



# PIASTRE E PORTASTAMPI

ELEMENTI NORMALIZZATI



## IL PORTASTAMPO PER STAMPAGGIO AD INIEZIONE DI MATERIE PLASTICHE

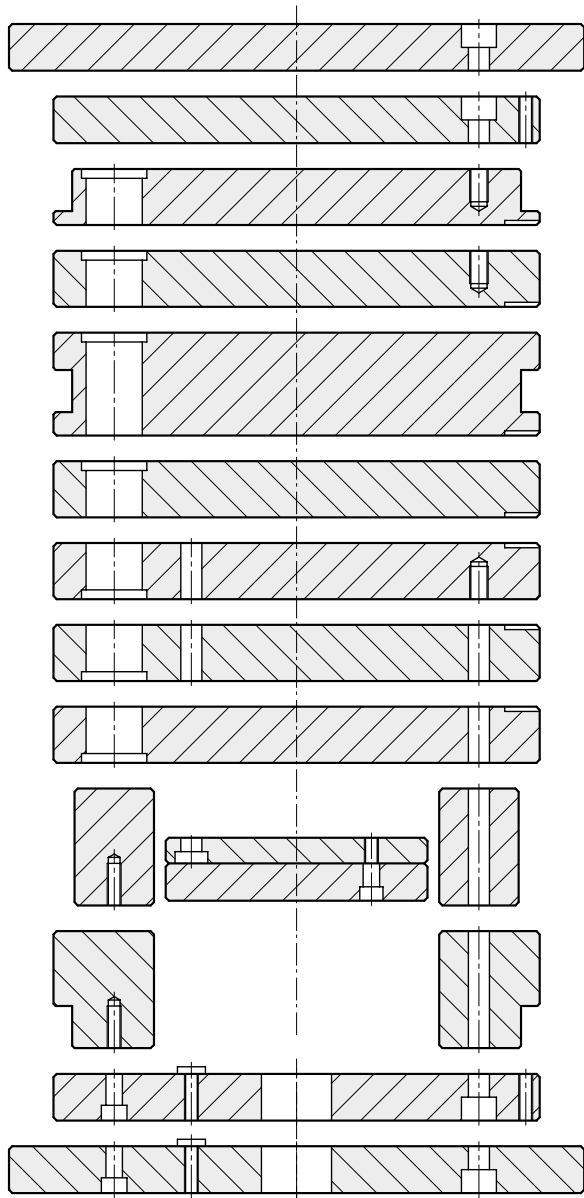
È l'attrezzatura nella quale viene collocato lo stampo per la produzione di oggetti in materiale plastico e metallico.

Nella sua forma più semplice è costituito da:

- un piano fisso, cui si ancora un semistampo (normalmente il semistampo femmina)
- un piano mobile, cui si fissa l'altro semistampo
- un sistema di supporto e guida del piano mobile (generalmente 4 colonne a sezione cilindrica)

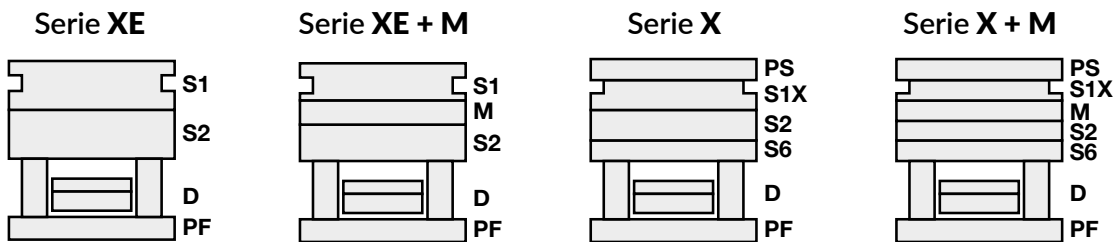


### ELEMENTI PER PORTASTAMPI NORMALIZZATO



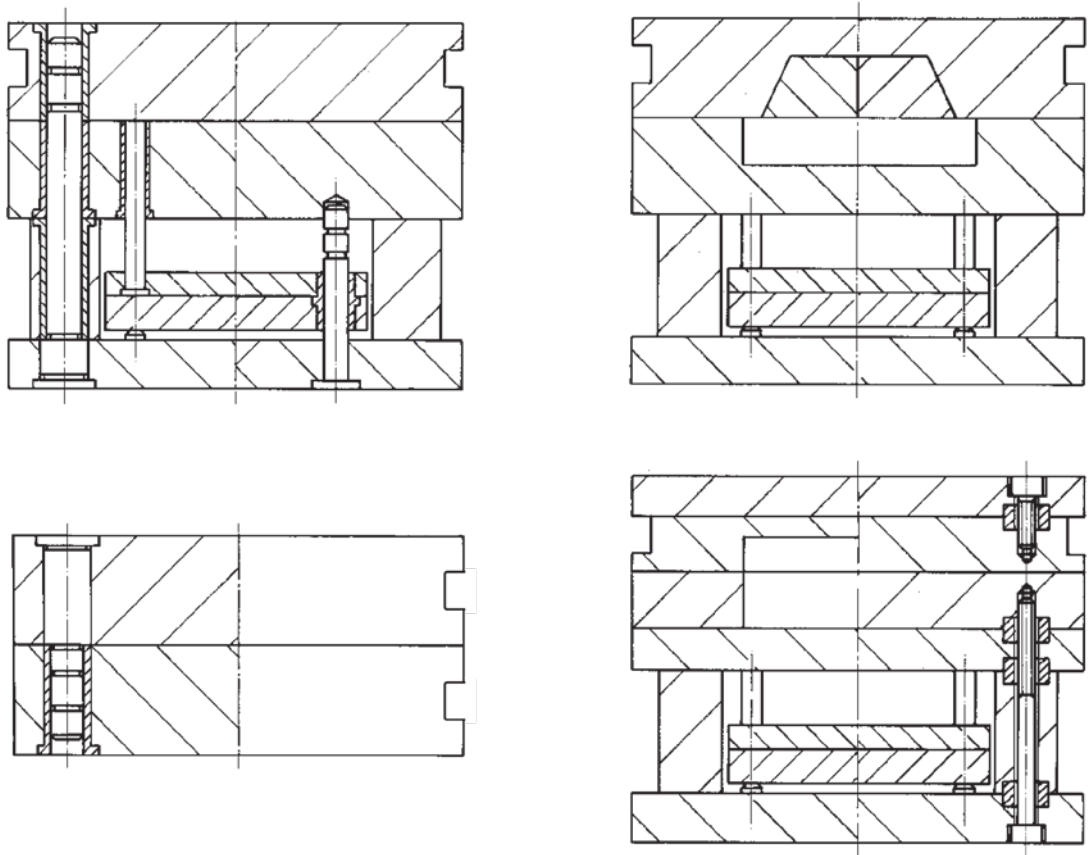
<b>PSD</b>	pietra superiore staffaggio debordante
<b>PS</b>	pietra superiore staffaggio
<b>SX1</b>	pietra iniezione
<b>S3</b>	pietra intermedia lato iniezione
<b>S1</b>	pietra iniezione
<b>M</b>	pietra mobile
<b>S2</b>	pietra intermedia lato mobile
<b>S6</b>	pietra intermedia lato estrazione
<b>S4</b>	pietra intermedia lato estrazione
<b>D</b>	distanziale
<b>T1</b>	tavolino estrazione superiore
<b>T2</b>	tavolino estrazione inferiore
<b>DX</b>	distanziale
<b>PF</b>	pietra fondo staffaggio
<b>PFD</b>	pietra fondo staffaggio debordante

PORTASTAMPI STANDARD



156	196	246	296	346	396	446	490	540	590
156	196	246	296	346	396	446	496	546	596
196	246	296	346	396	446	496	546	596	646
246	296	346	396	446	496	546	596	646	696
	346	396	446	496	546	596	646	696	746
							696	746	796
							796		

PORTASTAMPI IN ESECUZIONE SPECIALE A DISEGNO



**TIPI DI ACCIAIO**

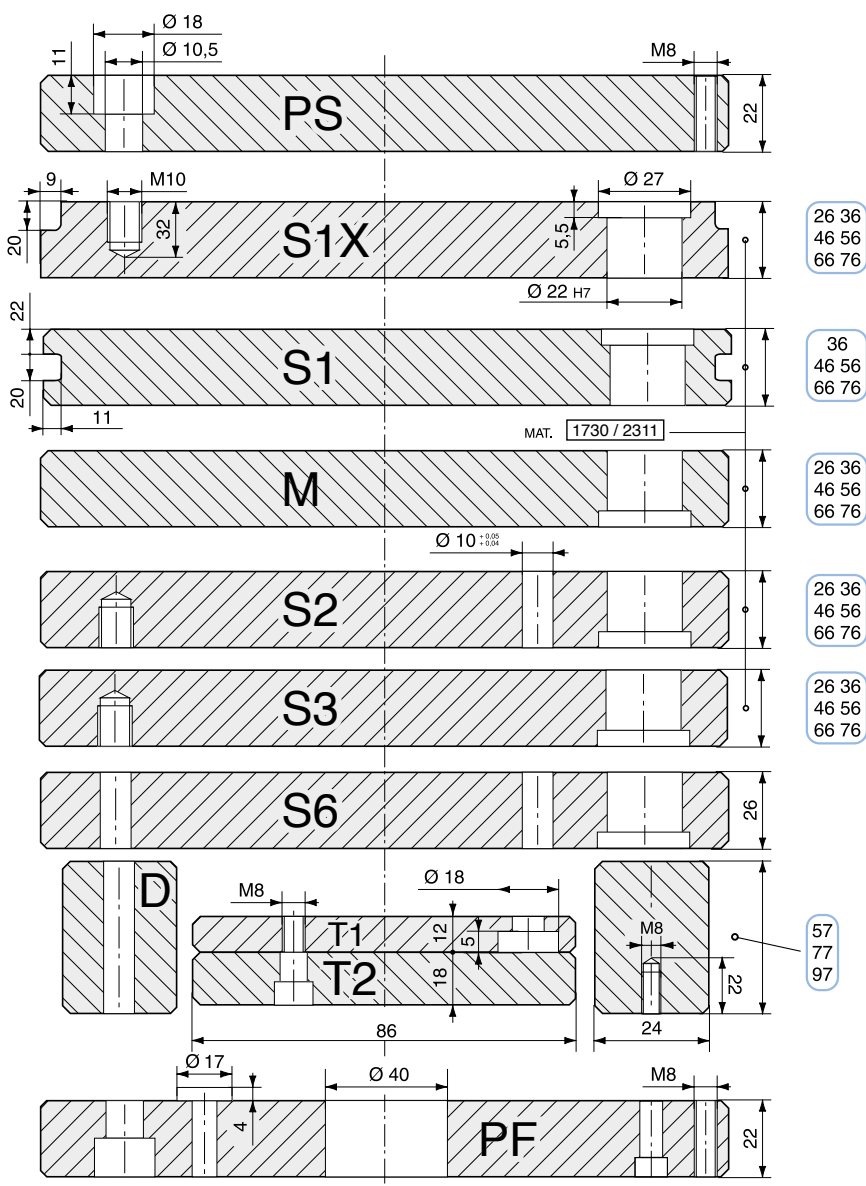
ACCIAI A MAGAZZINO					
CODICE	COMPOSIZIONE CHIMICA	DUREZZA HB	RESISTENZA kg/mm <sup>2</sup>	STATO DI FORNITURA	UTILIZZO
1.1730	C 0,45 Si 0,40 Mn 0,70 Mo 0,10 Ni 0,40	175 - 210	60 - 75	Disteso	Piastre portastampi mediamente sollecitati Castelli di estrazione
1.2311	C 0,40 Si 0,30 Mn 1,50 Cr 1,90 Mo 0,20	280 - 325	95 - 110	Bonificato 30-34 HRC	Piastre portastampi con figure dal pieno Matric
ACCIAI A RICHIESTA					
CODICE	COMPOSIZIONE CHIMICA	DUREZZA HB	RESISTENZA kg/mm <sup>2</sup>	STATO DI FORNITURA	UTILIZZO
1.2312	C 0,40 Si 0,30 Mn 1,50 Cr 1,90 Mo 0,20 S 0,05	280 - 325	95 - 110	Bonificato 30-34 HRC	Piastre portastampi fortemente sollecitati e con figure riportate
1.2738	C 0,40 Si 0,30 Mn 1,50 Cr 1,90 Mo 0,20 Ni 1,00	280 - 325	95 - 110	Bonificato 30-34 HRC	Piastre portastampi con figure dal pieno Matrici
1.2738 HH	C 0,40 Si 0,10 Mn 1,45 Cr 1,25 Mo 0,60 Ni 1,05 V 0,12	310 - 355	110 - 120	Bonificato 34-38 HRC	Piastre portastampi fortemente sollecitati e con figure dal pieno - Matrici
1.2714	C 0,55 Si 0,30 Mn 0,70 Cr 1,10 Mo 0,50 Ni 1,70 V 0,10	350 - 410	120 - 140	Bonificato 38-43 HRC	Piastre portastampi fortemente sollecitati e con figure dal pieno - Matrici
1.2085	C 0,33 Si 0,50 Mn 1,00 Cr 16,00 Ni 0,70 S 0,10	280 - 325	95 - 110	Bonificato Inossidabile 30-34 HRC	Piastre portastampi fortemente sollecitati e con figure riportate
1.2343	C 0,40 Si 0,30 Mn 1,50 Cr 1,90 Mo 0,20 Ni 1,00	200 - 230	95 - 110	Ricotto	Piastre portastampi o Matrici da Temprare

**TOLLERANZE DI LAVORAZIONE**
**Incolonnamento:** Fori H7, Interasse 0,005 su 100 mm | **Piani rettificati:** Planarità 0,005 su 100 mm

