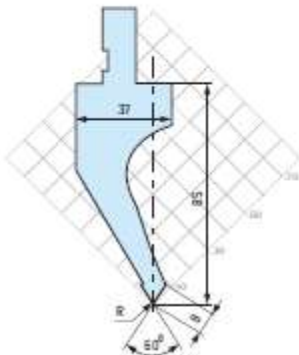
R = 0,8 mm



S 2034 35 t/m

$\alpha = 80^\circ$

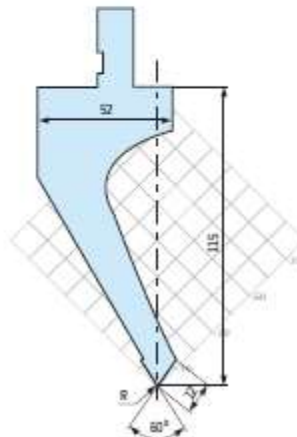
R = 0,8 mm



S 2035 35 t/m

$\alpha = 80^\circ$

R = 0,8 mm



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "A" PUNCHES

flattening tools

 42CrMo4

S 2033 70 t/m

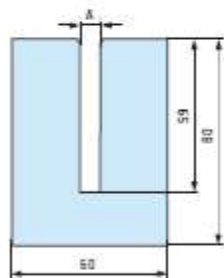
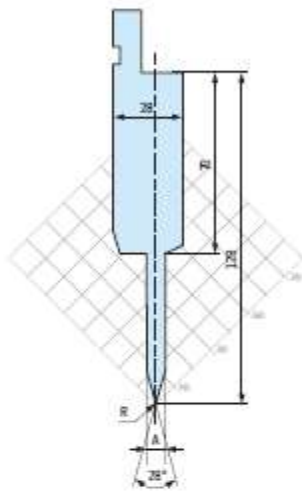
$\alpha = 28^\circ$

$R = 0,6 \text{ mm}$ A=8 mm, 10 mm, 12 mm

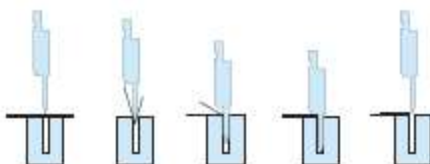
 42CrMo4

M 3000 70 t/m

A = 8 mm, 10 mm, 12 mm

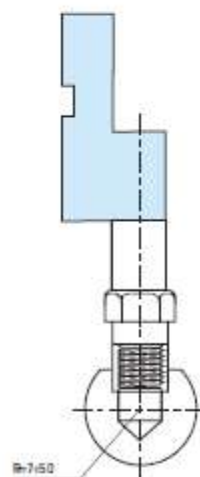


example of use S 2033 and M 3000



RADIUS PUNCHES

assembly



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

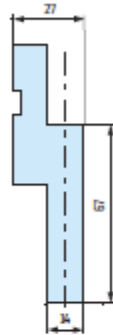
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RADIUS PUNCHES



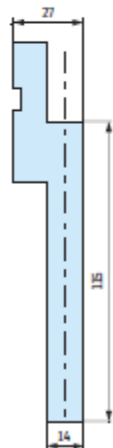
PUNCH R 80 t/m



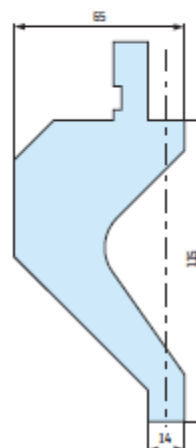
PUNCH R 2 80 t/m



PUNCH R/115 80 t/m



PUNCH R 2/115 60 t/m



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

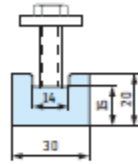
Email : gp-mo@wanadoo.fr

Site : gp-mo.com

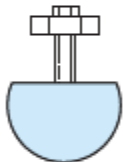
RADIUS PUNCHES



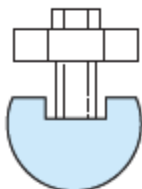
FLATTENING INSERT



INSERT R 7 - R 12



INSERT R 12.5 - R 50

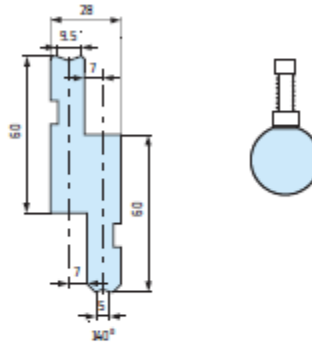


PUNCH R - R 80 t/m



PUNCH R 3 - R 6.5

Double radius punch

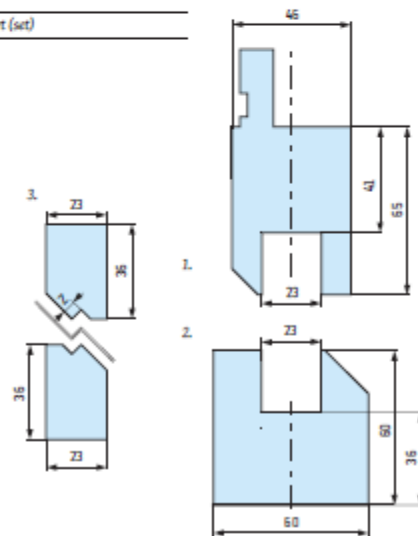


Z SHAPE TOOL

1. Z Punch

2. Z Die

3. Z Insert (set)



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

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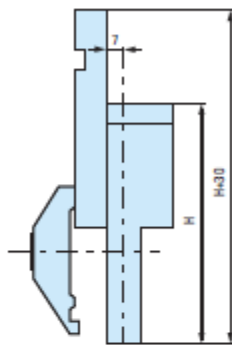
TYPE "A"

H = 100 mm, L = 150 mm

H = 120 mm, L = 150 mm

H = 140 mm, L = 150 mm

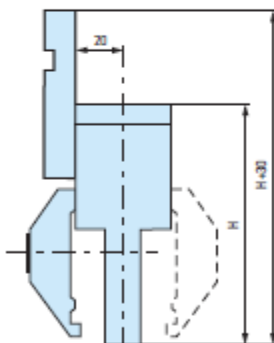
H = 150 mm, L = 150 mm



TYPE "B"

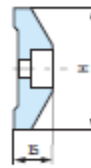
H = 120 mm, L = 150 mm

H = 170 mm, L = 150 mm



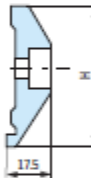
TYPE "A"

H = 50 mm, L = 150 mm



TYPE "S" | TYP "S"

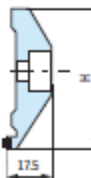
H = 58 mm, L = 150 mm



TYPE "P"

with plastic insert

H = 58 mm, L = 150 mm



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Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

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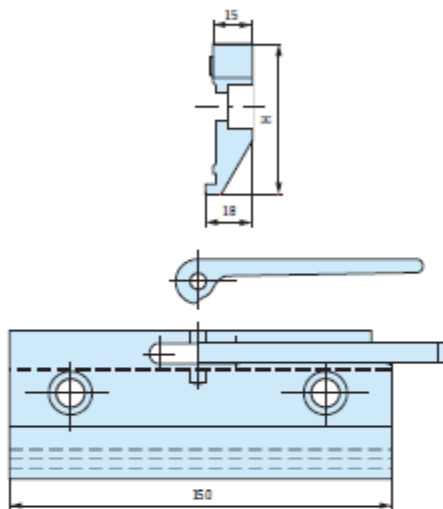
Site : gp-mo.com

MECHANICAL ADAPTORS FOR PUNCHES



TYPE "Q"

H = 60 mm, L = 150 mm

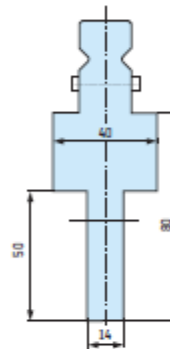


system changing adaptors



TYPE "T/A"

H = 100 mm, L = 100 mm

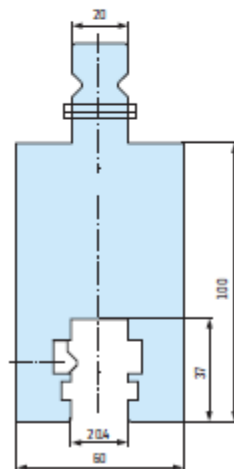


type "T" adaptor



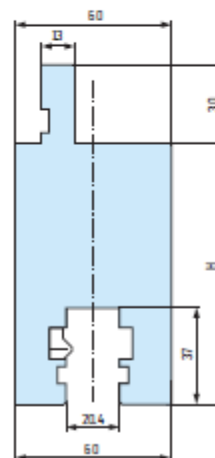
TYPE "T"

H = 100 mm, L = 100 mm



TYPE "A/T"

H = 60, 80, 100 mm, L = 100 mm



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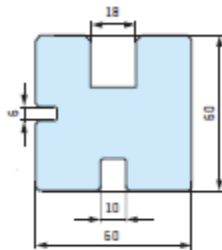
Site : gp-mo.com

