



PRESS BRAKE TOOLS LVD TYPE (LVD-W)

2020 VERS. 1.0

PROFESSIONAL NON-ORIGINAL
HIGH QUALITY TOOLING

MADE IN ITALY 



About Precitools

PRECITOOLS is the professional supplier of press brakes tools for various press brake models and manufacturers.

We are able to offer any standard or special types of tools (punches and dies, hemming sets, stamps, punchholders, die holders, adapters, die inserts, radius tooling etc.) for main press brake systems such as Promecam–EURO Style, Trumpf-WILA, Beyeler-Bystronic, LVD etc. We can supply rich selection of standard shapes or to make any special tools under request of customer including the length of 6000-8000 mm in one piece, together with specialized technical customer's support for any press brake bending application.

With our location in the heart of business Italy – Milan and available stocks in Piacenza and Milan we can carefully and accurate deliver any massive orders with the professional care and effective delivery time. :

Press brake bending

Press brake bending is the most general industrial process today to obtain the controlled deformation of the sheetmetal in cold with the use of press brake power (hydraulic or electric system) to obtain necessary force with the travel of the beam together with the upper punch. Today, press brake machinery is used for every workshop and jobshop connected with sheetmetal fabrication.

According to the geometry of the bend and form of bending tools it is possible to get the required deformation with the desired angle and shape. We are able to provide tools for any press brake technical process: air-bending, coining or stamping and bottom bending.

According to the clamping part of tools we can support most of the used press brake machines in the world. Together with standard geometries customized tooling is also possible to supply.



Stock and deliveries

Availability on stock for most common positions allows offering from our side the possibilities 24h; 48h and 72h deliveries which grants to our customers the receipt of tooling in the most shortest times.

Moreover we are trying to study all the projects with the possibility to offer standard tools with the short delivery time and more effective prices. We are able to make delivery to any place of European Union for the quick time and reasonable prices thanks to partnership with leading Italian transport companies.

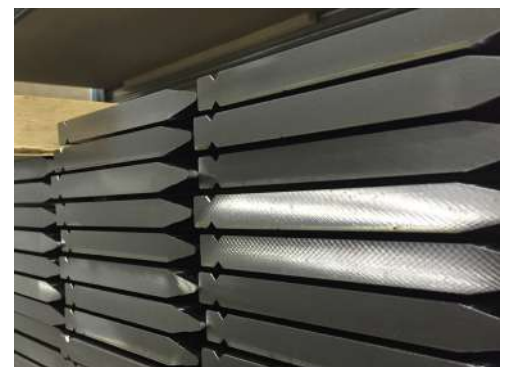
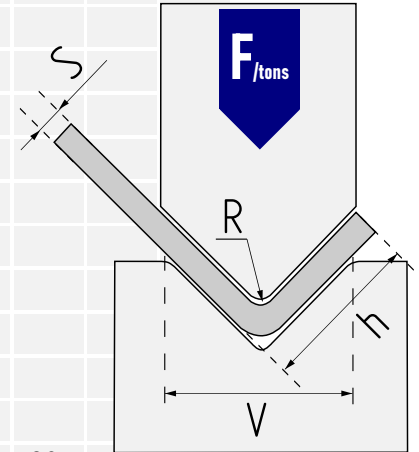


TABLE OF PRESS BRAKE FORCE FOR AIR BENDING



MILD STEEL BENDING (Resistance 450-500 N/mm²)

S	V	4	6	8	10	12	16	20	24	30	40	50	60	80	100	120	
	h	2,8	4,3	5,7	7,1	8,5	11,0	14,0	17,0	21,0	28,0	36,0	43,0	57,0	71,0	85,2	
	R	0,6	0,9	1,3	1,6	1,9	2,5	3,1	3,8	4,7	6,3	7,8	9,4	13,0	15,6	18,8	
0,5		4	3														
0,6		6	4	4													
0,8			7	5	4												
1,0			11	8	7	6											
1,2				12	10	8	6										
1,5				20	17	15	11	9									
2,0					22	17	13	11									
2,5					49	32	24	19	14								
3,0						50	36	29	21	15							
4,0							73	56	41	28	21						
5,0								97	70	47	35	28					
6,0										73	54	42	30				
8,0												83	57	43	34		
10,0													95	71	57		
12,0														108	86		
15,0																143	
20,0																	request more opening or Heavy Duty tooling - under request, contact us



STAINLESS STEEL (AISI) BENDING (Resistance 700 N/mm²)

