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Progettare stampi con acciai

termoconduttivi

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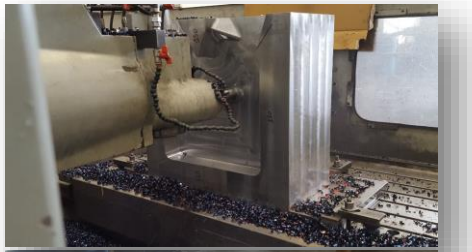
Bre-Men nasce nel 1985

8.000 m² - 11 carriponte
32 segatrici - 7 frese

La forza del nostro magazzino



Capacità e precisione

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PORTFOLIO

ROVALMA
THE STEEL INNOVATOR

Rovalma Material[1]	Thermal conductivity (W/m·k)	Typical Working Hardness Range	Replacing Conventional steels (DIN-EN)	Special features
FASTCOOL®-20	54	400 ± 20 HB	1.2311, 1.2738HH	Designed for high volume production series. Delivered in pre-hardened state[2] at very high mechanical strength level.
FASTCOOL®-50	50	44 - 53 HRc	1.2343, 1.2344, 1.2367	Excellent abrasive wear resistance, optimized for high fiber content plastics.
FASTCOOL®-70	46	50 - 52 HRc	1.2343, 1.2344, 1.2367	Age hardening steel with very high wear resistance, extreme dimensional stability during easy low temperature hardening.
HTCS®-130 DC	60	34 - 52 HRc	1.2343, 1.2344, CuBe	Best choice for CuBe replacement. Highest thermal conductivity combined with high mechanical properties.

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Case history by A.D Stampi srl

Item Name	Item Data
Covestro PC Medical Grade	Makrolon 2858
Ejection Temperature	130 °C
Freeze Temperature	170 °C
Glass Transition Temperature	143,85 °C

Max	Min	Avg	SD
7,5 mm	2,511 mm	3,496 mm	0,467 mm

Item Name	Item Data
Melt Temperature Range	280~320 °C (300 °C Used)
Mold Temperature Range	80~100 °C (90 °C Used)

Cooling	Item Data
Cooling Time	22,4 sec
Mold Open Time	5 sec
Air Temperature	25 °C
Cycle Time	43,64 sec

Filling	Item Data
Filling Time	2,44 sec
Max Injection Pressure	160 MPa
Injection Volume	183,005 cc

