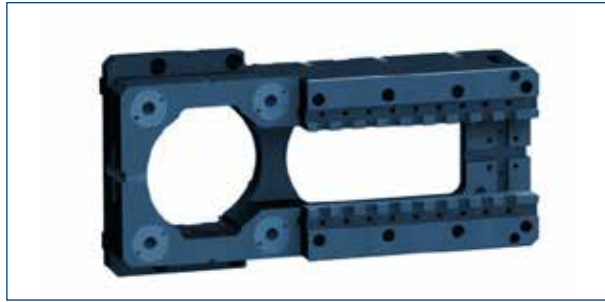


LEANTOOL

radial

Standard parts catalogue E 1.1



206-01-0377.1
Tool carrier

Basic structure for tool concept LEANTOOL with pneumatic zero point clamping system
Length 489 mm, Flange height 112 mm

*Without tool clamping plate
Without tool clamping insert



206-01-0381.1
Tool clamping plate

for LEANTOOL tool carrier, incl. clamping pins for zero point clamping system, (for preliminary setup of LEANTOOLS)



206-01-0383.1
Tool clamping plate

for LEANTOOL tool carrier incl. clamping pins for zero point clamping system (for adaptation to existing radial tools on tool plate carrier, diameter 200 mm
Height 67 mm



100-07-4900.1
Control unit

Position request for material end position in bending tool (after end of material feed)



206-01-0388.1
Retaining plate

for material guidance (to bending center)



206-03-0061.1
Central die unit

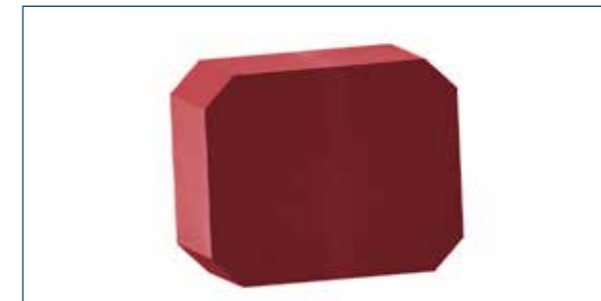
for LEANTOOL tool concept, incl. clamping pins for zero point clamping system for installation on GRM-NC central die holder, incl. fitting bolts for exact positioning of the retaining plate Diameter 102 mm

*without retaining plate



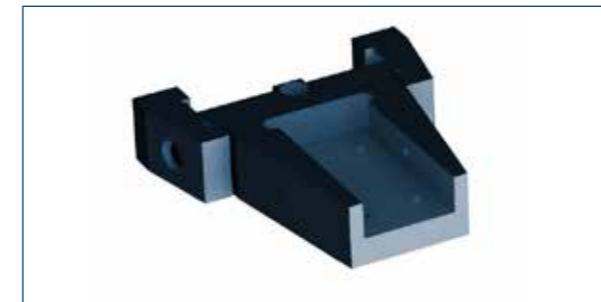
206-03-0063.5
Retaining plate

20 mm for LEANTOOL tool concept, incl. locating holes for exact positioning on central die unit (to accommodate the ejector elements)



206-03-0064.5
Retaining plate

50 mm for LEANTOOL tool concept, incl. locating holes for exact positioning on central die unit (to accommodate the ejector elements)



206-54-0029.1
Punch holder

for LEANTOOL tool concept installation on base plate for punch holder for punch width 30 mm
incl. adjustable stop block

*without base plate



206-54-0028.1
Base plate for punch holder

for LEANTOOL tool concept installation on NCA4 sleeve accommodates up to 2 punch holders

*without punch holder



606-10-0001.6
Blank punch

Suitable for LEANTOOL punch holder
Length: 240 mm
Width: 50 mm
Thickness: 20 mm
Material: 1.2379 hardened (58 HRC)

