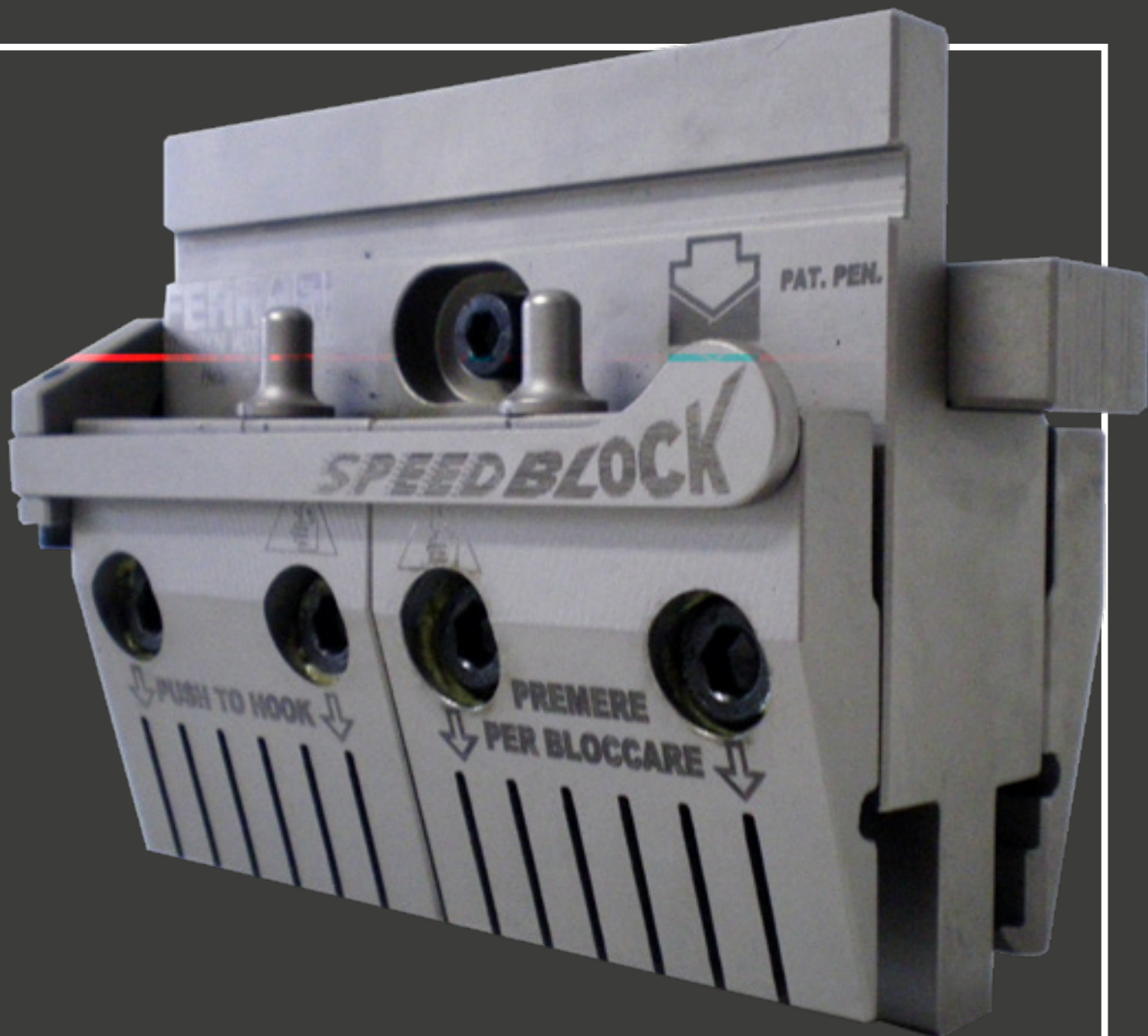




FERRARI



ATTREZZATURE/OTHERS

Press Brake Tools



ITA-ENG

FERRARI COSTRUZIONI MECCANICHE

Utensili e stampi per presse piegatrici

Azienda

Ferrari Costruzioni Meccaniche nasce nel 1979 a Basilicanova (PR). Da quarant'anni a fianco dei maggiori produttori di presse piegatrici, l'Azienda si distingue per ***l'efficace sinergia creatasi fra tradizione e innovazione***: investimenti tecnologici, progettazione tecnica, scelta dei materiali, controlli su ogni singolo pezzo sono aspetti fondamentali per garantire qualità delle realizzazioni e serietà del servizio offerto. Attenzione alle esigenze di ciascun cliente – anche dopo la vendita – e progettazione tecnica finalizzata alla ricerca delle migliori performance: ***i nostri punti di forza***. Seguire da vicino le evoluzioni del mercato – nazionale e internazionale – interpretandone efficacemente sviluppi ed esigenze: ***un obiettivo che da sempre perseguiamo***.

Servizi

- Utensili e Stampi Standard
- Utensili e Stampi Speciali
- Tavole di Compensazione
- Lame da Cesovia
- Guide di Scorrimento
- Linee di Piegatura
- Fornitura Accessori

Servizi su richiesta

- Rigeneratura Utensili Usurati
- Rigeneratura Lame da Cesovia Usurate
- Lavorazioni Meccaniche: Fresatura
Tempra a Induzione – Rettifica

Valore aggiunto

- Utensili e stampi costruiti con acciai certificati C45 e 42CrMo4 o secondo progetto
- ***Marchio High Quality Control*** – controlli e completa tracciabilità del prodotto
- Progettazione e lavorazione utensili di grandi dimensioni – fino a 8100 mm in un solo pezzo
- Tempra a induzione e a cuore – grande profondità di indurimento
- Rettificatrici speciali e a controllo numerico
- Utensili perfettamente intercambiabili ($\pm 0,01\text{mm}$)



FERRARI COSTRUZIONI MECCANICHE

Tools and dies for press brakes

Company

Ferrari Costruzioni Meccaniche was established in 1979 in Basilicanova (PR). 40 years alongside the major press brakes manufacturers have allowed **the company to develop a knowing synergy comprising craftsman's tradition and experience-based innovation**: investments in technology, technical design, choice of materials, tests and inspections performed on each individual item are essential elements to ensure product quality and timeliness of service. Our added value is given by the attention we pay to the needs of each customer – throughout the whole process – and by the technical design aimed at finding the best solutions and performances. Our main goal is to follow national and international market developments so as to understand customer needs better.