Packing	
Packing Time	13,8 sec
Max Packing Pressure	160 MPa

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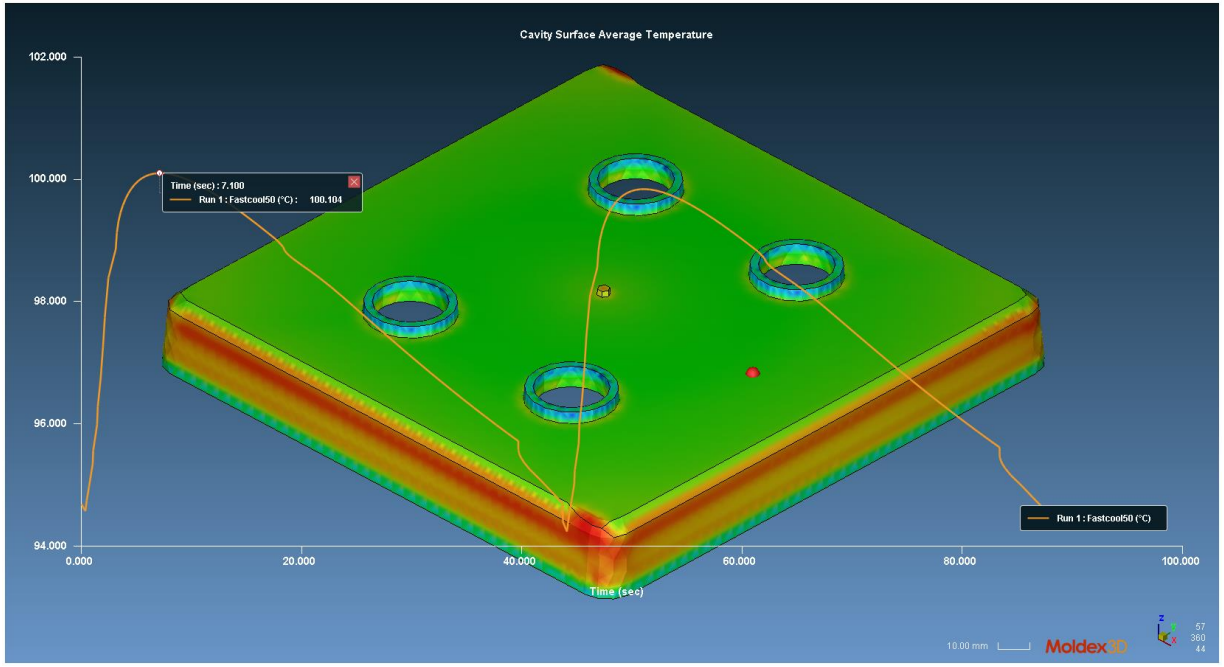
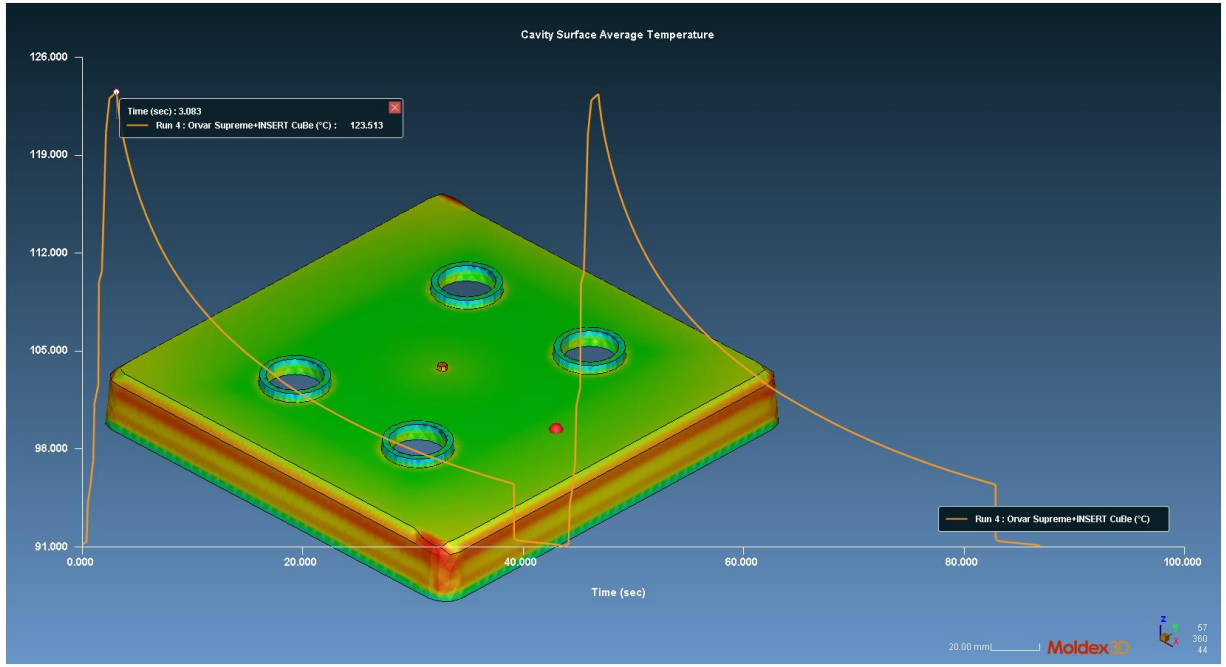
STRESS TERMICO E DERIVATI