**Spessore:** 0/+0,03 mm fino alla serie 346 x 496 | **Lati rettificati:** +/- 0,05 mm

**Dalla serie 396 in su riferimento centrato:** - 0,5 mm +/- 0,02 mm | **Lati fresati:** dimensione +/- 0,2 mmw

SERIE 156 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati



26 36  
46 56  
66 76

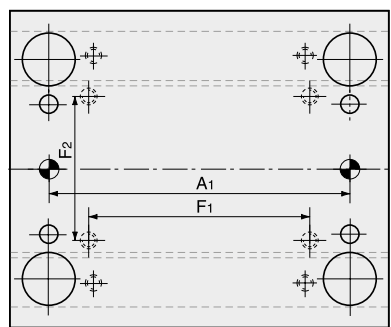
36  
46 56  
66 76

26 36  
46 56  
66 76

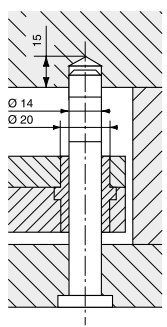
26 36  
46 56  
66 76

26 36  
46 56  
66 76

57  
77  
97



TIPO A

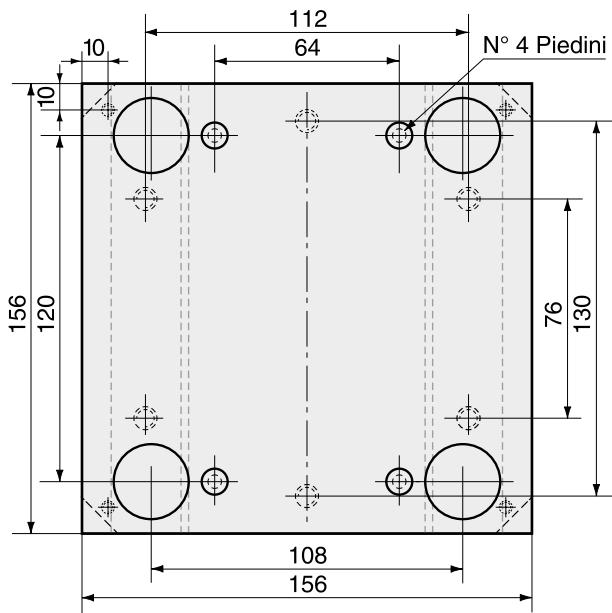


GUIDA TAVOLINO

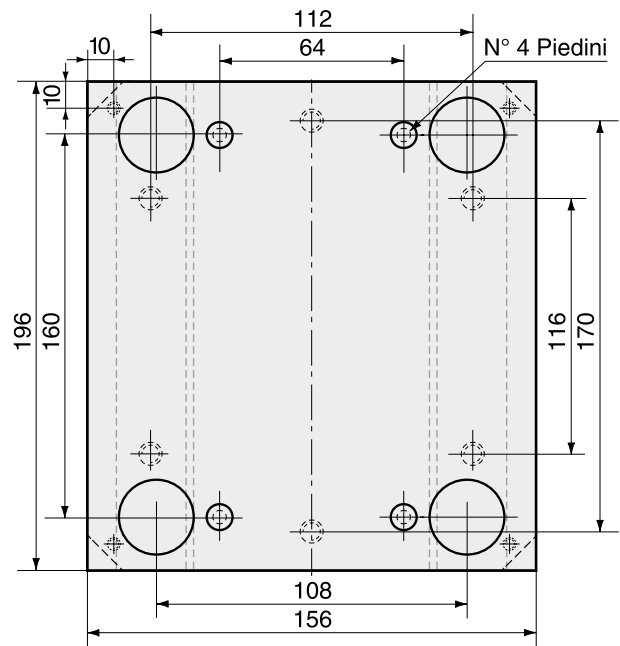
NOME	A1	F1	F2
156 x 156	120	90	65
156 x 196	160	130	65
156 x 246	210	180	65

Le misure sono espresse in mm.

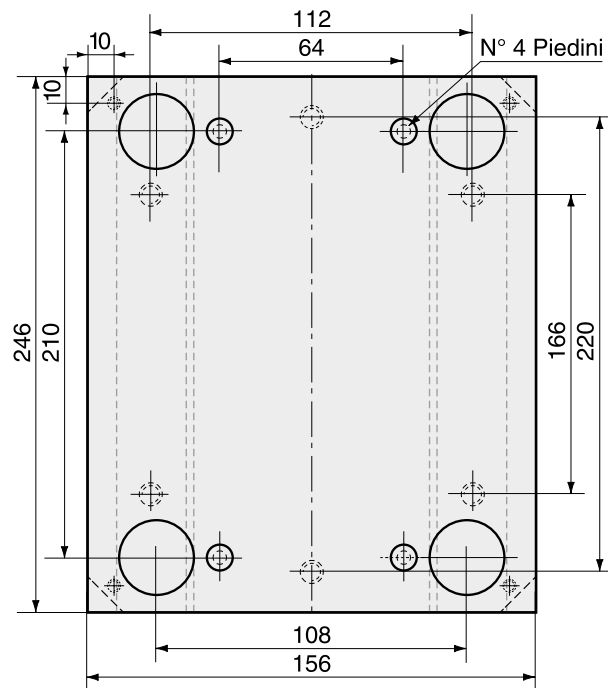
156 x 156



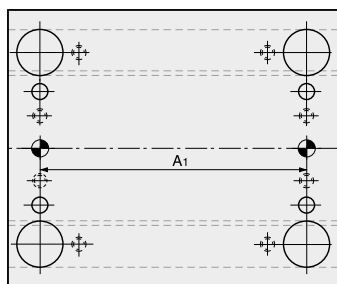
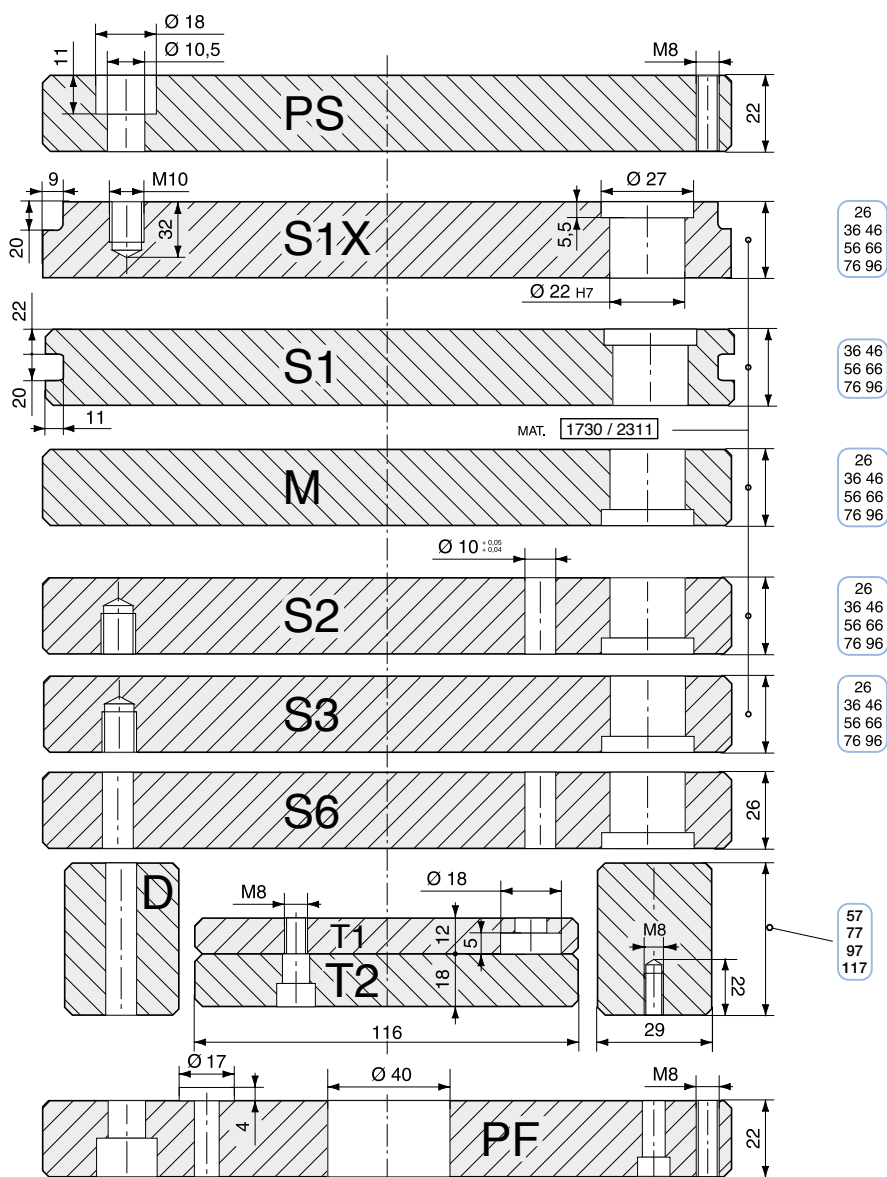
156 x 196



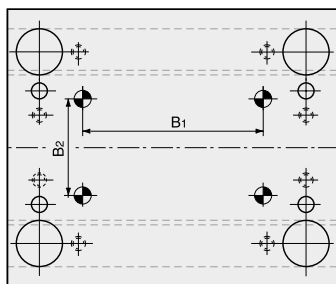
156 x 246



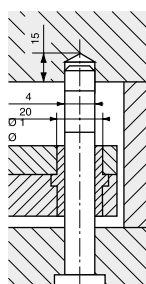
## SERIE 196 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati



TIPO A



TIPO B

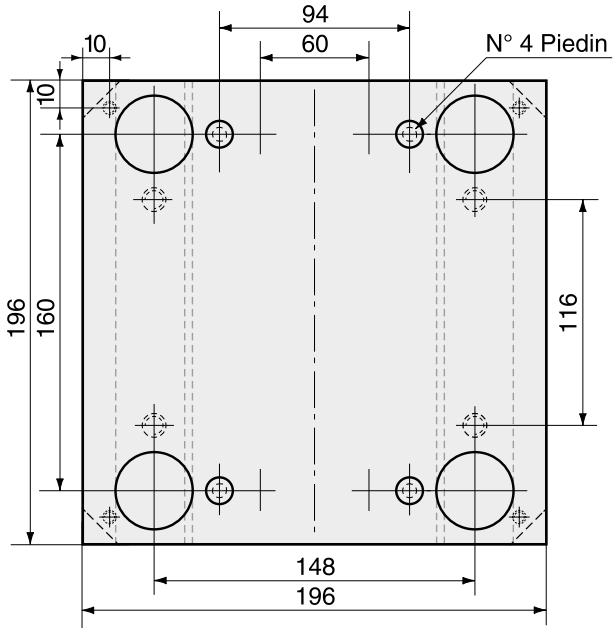


GUIDA TAVOLINO

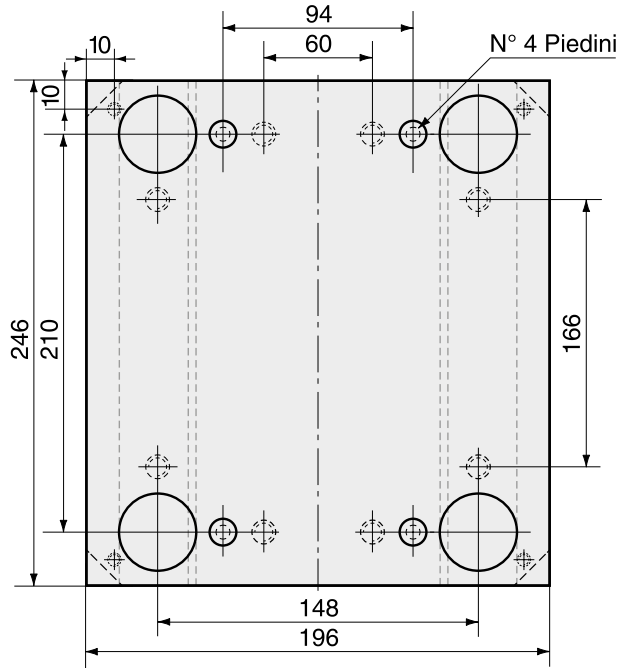
NOME	A1	B1	B2
196 x 196	160	114	84
196 x 246	210	164	84
196 x 296	260	214	84
196 x 346	310	264	84

Le misure sono espresse in mm.