S	V	4	6	8	10	12	16	20	24	30	40	50	60	80	100	120	
	h	2,8	4,3	5,7	7,1	8,5	11,0	14,0	17,0	21,0	28,0	36,0	43,0	57,0	71,0	85,2	
	R	0,6	0,9	1,3	1,6	1,9	2,5	3,1	3,8	4,7	6,3	7,8	9,4	13,0	15,6	18,8	
0,5		6	4														
0,6		9	6	6													
0,8			11	8	7												
1,0			19	13	10	8											
1,2				22	16	13	9										
1,5				34	25	20	13	10									
2,0					39	26	19	16									
2,5					67	44	33	26	19								
3,0						69	50	39	29	20							
4,0								78	57	39	29						
5,0									97	65	49	37					
6,0										74	59	41	31				
8,0												78	59	47			
10,0													98	78			
12,0																117	
15,0																	request more opening or Heavy Duty tooling - under request, contact us

► All dimensions in mm, force in metrical tons. The chart is only for informational purposes, without guarantees, the real values could be different. Please refer to CNC of your press brake, contact us or the manufacturer for actual values.



BASIC

Professional press brake tooling system for LVD-type press brakes for precision long-live effective bending.

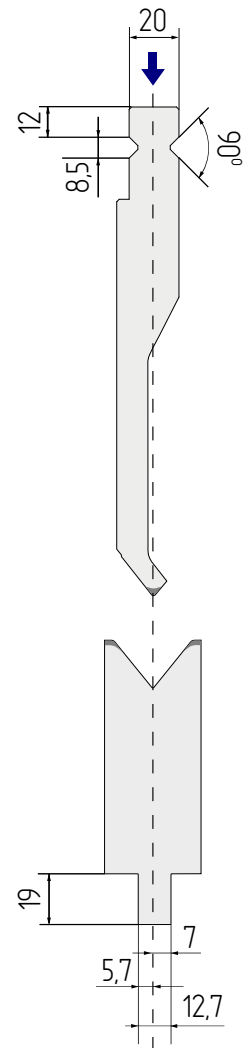
- With this color material C45 650-800 N/mm²
 - With this color material 1.2312 (similar to 40CrMnMo) 950-1100 N/mm²
 - Optional material 42CrMo4 1100-1200 N/mm²
- ▶ High-quality materials and all works, "Made in Italy"
 - ▶ Induction treatment for contact areas
 - ▶ Depth of hardening 3-4 mm, 52-58 HRC
 - ▶ Precision milling and grinding
 - ▶ Perfect parallelism
 - ▶ Effective replacement for LVD-type tools from any supplier

PUNCHES

- ▶ Type WILA
- ▶ Self-centering
- ▶ Mirror positioning, work available on both sides
- ▶ Pins on economic version or more than 12,5 kg
- ▶ Safety Clicks for vertical loading
- ▶ Specialized and customized solutions

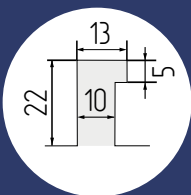
DIES

- ▶ Type LVD, tang 19 x 12,7
- ▶ Specialized and customized solutions

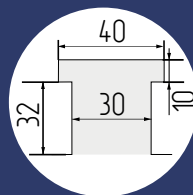
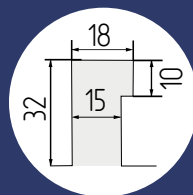


Professional assistance for other types of LVD tooling and non-standard geometries

Classic LVD



Classic LVD 400tons





AVAILABLE LENGTH

Solid section L=508 mm:

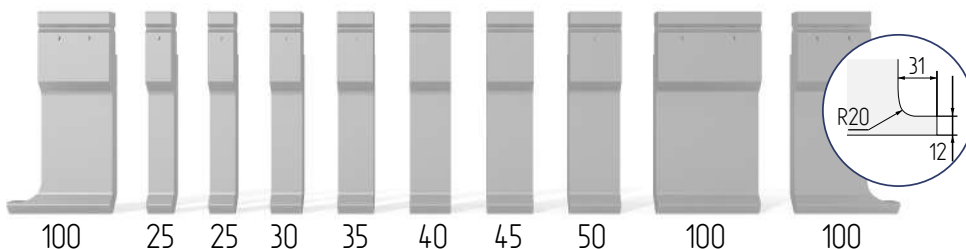


Solid section L=250 mm:



- ▶ Pins or Safety Click
- ▶ Solid sections till L=2000 mm under request

Sectioned set L=550 mm / 10 pieces:



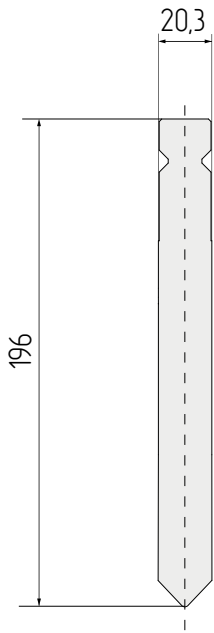
- ▶ Pins or Safety Click
- ▶ 100 mm horns (left and right) in standard for closed box bending
- ▶ Special horn radius under request
- ▶ Special sections length under request
- ▶ Toolcells modifications (buttons, sections 480 / 625 mm)
- ▶ Other individual modifications