Services

- Standard tools and dies
- Special tools and dies
- Compensation tables
- Shear blades
- Slide ways
- Bending lines
- Supply of accessories

Services request

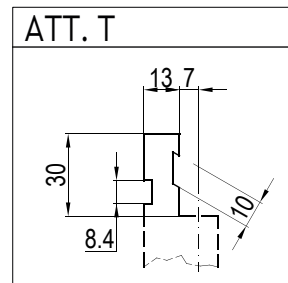
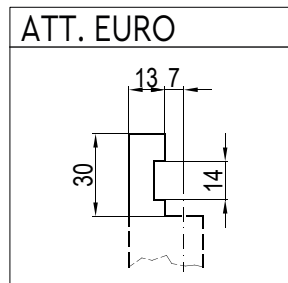
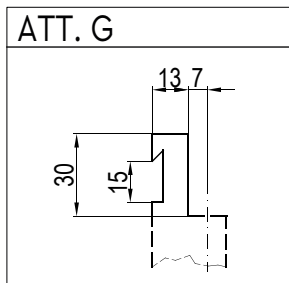
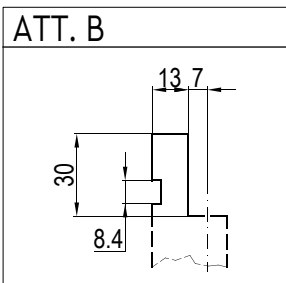
- Worn tool repair service
- Re-sharpening of worn shear blades
- Mechanical machining: milling – induction hardening – grinding

Added value

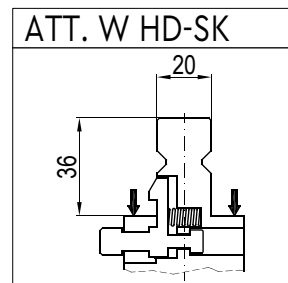
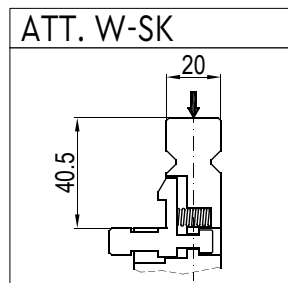
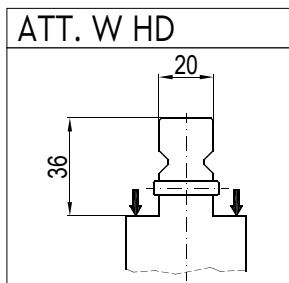
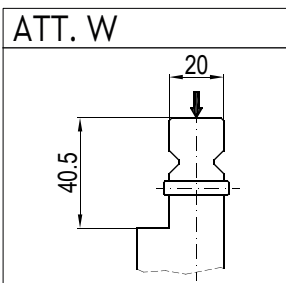
- Tools and dies are made of certified C45 and 42CrMo4 steels or according to design
- All our tools bear the High Quality Control mark and are completely traceable
- We design and process large tools of up to 8 meters
- Induction and core hardening – considerable depth of hardening
- Special and numerical control grinding machines
- Tools are perfectly interchangeable ($\pm 0,01$ mm accuracy)



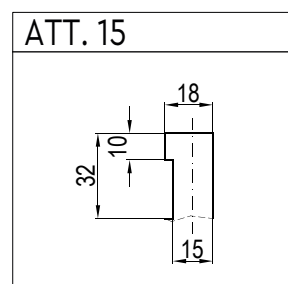
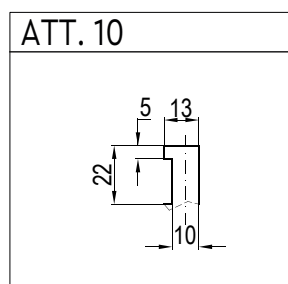
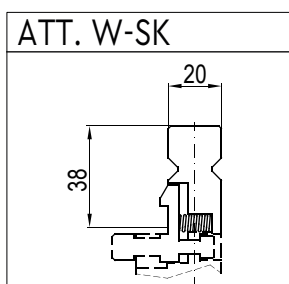
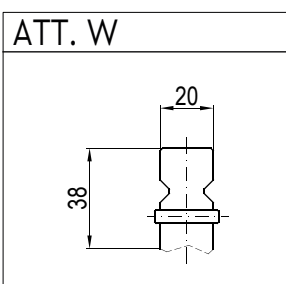
Att Type A