TYPE "A" DIES

multiple vee dies



MR 100 t/m



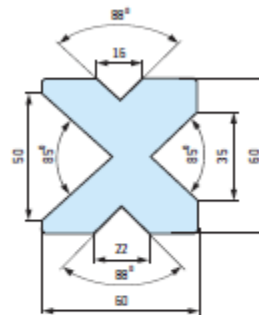
M 4 80 t/m

$\alpha = 85^\circ, 88^\circ$

N2CrMo4

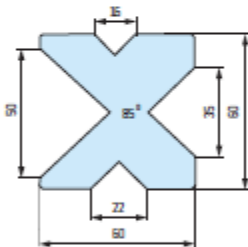
M 4 80 t/m

$\alpha = 85^\circ, 88^\circ$



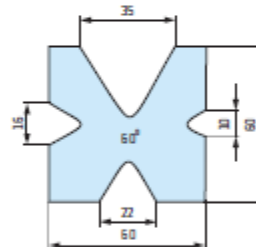
M 4/85° 80 t/m

$\alpha = 85^\circ$



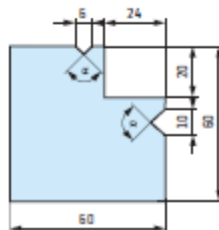
M 4/60° 60 t/m

$\alpha = 60^\circ$



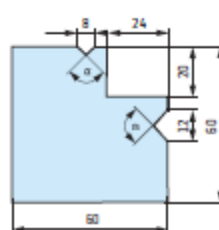
M 2/6 - 10 100 t/m

$\alpha = 88^\circ, 90^\circ$



M 2/8 - 12 100 t/m

$\alpha = 88^\circ, 90^\circ$



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE A DIES

with groove



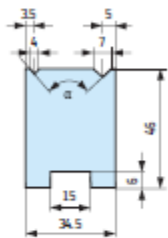
M 6019 100 t/m

$\alpha = 90^\circ$



M 6119 80 t/m

$\alpha = 88^\circ$



M 6020 80 t/m

$\alpha = 90^\circ$



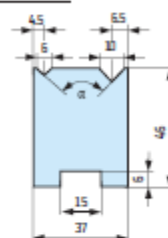
M 6120 80 t/m

$\alpha = 88^\circ$



M 6220 35 t/m*

$\alpha = 30^\circ$



M 6021 80 t/m

$\alpha = 90^\circ$



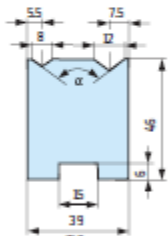
M 6121 80 t/m

$\alpha = 88^\circ$



M 6221 40 t/m

$\alpha = 30^\circ$



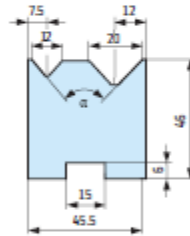
M 6022 80 t/m

$\alpha = 90^\circ$



M 6122 80 t/m

$\alpha = 88^\circ$



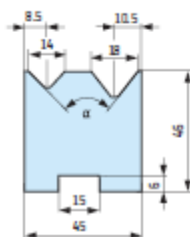
M 6023 80 t/m

$\alpha = 90^\circ$



M 6123 80 t/m

$\alpha = 88^\circ$



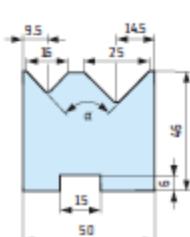
M 6024 80 t/m

$\alpha = 90^\circ$



M 6124 80 t/m

$\alpha = 88^\circ$



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Fax (33) 3 69 20 14 97

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TYPE "A" DIES

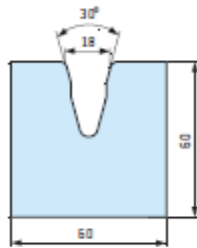
IV dies



M 3330/18

$\alpha = 30^\circ$

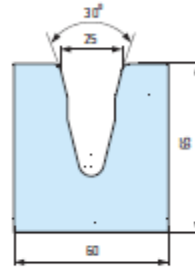
V = 18 mm



M 3330/25

$\alpha = 30^\circ$

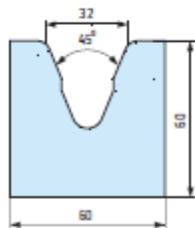
V = 25 mm



M 3345/32

$\alpha = 45^\circ$

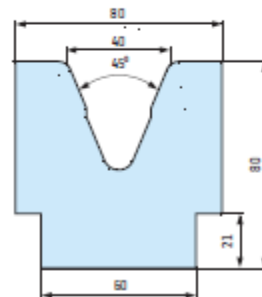
V = 32 mm



M 3345/40

$\alpha = 45^\circ$

V = 40 mm



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "A" DIES

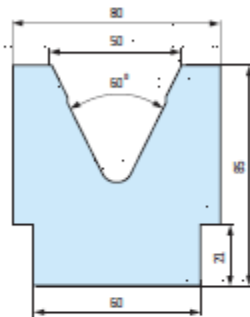
1V dies



M 3360/50

$\alpha = 60^\circ$

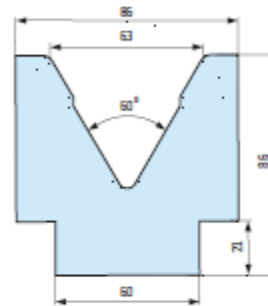
V = 50 mm



M 3360/63

$\alpha = 60^\circ$

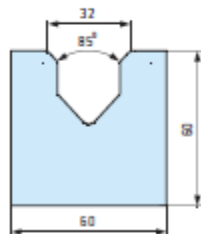
V = 63 mm



M 3385/32

$\alpha = 85^\circ$

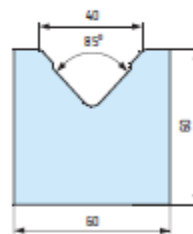
V = 32 mm



M 3385/40

$\alpha = 85^\circ$

V = 40 mm



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "A" DIES

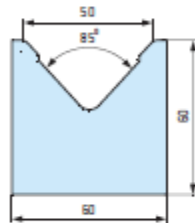
1V dies



M 3385/50

$\alpha = 85^\circ$

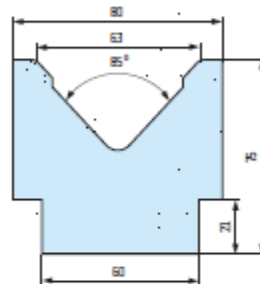
V = 50 mm



M 3385/63

$\alpha = 85^\circ$

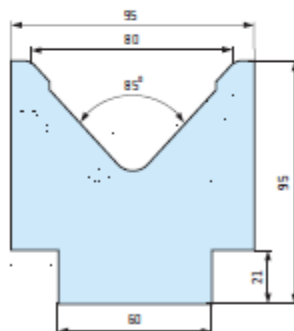
V = 63 mm



M 3385/80

$\alpha = 85^\circ$

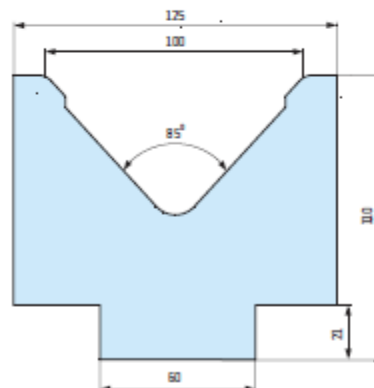
V = 80 mm



M 3385/100

$\alpha = 85^\circ$

V = 100 mm



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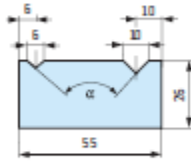
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Site : gp-mo.com

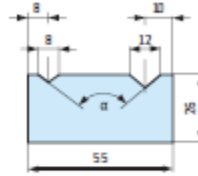
TYPE "A" DIES

bolt fastened

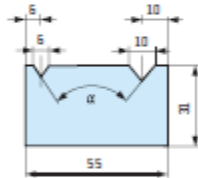
	
M 6112 100 t/m	M 6212 80 t/m
$\alpha = 90^\circ$	$\alpha = 60^\circ$



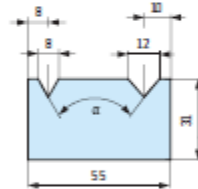
	
M 6113 100 t/m	M 6213 80 t/m
$\alpha = 90^\circ$	$\alpha = 60^\circ$





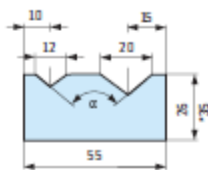

M 6312 60 t/m
$\alpha = 35^\circ$



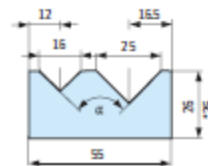

M 6313 60 t/m
$\alpha = 35^\circ$



	
M 6114 100 t/m	M 6214 80 t/m *
$\alpha = 80^\circ$	$\alpha = 60^\circ$



	
M 6115 100 t/m	M 6215 80 t/m *
$\alpha = 80^\circ$	$\alpha = 60^\circ$



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "A" DIES

dies with base H = 80 mm



M 6130 30 t/m

A = 8 mm, B = 16 mm

R₁ = 1 mm, R₂ = 1 mm



M 6230 35 t/m

A = 10 mm, B = 20 mm

R₁ = 1 mm, R₂ = 1 mm



M 6330 35 t/m

A = 12 mm, B = 22 mm

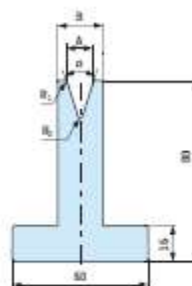
R₁ = 1 mm, R₂ = 1 mm



M 6430 45 t/m

A = 16 mm, B = 30 mm

R₁ = 2 mm, R₂ = 2 mm



M 6135 35 t/m

A = 8 mm, B = 14 mm

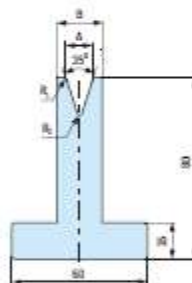
R₁ = 1.5 mm, R₂ = 0.8 mm



M 6235 40 t/m

A = 12 mm, B = 18 mm

R₁ = 2 mm, R₂ = 1 mm



M 6145 50 t/m

A = 10 mm, B = 16 mm

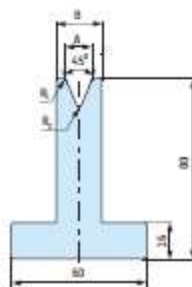
R₁ = 2 mm, R₂ = 1 mm



M 6245 50 t/m

A = 12 mm, B = 18 mm

R₁ = 2.5 mm, R₂ = 1 mm



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Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

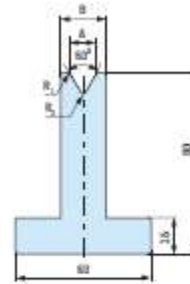
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Site : gp-mo.com

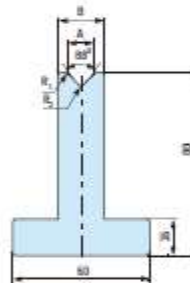
TYPE "A" DIES

dies with base H = 80 mm

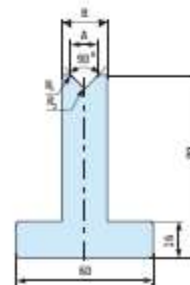
		
M 6160 60 t/m	M 6260 60 t/m	M 6360 60 t/m
A = 8 mm, B = 14 mm	A = 10 mm, B = 16 mm	A = 12 mm, B = 18 mm
R ₁ = 1.5 mm, R ₂ = 0.8 mm	R ₁ = 2 mm, R ₂ = 1 mm	R ₁ = 2.5 mm, R ₂ = 1 mm
		
M 6460 60 t/m	M 6560 60 t/m	M 6660 60 t/m
A = 16 mm, B = 24 mm	A = 20 mm, B = 30 mm	A = 25 mm, B = 40 mm
R ₁ = 1.5 mm, R ₂ = 1.5 mm	R ₁ = 2 mm, R ₂ = 2 mm	R ₁ = 3 mm, R ₂ = 3 mm



		
M 6088 100 t/m	M 6188 100 t/m	M 6288 100 t/m
A = 8 mm, B = 14 mm	A = 12 mm, B = 18 mm	A = 16 mm, B = 22 mm
R ₁ = 1 mm, R ₂ = 0.5 mm	R ₁ = 2.5 mm, R ₂ = 1 mm	R ₁ = 2.5 mm, R ₂ = 1 mm
		
M 6388 100 t/m	M 6488 100 t/m	M 6588 100 t/m
A = 20 mm, B = 30 mm	A = 25 mm, B = 40 mm	A = 30 mm, B = 16 mm
R ₁ = 3 mm, R ₂ = 1.5 mm	R ₁ = 3 mm, R ₂ = 3 mm	R ₁ = 1 mm, R ₂ = 1 mm
		
M 6688 100 t/m	M 6488 100 t/m	
A = 14 mm, B = 18 mm	A = 6 mm, B = 12 mm	
R ₁ = 2.6 mm, R ₂ = 0.4 mm	R ₁ = 0.5 mm, R ₂ = 0.5 mm	



		
M 6190 100 t/m	M 6290 100 t/m	M 6390 100 t/m
A = 6 mm, B = 12 mm	A = 8 mm, B = 14 mm	A = 10 mm, B = 16 mm
R ₁ = 1.5 mm, R ₂ = 0.5 mm	R ₁ = 1.5 mm, R ₂ = 0.8 mm	R ₁ = 2 mm, R ₂ = 1 mm
		
M 6490 100 t/m		
A = 12 mm, B = 18 mm		
R ₁ = 2.5 mm, R ₂ = 1.5 mm		

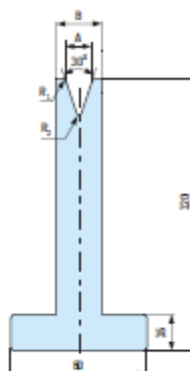


TYPE "A" DIES

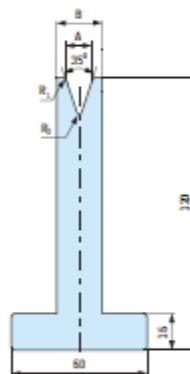
dies with base H = 120 mm

M 9130 30 t/m	M 9230 35 t/m	M 9330 35 t/m
A = 8 mm, B = 18 mm	A = 10 mm, B = 24 mm	A = 16 mm, B = 24 mm
R ₁ = 1 mm, R ₂ = 1 mm	R ₁ = 1 mm, R ₂ = 1 mm	R ₁ = 1 mm, R ₂ = 1 mm

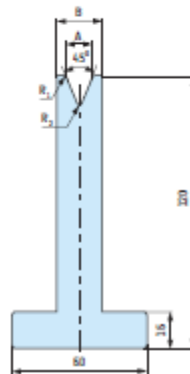
M 9430 45 t/m
A = 16 mm, B = 30 mm
R ₁ = 2 mm, R ₂ = 2 mm



M 9135 35 t/m	M 9235 40 t/m
A = 8 mm, B = 18 mm	A = 12 mm, B = 18 mm
R ₁ = 1.5 mm, R ₂ = 0.8 mm	R ₁ = 2 mm, R ₂ = 1 mm

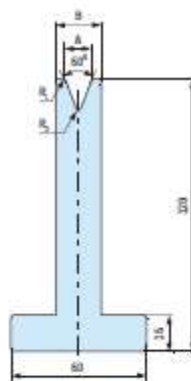


M 9145 50 t/m	M 9245 50 t/m
A = 10 mm, B = 18 mm	A = 12 mm, B = 18 mm
R ₁ = 2 mm, R ₂ = 1 mm	R ₁ = 2.5 mm, R ₂ = 1 mm

