










BENDING SOLUTIONS






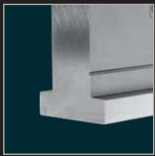
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## ▼ COMPATIBILITY

# R1

Check icon 

- ▶ Accurpress
- ▶ ACL
- ▶ Adira
- ▶ Amada
- ▶ Atlantic
- ▶ Baykal
- ▶ BL
- ▶ Boschert
- ▶ Boutillon
- ▶ Bystronic Beyeler
- ▶ Euro-B
- ▶ Coastone
- ▶ Colgar
- ▶ Dener
- ▶ Deratech
- ▶ Durmazlar
- ▶ Ermaksan
- ▶ Farina
- ▶ Gade
- ▶ Gasparini
- ▶ Gecko
- ▶ Gilardi
- ▶ Gizelis
- ▶ Haco
- ▶ Hindustan
- ▶ HPM
- ▶ Iturrospe
- ▶ Jfy
- ▶ JMT
- ▶ LFK
- ▶ Metfab
- ▶ MVD
- ▶ Oriance
- ▶ Prima Power
- ▶ Promecam
- ▶ Rico
- ▶ Salvagnini
- ▶ Schiavi
- ▶ SMD
- ▶ Sorg
- ▶ Somo
- ▶ Vicla
- ▶ Vimercati
- ▶ Warcom
- ▶ Yawei
- ▶ etc.



Check icon 

# R2

- ▶ Darley
- ▶ LVD
- ▶ Safan
- ▶ Trumpf
- ▶ Press brake machines with System NSCL



Check icon 

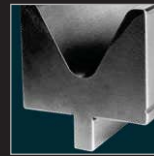
# R3

Bystronic Beyeler:

- ▶ RFA
- ▶ RF
- ▶ R
- ▶ S



- ▶ Bystronic Beyeler
- ▶ Darley
- ▶ Safan
- ▶ SMD
- ▶ Trumpf
- ▶ Press brake machines with System NSCR




Check icon 

# R4

▶ LVD



Check icon 

# RX








- ▶ American
- ▶ Ajall-Axial
- ▶ Colgar
- ▶ Colly
- ▶ EHT
- ▶ Gasparini
- ▶ Hämmerle-Bystronic
- ▶ Ursviken
- ▶ Weinbrenner



Check icon  → Universal compatibility

Check icon  → Patented Product

#### OTHER ROLLERI CATALOGUES:

- ▶ CLAMPING SYSTEMS  
Check icon 
- ▶ PRESS BRAKE TOOLS  
Check icon 
- ▶ PRESS BRAKE TOOLS  
Check icon 
- ▶ PUNCHING TOOLS  
Check icon 
- ▶ IRON WORKER  
Check icon 
- ▶ LASER CONSUMABLES  
Check icon 
- ▶ INDUSTRIAL EQUIPMENT  
Check icon 
- ▶ CRIMPING MACHINES







## PUNCHES ROLLER TYPE R1

### ▼ COMPATIBILITY

Accurl  
Accurpress  
ACL  
Adira  
Amada  
Atlantic  
Baykal  
BL  
Boschert  
Boutillon  
Bystronic Beyeler  
Euro-B  
Coastone  
Colgar  
Dener  
Deratech

Durmazlar  
Ermaksan  
Farina  
Gade  
Gasparini  
Gecko  
Gilardi  
Gizelis  
Haco  
Hindustan  
HPM  
Iturrospe  
Jfy  
JMT  
LFK  
Metfab

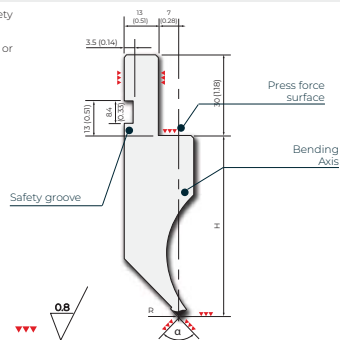
MVD  
Oriance  
Prima Power  
Promecam  
Rico  
Salvagnini  
Schlavi  
SMD  
Sorg  
Somo  
Vicia  
Vimercati  
Warcom  
Yawei  
etc.

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88°	19 - 24
85°	25 - 27
75°	27 - 28
70°	28
60°	29 - 30
45°	30 - 31
35°	31 - 32
30°	33
26°	33 - 3
<b>® A Series</b>	
<b>Punches</b>	35 - 39
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Content Explanation - (R)

**STANDARD TANG**

- Punches are standardized with a 8.4 x 3.5 mm safety groove, which keeps the tool from falling out
- Depending on the clamping system: horizontal or vertical, tool + change is possible



**MODIFICATIONS FROM SAFETY GROOVES**

<p><b>A1</b> Groove in addition to 8.4 x 3.5 mm groove for: - Pneumatic clamping</p>	<p><b>A8</b> Groove for: - Hydraulic clamping - Casparini</p>	<p><b>A42</b> Modified groove for: - Bystronic-Beyerler Euro - Safan</p>
<p><b>A6</b> Groove in addition to 8.4 x 3.5 mm groove for: - Bystronic-Beyerler Euro - Safan</p>	<p><b>A9</b> Modified groove for: - Bystronic-Beyerler Euro - Safan</p>	<p><b>OT</b> Modification for: - For Armada fast clamping system</p>
<p><b>A7</b> Groove in addition to 8.4 x 3.5 mm and shortened tang for: - Bystronic-Beyerler Euro - Safan</p>	<p><b>A41</b> Modified groove for: - Bystronic-Beyerler Euro - Safan</p>	<p>chamfer</p>

**STANDARD LENGTH**

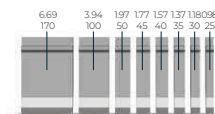
- **TOP**  
525 mm (20.67 in)
- **CLASSIC - A - AFH**  
415 mm (16.34 in)  
835 mm (32.87 in)  
900 mm (35.43 in)

Content Explanation - (R)

**SEGMENTATION**

► **TOP**

FA: 495 mm (19.49 in) - 8 segments

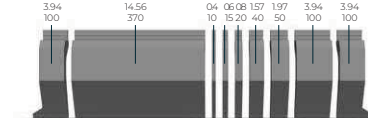


FB: 500 mm (19.68 in) - 3 segments

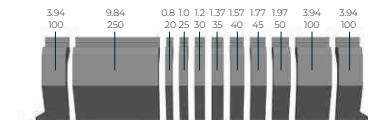


► **CLASSIC - A - AFH**

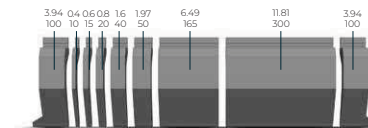
F: 805 mm (31.69 in) - 9 segments



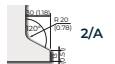
FX: 795 mm (31.29 in) - 11 segments



FC: 800 mm (31.50 in) - 9 segments



**TOP - Horn types**

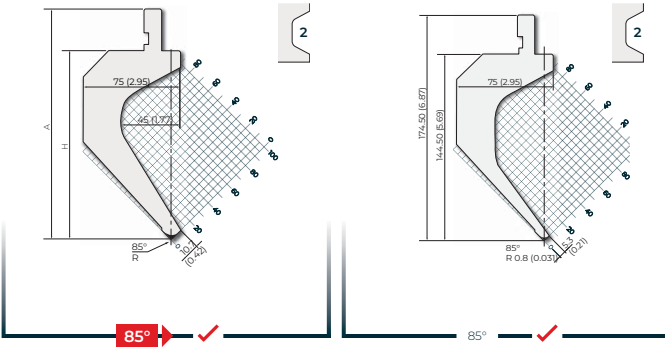


**CLASSIC - A - AFH Horn types**

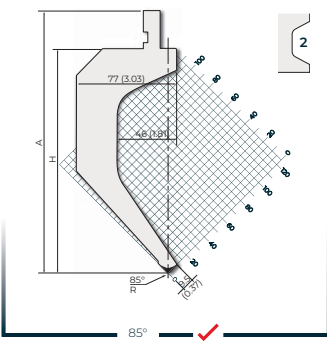


Punches -  TOP Series

42Cr: 900-1150 N/mm <sup>2</sup>		900 kN/m max.		42Cr: 900-1150 N/mm <sup>2</sup>		900 kN/m max.		42Cr: 900-1150 N/mm <sup>2</sup>		200 kN/m max.	
TOP.175.85.R08				TOP.175.85.R2				TOP.175.85.R08.S			
H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)	
H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)	
525 mm	20.67 in	20.9 kg		525 mm	20.67 in	20.9 kg		525 mm	20.67 in	18.5 kg	FA
495 mm	19.49 in	19.7 kg	FA	495 mm	19.49 in	19.7 kg	FA	495 mm	19.49 in	17.4 kg	FB
500 mm	19.68 in	19.9 kg	FB	500 mm	19.68 in	19.9 kg	FB	500 mm	19.68 in	17.6 kg	FB

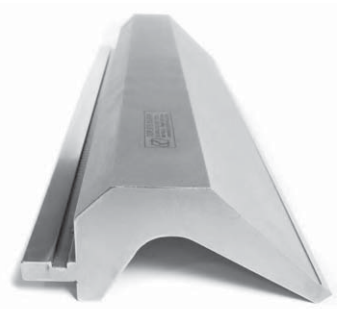
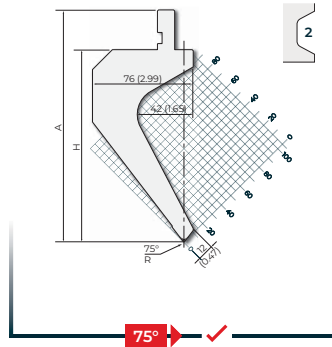


42Cr: 900-1150 N/mm <sup>2</sup>		700 kN/m max.		42Cr: 900-1150 N/mm <sup>2</sup>		700 kN/m max.	
TOP.205.85.R08				TOP.205.85.R2			
H=174.30 / A=205.00 / R=0.8 (mm)		H=174.30 / A=205.00 / R=0.8 (mm)		H=174.30 / A=205.00 / R=0.8 (mm)		H=174.30 / A=205.00 / R=0.8 (mm)	
H=6.87 / A=8.07 / (r=0.078) (in)		H=6.87 / A=8.07 / (r=0.078) (in)		H=6.87 / A=8.07 / (r=0.078) (in)		H=6.87 / A=8.07 / (r=0.078) (in)	
525 mm	20.67 in	24.0 kg		525 mm	20.67 in	24.0 kg	
495 mm	19.49 in	22.6 kg	FA	495 mm	19.49 in	22.6 kg	FA
500 mm	19.68 in	22.9 kg	FB	500 mm	19.68 in	22.9 kg	FB

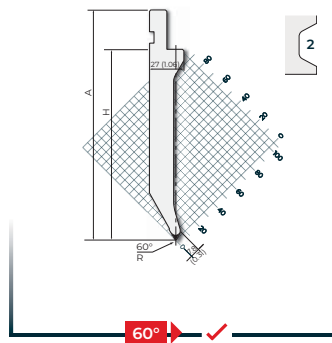


Punches -  TOP Series

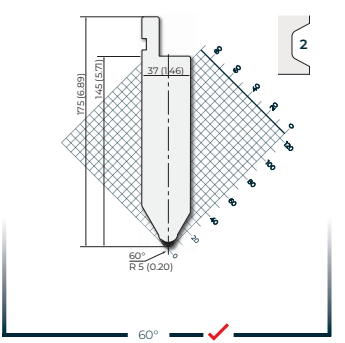
42Cr: 900-1150 N/mm <sup>2</sup>		750 kN/m max.		42Cr: 900-1150 N/mm <sup>2</sup>		750 kN/m max.	
TOP.175.75.R08				TOP.175.75.R2			
H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)	
H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)	
525 mm	20.67 in	21.5 kg		525 mm	20.67 in	21.5 kg	
495 mm	19.49 in	20.3 kg	FA	495 mm	19.49 in	20.3 kg	FA
500 mm	19.68 in	20.5 kg	FB	500 mm	19.68 in	20.5 kg	FB



42Cr: 900-1150 N/mm <sup>2</sup>		800 kN/m max.		42Cr: 900-1150 N/mm <sup>2</sup>		800 kN/m max.	
TOP.175.60.R08				TOP.175.60.R2			
H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)	
H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)	
525 mm	20.67 in	12.0 kg		525 mm	20.67 in	12.0 kg	
495 mm	19.49 in	11.3 kg	FA	495 mm	19.49 in	12.0 kg	FA
500 mm	19.68 in	11.4 kg	FB	500 mm	19.68 in	11.0 kg	FB

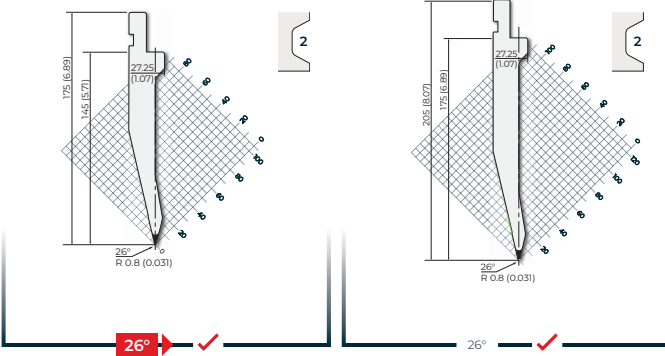


42Cr: 900-1150 N/mm <sup>2</sup>		1600 kN/m max.	
TOP.175.60.R5			
H=143.00 / A=175.00 / R=0.8 (mm)		H=143.00 / A=175.00 / R=0.8 (mm)	
H=5.71 / A=5.89 / (r=0.078) (in)		H=5.71 / A=5.89 / (r=0.078) (in)	
525 mm	20.67 in	21.5 kg	
495 mm	19.49 in	21.0 kg	FA
500 mm	19.68 in	19.0 kg	FB



Punches - **TOP Series**

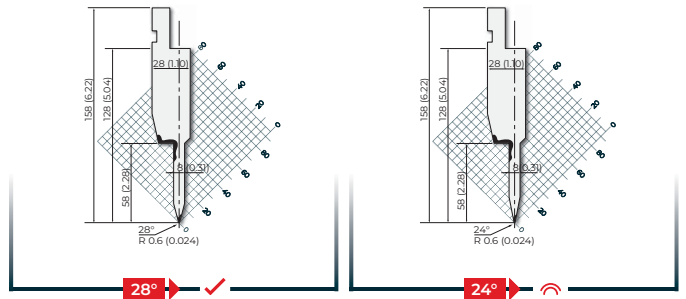
42Cr: 900-1150 N/mm <sup>2</sup>			950 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			950 kN/m max.
<b>TOP.175.26.R08</b>							
525 mm	20.67 in	11.0 kg		525 mm	20.67 in	14.0 kg	
495 mm	19.49 in	10.4 kg	FA	495 mm	19.49 in	13.2 kg	FA
500 mm	19.68 in	10.5 kg	FB	500 mm	19.68 in	13.3 kg	FB



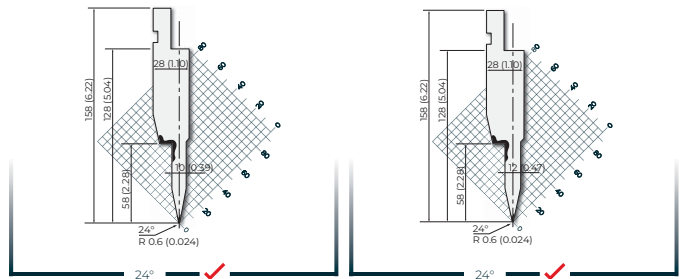
42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
<b>TOP.250.26.R1</b>			
525 mm	20.67 in	17.7 kg	
495 mm	19.49 in	17.7 kg	FA
500 mm	19.68 in	17.7 kg	FB

Hemming Tools - **TOP Series**

42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max. - 1000 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max. - 1000 kN/m max.
<b>TOP.SP.134.28.8</b>							
525 mm	20.67 in	11.0 kg		525 mm	20.67 in	11.0 kg	
495 mm	19.49 in	10.3 kg	FA	To use with:	495 mm	19.49 in	10.3 kg
				TOP.SM-134.28.8 (Page 81)	To use with:		TOP.SM-134.24.8 (Page 81)



42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max. - 1000 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max. - 1000 kN/m max.
<b>TOP.SP.134.24.10</b>							
525 mm	20.67 in	11.0 kg		525 mm	20.67 in	11.6 kg	
495 mm	19.49 in	10.3 kg	FA	To use with:	495 mm	19.49 in	11.0 kg
				TOP.SM-134.24.10 (Page 81)	To use with:		TOP.SM-134.24.12 (Page 81)



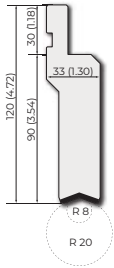
Ex. Application

S	S	A	A	R430	R700	S	S	A	A	R430	R700
[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>	[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>
0.6	0.02	3.0	0.12	90	150	0.6	0.02	1.2	0.05	220	350
0.8	0.03	3.0	0.12	120	200	0.8	0.03	1.6	0.06	320	500
1.0	0.04	3.5	0.14	150	250	1.0	0.04	1.0	0.04	400	600
1.25	0.05	3.5	0.14	170	260	1.25	0.05	2.5	0.10	500	800

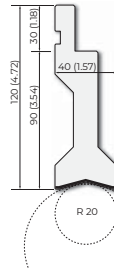


## Radius punches - TOP Series

42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.				
TOP.PC.120-08						TOP.PC.120-20							
522 mm	20.55 in	11.0 kg	522 mm	20.67 in	10.5 kg	495 mm	19.49 in	12.0 kg	FA	495 mm	19.49 in	10.0 kg	FA

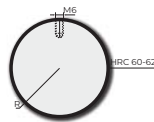


R8 - R20 ✓



R20 - R40 ✓

CS3: 610-760 N/mm <sup>2</sup>						1000 kN/m max.						
Radius punches: R08-R40												
Model	R [mm]	R [in]	125 mm (4.92 in)		150 mm (5.91 in)		175 mm (6.89 in)		200 mm (7.87 in)		225 mm (8.86 in)	
TOP-C08	8	0.31	0.8 kg				1.9 kg					
TOP-C10	10	0.39	1.3 kg				2.7 kg					
TOP-C12.5	12.5	0.49	2.0 kg				2.8 kg					
TOP-C15	15	0.59	3.0 kg				3.8 kg					
TOP-C17.5	17.5	0.69	4.0 kg				4.7 kg					
TOP-C20	20	0.79	5.2 kg				6.6 kg					
TOP-C22.5	22.5	0.88	6.6 kg				6.6 kg					
TOP-C25	25	0.98	8.1 kg				7.5 kg					
TOP-C27.5	27.5	1.08	9.8 kg				9.2 kg					
TOP-C30	30	1.18	11.7 kg				11.3 kg					
TOP-C32.5	32.5	1.28	13.7 kg				12.9 kg					
TOP-C35	35	1.38	16.0 kg				15.1 kg					
TOP-C37.5	37.5	1.47	18.2 kg				17.2 kg					
TOP-C40	40	1.57	20.7 kg				19.5 kg					

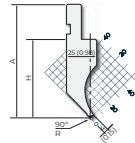


## Punches - CLASSIC Series

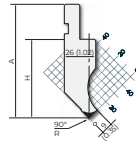


R1

42Cr: 900-1150 N/mm <sup>2</sup>			350 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			350 kN/m max.			C45: 580-710 N/mm <sup>2</sup>			1000 kN/m max.			C45: 580-710 N/mm <sup>2</sup>			1000 kN/m max.											
PK.97.90.R06						P.97.90.R025						PK.97.90.R08						PK.97.90.R025														
835 mm	32.87 in	10.5 kg	835 mm	32.87 in	10.5 kg	835 mm	32.87 in	11.0 kg	835 mm	32.87 in	11.0 kg	835 mm	32.87 in	11.0 kg	835 mm	32.87 in	11.0 kg	835 mm	32.87 in	11.0 kg	835 mm	32.87 in	11.0 kg	835 mm	32.87 in	11.0 kg	835 mm	32.87 in	11.0 kg			
415 mm	16.34 in	5.2 kg	415 mm	16.34 in	5.2 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg
795 mm	31.29 in	10.1 kg	795 mm	31.29 in	10.1 kg	795 mm	31.29 in	10.1 kg	795 mm	31.29 in	10.5 kg	795 mm	31.29 in	10.5 kg	795 mm	31.29 in	10.5 kg	795 mm	31.29 in	10.5 kg	795 mm	31.29 in	11.0 kg	795 mm	31.29 in	11.0 kg	795 mm	31.29 in	11.0 kg	795 mm	31.29 in	11.0 kg
805 mm	31.69 in	10.1 kg	805 mm	31.69 in	10.1 kg	805 mm	31.69 in	10.1 kg	805 mm	31.69 in	10.5 kg	805 mm	31.69 in	10.5 kg	805 mm	31.69 in	10.5 kg	805 mm	31.69 in	10.5 kg	805 mm	31.69 in	11.0 kg	805 mm	31.69 in	11.0 kg	805 mm	31.69 in	11.0 kg	805 mm	31.69 in	11.0 kg

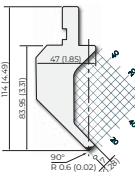


90°

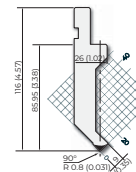


90°

42Cr: 900-1150 N/mm <sup>2</sup>			200 kN/m max.			C45: 580-710 N/mm <sup>2</sup>			400 kN/m max.																							
PK.114.90.R06						PK.116.90.R08																										
835 mm	32.87 in	14.0 kg	835 mm	32.87 in	13.0 kg	835 mm	32.87 in	13.0 kg	835 mm	32.87 in	13.0 kg	835 mm	32.87 in	13.0 kg	835 mm	32.87 in	13.0 kg	835 mm	32.87 in	13.0 kg	835 mm	32.87 in	13.0 kg	835 mm	32.87 in	13.0 kg	835 mm	32.87 in	13.0 kg			
415 mm	16.34 in	7.0 kg	415 mm	16.34 in	7.0 kg	415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.5 kg
795 mm	31.29 in	14.0 kg	795 mm	31.29 in	14.0 kg	795 mm	31.29 in	13.0 kg	795 mm	31.29 in	13.0 kg	795 mm	31.29 in	13.0 kg	795 mm	31.29 in	13.0 kg	795 mm	31.29 in	13.0 kg	795 mm	31.29 in	13.0 kg	795 mm	31.29 in	13.0 kg	795 mm	31.29 in	13.0 kg	795 mm	31.29 in	13.0 kg
805 mm	31.69 in	14.0 kg	805 mm	31.69 in	14.0 kg	805 mm	31.69 in	13.0 kg	805 mm	31.69 in	13.0 kg	805 mm	31.69 in	13.0 kg	805 mm	31.69 in	13.0 kg	805 mm	31.69 in	13.0 kg	805 mm	31.69 in	13.0 kg	805 mm	31.69 in	13.0 kg	805 mm	31.69 in	13.0 kg	805 mm	31.69 in	13.0 kg



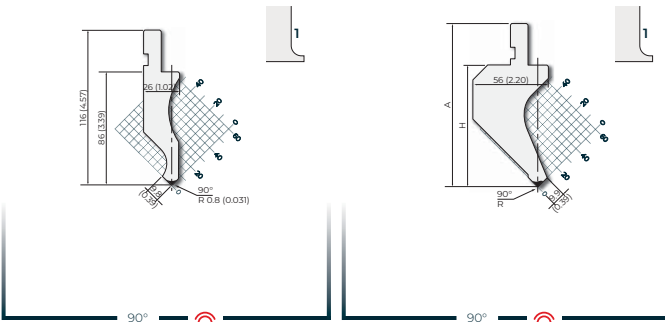
90°



90°

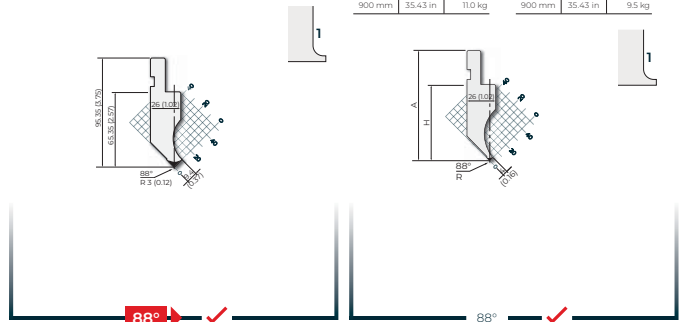
Punches - CLASSIC Series

C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.
DK116.90.R08				PK120.90.R08				PK120.90.R025			
H=88.25 / A=116.25 / R=0.8 (mm)	H=88.25 / A=116.25 / R=0.8 (in)			H=88.25 / A=116.25 / R=0.25 (mm)	H=88.25 / A=116.25 / R=0.25 (in)			H=88.25 / A=116.25 / R=0.25 (mm)	H=88.25 / A=116.25 / R=0.25 (in)		
835 mm	32.87 in	13.0 kg		835 mm	32.87 in	21.0 kg		835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	6.5 kg		415 mm	16.34 in	10.5 kg		415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	13.0 kg	FX	795 mm	31.29 in	21.0 kg	FX	795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	13.0 kg	F	805 mm	31.69 in	21.0 kg	F	805 mm	31.69 in	21.0 kg	F

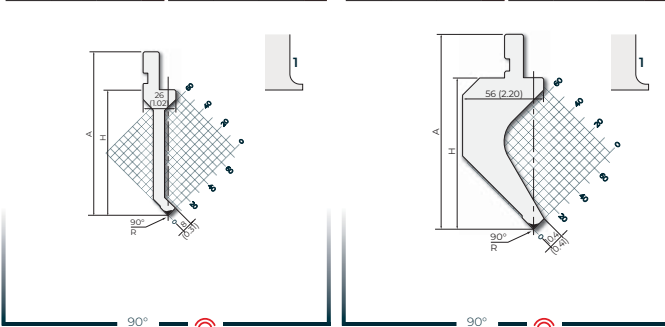


Punches - CLASSIC Series

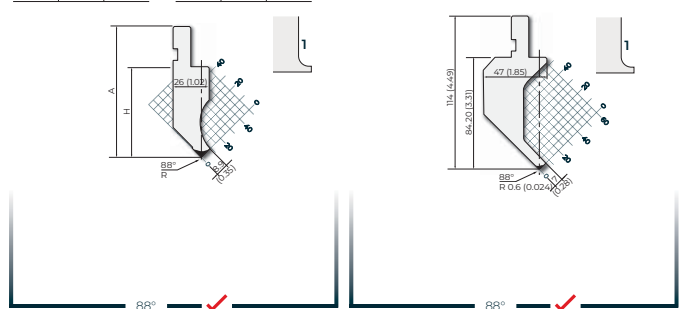
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			350 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			350 kN/m max.
P.95.88.R3				P.97.88.R06				P.97.88.R025			
H=66.65 / A=95.65 / R=0.8 (mm)	H=66.65 / A=95.65 / R=0.8 (in)			H=66.65 / A=96.65 / R=0.25 (mm)	H=66.65 / A=96.65 / R=0.25 (in)			H=66.65 / A=96.65 / R=0.25 (mm)	H=66.65 / A=96.65 / R=0.25 (in)		
835 mm	32.87 in	11.0 kg		835 mm	32.87 in	9.5 kg		835 mm	32.87 in	9.5 kg	
415 mm	16.34 in	5.5 kg		415 mm	16.34 in	5.0 kg		415 mm	16.34 in	5.0 kg	
795 mm	31.29 in	10.0 kg	FX	795 mm	31.29 in	10.0 kg	FX	795 mm	31.29 in	9.2 kg	FX
805 mm	31.69 in	10.0 kg	F	805 mm	31.69 in	10.0 kg	F	805 mm	31.69 in	9.2 kg	F
				900 mm	35.43 in	11.0 kg		900 mm	35.43 in	9.5 kg	



42Cr: 900-1150 N/mm <sup>2</sup>			350 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			350 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.
P.130.90.R06				P.130.90.R025				PK.135.90.R08				PK.135.90.R025			
H=100.00 / A=130.00 / R=0.6 (mm)	H=100.00 / A=130.00 / R=0.6 (in)			H=100.00 / A=130.00 / R=0.25 (mm)	H=100.00 / A=130.00 / R=0.25 (in)			H=104.35 / A=134.35 / R=0.8 (mm)	H=104.35 / A=134.35 / R=0.8 (in)			H=104.60 / A=134.60 / R=0.25 (mm)	H=104.60 / A=134.60 / R=0.25 (in)		
835 mm	32.87 in	11.5 kg		835 mm	32.87 in	11.5 kg		835 mm	32.87 in	22.0 kg		835 mm	32.87 in	22.0 kg	
415 mm	16.34 in	5.7 kg		415 mm	16.34 in	5.7 kg		415 mm	16.34 in	11.5 kg		415 mm	16.34 in	11.5 kg	
795 mm	31.29 in	11.0 kg	FX	795 mm	31.29 in	11.0 kg	FX	795 mm	31.29 in	23.0 kg	FX	795 mm	31.29 in	23.0 kg	FX
805 mm	31.69 in	11.0 kg	F	805 mm	31.69 in	11.0 kg	F	805 mm	31.69 in	23.0 kg	F	805 mm	31.69 in	23.0 kg	F



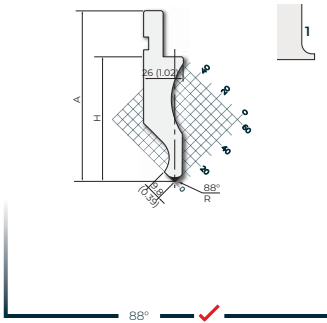
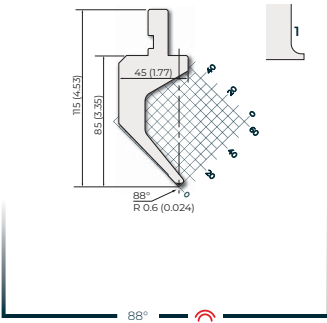
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			200 kN/m max.
P.97.88.R08				PK.97.88.R025				P.114.88.R06			
H=66.65 / A=96.65 / R=0.8 (mm)	H=66.65 / A=96.65 / R=0.8 (in)			H=66.65 / A=96.65 / R=0.25 (mm)	H=66.65 / A=96.65 / R=0.25 (in)			H=114.00 / A=114.00 / R=0.6 (mm)	H=114.00 / A=114.00 / R=0.6 (in)		
835 mm	32.87 in	11.1 kg		835 mm	32.87 in	11.1 kg		835 mm	32.87 in	15.6 kg	
415 mm	16.34 in	5.5 kg		415 mm	16.34 in	5.5 kg		415 mm	16.34 in	7.7 kg	
795 mm	31.29 in	10.6 kg	FX	795 mm	31.29 in	10.0 kg	FX	795 mm	31.29 in	14.5 kg	FX
805 mm	31.69 in	10.6 kg	F	805 mm	31.69 in	10.0 kg	F	805 mm	31.69 in	14.5 kg	F
900 mm	35.43 in	11.0 kg		900 mm	35.43 in	11.8 kg					



Punches - CLASSIC Series

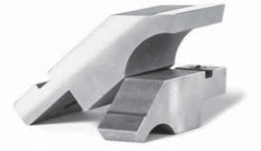
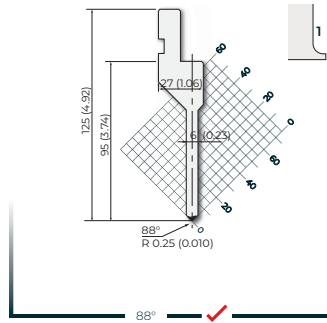
42Cr: 900-1150 N/mm <sup>2</sup>			130 kN/m max.
P.115.88.R06			
835 mm	32.87 in	13.0 kg	
415 mm	16.34 in	6.5 kg	
795 mm	31.29 in	12.4 kg	FX
805 mm	31.69 in	12.6 kg	F

C45: 860-710 N/mm <sup>2</sup>		500 kN/m max.	C45: 560-710 N/mm <sup>2</sup>		500 kN/m max.
D.116.88.R08			D.116.88.R3		
H=88.50 / A=120.00 / R=0.8 (mm)	H=83.50 / A=145.70 / R=0.825 (in)		H=88.50 / A=120.00 / R=0.30 (mm)	H=83.50 / A=145.70 / R=0.318 (in)	
835 mm	32.87 in	11.9 kg	835 mm	32.87 in	11.9 kg
415 mm	16.34 in	5.8 kg	415 mm	16.34 in	5.9 kg
795 mm	31.29 in	11.9 kg	795 mm	31.29 in	11.5 kg
805 mm	31.69 in	11.9 kg	805 mm	31.69 in	11.5 kg



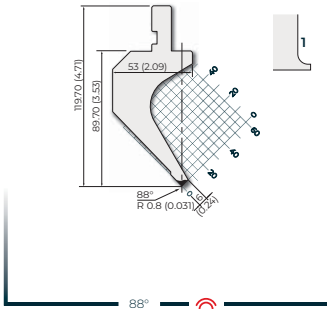
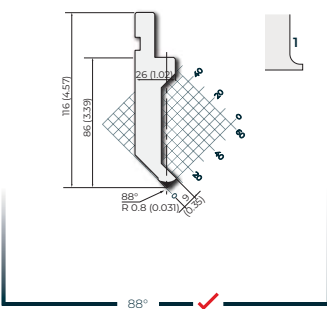
Punches - CLASSIC Series

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
P.125.88.R025			
835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm	31.29 in	9.0 kg	FX
805 mm	31.69 in	9.0 kg	F



C45: 560-710 N/mm <sup>2</sup>			400 kN/m max.
P.116.88.R08			
835 mm	32.87 in	12.0 kg	
415 mm	16.34 in	6.0 kg	
795 mm	31.29 in	12.0 kg	FX
805 mm	31.69 in	12.0 kg	F

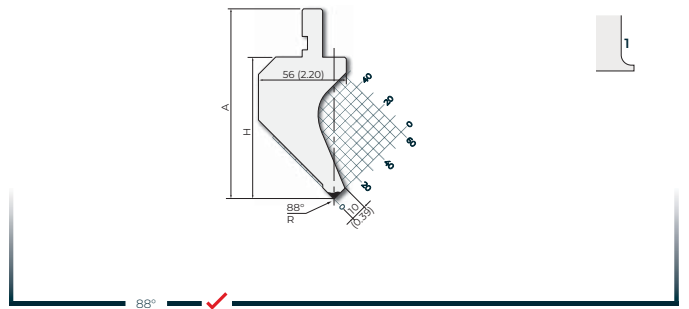
C45: 860-710 N/mm <sup>2</sup>			450 kN/m max.
PS.120.88.R08			
835 mm	32.87 in	17.0 kg	
415 mm	16.34 in	8.4 kg	
795 mm	31.29 in	16.4 kg	FX
805 mm	31.69 in	16.4 kg	F



C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.
P.120.88.R08			
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	11.0 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F

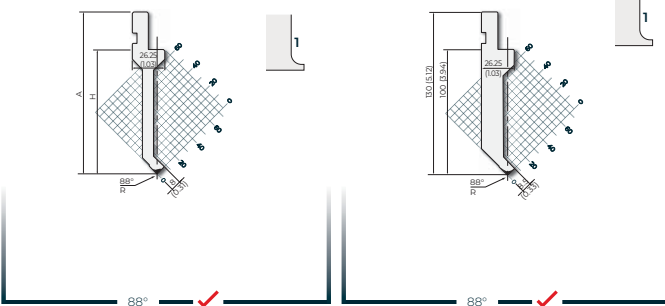
C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.
P.120.88.R3			
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.4 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F

C45: 710 N/mm <sup>2</sup>			600 kN/m max.
PK.120.88.R025			
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.4 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F

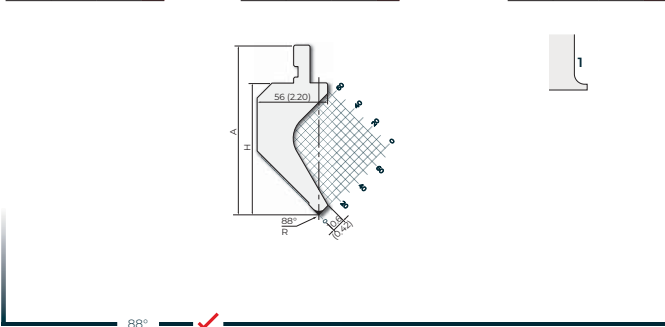


Punches - CLASSIC Series

42Cr: 900-1150 N/mm <sup>2</sup>		42Cr: 900-1150 N/mm <sup>2</sup>		C45: 560-710 N/mm <sup>2</sup>		C45: 560-710 N/mm <sup>2</sup>	
P.130.88.R06		PK.130.88.R025		P.130.88.R08		P.130.88.R025	
H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)
835 mm	32.87 in	9.8 kg	835 mm	32.87 in	9.7 kg	835 mm	32.87 in
415 mm	16.34 in	4.9 kg	415 mm	16.34 in	4.8 kg	415 mm	16.34 in
795 mm	31.29 in	9.4 kg	FX	795 mm	31.29 in	9.3 kg	FX
805 mm	31.69 in	9.4 kg	F	805 mm	31.69 in	9.3 kg	F
900 mm	35.43 in	10.5 kg		900 mm	35.43 in	10.4 kg	

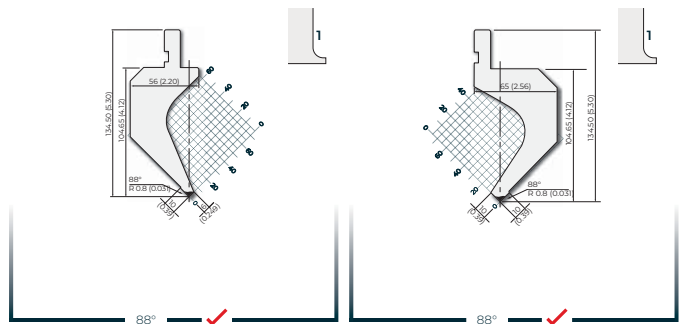


C45: 560-710 N/mm <sup>2</sup>		C45: 560-710 N/mm <sup>2</sup>		C45: 560-710 N/mm <sup>2</sup>		
P.135.88.R08		P.135.88.R3		PK.135.88.R025		
H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	
835 mm	32.87 in	22.5 kg	835 mm	32.87 in	22.7 kg	
415 mm	16.34 in	11.2 kg	415 mm	16.34 in	11.5 kg	
795 mm	31.29 in	21.7 kg	FX	795 mm	31.29 in	21.0 kg
805 mm	31.69 in	21.7 kg	F	805 mm	31.69 in	21.0 kg