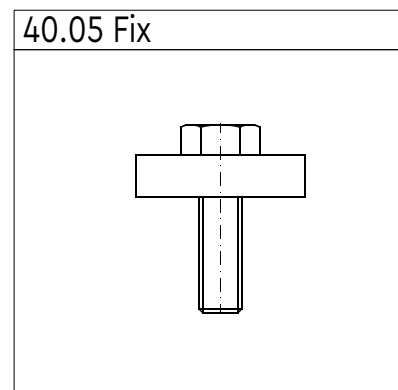
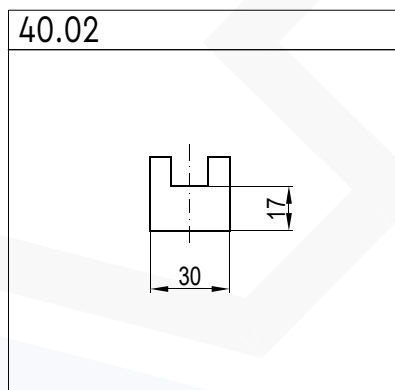
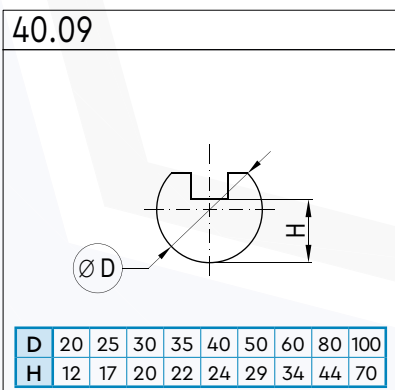
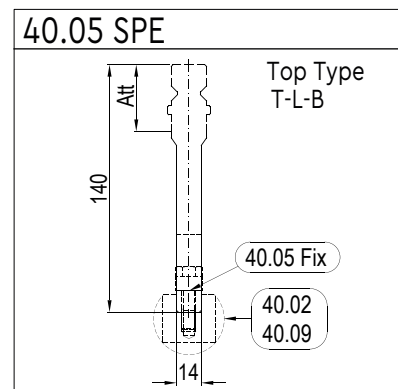
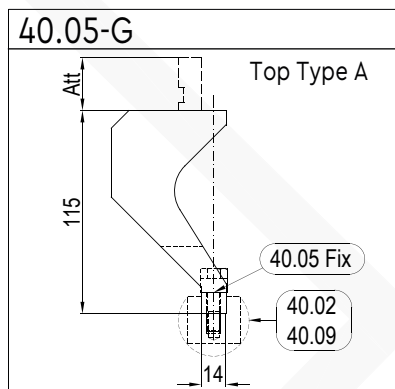
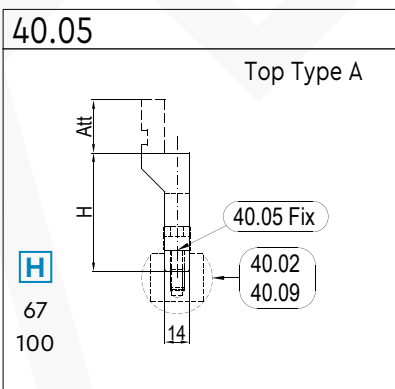
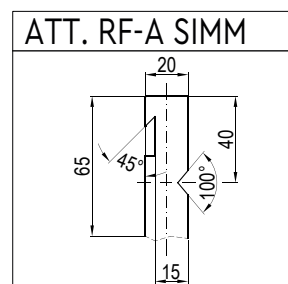
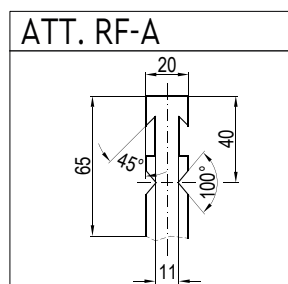
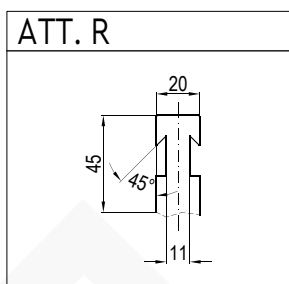
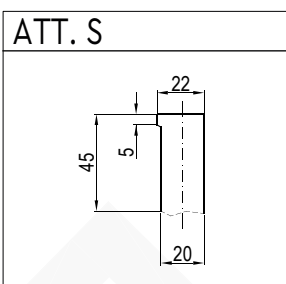
Att Type T



Att Type L

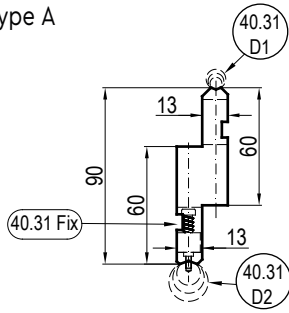


Att Type B

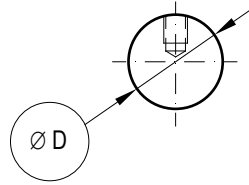


40.30

Top Type A



40.31



ØD1	6	8	10
ØD2	12	16	20

40.31 Fix

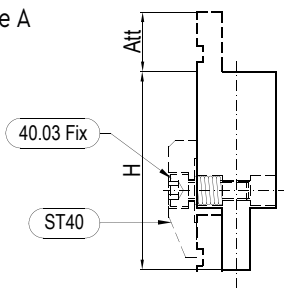


40.03

Top Type A

H

60
100
150



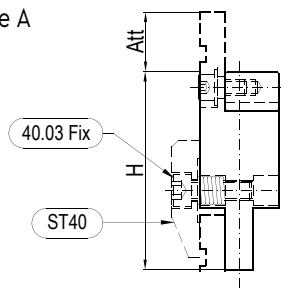
Down Type AM

40.03-C (with adj. wedge)

Top Type A

H

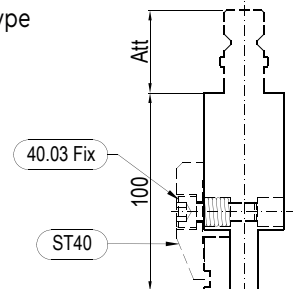
60
100
150



Down Type AM

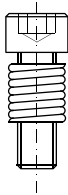
40.20-T-L-B

Top Type
T-L-B

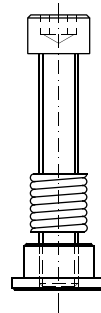


Down Type A

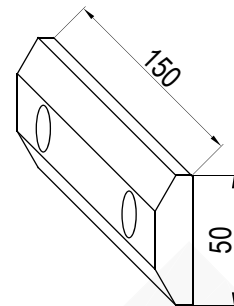
40.03 Fix (x2)



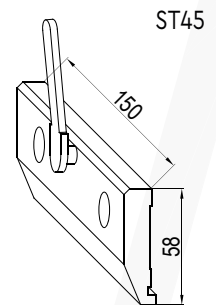
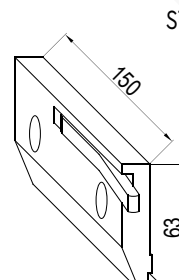
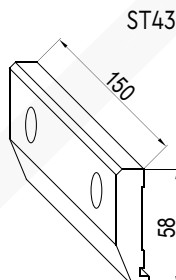
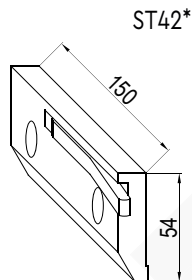
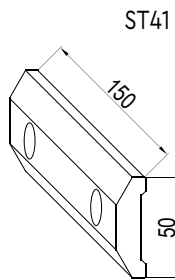
40.03 Fix DS (x2)