Standard pins version
Horizontal (side) loading, no limits for weight of punch and classical economical version



Safety Click (buttons) version
Vertical tooling change for any punches **less than 12,5 kg** of weight for safe of setup time. Ideal choice for sectioned tooling

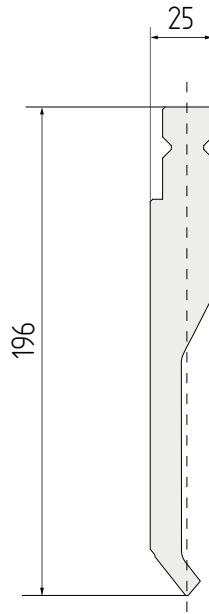


1.2312

LD-18001

α	R	H	KG
78°	2.00	196.00	80 t/m

Ref to original: R10 W



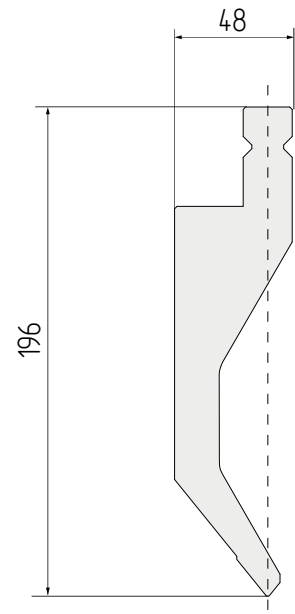
1.2312

LD-18002

α	R	H	KG
78°	1.00	196.00	40 t/m

Ref to original: E10 W

With R 2 (as E10 W R2) under request



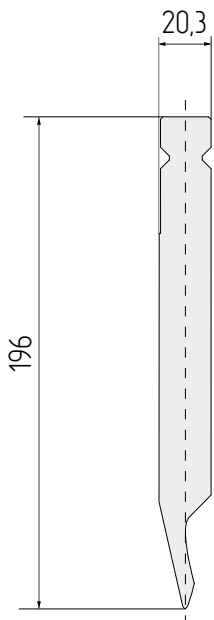
1.2312

LD-18003

α	R	H	KG
78°	1.00	196.00	40 t/m

Ref to original: D10 W

With R 2 (as D10 W R2) under request

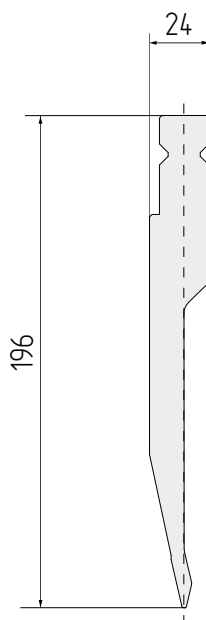


1.2312

LD-18004

α	R	H	KG
26°	1.00	196.00	40 t/m

Ref to original: F10 W



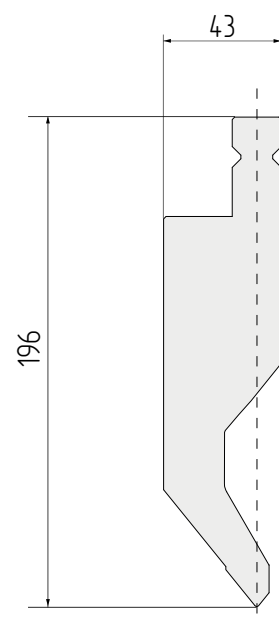
1.2312

LD-18005

α	R	H	KG
26°	1.00	196.00	40 t/m

Ref to original: J10 W

With R 2 (as J10 W R2) under request

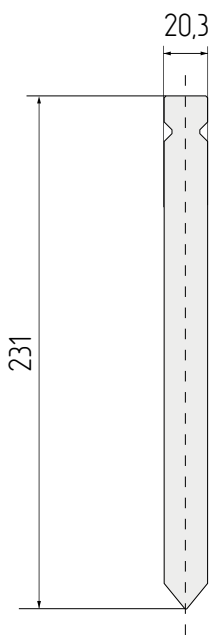


1.2312

LD-18006

α	R	H	KG
78°	2.00	196.00	70 t/m

Ref to original: C10 W (old vers.)

