

Toolspress

high quality tooling systems



tools  **press**

WILA STYLE
Press Brake Tooling

www.toolspress.com

VERSION 1.1

tools press

Spirito d'Innovazione

Toolspress è leader mondiale nella progettazione e produzione di utensili e sistemi di bloccaggio di alta qualità, per presse piegatrici. Realizziamo prodotti all'avanguardia ed innovativi, sfruttando 30 anni di esperienza ed un ampio programma di produzione, con più di mille modelli standard, che ci permettono di valutare e risolvere le problematiche proposteci, ottimizzando i vostri sistemi di piegatura.

Toolspress è composta da Quattro importanti divisioni:

- Utensili Standard di Alta Precisione per Presse Piegatrici
- Utensili Speciali di Alta Precisione per Presse Piegatrici
 - Sistemi di Bloccaggio per Presse Piegatrici
 - Soluzioni Industriali per Presse Piegatrici
 - Lamé da cesoia

Queste quattro divisioni sono indipendenti e utilizzano le tecnologie più avanzate disponibili nel mercato mondiale, in questo modo possiamo garantire prodotti di alta qualità senza paragoni. La qualità Toolspress è ben conosciuta nel mercato mondiale da molti anni. I nostri clienti sono per noi partners tecnologici, grazie ad una stretta collaborazione, risolviamo e incrementiamo le loro performance di piegatura. Il mercato globale richiede sempre più tecnologia a prezzi molto competitivi e nel minor tempo possibile, per questi motivi la nostra società ricerca e sviluppa metodi di produzione che ci permettono di soddisfare le richieste dei nostri clienti.

The Spirit of Innovation

Toolspress is a world-class designer and manufacturer of high-quality press brake tooling and clamping system. We provide the most innovative products in the fabricators industries. Through a great manufacturing program with more than thousand standard model, we are able to guide your choice of the best bending system in the fastest time, due to the long experience we got in 30th years.

Toolspress has four important divisions:

- Precision Ground Standard Press Brakes Tooling
- Precision Ground Special Press Brakes Tooling
 - Press Brakes Clamping System
 - Industrial Solutions for Press Brakes
 - Shear blades

These four divisions are independent and both use the ultimate technologies in manufacturing process available in the world market, in this way we can guarantee high precision quality products with no comparison. Toolspress quality is very well known in the world market since many years. Ours customers are for us technological partners, in fact through a tight cooperation they let us solve and improve their bending performance. The global market needs always more and more technology to a very competitive prices in the shortest time. In this way our company develops manufacturing methods that allow us to meet our costumers requirements.

The Spirit of Innovation

Toolspress® ist der weltweit führende Entwickler und Hersteller von qualitativ hochwertigen Abkantwerkzeugen und Werkzeug-Spannsysteme. Wir entwickeln und vertreiben die innovativsten Produkte im Bereich der Abkantechnik. Durch unser großes Herstellungsprogramm mit über tausend Standardwerkzeugen sind wir in der Lage, das von Ihnen gewünschten Werkzeugsystem innerhalb kürzester Zeit zu liefern. Toolspress® verfügt über eine 30-jährige Erfahrung in der Abkantechnik.

Toolspress® hat vier wichtige Bereiche:

- Präzisions Standard Abkantwerkzeuge
- Präzisions Spezial Abkantwerkzeuge
- Spannsysteme für Abkantwerkzeuge
- Industrielle Lösungen für Abkantpressen
 - Shear blades

Diese vier Bereiche sind unabhängig, aber alle nutzen die neuesten auf dem Weltmarkt verfügbaren Fertigungstechnologie. Auf diese Weise können wir hochpräzise Qualitätsprodukte ohne Kompromisse garantieren.

Die Qualität von Toolspress® ist seit Jahren auf dem Markt bekannt.

Für uns sind unsere Kunden technologische Partner.

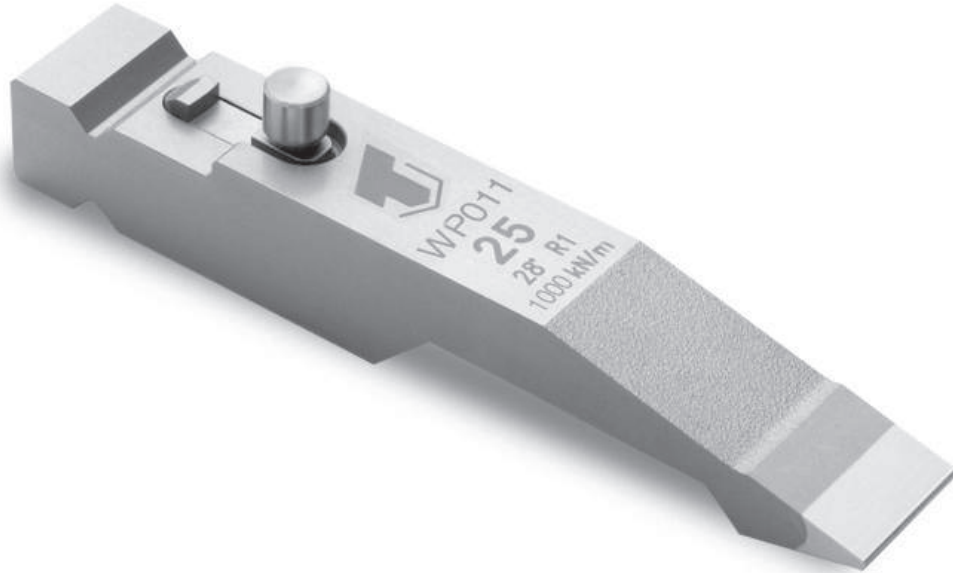
In enger Zusammenarbeit werden Lösungen erreicht und Abkanteleistungen verbessert. Die globalen Marktanforderungen fordern immer mehr Technologien, zu wettbewerbsfähigen Preisen, in kürzester Zeit. Daher entwickeln wir ständig neue Herstellungsverfahren, die es uns erlauben den Kundenanforderungen zu entsprechen.



Order	Minimum order is 100 €
Credit	All orders are subject to the approval of our credit department. If you are a new account, please furnish us with a bank reference and three supplier references. A credit limit will be imposed on new accounts until credit has been established.
Payment	Terms are net 30 days.
Cancellation	In the event an order is cancelled, a charge will be made to cover labour, materials and overheads.
Returned Material	A handling charge of 25% is made on all standard parts returned for credit. Written permission and shipping instructions must be obtained before the return of any material. Special tooling cannot be returned.
Claims	All claims for shortages must be made within 3 days of the invoice date.
Prices	Prices and specifications subject to change without prior notice. E & O E. All prices are exclusive of VAT.
Delivery Charge	All orders are subject to a delivery charge. Please call the sales desk for a delivery quotation.

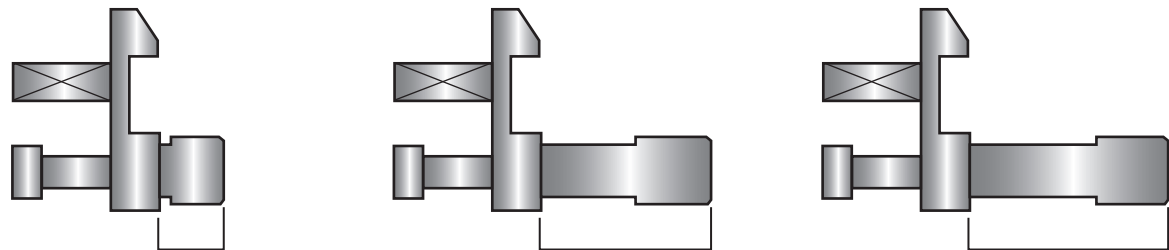


Click and Lock

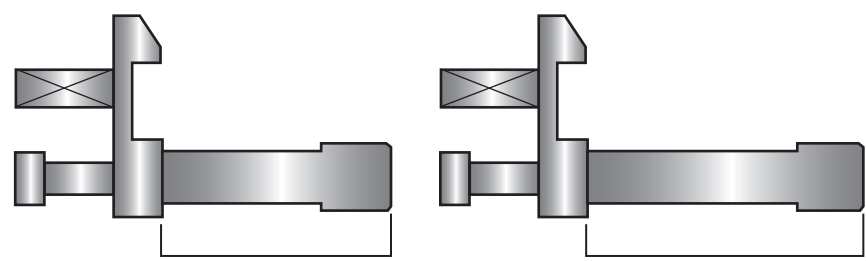


Safety clicks standard on all punches below 12,7 kg

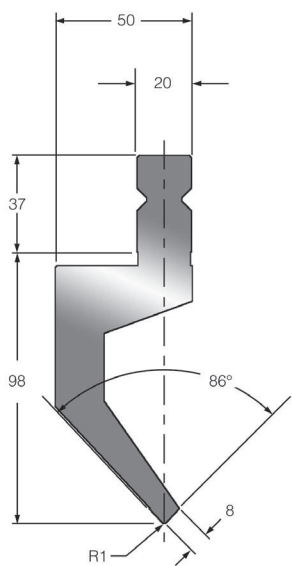
Description	Description	Description
Punch Button Assembly - 10mm	Punch Button Assembly - 24mm	Punch Button Assembly - 30mm



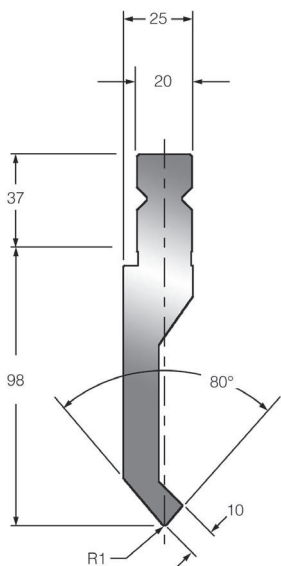
Description	Description
Punch Button Assembly - 35mm	Punch Button Assembly - 45mm



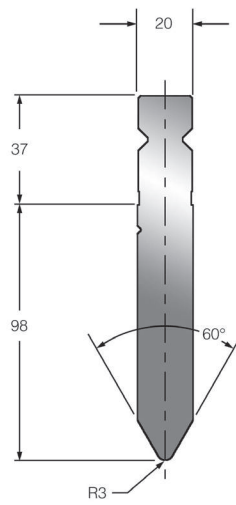
Punches - Height 135&157mm



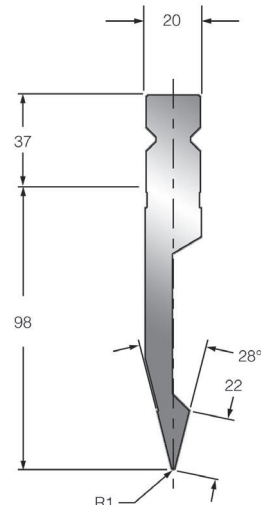
WP003



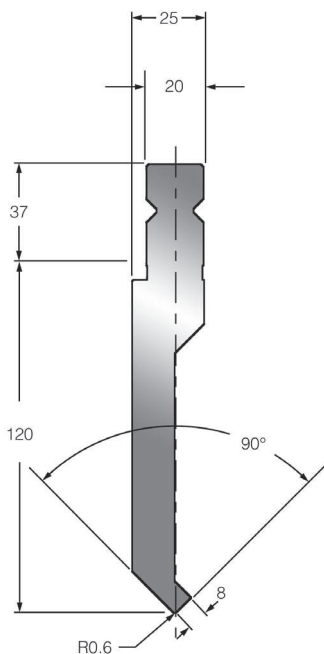
WP002



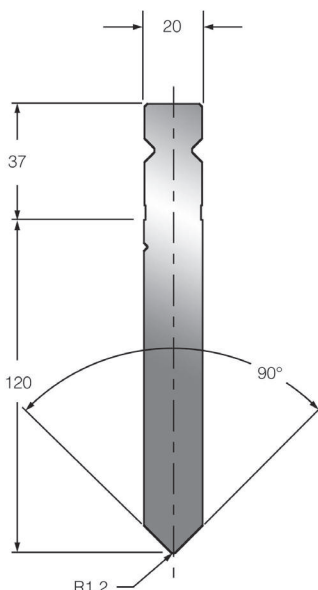
WP004



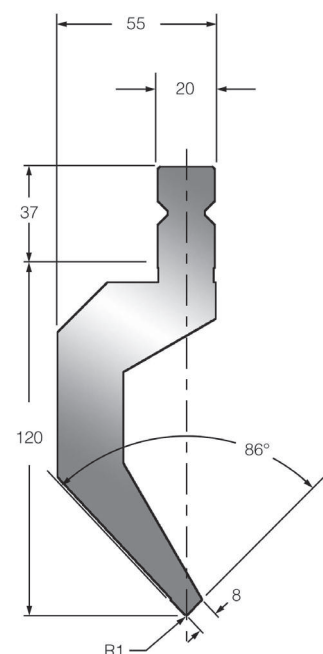
WP001



WP015



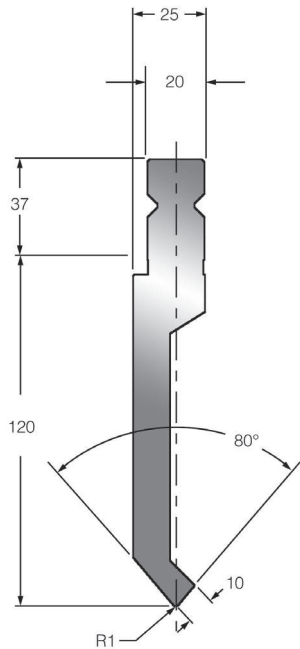
WP016



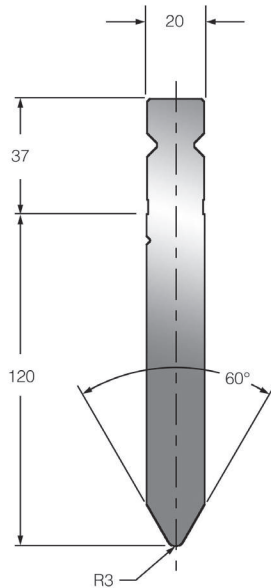
WP013

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
WP003	BIU-003	65	24	86°	135	515 / 200 / 550 sect / 200sect
WP002	BIU-002	100	18	80°	135	515 / 200 / 550 sect / 200sect
WP004	BIU-004	160	20,5	60°	135	515 / 200 / 550 sect / 200sect
WP001	BIU-001	100	14,5	28°	135	515 / 200 / 550 sect / 200sect
WP015	BIU-015	60	21	90°	157	515 / 200 / 550 sect / 200sect
WP016	BIU-016	100	24	90°	157	515 / 200 / 550 sect / 200sect
WP013	BIU-013	65	30	86°	157	515 / 200 / 550 sect / 200sect

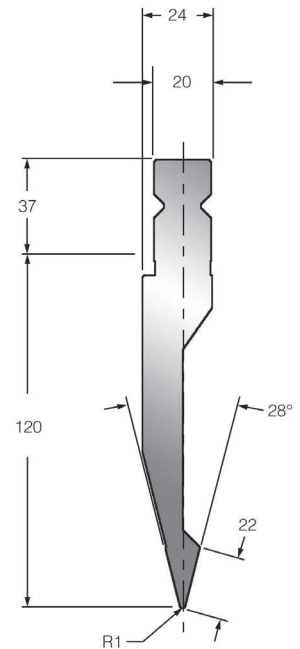
Punches - Height 157mm



WP012



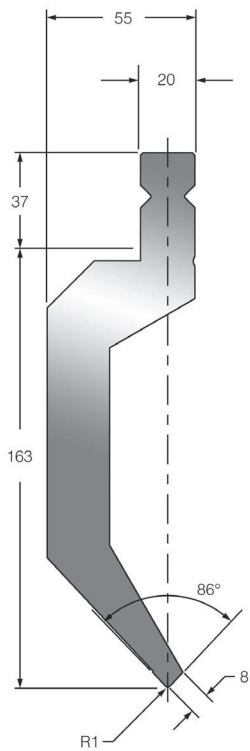
WP014



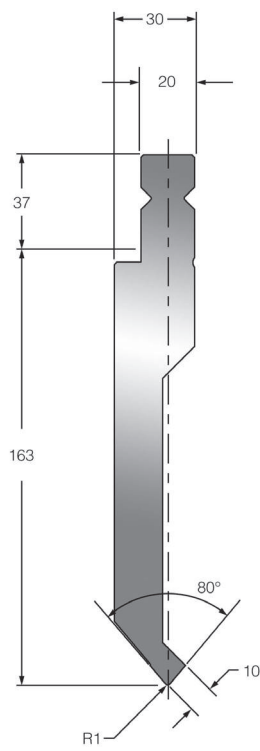
WP011

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
WP012	BIU-012	100	21	80°	157	515 / 200 / 550 sect / 200sect
WP014	BIU-014	160	24	60°	157	515 / 200 / 550 sect / 200sect
WP011	BIU-011	100	18,5	28°	157	515 / 200 / 550 sect / 200sect

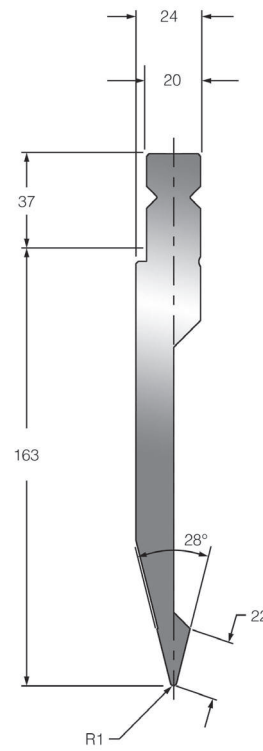
Punches - Height 200mm



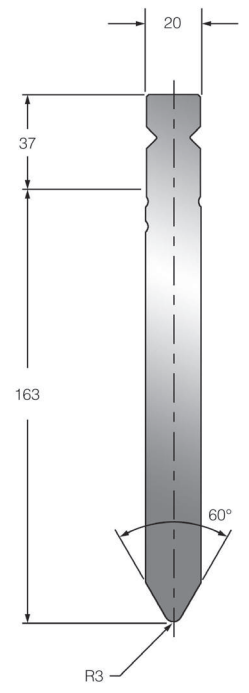
WP023



WP022



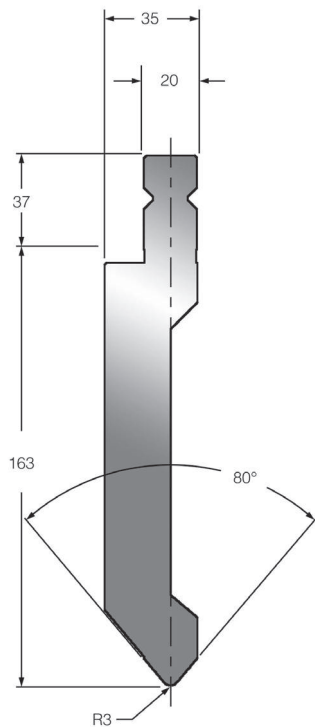
WP021



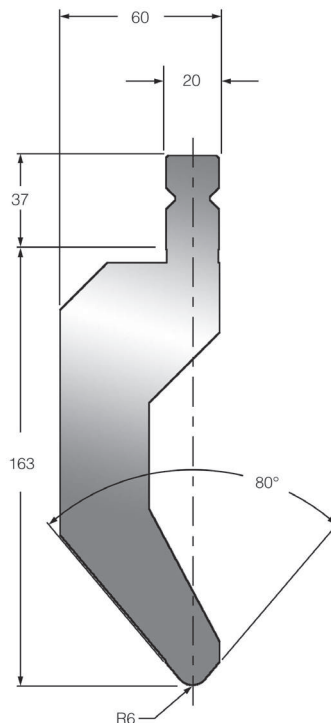
WP024

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
WP023	BIU-023	65	38	86°	200	515 / 200 / 550 sect / 200sect
WP022	BIU-022	80	31,5	80°	200	515 / 200 / 550 sect / 200sect
WP021	BIU-021	70	24	28°	200	515 / 200 / 550 sect / 200sect
WP024	BIU-024	160	31	60°	200	515 / 200 / 550 sect / 200sect