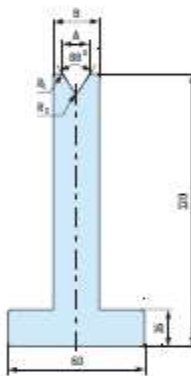


dies with base H = 120 mm

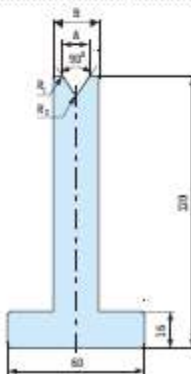
M 9160 60 t/m	M 9260 60 t/m	M 9360 60 t/m
A = 8 mm, B = 14 mm	A = 10 mm, B = 18 mm	A = 12 mm, B = 18 mm
R ₁ = 1.5 mm, R ₂ = 0.8 mm	R ₁ = 2 mm, R ₂ = 1 mm	R ₁ = 2.5 mm, R ₂ = 1 mm
M 9460 60 t/m	M 9560 60 t/m	M 9660 60 t/m
A = 16 mm, B = 24 mm	A = 20 mm, B = 30 mm	A = 25 mm, B = 40 mm
R ₁ = 1.5 mm, R ₂ = 1.5 mm	R ₁ = 2 mm, R ₂ = 2 mm	R ₁ = 3 mm, R ₂ = 3 mm



M 9088 100 t/m	M 9188 100 t/m	M 9288 100 t/m
A = 8 mm, B = 14 mm	A = 12 mm, B = 18 mm	A = 16 mm, B = 24 mm
R ₁ = 1 mm, R ₂ = 0.5 mm	R ₁ = 2.5 mm, R ₂ = 1 mm	R ₁ = 2.5 mm, R ₂ = 1 mm
M 9388 100 t/m	M 9488 100 t/m	M 9588 100 t/m
A = 20 mm, B = 30 mm	A = 25 mm, B = 40 mm	A = 10 mm, B = 18 mm
R ₁ = 3 mm, R ₂ = 1.5 mm	R ₁ = 3 mm, R ₂ = 3 mm	R ₁ = 1 mm, R ₂ = 1 mm
M 9688 100 t/m	M 9788 100 t/m	
A = 14 mm, B = 18 mm	A = 6 mm, B = 14 mm	
R ₁ = 2.6 mm, R ₂ = 0.4 mm	R ₁ = 0.5 mm, R ₂ = 0.5 mm	



M 9190 100 t/m	M 9290 100 t/m	M 9390 100 t/m
A = 6 mm, B = 14 mm	A = 8 mm, B = 14 mm	A = 10 mm, B = 18 mm
R ₁ = 1.5 mm, R ₂ = 0.5 mm	R ₁ = 1.5 mm, R ₂ = 0.8 mm	R ₁ = 2 mm, R ₂ = 1 mm
M 9490 100 t/m		
A = 12 mm, B = 18 mm		
R ₁ = 3 mm, R ₂ = 0.8 mm		

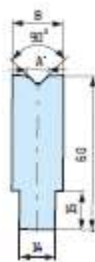
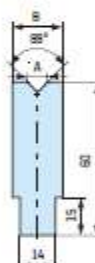
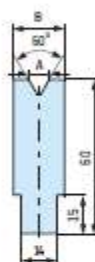
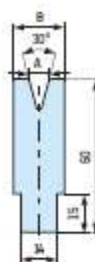


TYPE "A" DIES

insert dies

Dies fixed using die supports A 31 or A 61 -> p. 52

 42CrMo4 SM 8130 $\alpha = 30^\circ$ A = 6 mm, B = 16 mm	 42CrMo4 M 8230 $\alpha = 30^\circ$ A = 8 mm, B = 19 mm	 42CrMo4 S 8330 $\alpha = 30^\circ$ A = 10 mm, B = 24 mm
 42CrMo4 M 8430 $\alpha = 30^\circ$ A = 12 mm, B = 25 mm		
 42CrMo4 M 8160 $\alpha = 60^\circ$ A = 6 mm, B = 14 mm	 42CrMo4 M 8260 $\alpha = 60^\circ$ A = 8 mm, B = 15 mm	 42CrMo4 M 8360 $\alpha = 60^\circ$ A = 10 mm, B = 18 mm
 42CrMo4 M 8460 $\alpha = 60^\circ$ A = 12 mm, B = 18 mm	 42CrMo4 M 8560 $\alpha = 60^\circ$ A = 16 mm, B = 24 mm	 42CrMo4 M 8660 $\alpha = 60^\circ$ A = 20 mm, B = 30 mm
 42CrMo4 M 8188 $\alpha = 88^\circ$ A = 6 mm, B = 14 mm	 42CrMo4 M 8288 $\alpha = 88^\circ$ A = 8 mm, B = 14 mm	 42CrMo4 M 8388 $\alpha = 88^\circ$ A = 10 mm, B = 15 mm
 42CrMo4 M 8488 $\alpha = 88^\circ$ A = 12 mm, B = 17 mm	 42CrMo4 M 8588 $\alpha = 88^\circ$ A = 14 mm, B = 18 mm	 42CrMo4 M 8688 $\alpha = 88^\circ$ A = 16 mm, B = 21 mm
 42CrMo4 M 8788 $\alpha = 88^\circ$ A = 18 mm, B = 21 mm	 42CrMo4 M 8888 $\alpha = 88^\circ$ A = 20 mm, B = 25 mm	 42CrMo4 M 8988 $\alpha = 88^\circ$ A = 25 mm, B = 30 mm
 42CrMo4 M 8190 $\alpha = 90^\circ$ A = 6 mm, B = 14 mm	 42CrMo4 M 8290 $\alpha = 90^\circ$ A = 8 mm, B = 14 mm	 42CrMo4 M 8390 $\alpha = 90^\circ$ A = 10 mm, B = 15 mm
 42CrMo4 M 8490 $\alpha = 90^\circ$ A = 12 mm, B = 17 mm	 42CrMo4 M 8590 $\alpha = 90^\circ$ A = 14 mm, B = 18 mm	



GP-MO

39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

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TYPE "A" DIES

flattening dies

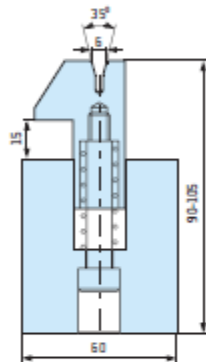
Bending and folding die, upper part moves on springs.



M 3033/6

$\alpha = 35^\circ$

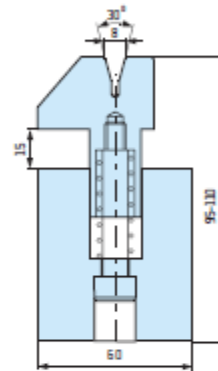
V = 6 mm



M 3033/8

$\alpha = 30^\circ$

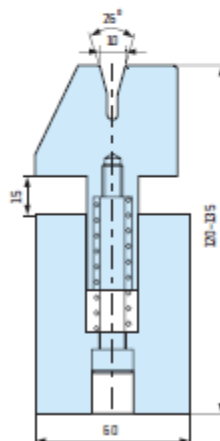
V = 8 mm



M 3033/10

$\alpha = 25^\circ$

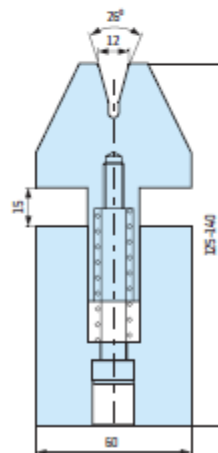
V = 10 mm



M 3033/12

$\alpha = 20^\circ$

V = 12 mm



GP-MO

39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "A" DIES



W 24

B = 14 mm, H = 15 mm, A = 24 mm

$\alpha = 35^\circ$, V = 6 mm / 8 mm / 10 mm

$\alpha = 45^\circ$, V = 6 mm / 8 mm / 10 mm / 12 mm

$\alpha = 60^\circ$, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm

$\alpha = 88^\circ$, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm



W 35

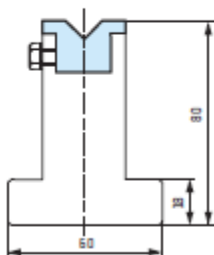
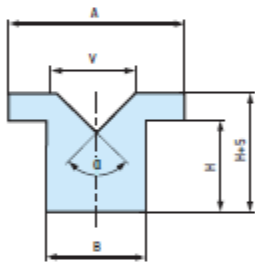
B = 20 mm, H = 19 mm, A = 35 mm

$\alpha = 35^\circ$, V = 6 mm / 8 mm / 10 mm

$\alpha = 45^\circ$, V = 6 mm / 8 mm / 10 mm / 12 mm

$\alpha = 60^\circ$, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm

$\alpha = 88^\circ$, V = 6 mm / 8 mm / 10 mm / 12 mm / 16 mm / 20 mm / 25 mm

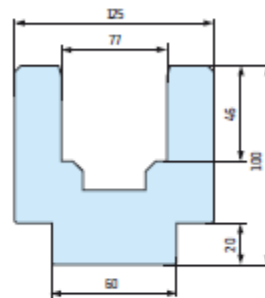


Polyamid inserts allow to minimize bending marks on coated or stainless steel.

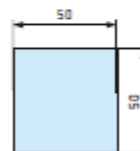
30



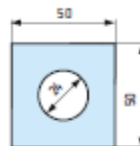
W 50



INSERT 50 FULL



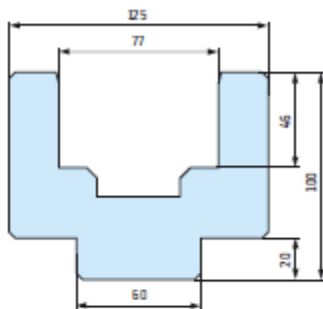
INSERT 50 WITH HOLE



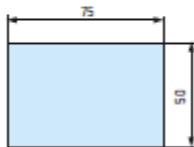
TYPE "A" DIES



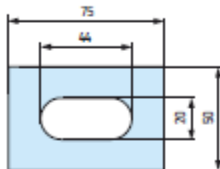
W 75



INSERT 75 FULL



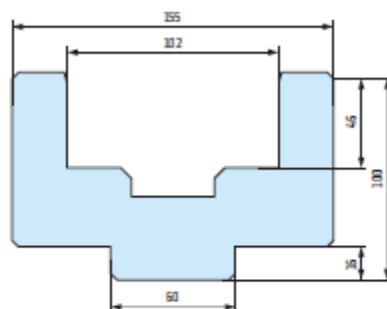
INSERT 75 WITH HOLE



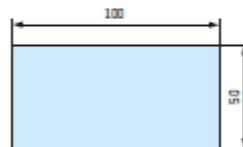
Rubber inserts allow mark free bending. Especially good with type "K" punches.



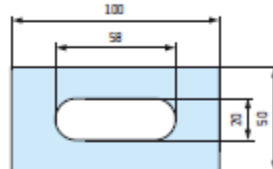
W 100



INSERT 100 FULL



INSERT 100 WITH HOLE



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

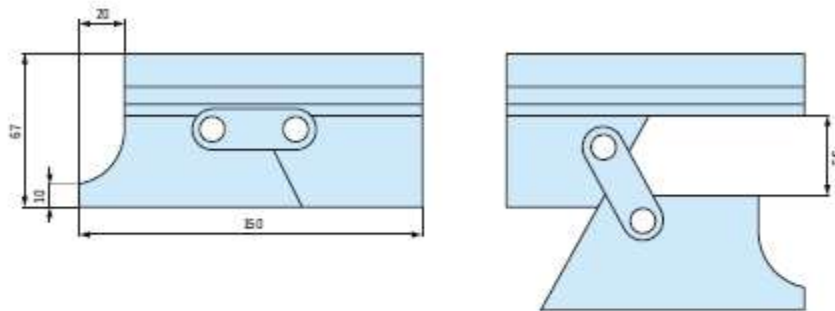
Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

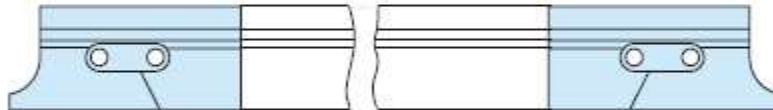
Site : gp-mo.com

BOX – CLOSING PUNCH

Punch with dimensions as S2010/88/80.8 used for closing boxes.