ST55



ST40



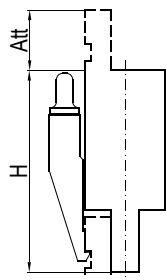
*: ST42-D & ST44-D Flat lever version

40.40-S SPEEDBLOCK®

Top Type A

H

100
120
150



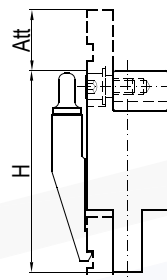
Down Type A (B)

40.40-C SPEEDBLOCK®

Top Type A

H

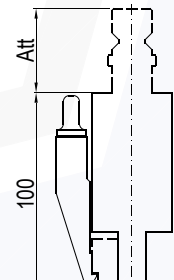
100
120
150



Down Type A (B)

40.40-T-L-B SPEEDBLOCK®

Top Type
T-L-B



Down Type A (B)

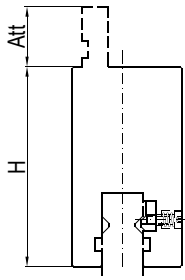
SPE-EXT AW

Top Type A

H

67
100

Down Type
T-L (W)



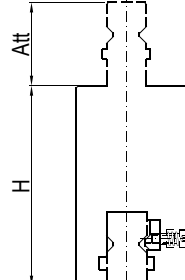
SPE-EXT TW/LW/BW

Top Type
T-L-B

H

100
150

Down Type
T-L (W)



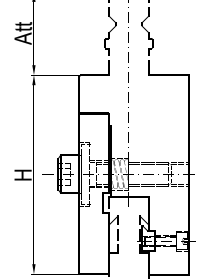
SPE-EXT TB/LB/BB

Top Type
T-L-B

H

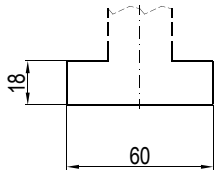
100
120

Down Type B
(R-RF-A)

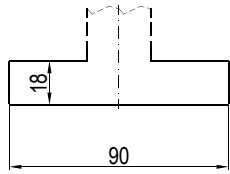


Base Type A

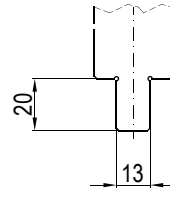
Base B60



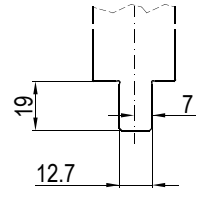
Base B90



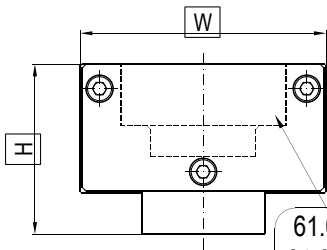
Base Type W-T-B



Base Type L



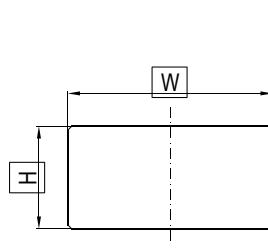
60.0



Down Type A

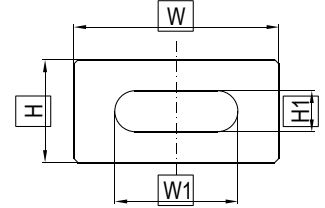
H	60	100	83	108	100	100	110	65
W	60	100	120	150	125	155	215	239

61.0



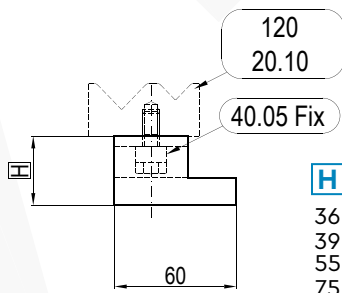
H	25	50	30	45	50	50	70	100
W	25	50	80	110	75	100	150	200