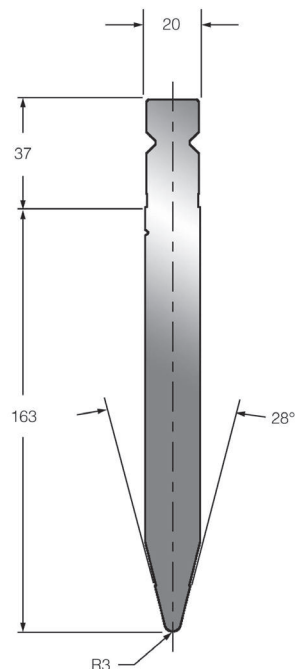
Punches - Height 200mm



WP026



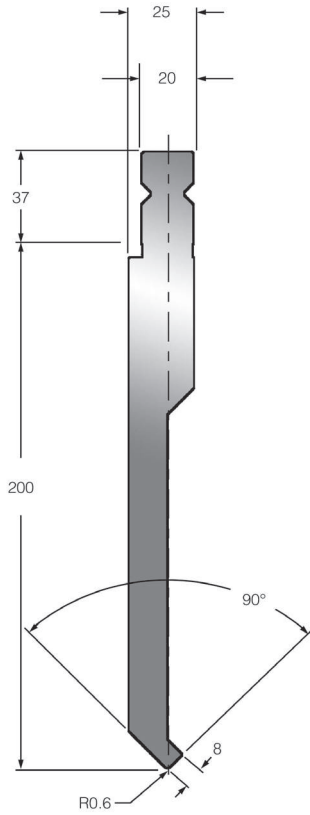
WP025



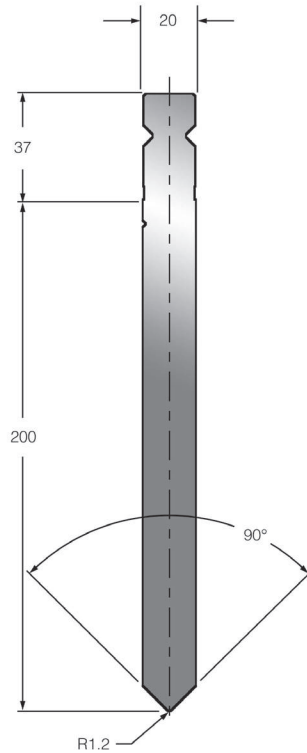
WP029

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
WP026	BIU-026	140	38	80°	200	515 / 200 / 550 sect / 200sect
WP025	BIU-025	130	53	80°	200	515 / 200 / 550 sect / 200sect
WP029	BIU-029	160	30,3	28°	200	515 / 200 / 550 sect / 200sect

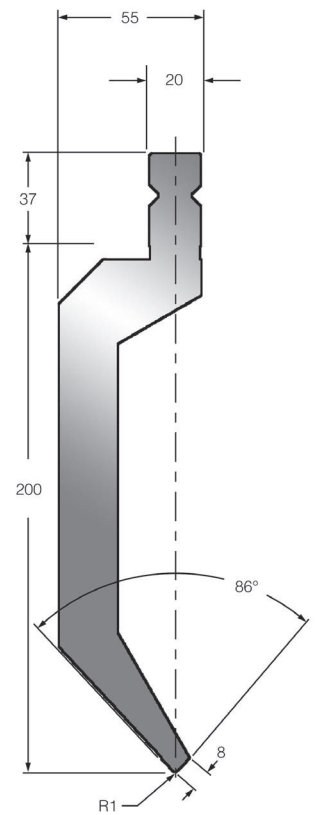
Punches - Height 237mm



WP035



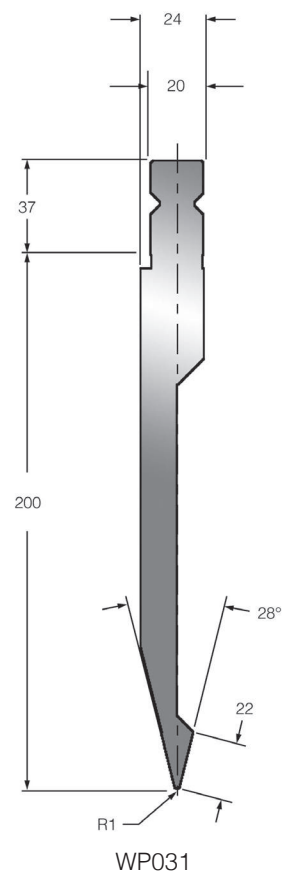
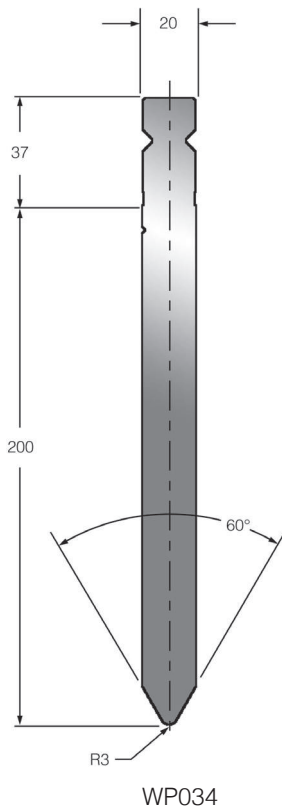
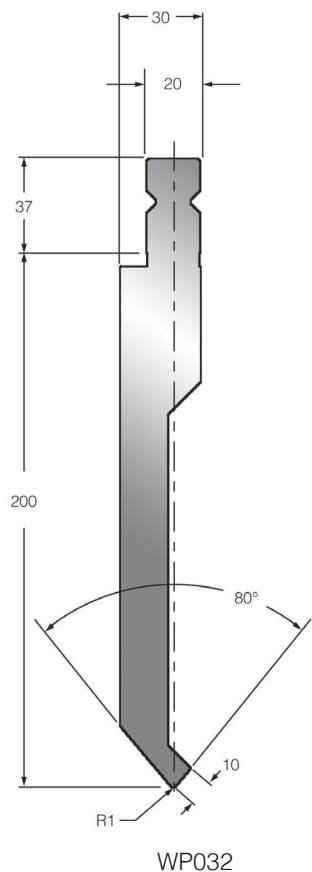
WP036



WP033

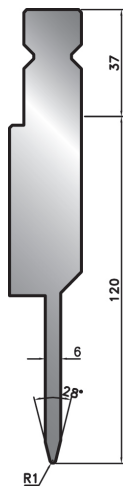
Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
WP035	BIU-035	60	34	90°	237	515 / 200 / 550 sect / 200sect
WP036	BIU-036	100	37	90°	237	515 / 200 / 550 sect / 200sect
WP033	BIU-033	50	45	86°	237	515 / 200 / 550 sect / 200sect

Punches - Height 237mm

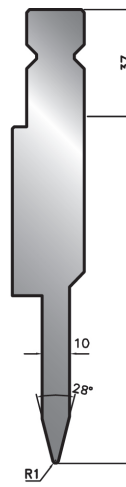


Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lenghts
WP032	BIU-032	70	38,4	80°	237	515 / 200 / 550 sect / 200sect
WP034	BIU-034	160	36,6	60°	237	515 / 200 / 550 sect / 200sect
WP031	BIU-031	60	29	28°	237	515 / 200 / 550 sect / 200sect

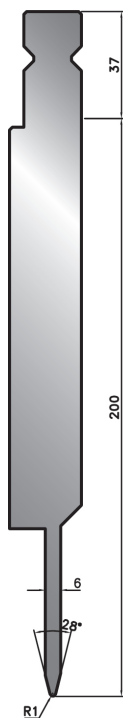
Punches - Hemming Punches



WP061



WP051



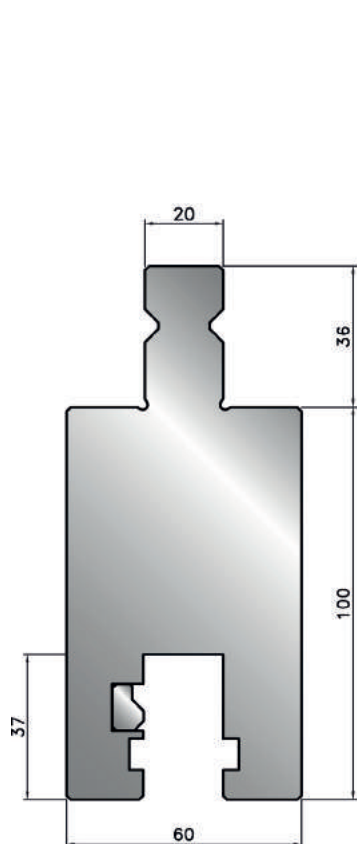
WP063



WP053

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m	Weight Kg/m	Angle	Height	Possible lengths
WP061	BIU-061	50	20,2	28°	157	515 / 200 / 550 sect / 200sect
WP051	BIU-051	100	22	28°	157	515 / 200 / 550 sect / 200sect
WP063	BIU-063	50	37,9	28°	237	515 / 200 / 550 sect / 200sect
WP053	BIU-053	100	37,9	28°	237	515 / 200 / 550 sect / 200sect

Punches adaptors



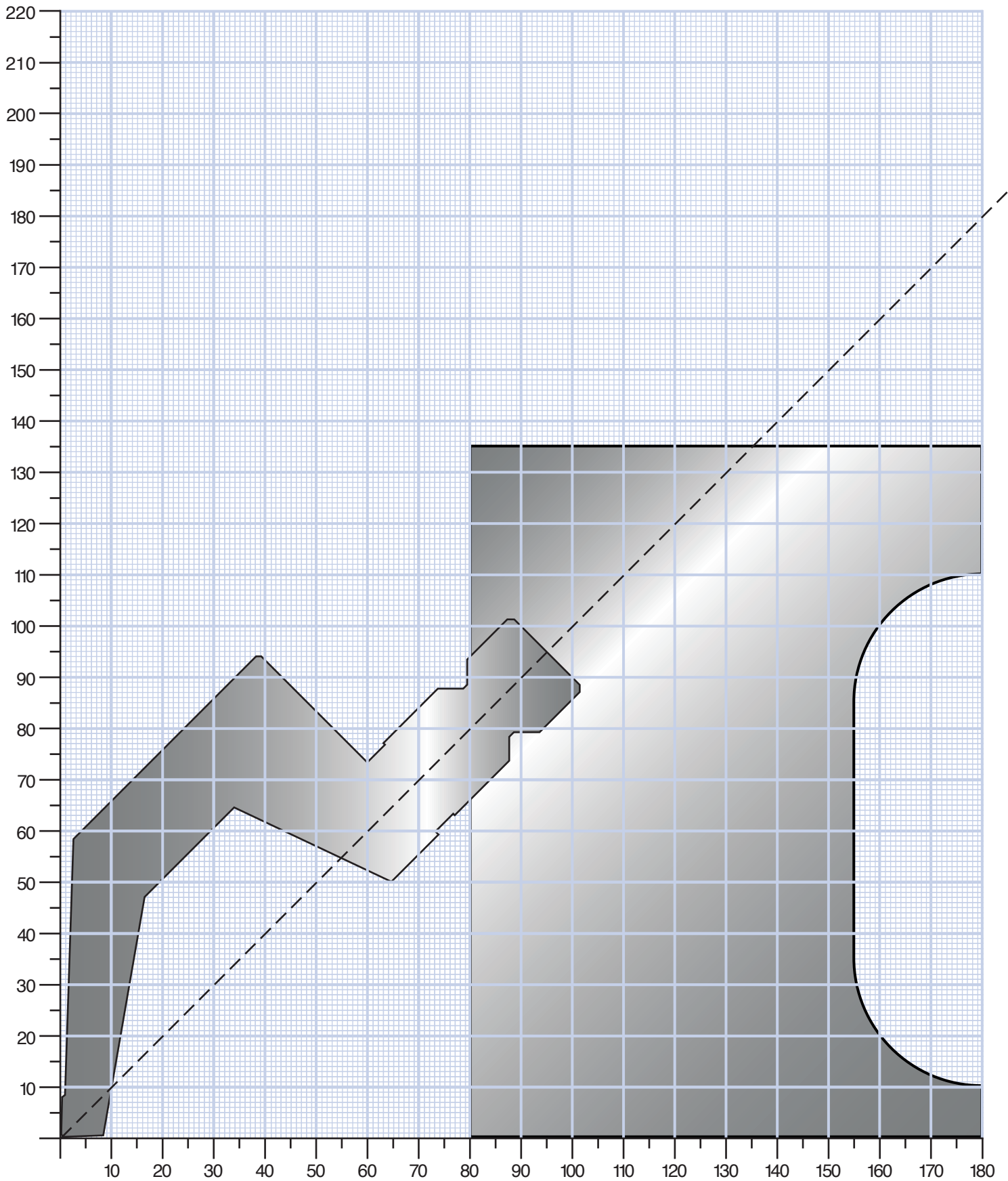
MODUFIX H=100



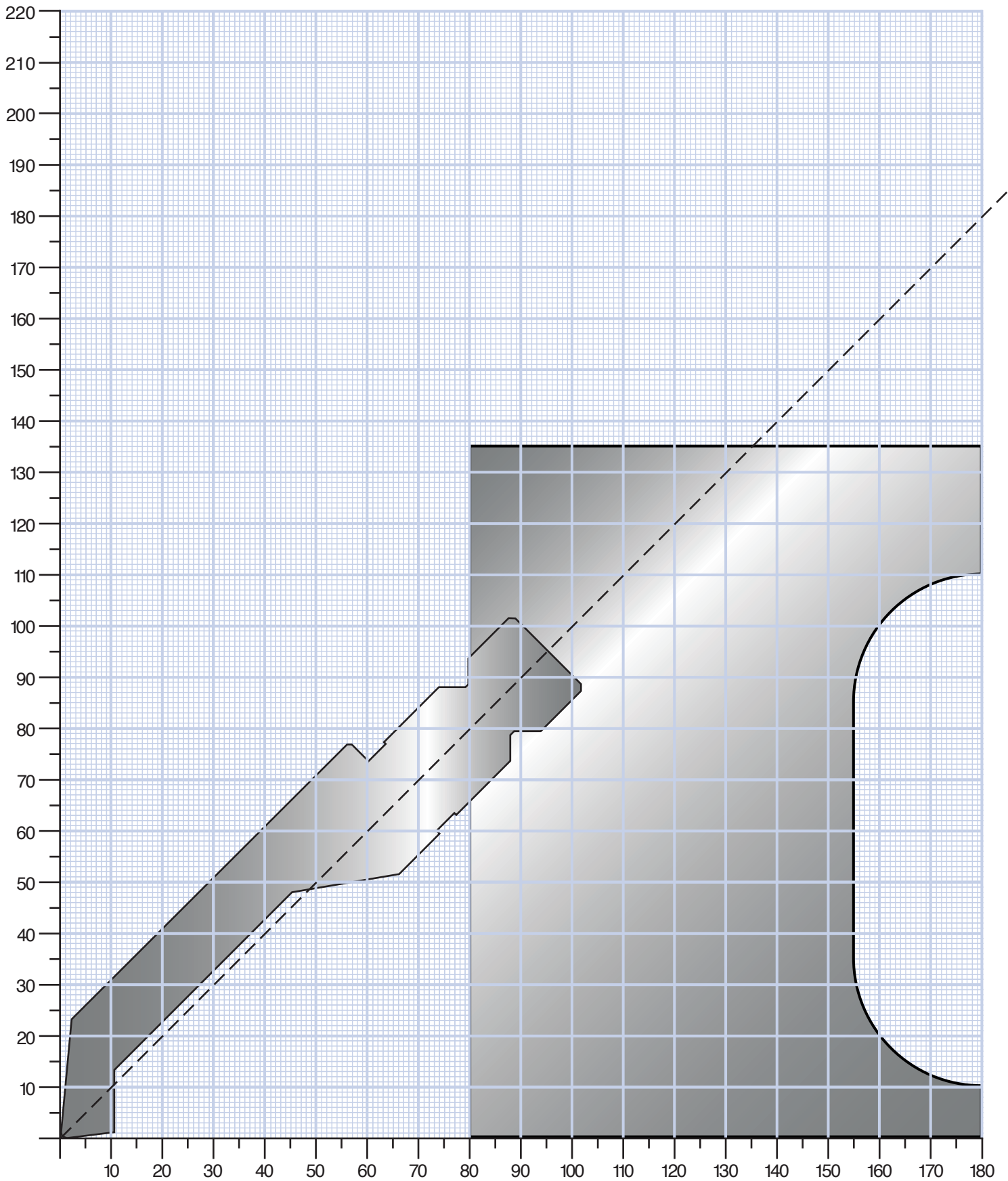
MODUFIX H=150

Toolspress Cat. No.	Max Loading T/m	Weight Kg/m	Height	Possible lengths
Modufix H=100	150	45,3	100	100 / 550 S
Modufix H=150	150	68,6	150	100 / 550 S