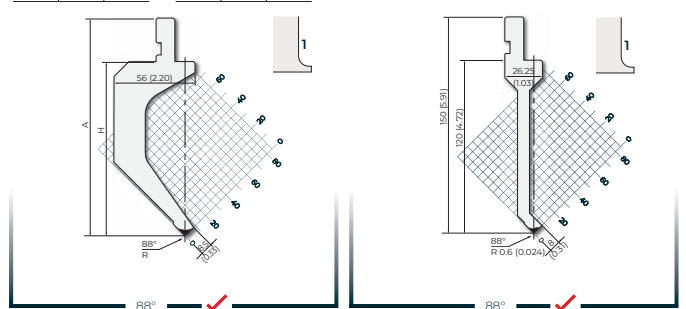


Punches - CLASSIC Series

C45: 560-710 N/mm <sup>2</sup>		450 kN/m max.		C45: 560-710 N/mm <sup>2</sup>		450 kN/m max.	
PS.135.88.R08		PR.135.88.R08		PR.135.88.R08		PR.135.88.R08	
H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)	H=104.65 / A=134.50 / R=0.8 (mm)
835 mm	32.87 in	22.0 kg	835 mm	32.87 in	25.0 kg	835 mm	32.87 in
415 mm	16.34 in	12.5 kg	415 mm	16.34 in	11.5 kg	415 mm	16.34 in
795 mm	31.29 in	21.5 kg	FX	795 mm	31.29 in	24.1 kg	FX
805 mm	31.69 in	21.5 kg	F	805 mm	31.69 in	24.1 kg	F

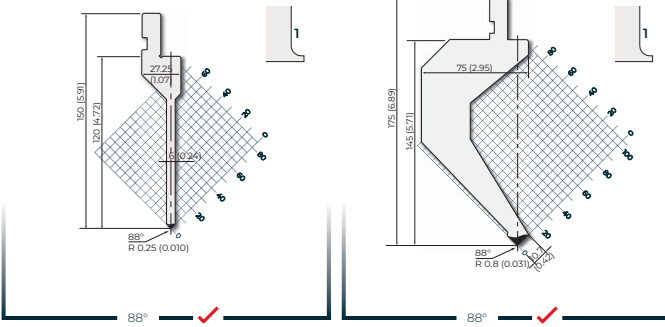


42Cr: 900-1150 N/mm <sup>2</sup>		42Cr: 900-1150 N/mm <sup>2</sup>		42Cr: 900-1150 N/mm <sup>2</sup>		
P.150.88.R08		P.150.88.R3		P.150.88.R06		
H=120.00 / A=150.00 / R=0.8 (mm)	H=120.00 / A=150.00 / R=0.8 (mm)	H=120.00 / A=150.00 / R=0.8 (mm)	H=120.00 / A=150.00 / R=0.8 (mm)	H=120.00 / A=150.00 / R=0.8 (mm)	H=120.00 / A=150.00 / R=0.8 (mm)	
835 mm	32.87 in	21.0 kg	835 mm	32.87 in	19.2 kg	
415 mm	16.34 in	10.5 kg	415 mm	16.34 in	15.0 kg	
795 mm	31.29 in	20.5 kg	FX	795 mm	31.29 in	20.0 kg
805 mm	31.69 in	20.5 kg	F	805 mm	31.69 in	20.0 kg
900 mm	35.43 in	23.0 kg		900 mm	35.43 in	22.6 kg

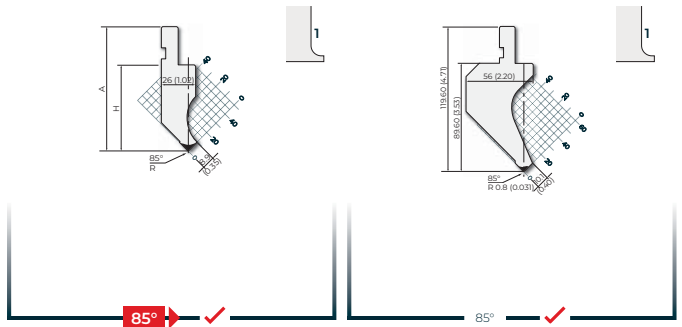




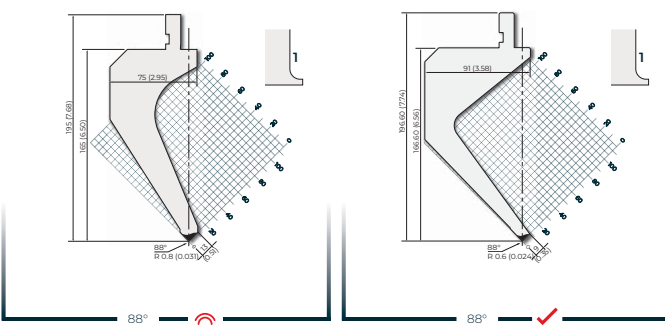
42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.
<b>P.150.88.R025</b>							
835 mm	32.87 in	10.6 kg		835 mm	32.87 in	35.0 kg	
415 mm	16.34 in	5.3 kg		415 mm	16.34 in	17.5 kg	
795 mm	31.29 in	101 kg	FX	795 mm	31.29 in	39.0 kg	FX
805 mm	31.69 in	102 kg	F	805 mm	31.69 in	39.0 kg	F



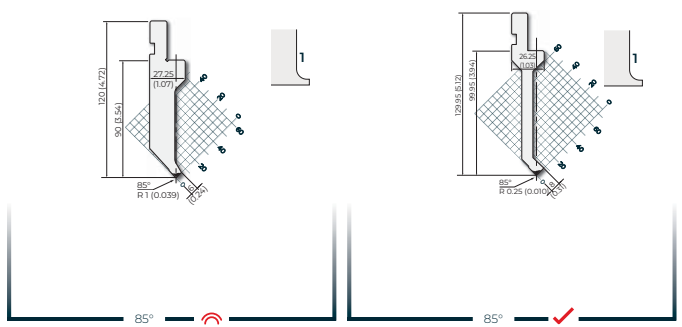
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.
<b>P.97.85.R08</b>											
835 mm	32.87 in	11.0 kg		835 mm	32.87 in	11.0 kg		835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	5.5 kg		415 mm	16.34 in	5.5 kg		415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	10.4 kg	FX	795 mm	31.29 in	10.4 kg	FX	795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	10.6 kg	F	805 mm	31.69 in	10.6 kg	F	805 mm	31.69 in	21.0 kg	F



C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			300 kN/m max.
<b>P.195.88.R08</b>							
835 mm	32.87 in	41.0 kg		835 mm	32.87 in	41.8 kg	
415 mm	16.34 in	20.4 kg		415 mm	16.34 in	20.8 kg	
795 mm	31.29 in	39.5 kg	FX	795 mm	31.29 in	40.2 kg	FX
805 mm	31.69 in	39.5 kg	F	805 mm	31.69 in	40.2 kg	F
				900 mm	35.43 in	45.0 kg	

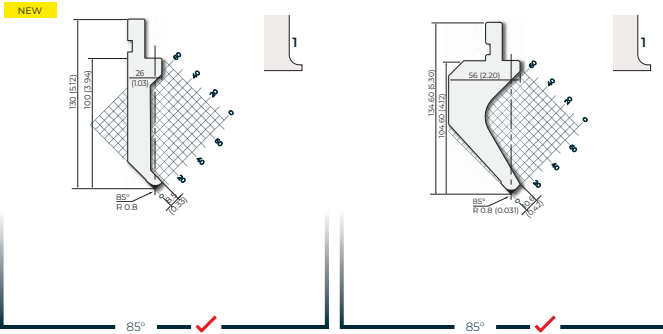


42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			300 kN/m max.
<b>P.120.85.R1</b>							
835 mm	32.87 in	13.5 kg		835 mm	32.87 in	11.5 kg	
415 mm	16.34 in	6.7 kg		415 mm	16.34 in	5.7 kg	
795 mm	31.29 in	12.9 kg	FX	795 mm	31.29 in	10.9 kg	FX
805 mm	31.69 in	13.0 kg	F	805 mm	31.69 in	11.1 kg	F



Punches - CLASSIC Series

C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.
P.130.85.R08				PK.135.65.R08			
835 mm	32.87 in	13.7 kg		835 mm	32.87 in	22.2 kg	
415 mm	16.34 in	6.8 kg		415 mm	16.34 in	11.0 kg	
795 mm	31.29 in	13.0 kg	FX	795 mm	31.29 in	21.7 kg	FX
805 mm	31.69 in	13.2 kg	F	805 mm	31.69 in	21.7 kg	F

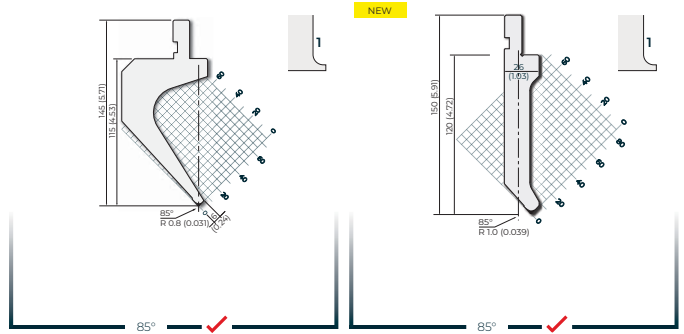


Punches - CLASSIC Series

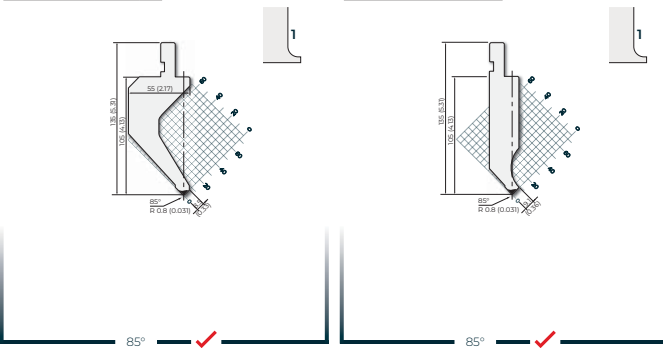


R1

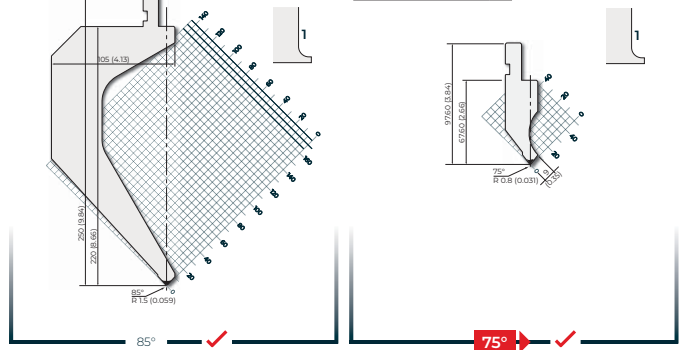
42Cr: 900-1150 N/mm <sup>2</sup>			600 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.
P.145.85.R08				P.150.85.R1			
835 mm	32.87 in	22.6 kg		835 mm	32.87 in	17.5 kg	
415 mm	16.34 in	11.2 kg		415 mm	16.34 in	8.7 kg	
795 mm	31.29 in	20.0 kg	FX	795 mm	31.29 in	16.6 kg	FX
805 mm	31.69 in	20.0 kg	F	805 mm	31.69 in	16.9 kg	F



42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
P.135.85.R08				PS.135.85.R08			
835 mm	32.87 in	20.9 kg		835 mm	32.87 in	17.7 kg	
415 mm	16.34 in	10.4 kg		415 mm	16.34 in	8.5 kg	
795 mm	31.29 in	19.2 kg	FX	795 mm	31.29 in	16.0 kg	FX
805 mm	31.69 in	19.2 kg	F	805 mm	31.69 in	16.0 kg	F

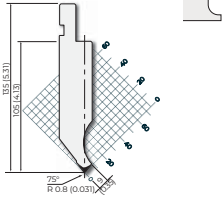


42Cr: 900-1150 N/mm <sup>2</sup>			850 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
P.250.85.R15				P.97/75.R08			
415 mm	16.34 in	33.1 kg		835 mm	32.87 in	11.0 kg	
795 mm	31.29 in	63.3 kg	FX	415 mm	16.34 in	5.5 kg	
				795 mm	31.29 in	11.0 kg	FX
				805 mm	31.69 in	11.0 kg	F



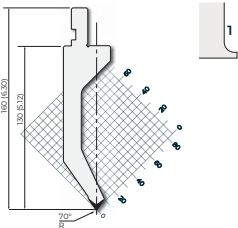
Punches - CLASSIC Series

42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
P.135.75.R08			
835 mm	32.87 in.	175 kg	
415 mm	16.34 in.	8.8 kg	
795 mm	31.29 in.	175 kg	FX
805 mm	31.69 in.	175 kg	F



75° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			42Cr: 900-1150 N/mm <sup>2</sup>			450 kN/m max.
P.160.70.R08			P.160.70.R3			
R=0.8 (0.031)			R=3.0 (0.118)			
835 mm	32.87 in.	18.0 kg	835 mm	32.87 in.	38.0 kg	
415 mm	16.34 in.	8.9 kg	415 mm	16.34 in.	8.9 kg	
795 mm	31.29 in.	173 kg	795 mm	31.29 in.	173 kg	FX
805 mm	31.69 in.	173 kg	805 mm	31.69 in.	173 kg	F

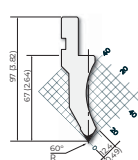


70° ✓

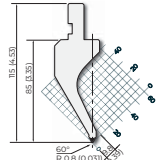


Punches - CLASSIC Series

C45: 560-710 N/mm <sup>2</sup>			C45: 560-710 N/mm <sup>2</sup>			42Cr: 900-1150 N/mm <sup>2</sup>			400 kN/m max.
P.97.60.R08			P.97.60.R2			P.115.60.R08			
R=0.8 (0.031)			R=2.0 (0.079)						
835 mm	32.87 in.	9.0 kg	835 mm	32.87 in.	9.0 kg	835 mm	32.87 in.	11.9 kg	
415 mm	16.34 in.	4.5 kg	415 mm	16.34 in.	5.0 kg	415 mm	16.34 in.	5.9 kg	
795 mm	31.29 in.	9.0 kg	795 mm	31.29 in.	9.0 kg	795 mm	31.29 in.	10.7 kg	FX
805 mm	31.69 in.	9.0 kg	805 mm	31.69 in.	9.0 kg	805 mm	31.69 in.	10.7 kg	F

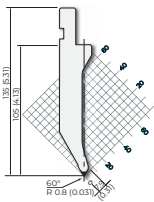


60° ✓

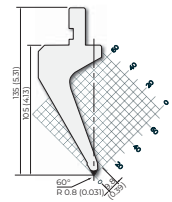


60° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			700 kN/m max.
P.135.60.R08			PG.135.60.R08						
835 mm	32.87 in.	14.0 kg	835 mm	32.87 in.	16.5 kg				
415 mm	16.34 in.	7.0 kg	415 mm	16.34 in.	8.5 kg				
795 mm	31.29 in.	13.5 kg	795 mm	31.29 in.	16.0 kg				FX
805 mm	31.69 in.	13.5 kg	805 mm	31.69 in.	16.0 kg				F



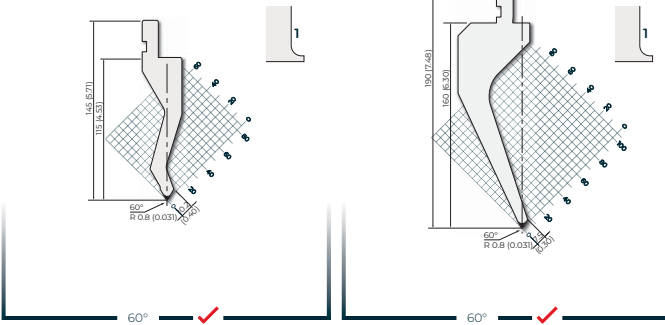
60° ✓



60° ✓

Punches - CLASSIC Series

42Cr- 900-1150 N/mm <sup>2</sup>			700 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			400 kN/m max.
<b>P.145.60.R08</b>				<b>P.190.60.R08</b>			
835 mm	32.87 in	15.0 kg		835 mm	32.87 in	27.0 kg	
415 mm	16.34 in	7.5 kg		415 mm	16.34 in	13.5 kg	
795 mm	31.29 in	15.0 kg	<b>FX</b>	795 mm	31.29 in	26.0 kg	<b>FX</b>
805 mm	31.69 in	15.0 kg	<b>F</b>	805 mm	31.69 in	26.1 kg	<b>F</b>

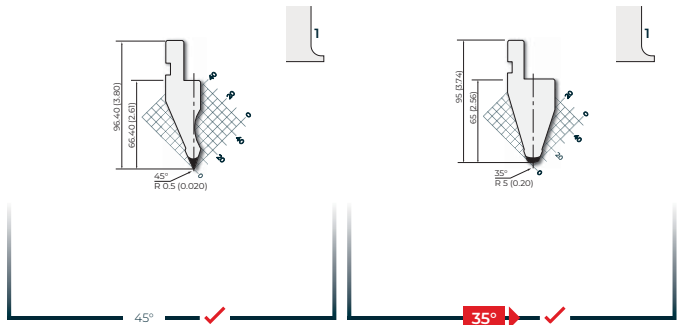


Punches - CLASSIC Series

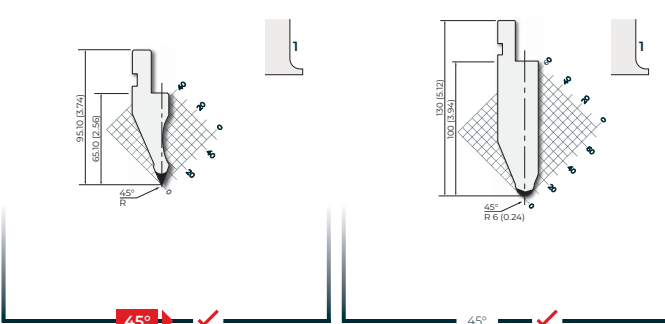


R1

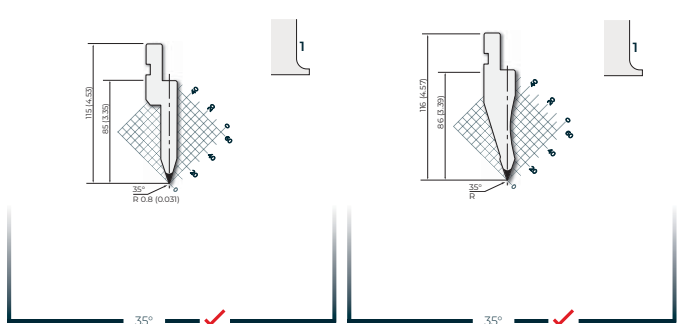
C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>P.97.45.R05</b>				<b>P.95.35.R5</b>			
835 mm	32.87 in	10.2 kg		835 mm	32.87 in	13.5 kg	
415 mm	16.34 in	5.1 kg		415 mm	16.34 in	7.0 kg	
795 mm	31.29 in	10.2 kg	<b>FX</b>	795 mm	31.29 in	14.0 kg	<b>FX</b>
805 mm	31.69 in	10.2 kg	<b>F</b>	805 mm	31.69 in	14.0 kg	<b>F</b>
900 mm	35.43 in	10.2 kg					



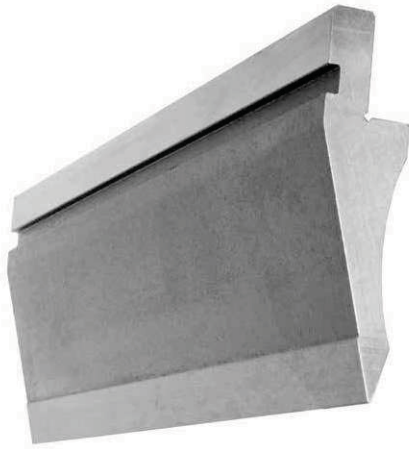
C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>P.95.45.R08</b>				<b>P.95.45.R15</b>				<b>P.130.45.R6</b>			
R=0.8 (0.031)				R=1.5 (0.059)							
835 mm	32.87 in	9.5 kg		835 mm	32.87 in	9.5 kg		835 mm	32.87 in	19.5 kg	
415 mm	16.34 in	4.2 kg		415 mm	16.34 in	4.2 kg		415 mm	16.34 in	9.6 kg	
795 mm	31.29 in	9.0 kg	<b>FX</b>	795 mm	31.29 in	9.5 kg	<b>FX</b>	795 mm	31.29 in	18.3 kg	<b>FX</b>
805 mm	31.69 in	9.0 kg	<b>F</b>	805 mm	31.69 in	9.5 kg	<b>F</b>	805 mm	31.69 in	18.3 kg	<b>F</b>



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.
<b>PJ.85.35.R08</b>				<b>P.116.35.R08</b>				<b>P.116.35.R15</b>			
				R=0.8 (0.031)				R=1.5 (0.059)			
835 mm	32.87 in	11.0 kg		835 mm	32.87 in	10.5 kg		835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg		415 mm	16.34 in	5.7 kg		415 mm	16.34 in	5.7 kg	
795 mm	31.29 in	10.5 kg	<b>FX</b>	795 mm	31.29 in	10.1 kg	<b>FX</b>	795 mm	31.29 in	10.0 kg	<b>FX</b>
805 mm	31.69 in	10.5 kg	<b>F</b>	805 mm	31.69 in	10.1 kg	<b>F</b>	805 mm	31.69 in	10.0 kg	<b>F</b>



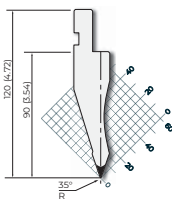




C45: 560-710 N/mm <sup>2</sup> 700 kN/m max.		
P.120.35.R08		
R=0.8 (0.031)		
835 mm	32.87 in	12.3 kg
415 mm	16.34 in	6.1 kg
795 mm	31.29 in	11.5 kg <b>FX</b>
805 mm	31.69 in	11.5 kg <b>F</b>

C45: 560-710 N/mm <sup>2</sup> 700 kN/m max.		
P.120.35.R15		
R=1.5 (0.059)		
835 mm	32.87 in	12.5 kg
415 mm	16.34 in	6.0 kg
795 mm	31.29 in	12.0 kg <b>FX</b>
805 mm	31.69 in	12.0 kg <b>F</b>

C45: 560-710 N/mm <sup>2</sup> 700 kN/m max.		
P.120.35.R3		
R=3.0 (0.118)		
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.4 kg
795 mm	31.29 in	12.0 kg <b>FX</b>
805 mm	31.69 in	12.0 kg <b>F</b>

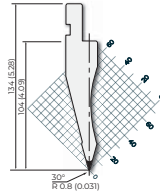


35° 

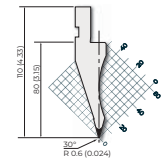


C45: 560-710 N/mm <sup>2</sup> 700 kN/m max.		
PS.134.30.R08		
835 mm	32.87 in	13.3 kg
415 mm	16.34 in	6.5 kg
795 mm	31.29 in	12.5 kg <b>FX</b>
805 mm	31.69 in	12.5 kg <b>F</b>

C45: 560-710 N/mm <sup>2</sup> 500 kN/m max.		
P.110.30.R06		
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm	31.29 in	10.0 kg <b>FX</b>
805 mm	31.69 in	10.0 kg <b>F</b>



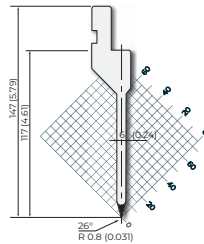
30° 



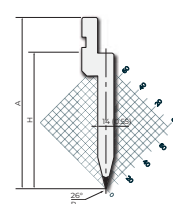
30° 

42Cr: 900-1150 N/mm <sup>2</sup> 500 kN/m max.		
P.147.26.R08		
835 mm	32.87 in	9.8 kg
415 mm	16.34 in	4.9 kg
795 mm	31.29 in	9.8 kg <b>FX</b>
805 mm	31.69 in	9.8 kg <b>F</b>

C45: 560-710 N/mm <sup>2</sup> 1000 kN/m max.		C45: 560-710 N/mm <sup>2</sup> 1000 kN/m max.			
PU.117.26.R08		PU.117.26.R3			
H=117.00 / A=147.00 / R=0.8 (mm) H=4.609 / A=183.79 / R=0.031 (in)		H=109.00 / A=139.00 / R=3.0 (mm) H=4.291 / A=135.47 / R=0.118 (in)			
835 mm	32.87 in	13.5 kg	835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.5 kg	415 mm	16.34 in	6.7 kg
795 mm	31.29 in	12.6 kg <b>FX</b>	795 mm	31.29 in	13.5 kg <b>FX</b>
805 mm	31.69 in	12.6 kg <b>F</b>	805 mm	31.69 in	13.5 kg <b>F</b>



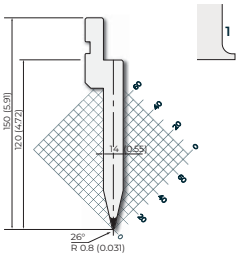
26° 



26° 

Punches - CLASSIC Series

C4S: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
PU150.26.R08.L			
900 mm	35.43 in	15.0 kg	
415 mm	16.34 in	6.2 kg	
795 mm	31.29 in	12.0 kg	FX
805 mm	31.69 in	12.0 kg	F



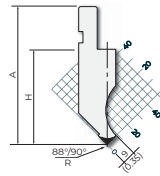
26° ✓

Punches - A Series

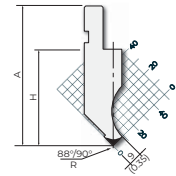


R1

C4S: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C4S: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C4S: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C4S: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
00402				01602				00430				01630			
H=66.91 / A=96.91 / 88° (mm) / H=2.63 / A=3.81 / R=0.008 (in)				H=66.91 / A=96.91 / 90° (mm) / H=2.63 / A=3.81 / R=0.008 (in)				H=104.91 / A=154.91 / 88° (mm) / H=4.12 / A=6.12 / R=0.008 (in)				H=104.91 / A=154.91 / 90° (mm) / H=4.12 / A=6.12 / R=0.008 (in)			
835 mm	32.87 in	11.0 kg		835 mm	32.87 in	11.0 kg		835 mm	32.87 in	11.1 kg		835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg		415 mm	16.34 in	5.5 kg		415 mm	16.34 in	5.5 kg		415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX	795 mm	31.29 in	10.5 kg	FX	795 mm	31.29 in	10.5 kg	FX	795 mm	31.29 in	10.5 kg	FX
800 mm	31.50 in	10.5 kg	F	800 mm	31.50 in	10.5 kg	F	800 mm	31.50 in	10.5 kg	F	800 mm	31.50 in	10.5 kg	F



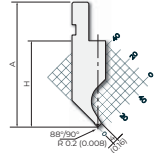
88° - 90° ✓



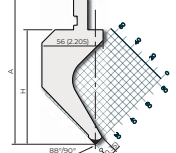
88° - 90° ✓



42Cr: 900-1150 N/mm <sup>2</sup>			200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
T1700				T1600				04502				04600			
H=66.91 / A=96.91 / 88° (mm) / H=2.63 / A=3.81 (in)				H=66.91 / A=96.91 / 90° (mm) / H=2.63 / A=3.81 (in)				H=104.91 / A=154.91 / 88° (mm) / H=4.12 / A=6.12 (in)				H=104.91 / A=154.91 / 90° (mm) / H=4.12 / A=6.12 (in)			
835 mm	32.87 in	10.7 kg		835 mm	32.87 in	11.0 kg		835 mm	32.87 in	22.0 kg		835 mm	32.87 in	22.0 kg	
415 mm	16.34 in	5.3 kg		415 mm	16.34 in	5.5 kg		415 mm	16.34 in	10.9 kg		415 mm	16.34 in	11.0 kg	
795 mm	31.29 in	10.3 kg	FX	795 mm	31.29 in	10.1 kg	FX	795 mm	31.29 in	22.0 kg	FX	795 mm	31.29 in	21.0 kg	FX
800 mm	31.50 in	10.2 kg	FC	800 mm	31.50 in	11.0 kg	FC	800 mm	31.50 in	22.0 kg	FC	800 mm	31.50 in	21.3 kg	FC



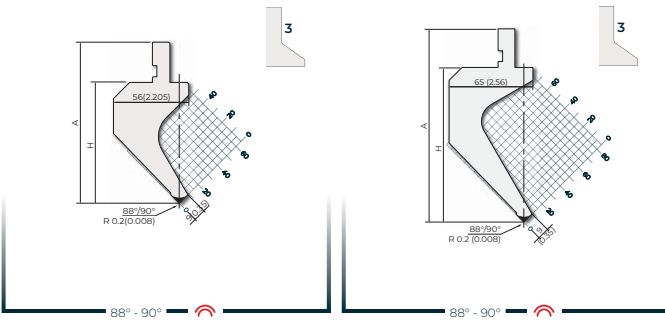
88° - 90° ✓



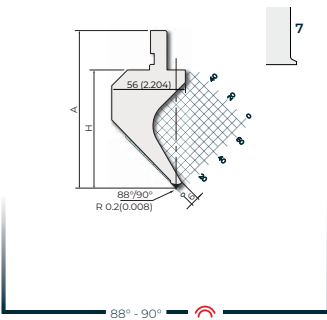
88° - 90° ✓

Punches - **A Series**

42Cr: 900-1150 N/mm <sup>2</sup>		700 kN/m max.		42Cr: 900-1150 N/mm <sup>2</sup>		700 kN/m max.	
45202		46200		42Cr: 900-1150 N/mm <sup>2</sup>		500 kN/m max.	
H=89.9 / A=19.9 / SP (mm) / H=3.54 / A=0.78 (in)		H=89.9 / A=19.9 / SP (mm) / H=3.54 / A=0.78 (in)		H=104.0 / A=20.0 / SP (mm) / H=4.12 / A=0.80 (in)		H=104.0 / A=20.0 / SP (mm) / H=4.12 / A=0.80 (in)	
835 mm	32.87 in	19.6 kg		835 mm	32.87 in	19.6 kg	
415 mm	16.34 in	9.7 kg		415 mm	16.34 in	9.8 kg	
795 mm	31.29 in	18.9 kg	FX	795 mm	31.29 in	18.7 kg	FX
800 mm	31.50 in	18.9 kg	FC	800 mm	31.50 in	18.9 kg	FC

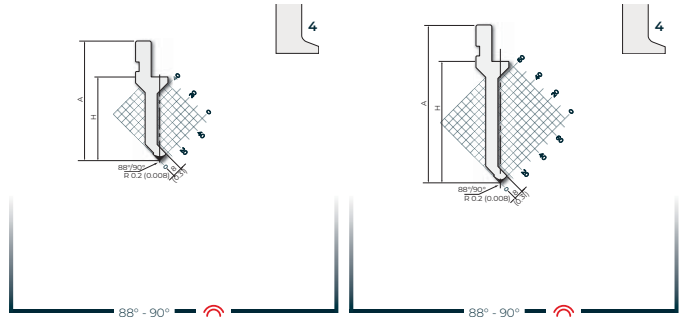


42Cr: 900-1150 N/mm <sup>2</sup>		500 kN/m max.		42Cr: 900-1150 N/mm <sup>2</sup>		500 kN/m max.	
45302		46300		42Cr: 900-1150 N/mm <sup>2</sup>		500 kN/m max.	
H=89.9 / A=19.9 / SP (mm) / H=3.54 / A=0.78 (in)		H=89.9 / A=19.9 / SP (mm) / H=3.54 / A=0.78 (in)		H=104.0 / A=20.0 / SP (mm) / H=4.12 / A=0.80 (in)		H=104.0 / A=20.0 / SP (mm) / H=4.12 / A=0.80 (in)	
835 mm	32.87 in	18.6 kg		835 mm	32.87 in	18.6 kg	
415 mm	16.34 in	9.3 kg		415 mm	16.34 in	9.3 kg	
795 mm	31.29 in	17.7 kg	FX	795 mm	31.29 in	17.7 kg	FX
800 mm	31.50 in	17.9 kg	FC	800 mm	31.50 in	17.9 kg	FC



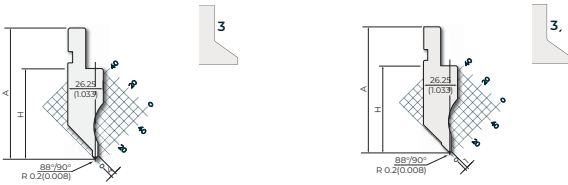
Punches - **A Series**

42Cr: 900-1150 N/mm <sup>2</sup>		300 kN/m max.		42Cr: 900-1150 N/mm <sup>2</sup>		300 kN/m max.	
20000		20100		42Cr: 900-1150 N/mm <sup>2</sup>		300 kN/m max.	
H=89.9 / A=19.9 / SP (mm) / H=3.54 / A=0.78 (in)		H=89.9 / A=19.9 / SP (mm) / H=3.54 / A=0.78 (in)		H=89.9 / A=19.9 / SP (mm) / H=3.54 / A=0.78 (in)		H=89.9 / A=19.9 / SP (mm) / H=3.54 / A=0.78 (in)	
835 mm	32.87 in	7.9 kg		835 mm	32.87 in	7.9 kg	
415 mm	16.34 in	3.9 kg		415 mm	16.34 in	3.9 kg	
795 mm	31.29 in	7.5 kg	FX	795 mm	31.29 in	7.6 kg	FX
800 mm	31.50 in	7.5 kg	FC	800 mm	31.50 in	7.7 kg	FC

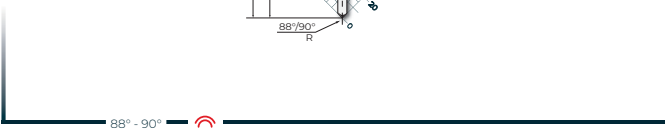
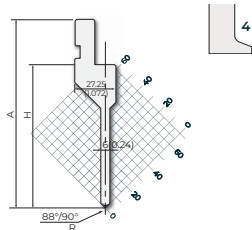


Punches - **RT** A Series

C45: 560-710 N/mm <sup>2</sup> 1000 kN/m max.			C45: 560-710 N/mm <sup>2</sup> 400 kN/m max.			C45: 560-710 N/mm <sup>2</sup> 800 kN/m max.			C45: 560-710 N/mm <sup>2</sup> 800 kN/m max.		
00480			01680			00490			01690		
H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]			H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]			H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]			H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]		
835 mm	32.87 in	11.0 kg	835 mm	32.87 in	10.7 kg	835 mm	32.87 in	11.0 kg	835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg	415 mm	16.34 in	5.5 kg
795 mm	31.29 in	10.5 kg <b>FX</b>	795 mm	31.29 in	10.2 kg <b>FX</b>	795 mm	31.29 in	10.5 kg <b>FX</b>	795 mm	31.29 in	10.5 kg <b>FX</b>
800 mm	31.50 in	10.5 kg <b>FC</b>	800 mm	31.50 in	10.3 kg <b>FC</b>	800 mm	31.50 in	10.6 kg <b>FC</b>	800 mm	31.50 in	10.6 kg <b>FC</b>

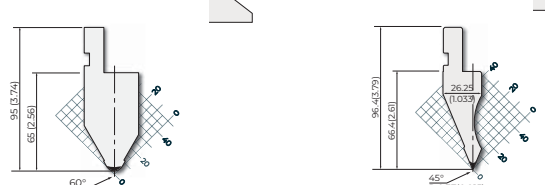


42Cr: 900-1150 N/mm <sup>2</sup> 500 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup> 500 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup> 500 kN/m max.		
10900			10906			10800		
H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]			H=84.74 / A=124.74 / R=0.6 / 88° [mm] H=3.327 / A=4.97 / R=0.024 [in]			H=84.97 / A=124.97 / R=0.2 (90°) [mm] H=3.327 / A=4.97 / R=0.008 [in]		
835 mm	32.87 in	9.0 kg	835 mm	32.87 in	9.0 kg	835 mm	32.87 in	11.0 kg
415 mm	16.34 in	4.5 kg	415 mm	16.34 in	4.5 kg	415 mm	16.34 in	5.5 kg
795 mm	31.29 in	8.5 kg <b>FX</b>	795 mm	31.29 in	8.5 kg <b>FX</b>	795 mm	31.29 in	8.5 kg <b>FX</b>
800 mm	31.50 in	8.6 kg <b>FC</b>	800 mm	31.50 in	8.6 kg <b>FC</b>	800 mm	31.50 in	8.6 kg <b>FC</b>

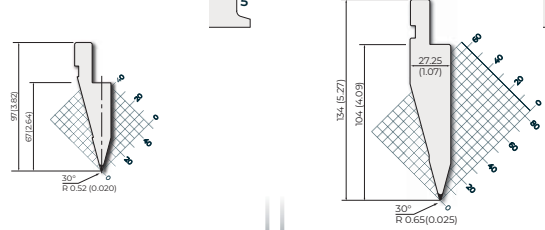


Punches - **RT** A Series

C45: 560-710 N/mm <sup>2</sup> 1000 kN/m max.			C45: 560-710 N/mm <sup>2</sup> 600 kN/m max.		
00300			00800		
H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]			H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]		
835 mm	32.87 in	15.0 kg	835 mm	32.87 in	9.3 kg
415 mm	16.34 in	7.5 kg	415 mm	16.34 in	4.6 kg
795 mm	31.29 in	14.4 kg <b>FX</b>	795 mm	31.29 in	9.3 kg <b>FX</b>
800 mm	31.50 in	14.4 kg <b>FC</b>	800 mm	31.50 in	9.3 kg <b>FC</b>



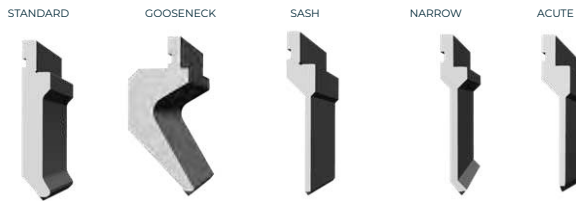
42Cr: 900-1150 N/mm <sup>2</sup> 1000 kN/m max.			C45: 560-710 N/mm <sup>2</sup> 1000 kN/m max.		
10300			21000		
H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]			H=84.97 / A=124.97 / R=0.2 (88°) [mm] H=3.327 / A=4.97 / R=0.008 [in]		
835 mm	32.87 in	11.0 kg	835 mm	32.87 in	15.3 kg
415 mm	16.34 in	5.5 kg	415 mm	16.34 in	7.6 kg
795 mm	31.29 in	10.4 kg <b>FX</b>	795 mm	31.29 in	14.5 kg <b>FX</b>
800 mm	31.50 in	10.5 kg <b>FC</b>	800 mm	31.50 in	14.6 kg <b>FC</b>





Punches - **AFH Series**

Rolleri offers you fixed height solution compatible with Amada and other European Fixed Height press brake tool styles. We offer the best solution in shapes, guaranteeing to increase flexibility of your press brake. All Rolleri tools are state of the art manufactured to ensure precision bending. Using only best quality steels on the market and applying induction deep hardening up to 60 HRC we provide tools that align with a tolerance of +/- .0004" - 0,01 mm and have the longest working lifetime in the market. Rolleri provides best standard solutions based in 30 years experience in over 65 countries around the globe. We also manufacture custom solutions for any bending needs and applications guarantee always the best quality and precision on each and every single one of our tools.