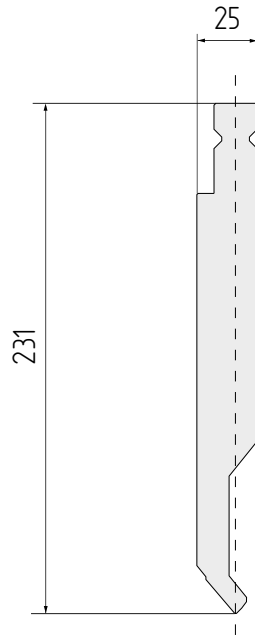


1.2312

LD-18007

α	R	H	KG
78°	3.00	231.00	120 t/m

Ref to original: R15 W

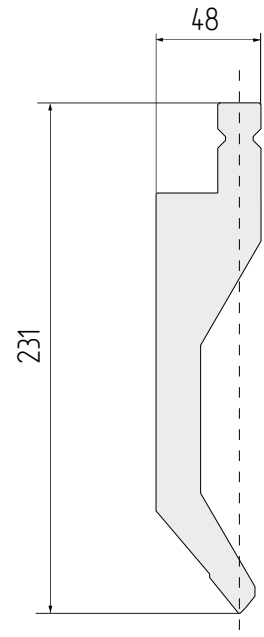


1.2312

LD-18008

α	R	H	KG
78°	2.00	231.00	50 t/m

Ref to original: E15 W

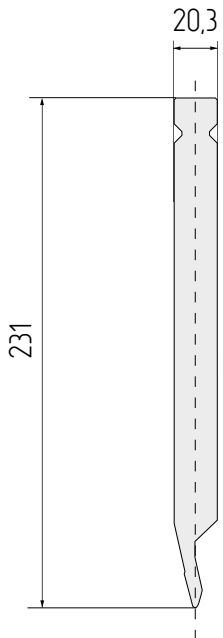


1.2312

LD-18009

α	R	H	KG
78°	2.00	231.00	75 t/m

Ref to original: D15 W

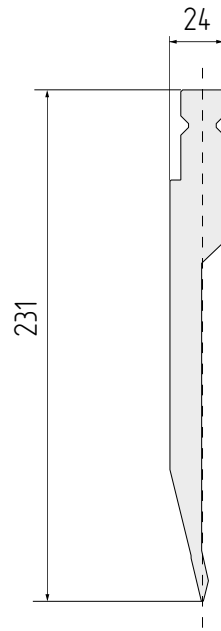


1.2312

LD-18010

α	R	H	KG
26°	2.00	231.00	50 t/m

Ref to original: F15 W

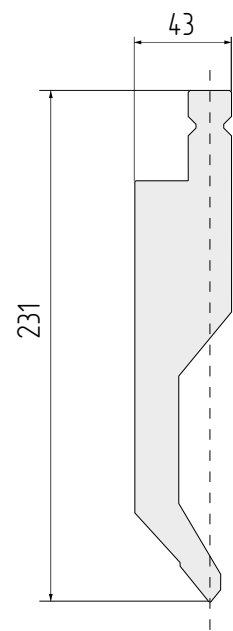


1.2312

LD-18011

α	R	H	KG
26°	2.00	231.00	50 t/m

Ref to original: J15 W



1.2312

LD-18012

α	R	H	KG
78°	2.00	231.00	70 t/m

Ref to original: C15 W



1.2312
LD-18013

α	R	H	KG
20°	1.00	206.00	40 t/m

1.2312