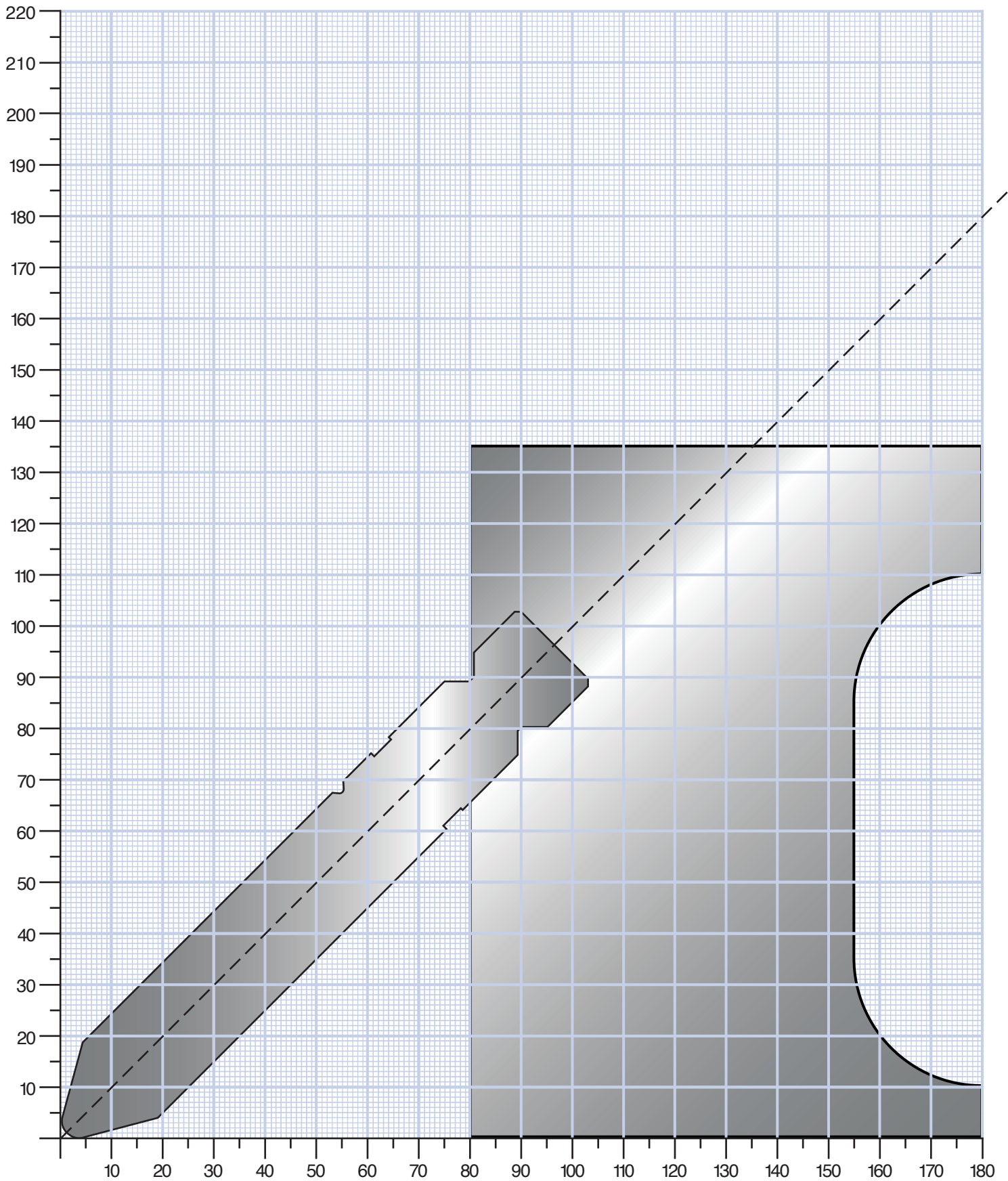
WP003 - Bend Limit Graph



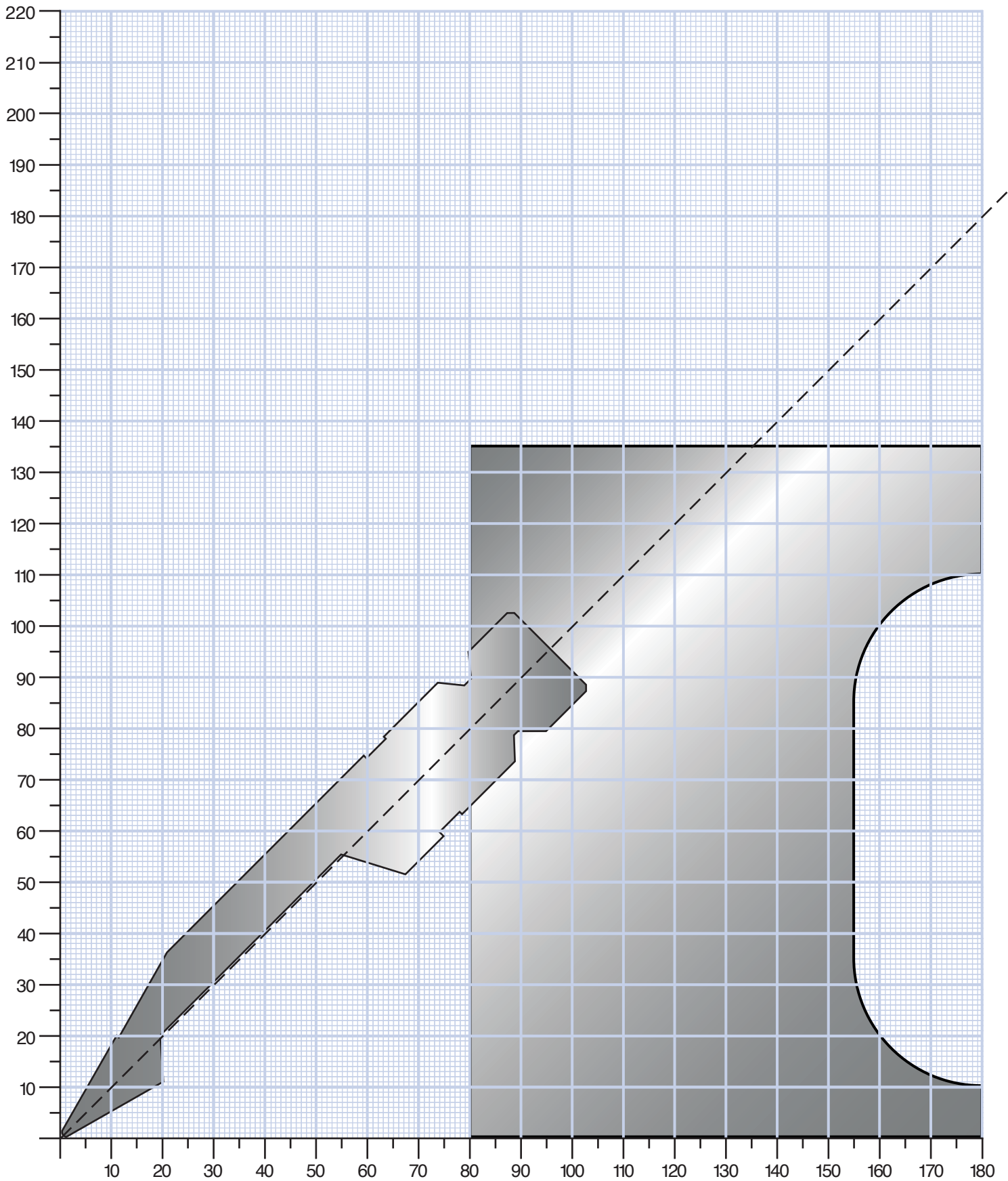
WP002 - Bend Limit Graph



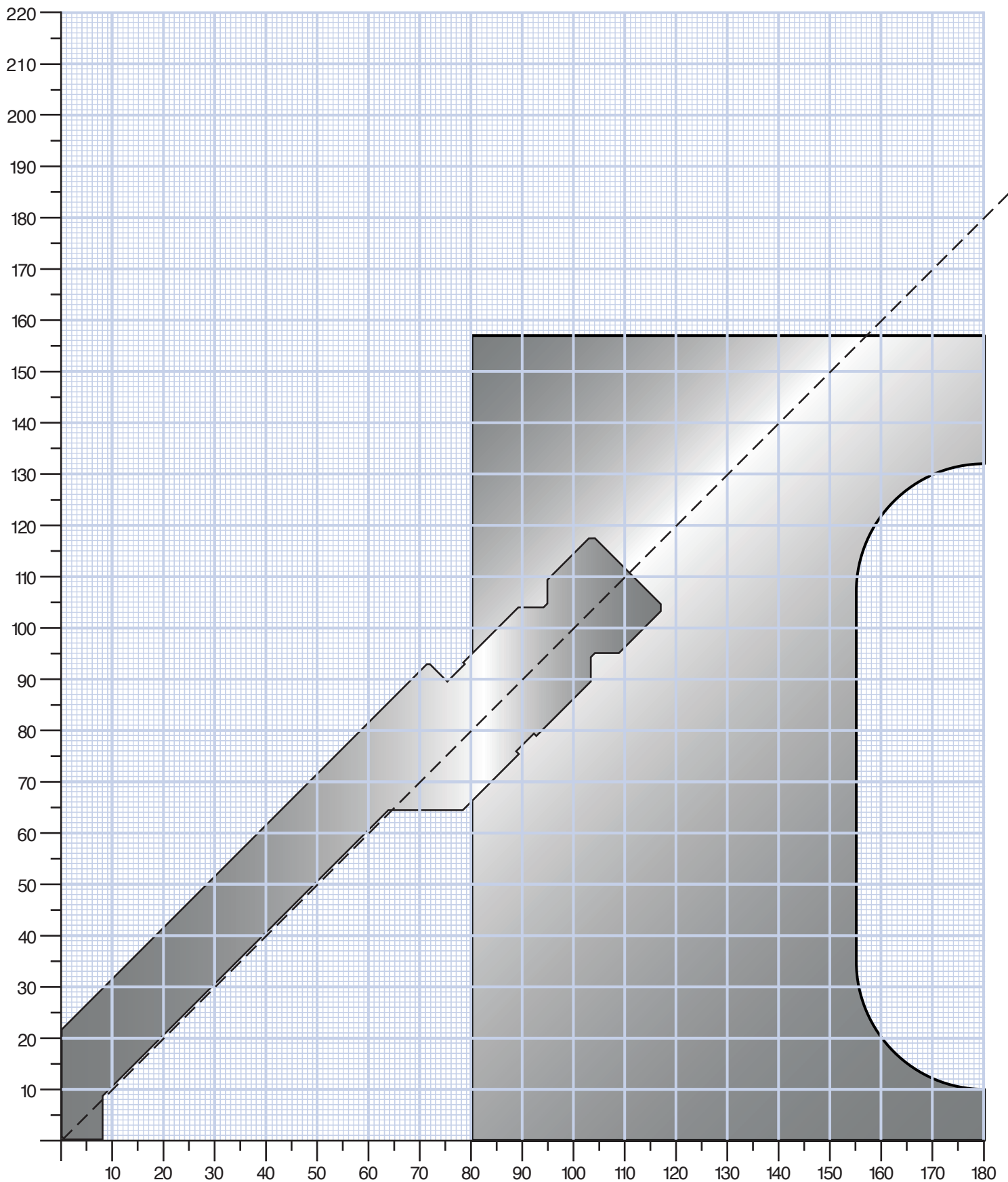
WP004 - Bend Limit Graph



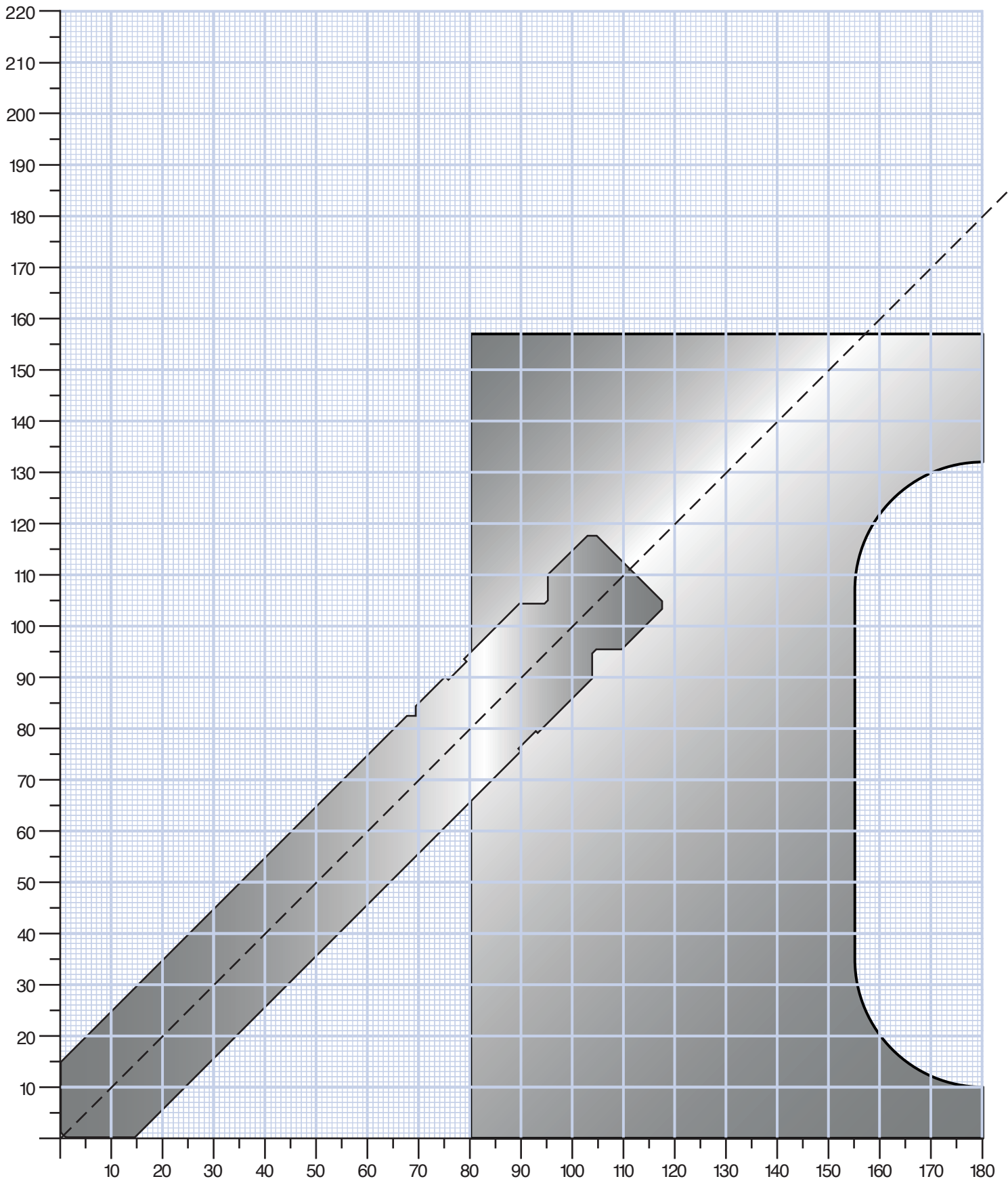
WP001 - Bend Limit Graph



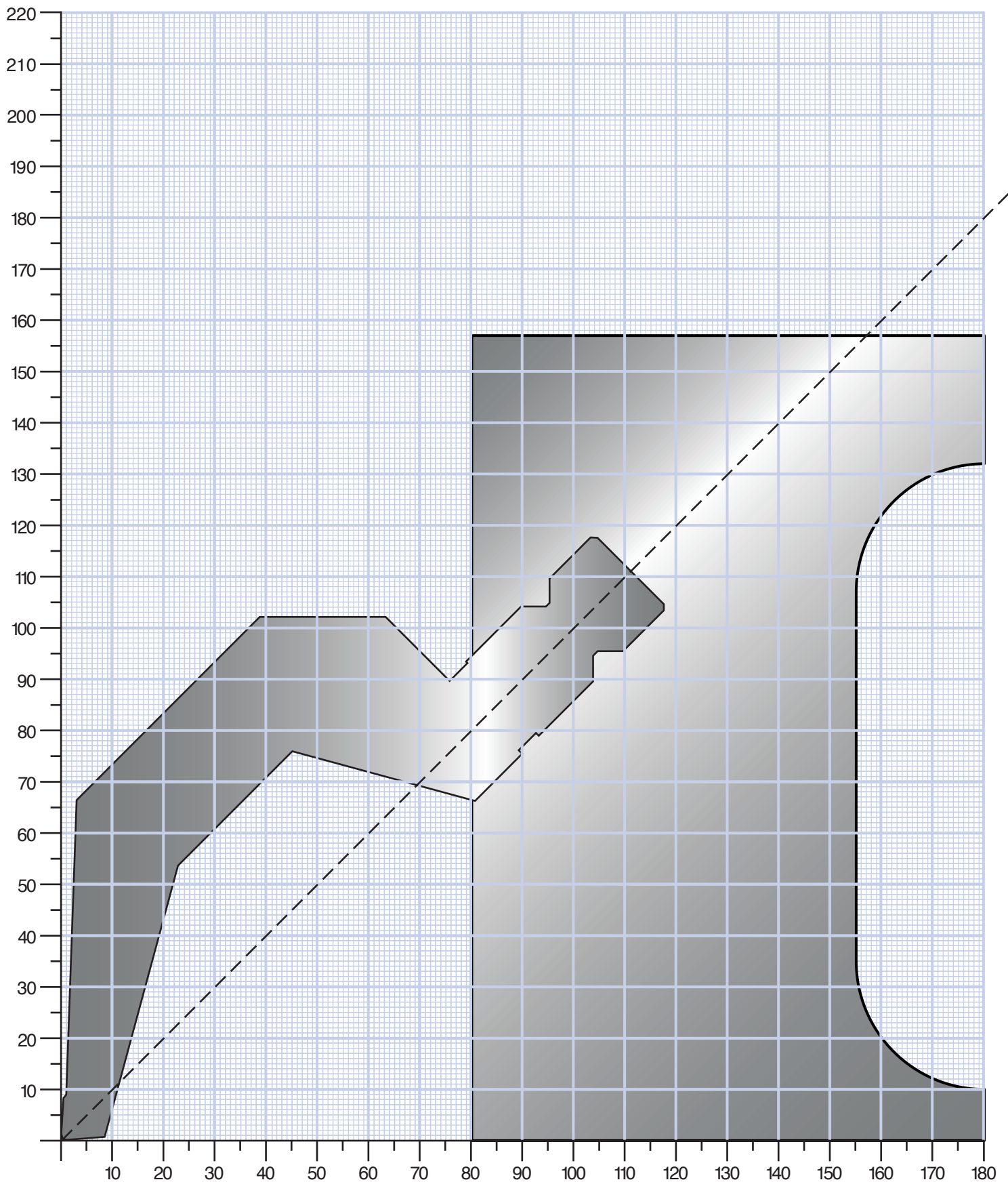
WP015 - Bend Limit Graph



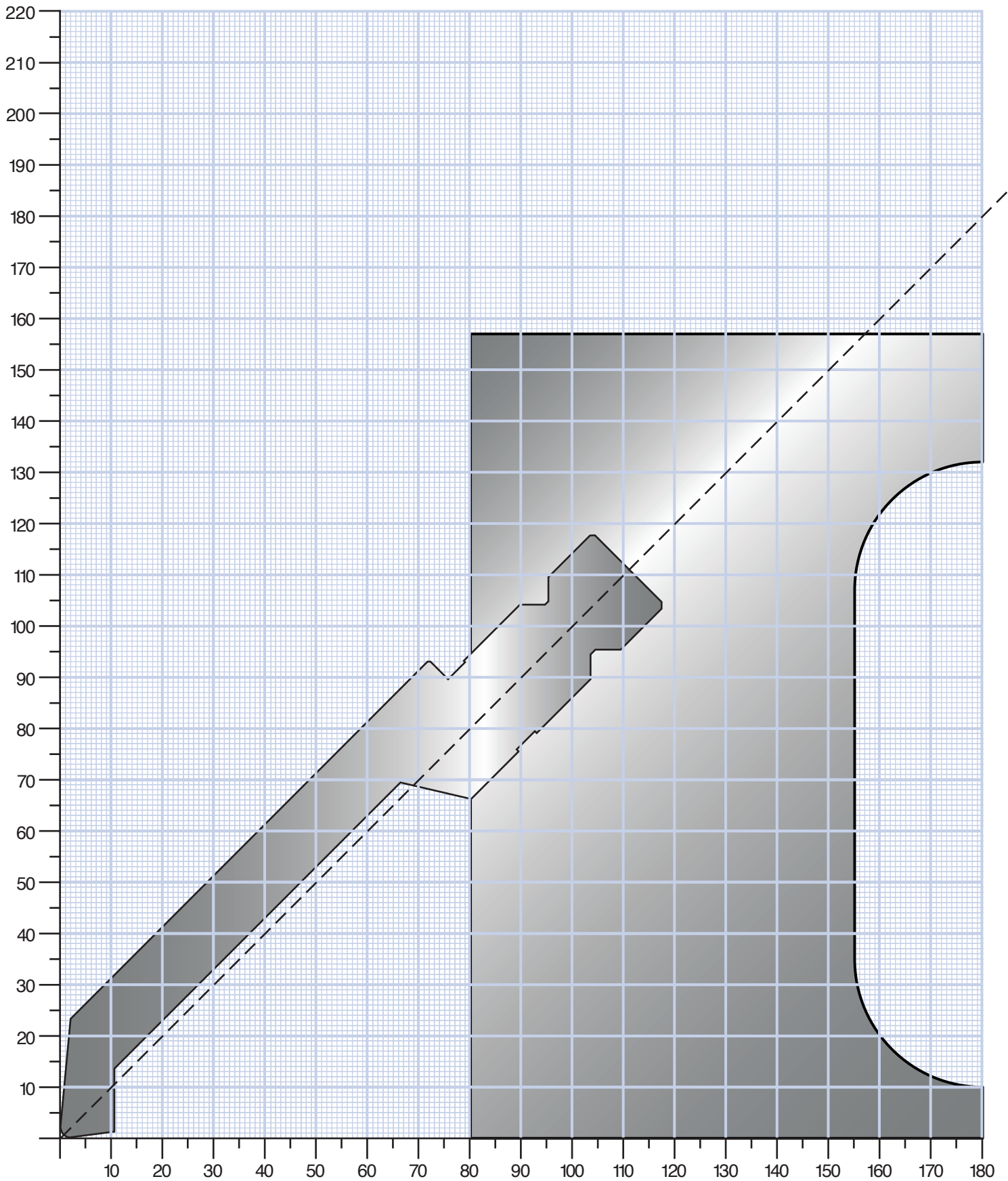
WP016 - Bend Limit Graph



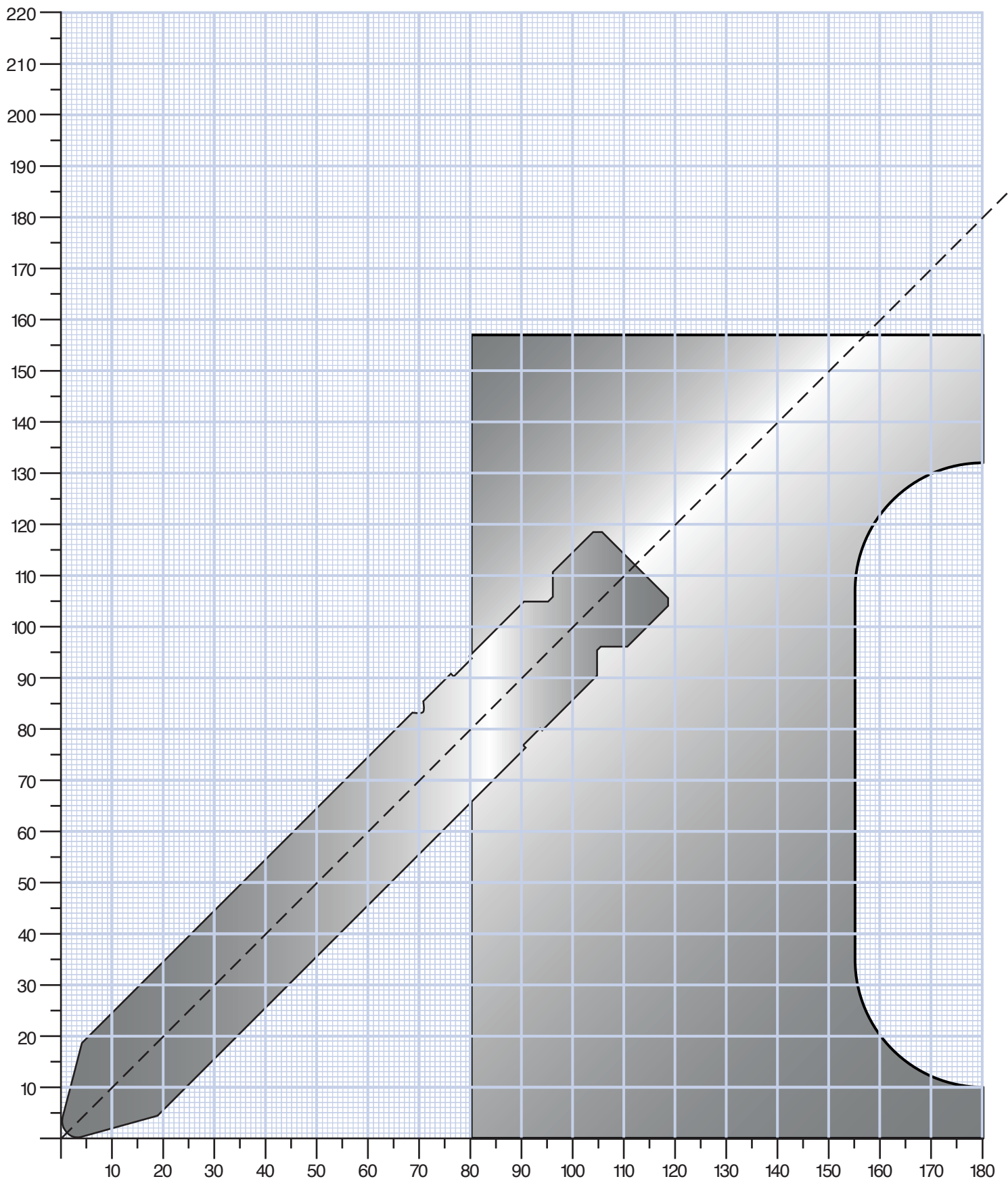
WP013 - Bend Limit Graph



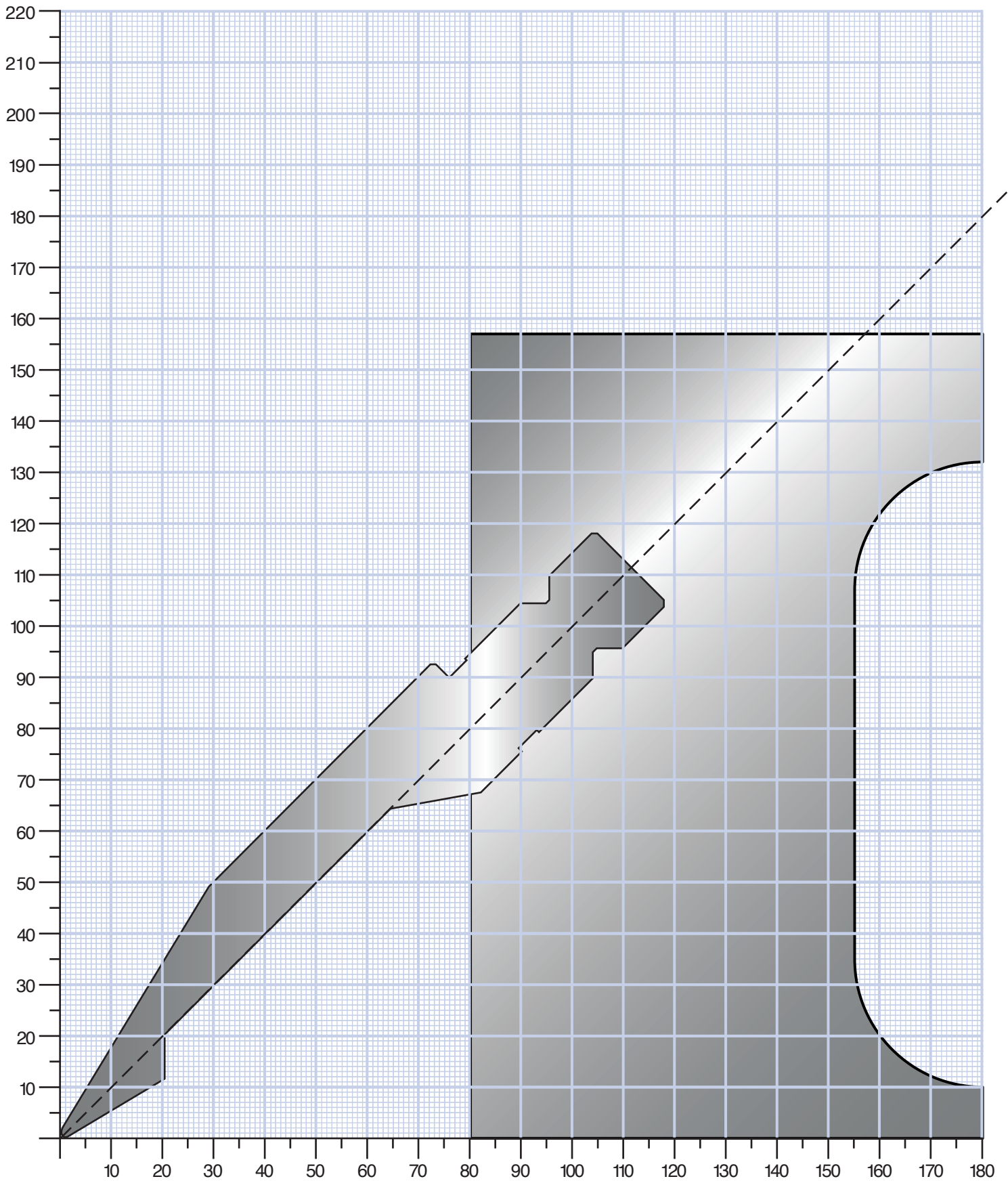
WP012 - Bend Limit Graph



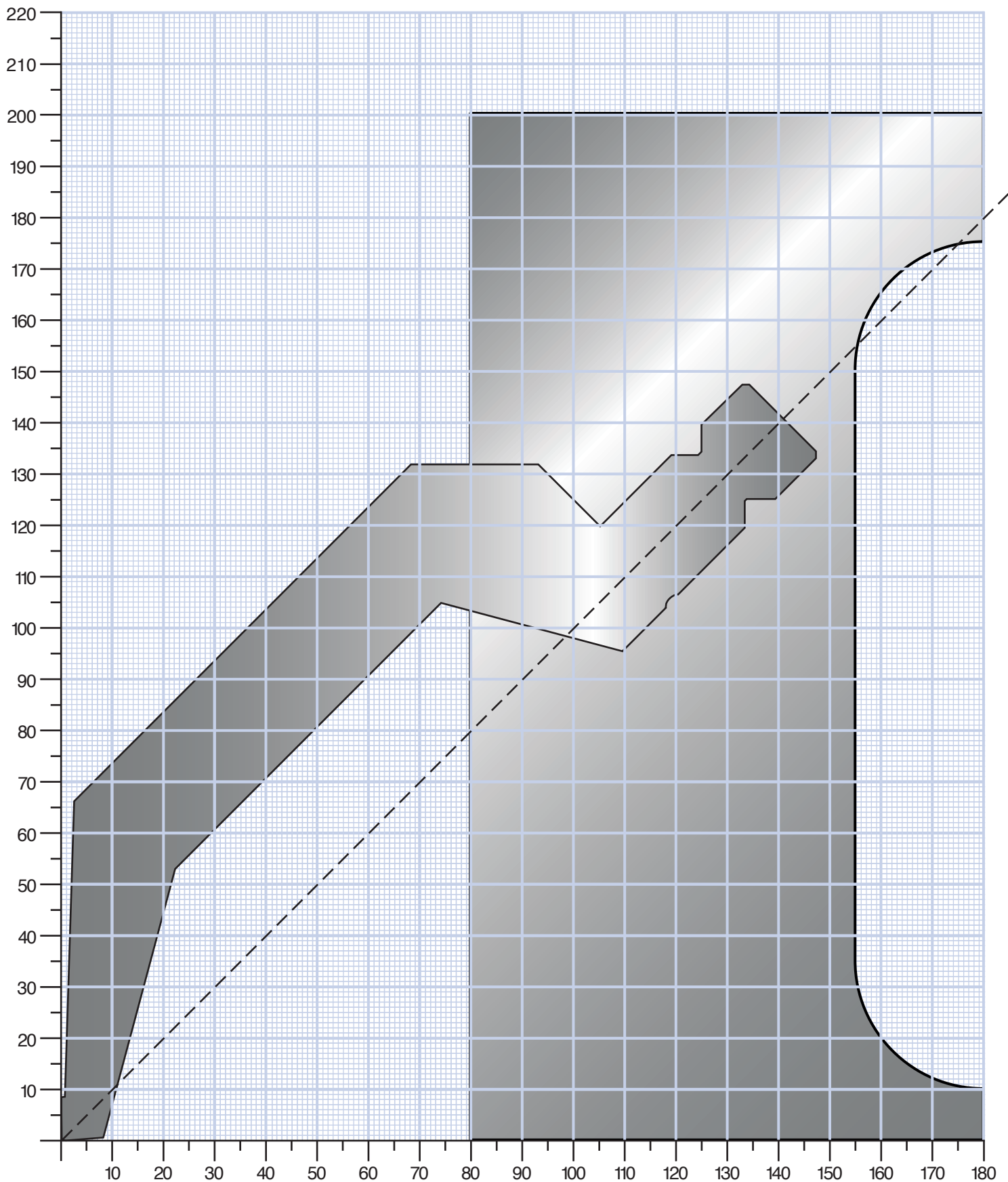