606-10-0002.6
Blank punch

Suitable for LEANTOOL punch holder
Length: 240 mm
Width: 50 mm
Thickness: 25 mm
Material: 1.2379 hardened (58 HRC)

606-10-0003.6
Blank punch

Suitable for LEANTOOL punch holder
Length: 240 mm
Width: 50 mm
Thickness: 30 mm
Material: 1.2379 hardened (58 HRC)

606-10-0004.6
Blank punch

Suitable for LEANTOOL punch holder
Length: 245 mm
Width: 50 mm
Thickness: 45 mm
Material: 1.2379 hardened (58 HRC)

606-10-0005.6
Blank punch

Suitable for LEANTOOL punch holder
Length: 260 mm
Width: 50 mm
Thickness: 60 mm
Material: 1.2379 hardened (58 HRC)



206-67-0001.0
Separating module

Operation from behind, incl. central mandrel headpiece for operation with 2nd central mandrel
Separating area:
from min. 1.5 mm under machine center
to max. 41.5 mm above machine center
from min. 135 mm to max. 181 mm in front of perforated plate
from min. 138 mm to max. 265 mm to the right of machine center
Excluding:
Rear shearing punch 206-67-0008.5
Die insert (knife) 206-67-0010.5
Die insert (die) 206-67-0023.1
Shearing force max. 10 kN
Wire diameter max. 6 mm



206-67-0002.0
Separating module

Operation from above
Separating area:
from min. 1 mm under machine center
to max. 40.5 mm above machine center
from min. 135 mm to max. 177 mm in front of perforated plate
from min. 105.5 mm to max. 260 mm to the right of machine center
Excluding:
Top shearing punch 206-67-0013.5
Die insert (knife) 206-67-0010.5
Die insert (die) 206-67-0024.1
Shearing force max. 10 kN
Shearing stroke max. 6 mm
Wire diameter max. 6 mm
Strip width max. 30 mm
Strip thickness max. 3 mm



206-67-0003.0
Separating module

Operation from below
Separating area:
from min. 1 mm under machine center
to max. 40.5 mm above machine center
from min. 135 mm to max. 177 mm in front of perforated
plate
from min. 105.5 mm to max. 260 mm to the right of
machine center
Excluding:
Bottom shearing punch 206-67-0020.5
Die insert (knife) 206-67-0010.5
Die insert (die) 206-67-0024.1
Shearing force max. 10 kN
Shearing stroke max. 6 mm
Wire diameter max. 6 mm
Strip width max. 30 mm
Strip thickness max. 3 mm



206-67-0020.0
Bottom shearing punch

for separating module,
operation from below
Material: 1.2379+-1HRc (X155CrVMo12)



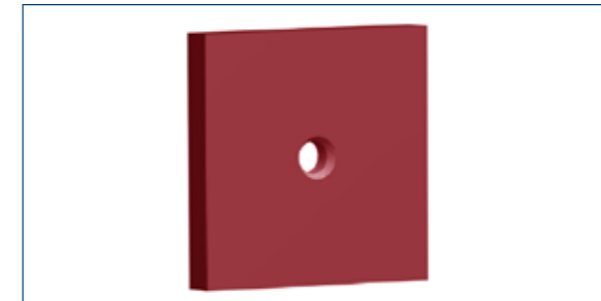
206-67-0013.5
Top shearing punch

for separating module,
operation from above
Material: 1.2379+-1HRc (X155CrVMo12)



206-67-0008.5
Rear shearing punch

for separating module,
operation from behind
Material: 1.2379+-1HRc (X155CrVMo12)



206-67-0010.5
Die insert (knife)

Blank for shearing punch
Material: 1.2379+-1HRc (X155CrVMo12)



206-67-0023.1
Die insert (die)

Blank for separating module,
operation from behind
Material: 1.2379+-1HRc (X155CrVMo12)
incl. packing plate set



206-67-0024.1
Die insert (die)

Blank for separating module,
operation from above/below
Material: 1.2379+-1HRc (X155CrVMo12)
incl. packing plate set