Fastcool50



1.2344 + inserto in CuBe



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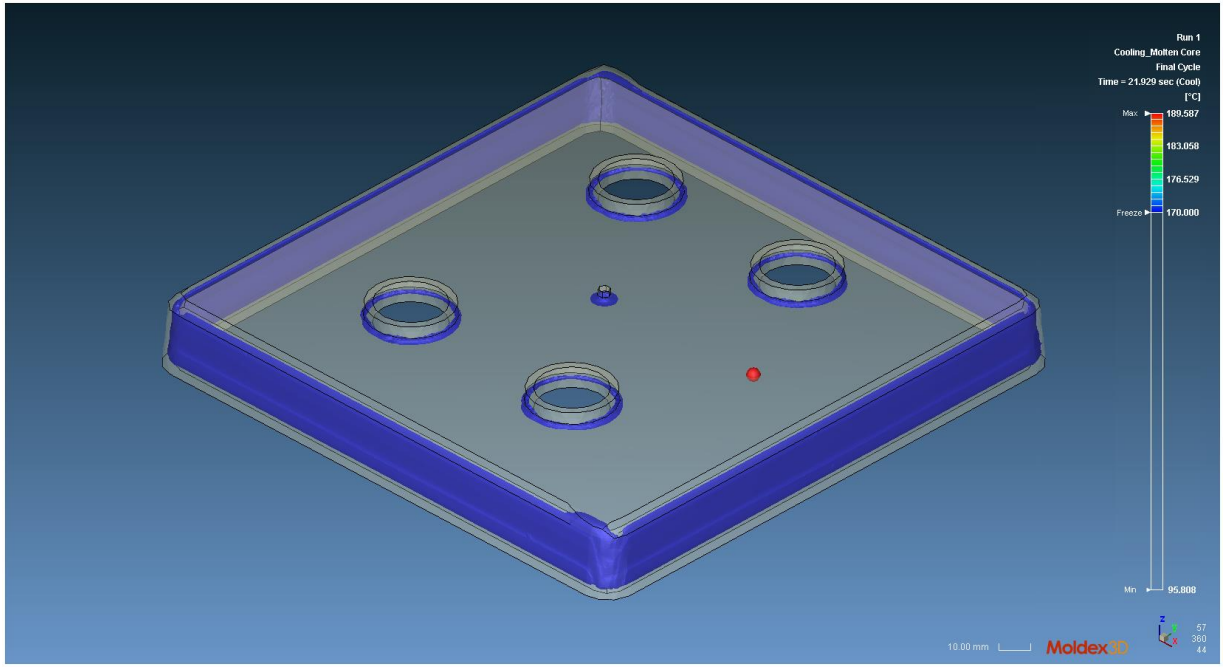
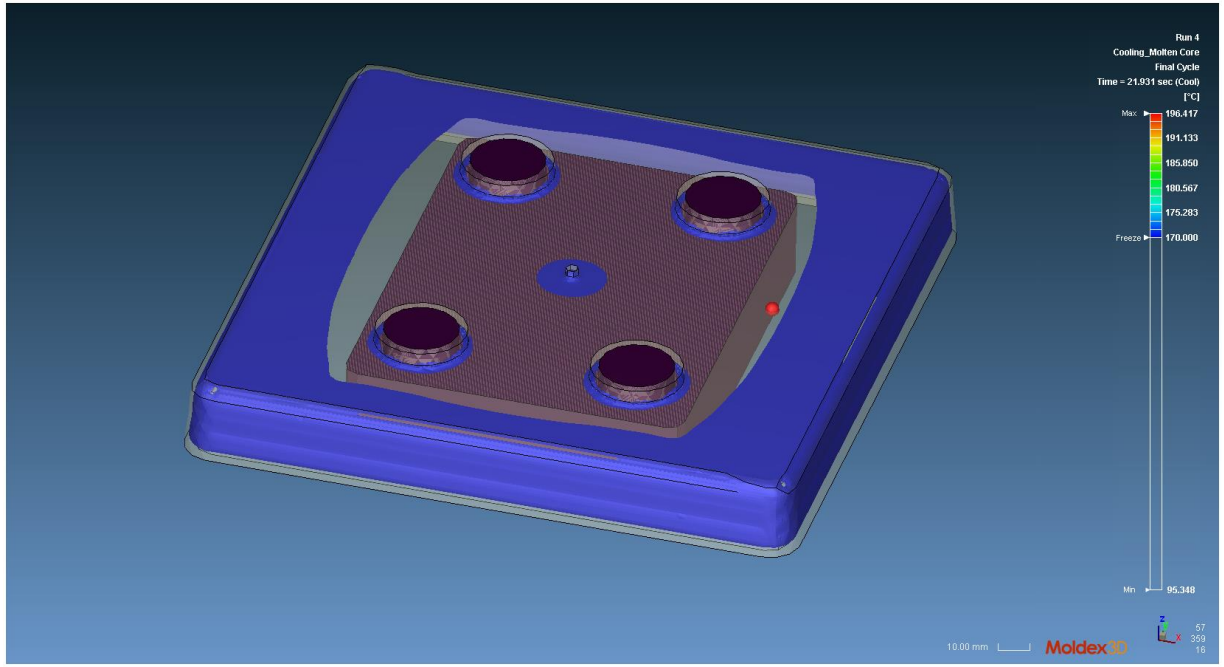
COMPORTAMENTO DURANTE IL RAFFREDDAMENTO (21 sec)