WP014 - Bend Limit Graph



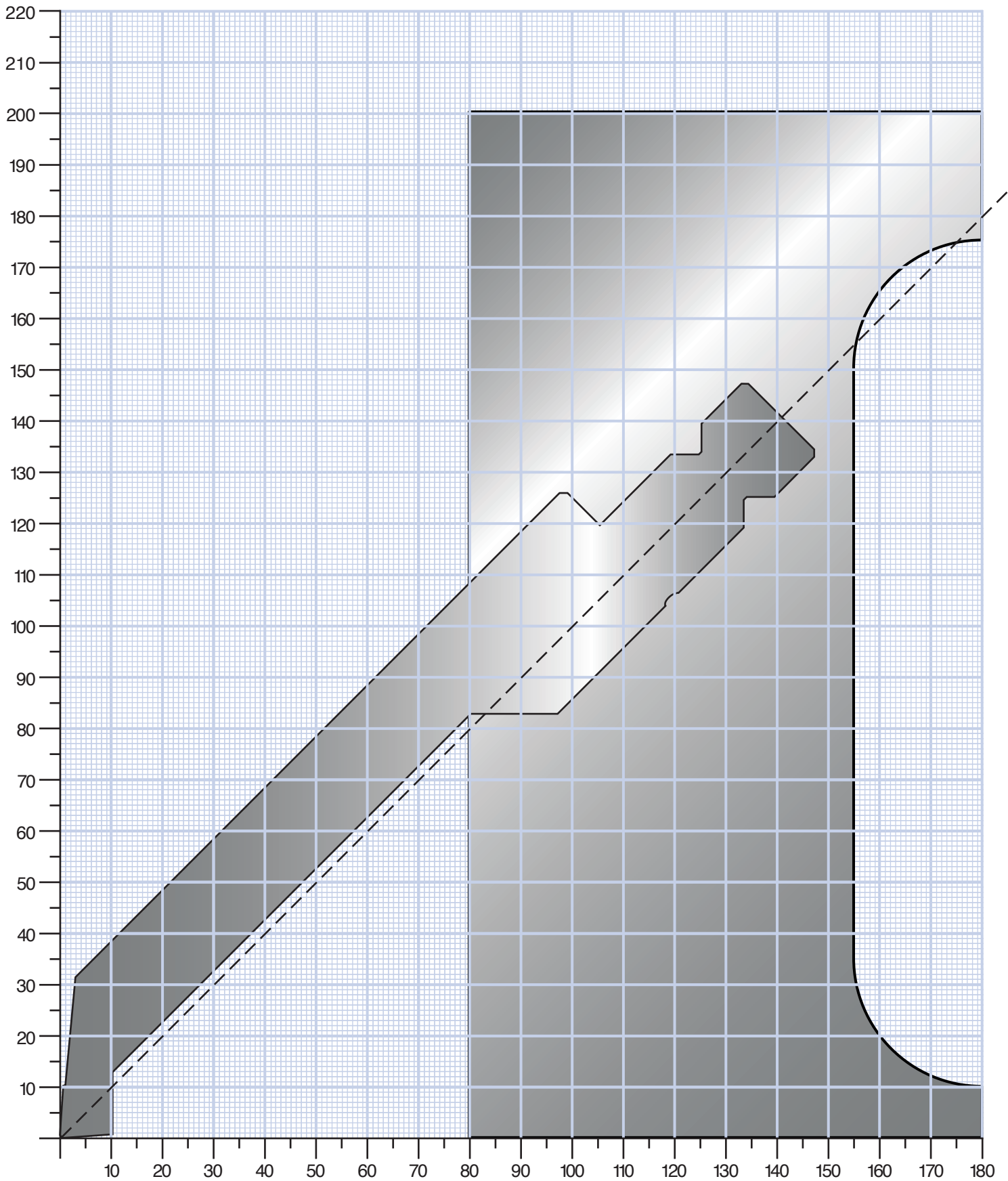
WP011 - Bend Limit Graph



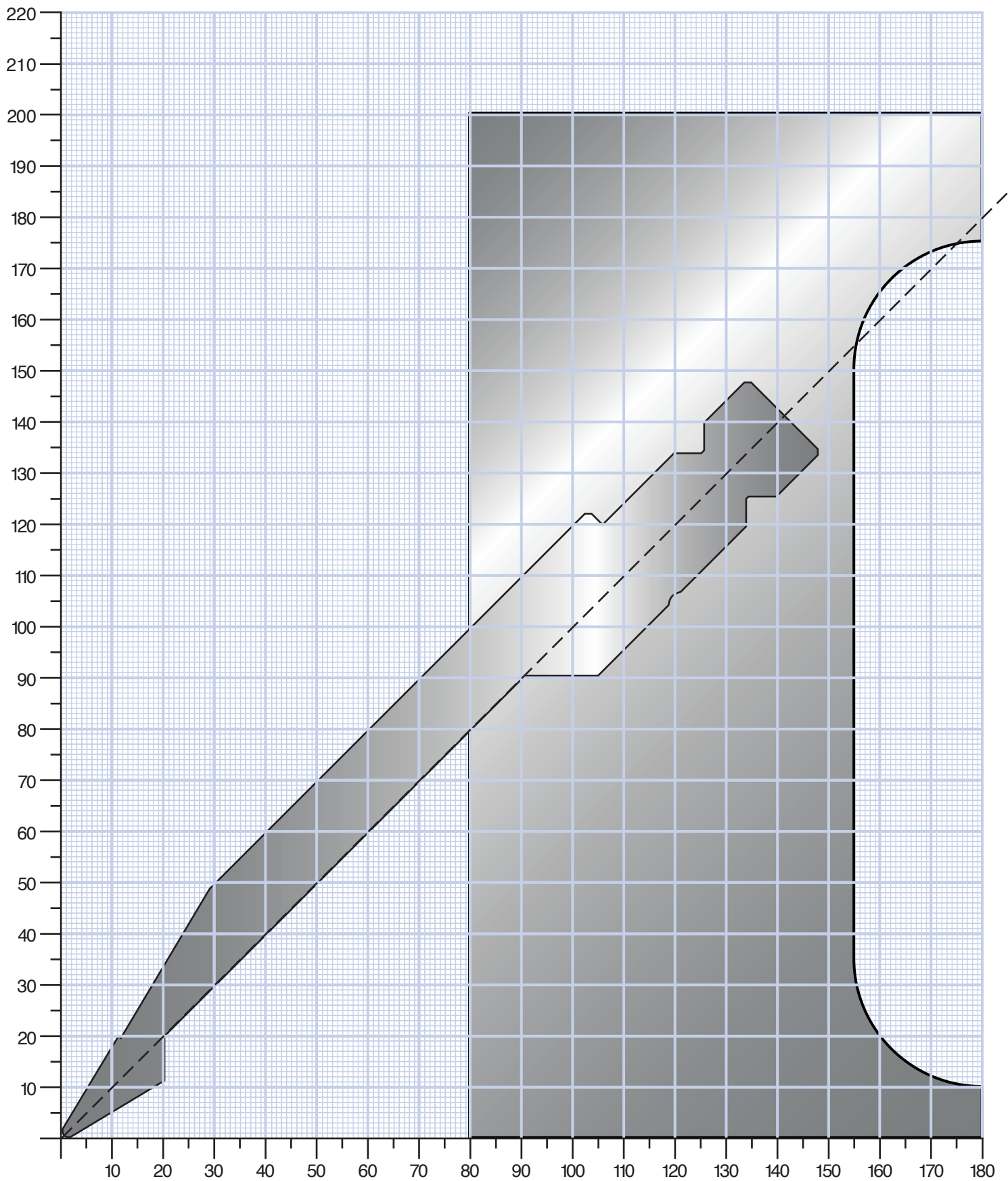
WP023 - Bend Limit Graph



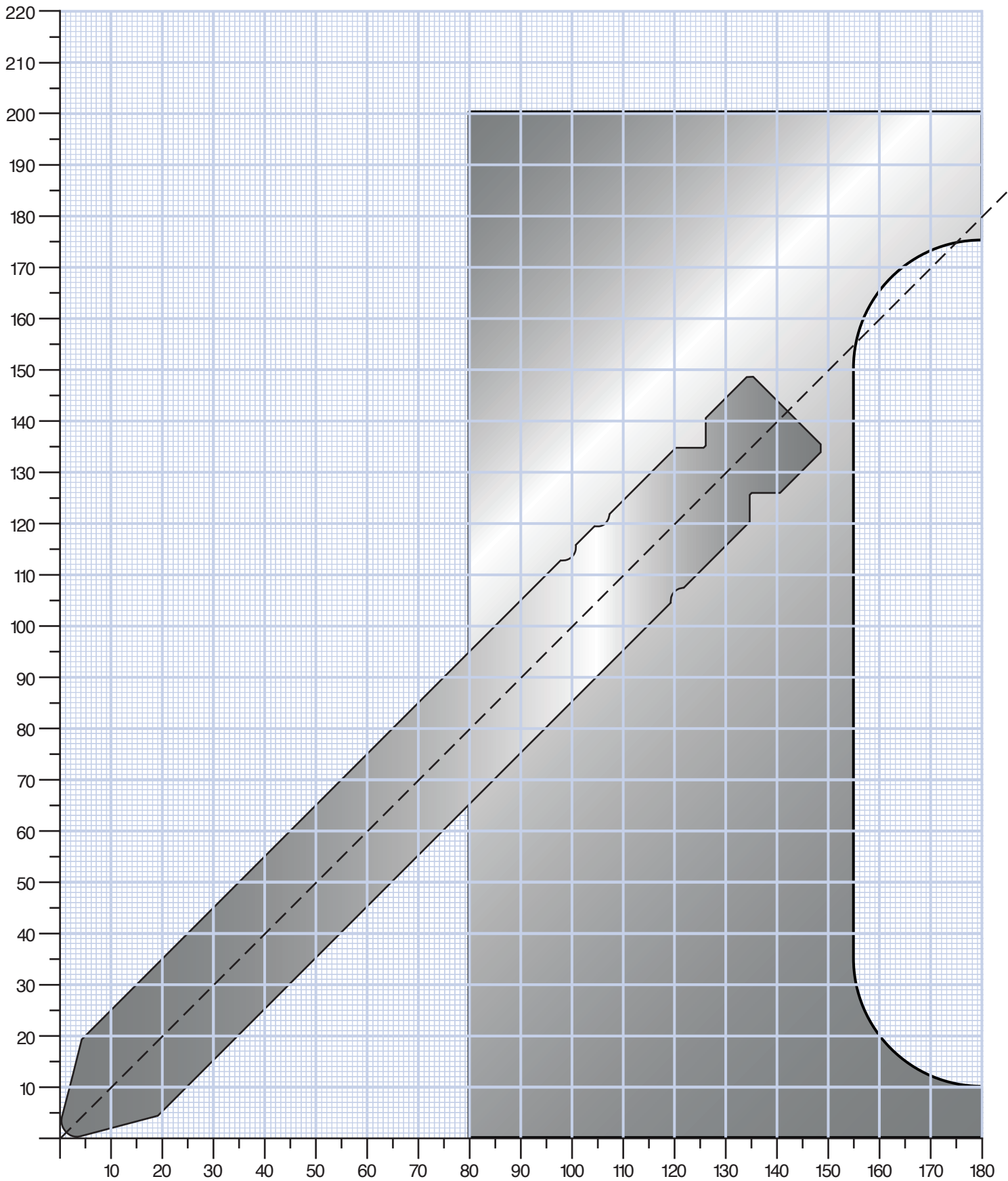
WP022 - Bend Limit Graph



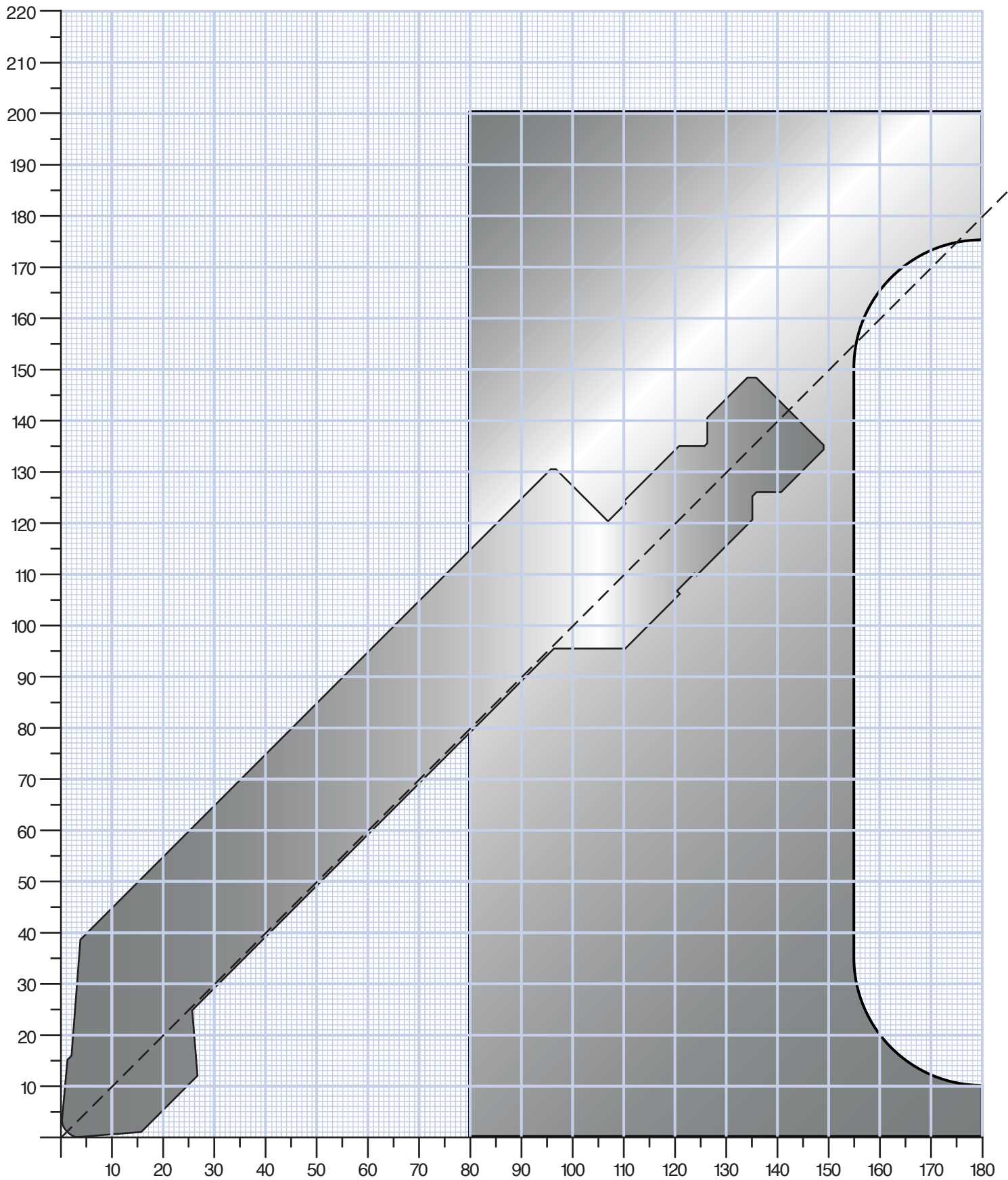
WP021 - Bend Limit Graph



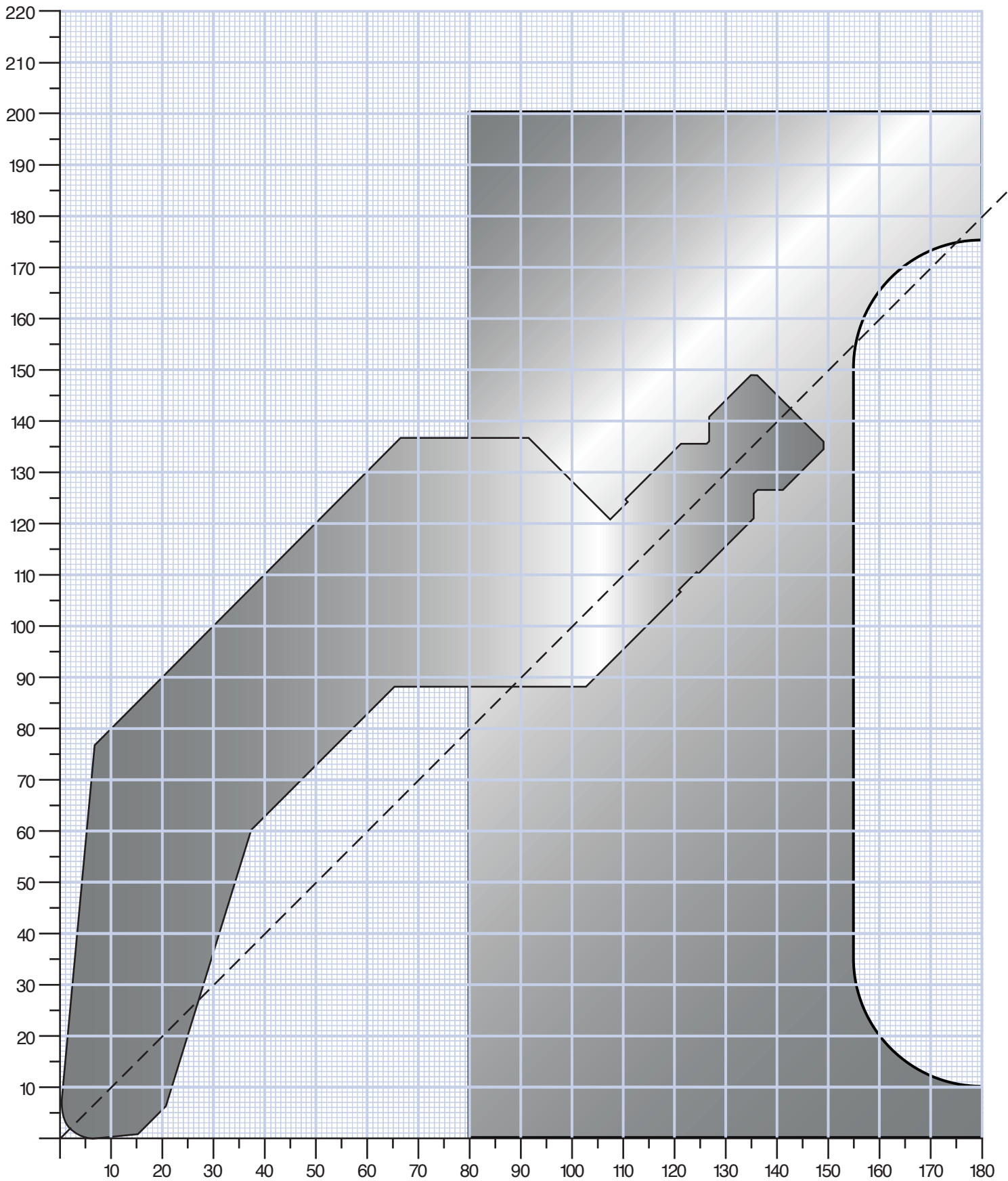
WP024 - Bend Limit Graph



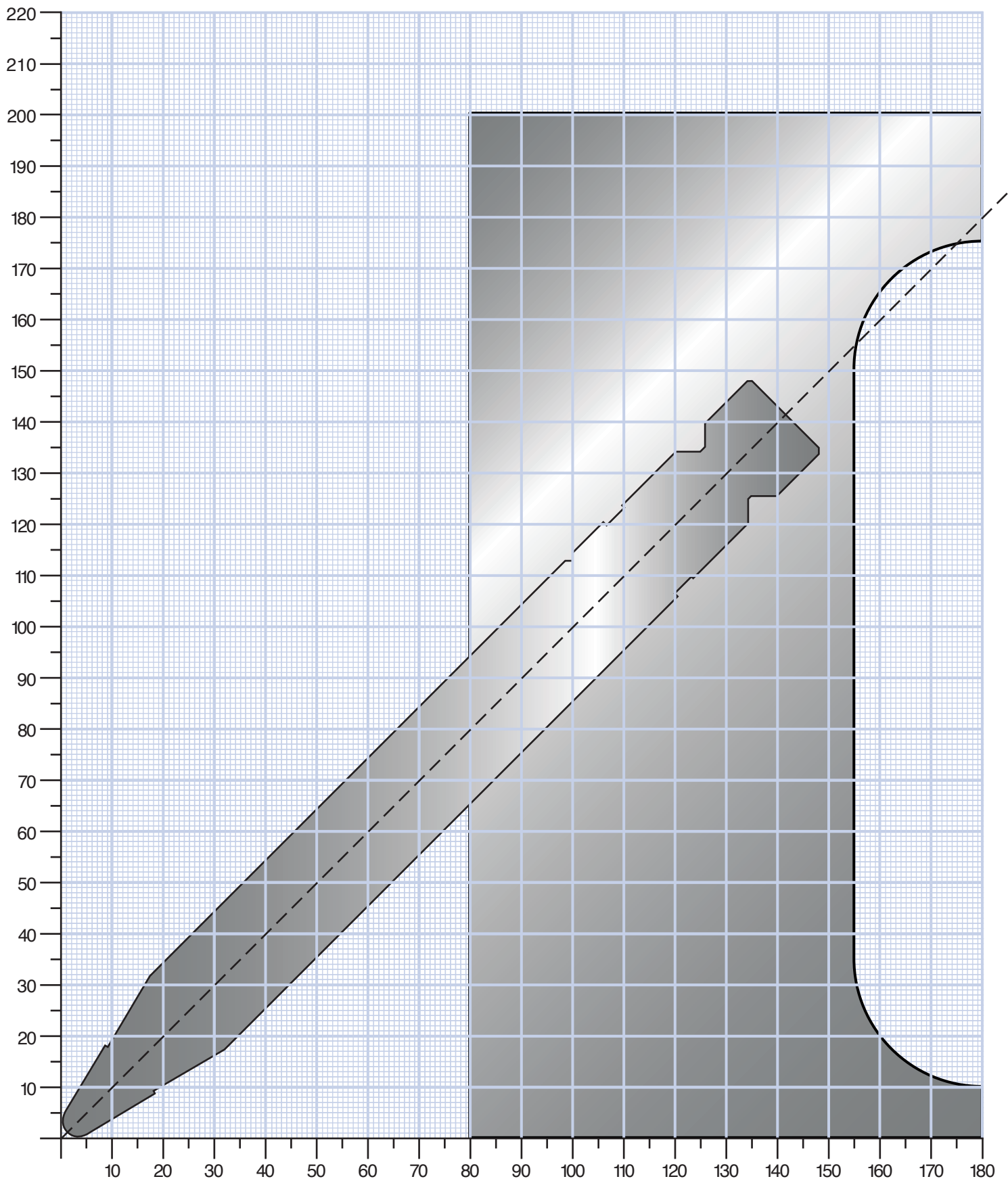
WP026 - Bend Limit Graph



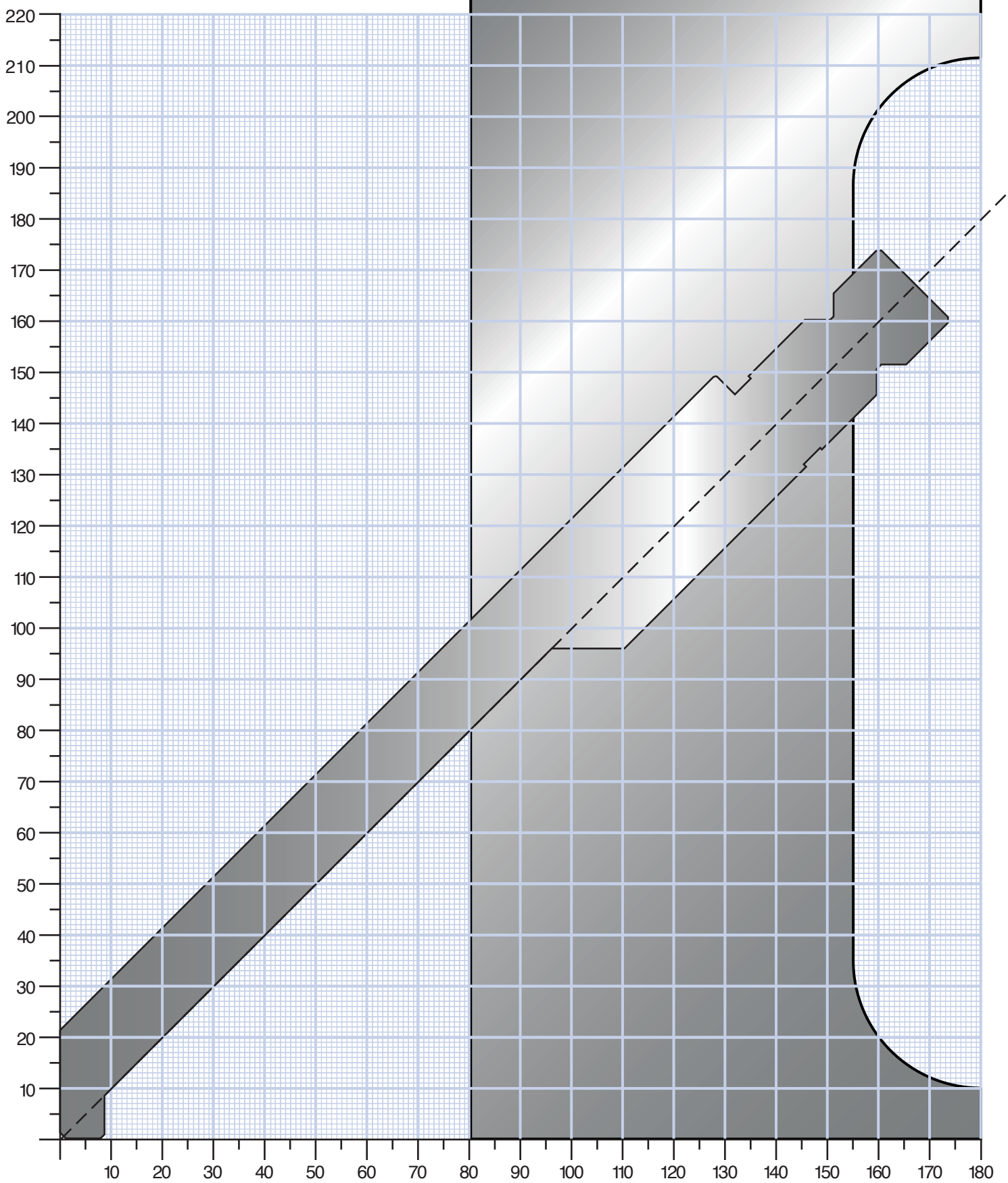
WP025 - Bend Limit Graph



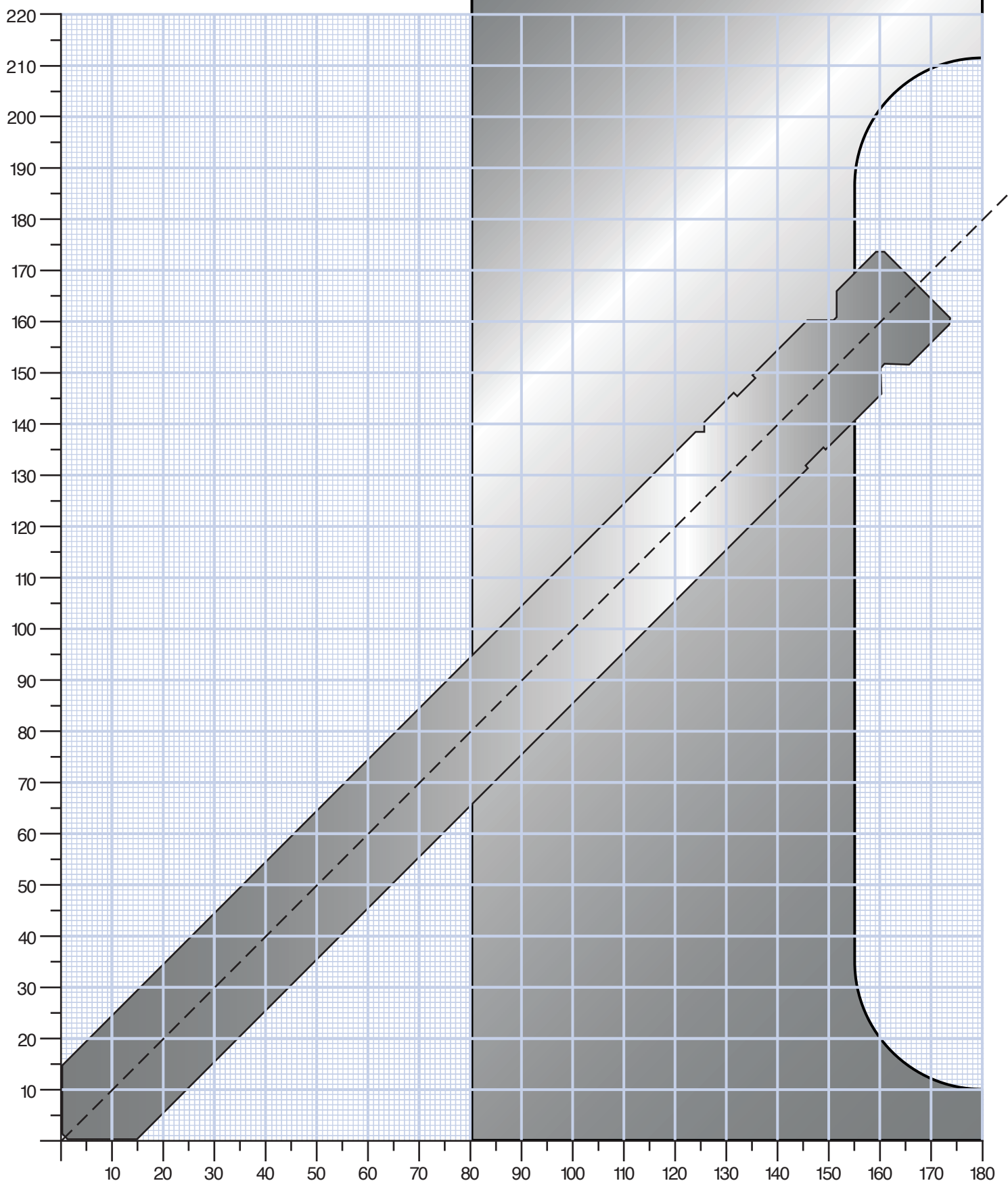
WP029 - Bend Limit Graph