Assembly with S2010.



PROTECTIVE TAPE

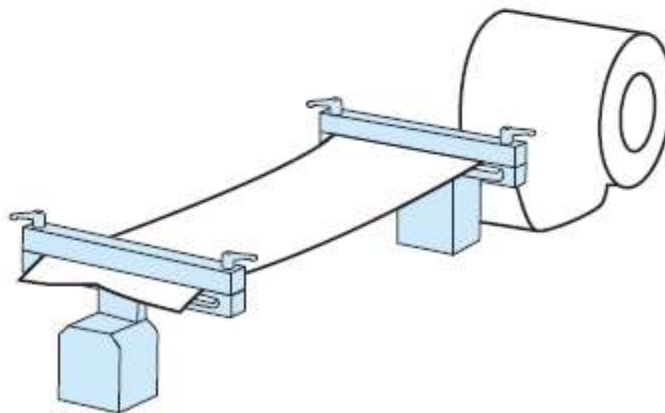
Tape size

thickness = 0.5 mm, width = 105 mm

thickness = 0.8 mm, width = 95 mm

Holder for protective tape

suitable for dies size 13mm to 60mm



Plastic tape protecting sheet metal from damage.

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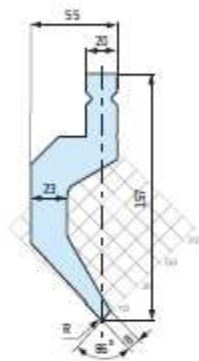
TYPE "T" PUNCHES

 1.2Cr1Mo4

S 2200 80 t/m

$\alpha = 86^\circ$

R = 1 mm

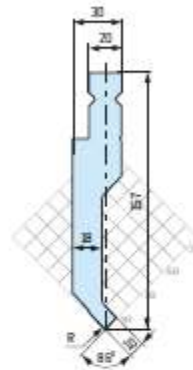


 1.2Cr1Mo4

S 2201 80 t/m

$\alpha = 86^\circ$

R = 1 mm

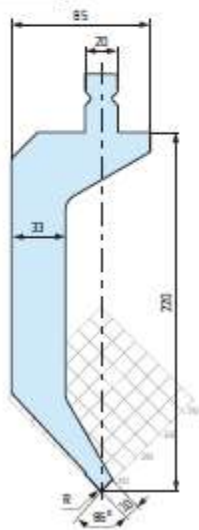


 1.2Cr1Mo4

S 2200 W 80 t/m

$\alpha = 86^\circ$

R = 1 mm

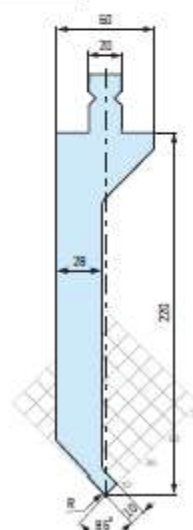


 1.2Cr1Mo4

S 2201 W 80 t/m

$\alpha = 86^\circ$

R = 1 mm



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39 rte du Hohwald 67140 BARR (France)

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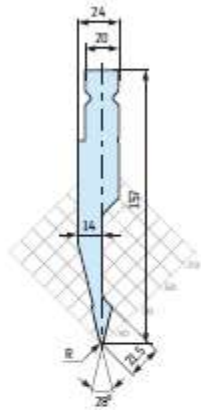
TYPE "T" PUNCHES

 42CrMo4

S 2202 60 t/m

$\alpha = 28^\circ$

R = 1 mm

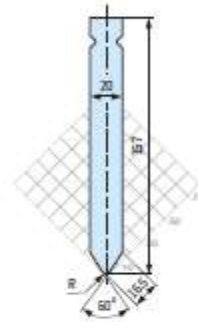


 42CrMo4

S 2203 130 t/m

$\alpha = 60^\circ$

R = 4 mm

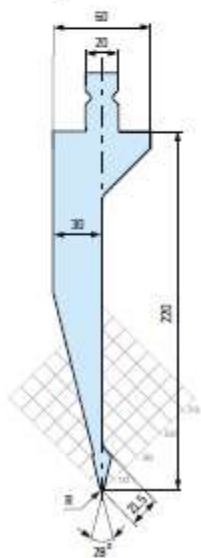


 42CrMo4

S 2202 W 60 t/m

$\alpha = 28^\circ$

R = 1 mm

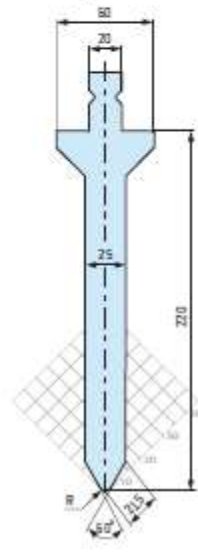


 42CrMo4

S 2203 W 130 t/m

$\alpha = 60^\circ$

R = 4 mm



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "T" PUNCHES

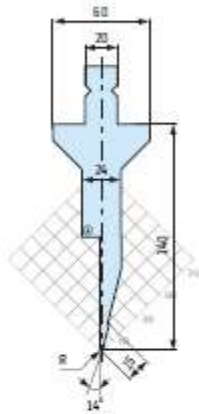


S 2204 40 t/m

⊙ 130 t/m

$\alpha = 14^\circ$

R = 1 mm

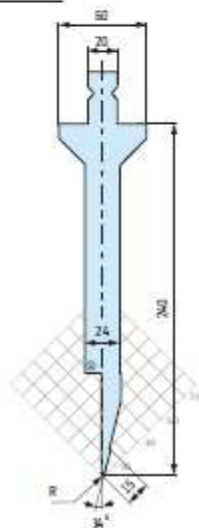


S 2204 W 40 t/m

⊙ 130 t/m

$\alpha = 14^\circ$

R = 1 mm



flattening tools



H2CrMo4

S 2205 80 t/m

A = 8 mm, 10 mm, 12 mm

R = 0.6 mm

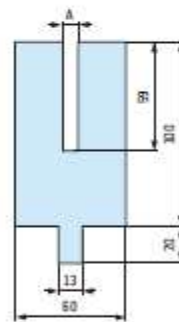
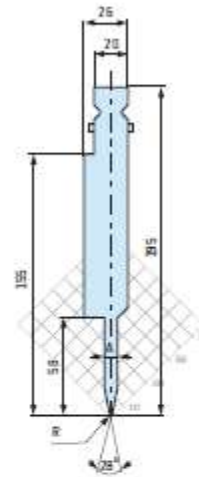


H2CrMo4

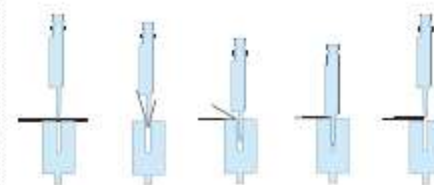
M 2000 50 t/m

A = 8 mm, 10 mm, 12 mm

R = 0.6 mm



example of use S 2205 and M 2000



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

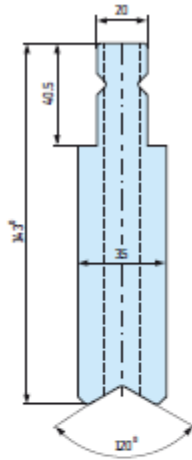
Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

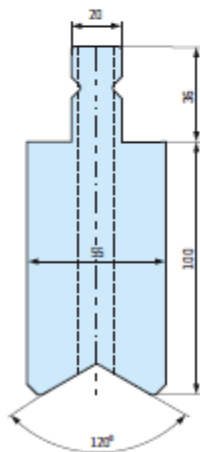
Site : gp-mo.com

TYPE "T" PUNCHES

S 2208 R 10 - R 25



S 2208 W R 25 - R 75



RADIUS INSERTS

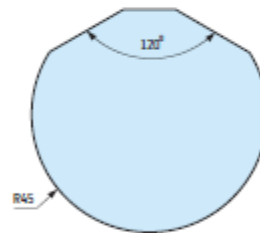
R 10



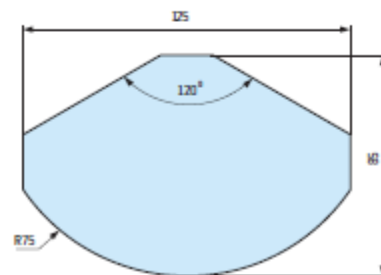
R 25



R 45

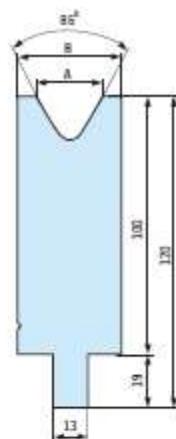


R 75

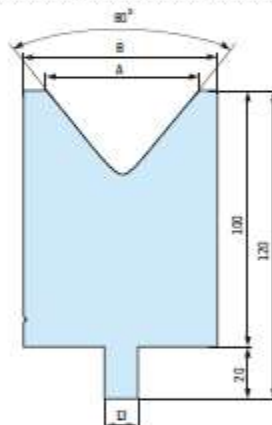


TYPE "T" DIES 100 MM

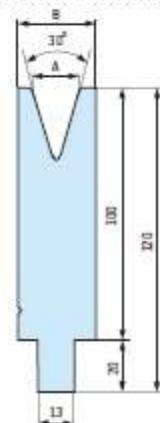
 42CrMo4 M 7106 100 t/m A = 6 mm, B = 20 mm	 42CrMo4 M 7108 100 t/m A = 8 mm, B = 20 mm	 42CrMo4 M 7110 100 t/m A = 10 mm, B = 20 mm
 42CrMo4 M 7112 100 t/m A = 12 mm, B = 25 mm	 42CrMo4 M 7116 100 t/m A = 16 mm, B = 30 mm	 42CrMo4 M 7120 100 t/m A = 20 mm, B = 30 mm
 42CrMo4 M 7124 100 t/m A = 24 mm, B = 35 mm	 42CrMo4 M 7130 100 t/m A = 30 mm, B = 45 mm	 42CrMo4 M 7140 100 t/m A = 40 mm, B = 55 mm
 42CrMo4 M 7150 100 t/m A = 50 mm, B = 75 mm		



 42CrMo4 M 7260 100 t/m A = 60 mm, B = 75 mm	 42CrMo4 M 7280 100 t/m A = 80 mm, B = 100 mm
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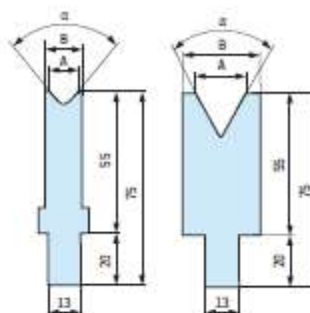


 42CrMo4 M 7306 50 t/m A = 6 mm, B = 20 mm	 42CrMo4 M 7308 40 t/m A = 8 mm, B = 20 mm	 42CrMo4 M 7310 40 t/m A = 10 mm, B = 20 mm
 42CrMo4 M 7312 40 t/m A = 12 mm, B = 25 mm	 42CrMo4 M 7316 45 t/m A = 16 mm, B = 30 mm	 42CrMo4 M 7320 50 t/m A = 20 mm, B = 35 mm
 42CrMo4 M 7324 50 t/m A = 24 mm, B = 40 mm		

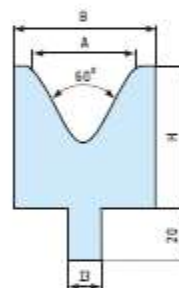


TYPE "T" DIES 55 MM

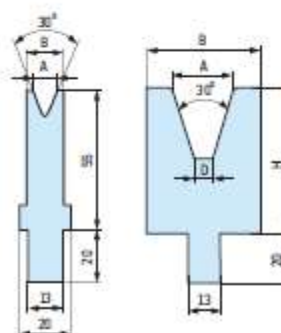
<p>42CrMo4</p> <p>M 7406 100 t/m</p> <p>$\alpha = 90^\circ$</p> <p>A = 6 mm, B = 15 mm</p>	<p>42CrMo4</p> <p>M 7408 100 t/m</p> <p>$\alpha = 90^\circ$</p> <p>A = 8 mm, B = 15 mm</p>	<p>42CrMo4</p> <p>M 7410 100 t/m</p> <p>$\alpha = 90^\circ$</p> <p>A = 10 mm, B = 20 mm</p>
<p>42CrMo4</p> <p>M 7412 100 t/m</p> <p>$\alpha = 88^\circ$</p> <p>A = 12 mm, B = 20 mm</p>	<p>42CrMo4</p> <p>M 7116 100 t/m</p> <p>$\alpha = 88^\circ$</p> <p>A = 16 mm, B = 30 mm</p>	<p>42CrMo4</p> <p>M 7120 100 t/m</p> <p>$\alpha = 88^\circ$</p> <p>A = 20 mm, B = 30 mm</p>
<p>42CrMo4</p> <p>M 7424 100 t/m</p> <p>$\alpha = 88^\circ$</p> <p>A = 24 mm, B = 40 mm</p>	<p>42CrMo4</p> <p>M 7130 100 t/m</p> <p>$\alpha = 88^\circ$</p> <p>A = 32 mm, B = 50 mm</p>	<p>42CrMo4</p> <p>M 7140 100 t/m</p> <p>$\alpha = 88^\circ$</p> <p>A = 40 mm, B = 55 mm</p>