61.0F



H	25	50	30	45	50	50	70	100
W	25	50	80	110	75	100	150	200
H1			15	20	20	20	35	45
W1	∅10	∅25	40	60	45	60	90	135

40.00

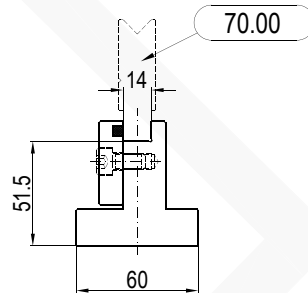


Down Type A

H

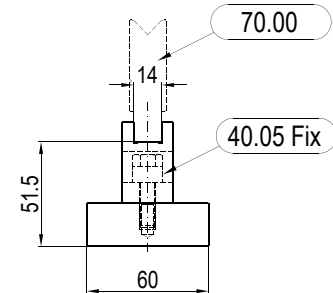
36
39
55
75

40.13



Down Type A

40.14

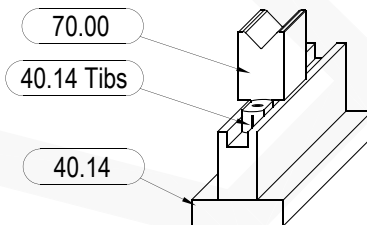


Down Type A

40.14 Tibs

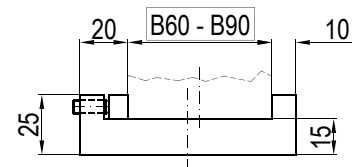


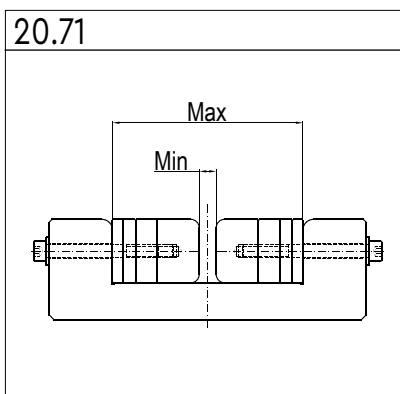
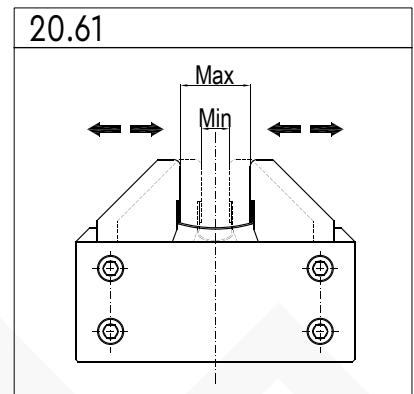
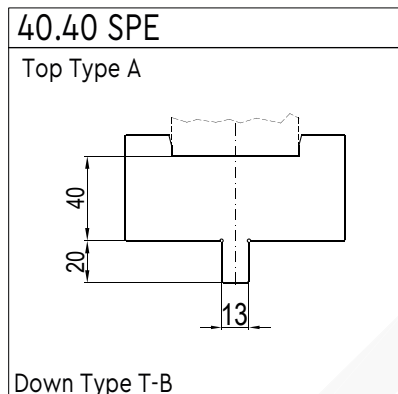
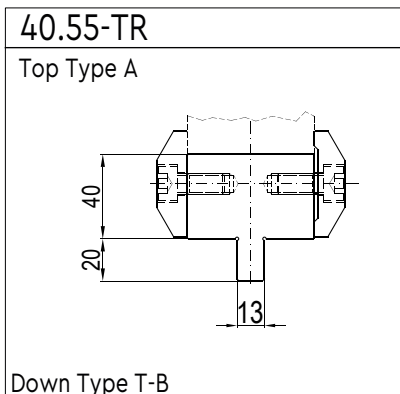
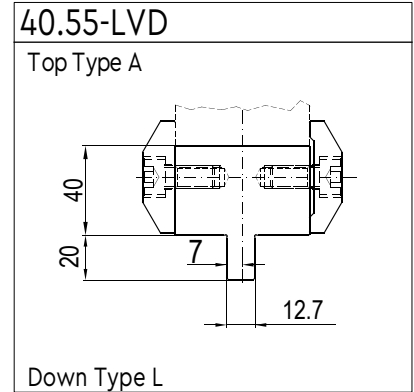
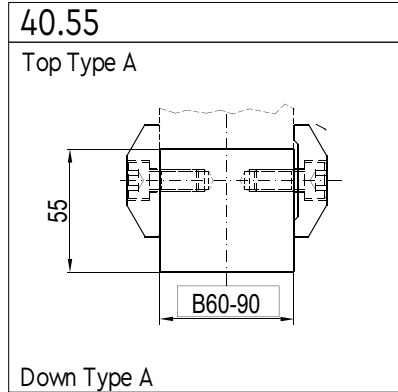
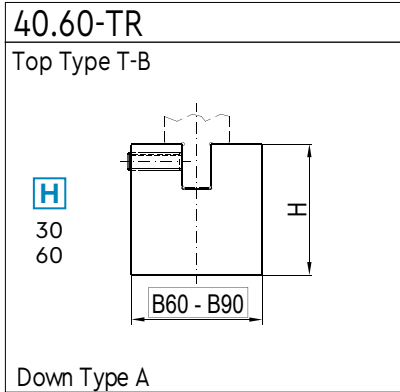
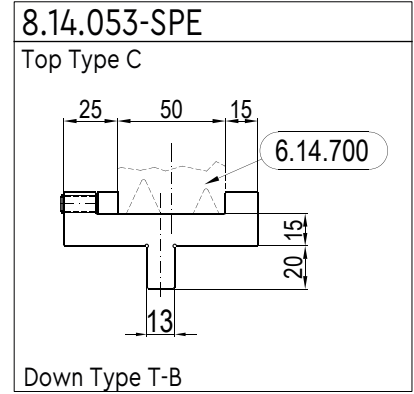
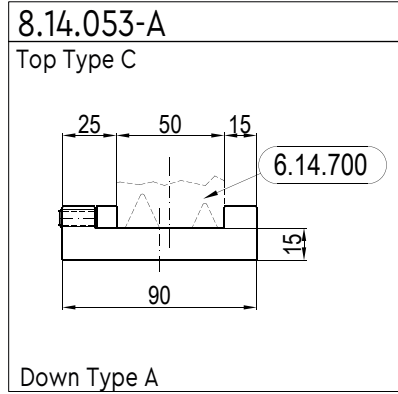
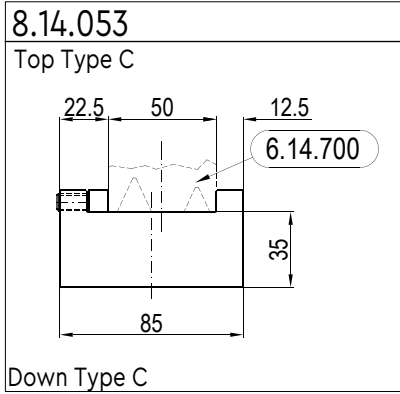
Install. Exam.



40.60

Top Type A





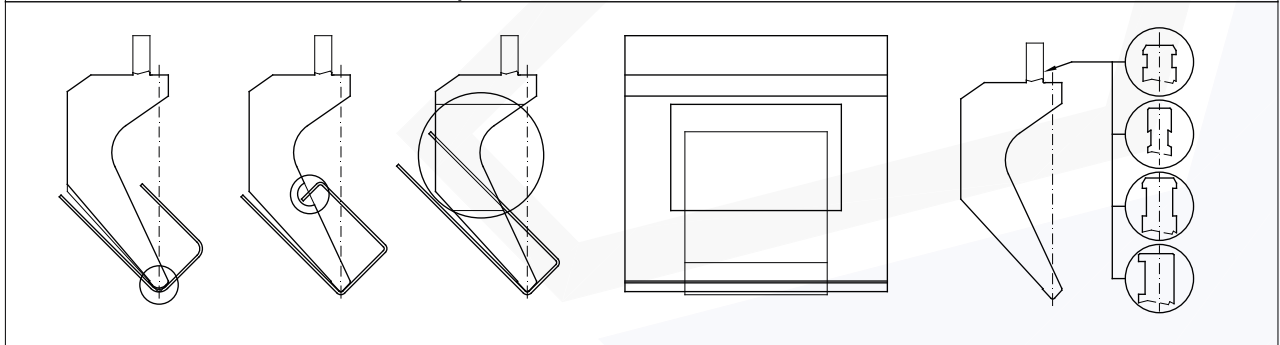
Subfornitura/Subcontracting

Guide e incontri a disegno LMax 8000mm
Guides and strikers on drawing LMax 8000mm