C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.85.R1</b>							
835 mm	32.87 in.	175 kg	Also available H=85	835 mm	32.87 in.	21.0 kg	Also available H=85
415 mm	16.34 in.	8.7 kg		415 mm	16.34 in.	10.5 kg	
795 mm	31.29 in.	16.6 kg	FX	795 mm	31.29 in.	20.5 kg	FX
805 mm	31.69 in.	16.9 kg	F	800 mm	31.50 in.	20.5 kg	FC

C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.88.R08</b>							
900 mm	35.43 in.	10.6 kg	Also available H=85	900 mm	35.43 in.	12.9 kg	Also available H=85
415 mm	16.34 in.	5.3 kg		415 mm	16.34 in.	5.9 kg	
795 mm	31.29 in.	10.1 kg	FX	795 mm	31.29 in.	12.2 kg	FX
805 mm	31.69 in.	10.2 kg	F	805 mm	31.69 in.	12.4 kg	F

C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.85.R1</b>							
150 mm	5.91 in.	26	R 1 (0.039)	150 mm	5.91 in.	21.0	R 0.8 (0.031)
120 mm	4.72 in.			120 mm	4.72 in.		

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.30.R08</b>							
900 mm	35.43 in.	10.8 kg	Also available H=85	900 mm	35.43 in.	10.8 kg	Also available H=85
415 mm	16.34 in.	4.9 kg		415 mm	16.34 in.	4.9 kg	
795 mm	31.29 in.	9.5 kg	FX	795 mm	31.29 in.	9.5 kg	FX
805 mm	31.69 in.	9.6 kg	F	805 mm	31.69 in.	9.6 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.88.R02S</b>							
900 mm	35.43 in.	10.6 kg	Also available H=85	900 mm	35.43 in.	12.9 kg	Also available H=85
415 mm	16.34 in.	5.3 kg		415 mm	16.34 in.	5.9 kg	
795 mm	31.29 in.	10.1 kg	FX	795 mm	31.29 in.	12.2 kg	FX
805 mm	31.69 in.	10.2 kg	F	805 mm	31.69 in.	12.4 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.88.R06</b>							
900 mm	35.43 in.	10.6 kg	Also available H=85	900 mm	35.43 in.	12.9 kg	Also available H=85
415 mm	16.34 in.	5.3 kg		415 mm	16.34 in.	5.9 kg	
795 mm	31.29 in.	10.1 kg	FX	795 mm	31.29 in.	12.2 kg	FX
805 mm	31.69 in.	10.2 kg	F	805 mm	31.69 in.	12.4 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.88.R02S</b>							
900 mm	35.43 in.	10.6 kg	Also available H=85	900 mm	35.43 in.	12.9 kg	Also available H=85
415 mm	16.34 in.	5.3 kg		415 mm	16.34 in.	5.9 kg	
795 mm	31.29 in.	10.1 kg	FX	795 mm	31.29 in.	12.2 kg	FX
805 mm	31.69 in.	10.2 kg	F	805 mm	31.69 in.	12.4 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.88.R06</b>							
900 mm	35.43 in.	10.6 kg	Also available H=85	900 mm	35.43 in.	12.9 kg	Also available H=85
415 mm	16.34 in.	5.3 kg		415 mm	16.34 in.	5.9 kg	
795 mm	31.29 in.	10.1 kg	FX	795 mm	31.29 in.	12.2 kg	FX
805 mm	31.69 in.	10.2 kg	F	805 mm	31.69 in.	12.4 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.30.R08</b>							
900 mm	35.43 in.	10.8 kg	Also available H=85	900 mm	35.43 in.	10.8 kg	Also available H=85
415 mm	16.34 in.	4.9 kg		415 mm	16.34 in.	4.9 kg	
795 mm	31.29 in.	9.5 kg	FX	795 mm	31.29 in.	9.5 kg	FX
805 mm	31.69 in.	9.6 kg	F	805 mm	31.69 in.	9.6 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.88.R02S</b>							
900 mm	35.43 in.	10.6 kg	Also available H=85	900 mm	35.43 in.	12.9 kg	Also available H=85
415 mm	16.34 in.	5.3 kg		415 mm	16.34 in.	5.9 kg	
795 mm	31.29 in.	10.1 kg	FX	795 mm	31.29 in.	12.2 kg	FX
805 mm	31.69 in.	10.2 kg	F	805 mm	31.69 in.	12.4 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>AFH.150.88.R06</b>							
900 mm	35.43 in.	10.6 kg	Also available H=85	900 mm	35.43 in.	12.9 kg	Also available H=85
415 mm	16.34 in.	5.3 kg		415 mm	16.34 in.	5.9 kg	
795 mm	31.29 in.	10.1 kg	FX	795 mm	31.29 in.	12.2 kg	FX
805 mm	31.69 in.	10.2 kg	F	805 mm	31.69 in.	12.4 kg	F

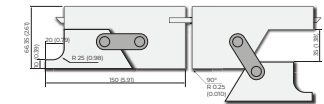
## Mobile Horns -

- For easy bending of special box profiles
- Can be produced for these Rolleri R1 tool models:

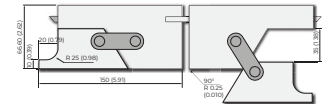
88°	85°	70°	60°	26°
P97.88.R08	TOP.175.85.R08	P160.70.R08	P.135.60.R08	PU.117.26.R08
P97.88.R08	TOP.205.85.R08		P.145.60.R08	TOP.205.26.R08
P130.88.R08			TOP.175.60.R08	TOP.175.26.R08
P150.88.R08				



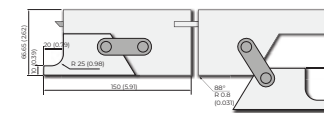
C45: 560-710 N/mm<sup>2</sup> 150 kN/m max.  
**SCA.M.90.R08**  
 per pair 3,5 kg 1 Pair left/right compatible with Pk.97.90.R08



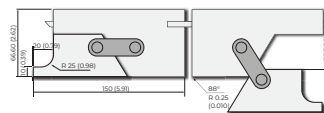
C45: 560-710 N/mm<sup>2</sup> 150 kN/m max.  
**SCA.M.90.R025**  
 per pair 3,5 kg 1 Pair left/right compatible with Pk.97.90.R025



C45: 560-710 N/mm<sup>2</sup> 150 kN/m max.  
**SCA.M.88.R08**  
 per pair 3,5 kg 1 Pair left/right compatible with P.97.88.R08



C45: 560-710 N/mm<sup>2</sup> 150 kN/m max.  
**SCA.M.88.R025**  
 per pair 3,5 kg 1 Pair left/right compatible with Pk.97.88.R025

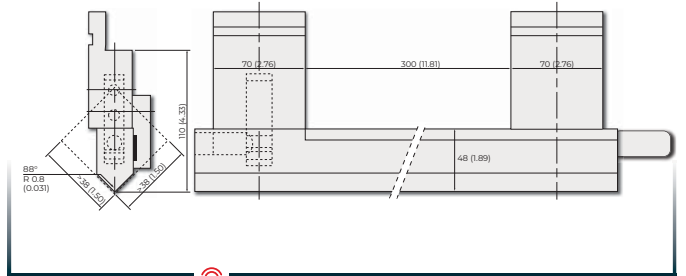


## Punches for closed profiles -



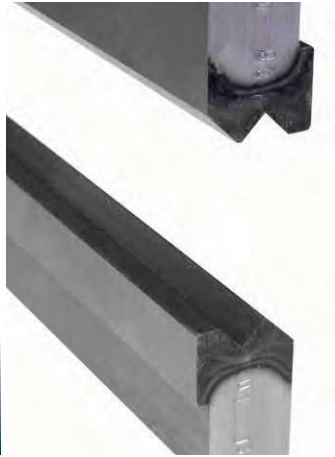
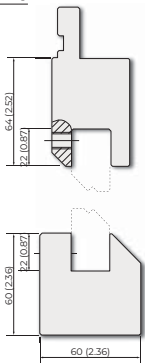
R1

42Cr: 900-1150 N/mm<sup>2</sup> 150 kN/m max.  
**SPE.11**  
 70 kg Per piece



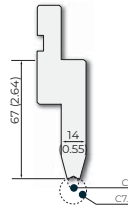
## Joggle Tools -

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
CPZ			
835 mm	32.87 in	375 kg	
415 mm	16.34 in	187 kg	



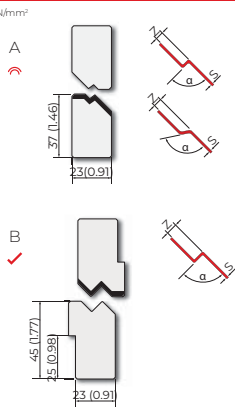
## Radius Tools -

C45: 560-710 N/mm <sup>2</sup>			400 kN/m max.
PU.67.14-S			
830 mm	32.68 in	97 kg	
410 mm	16.14 in	5.0 kg	



C45: 560-710 N/mm <sup>2</sup>						1000 kN/m max.
Joggle Tool Inserts						
Model	Z [mm]	Z [in]	α	S <sup>1</sup> [mm]	S <sup>2</sup> [in]	Weight

Model	Z [mm]	Z [in]	α	S <sup>1</sup> [mm]	S <sup>2</sup> [in]	Weight
CEZ 1.0	10	0.04	160°	12	0.05	11.0 kg
CEZ 1.5	15	0.06	160°	15	0.06	11.0 kg
CEZ 2.0	20	0.08	150°	14	0.06	11.0 kg
CEZ 2.5	25	0.10	140°	13	0.05	11.0 kg
CEZ 10/90	10	0.04	90°	0.3	0.01	11.0 kg
CEZ 15/90	15	0.06	90°	0.3	0.01	11.0 kg
CEZ 20/90	20	0.08	90°	0.4	0.02	11.0 kg
CEZ 25/90	25	0.10	90°	0.5	0.02	11.0 kg
CEZ 3.0	30	0.12	90°	1.0	0.04	10.3 kg
CEZ 3.5	35	0.14	90°	1.0	0.04	10.0 kg
CEZ 4.0	40	0.16	90°	1.2	0.05	10.0 kg
CEZ 4.5	45	0.18	90°	1.2	0.05	10.0 kg
CEZ 5.0	50	0.20	90°	1.3	0.05	10.0 kg
CEZ 5.5	55	0.22	90°	1.4	0.06	10.0 kg
CEZ 6.0	60	0.24	90°	1.5	0.06	10.0 kg
CEZ 6.5	65	0.26	90°	1.5	0.06	10.0 kg
CEZ 7.0	70	0.28	90°	1.5	0.06	10.0 kg
CEZ 7.5	75	0.30	90°	1.6	0.06	10.0 kg
CEZ 8.0	80	0.31	90°	1.6	0.06	10.0 kg
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg
CEZ 15.0	15	0.59	90°	2.3	0.09	13.5 kg



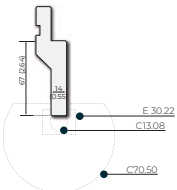
C45: 560-710 N/mm <sup>2</sup>						400 kN/m max.
C3 - C7.5						
Model	R [mm]	R [in]	Weight	Weight		

Model	R [mm]	R [in]	Weight	Weight		
C3	3.0	0.12	0.20 kg	0.10 kg		
C3.5	3.5	0.14	0.20 kg	0.10 kg		
C4	4.0	0.16	0.35 kg	0.17 kg		
C4.5	4.5	0.18	0.50 kg	0.25 kg		
C5	5.0	0.20	0.60 kg	0.30 kg		
C5.5	5.5	0.22	0.70 kg	0.35 kg		
C6	6.0	0.24	0.80 kg	0.40 kg		
C6.5	6.5	0.26	1.00 kg	0.50 kg		
C7	7.0	0.28	0.80 kg	0.40 kg		
C7.5	7.5	0.30	1.00 kg	0.50 kg		



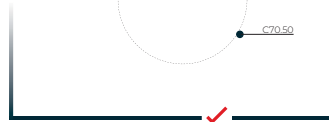
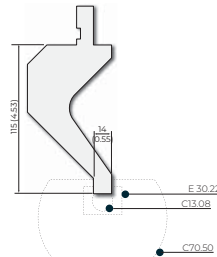
## Radius Tools -

C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.
PU.67.14			
830 mm	32.68 in	9.0 kg	
412 mm	16.14 in	5.0 kg	

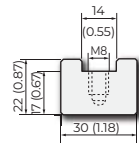


## Radius Tools and Hemming tool -

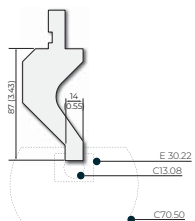
C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.
PU.115.14			
830 mm	32.68 in	26.0 kg	
412 mm	16.22 in	13.0 kg	



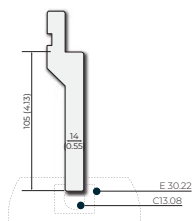
C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.
E30.22			
830 mm	32.68 in	3.5 kg	▶ Hemming tool
412 mm	16.22 in	1.7 kg	



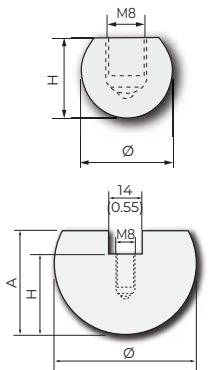
C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.
PU.87.14			
830 mm	32.68 in	9.0 kg	
412 mm	16.22 in	4.5 kg	



C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.
PU.105.14			
830 mm	32.68 in	12.0 kg	
412 mm	16.22 in	6.0 kg	



C45: 560-710 N/mm <sup>2</sup>										800 kN/m max.
Radius tools ø 16 - 100										
Model	Z	Ø	H	H	A	A	Weight	Weight		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
C13.08	16	0.63	13	0.51	-	-	2.0 kg	1.0 kg		
C13.09	18	0.71	16	0.63	-	-	2.0 kg	1.0 kg		
C16.10	20	0.79	16	0.63	-	-	2.0 kg	1.0 kg		
C17.12	25	0.98	17	0.67	22	0.87	2.5 kg	1.2 kg		
C20.15	30	1.18	20	0.79	27	1.06	3.7 kg	1.8 kg		
C22.17	35	1.38	22	0.87	32	1.26	5.0 kg	2.4 kg		
C24.20	40	1.57	24	0.94	34	1.33	7.0 kg	3.5 kg		
C25.22	45	1.77	25	0.98	35	1.38	7.5 kg	3.8 kg		
C29.25	50	1.97	29	1.14	39	1.53	10.0 kg	4.7 kg		
C34.27	55	2.16	34	1.33	44	1.73	12.4 kg	6.2 kg		
C34.30	60	2.36	34	1.33	44	1.73	13.5 kg	6.7 kg		
C37.32	65	2.56	37	1.46	47	1.85	15.9 kg	7.9 kg		
C45.35	70	2.75	45	1.77	55	2.16	20.3 kg	10.0 kg		
C42.37	75	2.95	42	1.65	52	2.04	20.5 kg	10.3 kg		
C45.40	80	3.15	45	1.77	55	2.16	23.0 kg	11.5 kg		
C60.45	90	3.54	60	2.36	70	2.75	34.0 kg	17.0 kg		
C70.50	100	3.93	70	2.75	80	3.15	43.5 kg	21.7 kg		





## DIES ROLLER TYPE R1

### ▼ COMPATIBILITY

Accurl  
Accurpress  
ACL  
Adira  
Amada  
Atlantic  
Baykal  
BL  
Boschert  
Boutillon  
Bystronic Beyeler  
Euro-B  
Coastone  
Colgar  
Dener  
Deratech

Durmazlar  
Ermaksan  
Farina  
Gade  
Gasparini  
Gecko  
Gillard  
Gizelis  
Haco  
Hindustan  
HPM  
Iturrospe  
Jfy  
JMT  
LFK  
Metfab

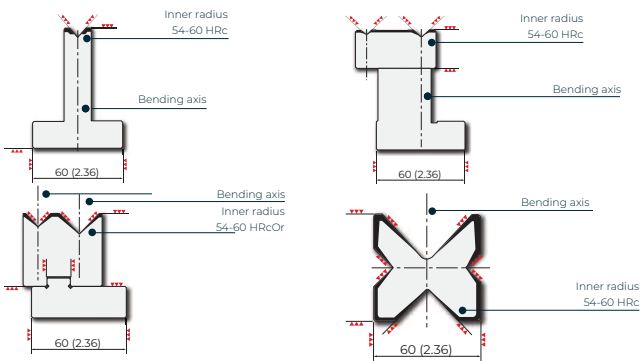
MVD  
Oriance  
Prima Power  
Promecam  
Rico  
Salvagnini  
Schlavi  
SMD  
Sorg  
Somo  
Vicia  
Vimercati  
Warcom  
Yawei  
etc.

Content explanation	57 - 58	Multi-V Dies and Holders	70 - 71
CLASSIC Series		Multi-V Dies	70 - 71
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88°	59	<b>2-V dies</b>	72 - 73
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35°	60	88°	72 - 73
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90°	62	88°	75 - 76
88°	62 - 63	Holder	76
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<b>1-V Dies - Self centering and Holders</b>	64 - 65	90°, H=60 mm	78
88°	64	88°, H=60 mm	78
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80°	75 - 76		
70°	76		
60°	76		
45°	76		

Content Explanation - (R)

STANDARD TANG

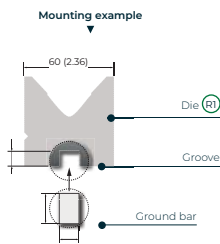
All dies (R) have base 60 mm, 90 mm or 120 mm.



MODIFICATIONS WEDGE/BAR TAIL

To use (R) dies, a 10 mm (0.39 in) groove is milled where a ground bar is mounted.

Wedge Bar / Tail (W x H)	System
13 x 30 mm	(R) (R) Bystronic-Beyeler,Safan,Trumpf,etc.
55 x 55 mm	(R) EHT
12.7 x 29 mm	(R)
35 x 55 mm	(R) Weinbrenner



Content Explanation - (R)



R1

STANDARD LENGTH

- TOP
  - 525 mm (20.67 in)
- CLASSIC - A
  - 415 mm (16.34 in)
  - 835 mm (32.87 in)
  - 900 mm (35.43 in)

SEGMENTATION

- TOP
  - FC: 495 mm (19.49 in) - 8 segments
- CLASSIC - A
  - F: 805 mm (31.69 in) - 8 segments
  - FX: 795 mm (31.29 in) - 10 segments

2-V Dies and Holders - CLASSIC Series

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M26.90.01</b>				<b>M26.90.02</b>			
835 mm	32.87 in	9.0 kg		835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg		415 mm	16.34 in	4.5 kg	
900 mm	35.43 in	10.0 kg		900 mm	35.43 in	10.0 kg	
			90° ✓				90° ✓
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M26.90.03</b>				<b>M26.88.01</b>			
835 mm	32.87 in	9.0 kg		835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg		415 mm	16.34 in	4.5 kg	
			90°				88° ✓
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M26.88.02</b>				<b>M26.88.03</b>			
835 mm	32.87 in	9.0 kg		835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg		415 mm	16.34 in	4.5 kg	
			88° ✓				88° ✓
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M26.88.04</b>				<b>M26.88.05</b>			
835 mm	32.87 in	8.0 kg		835 mm	32.87 in	8.0 kg	
415 mm	16.34 in	4.0 kg		415 mm	16.34 in	4.0 kg	
			88° ✓				88° ✓

2-V Dies and Holders - CLASSIC Series

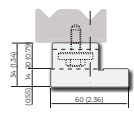
C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.
<b>M26.60.01</b>				<b>M26.60.02</b>			
835 mm	32.87 in	9.0 kg		835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg		415 mm	16.34 in	4.5 kg	
900 mm	35.43 in	10.0 kg		900 mm	35.43 in	10.0 kg	
			60° ✓				60° ✓
C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.
<b>M26.60.03</b>				<b>M26.60.05</b>			
835 mm	32.87 in	8.0 kg		835 mm	32.87 in	8.0 kg	
415 mm	16.34 in	4.0 kg		415 mm	16.34 in	4.0 kg	
			60° ✓				60° ✓
C45: 560-710 N/mm <sup>2</sup>			300 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			300 kN/m max.
<b>M31.35.01</b>				<b>M31.35.02</b>			
835 mm	32.87 in	11.0 kg		835 mm	32.87 in	10.0 kg	
415 mm	16.34 in	5.5 kg		415 mm	16.34 in	5.0 kg	
			35° ✓				35° ✓

2-V Dies and Holders - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup>

SU034

835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

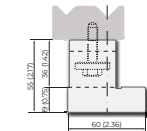


Holder ✓

C45: 560-710 N/mm<sup>2</sup>

SU055

835 mm	32.87 in	14.5 kg
415 mm	16.34 in	7.2 kg

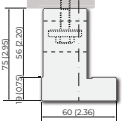


Holder ✓

C45: 560-710 N/mm<sup>2</sup>

SU075

830 mm	32.87 in	20.5 kg
410 mm	16.34 in	10.0 kg



Holder ✓



2-V Dies - Self centering and Holders - CLASSIC Series

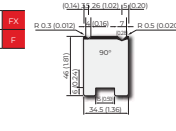


R1

C45: 560-710 N/mm<sup>2</sup>

46-10

835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
795 mm	31.29 in	9.7 kg
805 mm	31.69 in	9.7 kg

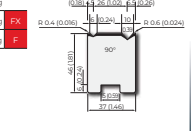


90° ✓

C45: 560-710 N/mm<sup>2</sup>

46-11

835 mm	32.87 in	10.3 kg
415 mm	16.34 in	5.1 kg
795 mm	31.29 in	9.9 kg
805 mm	31.69 in	9.9 kg

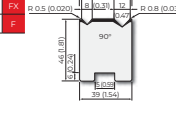


90° ✓

C45: 560-710 N/mm<sup>2</sup>

46-12

835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm	31.29 in	9.5 kg
805 mm	31.69 in	10.0 kg



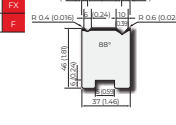
90° ✓



C45: 560-710 N/mm<sup>2</sup>

46.11.88

835 mm	32.87 in	10.3 kg
415 mm	16.34 in	5.2 kg
795 mm	31.29 in	9.8 kg
805 mm	31.69 in	10.3 kg

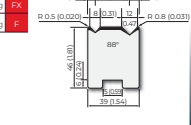


88° ✓

C45: 560-710 N/mm<sup>2</sup>

46.13

835 mm	32.87 in	10.9 kg
415 mm	16.34 in	5.4 kg
795 mm	31.29 in	9.6 kg
805 mm	31.69 in	9.6 kg

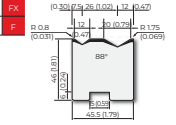


88° ✓

C45: 560-710 N/mm<sup>2</sup>

46.14

835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg
795 mm	31.29 in	11.4 kg
805 mm	31.69 in	11.5 kg

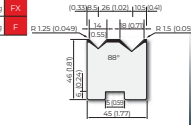


88° ✓

C45: 560-710 N/mm<sup>2</sup>

46.15

835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.0 kg
795 mm	31.29 in	12.0 kg
805 mm	31.69 in	12.1 kg



88° ✓

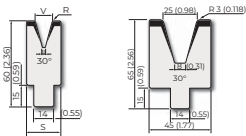




1-V Dies - Self centering and Holder - R1 CLASSIC Series

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max

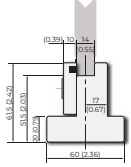
H=60-65 mm / 2.36-2.56 in									
Model	V [mm]	V [in]	R [mm]	R [in]	H [mm]	H [in]	S [mm]	S [in]	Weight
AMR60.06.30	6	0.24	0.6	0.02	-	-	14	0.55	5.9 kg
AMR60.08.30	8	0.31	0.8	0.03	2	0.08	18	0.70	6.6 kg
AMR60.10.30	10	0.39	1.0	0.04	2	0.08	24	0.94	7.8 kg
AMR60.12.30	12	0.47	1.5	0.04	2	0.08	24	0.94	7.9 kg
AMR60.16.30	16	0.63	2.0	0.06	5	0.19	30	1.18	8.8 kg
AMR60.20.30	20	0.79	2.5	0.08	5	0.19	35	1.38	15.9 kg
AMR65.25.30	25	0.98	3.0	0.12	8	0.31	45	1.78	13.0 kg



30° ✓

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max

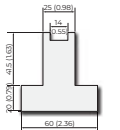
SU61F		
835 mm	32.87 in	16.0 kg
415 mm	16.34 in	7.3 kg



Holder ✓

C45: 560-710 N/mm<sup>2</sup> 950 kN/m max

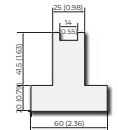
08000		
1950 mm	41.34 in	14.0 kg



Holder ✓

C45: 560-710 N/mm<sup>2</sup> 950 kN/m max

08100		
1260 mm	49.61 in	14.0 kg

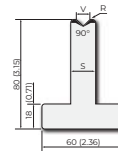


Holder ✓

T - Dies - R1 CLASSIC Series

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max

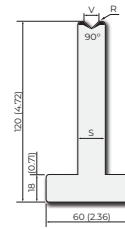
H=80 mm / 3.15 in									
Model	V [mm]	V [in]	R [mm]	R [in]	H [mm]	H [in]	S [mm]	S [in]	Weight
T80.06.90	6	0.24	0.4	0.01	14	0.55	-	-	13.0 kg
T80.08.90	8	0.31	0.5	0.02	14	0.55	-	-	13.0 kg
T80.10.90	10	0.39	0.6	0.02	18	0.71	-	-	14.2 kg
T80.12.90	12	0.47	0.8	0.03	18	0.71	-	-	15.0 kg



90° ✓

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max

H=120 mm / 4.72 in									
Model	V [mm]	V [in]	R [mm]	R [in]	H [mm]	H [in]	S [mm]	S [in]	Weight
T120.06.90	6	0.24	0.4	0.01	14	0.55	-	-	16.0 kg
T120.08.90	8	0.31	0.5	0.02	14	0.55	-	-	16.0 kg
T120.10.90	10	0.39	0.6	0.02	18	0.71	-	-	19.0 kg
T120.12.90	12	0.47	0.8	0.03	18	0.71	-	-	18.0 kg

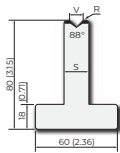


90° ✓

T - Dies - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m<sup>2</sup> max

H=80 mm / 3.15 in										
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Weight	Weight
T80.06.88	6	0.24	0.4	0.01	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.06.88	6	0.24	2.75	0.11	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.08.88	8	0.31	0.5	0.02	14	0.55	12.6 kg	6.3 kg	12.0 kg	12.1 kg
T80.08.88	8	0.31	2.75	0.11	14	0.55	13.0 kg	6.5 kg	13.0 kg	13.0 kg
T80.10.88	10	0.39	0.8	0.03	18	0.71	14.2 kg	7.0 kg	13.7 kg	13.7 kg
T80.10.88	10	0.39	2.75	0.11	18	0.71	15.0 kg	7.5 kg	15.0 kg	15.0 kg
T80.12.88	12	0.47	2.75	0.11	18	0.71	14.0 kg	7.0 kg	13.3 kg	13.5 kg
T80.16.88	16	0.63	2.75	0.11	24	0.94	16.0 kg	8.3 kg	16.0 kg	16.0 kg
T80.20.88	20	0.79	3.0	0.12	30	1.18	18.5 kg	9.2 kg	17.8 kg	17.8 kg
T80.25.88	25	0.98	3.0	0.12	35	1.38	20.2 kg	10.0 kg	19.5 kg	19.5 kg

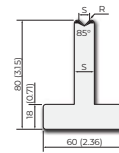


88°

T - Dies - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m<sup>2</sup> max

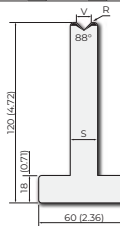
H=80 mm / 3.15 in										
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Weight	Weight
T80.06.85	6	0.24	2.75	0.11	14	0.55	13.0 kg	6.5 kg	13.0 kg	13.0 kg
T80.08.85	8	0.31	2.75	0.11	14	0.55	12.6 kg	6.2 kg	12.0 kg	12.0 kg
T80.10.85	10	0.39	2.75	0.11	18	0.71	14.2 kg	7.0 kg	13.7 kg	14.0 kg
T80.12.85	12	0.47	2.75	0.11	18	0.71	14.1 kg	7.0 kg	14.0 kg	14.0 kg
T80.16.85	16	0.63	2.75	0.11	24	0.94	16.4 kg	8.2 kg	15.8 kg	15.8 kg
T80.20.85	20	0.79	3.0	0.12	30	1.18	19.0 kg	9.5 kg	18.0 kg	18.0 kg
T80.25.85	25	0.98	3.0	0.12	35	1.38	20.0 kg	10.0 kg	19.0 kg	20.0 kg



85°

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m<sup>2</sup> max

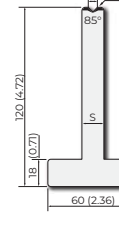
H=120 mm / 4.72 in										
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Weight	Weight
T120.06.88	6	0.24	0.4	0.01	14	0.55	16.5 kg	8.0 kg	16.0 kg	16.0 kg
T120.06.88	6	0.24	2.75	0.11	14	0.55	16.0 kg	8.0 kg	16.0 kg	16.0 kg
T120.08.88	8	0.31	0.5	0.02	14	0.55	16.0 kg	8.0 kg	16.0 kg	16.0 kg
T120.08.88	8	0.31	2.75	0.11	14	0.55	16.0 kg	8.0 kg	16.0 kg	16.0 kg
T120.10.88	10	0.39	0.8	0.03	18	0.71	19.0 kg	9.5 kg	18.0 kg	19.0 kg
T120.10.88	10	0.39	2.75	0.11	18	0.71	18.0 kg	9.0 kg	18.0 kg	18.0 kg
T120.12.88	12	0.47	2.75	0.11	18	0.71	19.0 kg	9.0 kg	18.0 kg	18.0 kg
T120.16.88	16	0.63	2.75	0.11	24	0.94	22.0 kg	11.0 kg	22.0 kg	22.0 kg
T120.20.88	20	0.79	3.0	0.12	30	1.18	27.0 kg	13.5 kg	25.7 kg	26.0 kg
T120.25.88	25	0.98	3.0	0.12	35	1.38	30.0 kg	15.0 kg	30.0 kg	30.0 kg



88°

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m<sup>2</sup> max

H=120 mm / 4.72 in										
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Weight	Weight
T120.06.85	6	0.24	2.75	0.11	14	0.55	16.3 kg	8.1 kg	15.7 kg	15.7 kg
T120.08.85	8	0.31	2.75	0.11	14	0.55	16.3 kg	8.1 kg	15.7 kg	15.7 kg
T120.10.85	10	0.39	2.75	0.11	18	0.71	19.0 kg	9.5 kg	19.0 kg	19.0 kg
T120.12.85	12	0.47	2.75	0.11	18	0.71	18.9 kg	9.4 kg	18.2 kg	18.2 kg
T120.16.85	16	0.63	2.75	0.11	24	0.94	22.7 kg	11.3 kg	21.9 kg	21.9 kg
T120.20.85	20	0.79	3.0	0.12	30	1.18	26.4 kg	13.0 kg	25.5 kg	25.5 kg
T120.25.85	25	0.98	3.0	0.12	35	1.38	30.0 kg	15.0 kg	30.0 kg	30.0 kg

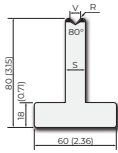


85°

T - Dies - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup> 950 kN/m max

H=80 mm / 3.15 in												
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Fx	Weight	F	Weight
T80.06.80	6	0.24	2.75	0.11	14	0.55	13.0 kg	6.5 kg	13.0 kg	13.0 kg	13.0 kg	13.0 kg
T80.08.80	8	0.31	2.75	0.11	14	0.55	13.0 kg	6.5 kg	13.0 kg	13.0 kg	13.0 kg	13.0 kg
T80.10.80	10	0.39	2.75	0.11	18	0.71	13.0 kg	6.5 kg	13.0 kg	13.0 kg	13.0 kg	13.0 kg
T80.12.80	12	0.47	2.75	0.11	18	0.71	13.0 kg	6.5 kg	13.0 kg	13.0 kg	13.0 kg	13.0 kg
T80.16.80	16	0.63	2.75	0.11	24	0.94	13.0 kg	6.5 kg	13.0 kg	13.0 kg	13.0 kg	13.0 kg
T80.20.80	20	0.79	3.0	0.12	30	1.18	17.0 kg	6.5 kg	12.4 kg	12.4 kg	12.5 kg	12.5 kg
T80.25.80	25	0.98	3.0	0.12	35	1.38	20.0 kg	10.0 kg	20.0 kg	20.0 kg	20.0 kg	20.0 kg

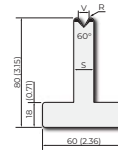


80° ✓

T - Dies - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup> 600 kN/m max

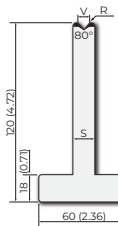
H=80 mm / 3.15 in												
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Fx	Weight	F	Weight
T80.06.60	6	0.24	0.5	0.02	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.4 kg	12.5 kg	12.5 kg
TR80.06.60	6	0.24	1.5	0.06	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.4 kg	12.5 kg	12.5 kg
T80.08.60	8	0.31	0.8	0.03	14	0.55	13.0 kg	6.5 kg	13.0 kg	13.0 kg	13.0 kg	13.0 kg
TR80.08.60	8	0.31	1.5	0.06	14	0.55	13.0 kg	6.5 kg	13.0 kg	13.0 kg	13.0 kg	13.0 kg
T80.10.60	10	0.39	0.8	0.03	18	0.71	14.5 kg	7.0 kg	15.5 kg	15.5 kg	15.5 kg	15.5 kg
TR80.10.60	10	0.39	2.75	0.108	18	0.71	15.0 kg	7.5 kg	15.0 kg	15.0 kg	15.0 kg	15.0 kg
T80.12.60	12	0.47	0.8	0.03	18	0.71	14.0 kg	7.0 kg	13.5 kg	13.5 kg	13.5 kg	13.5 kg
TR80.12.60	12	0.47	2.75	0.108	18	0.71	15.0 kg	7.5 kg	15.0 kg	15.0 kg	15.0 kg	15.0 kg
T80.16.60	16	0.63	2.75	0.108	24	0.94	15.6 kg	8.7 kg	16.0 kg	16.0 kg	16.0 kg	16.0 kg
T80.20.60	20	0.79	3.0	0.118	30	1.18	18.0 kg	9.5 kg	19.0 kg	19.0 kg	19.0 kg	19.0 kg
T80.25.60	25	0.98	3.0	0.118	35	1.38	19.5 kg	10.0 kg	18.8 kg	18.8 kg	18.8 kg	18.8 kg



60° ✓

C45: 560-710 N/mm<sup>2</sup> 950 kN/m max

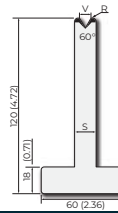
H=120 mm / 4.72 in												
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Fx	Weight	F	Weight
T120.06.80	6	0.24	2.75	0.11	14	0.55	18.0 kg	9.0 kg	17.1 kg	17.1 kg	17.4 kg	17.4 kg
T120.08.80	8	0.31	2.75	0.11	14	0.55	18.0 kg	9.0 kg	17.1 kg	17.1 kg	17.4 kg	17.4 kg
T120.10.80	10	0.39	2.75	0.11	18	0.71	18.0 kg	9.0 kg	17.1 kg	17.1 kg	17.4 kg	17.4 kg
T120.12.80	12	0.47	2.75	0.11	18	0.71	18.0 kg	9.0 kg	17.1 kg	17.1 kg	17.4 kg	17.4 kg
T120.16.80	16	0.63	2.75	0.11	24	0.94	18.0 kg	9.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T120.20.80	20	0.79	3.0	0.12	30	1.18	26.3 kg	13.0 kg	25.0 kg	25.0 kg	25.4 kg	25.4 kg
T120.25.80	25	0.98	3.0	0.12	35	1.38	30.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg



80° ✓

C45: 560-710 N/mm<sup>2</sup> 600 kN/m max

H=120 mm / 4.72 in												
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Fx	Weight	F	Weight
T120.06.60	6	0.24	0.5	0.02	14	0.55	16.0 kg	8.0 kg	16.0 kg	16.0 kg	15.4 kg	15.4 kg
TR120.06.60	6	0.24	1.5	0.06	14	0.55	16.0 kg	8.0 kg	15.2 kg	15.2 kg	15.4 kg	15.4 kg
T120.08.60	8	0.31	0.8	0.03	14	0.55	16.0 kg	8.0 kg	16.0 kg	16.0 kg	16.0 kg	16.0 kg
TR120.08.60	8	0.31	1.5	0.06	14	0.55	16.0 kg	8.0 kg	16.0 kg	16.0 kg	16.0 kg	16.0 kg
T120.10.60	10	0.39	0.8	0.03	18	0.71	18.8 kg	9.3 kg	18.1 kg	18.1 kg	18.1 kg	18.1 kg
TR120.10.60	10	0.39	2.75	0.108	18	0.71	18.0 kg	9.0 kg	17.1 kg	17.1 kg	17.4 kg	17.4 kg
T120.12.60	12	0.47	0.8	0.03	18	0.71	18.0 kg	9.0 kg	18.3 kg	18.3 kg	18.3 kg	18.3 kg
TR120.12.60	12	0.47	2.75	0.108	18	0.71	18.0 kg	9.0 kg	17.1 kg	17.1 kg	17.4 kg	17.4 kg
T120.16.60	16	0.63	2.75	0.108	24	0.94	22.4 kg	11.1 kg	21.6 kg	21.6 kg	21.6 kg	21.6 kg
T120.20.60	20	0.79	3.0	0.118	30	1.18	26.0 kg	13.0 kg	24.8 kg	24.8 kg	25.0 kg	25.0 kg
T120.25.60	25	0.98	3.0	0.118	35	1.38	29.0 kg	15.0 kg	30.0 kg	30.0 kg	30.0 kg	30.0 kg



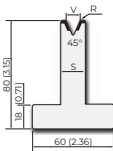
60° ✓

T - Dies - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup> 500kN/mm<sup>2</sup>

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Fx	Weight	F	Weight
T80.06.45	6	0.24	0.8	0.03	14	0.55	13.0 kg	6.5 kg	12.4 kg	15.0 kg	12.5 kg	15.0 kg
T80.08.45	8	0.31	1.0	0.04	18	0.71	15.0 kg	7.5 kg	15.0 kg	15.0 kg	15.0 kg	15.0 kg
T80.10.45	10	0.39	1.2	0.05	18	0.71	14.0 kg	7.0 kg	13.3 kg	15.0 kg	13.5 kg	15.0 kg
T80.12.45	12	0.47	1.6	0.06	24	0.94	16.3 kg	8.1 kg	15.7 kg	16.0 kg	15.7 kg	15.7 kg
T80.16.45	16	0.63	2.75	0.11	26	1.02	16.6 kg	8.3 kg	16.0 kg	16.0 kg	16.0 kg	16.0 kg
T80.20.45	20	0.79	3.0	0.12	30	1.18	18.0 kg	9.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T80.25.45	25	0.98	3.0	0.12	37	1.46	20.0 kg	10.0 kg	20.0 kg	20.0 kg	20.0 kg	20.0 kg

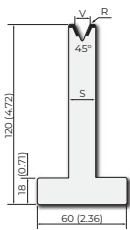


45°

C45: 560-710 N/mm<sup>2</sup> 500kN/mm<sup>2</sup>

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Fx	Weight	F	Weight
T120.06.45	6	0.24	0.8	0.03	14	0.55	16.0 kg	8.0 kg	16.0 kg	16.0 kg	16.0 kg	16.0 kg
T120.08.45	8	0.31	1.0	0.04	18	0.71	18.0 kg	9.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T120.10.45	10	0.39	1.2	0.05	18	0.71	18.0 kg	9.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T120.12.45	12	0.47	1.6	0.06	24	0.94	23.0 kg	9.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T120.16.45	16	0.63	2.75	0.11	26	1.02	25.0 kg	12.5 kg	25.0 kg	25.0 kg	25.0 kg	25.0 kg
T120.20.45	20	0.79	3.0	0.12	30	1.18	26.0 kg	13.5 kg	24.8 kg	28.0 kg	25.0 kg	25.0 kg
T120.25.45	25	0.79	3.0	0.12	37	1.46	30.0 kg	15.0 kg	28.6 kg	30.0 kg	28.9 kg	28.9 kg



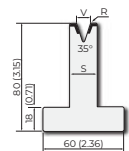
45°

T - Dies - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup> See table

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	kN/mm <sup>2</sup> max.	Weight	Weight	Fx	Weight	F	Weight
T80.06.35	6	0.24	0.8	0.03	14	0.55	350	12.5 kg	6.5 kg	12.0 kg	12.0 kg	12.0 kg	12.0 kg
T80.08.35	8	0.31	1.0	0.04	16	0.63	350	13.0 kg	7.0 kg	14.0 kg	14.0 kg	14.0 kg	14.0 kg
T80.10.35	10	0.39	1.2	0.05	20	0.79	400	15.0 kg	7.5 kg	15.0 kg	15.0 kg	15.0 kg	15.0 kg
T80.12.35	12	0.47	1.6	0.06	22	0.87	400	15.5 kg	8.0 kg	16.0 kg	16.0 kg	16.0 kg	16.0 kg
T80.16.35	16	0.63	3.0	0.12	30	1.18	450	18.0 kg	8.5 kg	17.0 kg	17.0 kg	17.0 kg	17.0 kg
T80.20.35	20	0.79	3.0	0.12	35	1.38	500	19.3 kg	9.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T80.25.35	25	0.98	3.0	0.12	40	1.57	500	20.0 kg	9.9 kg	19.3 kg	19.3 kg	19.3 kg	19.3 kg

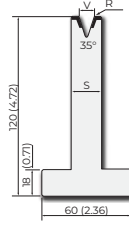


35°

C45: 560-710 N/mm<sup>2</sup> See table

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	kN/mm <sup>2</sup> max.	Weight	Weight	Fx	Weight	F	Weight
T120.06.35	6	0.24	0.8	0.03	14	0.55	350	16.0 kg	8.0 kg	16.0 kg	16.0 kg	16.0 kg	16.0 kg
T120.08.35	8	0.31	1.0	0.04	16	0.63	350	18.0 kg	9.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T120.10.35	10	0.39	1.2	0.05	20	0.79	400	19.9 kg	8.5 kg	19.0 kg	19.0 kg	19.0 kg	19.0 kg
T120.12.35	12	0.47	1.6	0.06	22	0.87	400	21.0 kg	10.0 kg	20.0 kg	20.0 kg	20.0 kg	20.0 kg
T120.16.35	16	0.63	3.0	0.12	30	1.18	450	25.8 kg	12.8 kg	24.8 kg	24.8 kg	24.8 kg	24.8 kg
T120.20.35	20	0.79	3.0	0.12	35	1.38	500	28.0 kg	14.0 kg	28.0 kg	28.0 kg	28.0 kg	28.0 kg
T120.25.35	25	0.98	3.0	0.12	40	1.57	500	30.5 kg	15.2 kg	29.0 kg	29.0 kg	29.4 kg	29.4 kg



35°

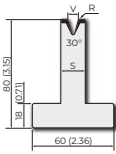
T - Dies - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup>

See table

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	KN/mm max.	Weight	Weight	Fx	Weight	F	Weight
T80.06.30	6	0.24	0.6	0.024	14	0.55	350	12.4 kg	6.5 kg	12.0 kg	12.0 kg	12.0 kg	12.0 kg
T80.08.30	8	0.31	0.8	0.031	18	0.71	350	15.0 kg	7.0 kg	14.0 kg	14.0 kg	14.0 kg	14.0 kg
T80.10.30	10	0.39	1.0	0.039	24	0.94	500	16.0 kg	8.0 kg	15.4 kg	15.0 kg	15.0 kg	15.0 kg
T80.12.30	12	0.47	1.5	0.059	24	0.94	400	16.0 kg	8.0 kg	15.5 kg	15.5 kg	15.5 kg	15.5 kg
T80.16.30	16	0.63	2.0	0.079	30	1.18	450	18.0 kg	9.9 kg	17.3 kg	17.3 kg	17.3 kg	17.3 kg
T80.20.30	20	0.79	2.5	0.099	35	1.38	500	19.0 kg	9.5 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T80.25.30	25	0.98	3.0	0.118	40	1.57	500	20.0 kg	10.0 kg	19.3 kg	19.3 kg	19.3 kg	19.3 kg



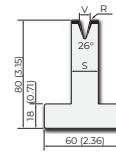
T - Dies - CLASSIC Series

C45: 560-710 N/mm<sup>2</sup>

200 kN/mm max.

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Fx	Weight	F	Weight
T80.06.26	6	0.24	0.8	0.031	16	0.63	14.0 kg	7.0 kg	13.3 kg	13.3 kg	13.3 kg	13.5 kg
T80.08.26	8	0.31	1.0	0.039	20	0.79	15.0 kg	7.5 kg	14.3 kg	14.3 kg	14.3 kg	14.5 kg
T80.10.26	10	0.39	1.2	0.047	24	0.94	15.5 kg	8.0 kg	15.5 kg	15.5 kg	15.5 kg	15.5 kg
T80.12.26	12	0.47	1.6	0.063	26	1.02	16.6 kg	7.5 kg	15.0 kg	15.0 kg	15.0 kg	16.0 kg

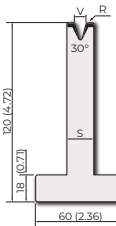


C45: 560-710 N/mm<sup>2</sup>

See table

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	KN/mm max.	Weight	Weight	Fx	Weight	F	Weight
T120.06.30	6	0.24	0.6	0.024	14	0.55	350	16.0 kg	8.0 kg	16.0 kg	16.0 kg	16.0 kg	16.0 kg
T120.08.30	8	0.31	0.8	0.031	18	0.71	350	19.0 kg	9.5 kg	19.0 kg	19.0 kg	19.0 kg	19.0 kg
T120.10.30	10	0.39	1.0	0.039	18	0.71	500	22.0 kg	10.9 kg	14.5 kg	14.5 kg	14.5 kg	14.5 kg
T120.12.30	12	0.47	1.5	0.059	24	0.94	400	22.0 kg	10.0 kg	20.0 kg	20.0 kg	20.0 kg	20.0 kg
T120.16.30	16	0.63	2.0	0.079	30	1.18	450	25.8 kg	13.0 kg	25.8 kg	25.8 kg	25.8 kg	25.8 kg
T120.20.30	20	0.79	2.5	0.099	35	1.38	500	28.0 kg	14.0 kg	28.0 kg	28.0 kg	28.0 kg	28.0 kg
T120.25.30	25	0.98	3.0	0.118	40	1.57	500	30.5 kg	15.0 kg	30.5 kg	30.5 kg	30.5 kg	30.5 kg

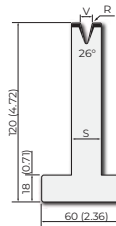


C45: 560-710 N/mm<sup>2</sup>

200 kN/mm max.

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	Fx	Weight	F	Weight
T120.06.26	6	0.24	0.8	0.031	16	0.63	18.0 kg	9.0 kg	18.0 kg	18.0 kg	18.0 kg	18.0 kg
T120.08.26	8	0.31	1.0	0.039	20	0.79	19.0 kg	9.5 kg	19.0 kg	19.0 kg	19.0 kg	19.0 kg
T120.10.26	10	0.39	1.2	0.047	24	0.94	22.0 kg	11.0 kg	22.0 kg	22.0 kg	22.0 kg	22.0 kg
T120.12.26	12	0.47	1.6	0.063	26	1.02	22.0 kg	11.0 kg	22.0 kg	22.0 kg	22.0 kg	22.0 kg



1-V Dies - CLASSIC Series

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M60.85.32</b>			
835 mm	32.87 in	21.6 kg	
415 mm	16.34 in	10.7 kg	
795 mm	31.29 in	20.6 kg	
805 mm	31.69 in	20.9 kg	
85°			
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M60.85.40</b>			
835 mm	32.87 in	20.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	19.0 kg	
805 mm	31.69 in	19.0 kg	
85°			
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M60.85.50</b>			
835 mm	32.87 in	19.0 kg	
415 mm	16.34 in	9.5 kg	
795 mm	31.29 in	19.0 kg	
805 mm	31.69 in	19.0 kg	
85°			
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M75.85.63</b>			
835 mm	32.87 in	29.2 kg	
415 mm	16.34 in	14.5 kg	
795 mm	31.29 in	28.0 kg	
805 mm	31.69 in	28.0 kg	
85°			
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M80.85.80</b>			
835 mm	32.87 in	33.5 kg	
415 mm	16.34 in	16.6 kg	
795 mm	31.29 in	32.2 kg	
805 mm	31.69 in	32.2 kg	
85°			
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M95.80.100</b>			
835 mm	32.87 in	46.2 kg	
415 mm	16.34 in	22.9 kg	
795 mm	31.29 in	44.5 kg	
805 mm	31.69 in	44.5 kg	
80°			
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>MK103.80.125</b>			
835 mm	32.87 in	62.0 kg	
415 mm	16.34 in	31.0 kg	
795 mm	31.29 in	59.8 kg	
805 mm	31.69 in	59.8 kg	
80°			

1-V Dies - CLASSIC Series

C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.	
<b>MK130.80.160</b>				
835 mm	32.87 in	93.0 kg		
415 mm	16.34 in	46.5 kg		
795 mm	31.29 in	88.5 kg		
805 mm	31.69 in	89.7 kg		
80°				
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	
<b>M130.80.160</b>				
835 mm	32.87 in	97.0 kg		
415 mm	16.34 in	47.4 kg		
795 mm	31.29 in	88.5 kg		
805 mm	31.69 in	89.7 kg		
80°				
42Cr: 908-1150 N/mm <sup>2</sup>			1800 kN/m max.	
<b>M195.70.200</b>				
415 mm	16.34 in	104.0 kg		
70°				
C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.
<b>M110.60.80</b>				
835 mm	32.87 in	53.0 kg		
415 mm	16.34 in	26.5 kg		
795 mm	31.29 in	50.5 kg		
805 mm	31.69 in	51.1 kg		
60°				
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	
<b>M80.45.32</b>				
835 mm	32.87 in	27.5 kg		
415 mm	16.34 in	13.7 kg		
795 mm	31.29 in	27.5 kg		
805 mm	31.69 in	27.5 kg		
45°				
C45: 560-710 N/mm <sup>2</sup>			950 kN/m max.	
<b>M80.45.50</b>				
835 mm	32.87 in	31.0 kg		
415 mm	16.34 in	15.5 kg		
795 mm	31.29 in	31.0 kg		
805 mm	31.69 in	31.0 kg		
45°				
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	
<b>M80.45.40</b>				
835 mm	32.87 in	30.9 kg		
415 mm	16.34 in	16.5 kg		
795 mm	31.29 in	30.7 kg		
805 mm	31.69 in	30.7 kg		
45°				
C45: 560-710 N/mm <sup>2</sup>			950 kN/m max.	
<b>M80.45.50</b>				
835 mm	32.87 in	31.0 kg		
415 mm	16.34 in	15.5 kg		
795 mm	31.29 in	31.0 kg		
805 mm	31.69 in	31.0 kg		
45°				

Multi-V Dies - CLASSIC Series

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M.60.90.01</b>			
835 mm	32.87 in.	20.0 kg	
415 mm	16.34 in.	10.0 kg	
795 mm	31.29 in.	20.0 kg	FX
805 mm	31.69 in.	20.0 kg	F

90° ✓

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M.60.90.02</b>			
835 mm	32.87 in.	20.0 kg	
415 mm	16.34 in.	10.0 kg	
795 mm	31.29 in.	20.0 kg	FX
805 mm	31.69 in.	20.0 kg	F

90° ✓

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M.360.R</b>			
835 mm	32.87 in.	20.0 kg	
415 mm	16.34 in.	10.0 kg	
795 mm	31.29 in.	20.0 kg	FX
805 mm	31.69 in.	20.0 kg	F

90° ✓

C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.
<b>M.460.R</b>			
835 mm	32.87 in.	15.7 kg	
415 mm	16.34 in.	7.7 kg	
795 mm	31.29 in.	15.1 kg	FX
805 mm	31.69 in.	15.1 kg	F

85° ✓

C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.
<b>M.460</b>			
835 mm	32.87 in.	15.7 kg	
415 mm	16.34 in.	7.7 kg	
795 mm	31.29 in.	15.5 kg	FX
805 mm	31.69 in.	15.5 kg	F

85° 88° ✓

C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.
<b>M.460.60</b>			
835 mm	32.87 in.	18.0 kg	
415 mm	16.34 in.	9.0 kg	
795 mm	31.29 in.	16.0 kg	FX
805 mm	31.69 in.	16.0 kg	F

60° ✓

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>M.490</b>			
835 mm	32.87 in.	38.9 kg	
415 mm	16.34 in.	20.0 kg	
795 mm	31.29 in.	39.0 kg	FX
805 mm	31.69 in.	39.0 kg	F

60° 80° ✓

C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.
<b>M.490.70</b>			
835 mm	32.87 in.	35.8 kg	
415 mm	16.34 in.	17.9 kg	
795 mm	31.29 in.	36.0 kg	FX
805 mm	31.69 in.	36.0 kg	F

60° 80° ✓

Multi-V Dies - CLASSIC Series

42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>	See table
<b>T70-88</b>					
525 mm	20.67 in.	17.5 kg			
495 mm	19.49 in.	16.5 kg			

88° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>	See table
<b>T70-60</b>					
525 mm	20.67 in.	16.8 kg			
495 mm	19.49 in.	15.8 kg			

60° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			See table	42Cr: 900-1150 N/mm <sup>2</sup>	See table
<b>T70-45</b>					
525 mm	20.67 in.	16.1 kg			
495 mm	19.49 in.	15.2 kg			

45° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			See table	42Cr: 900-1150 N/mm <sup>2</sup>	See table
<b>T70-35</b>					
525 mm	20.67 in.	15.3 kg			
495 mm	19.49 in.	14.4 kg			

35° ✓

C45: 560-710 N/mm <sup>2</sup>			See table	Fc37	See table
<b>SU-T70</b>					
525 mm	20.67 in.	12.4 kg			

Holder ✓

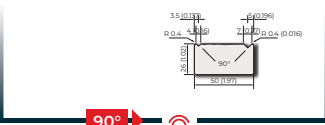
Fc37			See table	Fc37	See table
<b>PB-T70</b>					
20 mm	0.79 in.	0.2 kg			

Retainer ✓

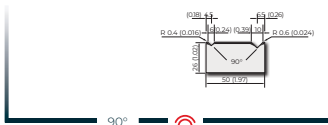


2-V Dies -  A Series

C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.
<b>12100</b>				<b>12300</b>			
835 mm	32.87 in.	8.4 kg		835 mm	32.87 in.	8.0 kg	
415 mm	16.34 in.	4.2 kg		415 mm	16.34 in.	3.9 kg	

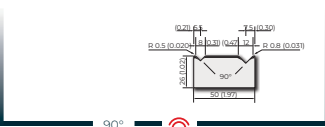


90° 

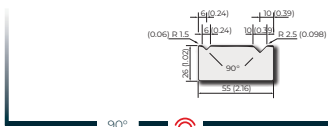


90° 

C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.
<b>12400</b>				<b>31100</b>			
835 mm	32.87 in.	8.0 kg		835 mm	32.87 in.	9.1 kg	
415 mm	16.34 in.	3.9 kg		415 mm	16.34 in.	4.5 kg	

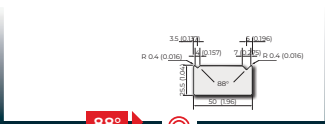


90° 

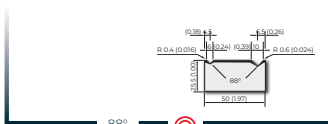


90° 

C45: 560-710 N/mm <sup>2</sup>			600 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.
<b>12106</b>				<b>12306</b>			
835 mm	32.87 in.	8.4 kg		835 mm	32.87 in.	8.0 kg	
415 mm	16.34 in.	7.8 kg		415 mm	16.34 in.	3.9 kg	

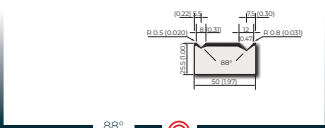


88° 

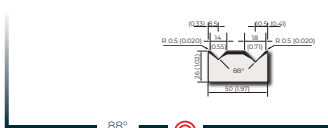


88° 

C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>12406</b>				<b>12500</b>			
835 mm	32.87 in.	8.0 kg		835 mm	32.87 in.	7.7 kg	
415 mm	16.34 in.	3.9 kg		415 mm	16.34 in.	3.8 kg	



88° 

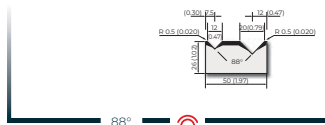


88° 

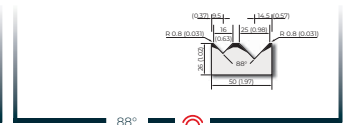
2-V Dies -  A Series



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.
<b>12600</b>				<b>12700</b>			
835 mm	32.87 in.	7.5 kg		835 mm	32.87 in.	7.0 kg	
415 mm	16.34 in.	3.7 kg		415 mm	16.34 in.	3.4 kg	

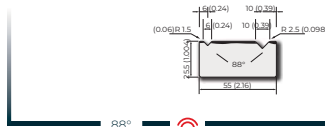


88° 

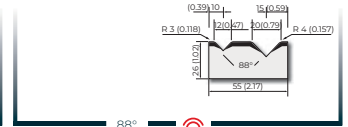


88° 

C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>31106</b>				<b>31400</b>			
835 mm	32.87 in.	8.9 kg		835 mm	32.87 in.	7.5 kg	
415 mm	16.34 in.	4.4 kg		415 mm	16.34 in.	3.7 kg	



88° 



88° 



Self centering 2-V Dies - **RA Series**

C45: 560-710 N/mm <sup>2</sup>			600 kN/m <sup>2</sup> max.
<b>30148</b>			
835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	<b>FX</b>
805 mm	31.69 in	13.7 kg	<b>F</b>

90°

C45: 560-710 N/mm <sup>2</sup>			700 kN/m <sup>2</sup> max.
<b>30248</b>			
835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	<b>FX</b>
805 mm	31.69 in	13.7 kg	<b>F</b>

90°

C45: 560-710 N/mm <sup>2</sup>			700 kN/m <sup>2</sup> max.
<b>30348</b>			
835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	<b>FX</b>
805 mm	31.69 in	13.7 kg	<b>F</b>

90°

C45: 560-710 N/mm <sup>2</sup>			600 kN/m <sup>2</sup> max.
<b>50190</b>			
835 mm	32.87 in	9.7 kg	
415 mm	16.34 in	4.8 kg	
795 mm	31.29 in	9.2 kg	<b>FX</b>
805 mm	31.69 in	9.4 kg	<b>F</b>

90°

C45: 560-710 N/mm <sup>2</sup>			700 kN/m <sup>2</sup> max.
<b>50290</b>			
835 mm	32.87 in	10.3 kg	
415 mm	16.34 in	5.2 kg	
795 mm	31.29 in	10.0 kg	<b>FX</b>
805 mm	31.69 in	10.1 kg	<b>F</b>

90°

C45: 560-710 N/mm <sup>2</sup>			700 kN/m <sup>2</sup> max.
<b>50390</b>			
835 mm	32.87 in	10.7 kg	
415 mm	16.34 in	5.3 kg	
795 mm	31.29 in	10.7 kg	<b>FX</b>
805 mm	31.69 in	10.7 kg	<b>F</b>

90°

C45: 560-710 N/mm <sup>2</sup>			600 kN/m <sup>2</sup> max.
<b>50790</b>			
835 mm	32.87 in	10.0 kg	
415 mm	16.34 in	5.0 kg	
795 mm	31.29 in	9.5 kg	<b>FX</b>
805 mm	31.69 in	9.7 kg	<b>F</b>

90°

C45: 560-710 N/mm <sup>2</sup>			600 kN/m <sup>2</sup> max.
<b>30147</b>			
835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	<b>FX</b>
805 mm	31.69 in	13.7 kg	<b>F</b>

88°

Self centering 2-V Dies - **RA Series**



C45: 560-710 N/mm <sup>2</sup>			700 kN/m <sup>2</sup> max.
<b>30247</b>			
835 mm	32.87 in	14.0 kg	
415 mm	16.34 in	8.4 kg	
795 mm	31.29 in	16.2 kg	<b>FX</b>
805 mm	31.69 in	16.4 kg	<b>F</b>

88°

C45: 560-710 N/mm <sup>2</sup>			700 kN/m <sup>2</sup> max.
<b>30347</b>			
835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	<b>FX</b>
805 mm	31.69 in	13.7 kg	<b>F</b>

88°

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m <sup>2</sup> max.
<b>30448</b>			
835 mm	32.87 in	13.5 kg	
415 mm	16.34 in	6.7 kg	
795 mm	31.29 in	13.5 kg	<b>FX</b>
805 mm	31.69 in	13.7 kg	<b>F</b>

88°

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m <sup>2</sup> max.
<b>30548</b>			
835 mm	32.87 in	13.5 kg	
415 mm	16.34 in	6.7 kg	
795 mm	31.29 in	13.5 kg	<b>FX</b>
805 mm	31.69 in	13.7 kg	<b>F</b>

88°

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m <sup>2</sup> max.
<b>30648</b>			
835 mm	32.87 in	12.9 kg	
415 mm	16.34 in	6.4 kg	
795 mm	31.29 in	13.5 kg	<b>FX</b>
805 mm	31.69 in	13.7 kg	<b>F</b>

88°

C45: 560-710 N/mm <sup>2</sup>			600 kN/m <sup>2</sup> max.
<b>50196</b>			
835 mm	32.87 in	9.5 kg	
415 mm	16.34 in	4.8 kg	
795 mm	31.29 in	9.5 kg	<b>FX</b>
805 mm	31.69 in	9.5 kg	<b>F</b>

88°

C45: 560-710 N/mm <sup>2</sup>			700 kN/m <sup>2</sup> max.
<b>50296</b>			
835 mm	32.87 in	10.4 kg	
415 mm	16.34 in	5.2 kg	
795 mm	31.29 in	10.4 kg	<b>FX</b>
805 mm	31.69 in	10.4 kg	<b>F</b>

88°

C45: 560-710 N/mm <sup>2</sup>			700 kN/m <sup>2</sup> max.
<b>50396</b>			
835 mm	32.87 in	10.8 kg	
415 mm	16.34 in	5.3 kg	
795 mm	31.29 in	10.8 kg	<b>FX</b>
805 mm	31.69 in	10.8 kg	<b>F</b>

88°

## Self centering 2-V Dies - A Series

**C4S: 560-710 N/mm<sup>2</sup>** 1000 kN/m max.

**50490**

835 mm	32.87 in	12.0 kg
415 mm	16.34 in	5.3 kg
795 mm	31.29 in	10.8 kg
805 mm	31.69 in	10.9 kg

88°

**C4S: 560-710 N/mm<sup>2</sup>** 700 kN/m max.

**50590**

835 mm	32.87 in	12.2 kg
415 mm	16.34 in	6.1 kg
795 mm	31.29 in	12.2 kg
805 mm	31.69 in	12.2 kg

88°

**C4S: 560-710 N/mm<sup>2</sup>** 1000 kN/m max.

**50690**

835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm	31.29 in	12.4 kg
805 mm	31.69 in	12.6 kg

88°

**C4S: 560-710 N/mm<sup>2</sup>** 600 kN/m max.

**50796**

835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm	31.29 in	9.5 kg
805 mm	31.69 in	9.5 kg

88°

**C4S: 560-710 N/mm<sup>2</sup>** 1000 kN/m max.

**30000**

835 mm	32.87 in	3.7 kg
415 mm	16.34 in	1.9 kg

90°

### Example of Application



**42Cr: 900-1150 N/mm<sup>2</sup>** 300 kN/m max.

**33700**

835 mm	32.87 in	13.3 kg
415 mm	16.34 in	5.6 kg

30°



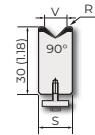
## Self centering 1-V Dies - A Series



**C4S: 560-710 N/mm<sup>2</sup>** See table

**H=30 mm / 3.15 in**

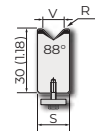
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	kN/m <sup>2</sup> max	Weight 835 mm / 32.87 in	Weight 415 mm / 16.34 in
32000	6	0.24	1.5	0.059	14	0.55	950	3.0 kg	1.5 kg
32100	8	0.31	1.5	0.059	14	0.55	950	3.0 kg	1.5 kg
32300	10	0.39	2.0	0.079	15	0.59	950	3.0 kg	1.5 kg
32600	12	0.47	2.5	0.09	17	0.70	1000	2.9 kg	1.5 kg



**C4S: 560-710 N/mm<sup>2</sup>** See table

**H=30 mm / 1.18 in \*H=29.5 / 1.16 in**

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	kN/m <sup>2</sup> max	Weight 835 mm / 32.87 in	Weight 415 mm / 16.34 in
32006*	6	0.24	1.5	0.059	14	0.55	950	3.0 kg	1.5 kg
32106*	8	0.31	1.5	0.059	14	0.55	950	3.0 kg	1.5 kg
32200	10	0.39	2.0	0.079	15	0.59	950	3.0 kg	1.5 kg
32400	12	0.47	2.5	0.09	17	0.67	1000	3.0 kg	1.5 kg
32500	14	0.55	2.5	0.09	18	0.71	1000	3.3 kg	1.6 kg



**C4S: 560-710 N/mm<sup>2</sup>** 1000 kN/m max.

**33000**

835 mm	32.87 in	12.7 kg
415 mm	16.34 in	6.3 kg

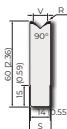
90°

**Example of Application**

Self centering 1-V Dies - **R1** A Series

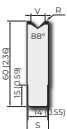
C45: 560-710 N/mm <sup>2</sup>										950 kN/m max		
H=60 mm / 2.36 in												
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	FX	Weight	F	Weight
07000	6	0.24	15	0.059	14	0.55	5.5 kg	2.7 kg	2.7 kg	5.2 kg		5.3 kg
07100	8	0.31	15	0.059	14	0.55	5.5 kg	2.7 kg	5.2 kg		5.3 kg	
07300	10	0.39	2.0	0.079	15	0.59	6.0 kg	3.0 kg	5.3 kg		5.4 kg	
07500	12	0.47	2.5	0.09	15	0.59	6.1 kg	3.0 kg	5.8 kg		5.9 kg	

For compatible holders see page 58



C45: 560-710 N/mm <sup>2</sup>										950 kN/m max		
H=60 mm / 2.36 in												
Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	Weight	Weight	FX	Weight	F	Weight
07006	6	0.24	15	0.059	14	0.55	5.5 kg	2.7 kg	2.7 kg	5.2 kg		5.3 kg
07106	8	0.31	15	0.059	14	0.55	5.5 kg	2.7 kg	5.2 kg		5.3 kg	
07200	10	0.39	2.0	0.079	15	0.59	6.0 kg	3.0 kg	5.4 kg		5.5 kg	
07400	12	0.47	2.5	0.09	17	0.67	6.0 kg	3.0 kg	5.8 kg		5.9 kg	
07600	14	0.55	2.5	0.09	17	0.67	6.1 kg	3.0 kg	5.8 kg		5.9 kg	

For compatible holders see page 58



1-V Dies - **R1** A Series



R1

C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max		C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max	
03500						03600					
835 mm	32.87 in	21.7 kg			835 mm	32.87 in	20.5 kg				
415 mm	16.34 in	10.8 kg			415 mm	16.34 in	10.2 kg				
795 mm	31.29 in	21.7 kg	FX		795 mm	31.29 in	19.5 kg	FX			
805 mm	31.69 in	21.7 kg	F		805 mm	31.69 in	19.7 kg	F			

C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max		C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max	
03700						03800					
835 mm	32.87 in	18.9 kg			835 mm	32.87 in	29.2 kg				
415 mm	16.34 in	9.4 kg			415 mm	16.34 in	14.5 kg				
795 mm	31.29 in	18.9 kg	FX		795 mm	31.29 in	29.2 kg	FX			
805 mm	31.69 in	18.9 kg	F		805 mm	31.69 in	29.2 kg	F			

C45: 560-710 N/mm <sup>2</sup>				700 kN/m max		C45: 560-710 N/mm <sup>2</sup>				400 kN/m max	
01360						34200					
835 mm	32.87 in	42.6 kg			835 mm	32.87 in	19.2 kg				
415 mm	16.34 in	21.2 kg			415 mm	16.34 in	9.6 kg				
795 mm	31.29 in	42.6 kg	FX		795 mm	31.29 in	19.2 kg	FX			
805 mm	31.69 in	42.6 kg	F		805 mm	31.69 in	19.2 kg	F			

C45: 560-710 N/mm <sup>2</sup>				700 kN/m max		C45: 560-710 N/mm <sup>2</sup>				800 kN/m max	
34300						34000					
835 mm	32.87 in	32.7 kg			835 mm	32.87 in	21.5 kg				
415 mm	16.34 in	16.2 kg			415 mm	16.34 in	10.7 kg				
795 mm	31.29 in	31.1 kg	FX		795 mm	31.29 in	21.5 kg	FX			
805 mm	31.69 in	31.5 kg	F		805 mm	31.69 in	21.5 kg	F			

## 1-V Dies - A Series

CAS: 560-710 N/mm <sup>2</sup>			CAS: 560-710 N/mm <sup>2</sup>		
34100			05500		
835 mm	32.87 in	21.7 kg	835 mm	32.87 in	21.7 kg
415 mm	16.34 in	10.8 kg	415 mm	16.34 in	10.8 kg
795 mm	31.29 in	21.7 kg			
805 mm	31.69 in	21.7 kg			

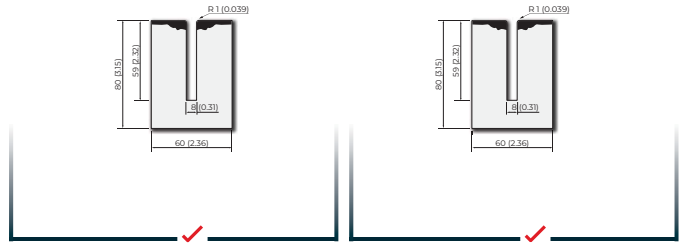
  

600 kN/m max.			1000 kN/m max.		

