

POINÇON EN TROMPETTE - FORME D

2284.3



MATIERE ET EXECUTION :

Acier HSS

Dureté tige : 56 – 60 HRC

Dureté tête : 45-50 HRC

La tête après estampage à, chaud est finement rectifiée

Le réfolement de matière sous la tête est ainsi éliminé et on obtient une concentricité parfaite entre la tige et la tête.

Cette précision assure ainsi une parfaite interchangeabilité des poinçons.

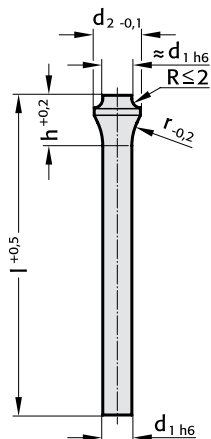
Fraise pour poinçon en trompette : Ref 2284.00...

REMARQUE :

Ces poinçons sont utilisés à la place de ceux à tête cylindrique ou à tête fraisée lorsque leurs têtes s'arrachent lors d'efforts trop importants.

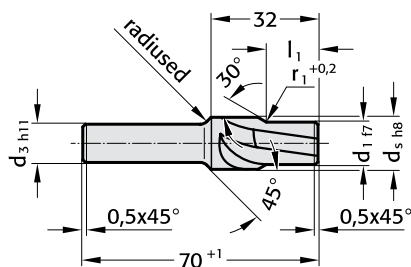
Les poinçons en trompette possèdent un grand rayon de transition qui compense la force exigée.

Leur utilisation est nécessaire en cas de grande force retour, d'épaisseur de tôles importante, du poinçonnage d'alliages durs et des INOX.



POUR LA COMMANDE :

2284.3, d1 = 20, l = 100 = 2284.3.2000.100



POUR LA COMMANDE :