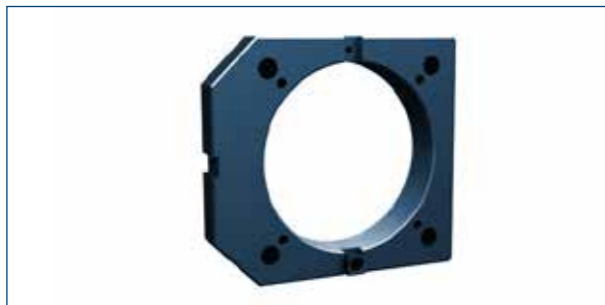
208-01-0131.1
Tool carrier

Basic structure for tool concept LEANTOOL
with pneumatic zero point clamping system
Length 341 mm
Flange height 93 mm
*Without tool clamping plate
Without tool clamping insert



208-01-0036.1
Tool clamping plate

for LEANTOOL tool carrier,
incl. clamping pins for
zero point clamping system,
(for preliminary setup of LEANTOOLS)



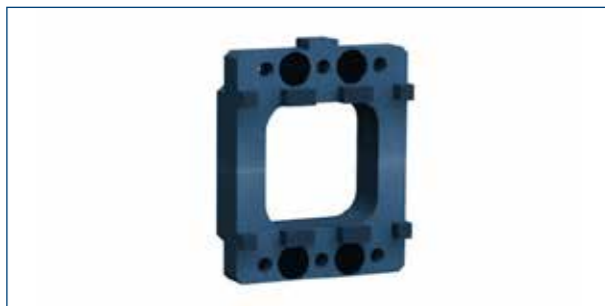
208-01-0139.1
Tool clamping plate

for LEANTOOL tool carrier incl. clamping pins for
zero point clamping system (for adaptation to
existing radial tools on tool plate carrier,
diameter 120 mm Height 68 mm



100-07-4900.1
Control unit

Position request
for material end position in bending tool
(after end of material feed)



208-01-0138.1
Tool clamping insert

for LEANTOOL tool carrier



208-01-0142.1
Retaining plate

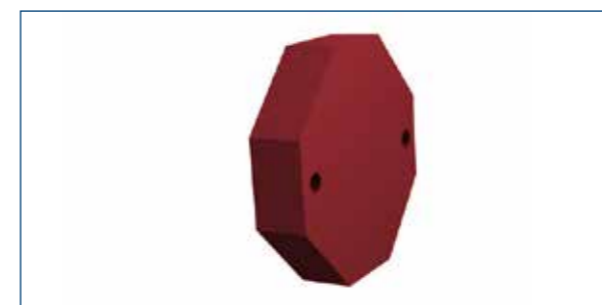
for material guidance
(to bending center)



208-03-0025.1
Central die unit

for LEANTOOL tool concept, incl. clamping pins for
zero point clamping system for installation on RM-NC
central die holder, incl. fitting bolts for exact
positioning of the retaining plate Diameter 94 mm

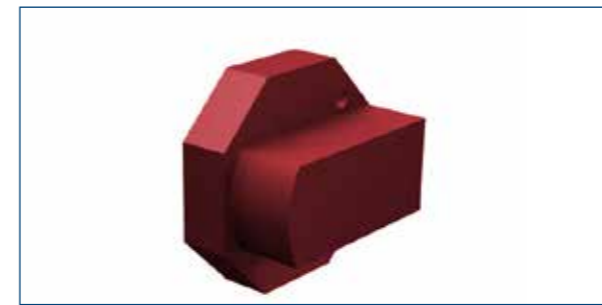
*without retaining plate



208-03-0028.5
Retaining plate "flat"