Fastcool50



1.2344 + inserto in CuBe



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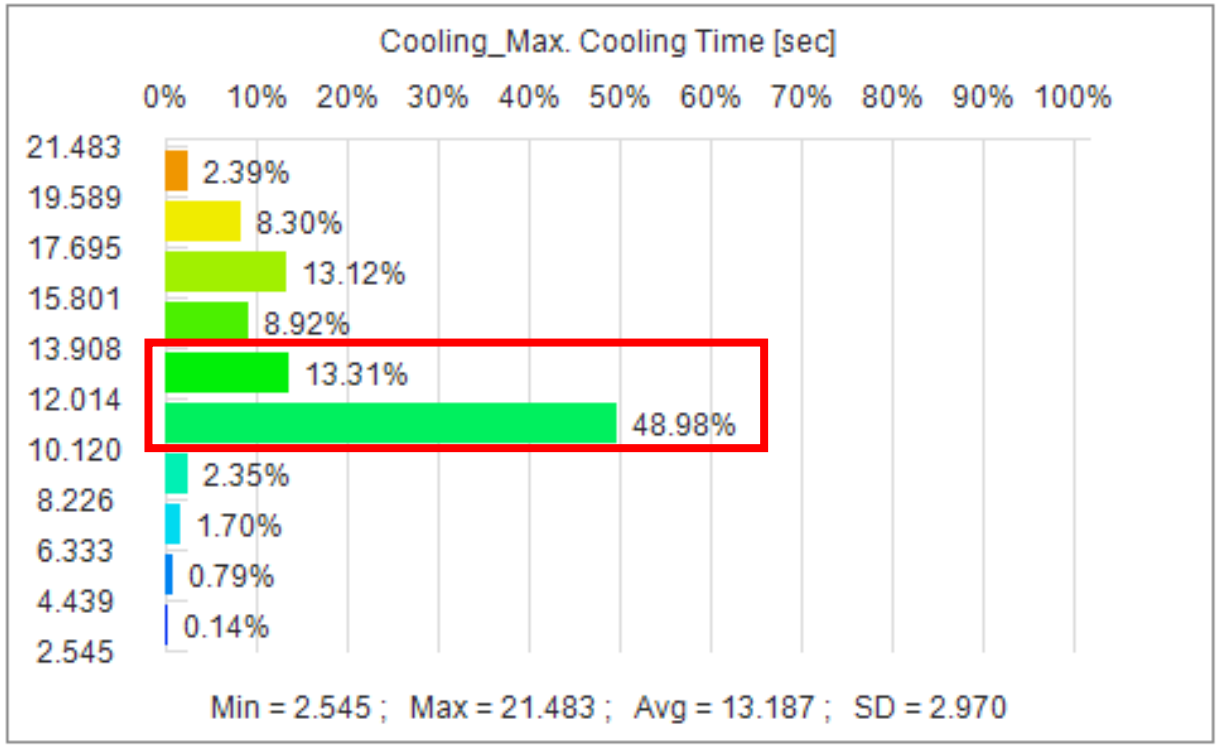
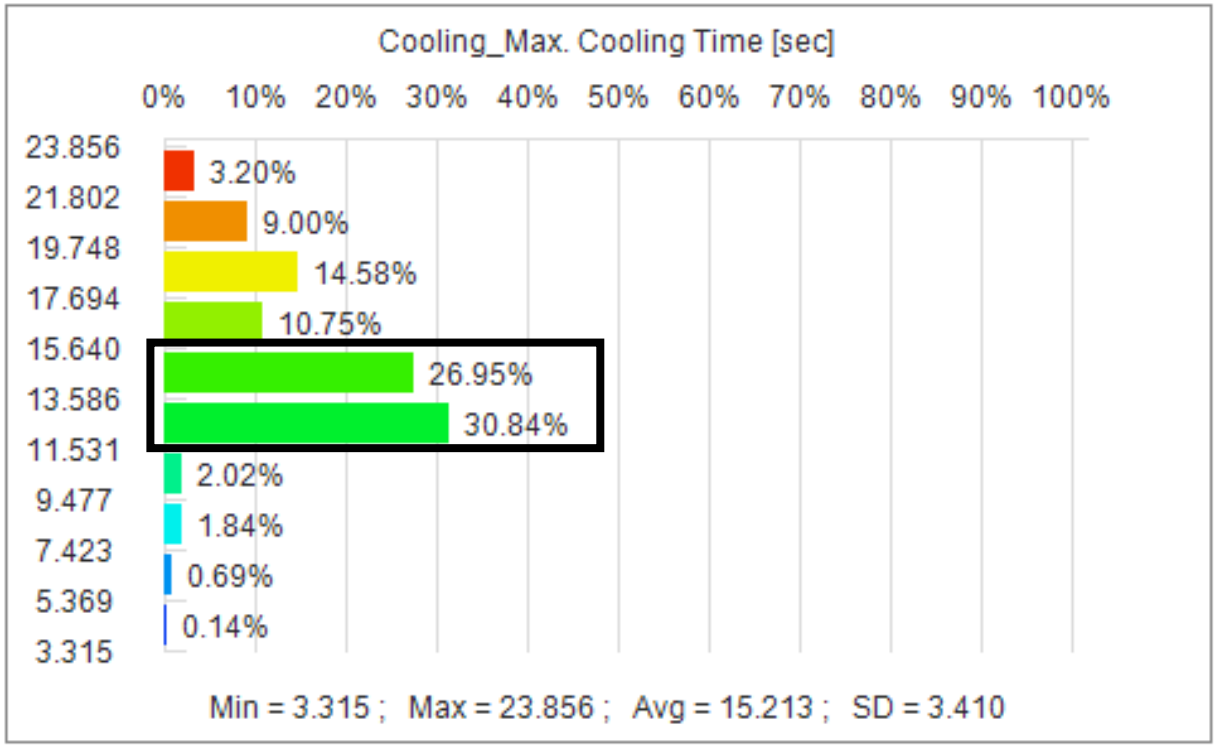
LE FASI DELLA CRISTALIZZAZIONE