<p>42CrMo4</p> <p>M 7540 80 t/m</p> <p>A = 40 mm, B = 55 mm, H = 55 mm</p>	<p>42CrMo4</p> <p>M 7560 60 t/m</p> <p>A = 60 mm, B = 80 mm, H = 65 mm</p>
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<p>42CrMo4</p> <p>M 7606 35 t/m</p> <p>A = 6 mm, B = 15 mm</p>	<p>42CrMo4</p> <p>M 7108 100 t/m</p> <p>A = 8 mm, B = 20 mm</p>	<p>42CrMo4</p> <p>M 7110 100 t/m</p> <p>A = 10 mm, B = 20 mm</p>
<p>42CrMo4</p> <p>M 7612 40 t/m</p> <p>A = 12 mm, B = 20 mm</p>	<p>42CrMo4</p> <p>M 7616 45 t/m</p> <p>A = 16 mm, B = 30 mm, H = 55 mm</p>	<p>42CrMo4</p> <p>M 7620 50 t/m</p> <p>A = 20 mm, B = 35 mm, H = 55 mm</p>
<p>42CrMo4</p> <p>M 7624 50 t/m</p> <p>A = 24 mm, B = 40 mm, H = 55 mm</p>	<p>42CrMo4</p> <p>M 7632 50 t/m</p> <p>A = 32 mm, B = 60 mm, H = 60 mm</p>	



GP-MO

39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

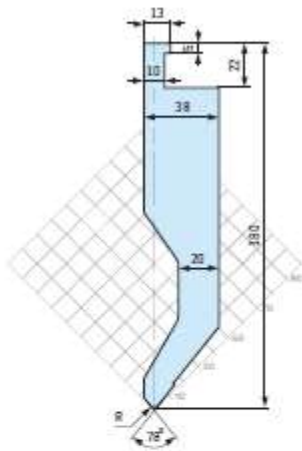
TYPE "L" PUNCHES

42CrMo4

S 2510 C 70 t/m

$\alpha = 78^\circ$

R = 2 mm

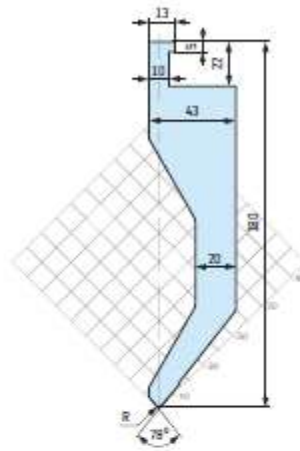


42CrMo4

S 2510 D 40 t/m

$\alpha = 78^\circ$

R = 1 mm

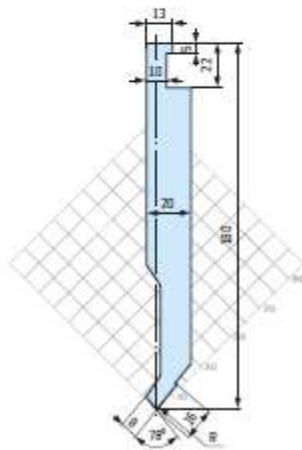


42CrMo4

S 2510 E 40 t/m

$\alpha = 78^\circ$

R = 1 mm

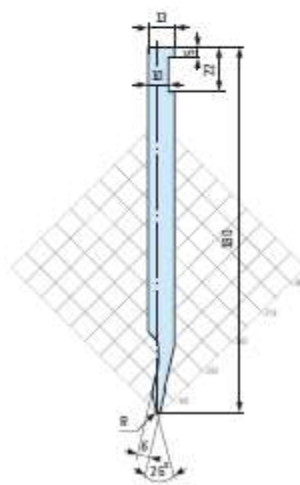


42CrMo4

S 2510 F 40 t/m

$\alpha = 28^\circ$

R = 1 mm



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39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

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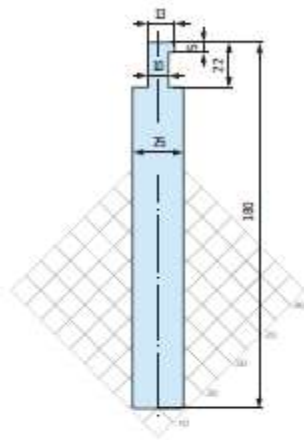
Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "L" PUNCHES

42CrMo4

S 2510 H 150 t/m

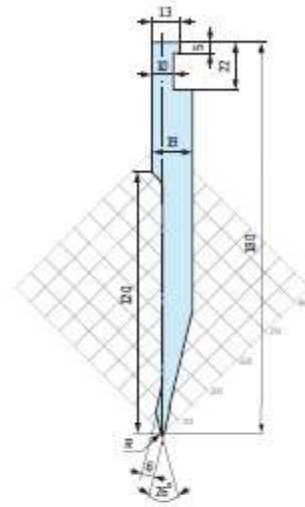


42CrMo4

S 2510 J 40 t/m

$\alpha = 20^\circ$

R = 1 mm



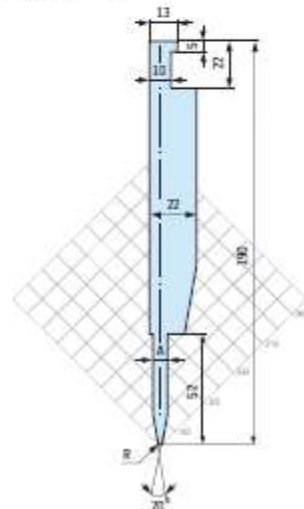
42CrMo4

S 2510 P 40 t/m

$\alpha = 30^\circ$

R = 1 mm

A = 8 mm, 10 mm, 12 mm

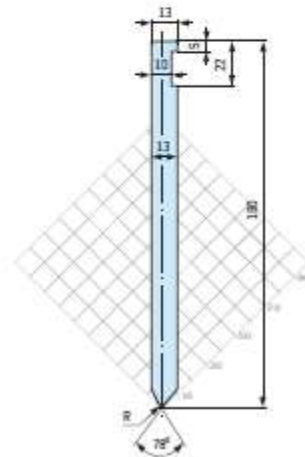


42CrMo4

S 2510 R 80 t/m

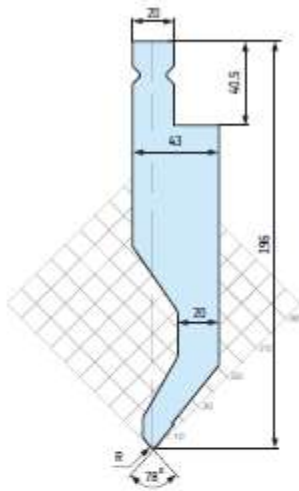
$\alpha = 78^\circ$

R = 2 mm

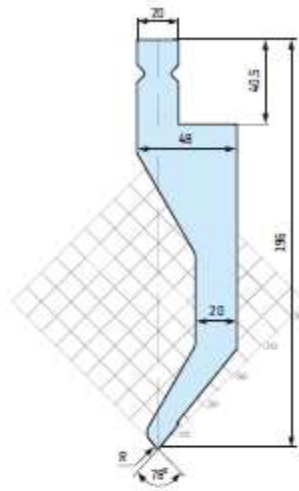


TYPE "L" PUNCHES

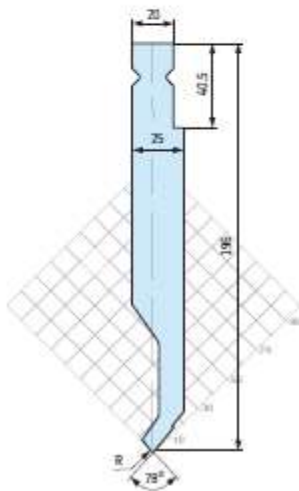
42CrMo4
S 2610 C 70 t/m
$\alpha = 78^\circ$
R = 2 mm



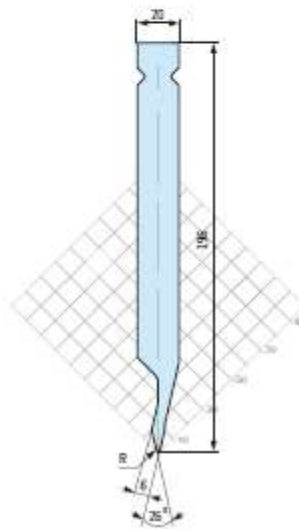
42CrMo4
S 2610 D 40 t/m
$\alpha = 78^\circ$
R = 1 mm