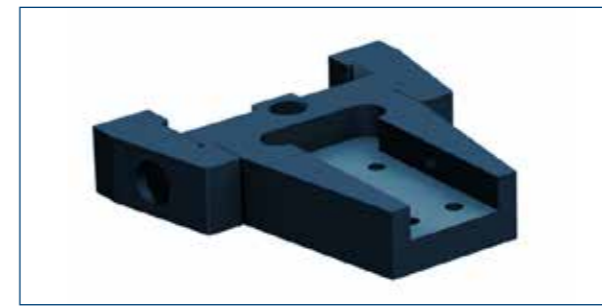
for LEANTOOL tool concept, incl. locating holes for
exact positioning on central die unit

(to accommodate the ejector elements)



208-03-0029.5
Retaining plate "stepped"

for LEANTOOL tool concept, incl. locating holes for exact
positioning on central die unit (to accommodate ejector
elements and bending cores)



208-54-0061.1
Punch holder

for LEANTOOL tool concept installation on base plate
for punch holder for punch width 30 mm incl. adjustable
stop block

*without base plate



208-54-0066.1
Base plate for punch holder

for LEANTOOL tool concept installation on NCA4 sleeve
accommodates up to 2 punch holders

*without punch holder



608-10-0001.6
Blank punch

Suitable for LEANTOOL punch holder
Length 150 mm
Width: 30 mm
Thickness: 10 mm
Material: 1.2379 hardened (58 HRC)

608-10-0002.6
Blank punch

Suitable for LEANTOOL punch holder
Length 150 mm
Width: 30 mm
Thickness: 20 mm
Material: 1.2379 hardened (58 HRC)

608-10-0003.6
Blank punch

Suitable for LEANTOOL punch holder
Length 150 mm
Width: 30 mm
Thickness: 30 mm
Material: 1.2379 hardened (58 HRC)

608-10-0004.6
Blank punch

Suitable for LEANTOOL punch holder
Length 150 mm
Width: 30 mm
Thickness: 40 mm
Material: 1.2379 hardened (58 HRC)



208-67-0001.0
Separating module

Operation from behind incl. central mandrel headpiece
for operation with 2nd central mandrel

Separating area:
from min. -1.0 mm under machine center
to max. 19 mm above machine center
from min. 125 mm to max. 150.5 mm in front of
perforated plate
from min. 75 mm to max. 190 mm to the right of
machine center

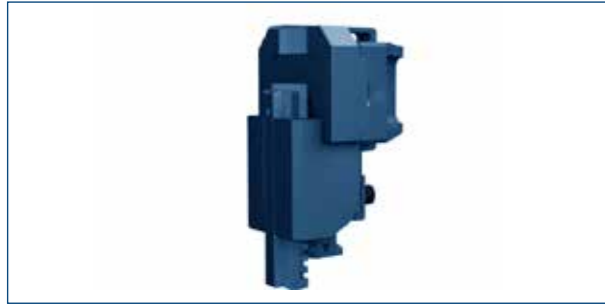
Excluding:
Rear shearing punch 208-67-0031.5
Die insert (knife) 208-67-0010.5
Die insert (die) 208-67-0024.1
Shearing force max. 5 kN
Wire diameter max. 4 mm



208-67-0002.0
Separating module

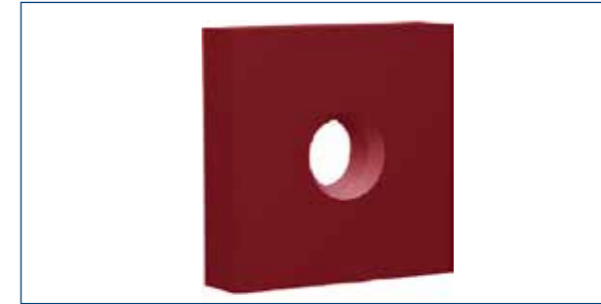
Operation from above
Separating area:
from min. -1.0 mm under machine center
to max. 19 mm above machine center
from min. 125 mm to max. 150.5 mm in front of
perforated plate
from min. 44 mm to max. 185 mm to the right of
machine center