Fastcool50



1.2344 + inserto in CuBe



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ABBATTIAMO OGNI LIMITE!

Fastcool50		CuBe
✓	Rivestimenti (PVD – CROMATURA …)	✓
✓	Saldatura	✗
✓	Indurimento Termico	✗
✓	Fotoincisione	✗
✓	Elettroerosione	✗
↑	Resistenza all’erosione	↓
↑	Resistenza alla corrosione	↓
↑	Frequenza e costi di manutenzione	↓
↓	Prezzo di acquisto	↑

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PURE SAVING

Material Grade FASTCOOL 50	BY REDUCING 20% CYCLE TIME	ESTIMATED SAVINGS
50 W/m·K	12 s	205.877 €

Information

Part material	PA6 + 30GF
Actual tool material	1,2343
Hardness	50 HRc
New tool Material	FASTCOOL 50
Hardness	50 HRc
Weight	0,5 kg
Press capacity	300-500 t
Current cycle time	60 s
Total Shots	1.000.000 shots

INJECTION MOULDING RATES 1.000.000 shots

Material	Material cost	Cycle time	Machine cost rate*
1,2343	4,60 €/kg	60,00 s	40,0 €/h
FASTCOOL 50	10,00 €/kg	48,00 s	40,0 €/h
Savings	▼ 5,40 €/kg	▲ 12,00 s	▭ 0,0 €/h

Material	Productivity	Cost/piece	Estimated Prod. Cost
1,2343	48,00 p/h	0,833 €/p	833.337,93 €
FASTCOOL 50	63,75 p/h	0,627 €/p	627.460,98 €
Savings	▲ 15,75 p/h	▲ 0,206 €/p	▲ 205.876,95 €