42CrMo4
S 2610 E 40 t/m
$\alpha = 78^\circ$
R = 1 mm



42CrMo4
S 2610 F 40 t/m
$\alpha = 26^\circ$
R = 1 mm



GP-MO

39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

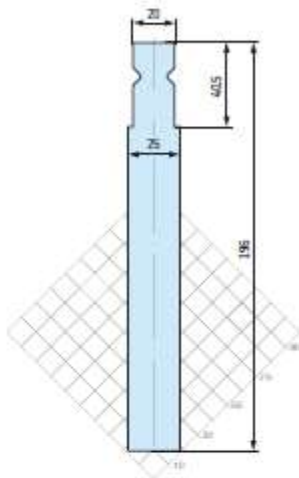
Email : gp-mo@wanadoo.fr

Site : gp-mo.com

TYPE "L" PUNCHES

42CrMo4

S 2610 H 160 t/m

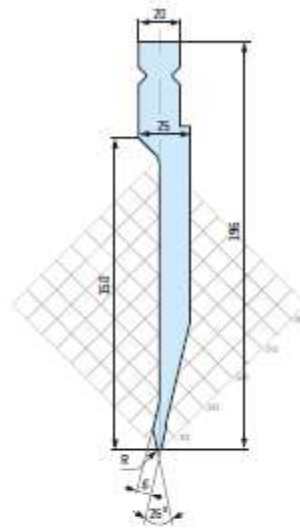


42CrMo4

S 2610 J 40 t/m

$\alpha = 20^\circ$

R = 1 mm



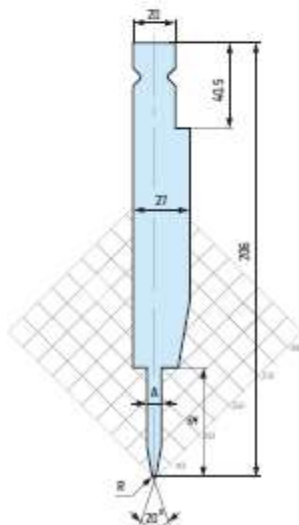
42CrMo4

S 2610 P 40 t/m

$\alpha = 20^\circ$

R = 1 mm

A = 8 mm, 10 mm, 12 mm

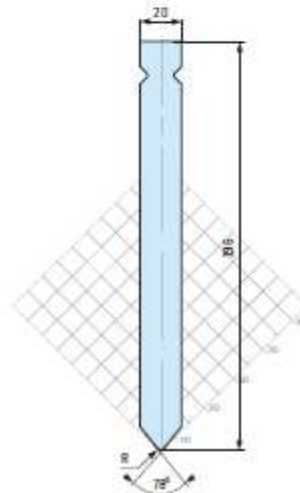


42CrMo4

S 2610 R 80 t/m

$\alpha = 70^\circ$

R = 2 mm



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Fax (33) 3 69 20 14 97

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Site : gp-mo.com

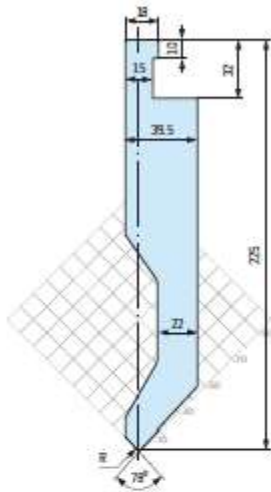
TYPE "L" PUNCHES

1/2 Cr-18Ni-4

S 2515 C 80 t/m

$\alpha = 78^\circ$

R = 2 mm

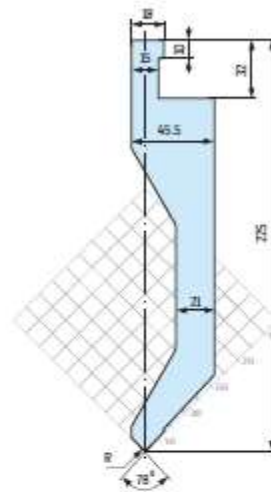


1/2 Cr-18Ni-4

S 2515 D 75 t/m

$\alpha = 78^\circ$

R = 2 mm

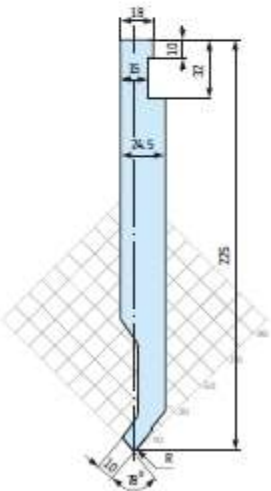


1/2 Cr-18Ni-4

S 2515 E 50 t/m

$\alpha = 78^\circ$

R = 2 mm

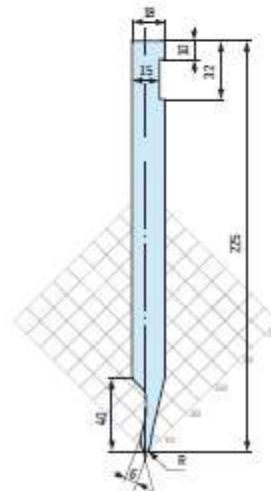


1/2 Cr-18Ni-4

S 2515 F 50 t/m

$\alpha = 28^\circ$

R = 2 mm



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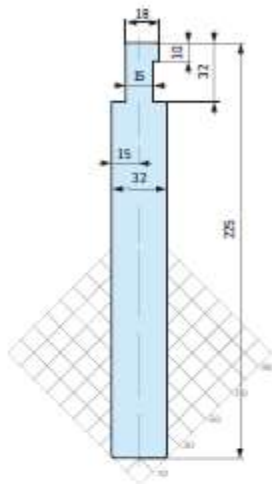
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TYPE "L" PUNCHES

42CrMo4

S 2515 H 150 t/m

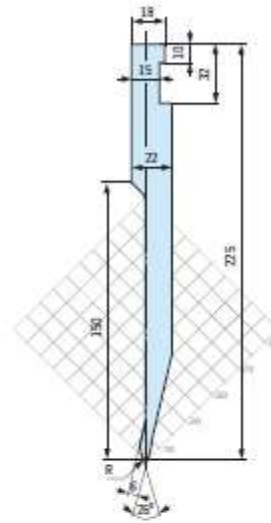


42CrMo4

S 2515 J 50 t/m

$\alpha = 20^\circ$

R = 2 mm

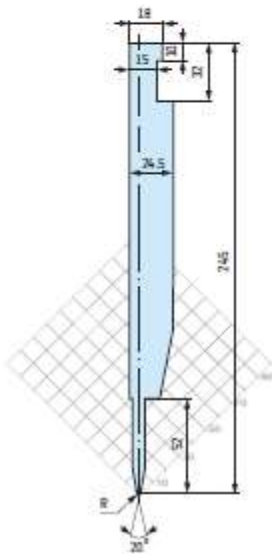


42CrMo4

S 2515 P 40 t/m

$\alpha = 30^\circ$

R = 1 mm

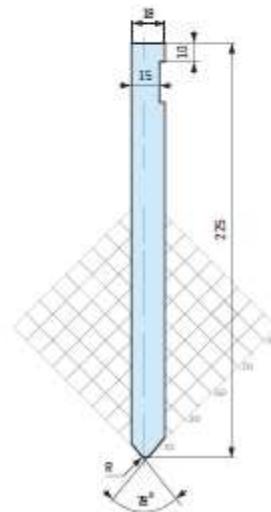


42CrMo4

S 2515 R 120 t/m

$\alpha = 70^\circ$

R = 2 mm



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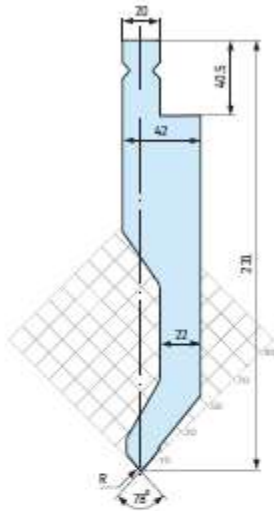
TYPE "L" PUNCHES

1/2Cr18Ni4

S 2615 C 80 t/m

$\alpha = 78^\circ$

R = 2 mm

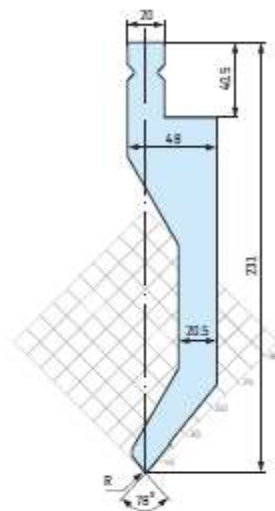


1/2Cr18Ni4

S 2615 D 75 t/m

$\alpha = 78^\circ$

R = 2 mm

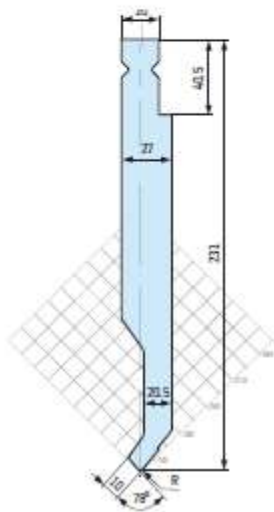


1/2Cr18Ni4

S 2615 E 50 t/m

$\alpha = 78^\circ$

R = 2 mm

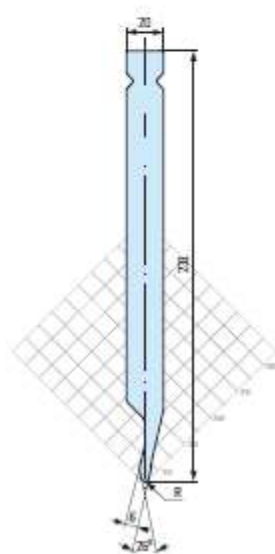


1/2Cr18Ni4

S 2615 F 50 t/m

$\alpha = 28^\circ$

R = 2 mm



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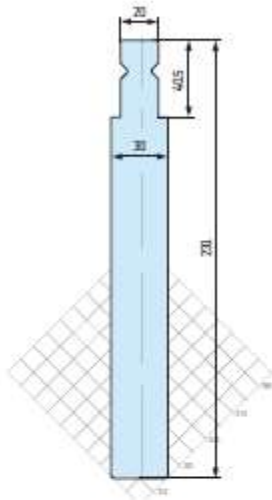
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TYPE "L" PUNCHES

H2CrMo4

S 2615 H 150 t/m

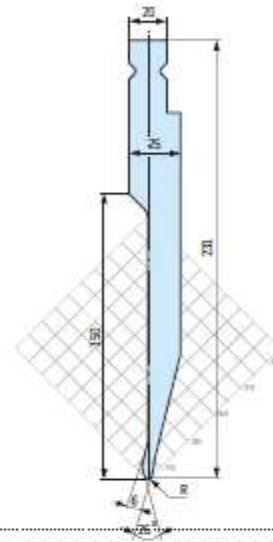


H2CrMo4

S 2615 J 50 t/m

$\alpha = 26^\circ$

R = 2 mm

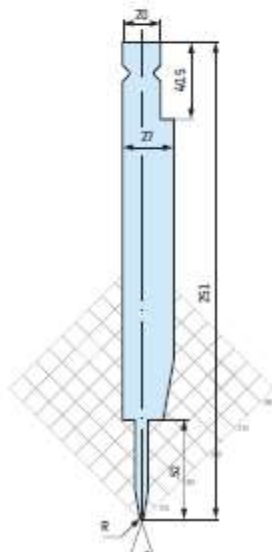


H2CrMo4

S 2615 P 40 t/m

$\alpha = 26^\circ$

R = 1 mm

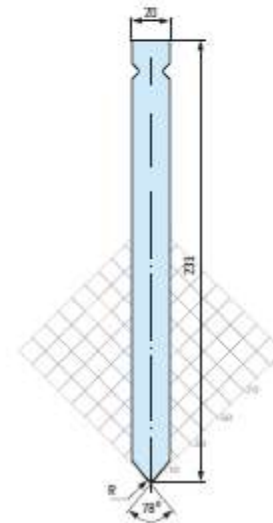


H2CrMo4

S 2615 R 120 t/m

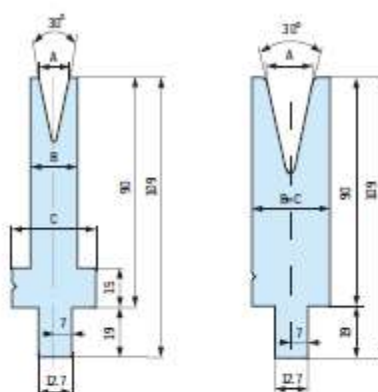
$\alpha = 78^\circ$

R = 3 mm

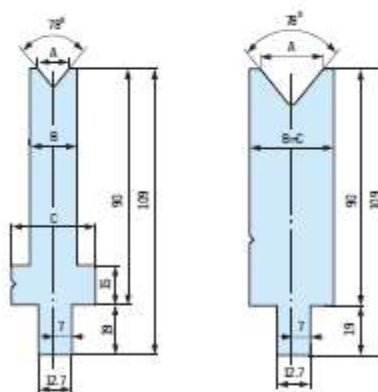


TYPE "L" DIES 90 MM

 H2Cr7Mo4	 H2Cr7Mo4
M 5106 20 t/m A = 6 mm, B = 16 mm, C = 32 mm	M 5108 20 t/m A = 8 mm, B = 18 mm, C = 32 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5110 30 t/m A = 10 mm, B = 25 mm, C = 32 mm	M 5112 35 t/m A = 12 mm, B = 25 mm, C = 32 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5116 35 t/m A = 16 mm, B = 32 mm, C = 32 mm	M 5130 60 t/m A = 20 mm, B = 40 mm, C = 40 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5124 55 t/m A = 24 mm, B = 45 mm, C = 45 mm	M 5320 35 t/m A = 30 mm, B = 70 mm, C = 70 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5140 60 t/m A = 40 mm, B = 75 mm, C = 75 mm	M 5150 80 t/m A = 50 mm, B = 95 mm, C = 95 mm

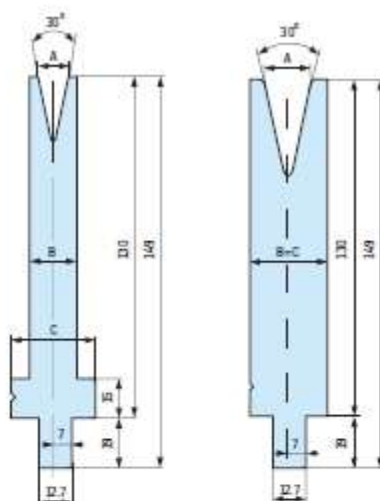


 H2Cr7Mo4	 H2Cr7Mo4
M 5206 40 t/m A = 6 mm, B = 12 mm, C = 32 mm	M 5208 40 t/m A = 8 mm, B = 12 mm, C = 32 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5210 50 t/m A = 10 mm, B = 14 mm, C = 32 mm	M 5212 60 t/m A = 12 mm, B = 18 mm, C = 32 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5216 80 t/m A = 16 mm, B = 25 mm, C = 32 mm	M 5220 100 t/m A = 20 mm, B = 32 mm, C = 32 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5224 100 t/m A = 24 mm, B = 32 mm, C = 32 mm	M 5230 110 t/m A = 30 mm, B = 40 mm, C = 40 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5240 130 t/m A = 40 mm, B = 50 mm, C = 50 mm	M 5250 150 t/m A = 50 mm, B = 70 mm, C = 70 mm
 H2Cr7Mo4	 H2Cr7Mo4
M 5260 150 t/m A = 60 mm, B = 70 mm, C = 70 mm	M 5280 150 t/m A = 80 mm, B = 95 mm, C = 95 mm