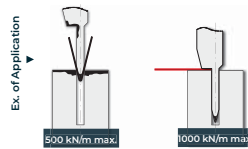
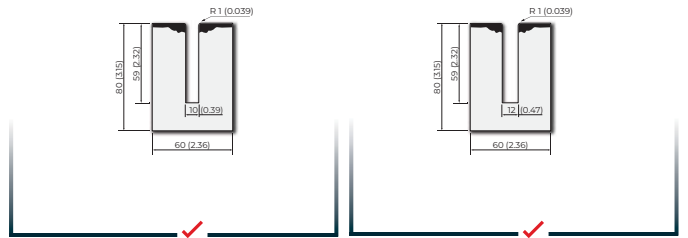


## Hemming Tools -

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max. - 1000 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max. - 1000 kN/m max.		
TOP.SM-134.28.8						TOP.SM-134.24.8					
525 mm	20.67 in	17.5 kg	To use with:			525 mm	20.67 in	16.5 kg	To use with:		
495 mm	19.49 in	16.5 kg	▶ TOP.SP-134.28.8 (pag. 15)			495 mm	19.49 in	16.5 kg	▶ TOP.SP-134.24.8 (page 15)		



42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max. - 1000 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max. - 1000 kN/m max.		
TOP.SM-134.24.10						TOP.SM-134.24.12					
525 mm	20.67 in	18.0 kg	To use with:			525 mm	20.67 in	16.8 kg	To use with:		
495 mm	19.49 in	16.9 kg	▶ TOP.SP-134.24.10 (page 15)			495 mm	19.49 in	15.9 kg	▶ TOP.SP-134.24.12 (page 15)		



S					A					R 420					R 700				
S	S	A	A	R 420	R 700	S	S	A	A	R 420	R 700	S	S	A	A	R 420	R 700		
[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>	[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>	[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>		
0.6	0.02	3.0	0.12	90	150	0.6	0.02	12	0.05	230	350	1.0	0.04	3.5	0.14	150	250		
0.8	0.03	3.0	0.12	120	200	0.8	0.03	16	0.06	320	500	1.25	0.05	3.5	0.14	170	260		



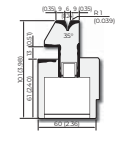
Pneumatic Hemming Dies - 




C4S: 560-710 N/mm<sup>2</sup> 600 kN/m max

**S10IPN.35.06**

835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

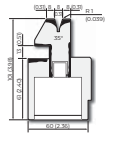



35° 

C4S: 560-710 N/mm<sup>2</sup> 600 kN/m max

**S10IPN.35.08**

835 mm	32.87 in	31.0 kg
415 mm	16.34 in	15.5 kg

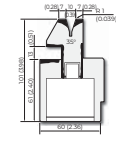



35° 

C4S: 560-710 N/mm<sup>2</sup> 600 kN/m max

**S10IPN.35.10**

835 mm	32.87 in	29.0 kg
415 mm	16.34 in	15.5 kg

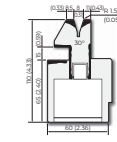



35° 

C4S: 560-710 N/mm<sup>2</sup> 800 kN/m max

**S110PN.30.08**

835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

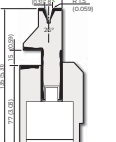



30° 

42Cr: 900-1150 N/mm<sup>2</sup> 400 kN/m max

**S13SPN.26.08**

835 mm	32.87 in	29.8 kg
415 mm	16.34 in	21.2 kg

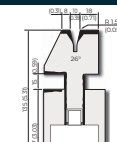



26° 

C4S: 560-710 N/mm<sup>2</sup> 1000 kN/m max

**S13SPN.26.10**

835 mm	32.87 in	41.3 kg
415 mm	16.34 in	20.7 kg

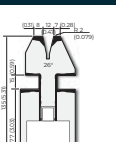



26° 

C4S: 560-710 N/mm<sup>2</sup> 1000 kN/m max


**SAT3SPN.26.12**

835 mm	32.87 in	41.0 kg
415 mm	16.34 in	20.5 kg



26° 

Pneumatic Hemming Dies - 



S [mm]	S [in]	A [mm]	A [in]	R45 Kgf/mm <sup>2</sup>	R45 Kgf/mm <sup>2</sup>	R70 Kgf/mm <sup>2</sup>	R70 Kgf/mm <sup>2</sup>	R45 Kgf/mm <sup>2</sup>	R45 Kgf/mm <sup>2</sup>	R70 Kgf/mm <sup>2</sup>	R70 Kgf/mm <sup>2</sup>
0.6	0.02	3.0	0.12	90	150	0.6	0.02	12	0.05	250	350
0.8	0.03	3.0	0.12	120	200	0.8	0.03	16	0.06	320	500
1.0	0.04	3.5	0.14	150	250	1.0	0.04	10	0.04	400	600
1.25	0.05	3.5	0.14	170	260	1.25	0.05	2.5	0.10	500	800
1.5	0.06	4.6	0.18	220	380	1.5	0.06	3.0	0.12	630	950
2.0	0.08	5.5	0.22	300	500	2.0	0.08	4.0	0.16	800	1300
2.5	0.10	6.5	0.26	550	-	2.5	0.10	5.0	0.20	900	-
3.0	0.12	8.0	0.31	700	-	3.0	0.12	6.0	0.24	1000	-



**PUNCHES ROLLERI TYPE R2**

**▼ COMPATIBILITY**

- Darley
- LVD
- Safan
- Trumpf
- Press brake machines with System NSCL

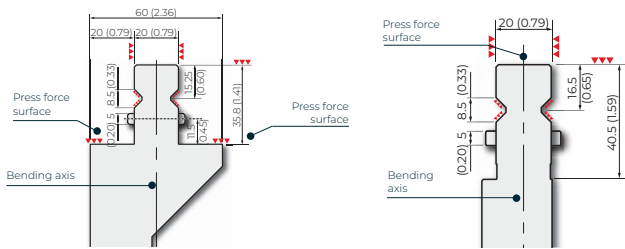
<b>Content explanation</b>	88 - 91
<b>Punches</b>	92 - 97
90°	92
86°	92 - 94
80°	94
60°	95 - 96
28°	96 - 97
<b>Hemming Punches</b>	98
<b>Joggle Tools</b>	99
<b>Radius Tools and Hemming tool</b>	100 - 101



Content Explanation - 


**STANDARD TANG**

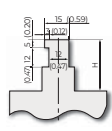
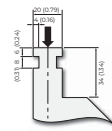
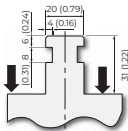
↓ Press force surface



**MODIFICATIONS FROM SAFETY GROOVES**

Modification of  punch with shoulder bearing

Modification of  punch with head bearing



**STANDARD LENGTH**

100 mm (3.93 in)	
250 mm (9.84 in)	
500 mm (19.68 in)	
515 mm (20.28 in)	
525 mm (20.67 in)	


Content Explanation - 

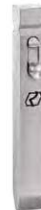


**CLAMPING SYSTEMS**

**QuickLock (Standard)**

- ▶ Vertical tool change
- ▶ Easy handling
- ▶ Substantial improvement in time consumption and related costs
- ▶ Applicable on tools < 12.5 kg
- ▶ Applicable on tools > 12.5 kg through special sectioning

 check this icon, you can chose between three different clamping solutions



**Safety Pins (Standard)**

- ▶ Horizontal tool change



**ROLI-System**

- ▶ Vertical tool change through spring-loaded ball bearings, which are mounted in the punch
- ▶ Increased longevity
- ▶ Easy handling
- ▶ To be used in hardened clamping systems only
- ▶ Applicable on tools < 12.5 kg



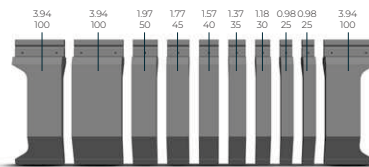


Content Explanation -



SEGMENTATION

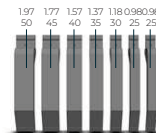
FW: 550 mm (21.65 in) - 10 segments



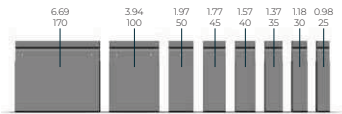
Horn types



FC: 250 mm (9.84 in) - 7 segments



F: 495 mm (19.49 in) - 8 segments



FA: 49.21-80.71-100.39-120.08-159.45 in

Length mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 [394] Horn L. (3.94)	100 [394] Horn r. (3.94)	100 (3.94)
1250 (49.21)	2	1	1	1	1	1	1	1	8
2050 (80.71)	2	1	1	1	1	1	1	1	16
2550 (100.39)	2	1	1	1	1	1	1	1	21
3050 (120.08)	2	1	1	1	1	1	1	1	26
4050 (159.45)	2	1	1	1	1	1	1	1	36

Available on request

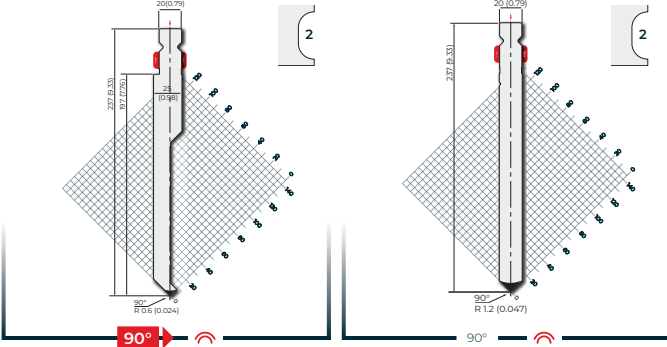
FB: 49.21-80.71-100.39-120.08-159.45 in

Length mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 [394] Horn L. (3.94)	100 [394] Horn r. (3.94)	100 (3.94)	200 (7.87)	300 (11.81)	500 (19.68)
1250 (49.21)	2	1	1	1	1	1	1	1	1	2	1	0
2050 (80.71)	2	1	1	1	1	1	1	1	1	1	1	2
2550 (100.39)	2	1	1	1	1	1	1	1	1	1	1	3
3050 (120.08)	2	1	1	1	1	1	1	1	1	1	1	4
4050 (159.45)	2	1	1	1	1	1	1	1	1	1	1	6

Available on request

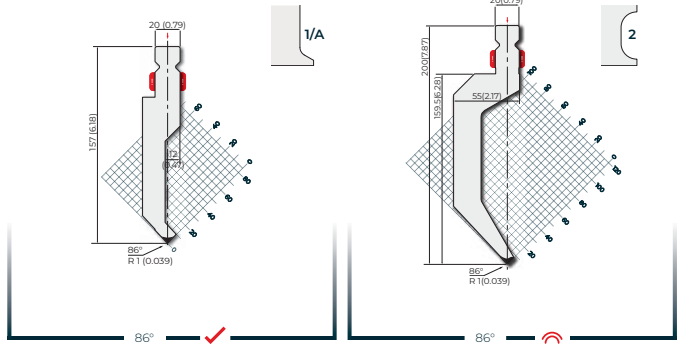
Punches - 

42Cr: 900-1150 N/mm <sup>2</sup>			600 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
TPR237.90.R06				TPR237.90.R12			
100 mm	3.93 in	3.4 kg		100 mm	3.93 in	3.7 kg	
250 mm	9.84 in	8.5 kg		250 mm	9.84 in	9.2 kg	
515 mm	20.82 in	17.5 kg		515 mm	20.82 in	19.0 kg	
550 mm	21.65 in	18.7 kg	<b>FW</b>	550 mm	21.65 in	20.3 kg	<b>FW</b>

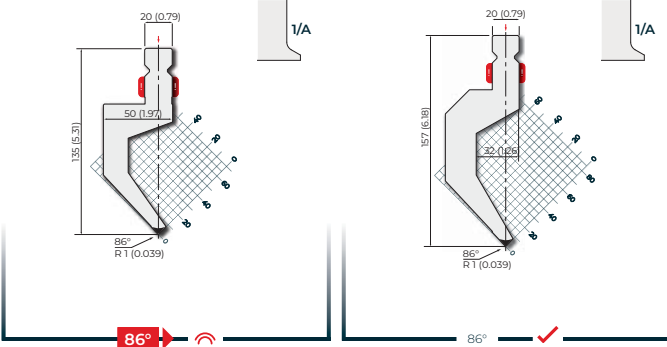


Punches - 

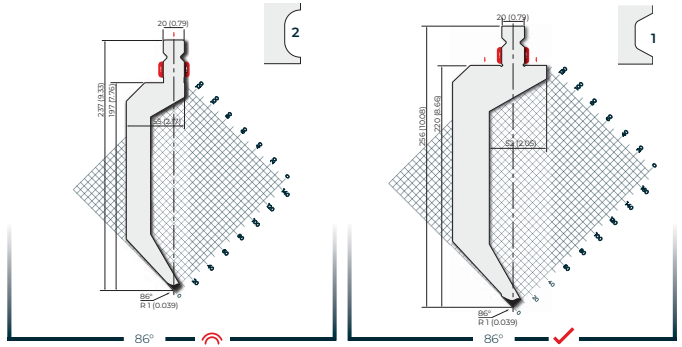
42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
TPRI57.86.R1-A				TPR200.86.R1			
100 mm	3.93 in	2.5 kg		100 mm	3.93 in	3.7 kg	
500 mm	19.68 in	12.5 kg		250 mm	9.84 in	6.1 kg	
250 mm	9.84 in	6.2 kg	<b>FC</b>	515 mm	20.82 in	19.1 kg	
550 mm	21.65 in	12.5 kg	<b>FW</b>	550 mm	21.65 in	20.4 kg	<b>FW</b>



42Cr: 900-1150 N/mm <sup>2</sup>			600 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.
TPRI35.86.R1				TPRI57.86.R1			
100 mm	3.93 in	2.4 kg		100 mm	3.93 in	3.0 kg	
250 mm	9.84 in	6.0 kg		500 mm	19.68 in	14.0 kg	
515 mm	20.82 in	12.3 kg		250 mm	9.84 in	7.5 kg	<b>FC</b>
550 mm	21.65 in	13.1 kg	<b>FW</b>	550 mm	21.65 in	15.0 kg	<b>FW</b>

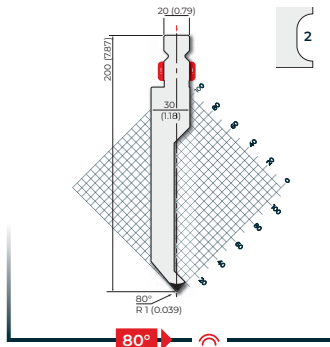
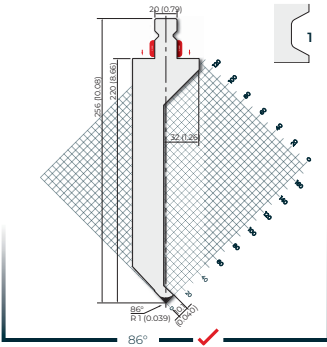


42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.
TPR237.86.R1				TPR256.86.R1			
100 mm	3.93 in	4.5 kg		100 mm	3.93 in	6.5 kg	
250 mm	9.84 in	11.2 kg		500 mm	19.68 in	33.0 kg	
515 mm	20.82 in	23.0 kg		250 mm	9.84 in	16.5 kg	<b>FC</b>
550 mm	21.65 in	24.6 kg	<b>FW</b>	550 mm	21.65 in	33.0 kg	<b>FW</b>



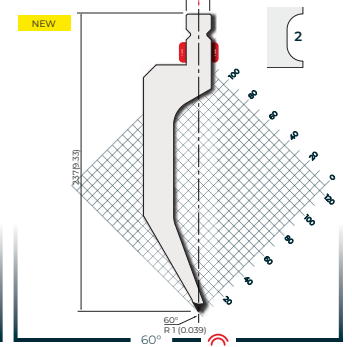
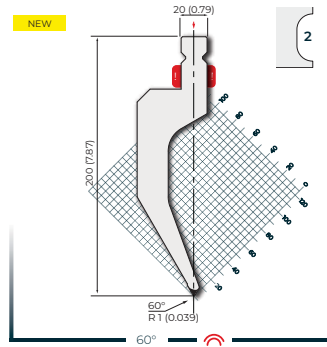
Punches - 

42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.
TPR256.86.R1-A				TPR200.80.R1			
100 mm	3.93 in	4.7 kg		100 mm	3.93 in	3.7 kg	
500 mm	19.68 in	28.5 kg		250 mm	9.84 in	9.2 kg	
250 mm	9.84 in	12.5 kg	FC	515 mm	20.82 in	19.0 kg	
550 mm	21.65 in	28.5 kg	FW	550 mm	21.65 in	21.0 kg	FW

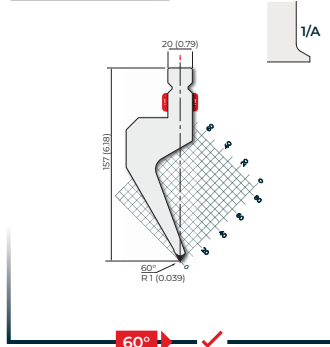
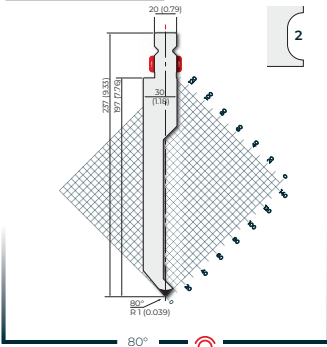


Punches - 

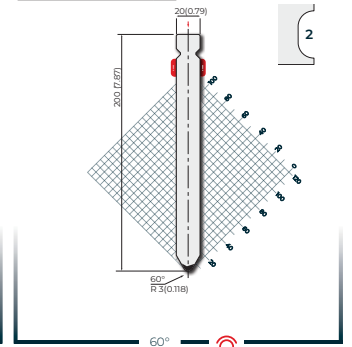
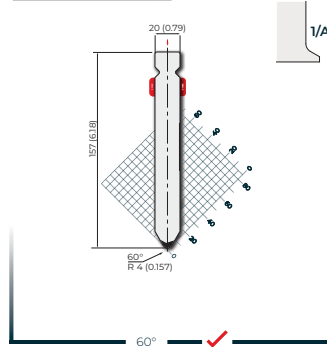
42Cr: 900-1150 N/mm <sup>2</sup>			700 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			700 kN/m max.
TPR200.60.R1				TPR237.60.R1			
100 mm	3.93 in	3.7 kg		100 mm	3.93 in	4.3 kg	
500 mm	19.68 in	18.3 kg		500 mm	19.68 in	21.6 kg	
250 mm	9.84 in	9.2 kg	FC	250 mm	9.84 in	10.8 kg	FC
550 mm	21.65 in	20.2 kg	FW	550 mm	21.65 in	23.8 kg	FW



42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			700 kN/m max.
TPR237.80.R1				TPR157.60.R1			
100 mm	3.93 in	3.8 kg		100 mm	3.93 in	3.0 kg	
250 mm	9.84 in	9.6 kg		500 mm	19.68 in	15.0 kg	
515 mm	20.82 in	19.7 kg	FW	250 mm	9.84 in	7.5 kg	FC
550 mm	21.65 in	21.0 kg	FW	550 mm	21.65 in	16.5 kg	FW

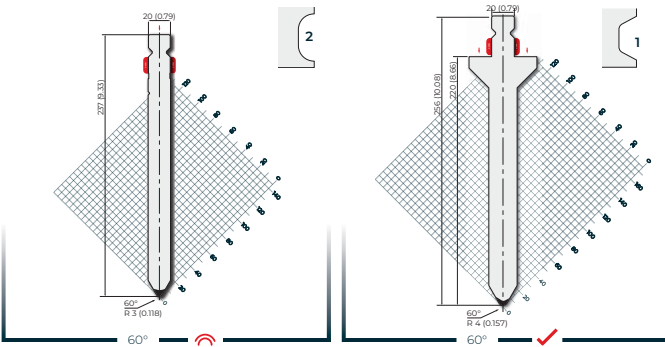


42Cr: 900-1150 N/mm <sup>2</sup>			1300 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1300 kN/m max.
TPR157.60.R4				TPR200.60.R3			
100 mm	3.93 in	2.4 kg		100 mm	3.93 in	3.0 kg	
500 mm	19.68 in	12.0 kg		250 mm	9.84 in	7.6 kg	
250 mm	9.84 in	6.0 kg	FC	515 mm	20.82 in	15.6 kg	
550 mm	21.65 in	12.0 kg	FW	550 mm	21.65 in	16.7 kg	FW



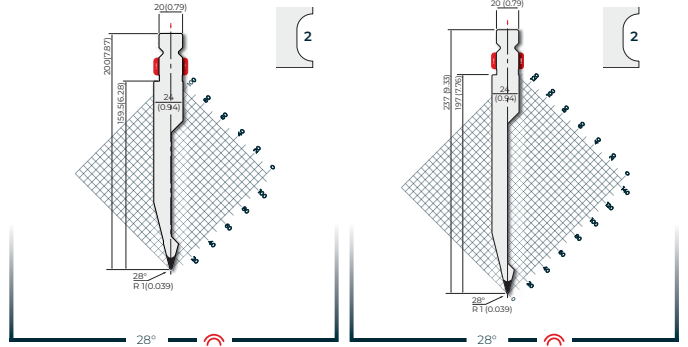
Punches - 

42Cr: 900-1150 N/mm <sup>2</sup>			1300 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1300 kN/m max.
TPR237.60.R3				TPR256.60.R4			
100 mm	3.93 in	3.6 kg		100 mm	3.93 in	5.2 kg	
250 mm	9.84 in	9.1 kg		500 mm	19.68 in	26.1 kg	
515 mm	20.82 in	18.8 kg		250 mm	9.84 in	13.5 kg	FC
550 mm	21.65 in	20.1 kg	FW	550 mm	21.65 in	27.0 kg	FW

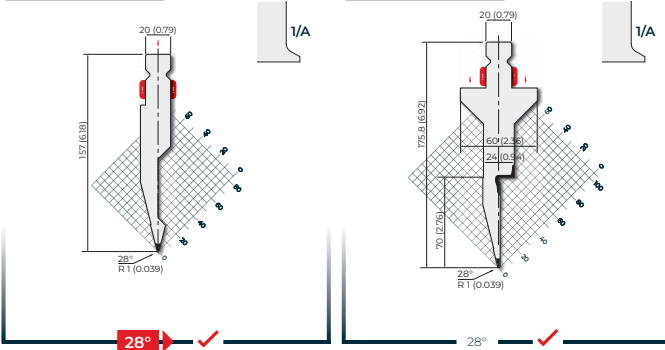


Punches - 

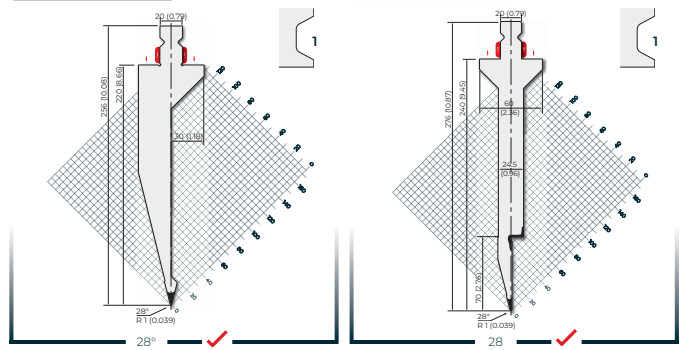
42Cr: 900-1150 N/mm <sup>2</sup>			600 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			600 kN/m max.
TPR200.28.R1				TPR237.28.R1			
100 mm	3.93 in	2.4 kg		100 mm	3.93 in	2.9 kg	
250 mm	9.84 in	6.1 kg		250 mm	9.84 in	7.3 kg	
515 mm	20.82 in	12.6 kg		515 mm	20.82 in	15.0 kg	
550 mm	21.65 in	13.5 kg	FW	550 mm	21.65 in	16.0 kg	FW



42Cr: 900-1150 N/mm <sup>2</sup>			600 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			400 kN/m max.
TPR157.28.R1				TPR176.28.R1			
100 mm	3.93 in	2.0 kg		100 mm	3.93 in	3.0 kg	
500 mm	19.68 in	10.0 kg		500 mm	19.68 in	15.0 kg	
250 mm	9.84 in	5.0 kg	FC	250 mm	9.84 in	7.5 kg	FC
550 mm	21.65 in	10.0 kg	FW	550 mm	21.65 in	10.0 kg	FW



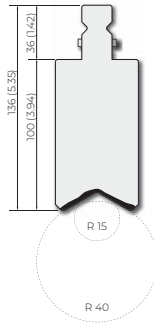
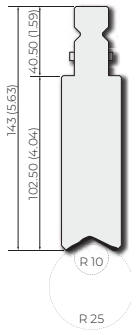
42Cr: 900-1150 N/mm <sup>2</sup>			600 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			400 kN/m max.
TPR256.28.R1				TPR276.28.R1			
100 mm	3.93 in	5.0 kg		100 mm	3.93 in	4.8 kg	
500 mm	19.68 in	25.0 kg		500 mm	19.68 in	24.0 kg	
250 mm	9.84 in	12.5 kg	FC	250 mm	9.84 in	12.0 kg	FC
550 mm	21.65 in	28.0 kg	FW	550 mm	21.65 in	26.4 kg	FW





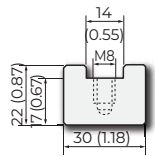
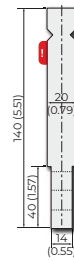
Radius punches -

42Cr: 900-1150 N/mm <sup>2</sup>				42Cr: 900-1150 N/mm <sup>2</sup>			
TPR143.10				TPR136.15			
525 mm	20.67 in	18.0 kg		525 mm	20.67 in	25.0 kg	
495 mm	19.49 in	17.0 kg	F	495 mm	19.49 in	23.7 kg	F



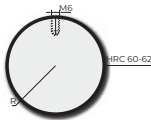
Radius Tools and Hemming tool -

C45: 560-710 N/mm <sup>2</sup>				C45: 560-710 N/mm <sup>2</sup>			
TPR140-14				E30.22			
830 mm	32.69 in	17.0 kg		830 mm	32.69 in	3.5 kg	▶ Hemming tool
412 mm	16.22 in	9.0 kg		412 mm	16.22 in	17 kg	



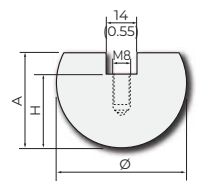
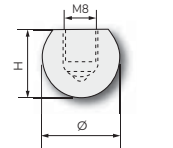
C33: 610-760 N/mm<sup>2</sup> Radius punches: R10-R40 1000 kN/m max

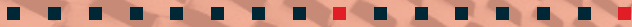
	R [mm]	R (in)		
TOP-C10	10	0.39	1.3 kg	2.7 kg
TOP-C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP-C15	15	0.59	3.0 kg	3.8 kg
TOP-C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP-C20	20	0.79	5.2 kg	6.6 kg
TOP-C22.5	22.5	0.89	6.6 kg	6.6 kg
TOP-C25	25	0.98	8.1 kg	7.5 kg
TOP-C27.5	27.5	1.08	9.8 kg	9.2 kg
TOP-C30	30	1.18	11.7 kg	11.3 kg
TOP-C32.5	32.5	1.28	13.7 kg	12.9 kg
TOP-C35	35	1.38	16.0 kg	15.1 kg
TOP-C37.5	37.5	1.47	18.2 kg	17.2 kg
TOP-C40	40	1.57	20.7 kg	19.5 kg



C45: 560-710 N/mm<sup>2</sup> Radius tool: ø 16 - 100 800 kN/m max

Ø [mm]	Ø [in]	A [mm]	A [in]	H [mm]	H [in]			
C13.08	16	0.63	13	0.51	-	20 kg	1.0 kg	
C16.10	18	0.71	16	0.63	-	20 kg	1.0 kg	
C16.10	20	0.79	16	0.63	-	20 kg	1.0 kg	
C17.12	25	0.98	17	0.67	22	0.86	25 kg	1.2 kg
C20.15	30	1.18	20	0.79	27	1.06	37 kg	1.8 kg
C22.17	35	1.38	22	0.86	32	1.26	50 kg	2.4 kg
C24.20	40	1.57	24	0.94	34	1.33	70 kg	3.5 kg
C25.22	45	1.78	25	0.98	35	1.33	75 kg	3.8 kg
C29.25	50	1.97	29	1.14	39	1.53	100 kg	4.7 kg
C34.27	55	2.16	34	1.33	44	1.73	124 kg	6.2 kg
C34.30	60	2.36	34	1.33	44	1.73	135 kg	6.7 kg
C37.32	65	2.56	37	1.45	47	1.85	159 kg	7.9 kg
C45.35	70	2.75	45	1.77	55	2.16	203 kg	10.0 kg
C42.37	75	2.95	42	1.65	52	2.04	205 kg	10.3 kg
C45.40	80	3.15	45	1.78	55	2.16	230 kg	11.5 kg
C60.45	90	3.54	60	2.36	70	2.75	340 kg	17.0 kg
C70.50	100	3.93	70	2.75	80	3.15	435 kg	21.7 kg










## PUNCHES ROLLERI TYPE R3

### ▼ COMPATIBILITY

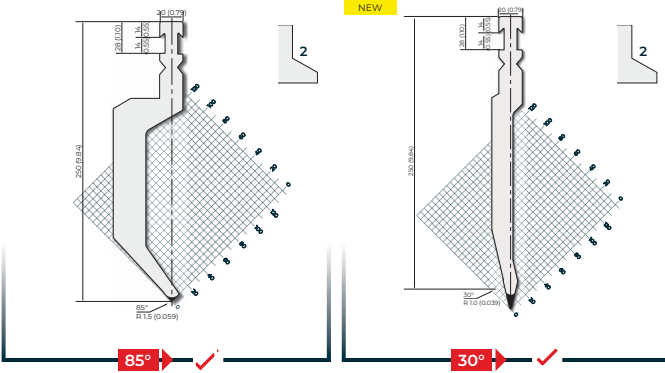
Bystronic Beyeler:  
RFA  
RF  
R  
S

Content Explanation	104 - 105
<b>Punches</b>	106 - 115
Bystronic-Beyeler  RFA	106 - 108
Bystronic-Beyeler  RFA Hemming Tools	109
Bystronic-Beyeler  RF	110
Bystronic-Beyeler  R	111 - 113
Bystronic-Beyeler  S	114 - 115
Joggle Tools	116 - 117
Radius Tools and Hemming Tool	118 - 121

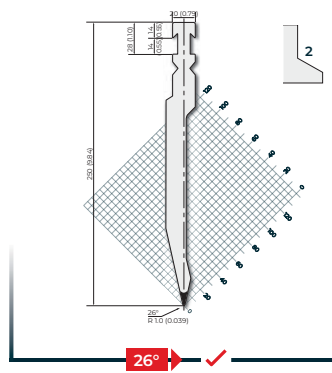




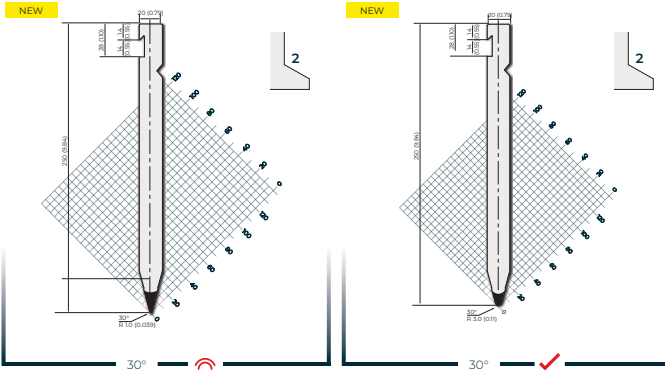
42Cr: 900-1150 N/mm <sup>2</sup>			900 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			750 kN/m max.
<b>BPR250.P4-RFA</b>							
508 mm	20.00 in	27.4 kg		508 mm	20.00 in	13.2 kg	
1100 mm	43.31 in	59.0 kg		1100 mm	43.31 in	28.6 kg	



42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
<b>BPR250.P5-RFA</b>			
508 mm	20.00 in	26.0 kg	
1100 mm	43.31 in	57.0 kg	

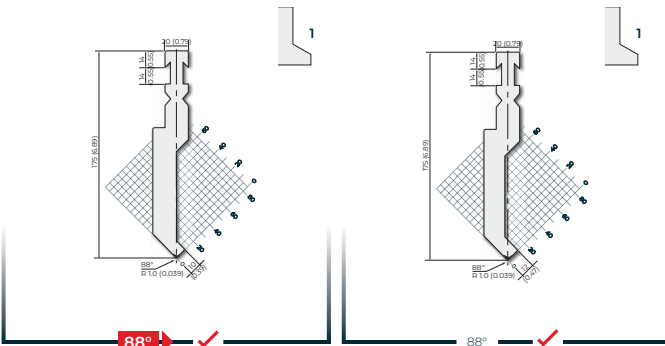


42Cr: 900-1150 N/mm <sup>2</sup>			1400 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1400 kN/m max.
<b>BPR.250.P6-RFA</b>							
508 mm	20.00 in	17.8 kg		508 mm	20.00 in	18.5 kg	
1100 mm	43.31 in	38.5 kg		1100 mm	43.31 in	40.1 kg	

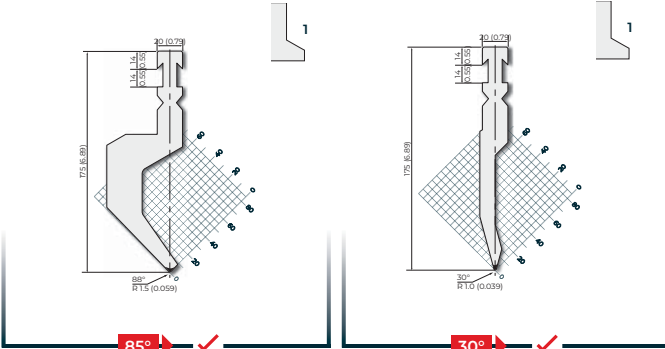


R3

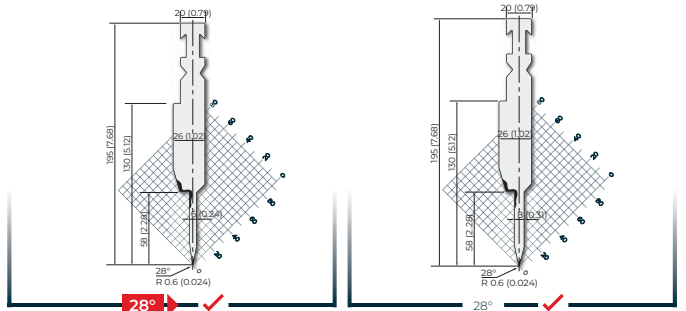
42Cr: 900-1150 N/mm <sup>2</sup>			42Cr: 900-1150 N/mm <sup>2</sup>		
BP175.88.R1-A-RFA			BP175.88.R1-B-RFA		
1000 mm	39.37 in	23.0 kg	1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg	500 mm	19.68 in	11.5 kg
1100 mm	43.31 in	25.3 kg	1100 mm	43.31 in	25.3 kg



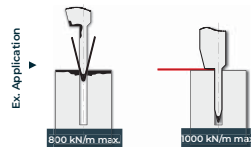
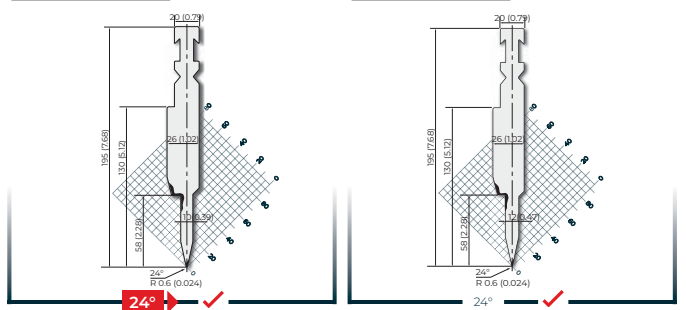
42Cr: 900-1150 N/mm <sup>2</sup>			42Cr: 900-1150 N/mm <sup>2</sup>		
BP175.88.R15-RFA			BP175.30.R1-RFA		
1000 mm	39.37 in	23.0 kg	1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	11.5 kg	500 mm	19.68 in	8.0 kg
1100 mm	43.31 in	23.0 kg	1100 mm	43.31 in	16.0 kg



42Cr: 900-1150 N/mm <sup>2</sup>			42Cr: 900-1150 N/mm <sup>2</sup>		
BPR.SP-195.28.6			BPR.SP-195.28.8		
525 mm	20.67 in	8.7 kg	525 mm	20.67 in	8.7 kg
495 mm	19.49 in	8.2 kg	495 mm	19.49 in	8.2 kg



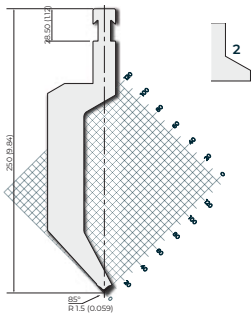
42Cr: 900-1150 N/mm <sup>2</sup>			42Cr: 900-1150 N/mm <sup>2</sup>		
BPR.SP-195.24.10			BPR.SP-195.24.12		
525 mm	20.67 in	8.7 kg	525 mm	20.67 in	8.7 kg
495 mm	19.49 in	8.2 kg	495 mm	19.49 in	8.2 kg



S	S	A	A	R420	R700	S	S	A	A	R420	R700
[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>	[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>
0.6	0.02	3.0	0.12	90	150	0.6	0.02	12	0.05	230	350
0.8	0.03	3.0	0.12	120	200	0.8	0.03	16	0.06	320	500
1.0	0.04	3.5	0.14	150	250	1.0	0.04	10	0.04	400	600
1.25	0.05	3.5	0.14	170	260	1.25	0.05	25	0.10	500	800

42Cr: 900-1150 N/mm <sup>2</sup>		
BPR250.P4-RF		
508 mm	20.00 in	276 kg
1100 mm	43.31 in	510 kg

1000 kN/m max.

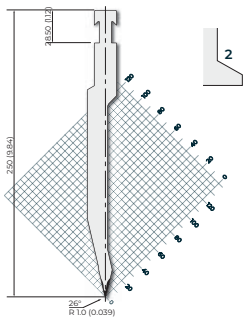


85° ✓



42Cr: 900-1150 N/mm <sup>2</sup>		
BPR250.P5-RF		
508 mm	20.00 in	16.6 kg
1100 mm	43.31 in	35.0 kg

900 kN/m max.



26° ✓

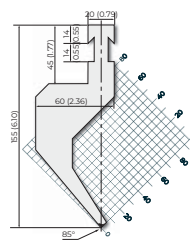


42Cr: 900-1150 N/mm <sup>2</sup>		
BPI55.85.R08-R		
1000 mm	39.37 in	22.0 kg
500 mm	19.68 in	12.5 kg
1100 mm	43.31 in	21.5 kg

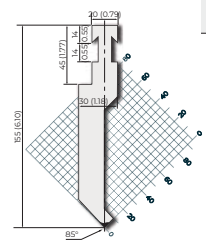
500 kN/m max.

42Cr: 900-1150 N/mm <sup>2</sup>		
BPI55.85.R1-R		
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm	43.31 in	23.0 kg

1000 kN/m max.



85°



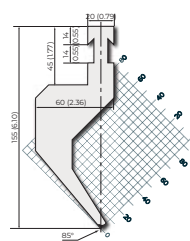
85°

42Cr: 900-1150 N/mm <sup>2</sup>		
BPI55.85.R15-R		
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm	43.31 in	32.0 kg

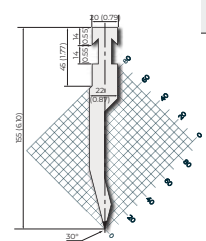
500 kN/m max.

42Cr: 900-1150 N/mm <sup>2</sup>		
BPI55.30.R1-R		
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm	43.31 in	18.0 kg



800 kN/m max.