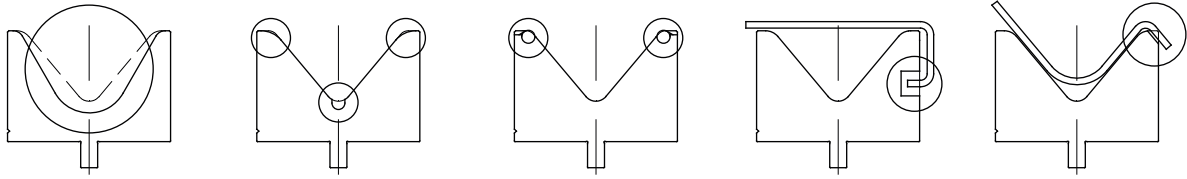
Lame pieghevoli LMax 8000mm
LMax 8000mm folding blades

Personalizzazioni/Customizations

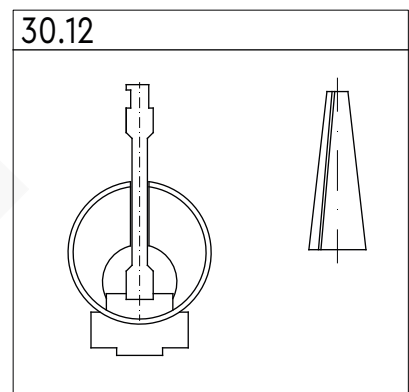
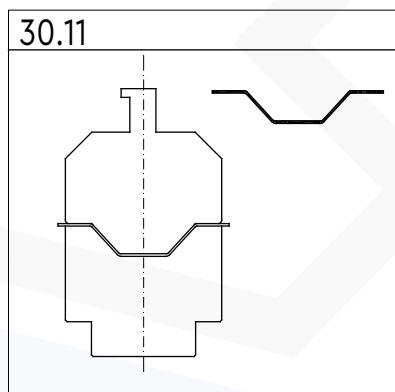
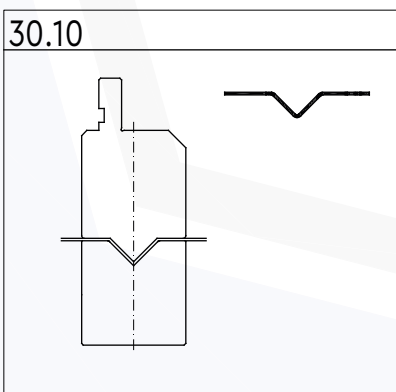
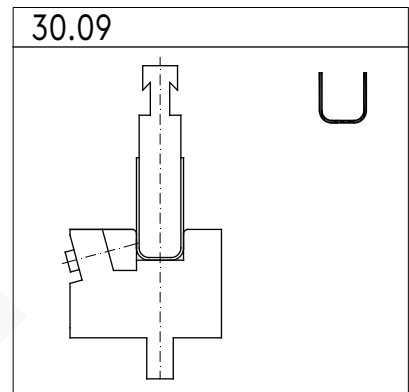
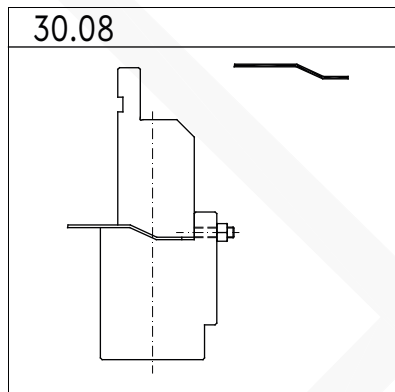
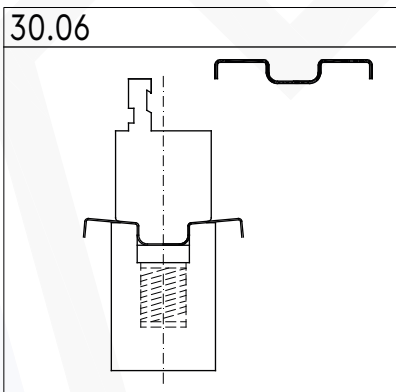
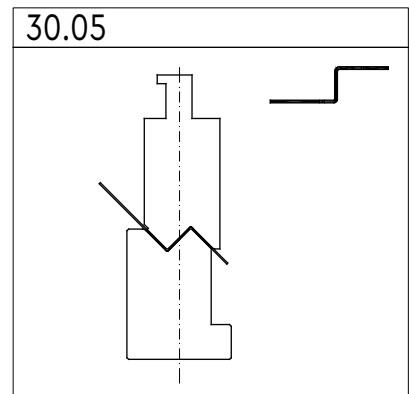
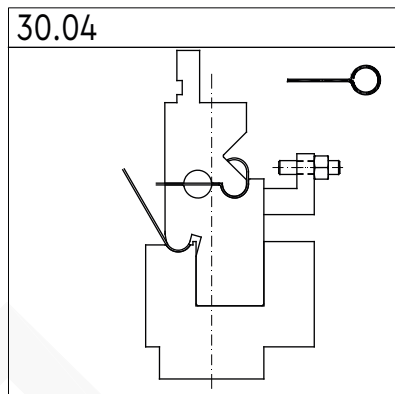
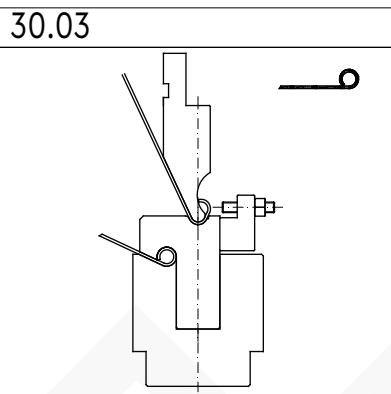
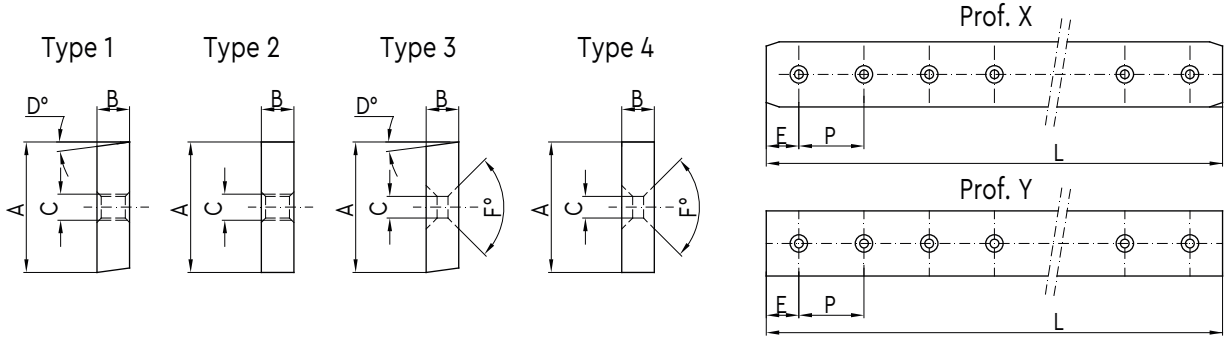
PERSONALIZZAZIONI PUNZONI/PUNCH CUSTOMIZATIONS