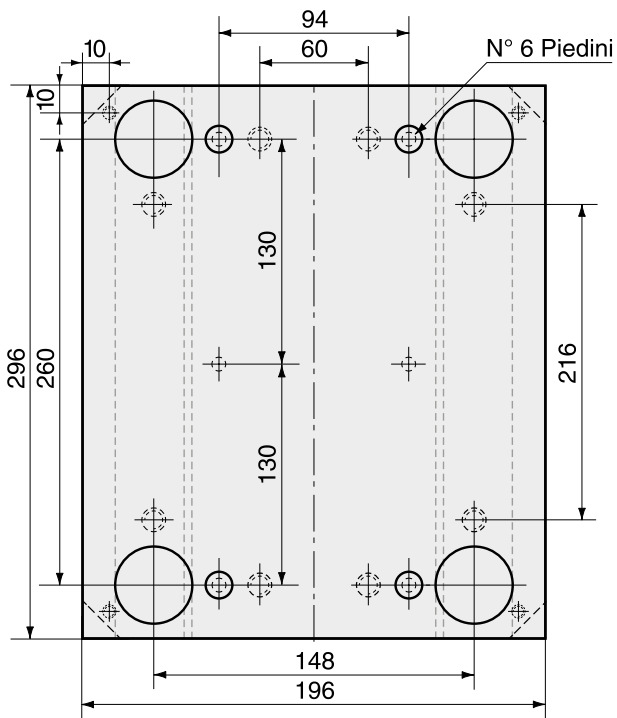
196 x 196



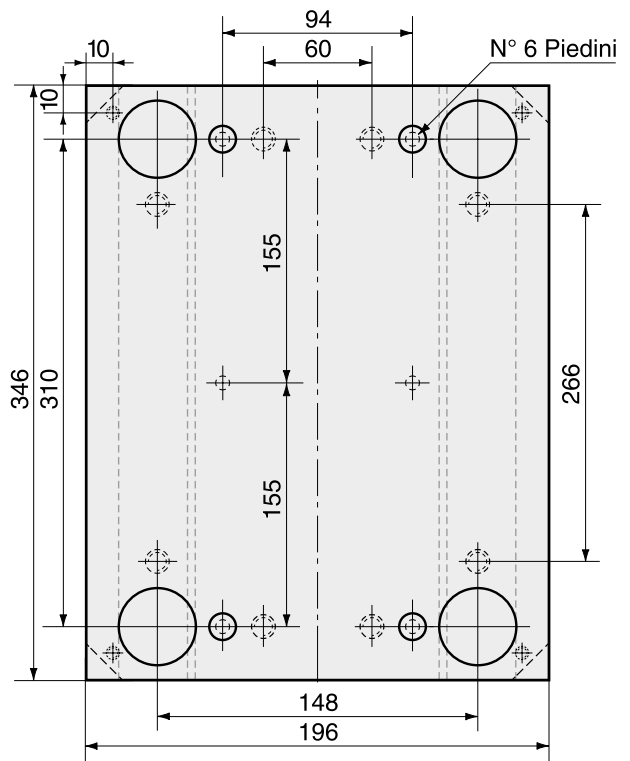
196 x 246



196 x 296

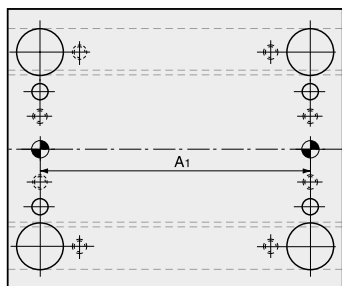
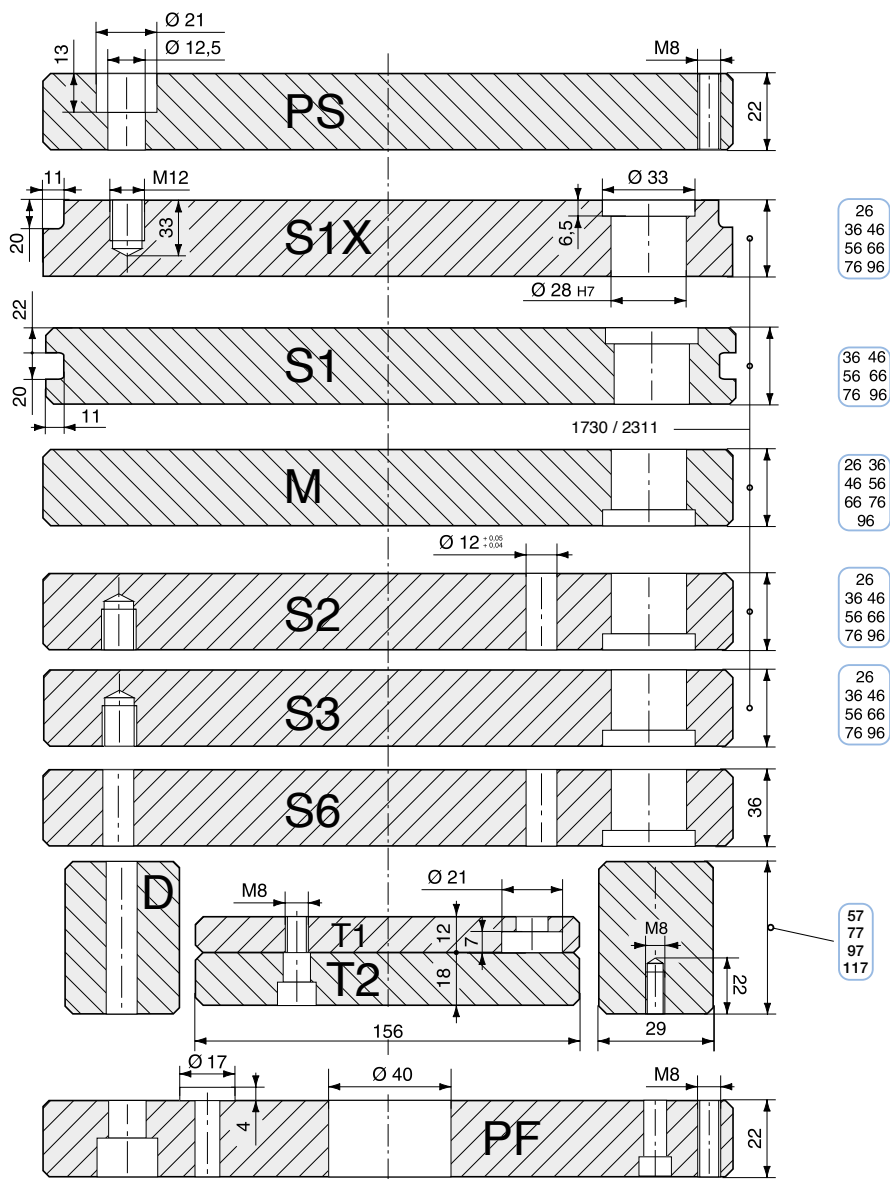


196 x 346

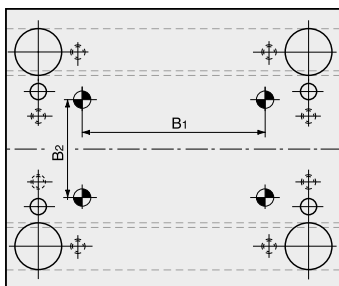




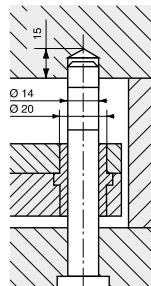
**SERIE 246 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati**



TIPO A



TIPO B

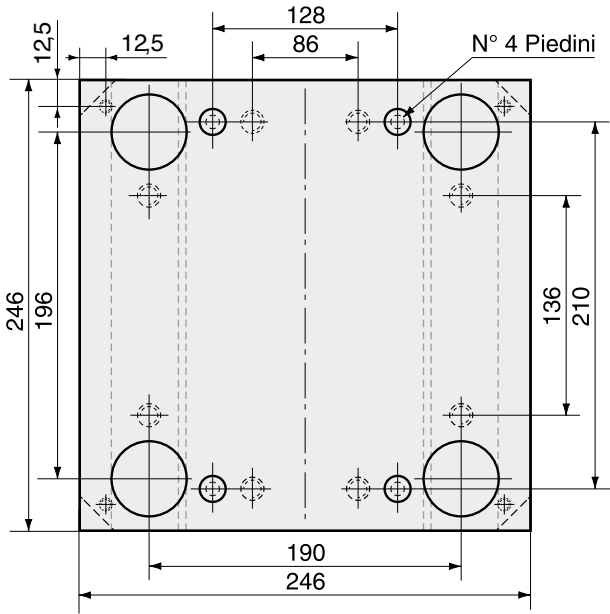


GUIDA TAVOLINO

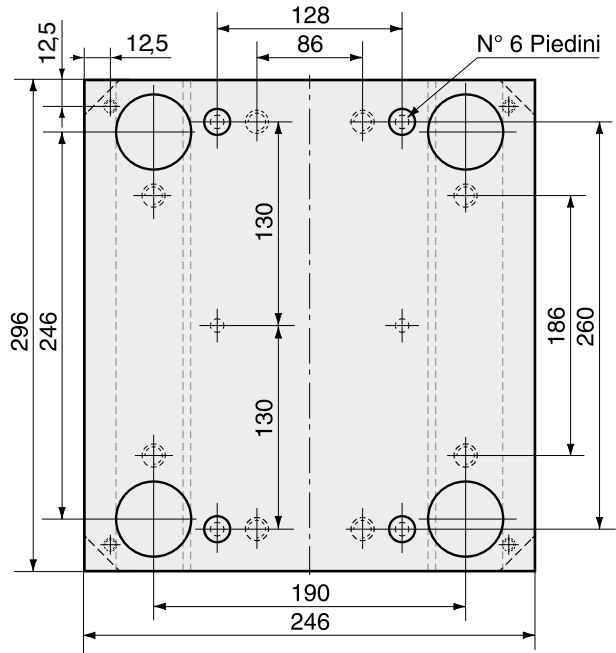
NOME	A1	B1	B2
246 x 246	210	158	126
246 x 296	260	208	126
246 x 346	310	258	126
246 x 396	360	308	126

Le misure sono espresse in mm.