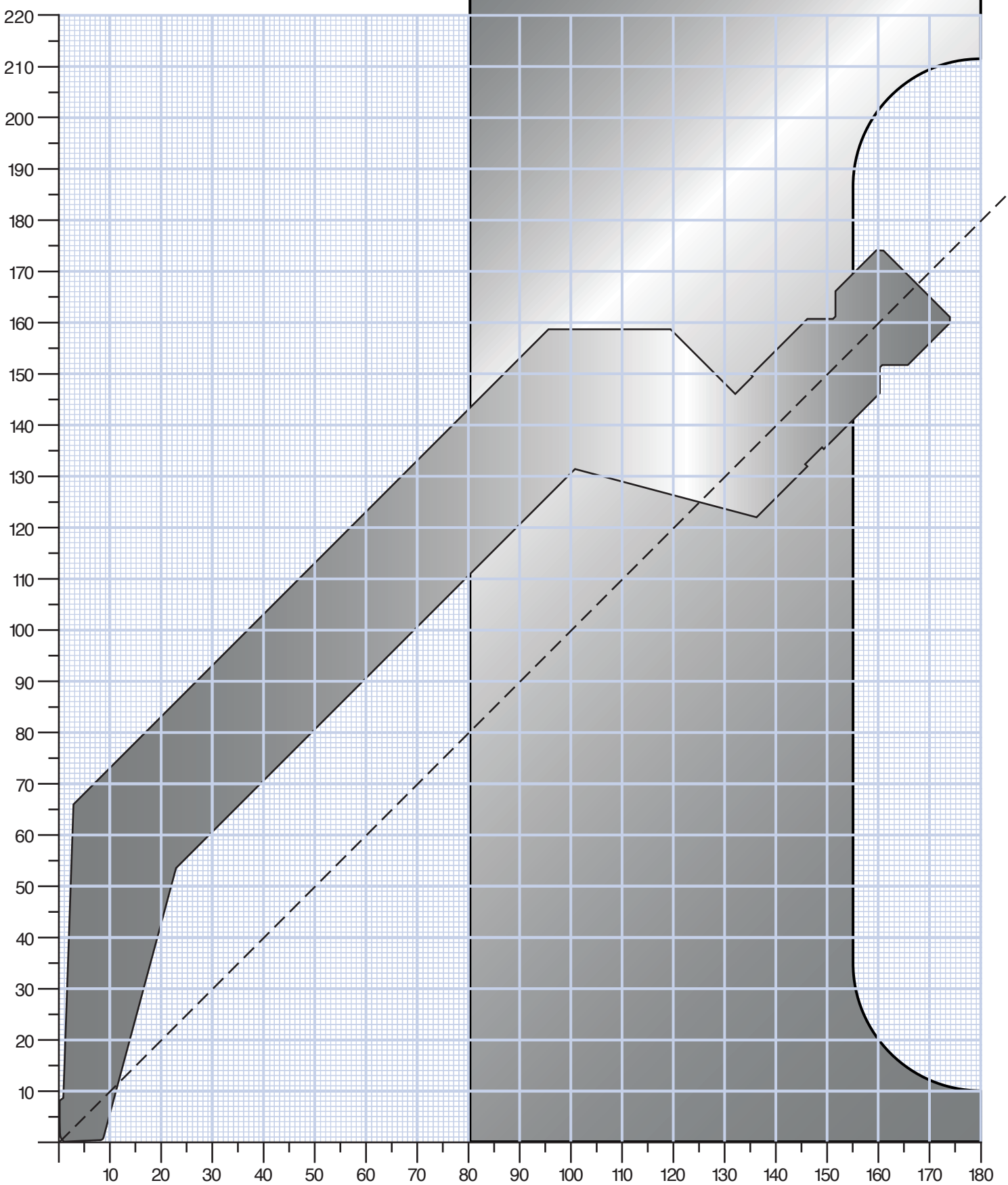
WP035 - Bend Limit Graph



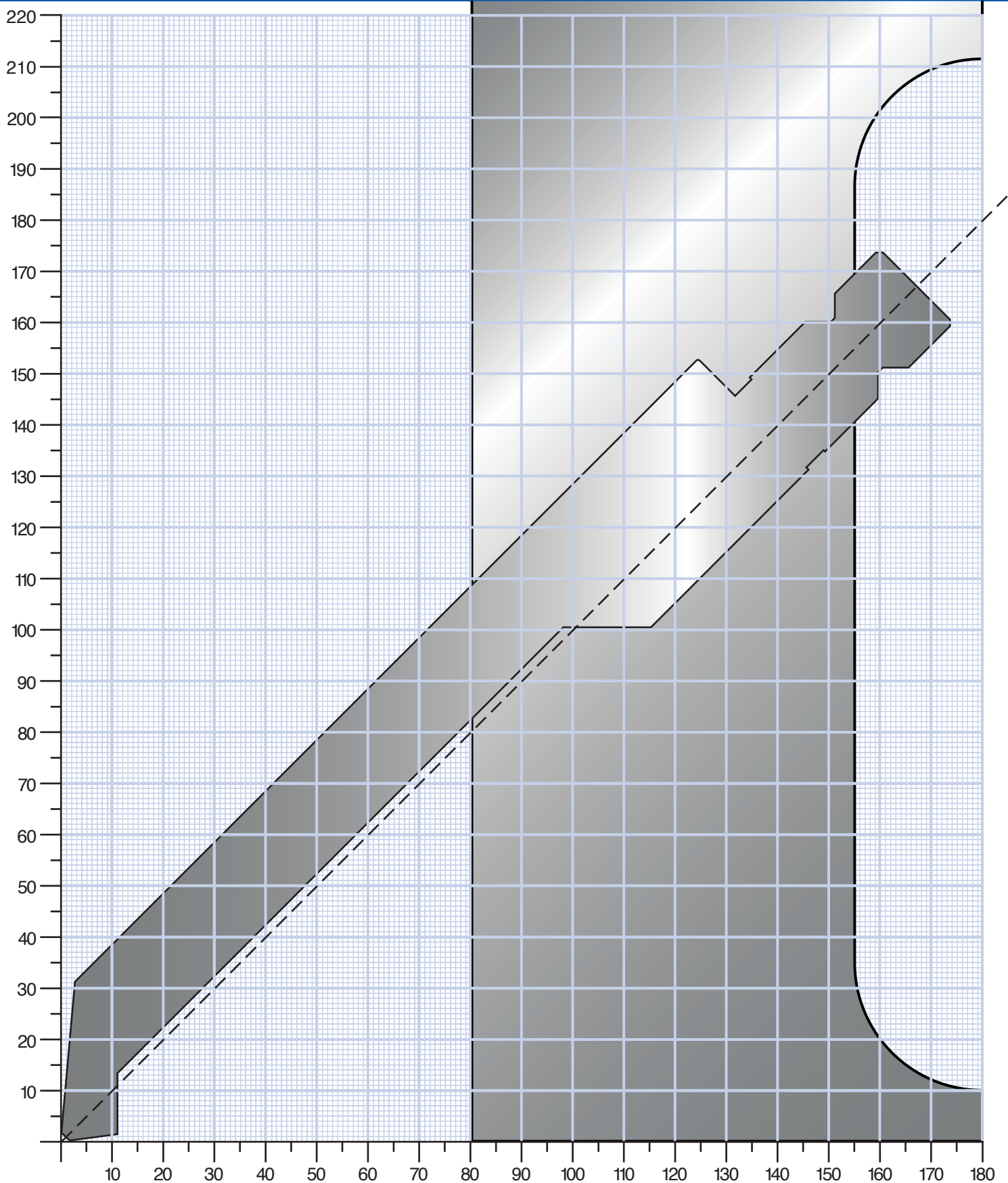
WP036 - Bend Limit Graph



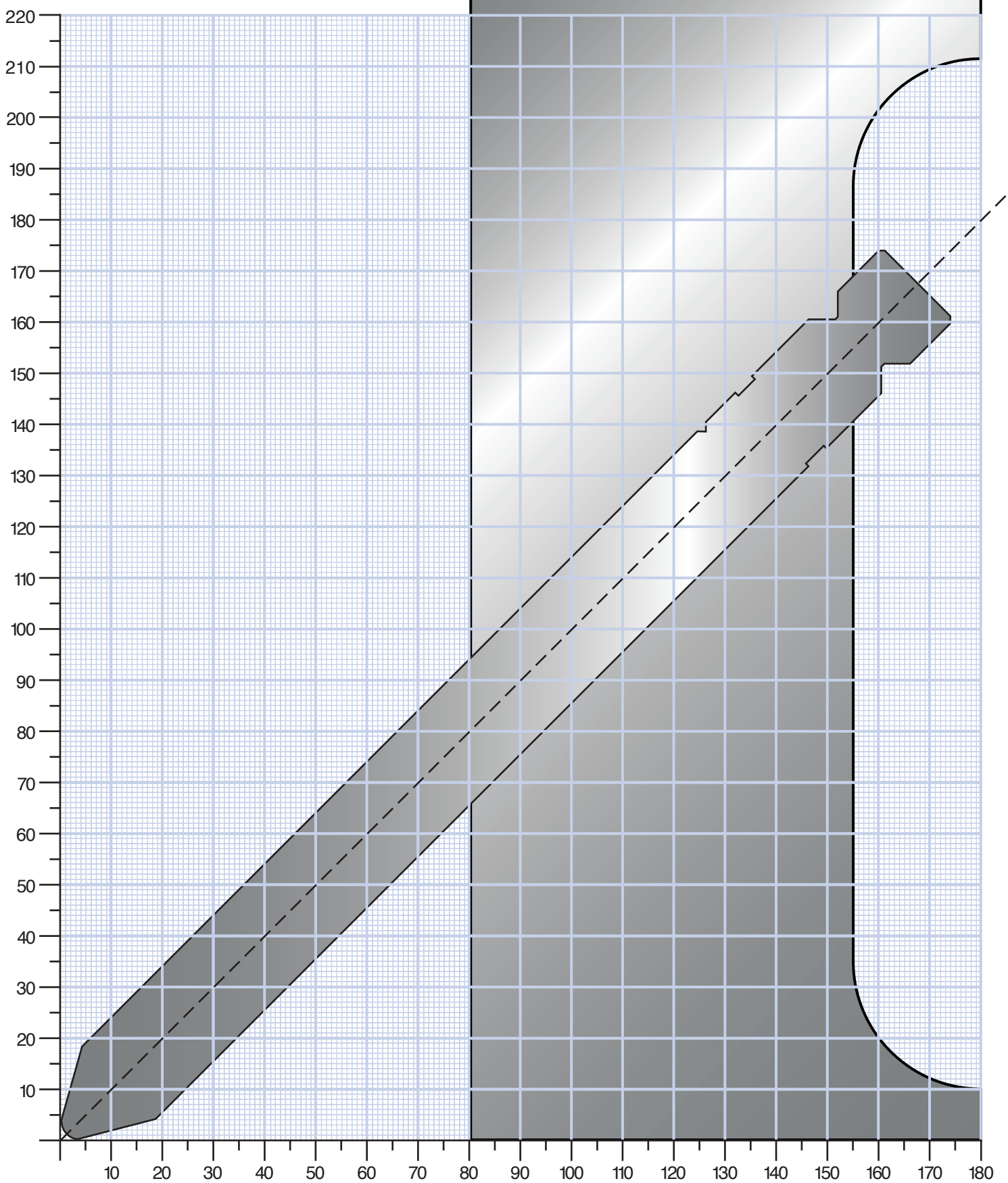
WP033 - Bend Limit Graph



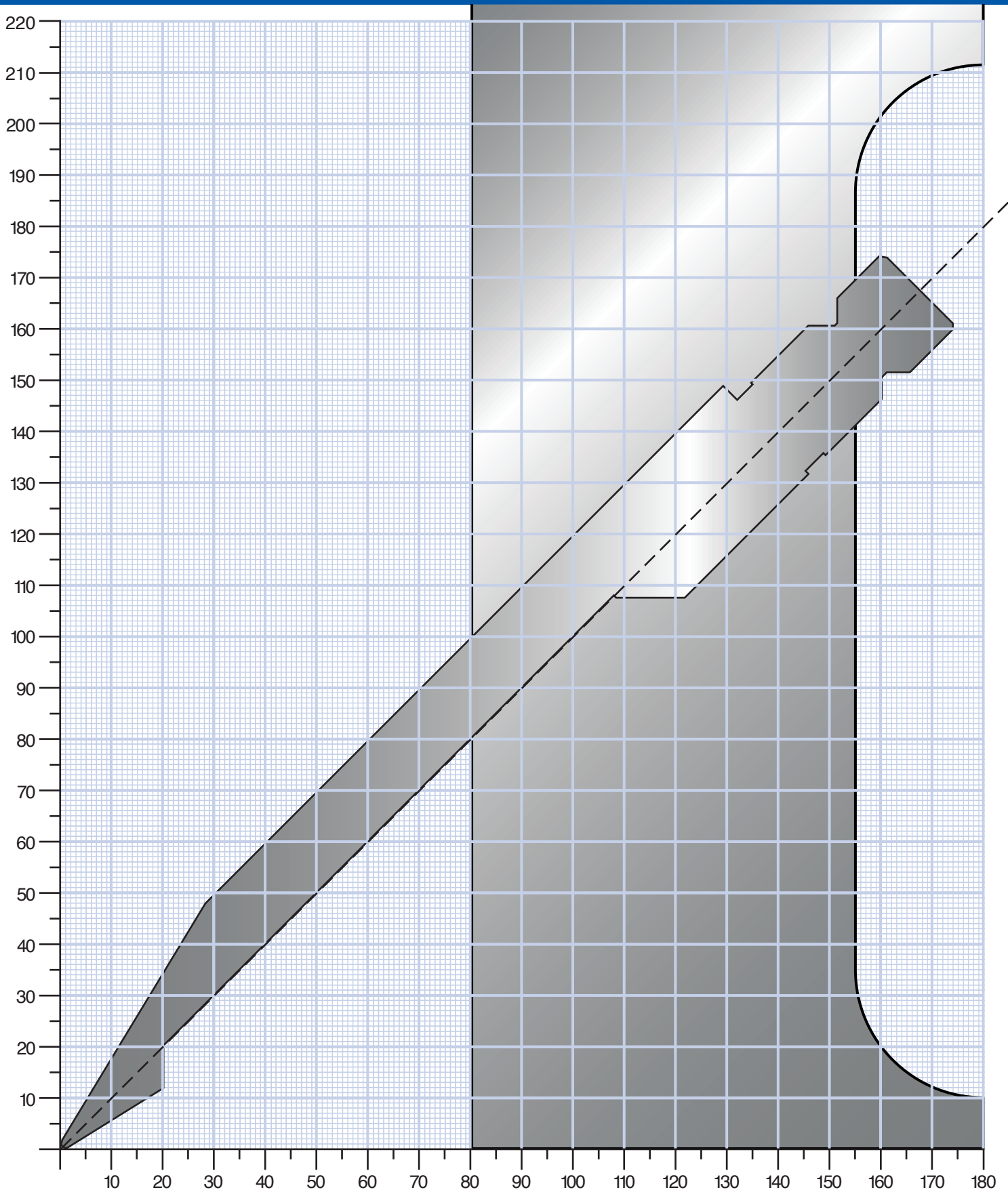
WP032 - Bend Limit Graph



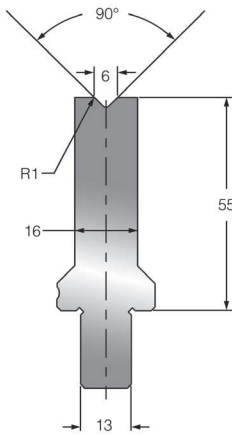
WP034 - Bend Limit Graph



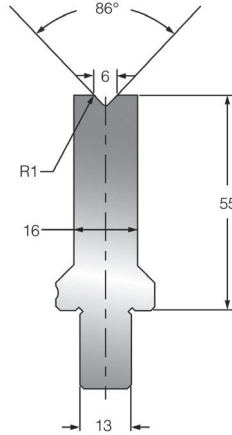
WP031 - Bend Limit Graph



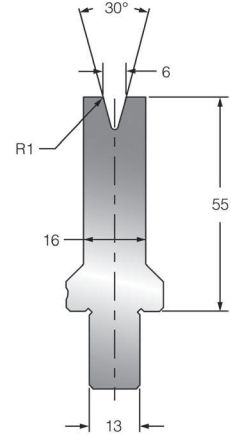
Die V-Opening = 6mm



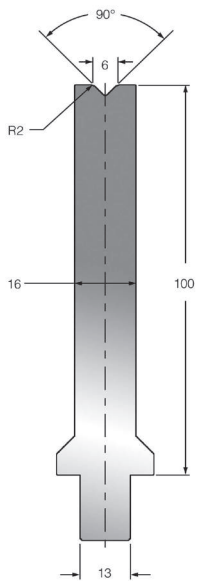
WM041



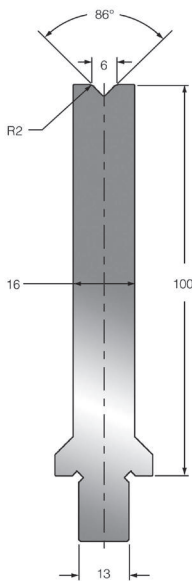
WM021