LD-18013

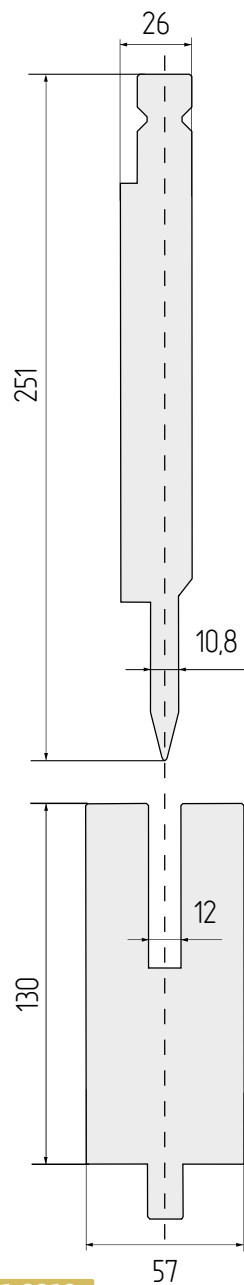
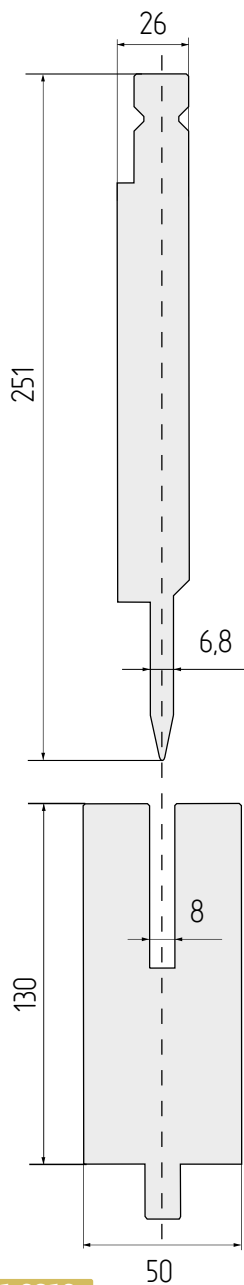
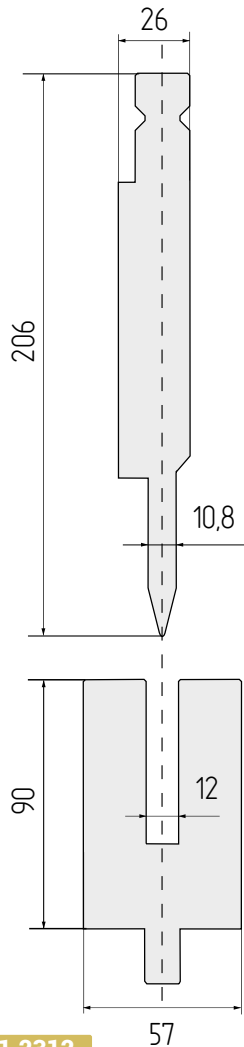
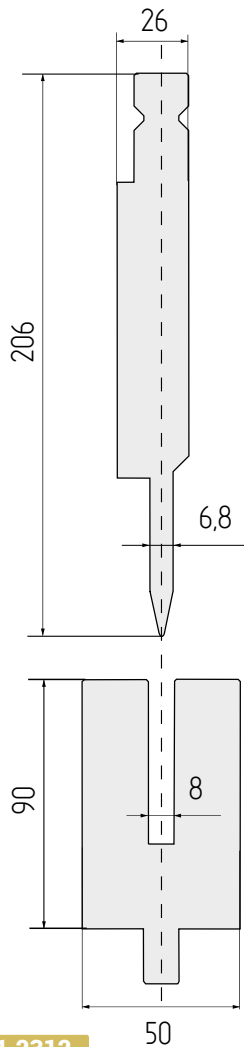
α	R	H	KG
20°	1.00	206.00	40 t/m

1.2312
LD-18013

α	R	H	KG
20°	1.00	206.00	40 t/m

1.2312
LD-18013

α	R	H	KG
20°	1.00	206.00	40 t/m



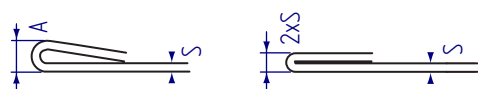
1.2312
LD-18013

α	R	H	KG
20°	1.00	206.00	40 t/m

1.2312
LD-18013

α	R	H	KG
20°	1.00	206.00	40 t/m

BENDING CHART



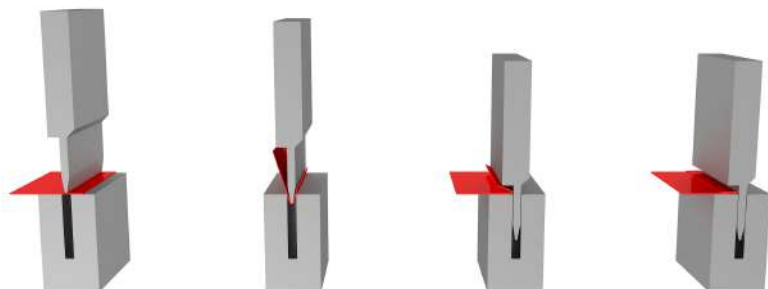
S mm	A mm	2xS	ton/m steel (A/2xS)	ton/m AISI (A/2xS)
0.6	3.00	1.2	9 / 23	15 / 35
0.8	3.00	1.6	12 / 32	20 / 50
1.0	3.50	2.0	15 / 40	25 / 60
1.25	3.50	2.5	17 / 50	26 / 80
1.5	4.60	3.0	22 / 63	38 / 95
2.0	5.50	4.0	30 / 80	50 / 130