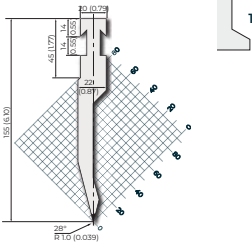


85° ✓

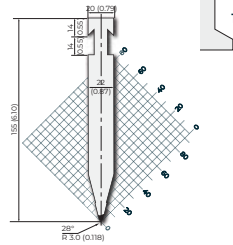


30° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
BP155.28.R1-R				BP155.28.R3-R			
1000 mm	39.37 in.	16.0 kg		1000 mm	39.37 in.	21.0 kg	
500 mm	19.68 in.	8.0 kg		500 mm	19.68 in.	11.0 kg	
1100 mm	43.31 in.	17.5 kg		1100 mm	43.31 in.	23.5 kg	



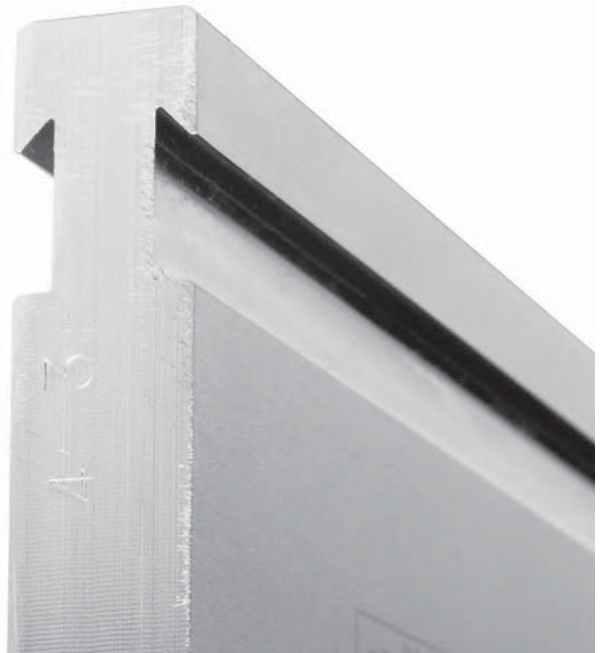
28° 





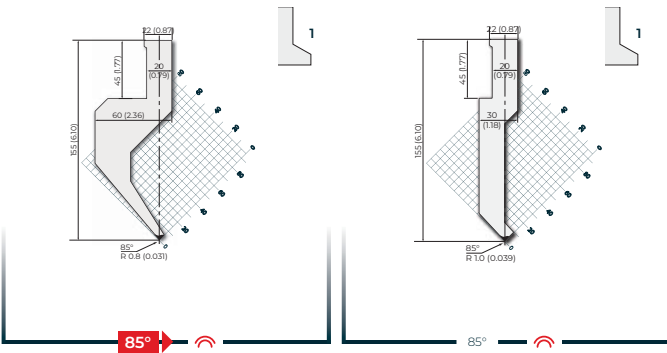
28° 




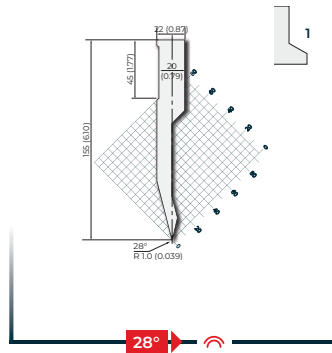
R3




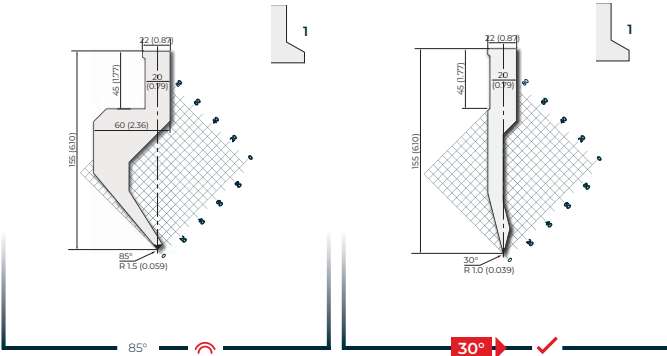
42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
BP155.85.R08-S				BP155.85.R1-S			
1000 mm	39.37 in	16.0 kg		1000 mm	39.37 in	32.0 kg	
500 mm	19.68 in	8.0 kg		500 mm	19.68 in	16.0 kg	
1100 mm	43.31 in	17.5 kg		1100 mm	43.31 in	35.2 kg	




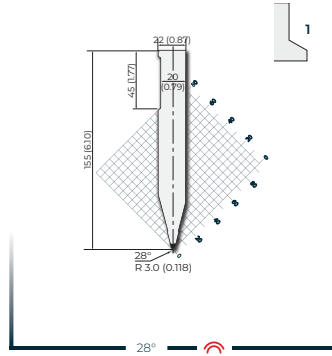
42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
BP155.28.R1-S			
1000 mm	39.37 in	16.0 kg	
500 mm	19.68 in	8.0 kg	
1100 mm	43.31 in	17.5 kg	



42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.
BP155.85.R15-S				BP155.30.R1-S			
1000 mm	39.37 in	32.0 kg		1000 mm	39.37 in	17.5 kg	
500 mm	19.68 in	16.5 kg		500 mm	19.68 in	9.0 kg	
1100 mm	43.31 in	32.0 kg		1100 mm	43.31 in	17.5 kg	



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
BP155.28.R3-S			
1000 mm	39.37 in	23.5 kg	
500 mm	19.68 in	12.0 kg	
1100 mm	43.31 in	23.5 kg	

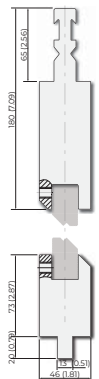


C45: 560-710 N/mm<sup>2</sup>

1000 kN/m<sup>2</sup> max.

**BPZ-RFA**

835 mm	32.87 in	375 kg
45 mm	16.34 in	187 kg

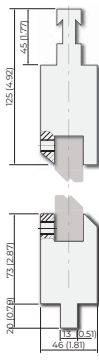


C45: 560-710 N/mm<sup>2</sup>

1000 kN/m<sup>2</sup> max.

**BPZ-R**

835 mm	32.87 in	24.7 kg
45 mm	16.34 in	12.3 kg

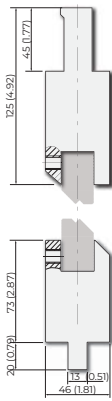


C45: 560-710 N/mm<sup>2</sup>

1000 kN/m<sup>2</sup> max.

**BPZ-S**

835 mm	32.87 in	375 kg
45 mm	16.34 in	185 kg



R3

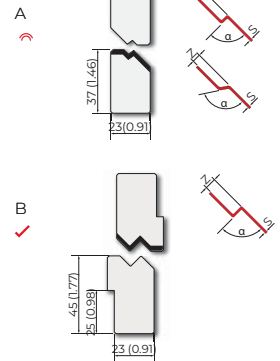
C45: 560-710 N/mm<sup>2</sup>

1000 kN/m<sup>2</sup> max.

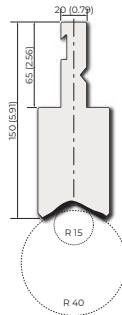
**Joggle Tool Inserts**

	Z	Z	a	S'	S'			
	[mm]	[in]	[°]	[mm]	[in]			
CEZ 10	1.0	0.04	160°	12	0.05	11.0 kg	5.5 kg	A
CEZ 15	1.5	0.06	160°	15	0.06	11.0 kg	5.5 kg	A
CEZ 2.0	2.0	0.08	150°	14	0.06	11.0 kg	5.5 kg	A
CEZ 2.5	2.5	0.10	140°	13	0.05	11.0 kg	5.5 kg	A
CEZ 10/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg	A
CEZ 15/90	1.5	0.06	90°	0.3	0.01	11.0 kg	5.5 kg	A
CEZ 2.0/90	2.0	0.08	90°	0.4	0.02	11.0 kg	5.5 kg	A
CEZ 2.5/90	2.5	0.10	90°	0.5	0.02	11.0 kg	5.5 kg	A
CEZ 3.0	3.0	0.12	90°	10	0.04	10.3 kg	5.1 kg	A
CEZ 3.5	3.5	0.14	90°	10	0.04	10.0 kg	5.0 kg	A
CEZ 4.0	4.0	0.16	90°	12	0.05	10.0 kg	5.0 kg	A
CEZ 4.5	4.5	0.18	90°	12	0.05	10.0 kg	5.0 kg	A
CEZ 5.0	5.0	0.20	90°	13	0.05	10.0 kg	5.0 kg	A
CEZ 5.5	5.5	0.22	90°	14	0.06	10.0 kg	5.0 kg	A
CEZ 6.0	6.0	0.24	90°	15	0.06	10.0 kg	5.0 kg	A
CEZ 6.5	6.5	0.26	90°	15	0.06	10.0 kg	5.0 kg	A
CEZ 7.0	7.0	0.28	90°	15	0.06	10.0 kg	5.0 kg	A
CEZ 7.5	7.5	0.30	90°	16	0.06	10.0 kg	5.0 kg	A
CEZ 8.0	8.0	0.33	90°	16	0.06	10.0 kg	5.0 kg	A
CEZ 9.0	9	0.35	90°	18	0.07	13.5 kg	6.5 kg	B
CEZ 10.0	10	0.39	90°	18	0.07	13.5 kg	6.5 kg	B
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	6.5 kg	B
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	6.5 kg	B
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	6.5 kg	B
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	6.5 kg	B
CEZ 15.0	15	0.59	90°	23	0.09	13.5 kg	6.5 kg	B

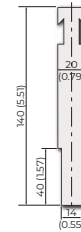
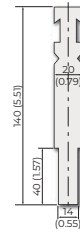
\* Fe Rmax = 420 N/mm<sup>2</sup>



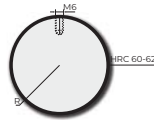
42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.		
BPR150.PI0.10-RFA						BPR150.PI0.15-RFA					
522 mm	20.55 in	16.5 kg	522 mm	20.55 in	23.0 kg	495 mm	19.49 in	16.0 kg	495 mm	19.49 in	21.7 kg



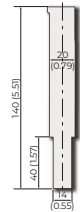
C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.			C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.		
BPU-RFA						BPU-R					
830 mm	32.68 in	15.3 kg	830 mm	32.68 in	15.8 kg	410 mm	16.14 in	7.6 kg	410 mm	16.14 in	7.8 kg



C53: 610-760 N/mm <sup>2</sup>				1000 kN/m max.			
Radius punches: R08-R40							
R [mm]		R [in]					
TOP-C08	8	0.31		0.8 kg		1.9 kg	
TOP-C10	10	0.39		1.3 kg		2.7 kg	
TOP-C12.5	12.5	0.49		2.0 kg		2.8 kg	
TOP-C15	15	0.59		3.0 kg		3.8 kg	
TOP-C17.5	17.5	0.69		4.0 kg		4.7 kg	
TOP-C20	20	0.79		5.2 kg		6.6 kg	
TOP-C22.5	22.5	0.88		6.6 kg		6.6 kg	
TOP-C25	25	0.98		8.1 kg		7.5 kg	
TOP-C27.5	27.5	1.08		9.8 kg		9.2 kg	
TOP-C30	30	1.18		11.7 kg		11.3 kg	
TOP-C32.5	32.5	1.28		13.7 kg		12.9 kg	
TOP-C35	35	1.38		16.0 kg		15.1 kg	
TOP-C37.5	37.5	1.47		18.2 kg		17.2 kg	
TOP-C40	40	1.57		20.7 kg		19.5 kg	



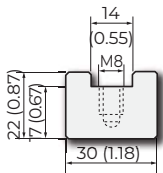
C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.		
BPU-S					
830 mm	32.68 in	16.8 kg	410 mm	16.14 in	8.3 kg





Radius Tools and Hemming Tool - 

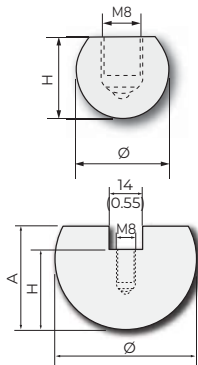
C45: 560-710 N/mm <sup>2</sup>			800 kN/m max.
<b>E30.22</b>			
830 mm	32.67 in	35 kg	▶ Hemming tool
412 mm	16.34 in	17 kg	



R3

C45: 560-710 N/mm<sup>2</sup>

Radius tools ø 16 - 100						800 kN/m max.
Ø	Ø	H	A	A		
[mm]	[in]	[mm]	[mm]	[in]		
C13.08	16	0.63	13	-	-	2.0 kg / 1.0 kg
C13.09	18	0.71	16	-	-	2.0 kg / 1.0 kg
C16.10	20	0.79	16	-	-	2.0 kg / 1.0 kg
C17.12	25	0.98	17	22	0.87	2.5 kg / 1.2 kg
C20.15	30	1.18	20	27	1.06	3.7 kg / 1.8 kg
C22.17	35	1.39	22	32	1.26	5.0 kg / 2.4 kg
C24.20	40	1.57	24	34	1.34	7.0 kg / 3.5 kg
C25.22	45	1.77	25	35	1.37	7.5 kg / 3.8 kg
C29.25	50	1.97	29	39	1.54	10.0 kg / 4.7 kg
C34.27	55	2.16	34	44	1.73	12.4 kg / 6.2 kg
C34.30	60	2.36	34	44	1.73	13.5 kg / 6.7 kg
C37.32	65	2.56	37	47	1.85	15.9 kg / 7.9 kg
C45.35	70	2.76	45	55	2.17	20.3 kg / 10.0 kg
C42.37	75	2.96	42	52	2.04	20.5 kg / 10.3 kg
C45.40	80	3.15	45	55	2.17	23.0 kg / 11.5 kg
C60.45	90	3.54	60	70	2.76	34.0 kg / 17.0 kg
C70.50	100	3.94	70	80	3.15	43.5 kg / 21.7 kg





## DIES ROLLERI TYPE R2-R3

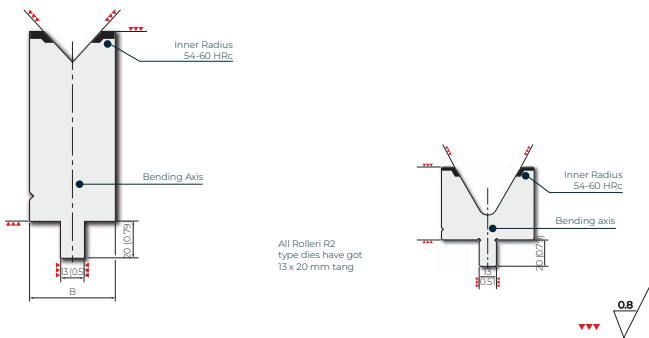
### ▼ COMPATIBILITY

Bystronic Beyeler  
 Darley  
 Safan  
 SMD  
 Trumpf  
 Press brake machines with System NSCR

Content Explanation	124 - 125
<b>Dies</b>	126 -141
90°, H=55 mm	126
88°, H=55 mm	126 - 127
85°, H=55 mm	127 - 128
80°, H=55 mm	128 - 129
60°, H=55 mm	130
30°, H=55 mm	130 - 131
90°, H=100 mm	132
86°, H=100 mm	132 - 133
84°, H=100 mm	133 - 134
80°, H=100 mm	134 - 135
60°, H=120 mm	135
30°, H=100 mm	136 - 137
86°, H=150 mm	138
84°, H=150 mm	138 - 139
80°, H=150 mm	139 - 140
30°, H=150 mm	140 - 141
<b>Hemming dies</b>	142
<b>Hemming dies for movable dies</b>	143

Content Explanation -

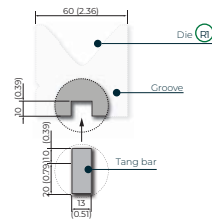
**STANDARD TANG**



**MODIFICATIONS WEDGE/BAR TAIL**

To use Rolleri Type dies, a 10 mm groove is milled where a ground bar is mounted.

**A30 [Example]**



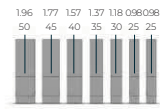
**STANDARD LENGTH**



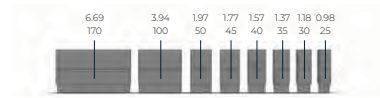
Content Explanation -

**SEGMENTATION**

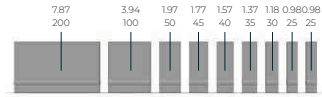
FC: 250 mm (9.84 in) - 7 segments



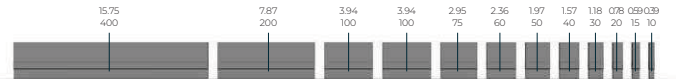
F: 495 mm (19.49 in) - 8 segments



FW: 550 mm (21.65 in) - 9 segments



F: 1100 mm (43.31 in) - 12 segments



FA: 49.21-80.71-100.39-120.08-159.45 in

Length mm [in]	25 [0.98]	30 [1.18]	35 [1.38]	40 [1.57]	45 [1.77]	50 [1.97]	100 [3.94]
1250 [49.21]	2	1	1	1	1	1	10
2050 [80.71]	2	1	1	1	1	1	18
2550 [100.39]	2	1	1	1	1	1	23
3050 [120.08]	2	1	1	1	1	1	28
4050 [159.45]	2	1	1	1	1	1	28

Available on request

FB: 49.21-80.71-100.39-120.08-159.45 in

Length mm [in]	25 [0.98]	30 [1.18]	35 [1.38]	40 [1.57]	45 [1.77]	50 [1.97]	100 [3.94]	200 [7.87]	300 [11.81]	500 [19.68]
1250 [49.21]	2	1	1	1	1	1	3	2	1	0
2050 [80.71]	2	1	1	1	1	1	3	1	1	2
2550 [100.39]	2	1	1	1	1	1	3	1	1	3
3050 [120.08]	2	1	1	1	1	1	3	1	1	4
4050 [159.45]	2	1	1	1	1	1	3	1	1	6

Available on request

42Cr: 900-1150 N/mm <sup>2</sup>			1150 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.
<b>BMR55.06.90</b>				<b>BMR55.08.90</b>			
1000 mm	39.37 in	8.5 kg		1000 mm	39.37 in	9.0 kg	
500 mm	19.68 in	4.2 kg		500 mm	19.68 in	4.5 kg	
1100 mm	43.31 in	8.5 kg	F	1100 mm	43.31 in	8.5 kg	F

90° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>BMR55.10.90</b>				<b>BMR55.12.90</b>			
1000 mm	39.37 in	10.5 kg		1000 mm	39.37 in	10.5 kg	
500 mm	19.68 in	5.2 kg	F	500 mm	19.68 in	5.2 kg	F
1100 mm	43.31 in	10.0 kg	F	1100 mm	43.31 in	10.0 kg	F

90° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1150 kN/m max.
<b>BMR55.16.90</b>				<b>BMR55.06.88</b>			
1000 mm	39.37 in	14.5 kg		1000 mm	39.37 in	8.5 kg	
500 mm	19.68 in	7.2 kg	F	500 mm	19.68 in	4.2 kg	
1100 mm	43.31 in	14.0 kg	F	1100 mm	43.31 in	8.5 kg	F

90° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.
<b>BMR55.08.88</b>				<b>BMR55.10.88</b>			
1000 mm	39.37 in	9.0 kg		1000 mm	39.37 in	11.0 kg	
500 mm	19.68 in	4.2 kg	F	500 mm	19.68 in	5.0 kg	
1100 mm	43.31 in	8.5 kg	F	1100 mm	43.31 in	12.0 kg	F

88° ✓



42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>BMR55.12.88</b>				<b>BMR55.16.88</b>			
1000 mm	39.37 in	10.5 kg		1000 mm	39.37 in	14.5 kg	
500 mm	19.68 in	5.2 kg		500 mm	19.68 in	7.2 kg	
1100 mm	43.31 in	10.0 kg	F	1100 mm	43.31 in	14.0 kg	F

88° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>BMR55.20.88</b>				<b>BMR55.24.88</b>			
1000 mm	39.37 in	14.5 kg		1000 mm	39.37 in	18.5 kg	
500 mm	19.68 in	7.2 kg	F	500 mm	19.68 in	9.2 kg	
1100 mm	43.31 in	14.0 kg	F	1100 mm	43.31 in	18.0 kg	F

88° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			1150 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.
<b>BMR55.06.85</b>				<b>BMR55.08.85</b>			
1000 mm	39.37 in	8.5 kg		1000 mm	39.37 in	9.0 kg	
500 mm	19.68 in	4.2 kg	F	500 mm	19.68 in	4.5 kg	
1100 mm	43.31 in	8.5 kg	F	1100 mm	43.31 in	8.5 kg	F

85° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>BMR55.10.85</b>				<b>BMR55.12.85</b>			
1000 mm	39.37 in	11.0 kg		1000 mm	39.37 in	10.5 kg	
500 mm	19.68 in	5.0 kg	F	500 mm	19.68 in	5.2 kg	
1100 mm	43.31 in	12.0 kg	F	1100 mm	43.31 in	10.0 kg	F

85° ✓

42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.
<b>BMR55.16.85</b>				<b>BMR55.20.85</b>			
1000 mm	39.37 in	14.5 kg		1000 mm	39.37 in	14.5 kg	
500 mm	19.68 in	7.2 kg		500 mm	19.68 in	7.2 kg	
1100 mm	43.31 in	14.0 kg	F	1100 mm	43.31 in	14.0 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1300 kN/m max.
<b>BMR55.24.85</b>				<b>BMR55.32.85</b>			
1000 mm	39.37 in	18.5 kg		1000 mm	39.37 in	21.0 kg	
500 mm	19.68 in	9.2 kg		500 mm	19.68 in	10.5 kg	
1100 mm	43.31 in	18.0 kg	F	1100 mm	43.31 in	20.5 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1150 kN/m max.
<b>BMR55.40.85</b>				<b>BMR55.06.80</b>			
1000 mm	39.37 in	21.5 kg		1000 mm	39.37 in	8.5 kg	
500 mm	19.68 in	10.7 kg		500 mm	19.68 in	4.2 kg	
1100 mm	43.31 in	25.0 kg	F	1100 mm	43.31 in	8.5 kg	F

42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.
<b>BMR55.08.80</b>				<b>BMR55.10.80</b>			
1000 mm	39.37 in	9.0 kg		1000 mm	39.37 in	11.0 kg	
500 mm	19.68 in	4.5 kg		500 mm	19.68 in	5.0 kg	
1100 mm	43.31 in	8.5 kg	F	1100 mm	43.31 in	12.0 kg	F

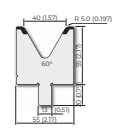

42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>BMR55.12.80</b>				<b>BMR55.16.80</b>			
1000 mm	39.37 in	10.5 kg		1000 mm	39.37 in	14.5 kg	
500 mm	19.68 in	5.2 kg		500 mm	19.68 in	7.2 kg	
1100 mm	43.31 in	10.0 kg	F	1100 mm	43.31 in	14.0 kg	F


42Cr: 900-1150 N/mm <sup>2</sup>			1100 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>BMR55.20.80</b>				<b>BMR55.24.80</b>			
1000 mm	39.37 in	14.5 kg		1000 mm	39.37 in	18.5 kg	
500 mm	19.68 in	7.2 kg		500 mm	19.68 in	9.2 kg	
1100 mm	43.31 in	14.0 kg	F	1100 mm	43.31 in	18.0 kg	F

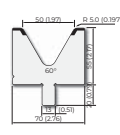

42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>BMR55.32.80</b>				<b>BMR55.40.80</b>			
1000 mm	39.37 in	21.0 kg		1000 mm	39.37 in	21.5 kg	
500 mm	19.68 in	10.5 kg		500 mm	19.68 in	10.7 kg	
1100 mm	43.31 in	20.5 kg	F	1100 mm	43.31 in	25.0 kg	F


42Cr: 900-1150 N/mm <sup>2</sup>			1700 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			2300 kN/m max.
<b>BMR65.80.80</b>				<b>BMR85.100.80</b>			
1000 mm	39.37 in	39.0 kg		1000 mm	39.37 in	62.0 kg	
500 mm	19.68 in	20.0 kg		500 mm	19.68 in	31.0 kg	
1100 mm	43.31 in	43.0 kg	F	1100 mm	43.31 in	69.0 kg	F

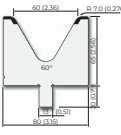

Dies - 


42Cr-900-1150 N/mm <sup>2</sup>			1300 kN/m max.
<b>BMR55.40.60</b>			
1000 mm	39.37 in	20.3 kg	
500 mm	19.68 in	10.5 kg	
1100 mm	43.31 in	22.3 kg 	

60° 



42Cr-900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>BMR55.50.60</b>			
1000 mm	39.37 in	24.0 kg	
500 mm	19.68 in	12.0 kg	
1100 mm	43.31 in	21.0 kg 	


60° 



42Cr-900-1150 N/mm <sup>2</sup>			1100 kN/m max.
<b>BMR65.60.60</b>			
1000 mm	39.37 in	31.0 kg	
500 mm	19.68 in	15.5 kg	
1100 mm	43.31 in	34.1 kg 	


60° 

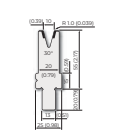




42Cr-900-1150 N/mm <sup>2</sup>			350 kN/m max.
<b>BMR55.06.30</b>			
1000 mm	39.37 in	8.0 kg	
500 mm	19.68 in	4.0 kg	
1100 mm	43.31 in	9.0 kg 	

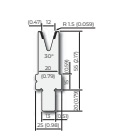

30° 


42Cr-900-1150 N/mm <sup>2</sup>			200 kN/m max.
<b>BMR55.08.30</b>			
1000 mm	39.37 in	9.2 kg	
500 mm	19.68 in	4.0 kg	
1100 mm	43.31 in	10.1 kg 	

30° 

42Cr-900-1150 N/mm <sup>2</sup>			350 kN/m max.
<b>BMR55.10.30</b>			
1000 mm	39.37 in	10.0 kg	
500 mm	19.68 in	5.0 kg	
1100 mm	43.31 in	11.0 kg 	

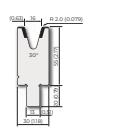

30° 


42Cr-900-1150 N/mm <sup>2</sup>			300 kN/m max.
<b>BMR55.12.30</b>			
1000 mm	39.37 in	10.0 kg	
500 mm	19.68 in	5.0 kg	
1100 mm	43.31 in	11.0 kg 	

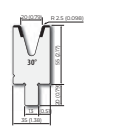

30° 


Dies - 

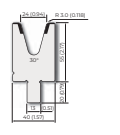




42Cr-900-1150 N/mm <sup>2</sup>			450 kN/m max.
<b>BMR55.16.30</b>			
1000 mm	39.37 in	13.5 kg	
500 mm	19.68 in	6.7 kg	
1100 mm	43.31 in	14.9 kg 	

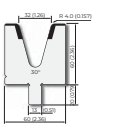

30° 


42Cr-900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>BMR55.20.30</b>			
1000 mm	39.37 in	14.0 kg	
500 mm	19.68 in	7.0 kg	
1100 mm	43.31 in	15.5 kg 	

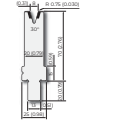

30° 


42Cr-900-1150 N/mm <sup>2</sup>			550 kN/m max.
<b>BMR55.24.30</b>			
1000 mm	39.37 in	15.5 kg	
500 mm	19.68 in	7.8 kg	
1100 mm	43.31 in	17.0 kg 	

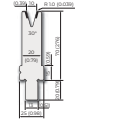

30° 


42Cr-900-1150 N/mm <sup>2</sup>			650 kN/m max.
<b>BMR60.32.30</b>			
1000 mm	39.37 in	23.0 kg	
500 mm	19.68 in	11.5 kg	
1100 mm	43.31 in	22.5 kg 	

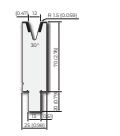

30° 


42Cr-900-1150 N/mm <sup>2</sup>			200 kN/m max.
<b>BMR70.08.30</b>			
1000 mm	39.37 in	13.1 kg	
500 mm	19.68 in	6.5 kg	
1100 mm	43.31 in	14.0 kg 	

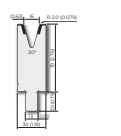

30° 


42Cr-900-1150 N/mm <sup>2</sup>			330 kN/m max.
<b>BMR70.10.30</b>			
1000 mm	39.37 in	12.8 kg	
500 mm	19.68 in	6.4 kg	
1100 mm	43.31 in	12.4 kg 	

30° 

42Cr-900-1150 N/mm <sup>2</sup>			300 kN/m max.
<b>BMR70.12.30</b>			
1000 mm	39.37 in	14.7 kg	
500 mm	19.68 in	7.3 kg	
1100 mm	43.31 in	14.3 kg 	

30° 

42Cr-900-1150 N/mm <sup>2</sup>			450 kN/m max.
<b>BMR70.16.30</b>			
1000 mm	39.37 in	16.7 kg	
500 mm	19.68 in	8.3 kg	
1100 mm	43.31 in	16.2 kg 	

30° 

**42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.** **42Cr: 900-1150 N/mm<sup>2</sup>** **250 kN/m max.**

**WMRI00.12.90** **TMRI00.04.86**

100 mm	39.37 in	17 kg
515 mm	20.28 in	9.0 kg
550 mm	21.65 in	9.6 kg

100 mm	3.94 in	1.0 kg
500 mm	19.68 in	4.8 kg
250 mm	9.84 in	2.4 kg
550 mm	21.65 in	5.2 kg

90° ✓

86° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.** **42Cr: 900-1150 N/mm<sup>2</sup>** **1150 kN/m max.**

**TMRI00.06.86** **TMRI00.08.86**

100 mm	3.94 in	1.8 kg
500 mm	19.68 in	8.9 kg
250 mm	9.84 in	4.4 kg
550 mm	21.65 in	8.9 kg

100 mm	3.94 in	1.8 kg
500 mm	19.68 in	8.8 kg
250 mm	9.84 in	4.4 kg
550 mm	21.65 in	9.6 kg

86° ✓

86° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>** **400 kN/m max.** **42Cr: 900-1150 N/mm<sup>2</sup>** **1100 kN/m max.**

**WMRI00.08.86** **TMRI00.10.86**

100 mm	39.37 in	15 kg
515 mm	20.28 in	7.7 kg
550 mm	43.31 in	8.2 kg

100 mm	3.94 in	1.8 kg
500 mm	19.68 in	8.8 kg
250 mm	9.84 in	4.4 kg
550 mm	21.65 in	9.6 kg

86° ✓

86° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.** **42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.**

**TMRI00.12.86** **WMRI00.12.86**

100 mm	3.94 in	2.1 kg
500 mm	19.68 in	10.7 kg
250 mm	9.84 in	5.0 kg
550 mm	21.65 in	11.7 kg

100 mm	39.37 in	1.7 kg
515 mm	20.28 in	9.0 kg
550 mm	43.31 in	9.6 kg

86° ✓

86° ✓



**42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.** **42Cr: 900-1150 N/mm<sup>2</sup>** **1150 kN/m max.**

**TMRI00.16.86** **TMRI00.20.86**

100 mm	3.94 in	2.5 kg
500 mm	19.68 in	12.5 kg
250 mm	9.84 in	6.3 kg
550 mm	21.65 in	13.8 kg

100 mm	3.94 in	2.4 kg
500 mm	19.68 in	12.2 kg
250 mm	9.84 in	6.2 kg
550 mm	21.65 in	13.5 kg

86° ✓

86° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.** **42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.**

**TMRI00.24.86** **TMRI00.30.86**

100 mm	3.94 in	2.8 kg
500 mm	19.68 in	14.0 kg
250 mm	9.84 in	7.0 kg
550 mm	21.65 in	15.5 kg

100 mm	3.94 in	3.5 kg
500 mm	19.68 in	17.6 kg
250 mm	9.84 in	8.8 kg
550 mm	21.65 in	19.4 kg

86° ✓

86° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.** **42Cr: 900-1150 N/mm<sup>2</sup>** **1500 kN/m max.**

**TMRI00.40.86** **TMRI00.50.86**

100 mm	3.94 in	13.1 kg
500 mm	19.68 in	6.5 kg
250 mm	9.84 in	14.0 kg
550 mm	21.65 in	22.8 kg

100 mm	3.94 in	4.1 kg
500 mm	19.68 in	6.4 kg
250 mm	9.84 in	12.4 kg
550 mm	21.65 in	30.5 kg

86° ✓

86° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>** **1200 kN/m max.** **42Cr: 900-1150 N/mm<sup>2</sup>** **1150 kN/m max.**

**TMRI00.06.84** **TMRI00.08.84**

100 mm	3.94 in	1.8 kg
500 mm	19.68 in	8.8 kg
250 mm	9.84 in	4.4 kg
550 mm	21.65 in	8.8 kg

100 mm	3.94 in	1.8 kg
500 mm	19.68 in	8.8 kg
250 mm	9.84 in	4.4 kg
550 mm	21.65 in	9.7 kg

84° ✓

84° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR100.10.84** 1100 kN/m max.

100 mm	3.94 in	1.8 kg
500 mm	19.68 in	8.8 kg
250 mm	9.84 in	4.4 kg
550 mm	21.65 in	9.6 kg

84° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR100.12.84** 1200 kN/m max.

100 mm	3.94 in	2.1 kg
500 mm	19.68 in	10.7 kg
250 mm	9.84 in	5.3 kg
550 mm	21.65 in	11.7 kg

84° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR100.16.84** 1200 kN/m max.

100 mm	3.94 in	2.5 kg
500 mm	19.68 in	12.5 kg
250 mm	9.84 in	6.3 kg
550 mm	21.65 in	13.8 kg

84° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR100.20.84** 1150 kN/m max.

100 mm	3.94 in	2.4 kg
500 mm	19.68 in	12.2 kg
250 mm	9.84 in	6.1 kg
550 mm	21.65 in	13.4 kg

84° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR100.24.84** 1200 kN/m max.

100 mm	3.94 in	2.8 kg
500 mm	19.68 in	14.0 kg
250 mm	9.84 in	7.0 kg
550 mm	21.65 in	15.4 kg

84° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR100.60.80** 1500 kN/m max.

100 mm	3.94 in	5.2 kg
500 mm	19.68 in	25.8 kg
250 mm	9.84 in	13.0 kg
550 mm	21.65 in	28.4 kg

80° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR100.70.80** 1500 kN/m max.

100 mm	3.94 in	5.7 kg
500 mm	19.68 in	28.2 kg
250 mm	9.84 in	14.1 kg
550 mm	21.65 in	31.0 kg

80° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR100.80.80** 1500 kN/m max.

100 mm	3.94 in	6.5 kg
500 mm	19.68 in	32.3 kg
250 mm	9.84 in	16.1 kg
550 mm	21.65 in	35.5 kg

80° ✓



**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR120.90.80** 1500 kN/m max.

100 mm	3.94 in	8.4 kg
500 mm	19.68 in	42.1 kg
250 mm	9.84 in	21.0 kg
550 mm	21.65 in	46.3 kg

80° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR120.100.80** 1500 kN/m max.