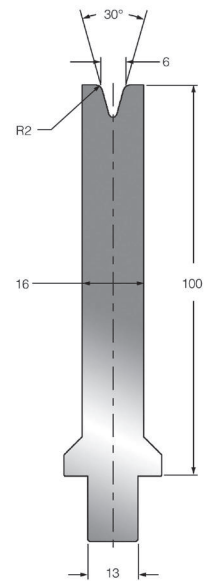
WM061



WM341



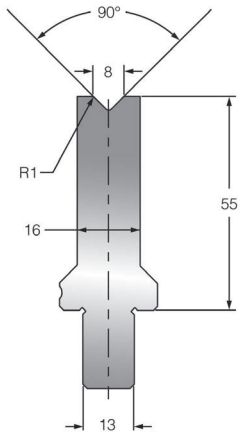
WM321



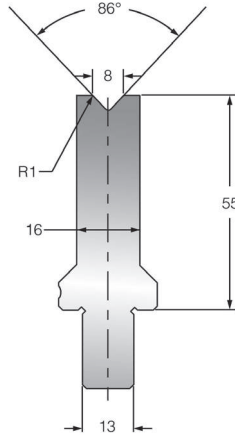
WM361

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM041	OZU-041	120	9,5	6	90°	55	515 / 200 / 550 sect / 200sect
WM021	OZU-021	120	9,5	6	86°	55	515 / 200 / 550 sect / 200sect
WM061	OZU-061	80	9,5	6	30°	55	515 / 200 / 550 sect / 200sect
WM341	OZU-341	120	15,1	6	90°	100	515 / 200 / 550 sect / 200sect
WM321	OZU-321	120	15,1	6	86°	100	515 / 200 / 550 sect / 200sect
WM361	OZU-361	80	15,2	6	30°	100	515 / 200 / 550 sect / 200sect