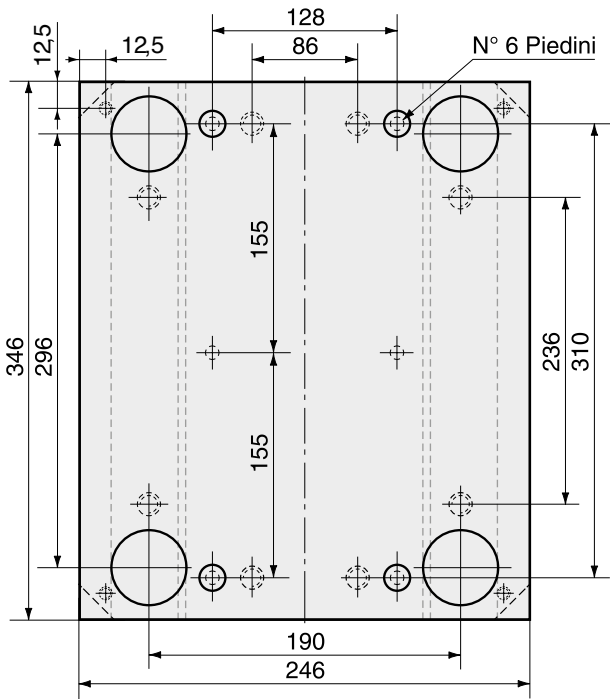
246 x 246



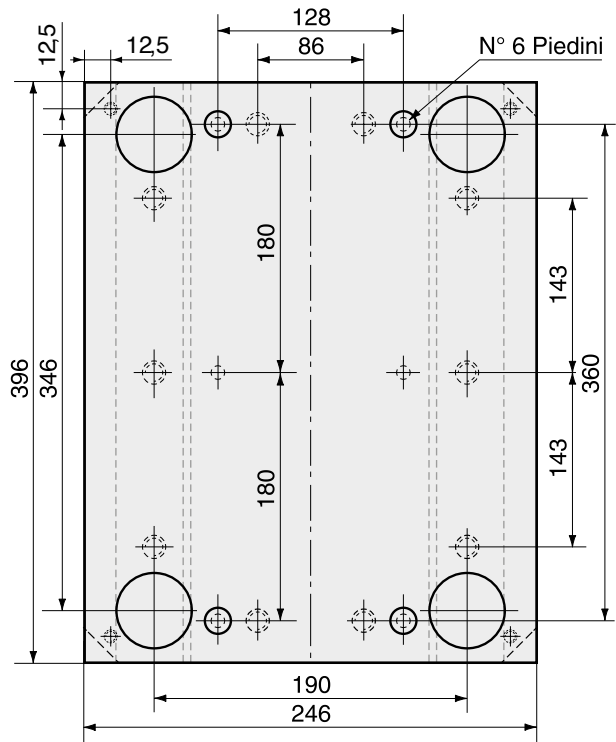
246 x 296



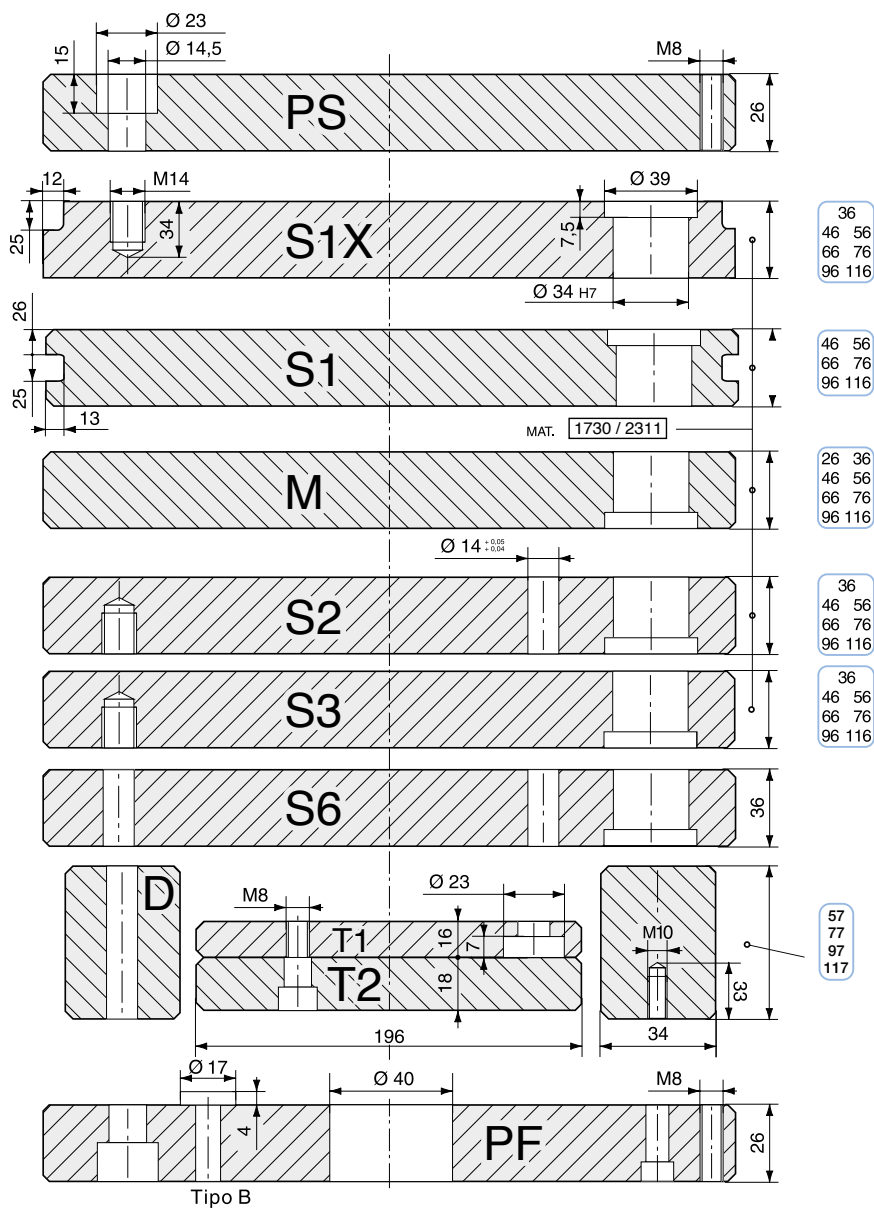
246 x 346



246 x 396



**SERIE 296 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati**



36  
46 56  
66 76  
96 116

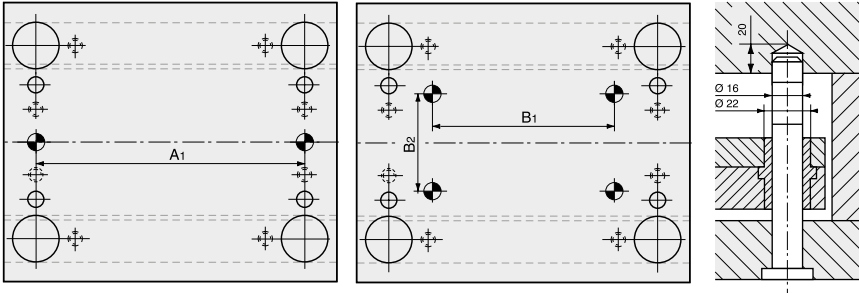
46 56  
66 76  
96 116

26 36  
46 56  
66 76  
96 116

36  
46 56  
66 76  
96 116

36  
46 56  
66 76  
96 116

57  
77  
97  
117



TIPO A

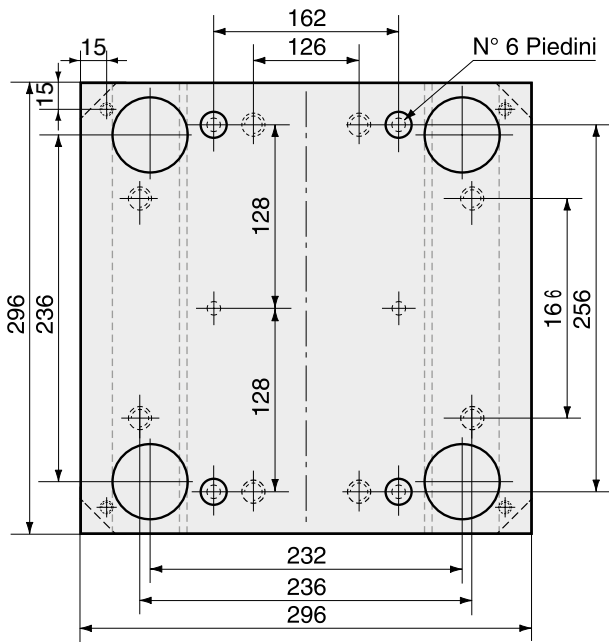
TIPO B

GUIDA TAVOLINO

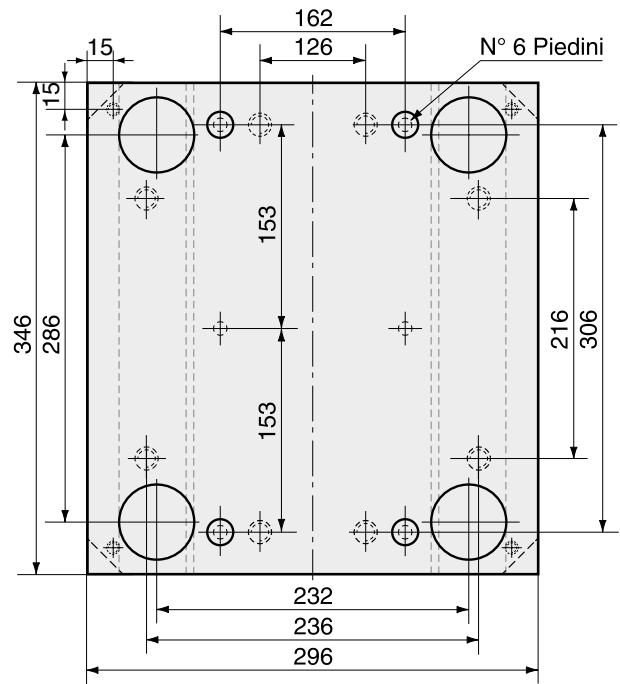
NOME	A1	B1	B2
296 x 296	260	204	162
296 x 346	310	254	162
296 x 396	360	304	162
296 x 446	410	354	162

Le misure sono espresse in mm.

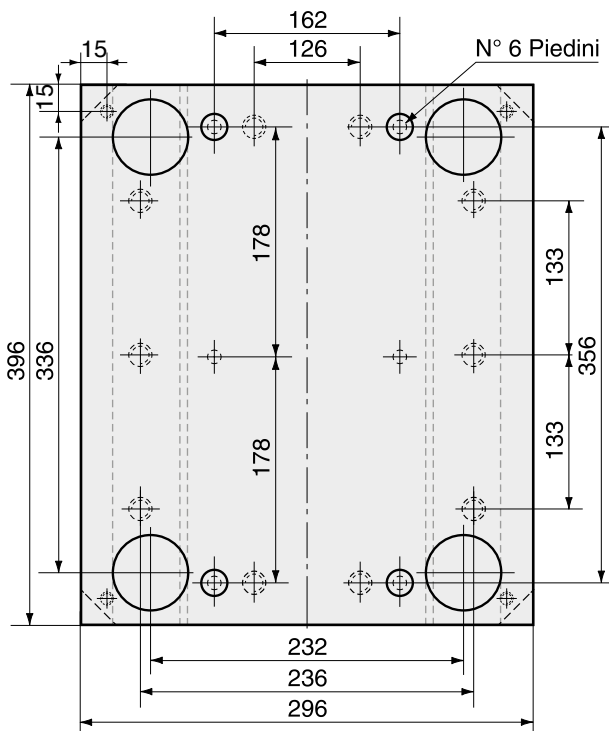
296 x 296



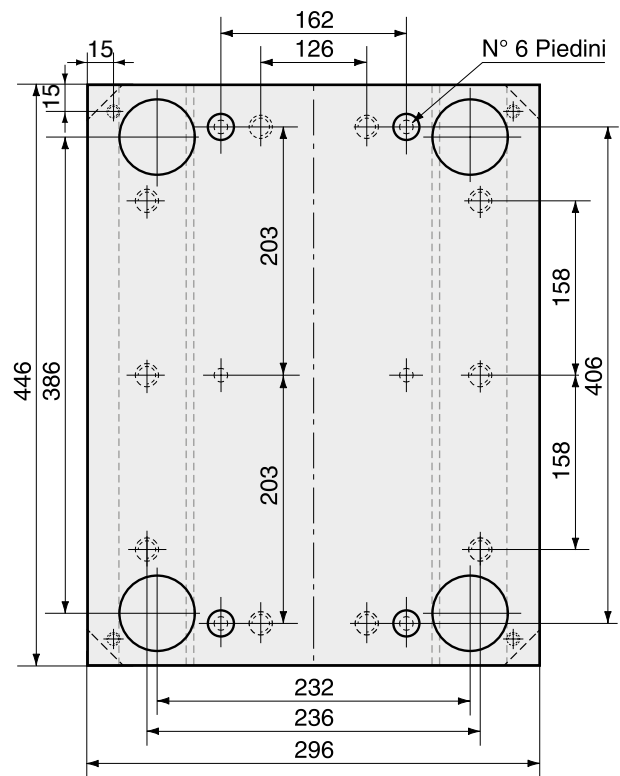
296 x 346



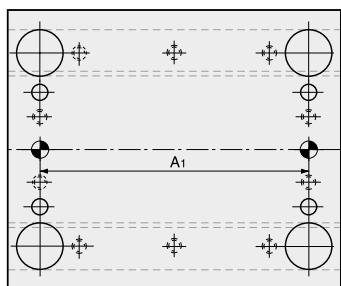
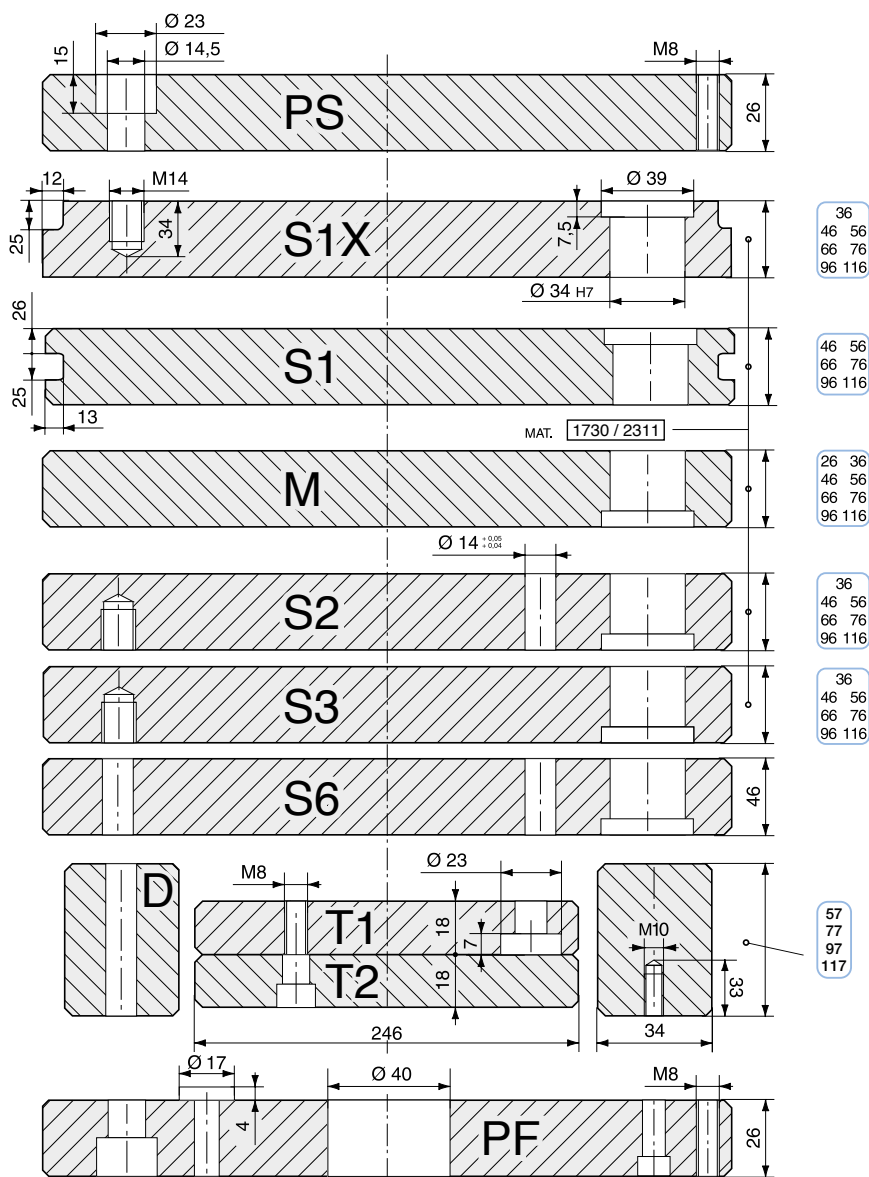
296 x 396



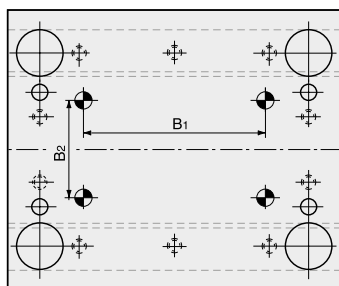
296 x 446



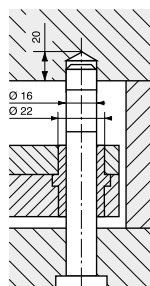
**SERIE 346 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati**



TIPO A



TIPO B

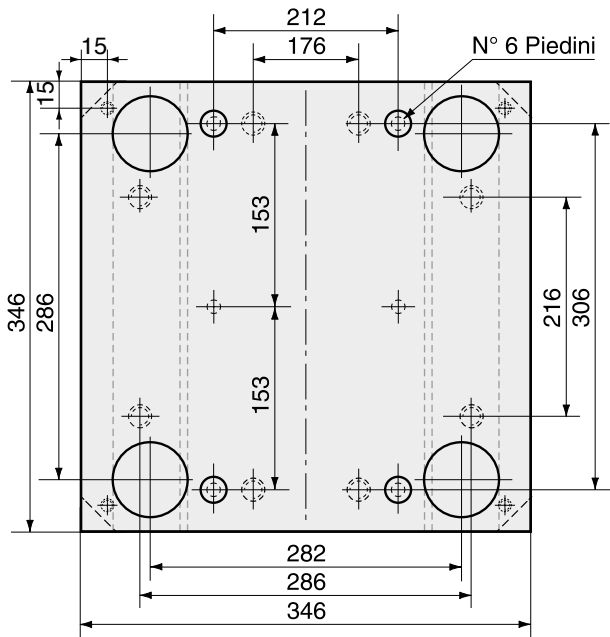


GUIDA TAVOLINO

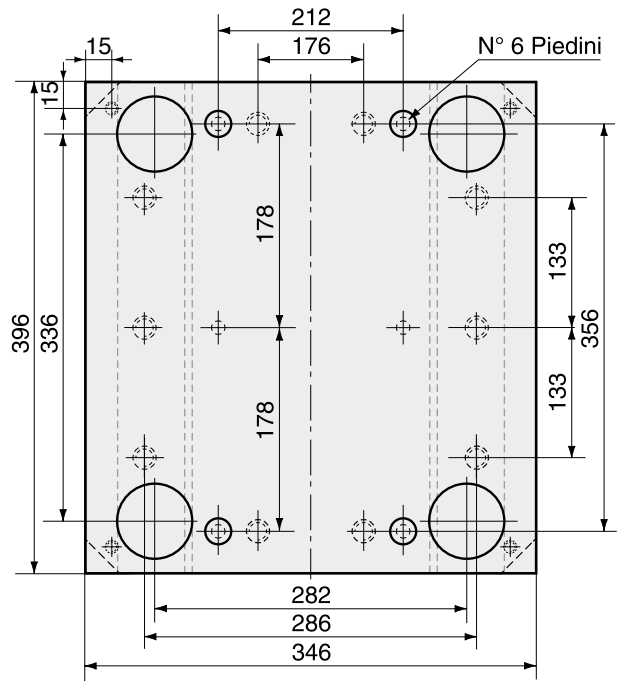
NOME	A1	B1	B2
346 x 346	310	254	212
346 x 396	360	304	212
346 x 446	410	354	212
346 x 496	460	404	212

Le misure sono espresse in mm.