2284.00, d1 = 5,5 = 2284.00.0550

POINÇON EN TROMPETTE - FORME D

2284.3

2284.3.								2284.00.				
d ₁	d ₂	h	r	71	80	l	100	110	d ₅	d ₃	r ₁	l ₁
2.0	3	4.80	3.5	●	●	●	●		3.3	3.3	3.5	5.0
2.1	3.2	5.28	5	●	●	●	●		3.5	3.5	5.0	5.0
2.2	3.2	5.18	5	●	●	●	●		3.5	3.5	5.0	5.0
2.3	3.5	5.37	5	●	●	●	●		3.8	3.8	5.0	5.0
2.4	3.5	5.28	5	●	●	●	●		3.8	3.8	5.0	5.0
2.5	3.5	5.18	5	●	●	●	●		3.8	3.8	5.0	5.0
2.6	4	5.93	6.5	●	●	●	●		4.3	4.3	6.5	7.0
2.7	4	5.83	6.5	●	●	●	●		4.3	4.3	6.5	7.0
2.8	4	5.73	6.5	●	●	●	●		4.3	4.3	6.5	7.0
2.9	4	5.62	6.5	●	●	●	●		4.3	4.3	6.5	7.0
3.0	4.5	6.03	6.5	●	●	●	●		4.9	4.9	6.5	7.0
3.1	4.5	5.93	6.5	●	●	●	●		4.9	4.9	6.5	7.0
3.2	4.5	5.83	6.5	●	●	●	●		4.9	4.9	6.5	7.0
3.3	4.5	5.73	6.5	●	●	●	●		4.9	4.9	6.5	7.0
3.4	4.5	5.62	6.5	●	●	●	●		4.9	4.9	6.5	7.0
3.5	5	6.38	8	●	●	●	●		5.4	5.4	8.0	7.0
3.6	5	6.27	8	●	●	●	●		5.4	5.4	8.0	7.0
3.7	5	6.16	8	●	●	●	●		5.4	5.4	8.0	7.0
3.8	5	6.04	8	●	●	●	●		5.4	5.4	8.0	7.0
4.0	5.5	7.38	8	●	●	●	●		5.9	5.9	8.0	8.0
4.1	5.5	7.27	8	●	●	●	●		5.9	5.9	8.0	8.0
4.2	5.5	7.16	8	●	●	●	●		5.9	5.9	8.0	8.0
4.3	5.5	7.04	8	●	●	●	●		5.9	5.9	8.0	8.0
4.4	5.5	6.92	8	●	●	●	●		5.9	5.9	8.0	8.0
4.5	6	7.38	8	●	●	●	●		6.4	6.4	8.0	8.0
4.6	6	7.27	8	●	●	●	●		6.4	6.4	8.0	8.0
4.7	6	7.16	8	●	●	●	●		6.4	6.4	8.0	8.0
4.8	6	7.04	8	●	●	●	●		6.4	6.4	8.0	8.0
4.9	6	6.92	8	●	●	●	●		6.4	6.4	8.0	8.0
5.0	7	8.36	10	●	●	●	●		7.4	7.4	10.0	10.0
5.1	7	8.25	10	●	●	●	●		7.4	7.4	10.0	10.0
5.2	7	8.15	10	●	●	●	●		7.4	7.4	10.0	10.0
5.5	8	8.84	10	●	●	●	●		8.5	8.5	10.0	10.0
5.6	8	8.75	10	●	●	●	●		8.5	8.5	10.0	10.0
6.0	9	9.27	10	●	●	●	●		9.5	9.5	10.0	10.0
6.1	9	9.19	10	●	●	●	●		9.5	9.5	10.0	10.0
6.2	9	9.10	10	●	●	●	●		9.5	9.5	10.0	10.0
6.3	9	9.02	10	●	●	●	●		9.5	9.5	10.0	10.0
6.4	9	8.93	10	●	●	●	●		9.5	9.5	10.0	10.0
6.5	10	10.24	12	●	●	●	●	●	10.5	10.5	12.0	12.0
7.0	10	9.81	12	●	●	●	●		10.5	10.5	12.0	12.0
7.5	11	10.24	12	●	●	●	●		11.5	11.5	12.0	12.0
7.7	11	10.07	12	●	●	●	●		11.5	11.5	12.0	12.0
8.0	11	9.81	12	●	●	●	●	●	11.5	11.5	12.0	12.0
8.1	11	9.72	12	●	●	●	●		11.5	11.5	12.0	12.0
8.5	13	11.90	15	●	●	●	●		13.5	13.0	15.0	12.0
9.0	13	11.48	15	●	●	●	●	●	13.5	13.0	15.0	12.0
9.5	14	11.90	15	●	●	●	●		14.5	13.0	15.0	12.0
10.0	14	11.48	15	●	●	●	●	●	14.5	13.0	15.0	12.0
10.5	15	11.90	15	●	●	●	●		15.5	13.0	15.0	15.0
11.0	15	11.48	15	●	●	●	●		15.5	13.0	15.0	15.0
11.5	16	11.90	15	●	●	●	●		16.5	13.0	15.0	15.0
12.0	16	11.48	15	●	●	●	●	●	16.5	13.0	15.0	15.0
12.5	17	11.90	15	●	●	●	●		17.5	13.0	15.0	15.0
13.0	17	11.48	15	●	●	●	●	●	17.5	13.0	15.0	15.0
13.5	18	11.90	15	●	●	●	●		18.5	13.0	15.0	15.0
14.0	18	11.48	15	●	●	●	●	●	18.5	13.0	15.0	15.0
14.5	19	11.90	15	●	●	●	●		19.5	13.0	15.0	15.0
15.0	19	11.48	15	●	●	●	●	●	19.5	13.0	15.0	15.0
15.5	20	11.90	15	●	●	●	●		20.5	13.0	15.0	15.0
16.0	20	11.48	15	●	●	●	●	●	20.5	13.0	15.0	15.0
17.0	21	11.48	15	●	●	●	●	●	21.5	16.0	15.0	15.0
18.0	22	11.48	15	●	●	●	●	●	22.5	16.0	15.0	15.0
19.0	23	11.48	15	●	●	●	●		23.5	16.0	15.0	15.0
19.5	25	12.66	15	●	●	●	●		25.5	16.0	15.0	15.0
20.0	25	12.29	15	●	●	●	●		25.5	16.0	15.0	15.0