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ECO FRIENDLY

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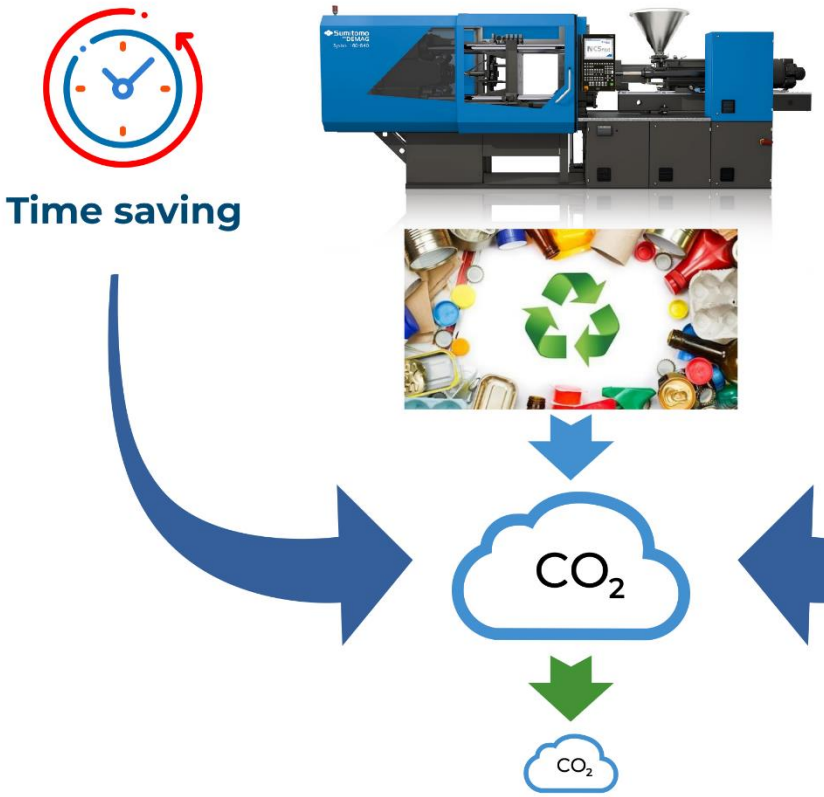

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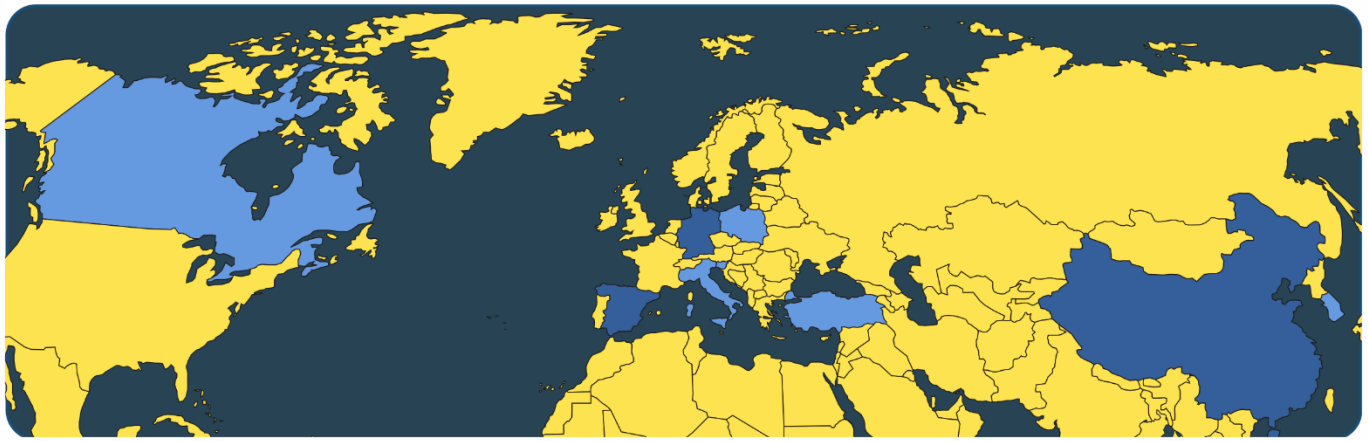
WORLDWIDE ORGANIZATION



45% Spain

25% Germany

20% China

10%

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Grazie per l'attenzione!

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