Excluding:
Top shearing punch 208-67-0027.5
Die insert (knife) 208-67-0013.5
Die insert (die) 208-67-0025.1
Shearing force max. 5 kN
Shearing stroke max. 4 mm
Wire diameter max. 4 mm
Strip width max. 25 mm
Strip thickness max. 2 mm



208-67-0020.0
Separating module

Operation from below
Separating area:
from min. -1.0 mm under machine center to max. 19 mm
above machine center from min. 125 mm to max. 150.5 mm
in front of perforated plate
from min. 44 mm to max. 185 mm to the right of
machine center
Excluding:
Bottom shearing punch 208-67-0029.5
Die insert (knife) 208-67-0013.5
Die insert (die) 208-67-0025.1
Shearing force max. 5 kN
Shearing stroke max. 4 mm
Wire diameter max. 4 mm
Strip width max. 25 mm
Strip thickness max. 2 mm



208-67-0013.5
Die insert (knife)

Blank for shearing punch from above/below
Material: 1.2379 hardened (58 HRC)



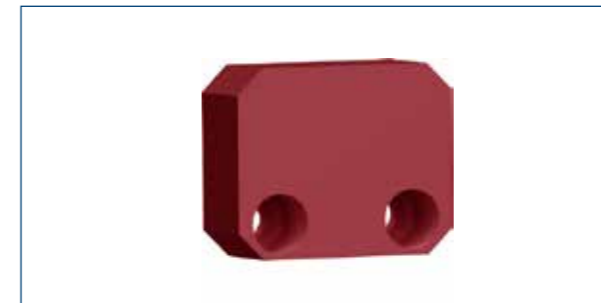
208-01-0139.1
Tool clamping plate

for LEANTOOL tool carrier
incl. clamping pins for zero point clamping system
(for adaptation to existing radial tools on tool plate carrier,
diameter 120 mm, height 68 mm)



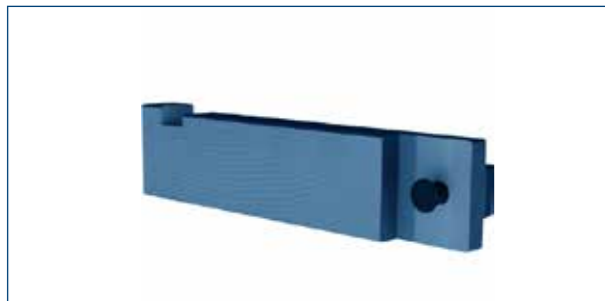
208-67-0029.5
Bottom shearing punch

for separating module,
operation from below
Material: 1.2379+-1HRc (X155CrVMo12)



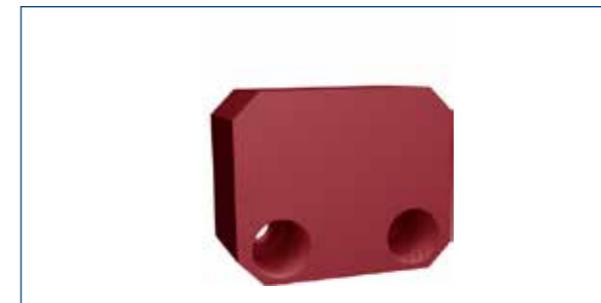
208-67-0024.1
Die insert (die)

Blank for separating module,
operation from behind
Material: 1.2379+-1HRc (X155CrVMo12)
incl. packing plate set



208-67-0031.5
Rear shearing punch

for separating module,
Operation from behind
Material: 1.2379+-1HRc (X155CrVMo12)



208-67-0025.1
Die insert (die)

Blank for separating module,
operation from above/below
Material: 1.2379+-1HRc (X155CrVMo12)
incl. packing plate set



208-67-0027.5
Top shearing punch

for separating module,
operation from behind
Material: 1.2379+-1HRc (X155CrVMo12)



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