PERSONALIZZAZIONI MATRICI/CUSTOMIZATION OF MATRICES

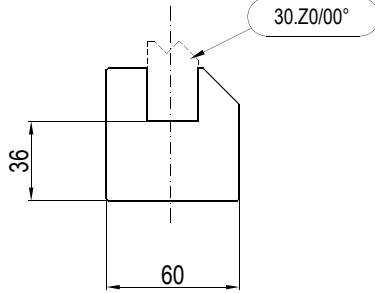
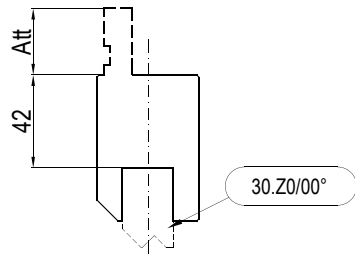


LAME DA CESCOIA/SHEARS BLADES



40.ZP + 40.ZD

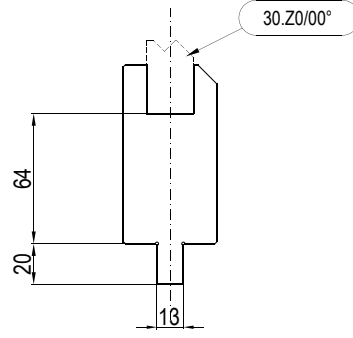
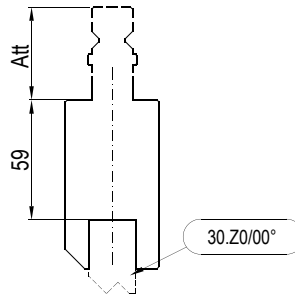
Top Type A



Down Type A

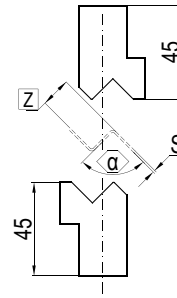
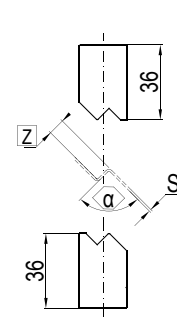
40.ZPW + 40.ZDW

Top Type T



Down Type T

30.Z0/00°



Z	α	S
1	90°	0.5
1	160°	0.5
1.5	90°	0.6
1.5	160°	0.6
2	90°	0.8
2	150°	0.8
2.5	90°	1
2.5	140°	1
3	90°	1
3.5	90°	1.2
4	90°	1.2
4.5	90°	1.5
5	90°	1.5
5.5	90°	1.5
6	90°	1.5
6.5	90°	1.5
7	90°	2
7.5	90°	2
8	90°	2.5

Z	α	S
9	90°	2.5
10	90°	3
11	90°	3
12	90°	3
13	90°	3
14	90°	3
15	90°	3



PORTAUTENSILI/TOOLCABINET



TEFLON/POLYURETHANE FILM



KIT TENDITORI/COUPLE OF TIGHTENERS



SUPPORTO BASE/BASE SUPPORT ARM



ARRESTO MICROTERMICO
STOP SYSTEM WITH
MICROMETRIC ADJUSTMENT



ARRESTO SEMPLICE
SIMPLE STOP SYSTEM



SQUADRA DI RIFERIMENTO GONIOMETRICA
SQUARING ARM WITH GONIOMETRIC



SQUADRA DI RIFERIMENTO FISSA
SQUARING ARM

DAL MATERIALE GREZZO AL PRODOTTO FINITO / FROM RAW MATERIAL TO FINISHED PRODUCT

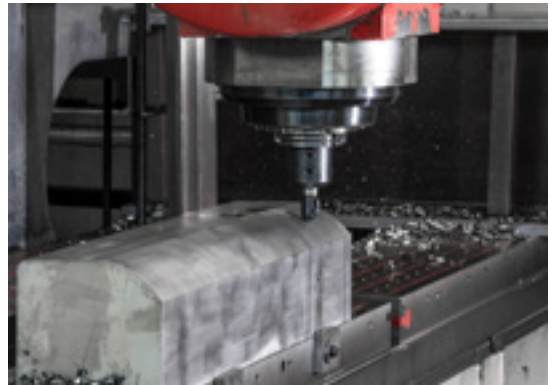
La Ferrari costruzioni Meccaniche ha una superficie produttiva di 5.000 m². Tutti i **materiali** acquistati provengono da una attenta selezione dei fornitori che ci garantisce la **qualità certificata con marchio CE**. La materia prima viene acquistata in lunghezze commerciali o tagliata a misura e il nostro ciclo di lavoro ci permette di eseguire tutte le lavorazioni al nostro interno così da ridurre i tempi di consegna. La nostra potenzialità produttiva è suddivisa su 4 reparti:

- **Reparto Fresatura**, dove vi sono 4 fresatrici tradizionali e 3 CNC in grado di lavorare pezzi con peso fino a 10 Ton. e dimensioni massime di 800×800×8.100 mm. Una di queste fresatrici CNC è una macchina a portale con testa a 5 assi in continuo, carico max 50 ton. e capacità dimensionale di 10.000×3000×1500 mm. Questo ci permette di ampliare notevolmente il nostro campo di lavorazioni meccaniche così da operare nella subfornitura di diversi componenti meccanici come travi, guide, piastre e strutture saldate complesse.