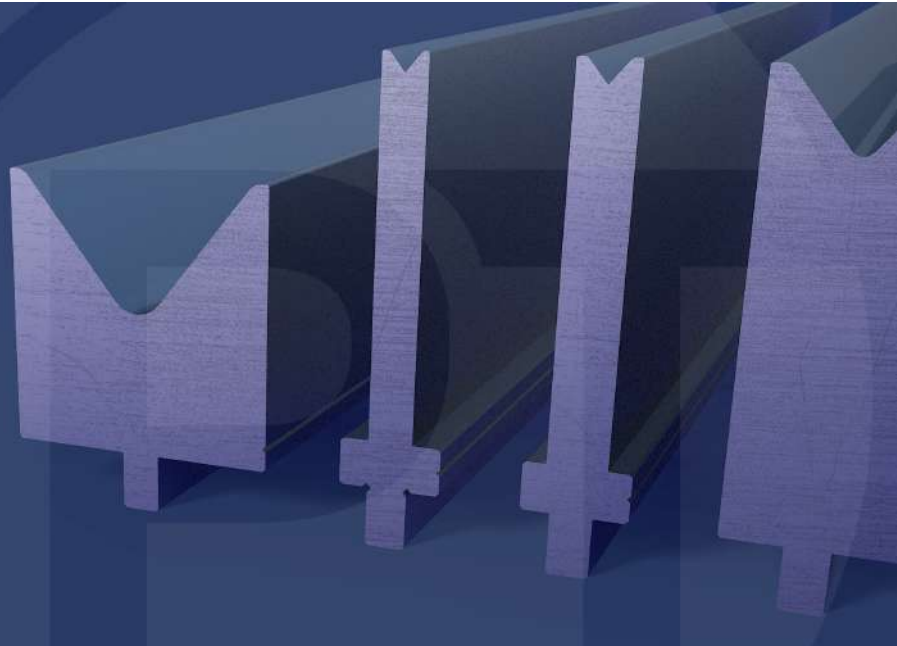
1.2312
LD-18013

α	R	H	KG
20°	1.00	206.00	40 t/m

1.2312
LD-18013

α	R	H	KG
20°	1.00	206.00	40 t/m





AVAILABLE LENGTH

Solid section L=508 mm:

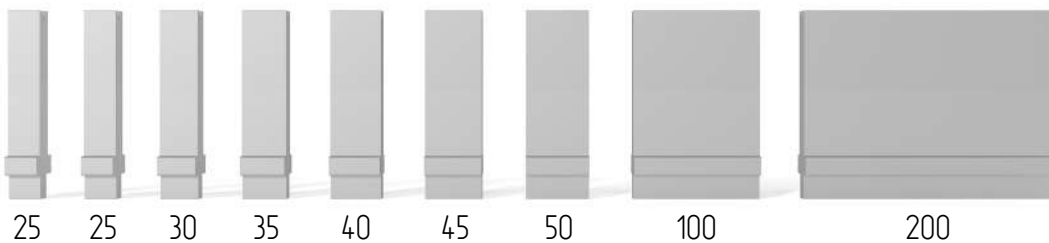


Solid section L=250 mm:

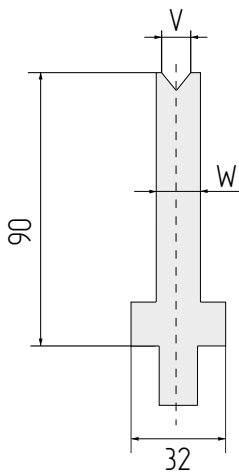


- ▶ Solid sections till L=2000 mm under request

Sectioned set L=550 mm / 9 pieces:



- ▶ Special sections length under request
- ▶ Toolcells modifications (sections 480 / 420 mm)
- ▶ Other individual modifications

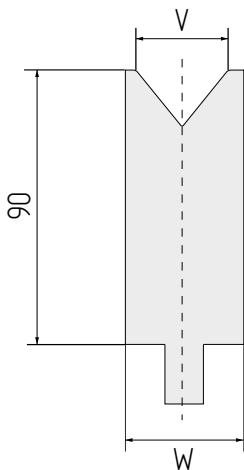


C45

LD-3210-X

α	Art.	V	W	R	KG
78°	3210-40	6	12	0.8	40 t/m
78°	3210-50	8	12	1.0	40 t/m
78°	3210-60	10	14	1.2	50 t/m
78°	3210-70	12	18	1.5	60 t/m
78°	3210-11	16	25	2.0	80 t/m

42CrMo4 / 1.2312 material under request

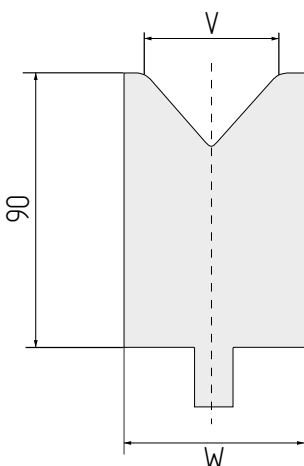


C45

LD-3211-X

α	Art.	V	W	R	KG
78°	3211-20	20	32	2.5	100 t/m
78°	3211-30	24	32	3.0	100 t/m
78°	3211-40	30	40	3.0	110 t/m
78°	3211-50	40	50	3.5	130 t/m
78°	3211-60	50	70	4.0	150 t/m