100 mm	3.94 in	10.0 kg
500 mm	19.68 in	44.7 kg
250 mm	9.84 in	22.4 kg
550 mm	21.65 in	49.2 kg

80° ✓

**42Cr: 900-1150 N/mm<sup>2</sup>**  
**TMR120.120.60** 1600 kN/m max.

100 mm	3.94 in	8.9 kg
500 mm	19.68 in	44.5 kg
250 mm	9.84 in	22.8 kg
550 mm	21.65 in	49.0 kg

60° ✓





Dies - R2 R3

**42Cr-900-1150 N/mm<sup>2</sup>** 150 kN/m max. **42Cr-900-1150 N/mm<sup>2</sup>** 400 kN/m max.

**TMRI00.04.30** **TMRI00.06.30**

100 mm	3.94 in	1.4 kg
500 mm	19.68 in	7.0 kg
250 mm	9.84 in	3.5 kg <b>FC</b>
550 mm	21.65 in	7.7 kg <b>FW</b>

30°

**42Cr-900-1150 N/mm<sup>2</sup>** 400 kN/m max. **42Cr-900-1150 N/mm<sup>2</sup>** 400 kN/m max.

**WMRI00.06.30** **TMRI00.08.30**

100 mm	3.94 in	1.8 kg
500 mm	19.68 in	8.8 kg
250 mm	9.84 in	4.4 kg <b>FC</b>
550 mm	21.65 in	9.6 kg <b>FW</b>

30°

**42Cr-900-1150 N/mm<sup>2</sup>** 400 kN/m max. **42Cr-900-1150 N/mm<sup>2</sup>** 400 kN/m max.

**WMRI00.08.30** **TMRI00.10.30**

100 mm	3.94 in	2.4 kg
500 mm	19.68 in	12.2 kg
250 mm	9.84 in	6.1 kg <b>FC</b>
550 mm	21.65 in	13.4 kg <b>FW</b>

30°

**42Cr-900-1150 N/mm<sup>2</sup>** 400 kN/m max. **42Cr-900-1150 N/mm<sup>2</sup>** 400 kN/m max.

**WMRI00.10.30** **TMRI00.12.30**

100 mm	3.94 in	1.7 kg
500 mm	19.68 in	8.5 kg
250 mm	9.84 in	4.3 kg <b>FC</b>
550 mm	21.65 in	9.4 kg <b>FW</b>

30°

Dies - R2 R3



**42Cr-900-1150 N/mm<sup>2</sup>** 400 kN/m max. **42Cr-900-1150 N/mm<sup>2</sup>** 500 kN/m max.

**WMRI00.12.30** **TMRI00.16.30**

100 mm	3.94 in	2.6 kg
500 mm	19.68 in	13.2 kg
250 mm	9.84 in	6.5 kg <b>FC</b>
550 mm	21.65 in	15.0 kg <b>FW</b>

30°

**42Cr-900-1150 N/mm<sup>2</sup>** 600 kN/m max. **42Cr-900-1150 N/mm<sup>2</sup>** 650 kN/m max.

**TMRI00.20.30** **TMRI00.24.30**

100 mm	3.94 in	3.0 kg
500 mm	19.68 in	14.8 kg
250 mm	9.84 in	7.4 kg <b>FC</b>
550 mm	21.65 in	16.2 kg <b>FW</b>

30°

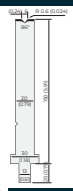


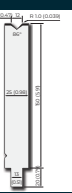
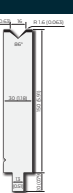

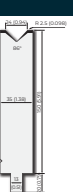

**42Cr-900-1150 N/mm<sup>2</sup>** 900 kN/m max. **42Cr-900-1150 N/mm<sup>2</sup>** 900 kN/m max.

**TMRI00.30.30** **TMRI00.40.30**

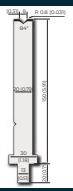
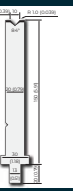




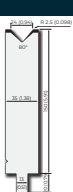

100 mm	3.94 in	3.8 kg
500 mm	19.68 in	19.0 kg
250 mm	9.84 in	9.5 kg <b>FC</b>
550 mm	21.65 in	21.0 kg <b>FW</b>

30°

R2 R3

42Cr-900-1150 N/mm <sup>2</sup>			400 kN/m max.	42Cr-900-1150 N/mm <sup>2</sup>			400 kN/m max.	
<b>TMR150.06.86</b>				<b>TMR150.08.86</b>				
100 mm	3.94 in	2.64 kg		100 mm	3.94 in	2.6 kg		
500 mm	19.68 in	13.1 kg		500 mm	19.68 in	13.1 kg		
250 mm	9.84 in	6.6 kg		250 mm	9.84 in	6.6 kg		
550 mm	21.65 in	14.3 kg	550 mm	21.65 in	14.4 kg	550 mm	21.65 in	14.3 kg
<b>42Cr-900-1150 N/mm<sup>2</sup></b>			500 kN/m max.	<b>42Cr-900-1150 N/mm<sup>2</sup></b>			500 kN/m max.	
<b>TMR150.10.86</b>				<b>TMR150.12.86</b>				
100 mm	3.94 in	2.6 kg		100 mm	3.94 in	3.1 kg		
500 mm	19.68 in	13.0 kg		500 mm	19.68 in	15.5 kg		
250 mm	9.84 in	6.5 kg		250 mm	9.84 in	7.8 kg		
550 mm	21.65 in	14.3 kg	550 mm	21.65 in	17.0 kg	550 mm	21.65 in	17.0 kg
<b>42Cr-900-1150 N/mm<sup>2</sup></b>			700 kN/m max.	<b>42Cr-900-1150 N/mm<sup>2</sup></b>			700 kN/m max.	
<b>TMR150.16.86</b>				<b>TMR150.20.86</b>				
100 mm	3.94 in	3.7 kg		100 mm	3.94 in	3.7 kg		
500 mm	19.68 in	18.4 kg		500 mm	19.68 in	18.3 kg		
250 mm	9.84 in	9.2 kg		250 mm	9.84 in	9.1 kg		
550 mm	21.65 in	20.2 kg	550 mm	21.65 in	20.0 kg	550 mm	21.65 in	20.0 kg
<b>42Cr-900-1150 N/mm<sup>2</sup></b>			700 kN/m max.	<b>42Cr-900-1150 N/mm<sup>2</sup></b>			400 kN/m max.	
<b>TMR150.24.86</b>				<b>TMR150.06.84</b>				
100 mm	3.94 in	4.2 kg		100 mm	3.94 in	2.6 kg		
500 mm	19.68 in	20.9 kg		500 mm	19.68 in	13.1 kg		
250 mm	9.84 in	10.5 kg		250 mm	9.84 in	6.6 kg		
550 mm	21.65 in	23.0 kg	550 mm	21.65 in	14.3 kg	550 mm	21.65 in	14.3 kg



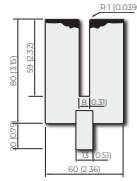
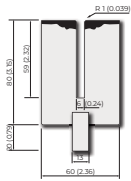
42Cr-900-1150 N/mm <sup>2</sup>			400 kN/m max.	42Cr-900-1150 N/mm <sup>2</sup>			500 kN/m max.	
<b>TMR150.08.84</b>				<b>TMR150.10.84</b>				
100 mm	3.94 in	2.6 kg		100 mm	3.94 in	2.6 kg		
500 mm	19.68 in	13.1 kg		500 mm	19.68 in	13.0 kg		
250 mm	9.84 in	6.6 kg		250 mm	9.84 in	6.5 kg		
550 mm	21.65 in	14.3 kg	550 mm	21.65 in	14.3 kg	550 mm	21.65 in	14.3 kg
<b>42Cr-900-1150 N/mm<sup>2</sup></b>			500 kN/m max.	<b>42Cr-900-1150 N/mm<sup>2</sup></b>			700 kN/m max.	
<b>TMR150.12.84</b>				<b>TMR150.16.84</b>				
100 mm	3.94 in	3.1 kg		100 mm	3.94 in	3.7 kg		
500 mm	19.68 in	15.5 kg		500 mm	19.68 in	18.4 kg		
250 mm	9.84 in	7.8 kg		250 mm	9.84 in	9.2 kg		
550 mm	21.65 in	17.0 kg	550 mm	21.65 in	20.2 kg	550 mm	21.65 in	20.2 kg
<b>42Cr-900-1150 N/mm<sup>2</sup></b>			700 kN/m max.	<b>42Cr-900-1150 N/mm<sup>2</sup></b>			700 kN/m max.	
<b>TMR150.20.84</b>				<b>TMR150.24.84</b>				
100 mm	3.94 in	3.7 kg		100 mm	3.94 in	4.2 kg		
500 mm	19.68 in	18.3 kg		500 mm	19.68 in	20.9 kg		
250 mm	9.84 in	9.1 kg		250 mm	9.84 in	10.4 kg		
550 mm	21.65 in	20.0 kg	550 mm	21.65 in	22.9 kg	550 mm	21.65 in	22.9 kg
<b>42Cr-900-1150 N/mm<sup>2</sup></b>			700 kN/m max.	<b>42Cr-900-1150 N/mm<sup>2</sup></b>			900 kN/m max.	
<b>TMR150.24.80</b>				<b>TMR150.30.80</b>				
100 mm	3.94 in	4.2 kg		100 mm	3.94 in	5.3 kg		
500 mm	19.68 in	20.9 kg		500 mm	19.68 in	26.3 kg		
250 mm	9.84 in	10.4 kg		250 mm	9.84 in	13.1 kg		
550 mm	21.65 in	22.9 kg	550 mm	21.65 in	28.9 kg	550 mm	21.65 in	28.9 kg



## Hemming Dies - R2 R3

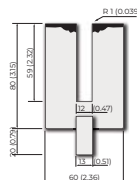
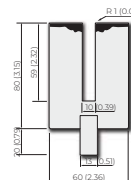
42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max - 1000 kN/m max.		
<b>BPR.SM.195.28.6</b>					
525 mm	20.67 in	12.0 kg	To use with:		
495 mm	19.49 in	11.0 kg	BPR.SP.195.28.6 (pag. 109)		

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max - 1000 kN/m max.		
<b>BPR.SM.195.28.8 - TPR.SM.195.28.8 - TPR.SM.195.24.8</b>					
525 mm	20.67 in	12.0 kg	To use with:		
495 mm	19.49 in	11.0 kg	BPR.SP.195.28.8 (pag. 109)		
			TPR.SP.195.28.8 (pag. 98)		
			TPR.SP.195.24.8 (pag. 98)		

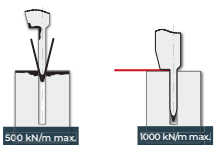


42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max - 1000 kN/m max.		
<b>BPR.SM.195.24.10 - TPR.SM.195.24.10</b>					
525 mm	20.67 in	12.0 kg	To use with:		
495 mm	19.49 in	11.0 kg	BPR.SP.195.24.10 (pag. 109)		
			TPR.SP.195.24.10 (pag. 98)		

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max - 1000 kN/m max.		
<b>BPR.SM.195.24.12 - TPR.SM.195.24.12</b>					
525 mm	20.67 in	12.0 kg	To use with:		
495 mm	19.49 in	11.0 kg	BPR.SP.195.24.12 (pag. 109)		
			TPR.SP.195.24.12 (pag. 98)		



Ex. of application

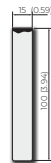


R 420				R 700			
S	A	A	R	S	A	A	R
[mm]	[in]	[mm]	[in]	[mm]	[in]	[mm]	[in]
0.6	0.02	3.0	0.12	90	3.54	1.2	0.05
0.8	0.03	3.0	0.12	120	4.72	1.6	0.06
1.0	0.04	3.5	0.14	150	5.91	2.0	0.08
1.25	0.05	3.5	0.14	170	6.70	2.5	0.10

## Hemming dies for movable table - R2 R3

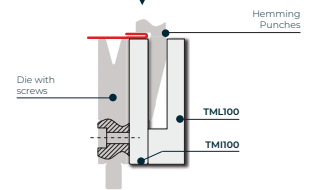
For press brakes with movable table

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>TMI100</b>					
100 mm	3.94 in	1.0 kg			
500 mm	19.68 in	5.0 kg			
250 mm	9.84 in	2.5 kg	FC		
550 mm	21.65 in	5.5 kg	FX		



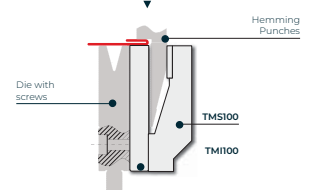
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>TMI100</b>					
100 mm	3.94 in	1.0 kg			
500 mm	19.68 in	5.0 kg			
250 mm	9.84 in	2.5 kg	FC		
550 mm	21.65 in	5.5 kg	FX		

TMI100 + TMI100 Example of application



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>TMS100</b>					
100 mm	3.94 in	1.0 kg			
500 mm	19.68 in	5.0 kg			
250 mm	9.84 in	2.5 kg	FC		
550 mm	21.65 in	5.5 kg	FX		

TMI100 + TMS100 Example of application





## PUNCHES ROLLERI TYPE R4

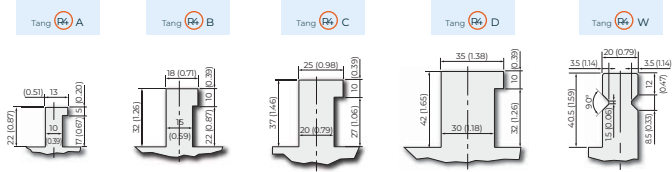
### ▼ COMPATIBILITY

LVD

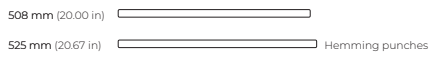
<b>Content Explanation</b>	146 - 147
<b>CLASSIC Series</b>	
<b>Punches</b>	148 - 149
78°	148
26°	149
<b>W Series</b>	
<b>Punches</b>	150 - 151
78°	150
26°	151
<b>NEW W Series</b>	
<b>Punches</b>	152 - 155
78°	152 - 154
26°	153 - 155
<b>Hemming Tools</b>	156

Content Explanation - 

STANDARD TANG



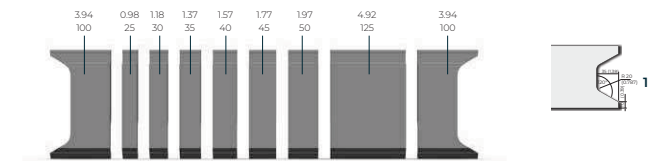
STANDARD LENGTH



Content Explanation - 

SEGMENTED

Punches

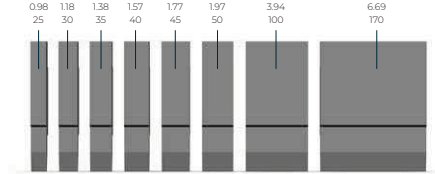


500 mm (21.65 in) - 2 segments

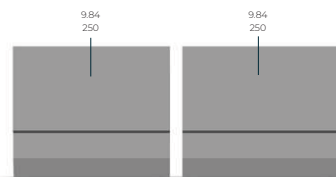


Hemming punches

495 mm (19.49 in) - 8 segments



500 mm (21.65 in) - 2 segments



Punches - CLASSIC Series and W Series

42Cr: 900-1150 N/mm <sup>2</sup>			700 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			450 kN/m max.		
<b>LP180.78.R1-A</b>						<b>LP180.78.R1-B</b>					
508 mm	20.00 in	22.0 kg	CLASSIC Series			508 mm	20.00 in	22.0 kg	CLASSIC Series		
550 mm	21.65 in	23.8 kg	Tang A: LP180.78.R1-A			550 mm	21.65 in	24.0 kg	Tang A: LP180.78.R1-B		
2x250 mm	2x9.84 in	21.7 kg	Tang B: LP180.78.R1-A			2x250 mm	2x9.84 in	21.7 kg	Tang B: LP180.78.R1-B		
			Tang C: LPC180.78.R1-A						Tang C: LPC180.78.R1-B		
			Tang D: LPO180.78.R1-A						Tang D: LPO180.78.R1-B		
508 mm	20.00 in	22.0 kg	W Series			508 mm	20.00 in	22.0 kg	W Series		
550 mm	21.65 in	23.8 kg	Tang W: LPW180.78.R1-A			550 mm	21.65 in	23.8 kg	Tang W: LPW180.78.R1-B		
2x250 mm	2x9.84 in	21.7 kg				2x250 mm	2x9.84 in	21.7 kg			

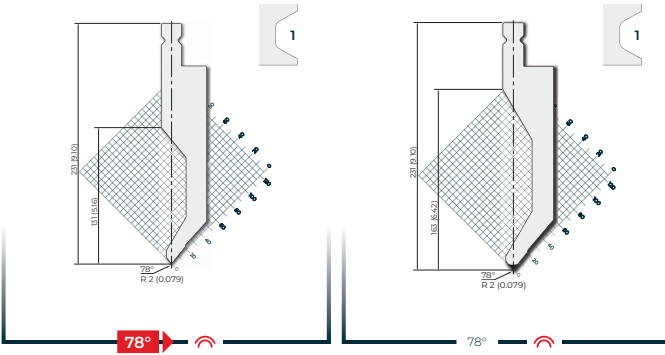
42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.		
<b>LP180.78.R1-C</b>						<b>LP180.78.R2</b>					
508 mm	20.00 in	11.0 kg	CLASSIC Series			508 mm	20.00 in	9.0 kg	CLASSIC Series		
550 mm	21.65 in	12.0 kg	Tang A: LP180.78.R1-C			550 mm	21.65 in	9.7 kg	Tang A: LP180.78.R2		
2x250 mm	2x9.84 in	10.0 kg	Tang B: LP180.78.R1-C			2x250 mm	2x9.84 in	8.9 kg	Tang B: LP180.78.R2		
			Tang C: LPC180.78.R1-C						Tang C: LPC180.78.R2		
			Tang D: LPO180.78.R1-C						Tang D: LPO180.78.R2		
508 mm	20.00 in	22.0 kg	W Series			508 mm	20.00 in	22.0 kg	W Series		
550 mm	21.65 in	23.8 kg	Tang W: LPW180.78.R1-C			550 mm	21.65 in	23.8 kg	Tang W: LPW180.78.R2		
2x250 mm	2x9.84 in	21.7 kg				2x250 mm	2x9.84 in	21.7 kg			

Punches - CLASSIC Series and W Series

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			400 kN/m max.		
<b>LP180.26-R1</b>						<b>LP180.26.R1-A</b>					
508 mm	20.00 in	9.0 kg	CLASSIC Series			508 mm	20.00 in	12.5 kg	CLASSIC Series		
550 mm	21.65 in	10.0 kg	Tang A: LP180.26.R1			550 mm	21.65 in	13.5 kg	Tang A: LP180.26.R1-A		
2x250 mm	2x9.84 in	8.9 kg	Tang B: LP180.26.R1			2x250 mm	2x9.84 in	12.3 kg	Tang B: LP180.26.R1-A		
			Tang C: LPC180.26.R1						Tang C: LPC180.26.R1-A		
			Tang D: LPO180.26.R1						Tang D: LPO180.26.R1-A		
508 mm	20.00 in	9.0 kg	W Series			508 mm	20.00 in	12.5 kg	W Series		
550 mm	21.65 in	10.0 kg	Tang W: LPW180.26.R1			550 mm	21.65 in	13.5 kg	Tang W: LPW180.26.R1-A		
2x250 mm	2x9.84 in	8.9 kg				2x250 mm	2x9.84 in	12.3 kg			

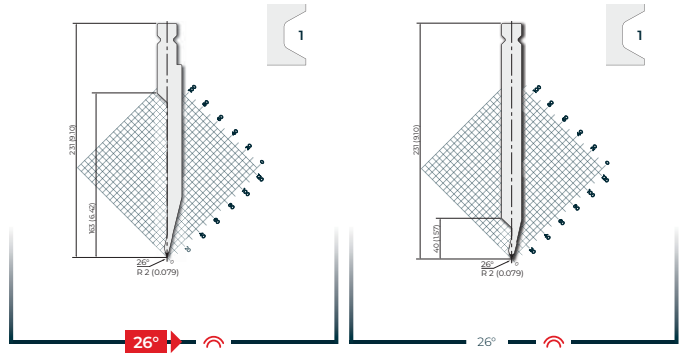
Punches -  W Series

42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			750 kN/m max.
<b>LPW231.78.R2-A</b>							
508 mm	20.00 in	276 kg		508 mm	20.00 in	23.4 kg	
550 mm	21.65 in	299 kg	F	550 mm	21.65 in	25.4 kg	F
2x250 mm	2x9.84 in	272 kg	FC	2x250 mm	2x9.84 in	231 kg	FC

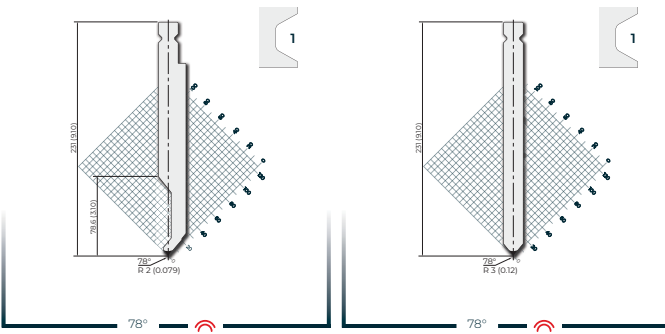


Punches -  W Series

42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.
<b>LPW231.26.R2-A</b>							
508 mm	20.00 in	9.0 kg		508 mm	20.00 in	16.3 kg	
550 mm	21.65 in	10.0 kg	F	550 mm	21.65 in	17.6 kg	F
2x250 mm	2x9.84 in	8.9 kg	FC	2x250 mm	2x9.84 in	16.0 kg	FC



42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
<b>LPW231.78.R2-C</b>							
508 mm	20.00 in	191 kg		508 mm	20.00 in	18.3 kg	
550 mm	21.65 in	207 kg	F	550 mm	21.65 in	19.8 kg	F
2x250 mm	2x9.84 in	18.8 kg	FC	2x250 mm	2x9.84 in	18.0 kg	FC





Punches - **NEW W Series**

42Cr: 900-1150 N/mm<sup>2</sup> 400 kN/m max.

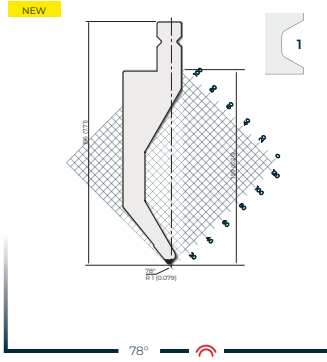
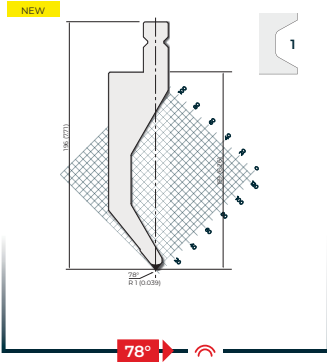
**LPW196.D10-R1**

510 mm	20.07 in.	16.3 kg	F
550 mm	21.65 in.	17.6 kg	F
2x250 mm	2x9.84 in.	16.0 kg	FC

42Cr: 900-1150 N/mm<sup>2</sup> 750 kN/m max.

**LPW196.D10-R2**

510 mm	20.07 in.	17.7 kg	F
550 mm	21.65 in.	19.1 kg	F
2x250 mm	2x9.84 in.	17.4 kg	FC



Punches - **NEW W Series**



42Cr: 900-1150 N/mm<sup>2</sup> 400 kN/m max.

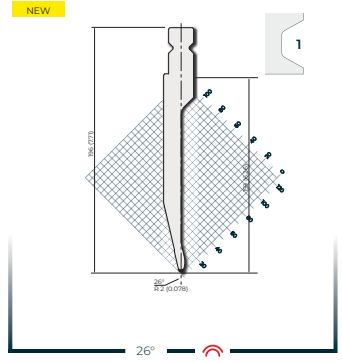
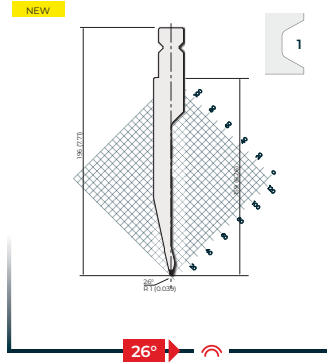
**LPW196.J10-R1**

510 mm	20.07 in.	8.8 kg	F
550 mm	21.65 in.	9.4 kg	F
2x250 mm	2x9.84 in.	8.6 kg	FC

42Cr: 900-1150 N/mm<sup>2</sup> 600 kN/m max.

**LPW196.J10-R2**

510 mm	20.07 in.	11.4 kg	F
550 mm	21.65 in.	12.3 kg	F
2x250 mm	2x9.84 in.	11.2 kg	FC



42Cr: 900-1150 N/mm<sup>2</sup> 400 kN/m max.

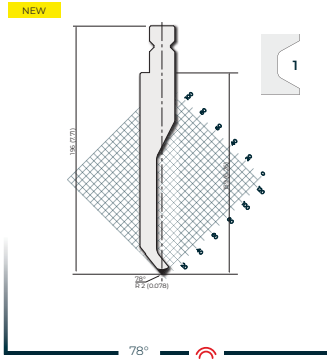
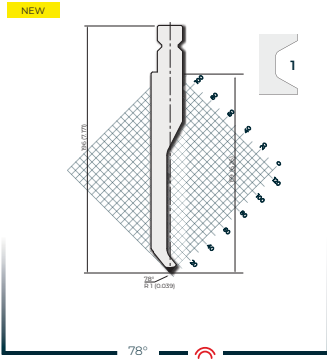
**LPW196.E10-R1**

510 mm	20.07 in.	12.9 kg	F
550 mm	21.65 in.	14.0 kg	F
2x250 mm	2x9.84 in.	12.7 kg	FC

42Cr: 900-1150 N/mm<sup>2</sup> 680 kN/m max.

**LPW196.E10-R2**

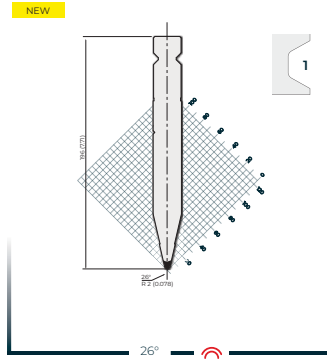
510 mm	20.07 in.	13.7 kg	F
550 mm	21.65 in.	14.9 kg	F
2x250 mm	2x9.84 in.	13.5 kg	FC



42Cr: 900-1150 N/mm<sup>2</sup> 800 kN/m max.



**LPW196.R10-R2**

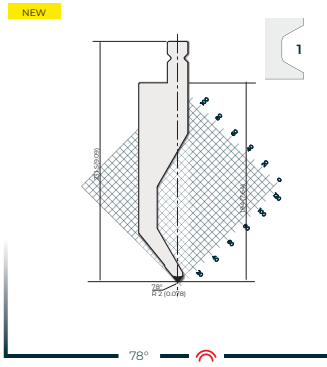
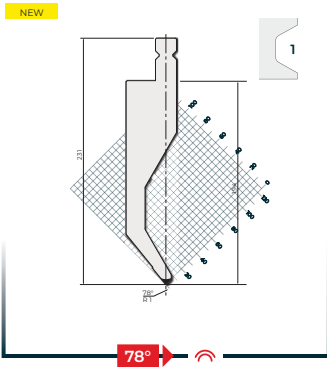
510 mm	20.07 in.	9.0 kg	F
550 mm	21.65 in.	9.8 kg	F
2x250 mm	2x9.84 in.	8.8 kg	FC





Punches -  NEW W Series

42Cr: 900-1150 N/mm <sup>2</sup>			400 kN/m max.
LPW231.D15-R1			
510 mm	20.07 in.	20.1 kg	 
550 mm	21.65 in.	21.7 kg	
2x250 mm	2x9.84 in.	19.8 kg	

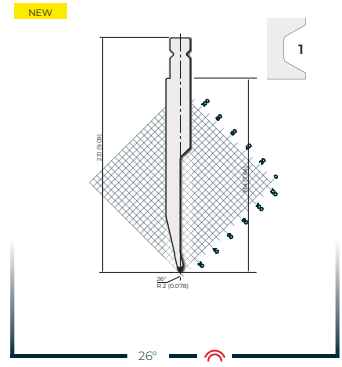
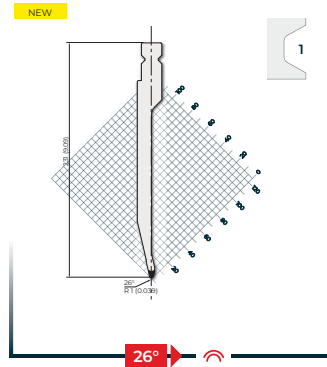
42Cr: 900-1150 N/mm <sup>2</sup>			750 kN/m max.
LPW231.D15-R2			
510 mm	20.07 in.	21.9 kg	 
550 mm	21.65 in.	23.7 kg	
2x250 mm	2x9.84 in.	21.4 kg	



Punches -  NEW W Series

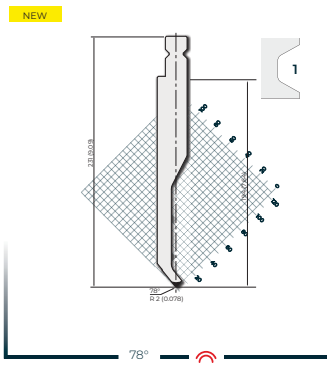
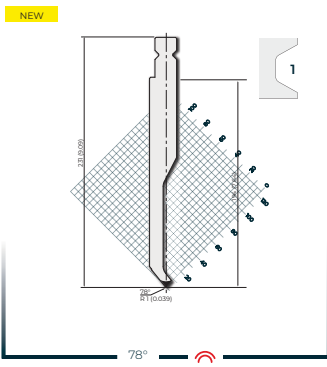
42Cr: 900-1150 N/mm <sup>2</sup>			400 kN/m max.
LPW231.J15-R1			
510 mm	20.07 in.	13.3 kg	 
550 mm	21.65 in.	14.5 kg	
2x250 mm	2x9.84 in.	13.1 kg	


42Cr: 900-1150 N/mm <sup>2</sup>			600 kN/m max.
LPW231.J15-R2			
510 mm	20.07 in.	12.2 kg	 
550 mm	21.65 in.	13.2 kg	
2x250 mm	2x9.84 in.	12.0 kg	

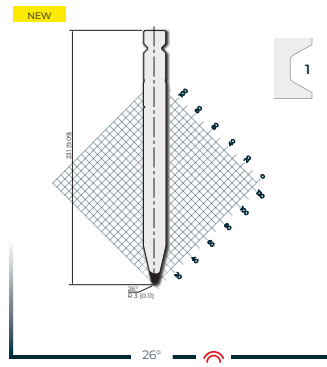


42Cr: 900-1150 N/mm <sup>2</sup>			400 kN/m max.
LPW231.E15-R1			
510 mm	20.07 in.	16.5 kg	 
550 mm	21.65 in.	17.9 kg	
2x250 mm	2x9.84 in.	16.3 kg	

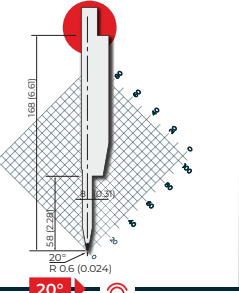
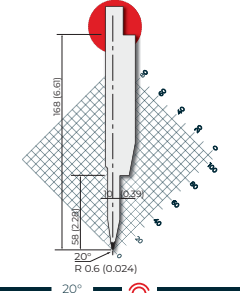
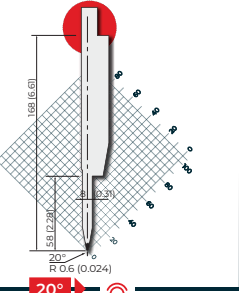
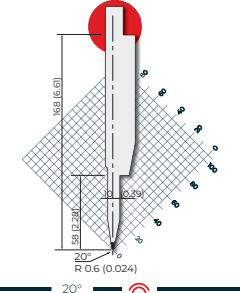
42Cr: 900-1150 N/mm <sup>2</sup>			680 kN/m max.
LPW231.E15-R2			
510 mm	20.07 in.	17.6 kg	 
550 mm	21.65 in.	19.0 kg	
2x250 mm	2x9.84 in.	17.4 kg	



42Cr: 900-1150 N/mm <sup>2</sup>			1200 kN/m max.
LPW231.R15-R3			
510 mm	20.07 in.	16.3 kg	 
550 mm	21.65 in.	17.6 kg	
2x250 mm	2x9.84 in.	16.0 kg	

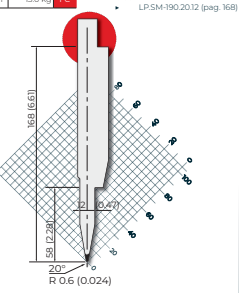
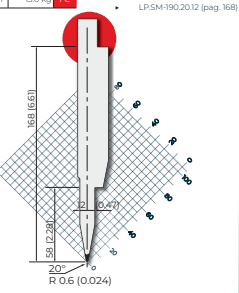


## Hemming Tools -

42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max - 1000 kN/m max			42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max - 1000 kN/m max		
LP.SP-190.20.8						LP.SP-190.20.10					
525 mm	20.67 in	13.4 kg		<b>CLASSIC Series</b>		525 mm	20.67 in	13.1 kg		<b>CLASSIC Series</b>	
495 mm	19.49 in	12.6 kg		Tang A LP.SP-190.20.8	Tang B LP.SP-190.20.10	495 mm	19.49 in	12.3 kg		Tang A LP.SP-190.20.10	Tang B LP.SP-190.20.10
2x250 mm	2x9.84 in	12.8 kg		Tang C LP.SP-190.20.8	Tang C LP.SP-190.20.10	2x250 mm	2x9.84 in	12.5 kg		Tang C LP.SP-190.20.10	Tang D LP.SP-190.20.10
				Tang D LP.SP-190.20.8						Tang D LP.SP-190.20.10	
525 mm	20.67 in	13.4 kg		<b>W Series</b>		525 mm	20.67 in	13.1 kg		<b>W Series</b>	
495 mm	19.49 in	12.6 kg		Tang W LP.W.SP-190.20.8		495 mm	19.49 in	12.3 kg		Tang W LP.W.SP-190.20.10	
2x250 mm	2x9.84 in	12.8 kg				2x250 mm	2x9.84 in	12.5 kg			


To use with:  
• LP.SM-190.20.8 (pag. 168)

To use with:  
• LP.SM-190.20.10 (pag. 168)

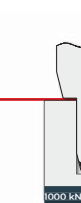
42Cr: 900-1150 N/mm <sup>2</sup>			800 kN/m max - 1000 kN/m max		
LP.SP-190.20.12					
525 mm	20.67 in	13.6 kg		<b>CLASSIC Series</b>	
495 mm	19.49 in	12.8 kg		Tang A LP.SP-190.20.12	
2x250 mm	2x9.84 in	13.0 kg		Tang B LP.SP-190.20.12	
				Tang C LP.SP-190.20.12	
525 mm	20.67 in	13.6 kg		<b>W Series</b>	
495 mm	19.49 in	12.8 kg		Tang W LP.W.SP-190.20.12	
2x250 mm	2x9.84 in	13.0 kg			

To use with:  
• LP.SM-190.20.12 (pag. 168)

**Example of Application**



800 kN/m max.



1000 kN/m max.

S	S	A	A	R420	R700	S	S	A	A	R420	R700
[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>	[mm]	[in]	[mm]	[in]	N/mm <sup>2</sup>	N/mm <sup>2</sup>
0.6	0.02	3.0	0.12	90	150	0.6	0.02	1.2	0.05	230	350
0.8	0.03	3.0	0.12	120	200	0.8	0.03	1.6	0.06	320	500
1.0	0.04	3.5	0.14	150	250	1.0	0.04	1.0	0.04	400	600
1.25	0.05	3.5	0.14	170	260	1.25	0.05	2.5	0.10	500	800



R4



## DIES ROLLERI TYPE R4

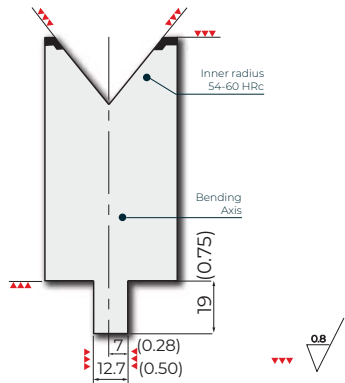
### ▼ COMPATIBILITY

LVD

<b>Content Explanation</b>	160 - 161
<b>Dies</b>	162 - 163
78°, H=90	162
78°, H=130	163
60°, H=130	164
30°, H=90	165
30°, H=130	166
<b>Multi-V Dies</b>	167
<b>Hemming dies</b>	168

Content Explanation - 

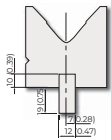
STANDARD TANG



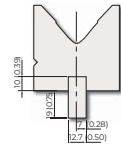
MODIFICATIONS FROM SAFETY GROOVES

To use Rolleri Type R1 dies, a 10 mm groove is milled where a ground bar is mounted.

A31



A32



STANDARD LENGTH

► Dies

508 mm (20.00 in)

► Hemming Dies

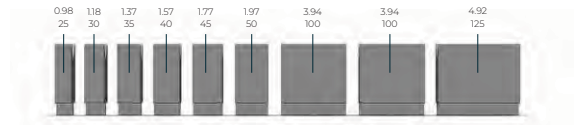
525 mm (20.67 in)

Content Explanation - 

SEGMENTATION

► Dies

550 mm (21.65 in) - 9 segments

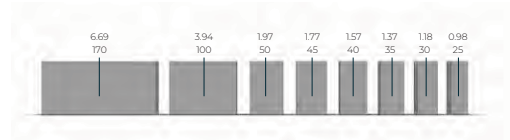


500 mm (19.68 in) - 2 segments



► Hemming dies

495 mm (19.48 in) - 8 segments



500 mm (19.68 in) - 2 segments



Dies - 

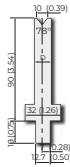
42Cr: 900-1150 N/mm<sup>2</sup>

See table

H=90 mm / 3.54 in

	V	V	R	R	D	D	KN/m	F	FC	
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.			
LM90.06.78	6	0.23	1.0	0.03	12	0.47	400	8.0 kg	8.6 kg	7.9 kg
LM90.08.78	8	0.31	1.0	0.03	12	0.47	400	8.0 kg	8.6 kg	7.9 kg
LM90.10.78	10	0.39	1.0	0.03	14	0.55	500	8.0 kg	8.6 kg	7.9 kg
LM90.12.78	12	0.47	2.0	0.07	18	0.70	600	8.0 kg	8.6 kg	7.9 kg
LM90.16.78	16	0.62	2.5	0.09	25	0.98	800	10.0 kg	10.8 kg	9.9 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



78° 

Dies - 

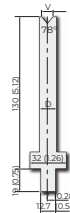
42Cr: 900-1150 N/mm<sup>2</sup>

See table

H=130 mm / 5.11 in

	V	V	R	R	D	D	KN/m	F	FC	
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.			
LM130.06.78	6	0.23	1.0	0.03	12	0.47	400	8.3 kg	9.0 kg	8.2 kg
LM130.08.78	8	0.31	1.0	0.03	12	0.47	400	8.4 kg	9.1 kg	8.3 kg
LM130.10.78	10	0.39	1.0	0.03	14	0.55	500	10.1 kg	11.0 kg	10.0 kg
LM130.12.78	12	0.47	2.0	0.07	18	0.70	600	11.1 kg	12.0 kg	10.9 kg
LM130.16.78	16	0.62	2.5	0.09	25	0.98	800	14.3 kg	15.5 kg	14.1 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



78° 

42Cr: 900-1150 N/mm<sup>2</sup>

See table

H=90 mm / 3.54 in

	V	V	R	R	D	D	KN/m	F	FC	
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.			
LM90.20.78	20	0.70	3.0	0.11	32	1.25	1000	119 kg	12.8 kg	11.8 kg
LM90.24.78	24	0.94	3.0	0.11	32	1.25	1000	10.0 kg	10.8 kg	9.9 kg
LM90.30.78	30	1.18	3.0	0.11	40	1.57	1100	12.0 kg	13.0 kg	11.8 kg
LM90.40.78	40	1.57	4.0	0.15	50	1.96	1300	13.0 kg	14.0 kg	12.8 kg
LM90.50.78	50	1.96	4.0	0.15	60	2.36	1500	19.5 kg	21.0 kg	19.2 kg
LM90.60.78	60	2.36	5.0	0.19	70	2.75	1500	23.0 kg	24.9 kg	22.7 kg
LM90.80.78	80	3.14	5.0	0.19	90	3.54	1500	25.5 kg	27.6 kg	25.1 kg
LM90.100.78	100	3.93	8.0	0.31	120	4.72	1200	31.0 kg	33.5 kg	30.6 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



78° 

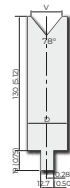
42Cr: 900-1150 N/mm<sup>2</sup>

See table

H=130 mm / 5.11 in

	V	V	R	R	D	D	KN/m	F	FC	
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.			
LM130.20.78	20	0.78	3.0	0.11	32	1.25	1000	175 kg	19.0 kg	17.2 kg
LM130.24.78	24	0.94	3.0	0.11	32	1.25	1000	17.0 kg	18.5 kg	16.8 kg
LM130.30.78	30	1.18	3.0	0.11	40	1.57	1100	20.7 kg	22.4 kg	20.4 kg
LM130.40.78	40	1.57	4.0	0.15	50	1.96	1300	26.6 kg	28.9 kg	26.2 kg
LM130.50.78	50	1.96	4.0	0.15	60	2.36	1500	34.2 kg	37.0 kg	33.6 kg
LM130.60.78	60	2.36	5.0	0.19	70	2.75	1500	34.2 kg	37.0 kg	33.6 kg
LM130.80.78	80	3.14	5.0	0.19	90	3.54	1500	42.3 kg	45.8 kg	41.6 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



78° 

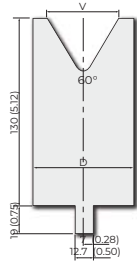
Dies - 

42Cr- 900-1150 N/mm<sup>2</sup>

See table

H=130 mm / 5.11 in										
V	V	R	R	D	D	kn/m	F	FC		
[mm]	[in]	[mm]	[in]	[mm]	[in]	max.				
LM1303060	30	1.18	3.0	0.11	40	157	500	20.4 kg	22.1 kg	20.1 kg
LM1304060	40	1.57	5.0	0.19	55	236	660	26.8 kg	29.1 kg	26.4 kg
LM1305060	50	1.96	5.0	0.19	70	275	1050	33.0 kg	35.7 kg	32.5 kg
LM1306060	60	2.36	7.0	0.27	80	314	1200	36.5 kg	39.6 kg	36.0 kg
LM1308060	80	3.14	8.0	0.31	102	4.01	1750	43.0 kg	46.6 kg	42.4 kg
LM13010060	100	3.93	8.0	0.31	130	4.72	1600	47.6 kg	51.5 kg	46.8 kg
LM13012060	120	4.72	8.0	0.31	145	5.70	1300	51.0 kg	55.2 kg	50.2 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