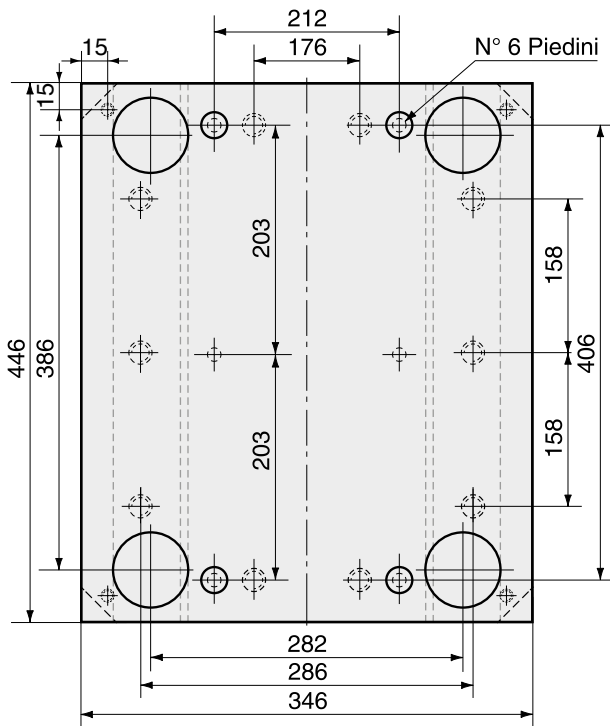
346 x 346



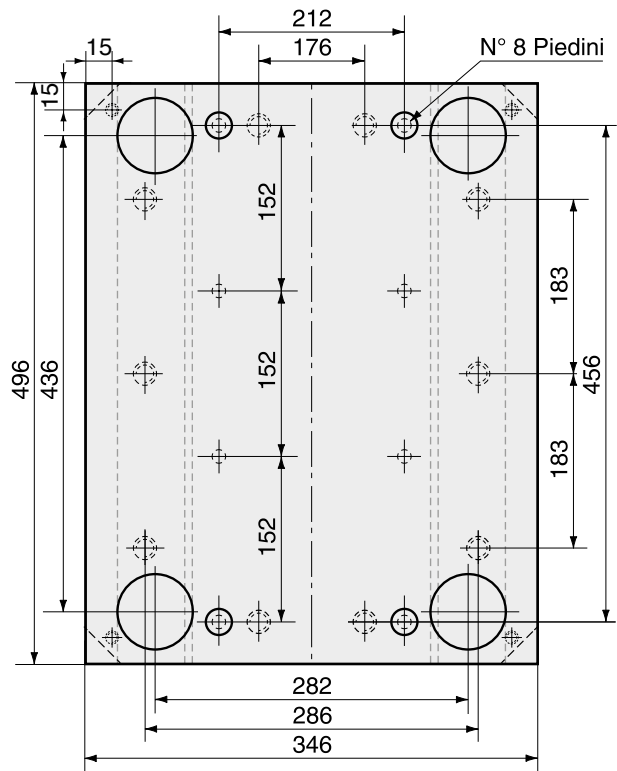
346 x 396



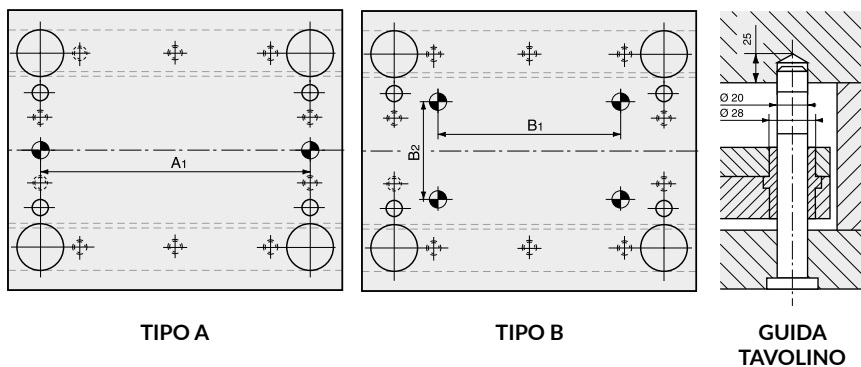
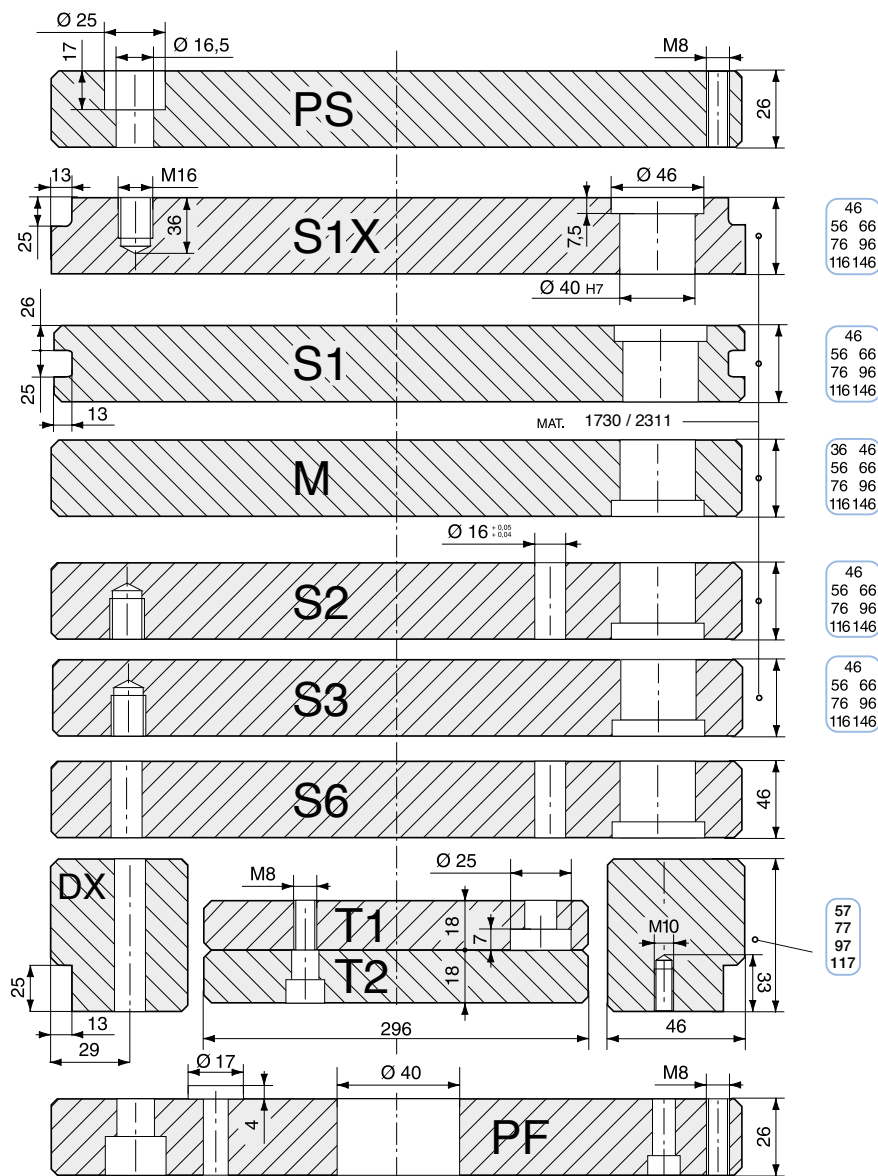
346 x 446



346 x 496



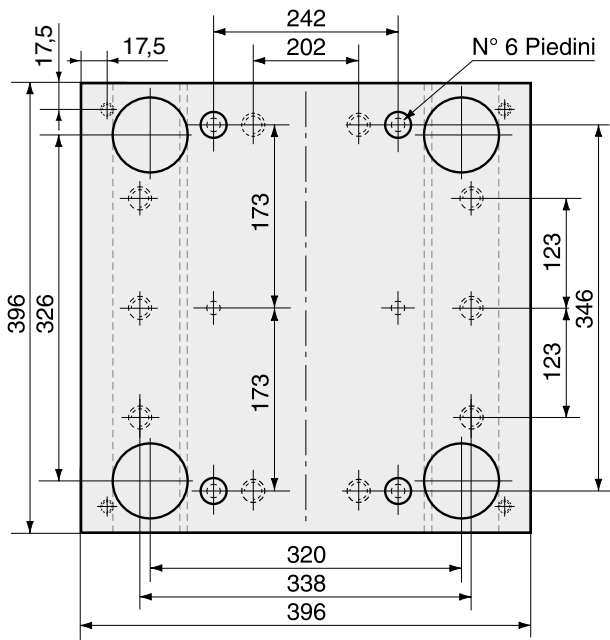
**SERIE 396 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati**



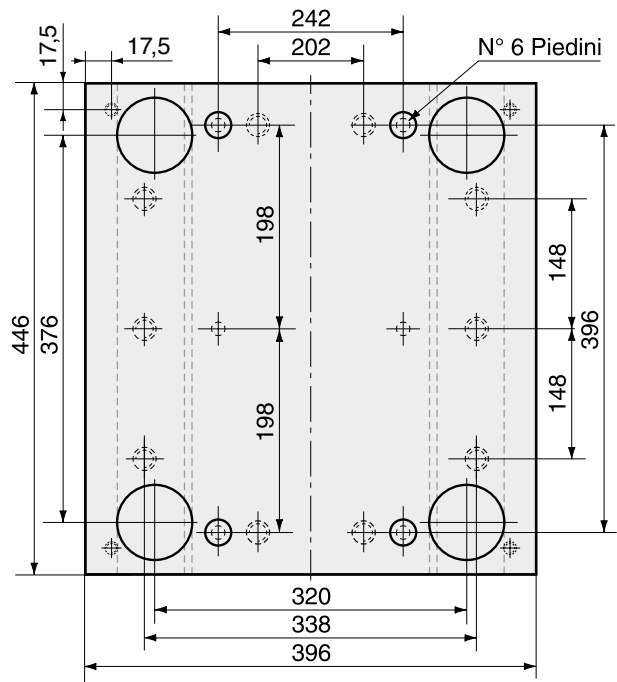
NOME	A1	B1	B2
396 x 396	354	280	250
396 x 446	404	330	250
396 x 496	454	380	250
396 x 546	504	430	250

Le misure sono espresse in mm.