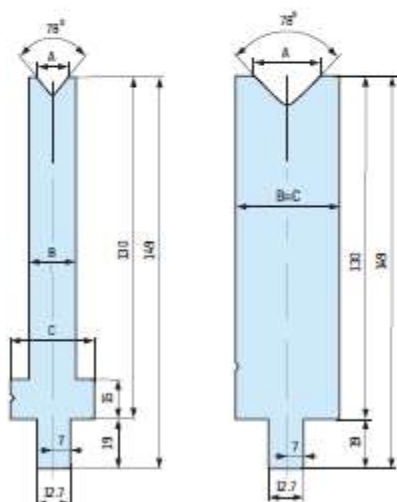


TYPE "L" DIES 130 MM

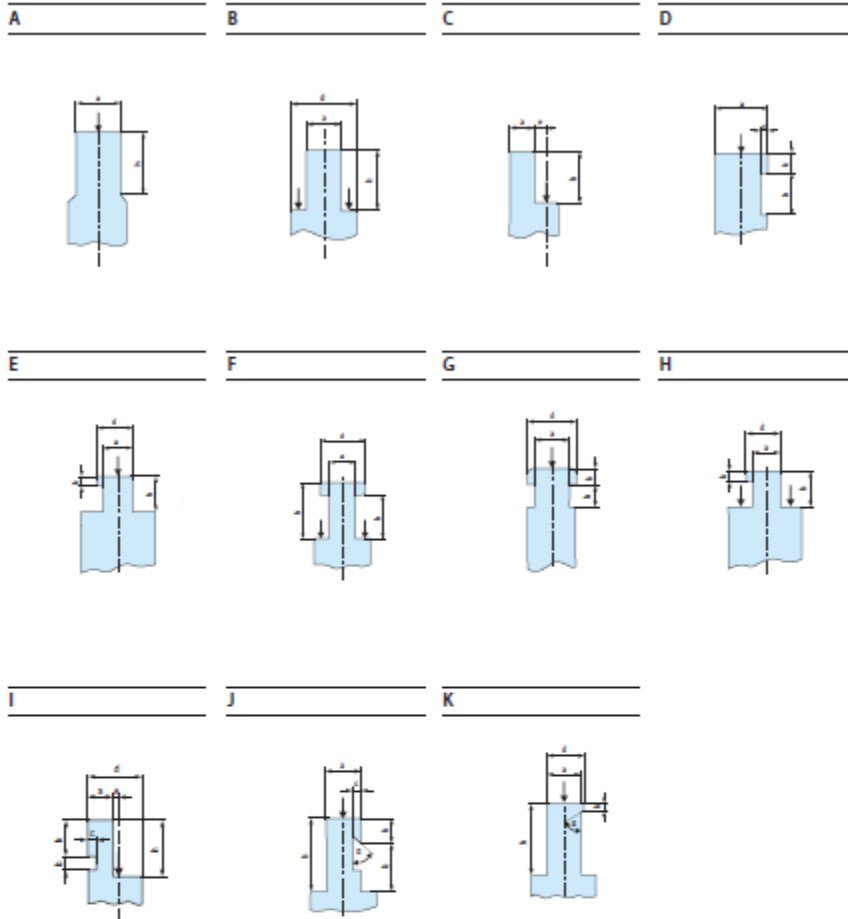
 42CrMo4 M 5306 20 t/m A = 6 mm, B = 16 mm, C = 32 mm	 42CrMo4 M 5308 20 t/m A = 6 mm, B = 16 mm, C = 32 mm
 42CrMo4 M 5310 30 t/m A = 10 mm, B = 25 mm, C = 40 mm	 42CrMo4 M 5312 35 t/m A = 12 mm, B = 25 mm, C = 32 mm
 42CrMo4 M 5320 35 t/m A = 20 mm, B = 30 mm, C = 32 mm	 42CrMo4 M 5424 55 t/m A = 24 mm, B = 45 mm, C = 45 mm
 42CrMo4 M 5330 60 t/m A = 30 mm, B = 70 mm, C = 70 mm	 42CrMo4 M 5340 60 t/m A = 40 mm, B = 75 mm, C = 75 mm
 42CrMo4 M 5350 70 t/m A = 50 mm, B = 80 mm, C = 80 mm	



 42CrMo4 M 5406 40 t/m A = 6 mm, B = 12 mm, C = 32 mm	 42CrMo4 M 5408 40 t/m A = 8 mm, B = 12 mm, C = 32 mm
 42CrMo4 M 5410 50 t/m A = 10 mm, B = 14 mm, C = 32 mm	 42CrMo4 M 5412 60 t/m A = 12 mm, B = 18 mm, C = 32 mm
 42CrMo4 M 5416 80 t/m A = 16 mm, B = 25 mm, C = 32 mm	 42CrMo4 M 5420 100 t/m A = 20 mm, B = 32 mm, C = 32 mm
 42CrMo4 M 5424 100 t/m A = 24 mm, B = 32 mm, C = 32 mm	 42CrMo4 M 5430 110 t/m A = 30 mm, B = 40 mm, C = 40 mm
 42CrMo4 M 5440 130 t/m A = 40 mm, B = 50 mm, C = 50 mm	 42CrMo4 M 5480 150 t/m A = 80 mm, B = 95 mm, C = 95 mm
 42CrMo4 M 5450 150 t/m A = 50 mm, B = 70 mm, C = 70 mm	 42CrMo4 M 54120 150 t/m A = 120 mm, B = 140 mm, C = 140 mm
 42CrMo4 M 54100 150 t/m A = 100 mm, B = 120 mm, C = 120 mm	



PUNCH MOUNTING EDGE



We offer punches with mounting edges as shown. The client can order a type from the drawing specifying his dimensions. The client may order a mounting edge to his own design.

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Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

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Site : gp-mo.com

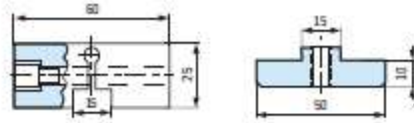
DIE HOLDERS



2V



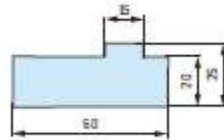
A



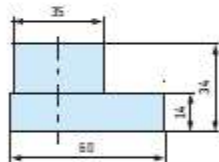
ASSEMBLY



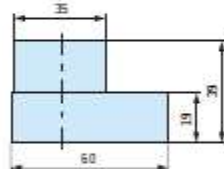
A 20



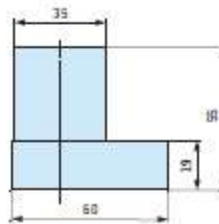
A 34



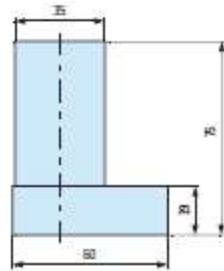
A 39



A 55



A 75



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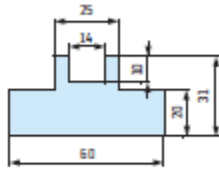
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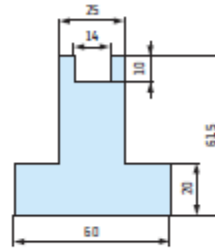
DIE HOLDERS



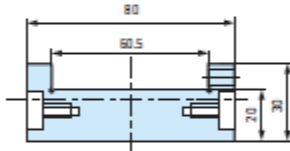
A 31



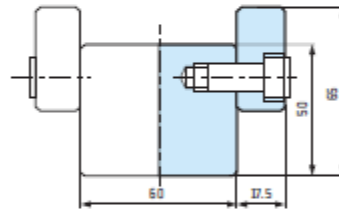
A 61



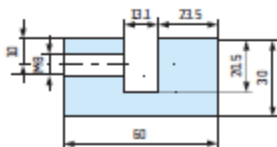
B 60



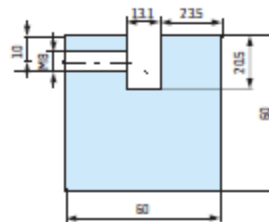
C 60



D 30



D 60



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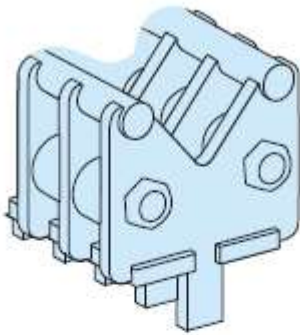
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COMPOUND DIES

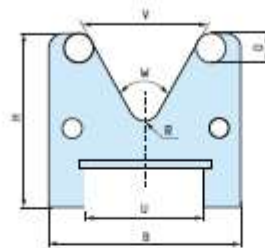


"Low Friction" dies meet the high demands of customers who need continual product improvement. By using new production techniques a new tooling product has been developed offering great value for money. It can be used for almost any application and will be a major advantage for use in the midrange and heavy sheet metal industry.

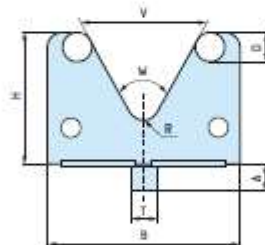
V	D	W ⁰	B	H	R	t/m
24	6	80	44	55	2	50
24	6	30	44	55	2	30
32	6	80	52	55	3	50
32	6	30	52	55	5	30
40	6	80	60	55	5	60
48	6	80	68	55	5	70
mm	mm	mm	mm	mm	mm	

V	D	W ⁰	B	H	R	t/m
40	15	30	78	80	5	100
50	15	35	88	90	7	100
60	15	40	98	110	10	120
80	20	45	130	130	10	160
100	20	55	150	140	18	200
120	25	60	180	160	18	250
150	25	70	212	180	25	300
200	30	80	270	220	30	350
250	30	80	325	300	40	400
300	40	80	400	360	40	450
400	50	80	524	400	50	550
mm	mm	mm	mm	mm	mm	

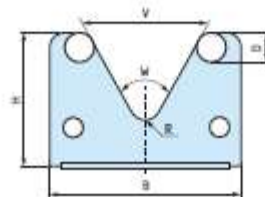
S



T



U



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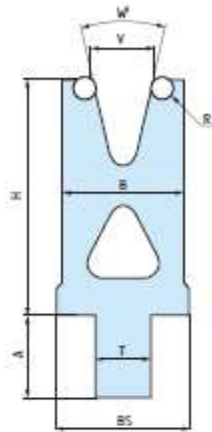
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Site : gp-mo.com

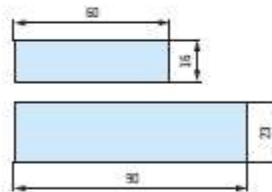
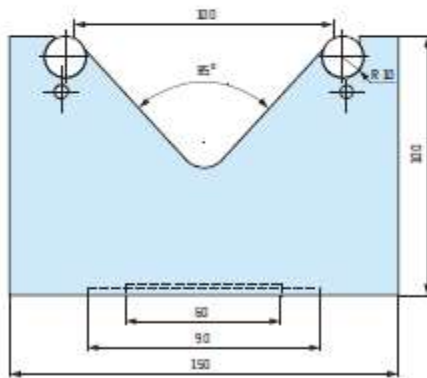
COMPOUND DIES



Compound dies are press brake dies for "airbending" only. The high precision, high quality, hardened and anodized, aluminium die body, contains the two hardened and ground die bars. The die bars are interchangeable in case of wear. The bars can be TiN coated for longer life, and less friction. Bronze or non metallic bars can be supplied for special applications.

V	R	W	B	BS	H	T/m	T	A
8	1.5	30	20	30	55	20	1.3	20
12	2	30	24	30	55	30	1.3	20
16	2.5	30	28	28	55	40	1.3	20
20	2.5	30	32	32	55	45	1.3	20
24	3	30	40	40	55	50	1.3	20
32	4	60	52	52	55	60	1.3	20

ROLL DIES



Round inserts hardened up to 60 HRC allow for bending steel up to 14 mm thick.