42CrMo4 / 1.2312 material under request

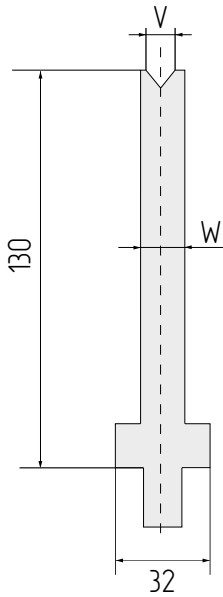


C45

LD-3212-X

α	Art.	V	W	R	KG
78°	3212-70	60	70	5.0	150 t/m
78°	3212-80	80	95	6.0	150 t/m
78°	3212-90	100	120	8.0	150 t/m
78°	3212-63	120	140	10.0	150 t/m

42CrMo4 / 1.2312 material under request

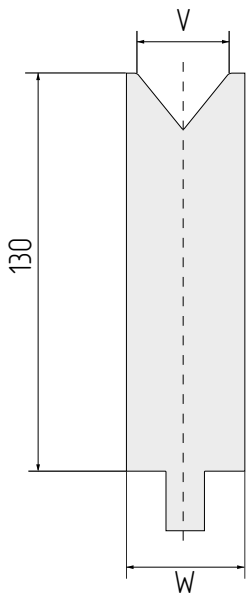


C45

LD-3215-X

α	Art.	V	W	R	KG
78°	3215-10	6	12	0.8	40 t/m
78°	3215-20	8	12	1.0	40 t/m
78°	3215-30	10	14	1.2	50 t/m
78°	3215-40	12	18	1.5	60 t/m
78°	3215-50	16	25	2.0	80 t/m

42CrMo4 / 1.2312 material under request

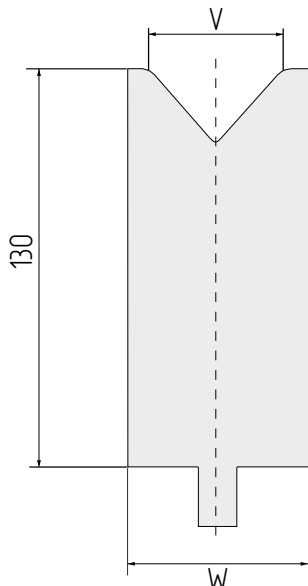


C45

LD-3216-X

α	Art.	V	W	R	KG
78°	3216-60	20	32	2.5	100 t/m
78°	3216-70	24	32	3.0	100 t/m
78°	3216-80	30	40	3.0	110 t/m
78°	3216-90	40	50	3.5	130 t/m
78°	3216-00	50	70	4.0	150 t/m

42CrMo4 / 1.2312 material under request

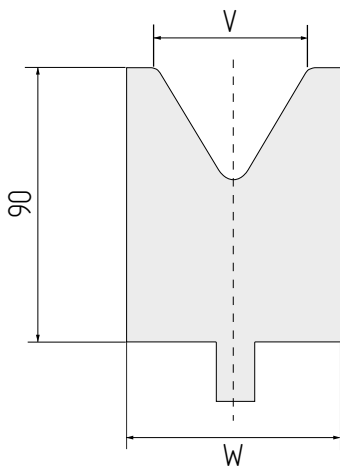


C45

LD-3217-X

α	Art.	V	W	R	KG
78°	3217-10	60	70	5.0	150 t/m
78°	3217-20	80	95	6.0	150 t/m
78°	3217-40	100	120	8.0	150 t/m
78°	3217-00	120	140	10.0	150 t/m

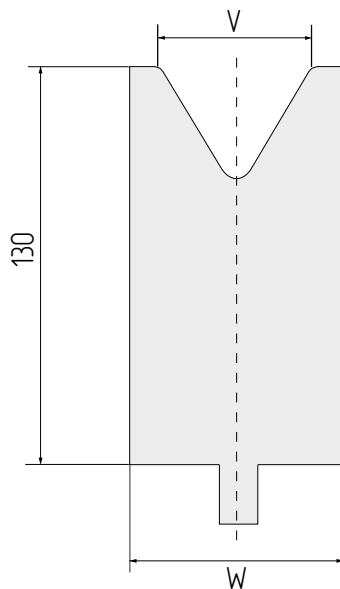
42CrMo4 / 1.2312 material under request



1.2312

LD-3213-X

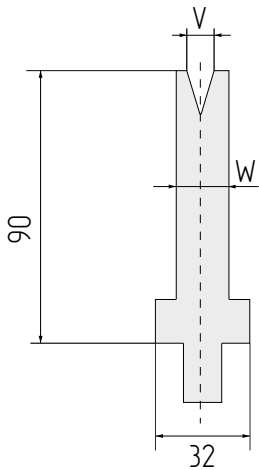
α	Art.	V	W	R	KG
60°	3213-70	30	40	3.0	50 t/m
60°	3213-80	40	55	5.0	66 t/m
60°	3213-90	50	70	5.0	105 t/m
60°	3213-30	60	80	7.0	135 t/m
60°	3213-40	80	102	8.0	175 t/m
60°	3213-71	100	120	8.0	150 t/m
60°	3213-81	120	145	8.0	130 t/m