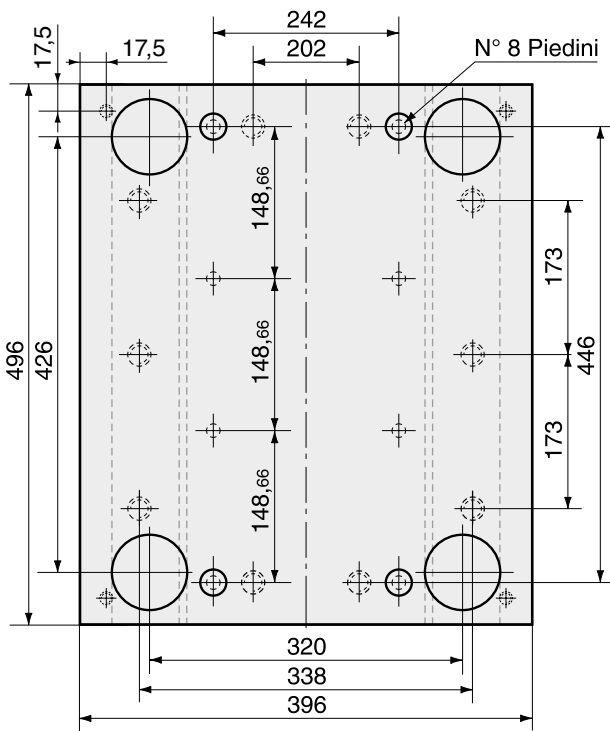
396 x 396



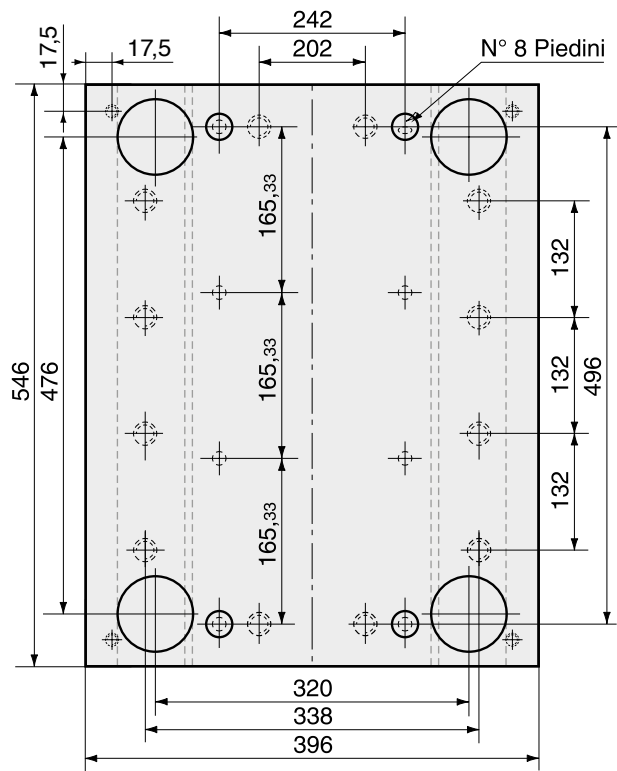
396 x 446



396 x 496

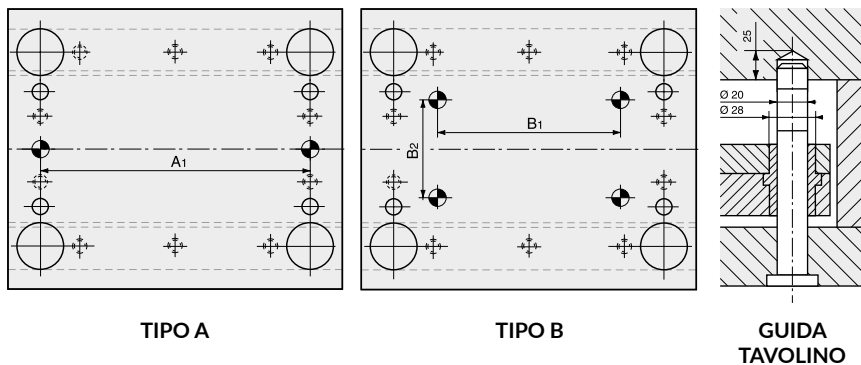
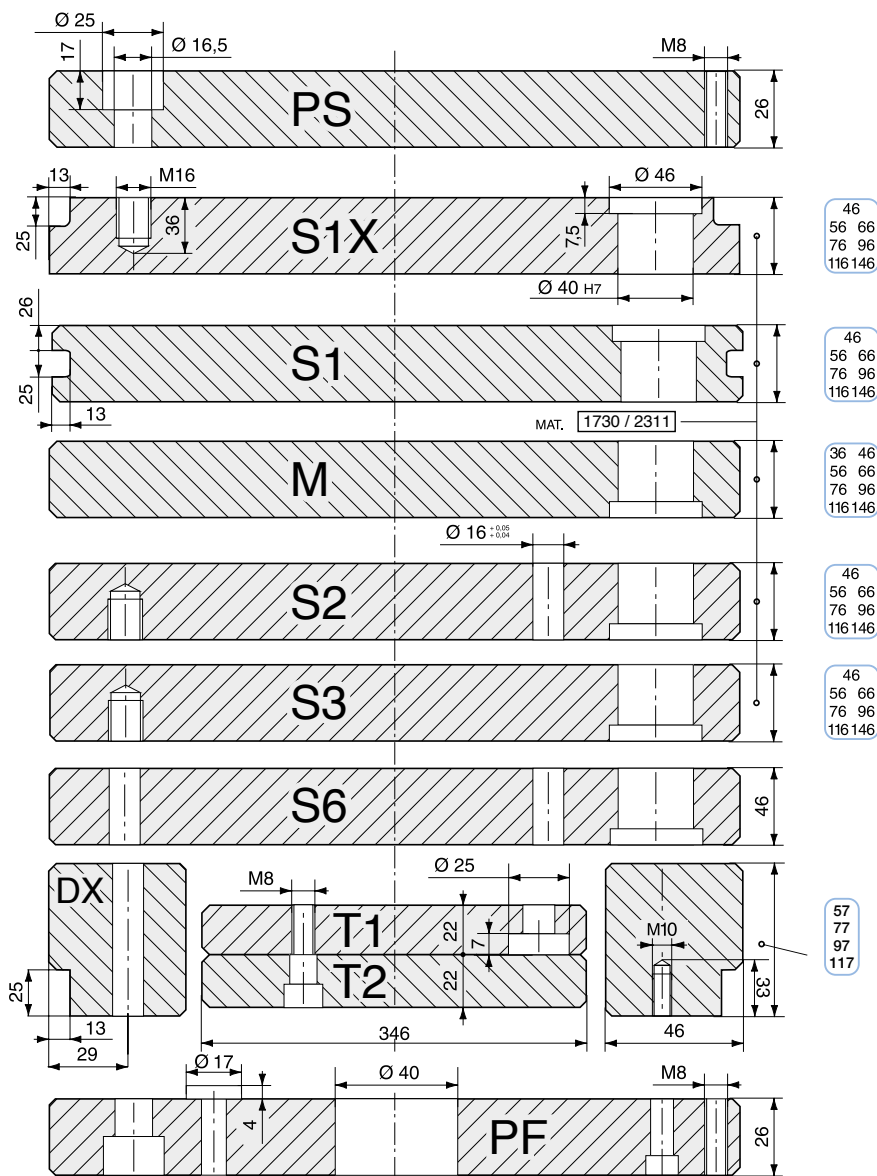


346 x 546





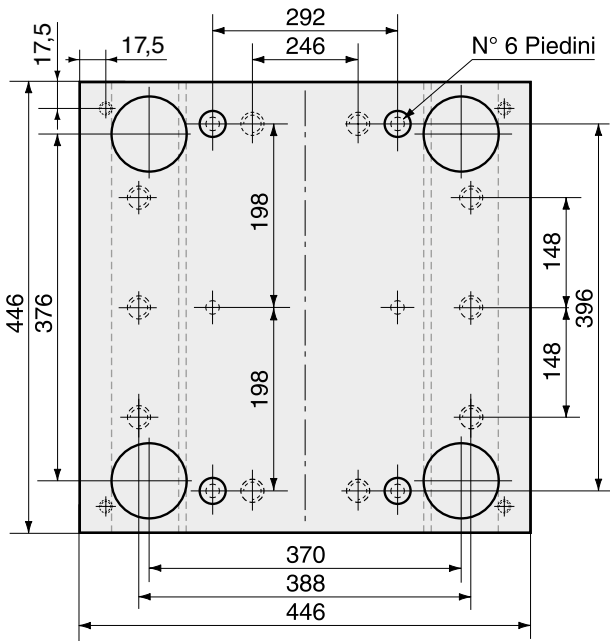
**SERIE 446 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati**



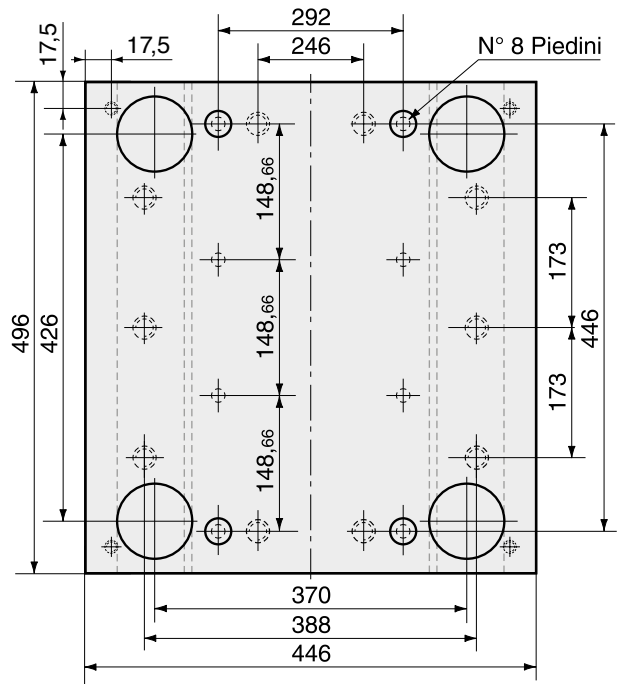
NOME	A1	B1	B2
446 x 446	404	330	300
446 x 496	454	380	300
446 x 546	504	430	300
446 x 596	554	480	300

Le misure sono espresse in mm.

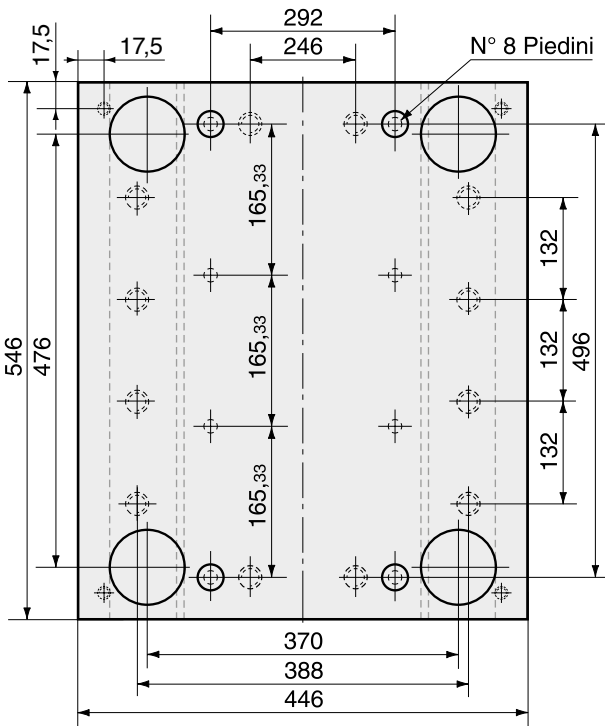
446 x 446



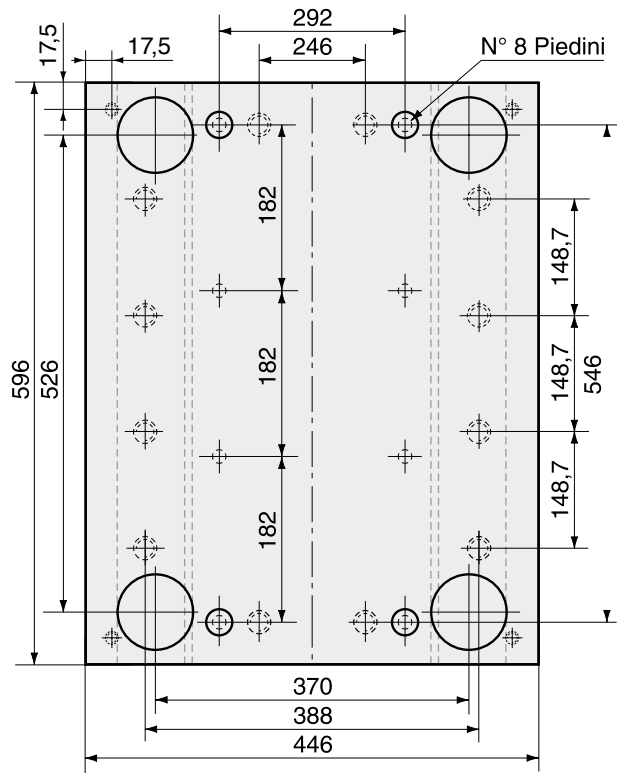
446 x 496



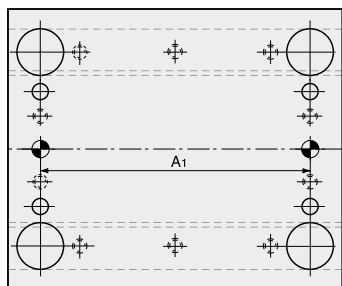
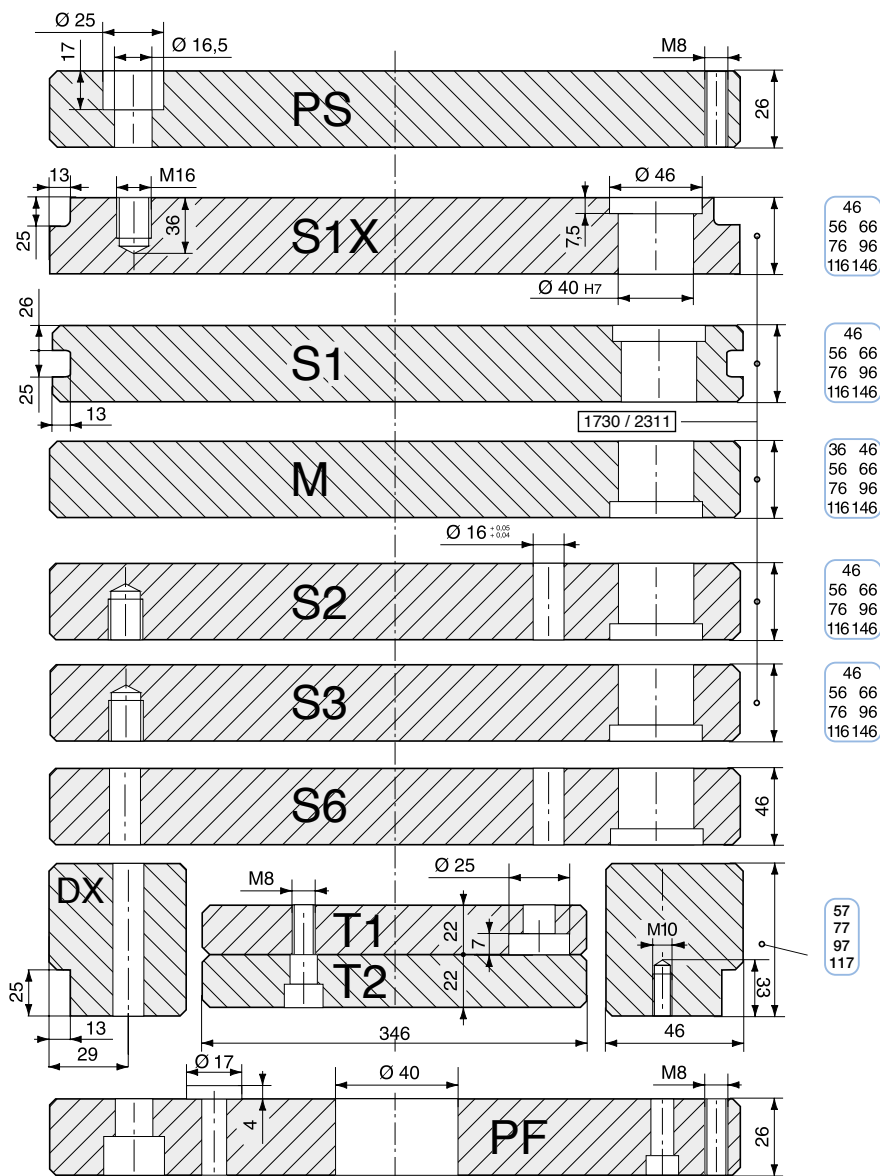
446 x 546



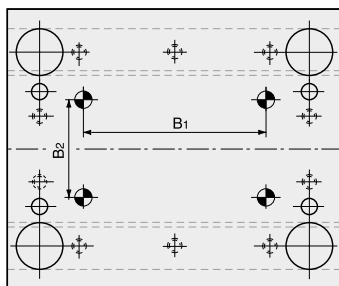
446 x 596



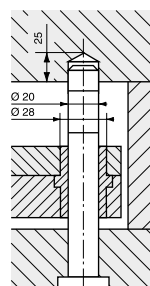
SERIE 490 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati



TIPO A



TIPO B

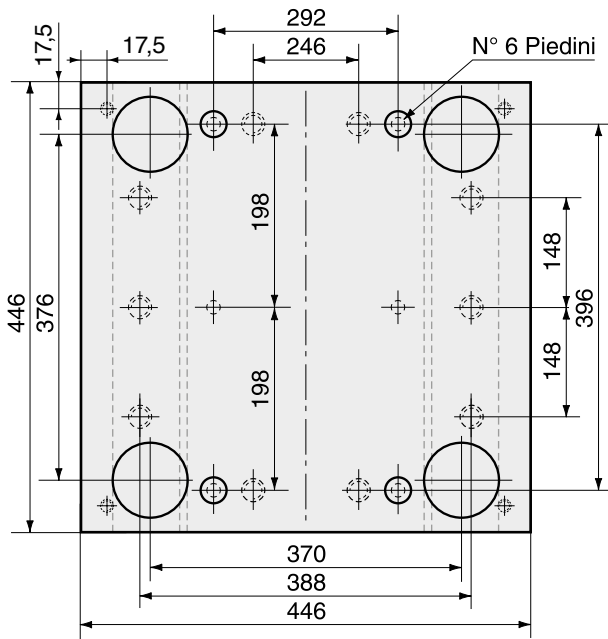


GUIDA TAVOLINO

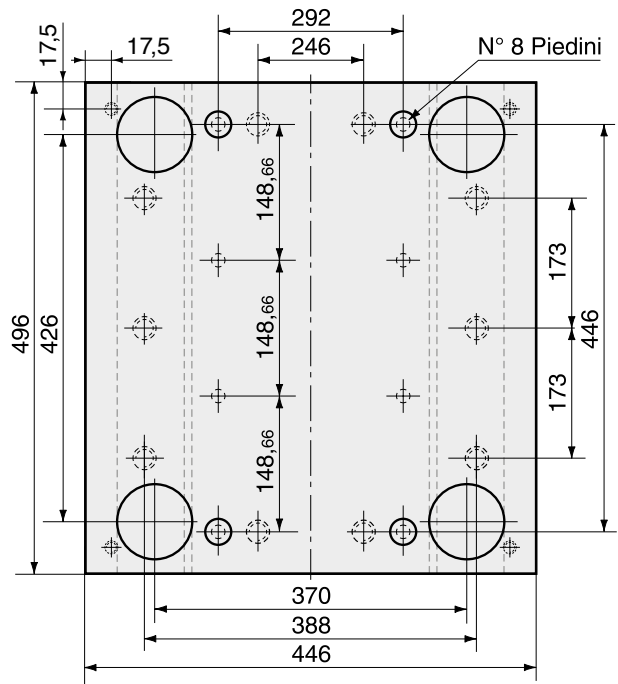
NOME	A1	B1	B2
490 x 496	454	370	306
490 x 546	504	420	306
490 x 596	554	470	306
490 x 646	604	520	306
490 x 696	564	570	306

Le misure sono espresse in mm.