- **Reparto Rettifica**, dove abbiamo 10 rettifiche tangenziali per una capacità lavorativa fino a una lunghezza max di 8.100 mm per un'altezza di 800 mm. Siamo in grado di rettificare particolari di precisione con requisiti di alta qualità e tolleranze di ±0,01 mm e rugosità superficiale Ra 0,4μ. La gamma di lavorazioni di rettifica tangenziale include anche la rigeneratura di utensili e stampi usurati, lame da cesoia e spianatura e squadratura su componenti di fornitura terzi.

- **Reparto Trattamento termico**, dove abbiamo internamente una tempra a induzione, che ci permette di eseguire trattamenti di indurimento superficiale con profondità di circa 4 mm su particolari di lunghezza fino a 8.100 mm, così da ridurre i tempi di attesa dei clienti. Eseguiamo anche trattamenti c/terzi.

- **Reparto Controllo Qualità**, dove disponiamo di macchina di misura CNC ad assi cartesiani di ultima generazione, testata secondo le norme UNI EN ISO 10360-2 in grado di garantire una metrologia di alta precisione. La macchina è interfacciata con l'ufficio tecnico per la verifica del prodotto durante le singole fasi di lavorazione e per la stesura del certificato finale di controllo.



Ferrari Costruzioni Meccaniche has a production area of 5.000 m². The **materials** purchased come from a careful selection of suppliers which **guarantees us the certified quality with the CE mark**. The raw material is purchased in commercial lengths or cut to size and our work cycle allows us to carry out all the internal workings in order to reduce delivery times. Our production potential is divided into 4 departments:

- **Milling department**, where there are 4 traditional and 3 CNC milling machines capable of processing pieces weighing up to 10 tons. and maximum dimensions of 800×800×8100 mm. One of these CNC milling machines is a portal machine with a 5-axis continuous head, max load 50 tons. and dimensional capacity of 10000×3000×1500 mm. This allows us to significantly expand our field of mechanical processing so as to operate in the sub-supply of various mechanical components such as beams, guides, plates and complex welded structures.

- **Grinding department**, where we have 10 tangential adjustments for a working capacity up to a maximum length of 8100 mm for a height of 800 mm. We are able to grind precision parts with high quality requirements and tolerances of ± 0.01 mm and surface roughness Ra 0.4μ. The range of tangential grinding processes also includes the regeneration of worn tools and molds, shear blades and flattening and squaring on third-party components.

- **Heat Treatment Department**, where we have an induction hardening internally, which allows us to perform surface hardening treatments with a depth of about 4 mm on parts up to 8100 mm long, so as to reduce customer waiting times. We also perform third party treatments.

- **Quality Control Department**, where we have the latest generation of Cartesian axis CNC measuring machine, tested according to UNI EN ISO 10360-2 standards able to guarantee high precision metrology. The machine is interfaced with the technical office to verify the product during the individual processing phases and to draw up the final control certificate.

Legenda:

- F → Forza di piegatura/Bending force [kN/m]
- S → Spessore lamiera/Material thickness [mm]
- V → Apertura matrice/Die opening [mm]
- Ri → Raggio interno piega/Inside radius [mm]
- B → Bordo minimo lamiera/Shortest flange [mm]
- α → Angolo di piega/Bending angle [°]

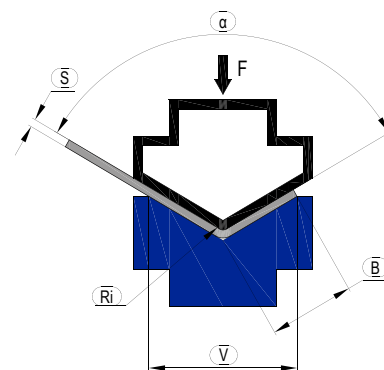


Tabella Forza di piegatura/ Table of bending force - F [kN/m]

Forza Minima necessaria per piega in aria, Angolo 90° (α), Lunghezza di piega 1000 [mm]
e Materiale Acciaio S235 (Resistenza Rm = 430 [N/mm²])

Needed force for 90° air bending sheet with 1000 mm and steel S235 (Resistance Rm=430 N/mm²)

V [mm]	Ri [mm]	B [mm]	S [mm]																						
			0,5	0,8	1	1,2	1,5	2	2,5	3	4	5	6	8	10	12	15	20	25	30					
4	0,7	2,6	40	124																					
6	1	3,9	24	70	119	186																			
8	1,5	5,2	17	48	81	124	212																		
10	1,7	6,5		36	60	92	155	310																	
12	2	7,8			48	72	121	239	411																
16	2,7	10,4				50	83	161	273	423															
20	3,4	13					63	120	202	310	619														
24	4	15,6						96	159	242	478	821													
30	5	19,5							119	181	352	597	929												
35	6	22,75								148	286	483	746												
40	7	26								126	241	403	619	1238											
50	8,5	32,5									182	301	458	903	1548										
55	9	35,75										267	404	791	1350										
60	10	39											239	361	703	1194									
70	12	45,5												297	573	965	1491								
80	13,5	52													252	482	806	1238	2116						
90	15	58,5														414	690	1055	1792						
100	17	65															363	602	916	1548					
120	20	78																478	722	1209					
140	24	91																	594	987	1931				
160	25	104																		831	1613	2729			
200	31	130																			629	1204	2016		
250	39	162,5																				908	1505	2291	
300	47	195																					726	1194	1806

Condizione Ottimale
Ideal condition

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