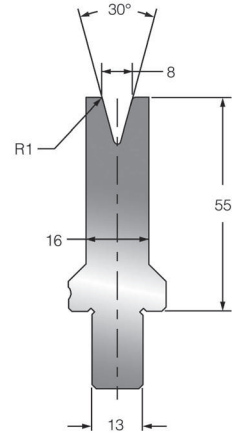
Die V-Opening = 8mm



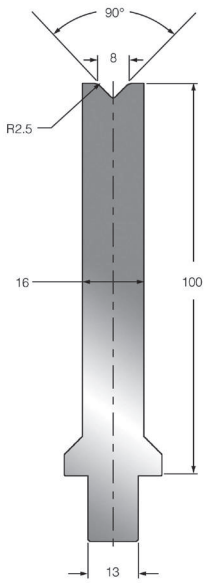
WM042



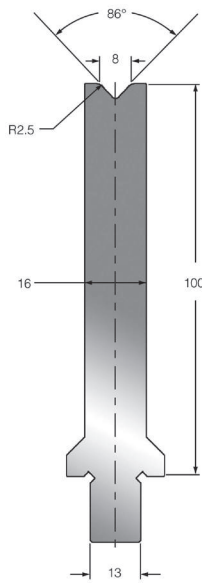
WM010



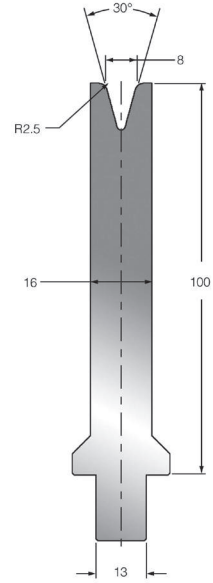
WM051



WM342



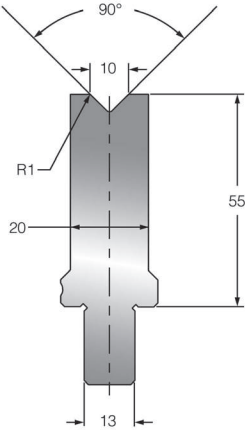
WM310



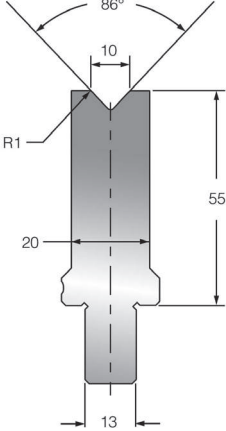
WM351

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM042	OZU-042	120	9,5	8	90°	55	515 / 200 / 550 sect / 200sect
WM010	OZU-010	120	9,5	8	86°	55	515 / 200 / 550 sect / 200sect
WM051	OZU-051	80	9,5	8	30°	55	515 / 200 / 550 sect / 200sect
WM342	OZU-342	120	15,1	8	90°	100	515 / 200 / 550 sect / 200sect
WM310	OZU-310	120	15,1	8	86°	100	515 / 200 / 550 sect / 200sect
WM351	OZU-351	80	15	8	30°	100	515 / 200 / 550 sect / 200sect

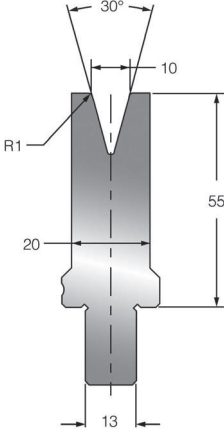
Die V-Opening = 10mm



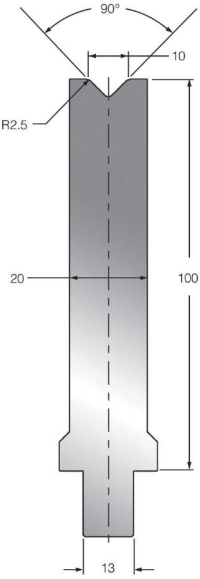
WM043



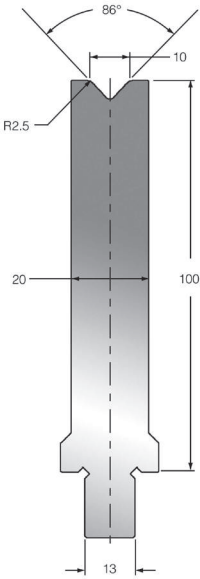
WM022



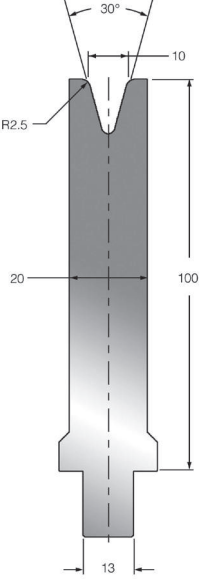
WM062



WM343



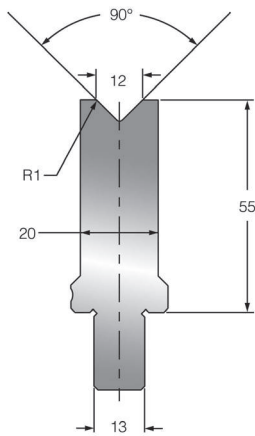
WM322



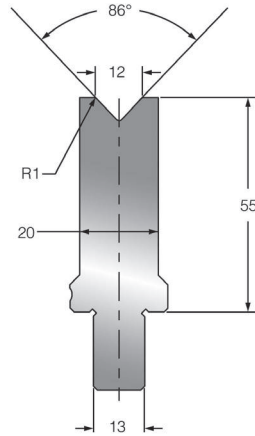
WM362

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lenghts
WM043	OZU-043	120	11	10	90°	55	515 / 200 / 550 sect / 200sect
WM022	OZU-022	120	11	10	86°	55	515 / 200 / 550 sect / 200sect
WM062	OZU-062	80	10,5	10	30°	55	515 / 200 / 550 sect / 200sect
WM343	OZU-343	120	17,9	10	90°	100	515 / 200 / 550 sect / 200sect
WM322	OZU-322	120	17,9	10	86°	100	515 / 200 / 550 sect / 200sect
WM362	OZU-362	80	17,7	10	30°	100	515 / 200 / 550 sect / 200sect

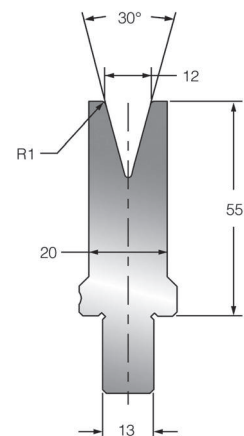
Die V-Opening = 12mm



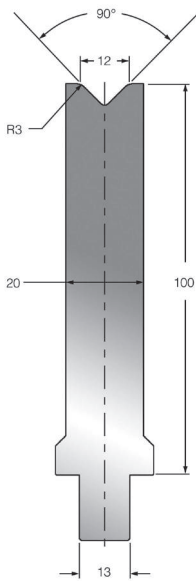
WM044



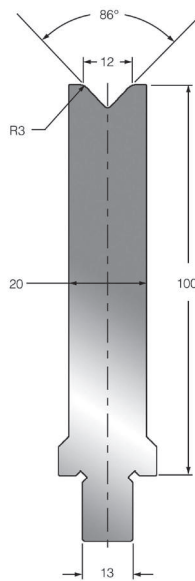
WM011



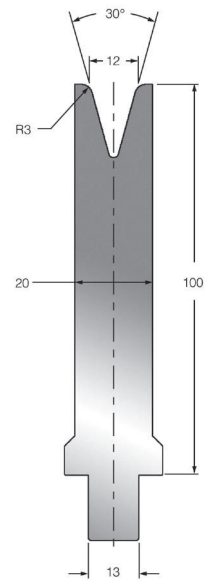
WM052



WM344



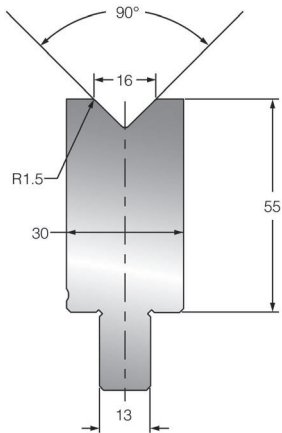
WM311



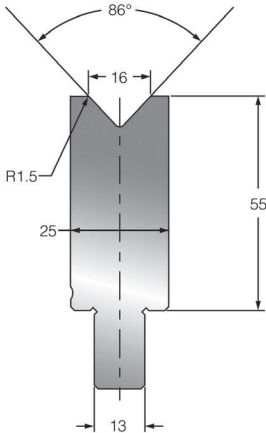
WM352

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM044	OZU-044	120	11	12	90°	55	515 / 200 / 550 sect / 200sect
WM011	OZU-011	120	11	12	86°	55	515 / 200 / 550 sect / 200sect
WM052	OZU-052	80	10	12	30°	55	515 / 200 / 550 sect / 200sect
WM344	OZU-344	120	17,8	12	90°	100	515 / 200 / 550 sect / 200sect
WM311	OZU-311	120	17,8	12	86°	100	515 / 200 / 550 sect / 200sect
WM352	OZU-352	80	17,4	12	30°	100	515 / 200 / 550 sect / 200sect

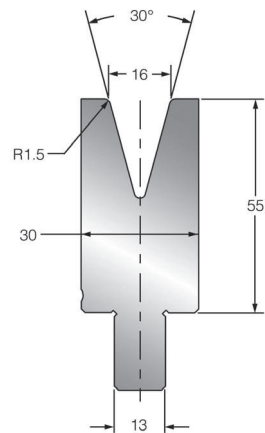
Die V-Opening = 16mm



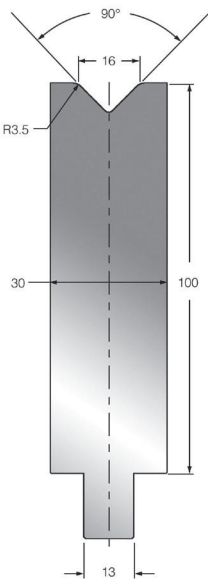
WM045



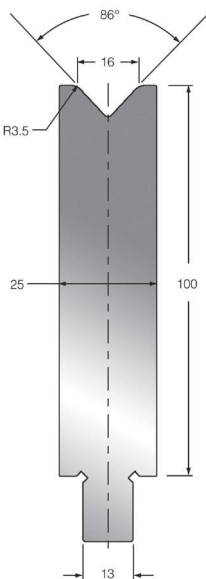
WM012



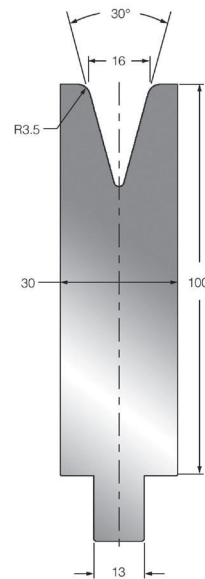
WM053



WM345



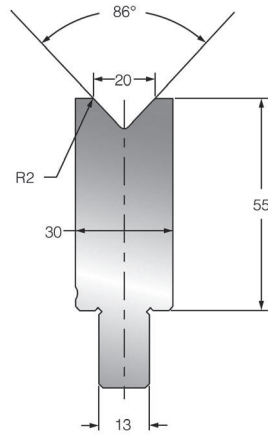
WM312



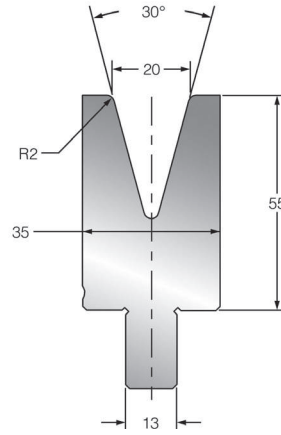
WM353

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM045	OZU-045	120	15	16	90°	55	515 / 200 / 550 sect / 200sect
WM012	OZU-012	120	13	16	86°	55	515 / 200 / 550 sect / 200sect
WM053	OZU-053	80	13,5	16	30°	55	515 / 200 / 550 sect / 200sect
WM345	OZU-345	120	25,8	16	90°	100	515 / 200 / 550 sect / 200sect
WM312	OZU-312	120	19,3	16	86°	100	515 / 200 / 550 sect / 200sect
WM353	OZU-353	80	24,2	16	30°	100	515 / 200 / 550 sect / 200sect

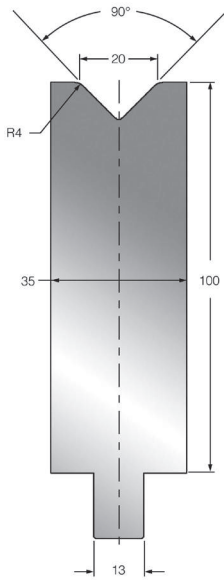
Die V-Opening = 20mm



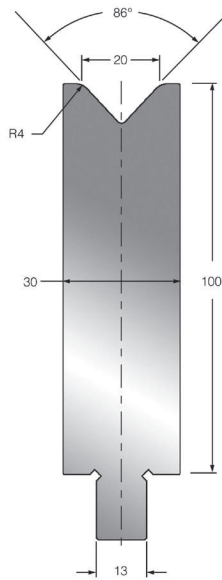
WM023



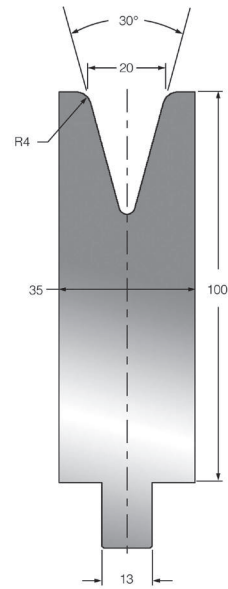
WM063



WM346



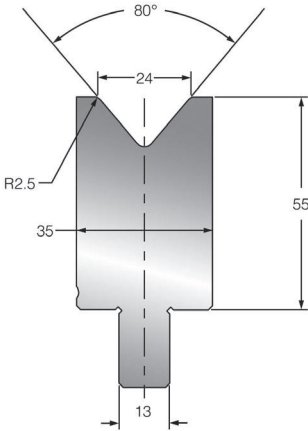
WM323



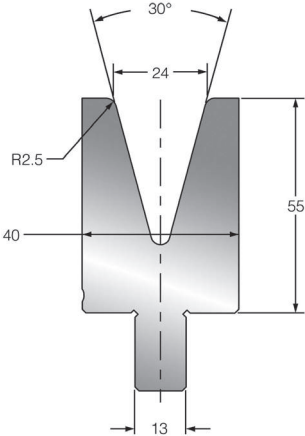
WM363

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM023	OZU-023	120	15	20	86°	55	515 / 200 / 550 sect / 200sect
WM063	OZU-063	80	15	20	30°	55	515 / 200 / 550 sect / 200sect
WM346	OZU-346	120	28,7	20	90°	100	515 / 200 / 550 sect / 200sect
WM323	OZU-323	120	24,9	20	86°	100	515 / 200 / 550 sect / 200sect
WM363	OZU-363	80	27,2	20	30°	100	515 / 200 / 550 sect / 200sect

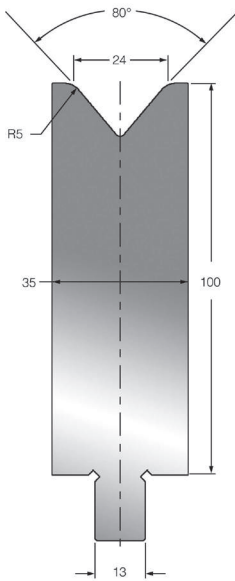
Die V-Opening = 24mm



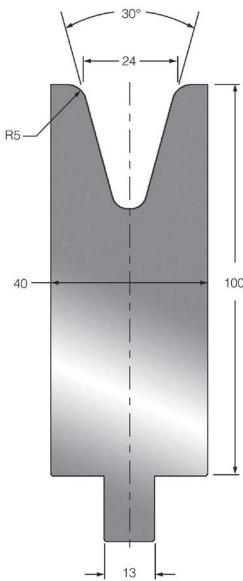
WM013



WM054



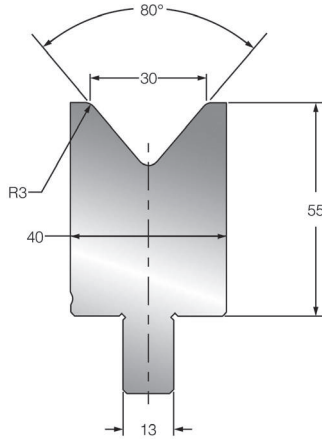
WM313



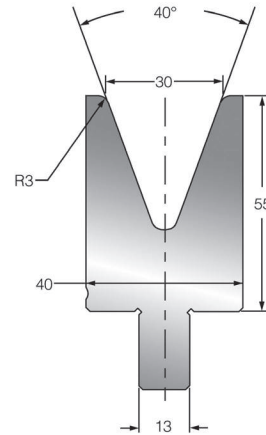
WM354

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM013	OZU-013	125	16	24	80°	55	515 / 200 / 550 sect / 200sect
WM054	OZU-054	80	16	24	30°	55	515 / 200 / 550 sect / 200sect
WM313	OZU-313	125	26,5	24	80°	100	515 / 200 / 550 sect / 200sect
WM354	OZU-354	80	30,1	24	30°	100	515 / 200 / 550 sect / 200sect

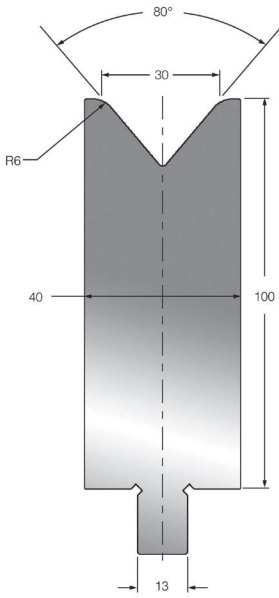
Die V-Opening = 30mm



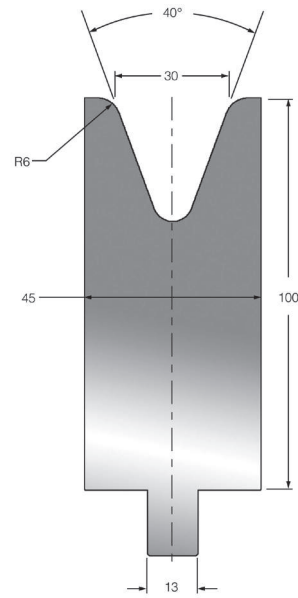
WM014



WM031



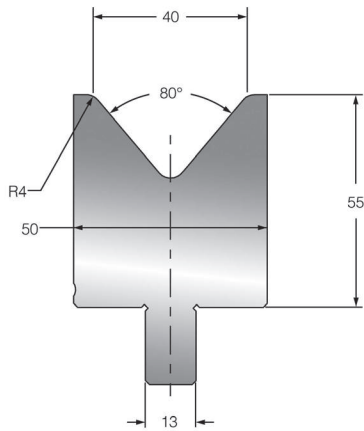
WM324



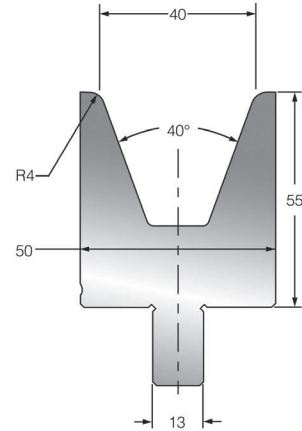
WM328

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM014	OZU-014	125	17	30	80°	55	515 / 200 / 550 sect / 200sect
WM031	OZU-031	70	15	30	40°	55	515 / 200 / 550 sect / 200sect
WM324	OZU-324	125	32,1	30	80°	100	515 / 200 / 550 sect / 200sect
WM328	OZU-328	100	33,1	30	40°	100	515 / 200 / 550 sect / 200sect