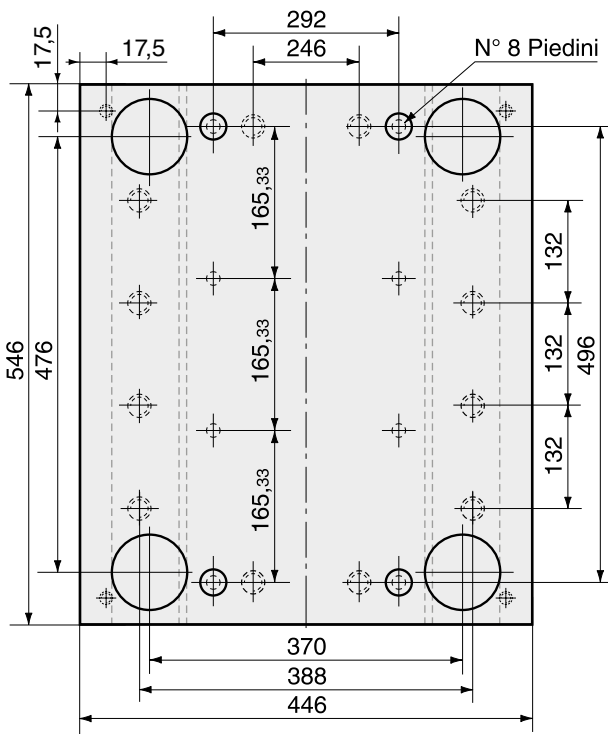
490 x 496



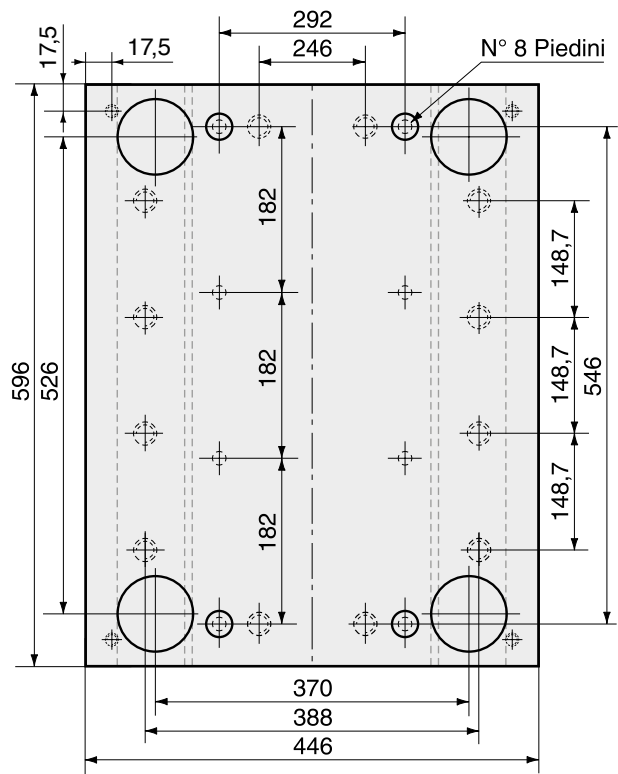
490 x 546



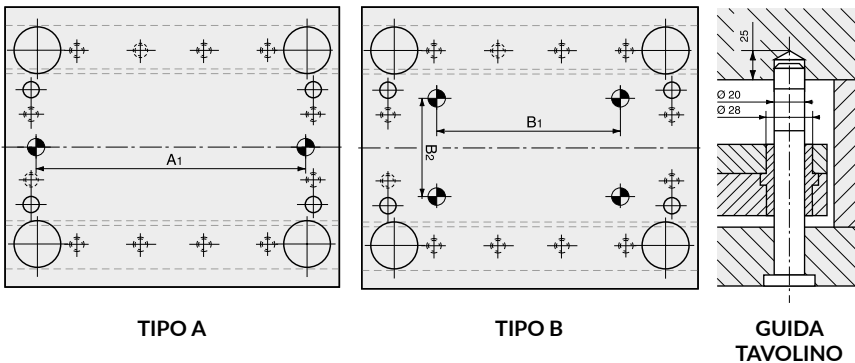
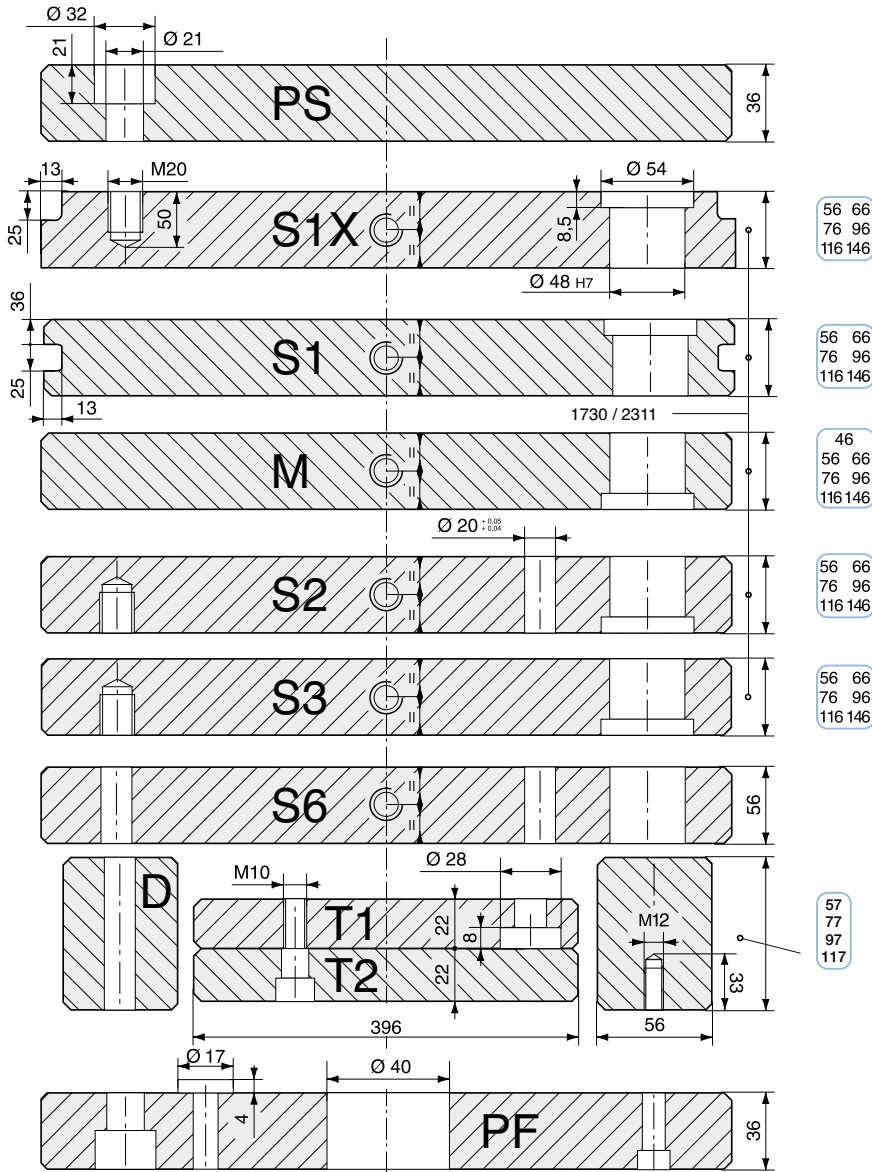
490 x 596



490 x 646

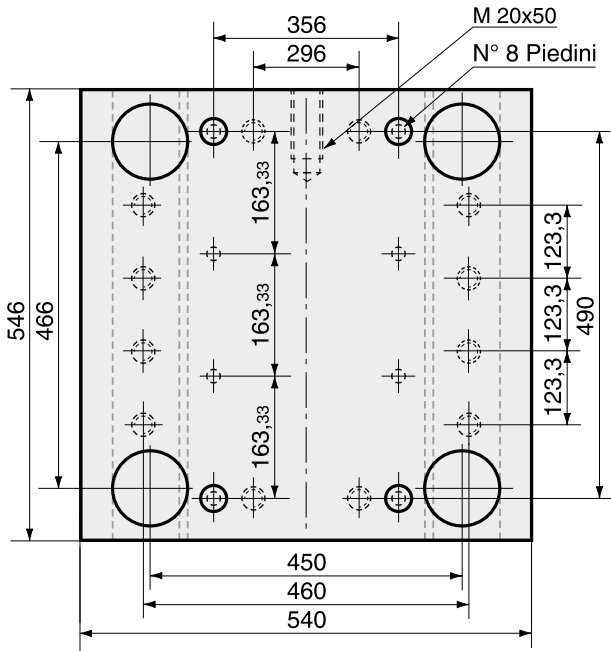


SERIE 540 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati

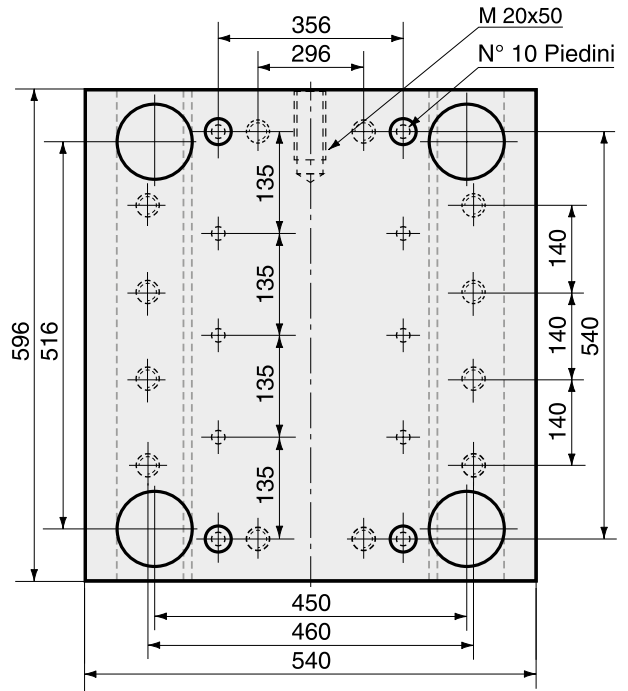


Le misure sono espresse in mm.