1.2312

LD-3214-X

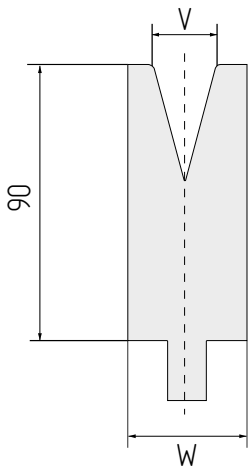
α	Art.	V	W	R	KG
60°	3214-00	30	40	3.0	50 t/m
60°	3214-10	40	55	5.0	66 t/m
60°	3214-20	50	70	5.0	105 t/m
60°	3214-50	60	80	7.0	135 t/m
60°	3214-60	80	102	8.0	175 t/m
60°	3214-90	100	120	8.0	150 t/m
60°	3214-91	120	145	8.0	130 t/m



1.2312

LD-3218-X

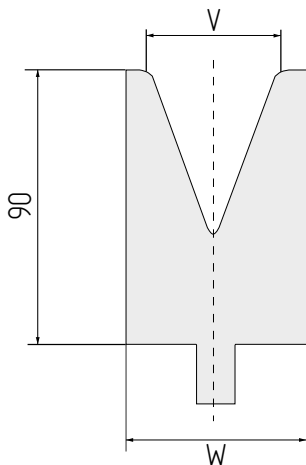
α	Art.	V	W	R	 KG
30°	3218-00	6	16	0.8	20 t/m
30°	3218-10	8	18	1.0	22 t/m
30°	3218-20	10	25	1.2	30 t/m
30°	3218-30	12	25	1.5	38 t/m



1.2312

LD-3219-X

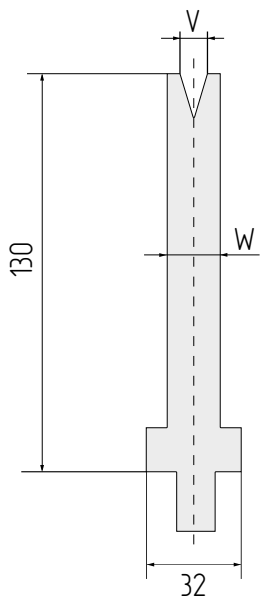
α	Art.	V	W	R	 KG
30°	3219-80	16	32	2.0	38 t/m
30°	3219-90	20	40	2.5	38 t/m
30°	3219-11	24	45	3.0	55 t/m



1.2312

LD-3220-X

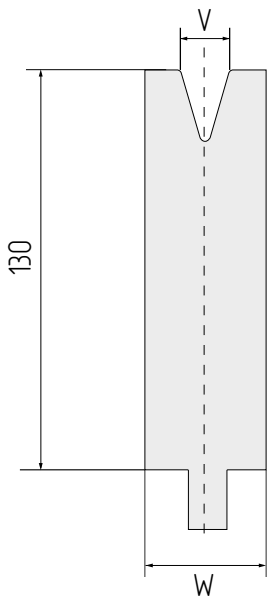
α	Art.	V	W	R	 KG
30°	3220-10	30	70	3.0	60 t/m
30°	3220-20	40	75	4.0	60 t/m
30°	3220-30	50	95	4.0	78 t/m



1.2312

LD-3221-X

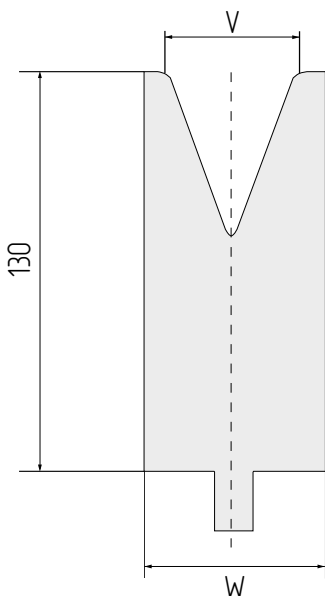
α	Art.	V	W	R	
30°	3221-40	6	16	0.8	20 t/m
30°	3221-50	8	18	1.0	22 t/m
30°	3221-60	10	25	1.2	30 t/m
30°	3221-70	12	25	1.5	38 t/m



1.2312

LD-3222-X

α	Art.	V	W	R	
30°	3222-80	16	32	2.0	38 t/m
30°	3222-90	20	40	2.5	38 t/m
30°	3222-11	24	45	3.0	55 t/m



1.2312

LD-3223-X

α	Art.	V	W	R	
30°	3223-40	30	70	3.0	60 t/m
30°	3223-50	40	75	4.0	60 t/m
30°	3223-60	50	95	4.0	78 t/m



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