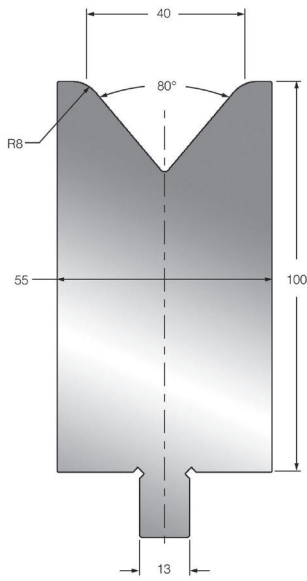
Die V-Opening = 40mm



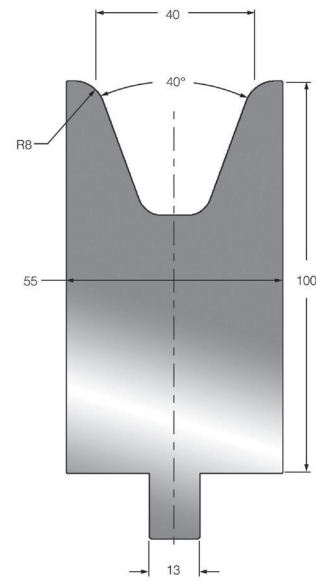
WM015



WM032



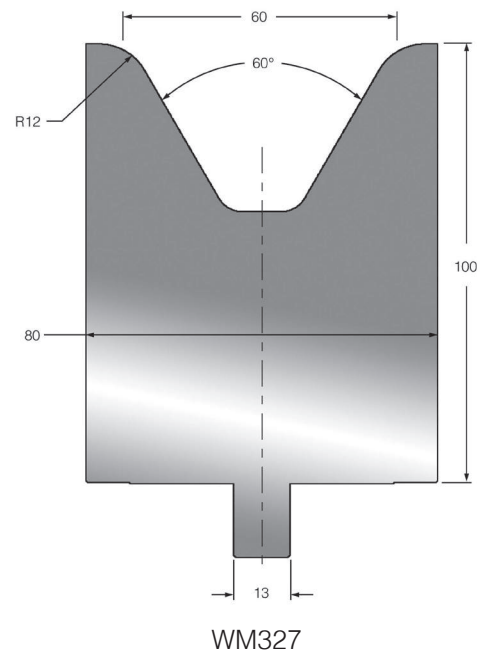
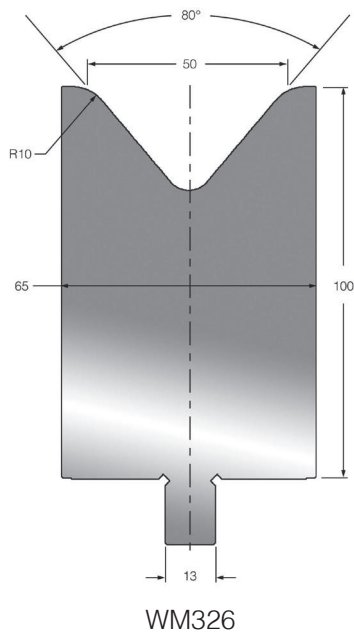
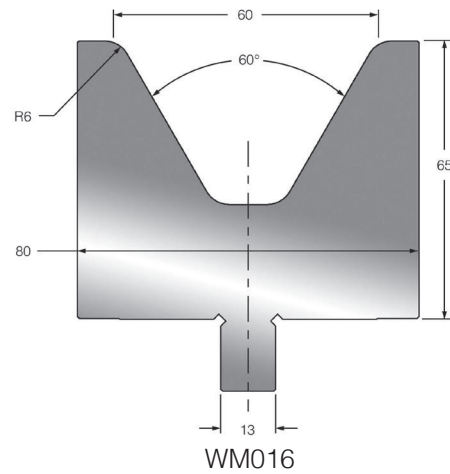
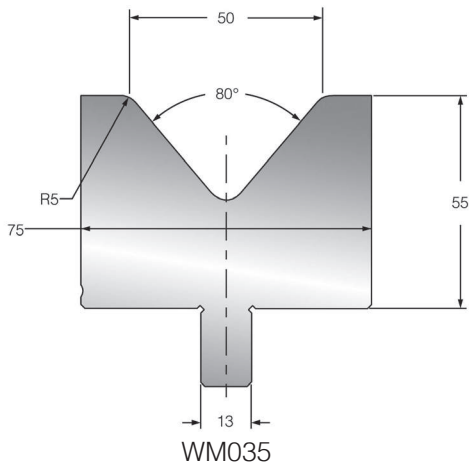
WM325



WM329

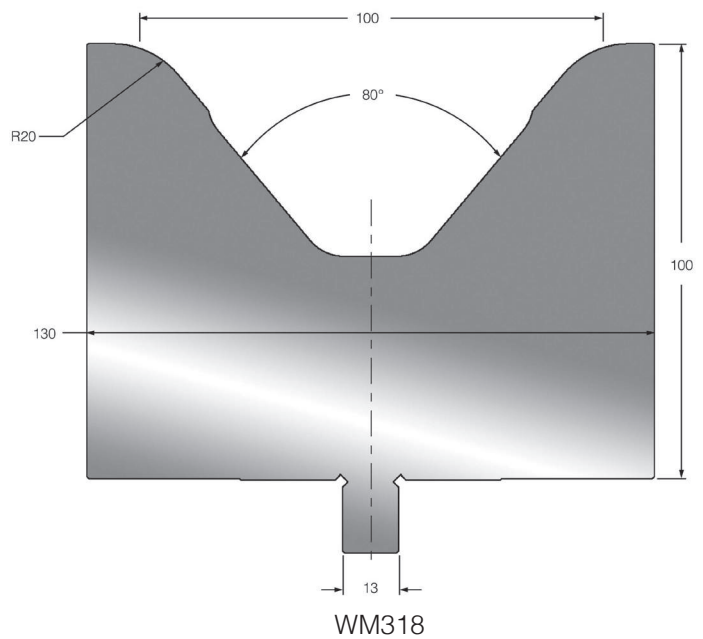
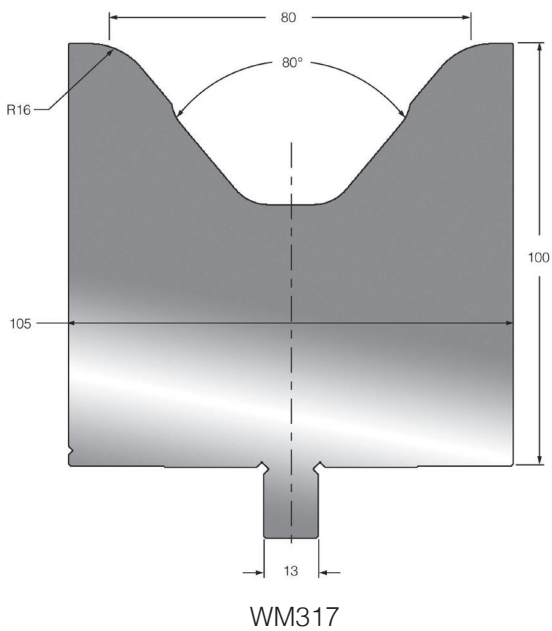
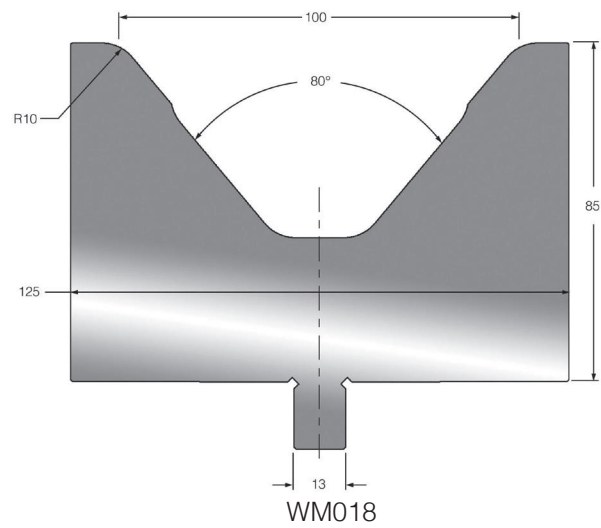
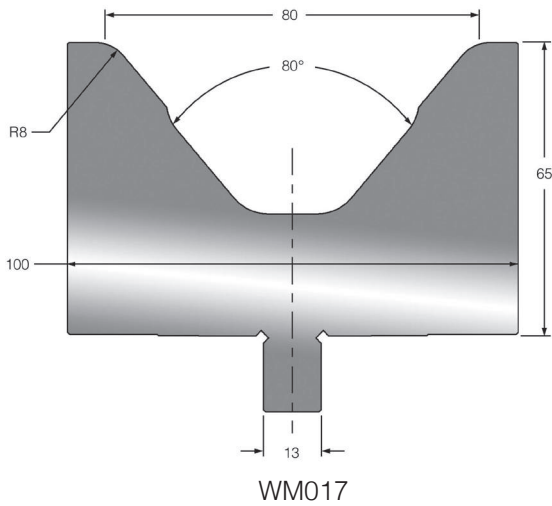
Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM015	OZU-015	125	21	40	80°	55	515 / 200 / 550 sect / 200sect
WM032	OZU-032	80	17	40	40°	55	515 / 200 / 550 sect / 200sect
WM325	OZU-325	125	41,9	40	80°	100	515 / 200 / 550 sect / 200sect
WM329	OZU-329	125	54,1	40	40°	100	515 / 200 / 550 sect / 200sect

Die V-Opening = 50&60mm



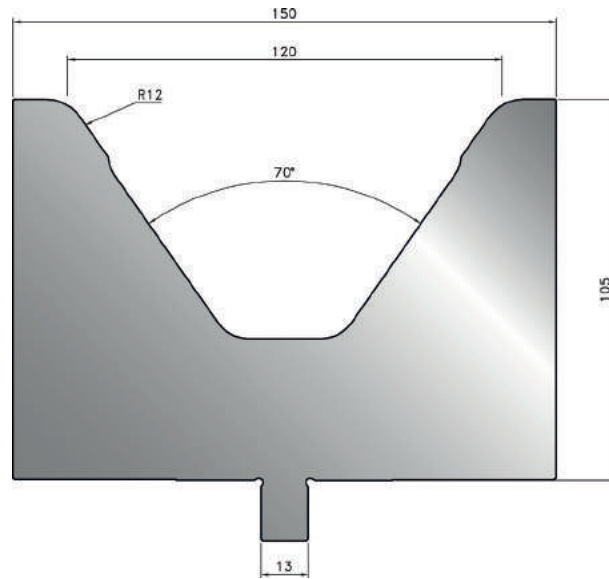
Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM035	OZU-035	150	29	50	80°	55	515 / 200 / 550 sect / 200sect
WM326	OZU-326	150	47,8	50	80°	100	515 / 200 / 550 sect / 200sect
WM016	OZU-016	125	32	60	60°	65	515 / 200 / 550 sect / 200sect
WM327	OZU-327	125	54,1	60	60°	100	515 / 200 / 550 sect / 200sect

Die V-Opening = 80&100mm

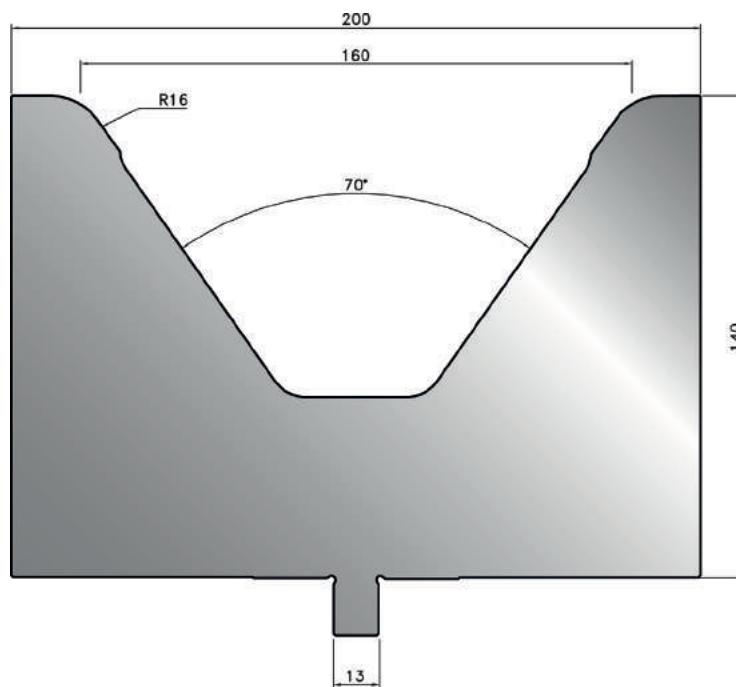


Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM017	OZU-017	150	38,5	80	80°	65	515 / 200
WM317	OZU-317	150	70,6	80	80°	100	515 / 200
WM018	OZU-018	150	62,5	100	80°	65	515 / 200
WM318	OZU-318	150	81,5	100	80°	100	515 / 200

Die V-Opening = 120&160mm



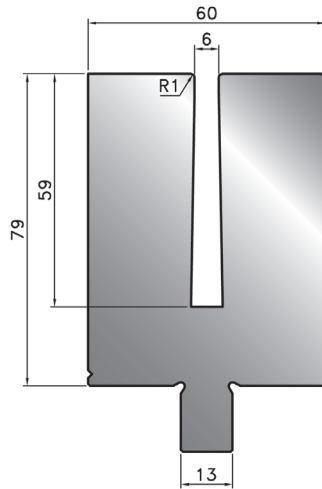
WM0070



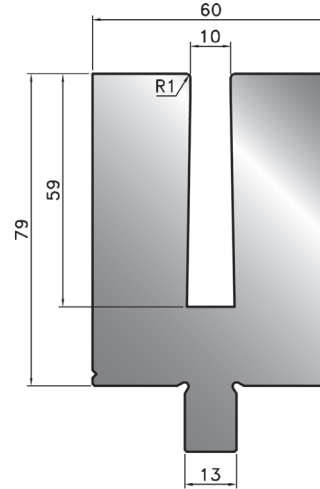
WM071

Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Weight Kg/m	V Opening	Angle	Height	Possible lengths
WM070	OZU-070	250	88,4	120	70°	105	515 / 200
WM071	OZU-071	250	153,8	160	70°	140	515 / 200

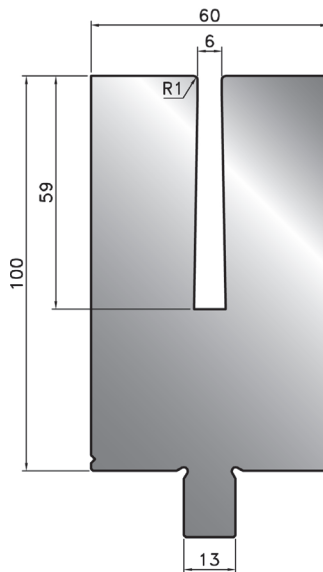
Hemming dies



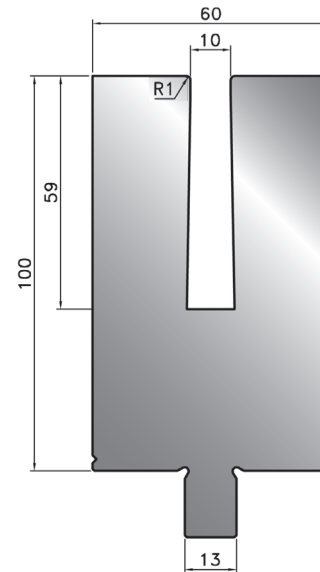
WM082



WM083



WM382

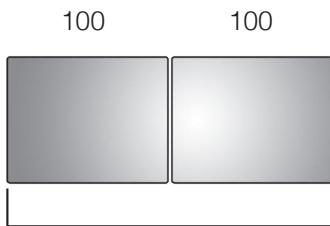
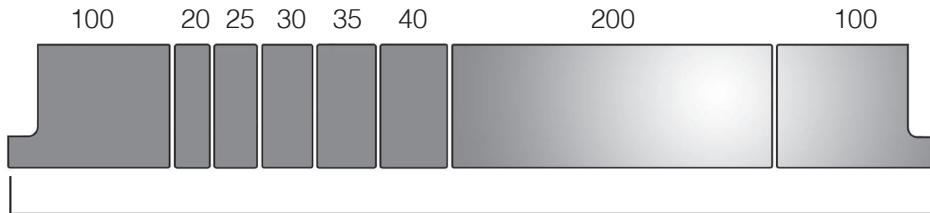


WM381

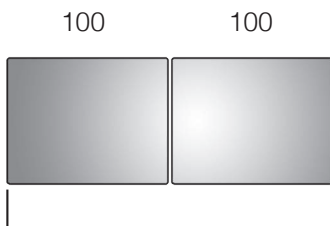
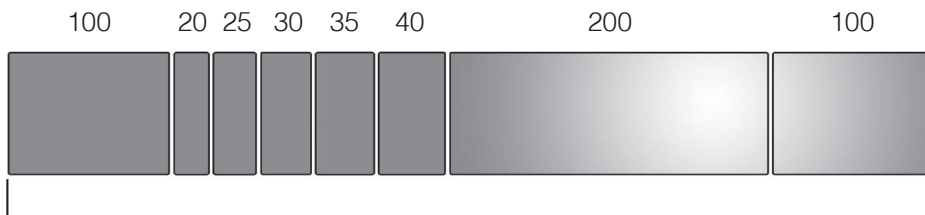
Toolspress Cat. No.	Wila Cat. No.	Max Loading T/m $\alpha=90^\circ$	Max Loading T/m flattening	Weight Kg/m	U Opening	Height	Possible lengths
WM082	OZU-082	50	100	36	6	79	515 / 200
WM083	OZU-083	50	100	35	10	79	515 / 200
WM381	OZU-381	50	100	44,7	10	100	515 / 200
WM382	OZU-382	50	100	45	6	100	515 / 200

System Divisions with tools

Punches

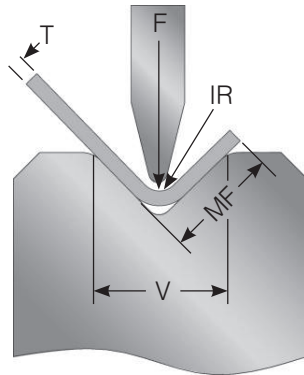


Dies



Press Force Table

- T = Material Thickness
- F = Press Force (kN/m)
- IR = Inside Radius
- MF = Minimum Flange
- V = Die V Opening

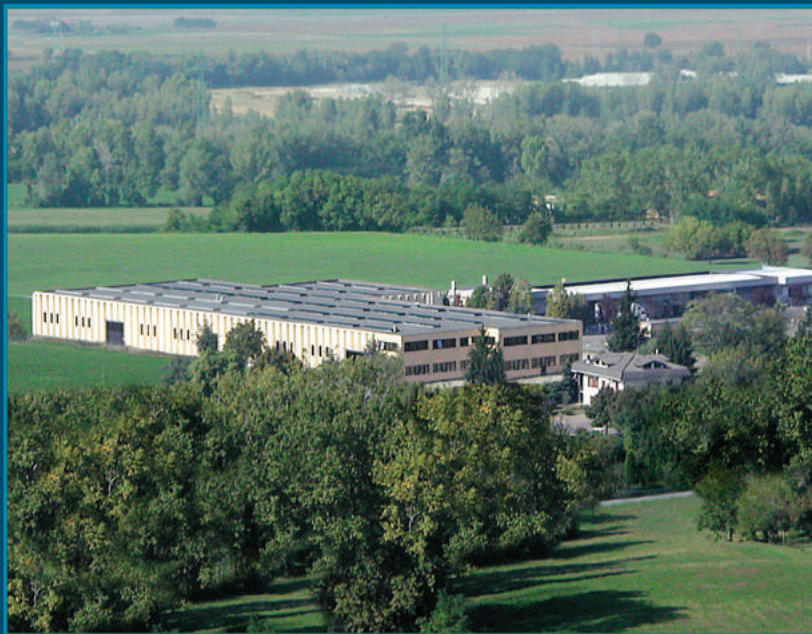


Notes	
*	Optimum Die
•	F in kN
•	T, MF, V, IR in mm

Material 400 N / mm ² Mild Steel																		
		6	8	10	12	16	20	24	30	40	50	60	70	80	90	100	120	V
		4.5	6	7.5	9	12	15	18	22.5	30	37.5	45	52.5	60	67.5	75	90	MF
		1	1.3	1.6	1.9	2.6	3.2	3.8	4.8	6.4	8	9.6	11	13	14	16	19	IR
Material Thickness	0.75	52*	39	31	26													
	1	93	70*	56	47	35												
	1.25	145	109	87*	73	55	44											
	1.5	209	157	126	105*	79	63											
	1.75		214	171	143*	107	86	71										
	2			223	186	140*	112	93										
	2.5				291	218	175*	145	116									
	3					314	251	209*	168	126								
	3.5					428	342	285	228*	171	137							
	4						447	372	298*	223	179	149						
	4.5						566	471	377	283*	226	189	162					
	5								466	349*	279	233	200	175				
	6								670	503	402*	335	287	251	223			
7									684	547*	456*	391	342	304	274			
8										715	596*	511*	447	397	358	298		
10												798*	698*	621	559	466		
12													1005	894*	804*	670		

Material 700 N / mm ² Stainless Steel																		
		6	8	10	12	16	20	24	30	40	50	60	70	80	90	100	120	V
		4.5	6	7.5	9	12	15	18	22.5	30	37.5	45	52.5	60	67.5	75	90	MF
		1	1.3	1.6	1.9	2.6	3.2	3.8	4.8	6.4	8	9.6	11	13	14	16	19	IR
Material Thickness	0.75	87*	65	52	44													
	1	155	116*	93	78	58												
	1.25	242	182	145*	121	91	73											
	1.5	349	262	209	175*	131	105											
	1.75		356	285	238*	178*	143	119										
	2			372	310	233*	186	155										
	2.5				485	364	291*	242	194									
	3					524	419	349*	279	209								
	3.5						570	475	380*	285	228							
	4							621	497*	372	298	248						
	4.5								628	471*	377	314	269					
	5									582*	466	388	333	291				
	6									838	670*	559	479	419				
7										912*	760*	652	570	507				
8										1192	993*	851*	745	662	596			
10												1330*	1164*	1034	931	776		
12													1675	1490*	1340*	1118		

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