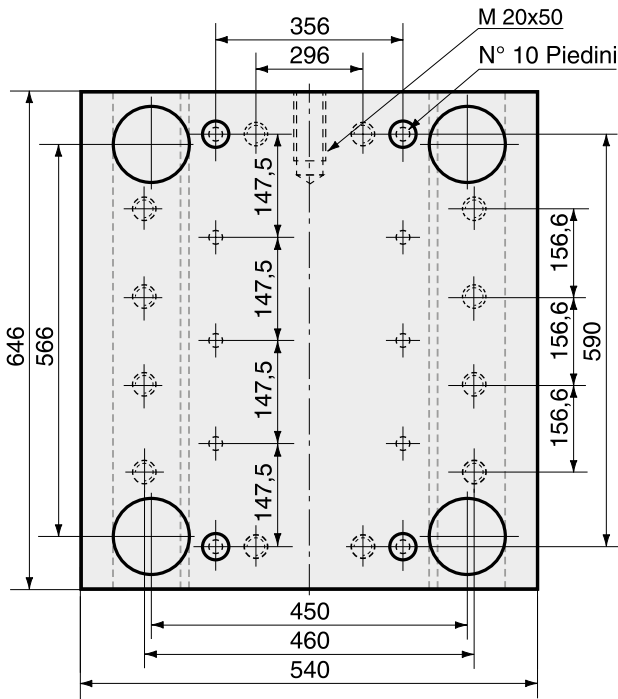
540 x 546



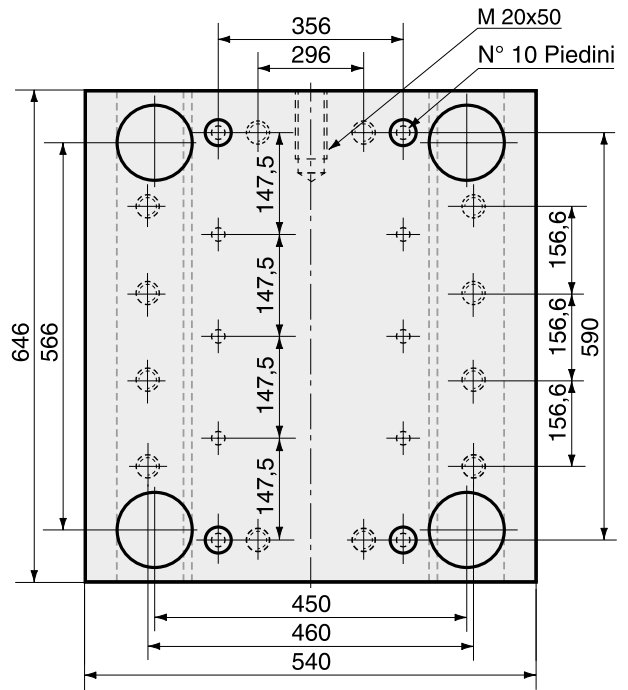
540 x 596



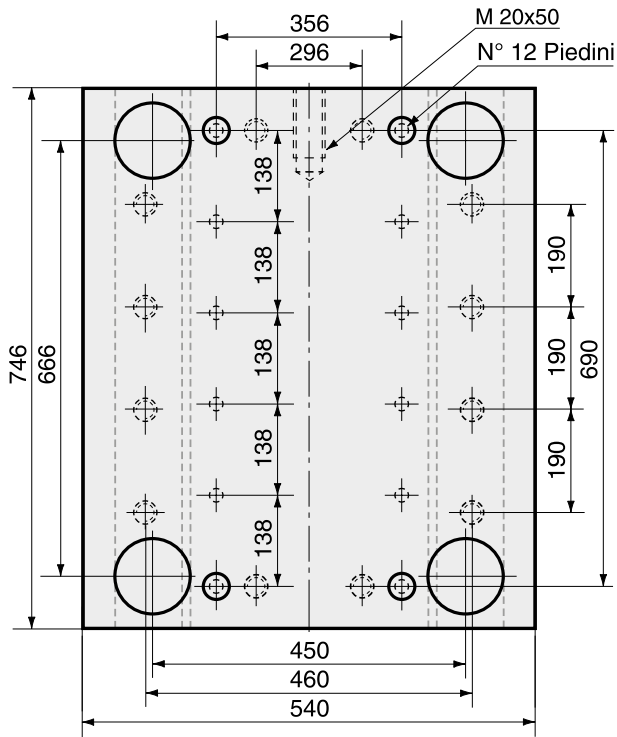
540 x 646



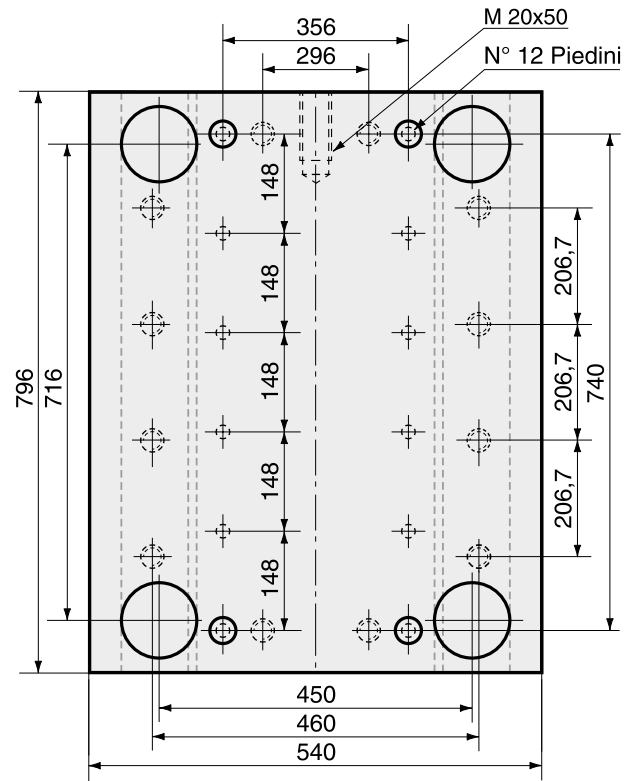
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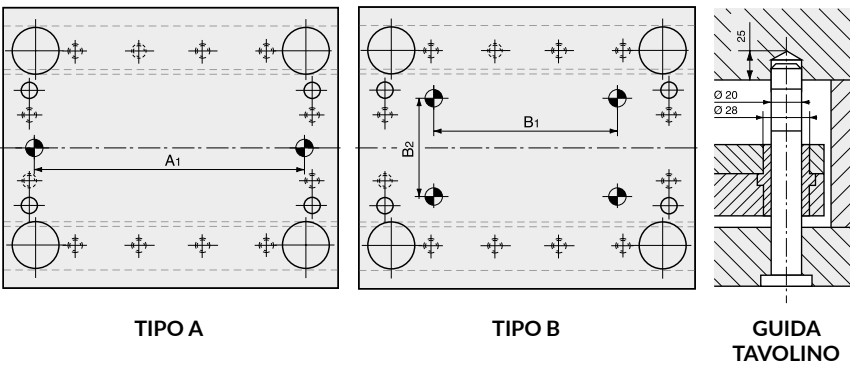
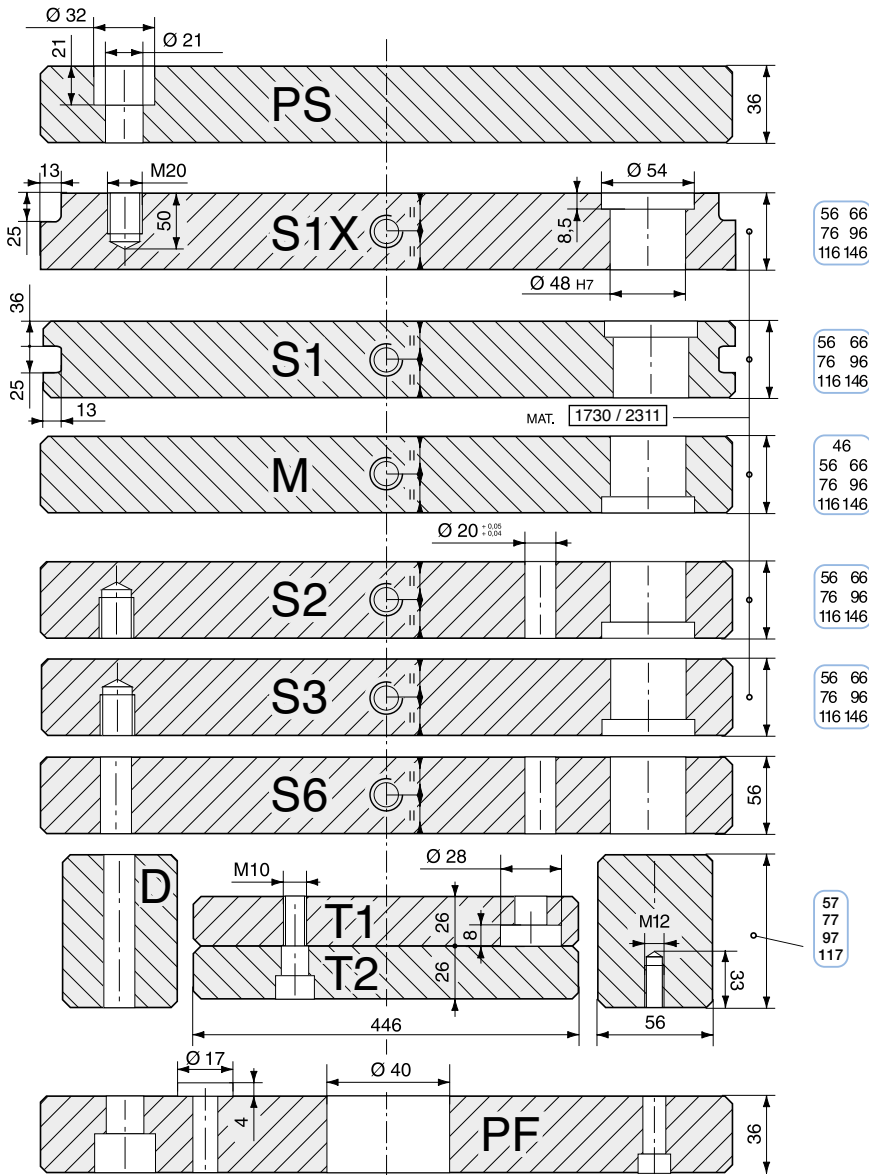
540 x 746



540 x 796



SERIE 590 | PIASTRE STANDARD CON PIANI RETTIFICATI - Esterni rettificati

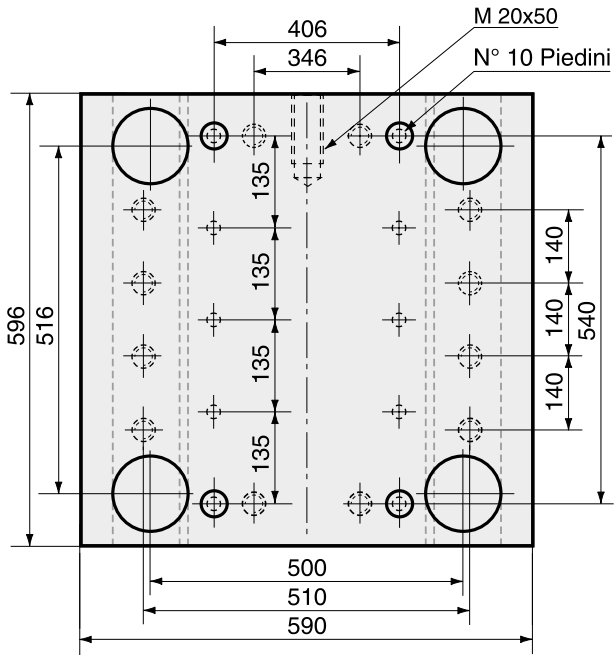


NOME	A1	B1	B2
590 x 596	504	420	356
590 x 646	554	470	356
590 x 696	604	520	356
590 x 746	654	570	356
540 x 796	704	620	356

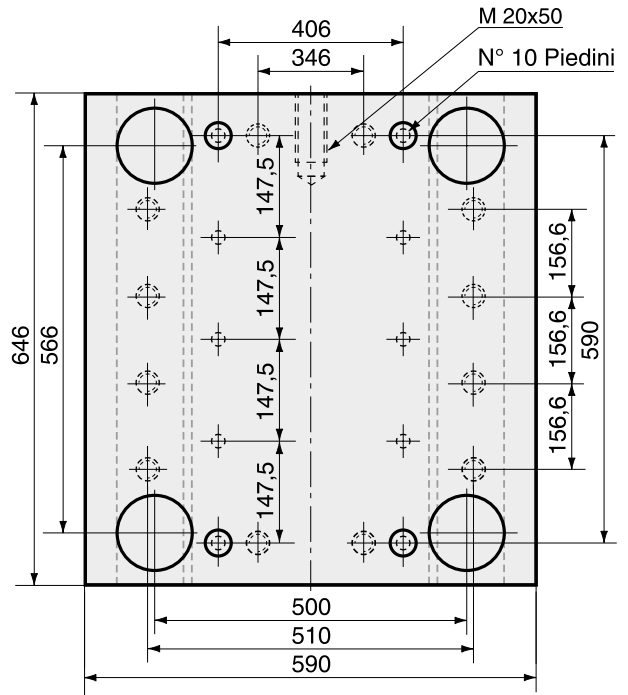
Le misure sono espresse in mm.



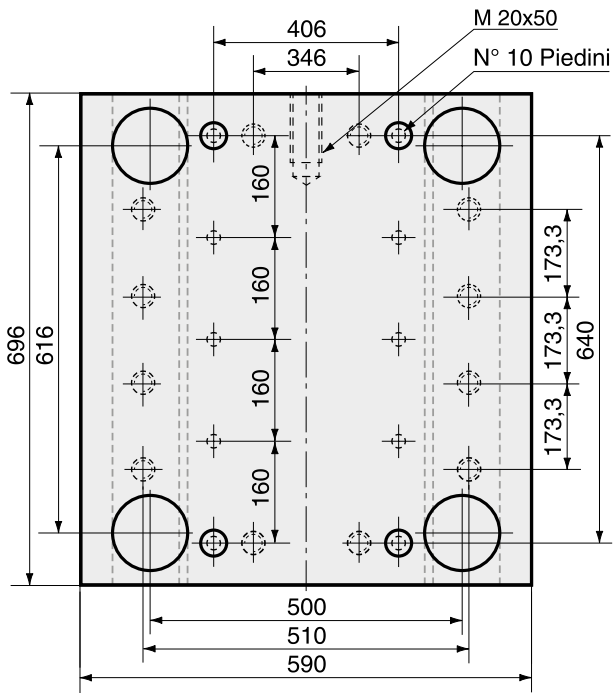
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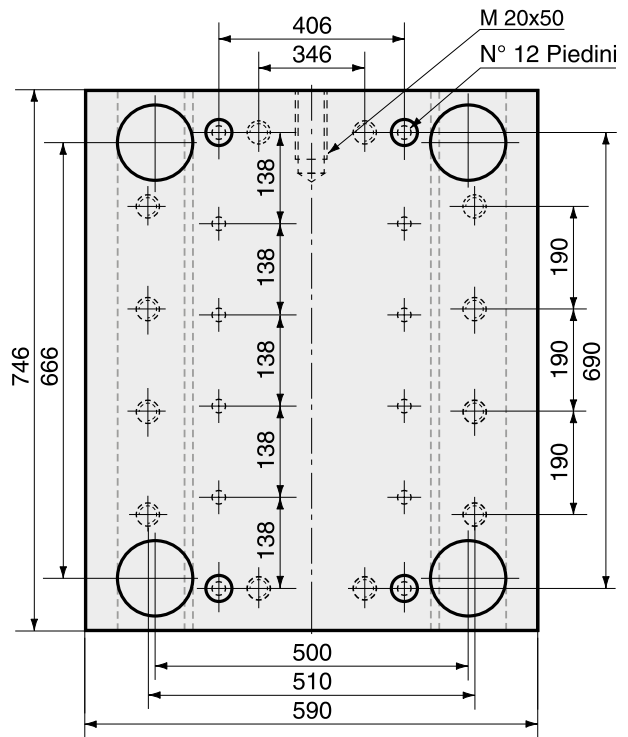
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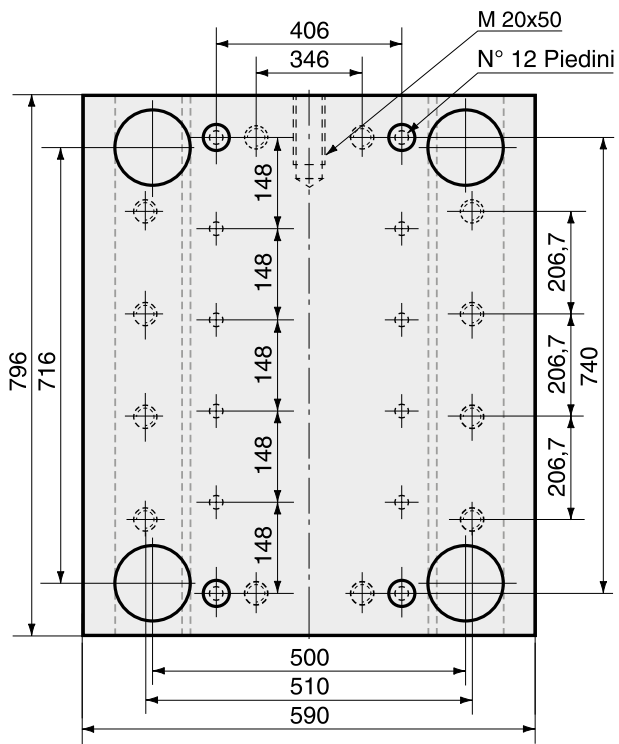
590 x 696



590 x 746



590 x 796





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