Rectangular inserts 60 mm or 90 mm wide allow the die to be fixed on smaller machine beams.

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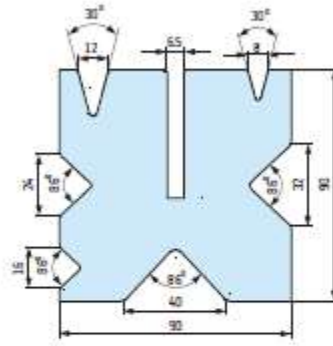
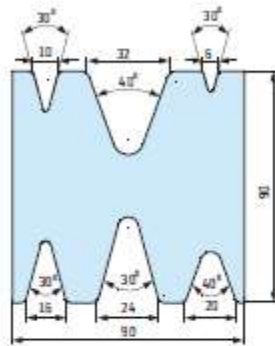
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SPECIAL DIES

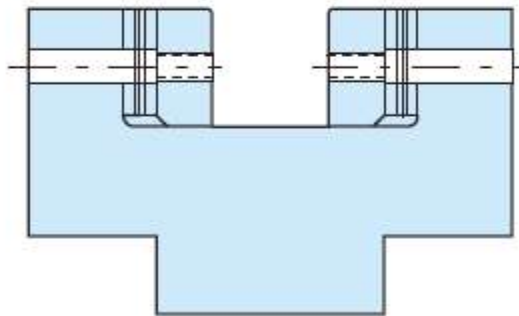
multiple vee dies 42CrMo4

We can offer different sizes to the customer's specification,
length up to 4100 mm.



variable vee die

Adjusted with inserts for different vee size



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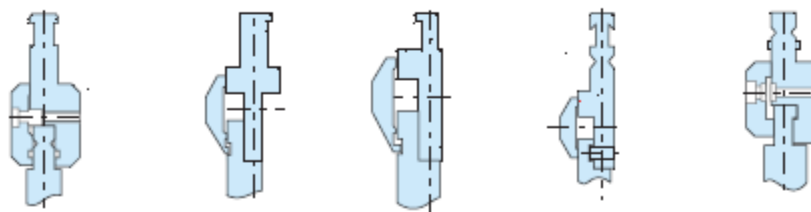
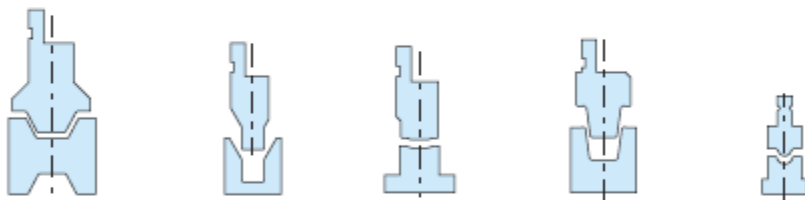
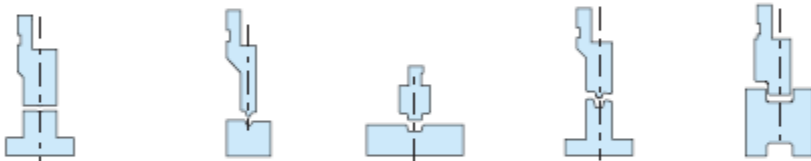
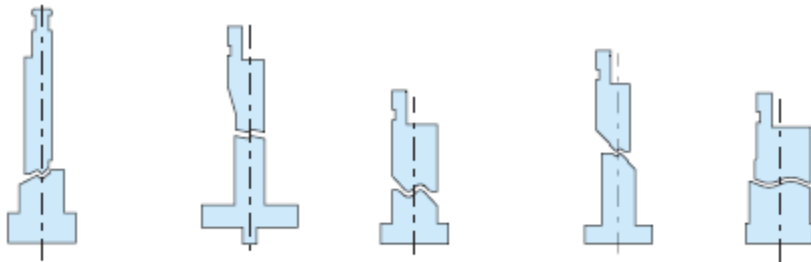
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SPECIAL TOOLING

Example of specialized tooling. We can offer many types of punches and dies for special applications, as well as non standard holders.



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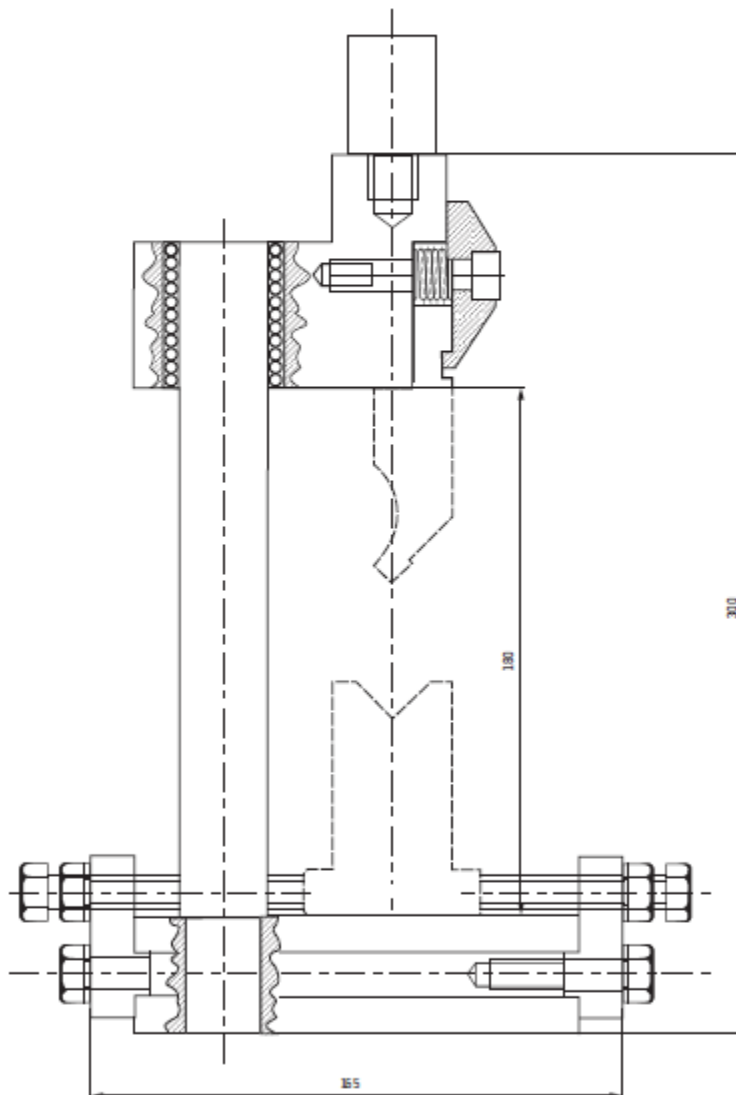
OTHER PRODUCTS

bending device

The device allows bending of sheet metal on mechanical and hydraulic presses.

Length of bending

L = 835 mm



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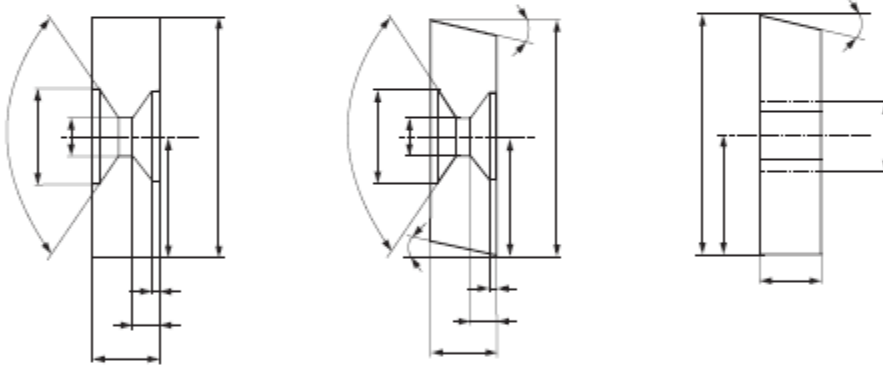
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OTHER PRODUCTS

shear blades

Insert dimensions



We offer shear blades for most types of shears, typical or according to the clients own drawings. We grind the blades and harden them to 55 ±2 HRC. We have in stock all types of Polish and Czech shear knives types NG 3 – 13, NTE, CNTA 6.3 – 25. We can also offer many other types of blades according to the client drawings and specification, of length up to 1550 mm. We can regrind and repair used blades of up to 4100 mm in length.

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Tél : (33) **3 88 08 39 35**

Fax (33) **3 69 20 14 97**

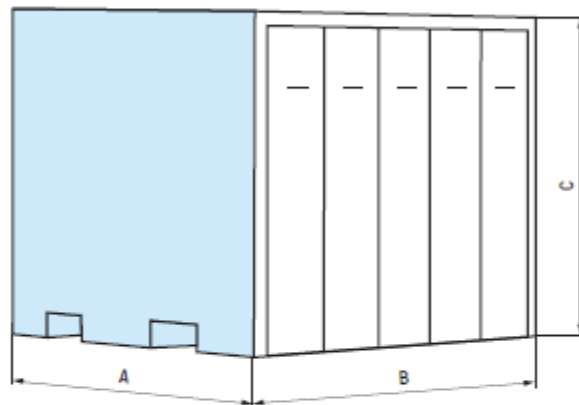
Mobile : **06 61 46 21 02**

Email : gp-mo@wanadoo.fr

Site : gp-mo.com

OTHER PRODUCTS

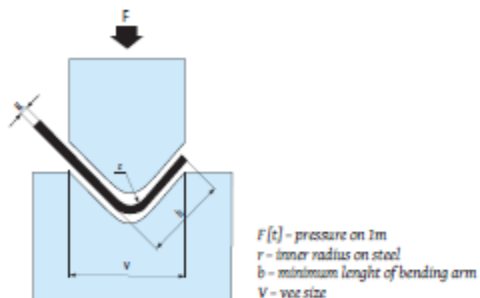
tooling cabinets



Safe and functional tooling cabinets allow fast and easy access to tools, while protecting them from mechanical damage. Available with 3, 4 or 5 sections, each capable of storing up to 10 m of tooling. Solid upper and lower shelves allow storing of sectionalized tooling. As standard made for type A tools, punches with 13 mm holding and dies with 60 mm holding, 835 mm in length, also possible to make shelves for tools of types T and L, with length of tool 1100 mm. Cabinets are powder coated and easy to transport. They were designed and manufactured to last a long time.

PRESSURE TABLE

The table shows bending pressure for sheets with air bending



RM = 45 kg/mm²

g	V	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	140	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	100	113	140	180
r	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	23	26	33	40	
0.5		4	3																				
0.6		6	4	3	3																		
0.8			7	6	5	4																	
1.0			13	10	8	6	5																
1.2				13	10	8	6	5															
1.5						13	10	9	8	7													
2.0							25	20	17	14	13	10											
2.5								29	24	21	16	12											
3.0									38	32	24	17	13										
4.0											47	34	25	19	14								
5.0													57	42	32	24	18						
6.0														65	48	36	26	20					
8.0															94	69	50	38	29	25			
10.0																84	63	48	41	35			
12.0																	130	96	72	62	53	40	31
16.0																		139	120	101	76	58	
20.0																						126	95

RM = 70 kg/mm²

g	V	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	140	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	100	113	140	180	
r	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	23	26	33	40		
0.5		7	4																					
0.6		10	6	5	4																			
0.8			11	9	8	6																		
1.0				19	16	13	10	8																
1.2					20	15	12	10	8															
1.5						20	16	14	12	10														
2.0							39	31	26	22	20	15												
2.5								44	38	33	25	18												
3.0									58	50	37	27	20											
4.0											73	53	39	30	22									
5.0												89	66	49	37	27								
6.0													101	75	55	41	31							
8.0														147	107	78	59	45	39					
10.0																	131	98	74	64	55			
12.0																		202	149	112	97	82	62	48
16.0																			217	187	157	118	90	
20.0																						196	148	



GP-MO

39 rte du Hohwald 67140 BARR (France)

Tél : (33) 3 88 08 39 35

Fax (33) 3 69 20 14 97

Mobile : 06 61 46 21 02

Email : gp-mo@wanadoo.fr

Site : gp-mo.com



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