60° 



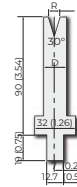
Dies - 

42Cr- 900-1150 N/mm<sup>2</sup>

See table

H=90 mm / 3.54 in										
V	V	R	R	D	D	kn/m	F	FC		
[mm]	[in]	[mm]	[in]	[mm]	[in]	max.				
LM900630	6	0.23	0.8	0.03	16	0.62	200	8.0 kg	8.6 kg	7.9 kg
LM900830	8	0.31	1.0	0.03	18	0.70	220	8.0 kg	8.6 kg	7.9 kg
LM901030	10	0.39	1.2	0.07	25	0.98	300	8.0 kg	8.6 kg	7.9 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



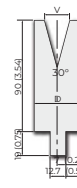
30° 

42Cr- 900-1150 N/mm<sup>2</sup>

See table

H=90 mm / 3.54 in										
V	V	R	R	D	D	kn/m	F	FC		
[mm]	[in]	[mm]	[in]	[mm]	[in]	max.				
LM901230	12	0.47	1.2	0.04	32	1.25	380	11.9 kg	12.6 kg	11.8 kg
LM901630	16	0.62	3.0	0.11	32	1.25	380	11.5 kg	12.4 kg	11.4 kg
LM902030	20	0.78	3.0	0.11	40	1.57	380	13.8 kg	15.0 kg	13.6 kg
LM902430	24	0.94	3.0	0.11	50	1.96	550	13.0 kg	14.0 kg	12.8 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



30° 

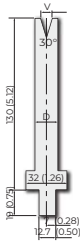
Dies - 

42Cr: 900-1150 N/mm<sup>2</sup> See table

**H=130 mm / 5.11 in**

	V	V	R	R	D	D	KN/m <sup>2</sup>	F	FS	
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.			
LM130.06.30	6	0.23	0.8	0.03	16	0.62	200	10.0 kg	10.8 kg	9.8 kg
LM130.08.30	8	0.31	1.0	0.03	18	0.70	220	10.9 kg	11.8 kg	10.7 kg
LM130.10.30	10	0.39	1.2	0.04	25	0.98	300	14.0 kg	15.1 kg	13.8 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



Multi-V Dies - 



42Cr: 900-1150 N/mm<sup>2</sup>

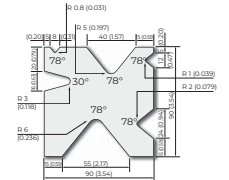
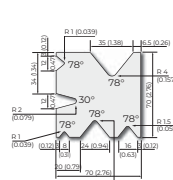
**LM70**

	V	V	R	R	D	D	KN/m <sup>2</sup>	F	FS
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.		
508 mm	20000	20000	16.8 kg						
550 mm	21.65 in	21.65 in	18.2 kg						

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90**

	V	V	R	R	D	D	KN/m <sup>2</sup>	F	FS
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.		
508 mm	20000	20000	25.4 kg						
550 mm	21.65 in	21.65 in	27.5 kg						

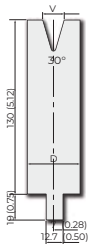


42Cr: 900-1150 N/mm<sup>2</sup> See table

**H=130 mm / 5.11 in**

	V	V	R	R	D	D	KN/m <sup>2</sup>	F	FS	
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.			
LM130.12.30	12	0.47	2.0	0.07	32	1.25	380	17.1 kg	18.5 kg	16.9 kg
LM130.16.30	16	0.62	3.0	0.11	32	1.25	380	20.8 kg	22.6 kg	20.5 kg
LM130.30.30	20	0.78	3.0	0.11	40	4.57	380	20.3 kg	22.0 kg	20.0 kg
LM130.34.30	24	0.94	3.0	0.11	50	1.96	550	24.4 kg	26.4 kg	24.0 kg

Available also 510 mm length and 550 mm sectioning  
(20,20,25,25,30,35,40,40,45,75,75,120)



42Cr: 900-1150 N/mm<sup>2</sup>

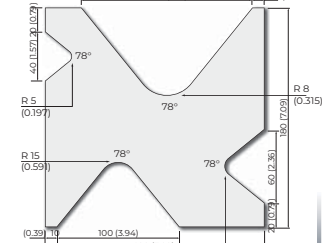
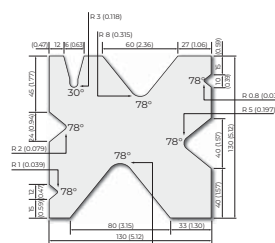
**LM130**

	V	V	R	R	D	D	KN/m <sup>2</sup>	F	FS
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.		
508 mm	20000	20000	51.8 kg						
550 mm	21.65 in	21.65 in	56.1 kg						

42Cr: 900-1150 N/mm<sup>2</sup>

**LM180**

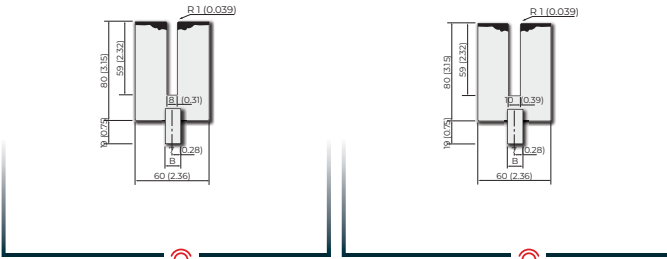
	V	V	R	R	D	D	KN/m <sup>2</sup>	F	FS
	[mm]	[in]	[mm]	[in]	[mm]	[in]	max.		
508 mm	20000	20000	25.4 kg						
550 mm	21.65 in	21.65 in	27.5 kg						



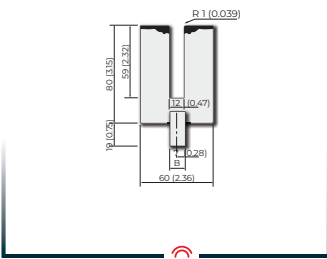


## Hemming Tools -

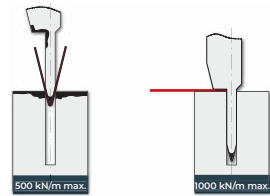
42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max - 1000 kN/m max			42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max - 1000 kN/m max		
LP.SM-190.20.8-12.7 / -12						LP.SM-190.20.10-12.7 / -12					
525 mm	20.67 in	18.7 kg	F	B=12.7 mm		525 mm	20.67 in	18.3 kg	F	B=12.7 mm	
495 mm	19.49 in	17.7 kg	FC			495 mm	19.49 in	17.2 kg	F		
2x250 mm	2x9.84 in	17.8 kg	FC			2x250 mm	2x9.84 in	17.4 kg	FC		
To use with: LP.SP-190.20.8 (pag. 156)											
525 mm	20.67 in	18.7 kg	F	B=32 mm		525 mm	20.67 in	18.3 kg	F	B=32 mm	
495 mm	19.49 in	17.7 kg	FC			495 mm	19.49 in	17.2 kg	F		
2x250 mm	2x9.84 in	17.8 kg	FC			2x250 mm	2x9.84 in	17.4 kg	FC		
To use with: LP.SP-190.20.10 (pag. 156)											



42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max - 1000 kN/m max		
LP.SM-190.20.12-12.7 / -12					
525 mm	20.67 in	13.6 kg	F	B=12.7 mm	
495 mm	19.49 in	12.8 kg	FC		
2x250 mm	2x9.84 in	13.0 kg	FC		
To use with: LP.SP-190.20.12 (pag. 156)					
525 mm	20.67 in	13.6 kg	F	B=32 mm	
495 mm	19.49 in	12.8 kg	FC		
2x250 mm	2x9.84 in	13.0 kg	FC		



### Example of Application



S (mm)	S (in)	A (mm)	A (in)	R-420	R-700	S (mm)	S (in)	A (mm)	A (in)	R-420	R-700
				N/mm <sup>2</sup>	N/mm <sup>2</sup>					N/mm <sup>2</sup>	N/mm <sup>2</sup>
0.6	0.02	3.0	0.11	90	150	0.6	0.02	1.2	0.04	230	350
0.8	0.03	3.0	0.11	120	200	0.8	0.03	1.6	0.06	320	500
1.0	0.03	3.5	0.13	150	250	1.0	0.03	1.0	0.03	400	600
1.25	0.04	3.5	0.13	170	260	1.25	0.04	2.5	0.09	500	800














R4



## ROLLERI TOOLS TYPE RX

### ▼ COMPATIBILITY

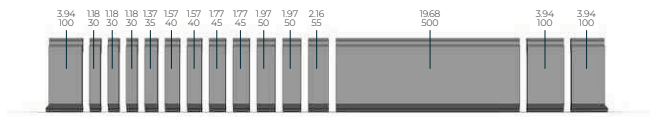
American  
 Ajial-Axial  
 Colly  
 Colgar  
 EHT  
 Gasparini  
 Hämmerle - Bystronic  
 Ursviken  
 Weinbrenner

<b>Colly</b>	
<b>Compatible tools</b>  <b>Colly</b>	172 - 180
Punches	172 - 176
Dies	177 - 180
<b>Ajial-Axial</b>	
<b>Compatible tools</b>  <b>Ajial-Axial</b>	181 - 182
Punches	181
<b>Gasparini</b>	
<b>Compatible tools</b>  <b>Gasparini</b>	183 - 186
Radius Tool Holders	184 - 185
Punches	186
<b>Colgar</b>	
<b>Compatible tools</b>  <b>Colgar</b>	187 - 188
Punches	188
<b>Ursviken</b>	
<b>Compatible tools</b>  <b>Ursviken</b>	189
Punches	189
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<b>EHT</b>	
<b>Compatible tools</b>  <b>EHT</b>	190
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<b>Weinbrenner</b>	
<b>Compatible tools</b>  <b>Weinbrenner</b>	191
Content Explanation	191
<b>American</b>	REQUEST  ROLLERI COMPLETE CATALOGUE
<b>Compatible tools</b>  <b>American</b>	
<b>Hämmerle - Bystronic</b>	REQUEST  ROLLERI COMPLETE CATALOGUE
<b>Compatible tools</b>  <b>Hämmerle-Bystronic</b>	

STANDARD LENGTH AND SEGMENTED

1020 mm (40.16 in) 

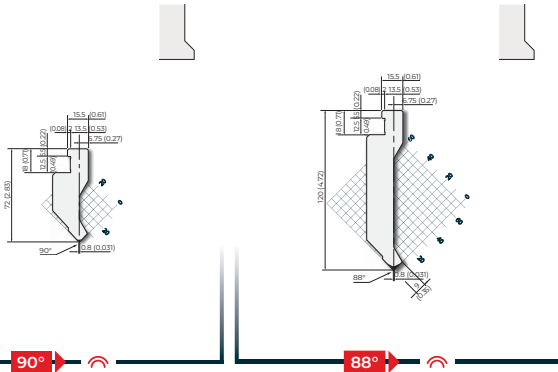
Total Length 1250 mm (49.21 in)



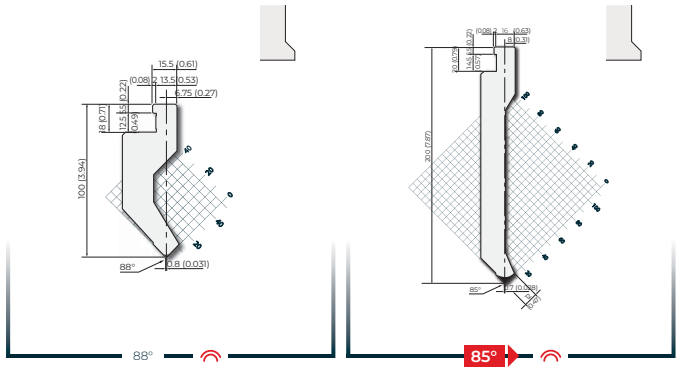
Horn types



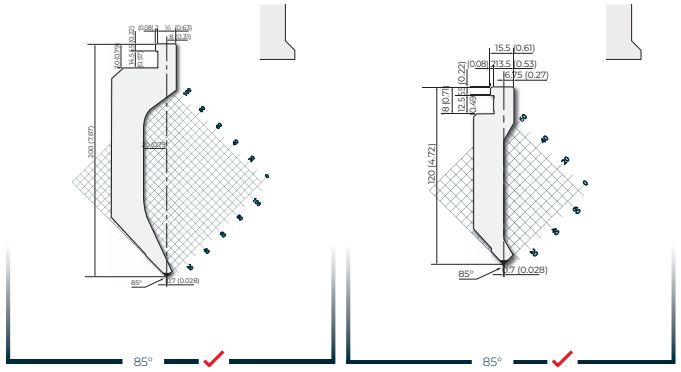
C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.
<b>CP72.90.08</b>				<b>CP120.88.08</b>			
1020 mm	40.16 in	10.2 kg		1020 mm	40.16 in	18.5 kg	
1250 mm	49.21 in	12.5 kg		1250 mm	49.21 in	22.6 kg	





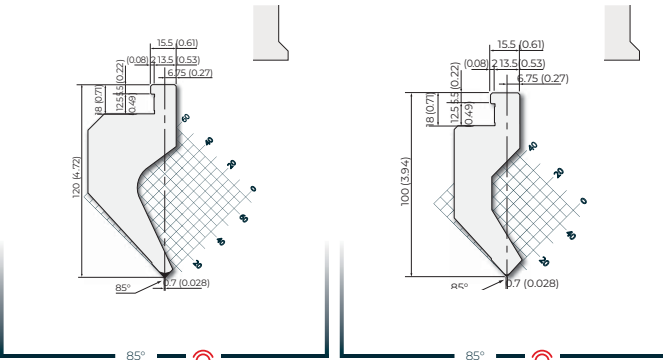
42Cr: 900-1150 N/mm <sup>2</sup>			500 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
<b>CP100.88.08-A</b>				<b>CP200.85.07</b>			
1020 mm	40.16 in	16.7 kg		1020 mm	40.16 in	31.6 kg	
1250 mm	49.21 in	20.4 kg		1250 mm	49.21 in	39.0 kg	



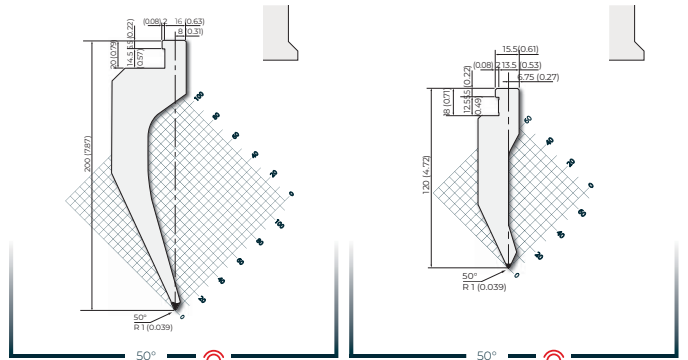
42Cr: 900-1150 N/mm <sup>2</sup>			750 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.
<b>CP200.85.07-A</b>				<b>CP120.85.07</b>			
1020 mm	40.16 in	49.0 kg		1020 mm	40.16 in	17.9 kg	
1250 mm	49.21 in	60.0 kg		1250 mm	49.21 in	21.9 kg	





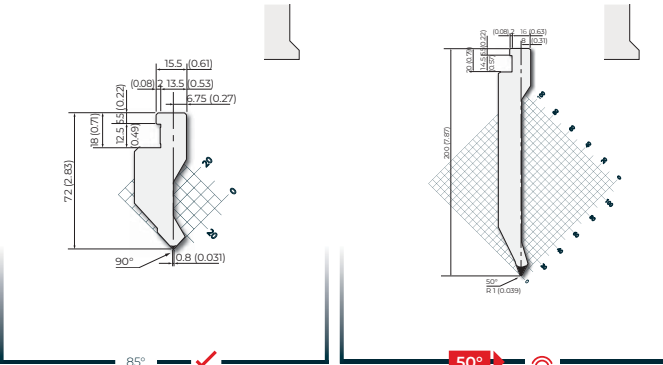
C45: 560-710 N/mm <sup>2</sup>			450 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			500 kN/m max.
<b>CP120.85.07-A</b>							
1020 mm	40.16 in	25.5 kg		1020 mm	40.16 in	17.0 kg	
1250 mm	49.21 in	49.0 kg		1250 mm	49.21 in	49.0 kg	



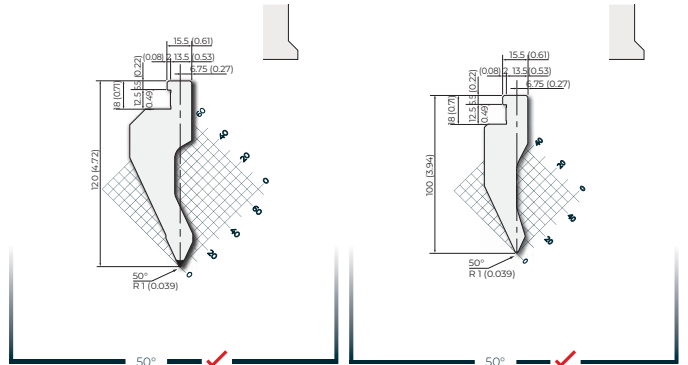
42Cr: 900-1150 N/mm <sup>2</sup>			550 kN/m max.	C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>CP200.50.R1-A</b>							
1020 mm	40.16 in	52.0 kg		1020 mm	40.16 in	17.0 kg	
1250 mm	49.21 in	47.0 kg		1250 mm	49.21 in	38.0 kg	



C45: 560-710 N/mm <sup>2</sup>			700 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
<b>CP72.85.07</b>							
1020 mm	40.16 in	10.0 kg		1020 mm	40.16 in	49.0 kg	
1250 mm	49.21 in	49.0 kg		1250 mm	49.21 in	38.0 kg	

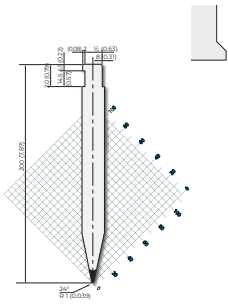


42Cr: 900-1150 N/mm <sup>2</sup>			550 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.
<b>CP120.50.R1-A</b>							
1020 mm	40.16 in	21.0 kg		1020 mm	40.16 in	13.0 kg	
1250 mm	49.21 in	38.0 kg		1250 mm	49.21 in	38.0 kg	



Punches 

C45: 560-710 N/mm <sup>2</sup>		1300 kN/m max.
<b>CP200.24.R1</b>		
1020 mm	40.16 in	49.0 kg
1250 mm	49.21 in	38.0 kg




24°



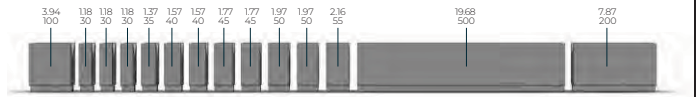
Dies 



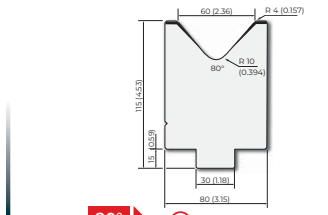
STANDARD LENGTH AND SEGMENTED

1020 mm ((40.61 in) 

Total Length 1250 mm (49.21 in)

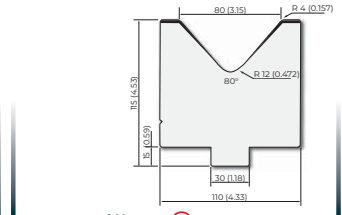


C45: 560-710 N/mm <sup>2</sup>		1200 kN/m max.
<b>M115.80.60</b>		
1020 mm	40.16 in	60.0 kg
1250 mm	49.21 in	73.6 kg



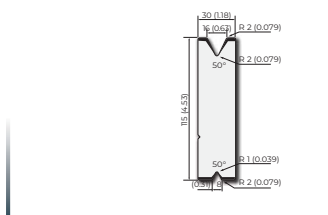
80°

C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.
<b>M115.80.80</b>		
1020 mm	40.16 in	80.0 kg
1250 mm	49.21 in	98.0 kg



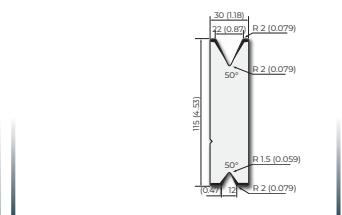
80°

C45: 560-710 N/mm <sup>2</sup>		600 kN/m max.
<b>M115.50.16</b>		
1020 mm	40.16 in	26.5 kg
1250 mm	49.21 in	32.4 kg



50°

C45: 560-710 N/mm <sup>2</sup>		500 kN/m max.
<b>M115.50.22</b>		
1020 mm	40.16 in	25.5 kg
1250 mm	49.21 in	31.2 kg



50°

C45: 560-710 N/mm<sup>2</sup> 400 kN/m max.

**MT15.50.30**

1020 mm	40.16 in	34.5 kg
1250 mm	49.21 in	43.0 kg

C45: 560-710 N/mm<sup>2</sup> 400 kN/m max.

**MT15.50.40**

1020 mm	40.16 in	36.0 kg
1250 mm	49.21 in	44.0 kg

C45: 560-710 N/mm<sup>2</sup> 600 kN/m max.

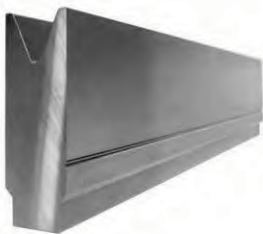
**MT15.50.50**

1020 mm	40.16 in	45.5 kg
1250 mm	49.21 in	31.0 kg

C45: 560-710 N/mm<sup>2</sup> 8.700 kN/m max. - 16.300 kN/m max.

**MT15.24.16**

1020 mm	40.16 in	24.9 kg
1250 mm	49.21 in	31.0 kg



C45: 560-710 N/mm<sup>2</sup> See table

**MC12.3050**

3050 mm	120.08 in	188.0 kg
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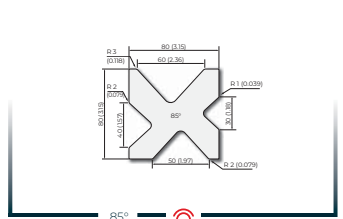
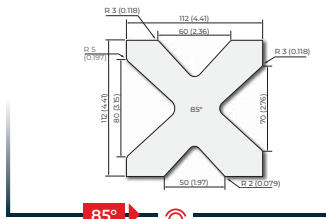
	V1	V2	V3	V4
V mm	60	70	50	80
V in	2.36	2.76	1.97	3.15
Angle	85°	85°	85°	85°
R [mm]	3.0	3.0	2.0	5.0
R [in]	0.118	0.118	0.079	0.197
kN/m max.	850	900	800	800

C45: 560-710 N/mm<sup>2</sup> See table

**MC80.2050 / MC80.3050**

2050 mm	80.71 in	66.0 kg
3050 mm	120.08 in	98.0 kg

	V1	V2	V3	V4
V mm	60	30	50	40
V in	2.36	1.18	1.97	1.57
Angle	85°	85°	85°	85°
R [mm]	3.0	2.0	2.0	1.0
R [in]	0.118	0.079	0.079	0.039
kN/m max.	750	750	750	750



C45: 560-710 N/mm<sup>2</sup> See table

**MC74.2050 / MC74.3050**

2050 mm	80.71 in	67.0 kg
3050 mm	120.08 in	101.0 kg

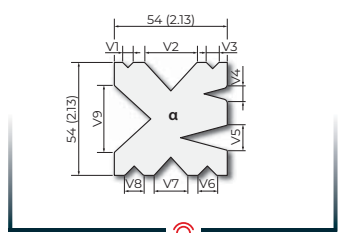
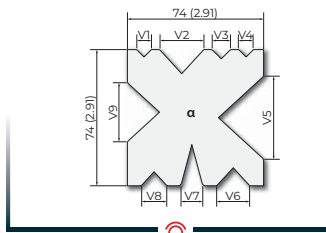
	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm [in]	8 [0.31]	24 [0.94]	10 [0.39]	8 [0.31]	45 [1.77]	18 [0.71]	12 [0.47]	14 [0.55]	32 [1.26]
Angle	90°	85°	90°	90°	85°	85°	30°	85°	85°
R mm [in]	0.8 [0.031]	0.8 [0.031]	2.0 [0.079]	0.8 [0.031]	2.0 [0.079]	1.0 [0.039]	2.0 [0.079]	2.0 [0.079]	2.0 [0.079]
kN/m max.	500	600	600	500	550	500	550	550	550

C45: 560-710 N/mm<sup>2</sup> See table

**MC54.2050 / MC54.3050**

2050 mm	80.71 in	35.6 kg
3050 mm	120.08 in	53.0 kg

	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm [in]	6 [0.24]	25 [0.98]	6 [0.24]	6 [0.24]	12 [0.47]	9 [0.35]	16 [0.63]	9 [0.35]	32 [1.26]
Angle	90°	85°	90°	30°	30°	90°	85°	90°	85°
R mm [in]	0.5 [0.02]	1.0 [0.039]	0.5 [0.02]	2.0 [0.079]	0.5 [0.02]	0.5 [0.02]	1.0 [0.039]	1.0 [0.039]	1.0 [0.039]
kN/m max.	500	600	600	500	550	500	550	550	550



STANDARD LENGTH AND SEGMENTED

1020 mm (40.61 in)

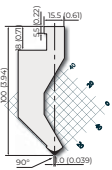


Total Length 990 mm (39.38 in)

Horn types

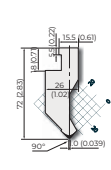


C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AXP.100.90.1</b>			
1020 mm	40.16 in	16.3 kg	
990 mm	38.98 in	15.2 kg	F



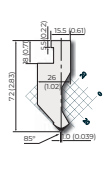
90°

C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AXP.72.90.1</b>			
1020 mm	40.16 in	10.0 kg	
990 mm	38.98 in	9.7 kg	F



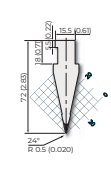
90°

C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AXP.72.85.1</b>			
1020 mm	40.16 in	10.0 kg	
990 mm	38.98 in	9.7 kg	F



85°

C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AXP.72.24.R05</b>			
1020 mm	40.16 in	7.1 kg	
990 mm	38.98 in	6.9 kg	F



24°

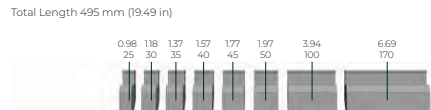
180 Segmented

On stock

Ask for delivery time

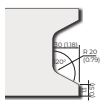
STANDARD LENGTH AND SEGMENTED

525 mm (20.67 in)

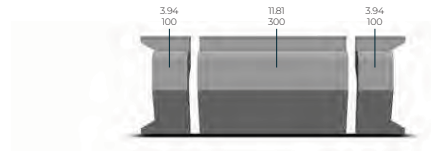


Total Length 495 mm (19.49 in)

Horn types

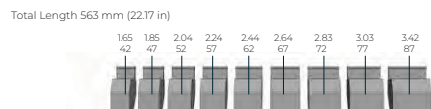


Total Length 500 mm (19.678 in)



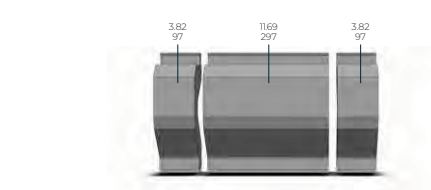
RADIUS TOOLS HOLDER

522 mm (20.55 in)



Total Length 563 mm (22.17 in)

Total Length 491 mm (19.33 in)

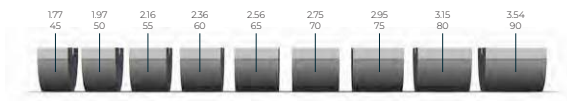


Radius Tool Holders Gasparini

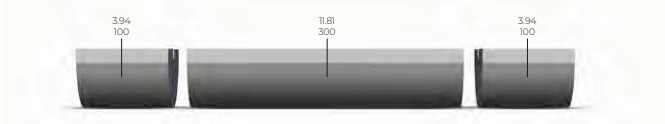
RADIUS TOOLS

525 mm (20.67 in)

Total Length 590 mm (23.23 in)



Total Length 500 mm (19.68 in)



C45: 560-710 N/mm <sup>2</sup>			C45: 560-710 N/mm <sup>2</sup>		
1000 kN/m max.			1800 kN/m max.		
<b>GASP293-16</b>			<b>GASPI70-16</b>		
525 mm	20.55 in	83.0 kg	522 mm	20.55 in	24.0 kg
563 mm	22.17 in	89.5 kg	563 mm	22.17 in	4.5 kg
491 mm	19.33 in	78.0 kg	491 mm	19.33 in	4.5 kg

Radius Tools Gasparini

C45: 560-710 N/mm <sup>2</sup>			C45: 560-710 N/mm <sup>2</sup>		
1000 kN/m max.			1000 kN/m max.		
<b>GASP40.60.03</b>			<b>GASP35.60.08</b>		
525 mm	20.67 in	4.7 kg	525 mm	20.67 in	4.7 kg
590 mm	23.23 in	5.3 kg	590 mm	23.23 in	5.3 kg
491 mm	19.33 in	4.5 kg	491 mm	19.33 in	4.5 kg

C45: 560-710 N/mm <sup>2</sup>			C45: 560-710 N/mm <sup>2</sup>		
1000 kN/m max.			1000 kN/m max.		
<b>GASP30.60.11.5</b>			<b>GASP30.60.16</b>		
525 mm	20.67 in	4.2 kg	525 mm	20.67 in	4.7 kg
590 mm	23.23 in	4.7 kg	590 mm	23.23 in	5.3 kg
500 mm	19.68 in	4.0 kg	500 mm	19.68 in	4.5 kg

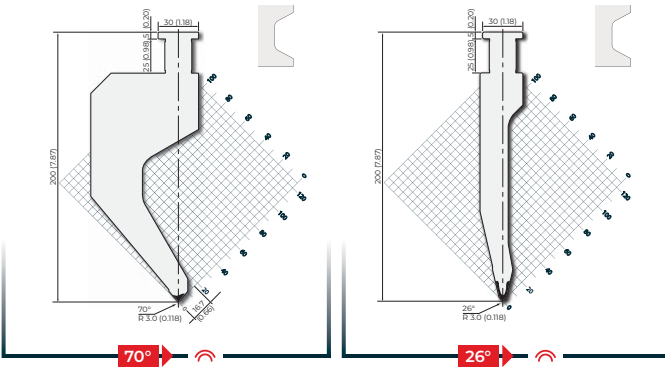
C45: 560-710 N/mm <sup>2</sup>			C45: 560-710 N/mm <sup>2</sup>		
1000 kN/m max.			1000 kN/m max.		
<b>GASP30.60.20</b>			<b>GASP30.60.32</b>		
525 mm	20.67 in	5.0 kg	525 mm	20.67 in	7.0 kg
590 mm	23.23 in	5.6 kg	590 mm	23.23 in	7.8 kg
500 mm	19.68 in	4.3 kg	500 mm	19.68 in	6.7 kg

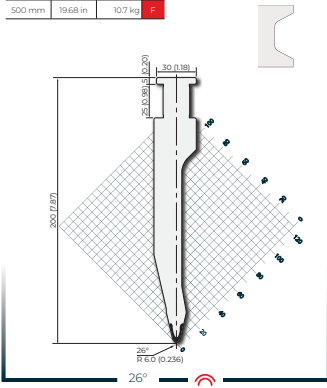
C45: 560-710 N/mm <sup>2</sup>			C45: 560-710 N/mm <sup>2</sup>		
1500 kN/m max.			1800 kN/m max.		
<b>GASP35.40.40</b>			<b>GASP55.40.60</b>		
525 mm	20.67 in	10.5 kg	525 mm	20.67 in	24.4 kg
590 mm	23.23 in	11.8 kg	590 mm	23.23 in	27.4 kg
500 mm	19.68 in	10.0 kg	500 mm	19.68 in	23.2 kg



42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			1300 kN/m max.		
GASP200.70.R3-30						GASP200.26.R3-30					
525 mm	20.67 in	31.8 kg	525 mm	20.67 in	16.9 kg						
495 mm	19.48 in	30.0 kg	495 mm	19.48 in	10.6 kg						
500 mm	19.68 in	30.3 kg	500 mm	19.68 in	10.7 kg						



42Cr: 900-1150 N/mm <sup>2</sup>			1300 kN/m max.		
GASP200.26.R6-30					
525 mm	20.67 in	16.9 kg			
495 mm	19.48 in	10.6 kg			
500 mm	19.68 in	10.7 kg			

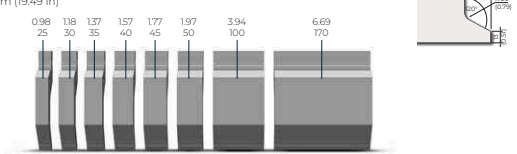


STANDARD LENGTH AND SEGMENTED

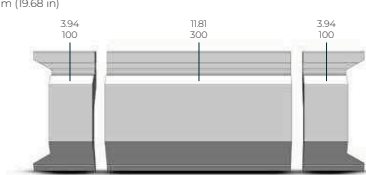
525 mm (20.67 in)


Horn types

Total Length 495 mm (19.49 in)

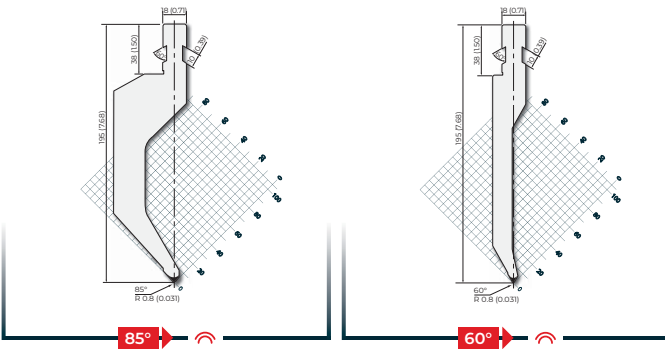


Total Length 500 mm (19.68 in)

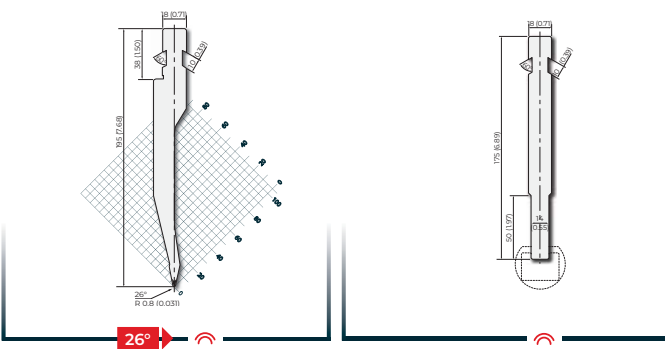


Punches and Radius Tools  Colgar

42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.			42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.		
<b>PAC195.85.R08</b>						<b>PAC195.60.R08</b>					
525 mm	20.67 in	20.6 kg				525 mm	20.67 in	12.0 kg			
495 mm	19.48 in	19.4 kg				495 mm	19.48 in	11.3 kg	F		
500 mm	19.68 in	19.6 kg				500 mm	19.68 in	11.4 kg	F		



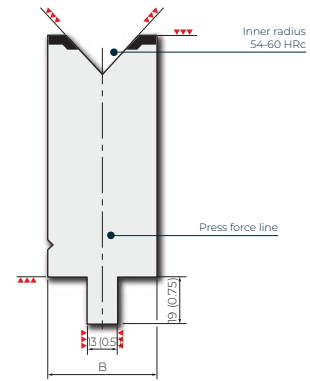
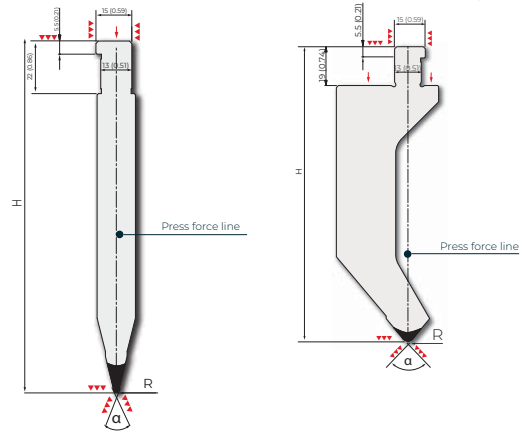
42Cr: 900-1150 N/mm <sup>2</sup>			1000 kN/m max.			C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>PAC195.26.R08</b>						<b>PAC175.14</b>					
525 mm	20.67 in	12.0 kg				830 mm	32.68 in	18.0 kg			
495 mm	19.48 in	11.3 kg				412 mm	16.22 in	9.0 kg			
500 mm	19.68 in	11.4 kg									



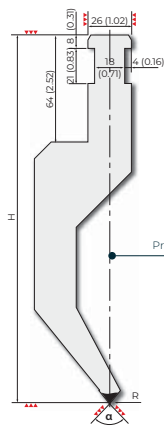
Punches and Dies  Ursviken **NEW**

STANDARD TANG

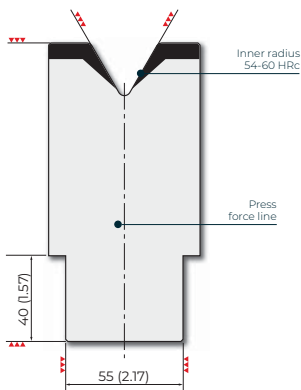
Please contact sales@roller.it for all information about complete range of products



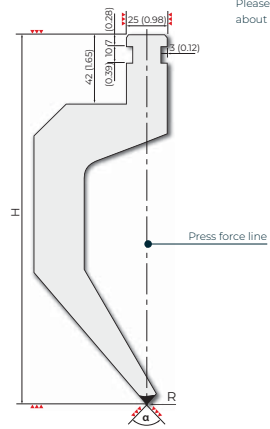
STANDARD TANG



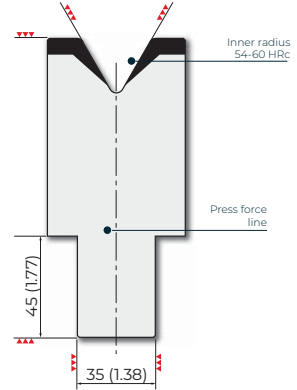
Please contact sales@roller.it for all information about complete range of products



STANDARD TANG

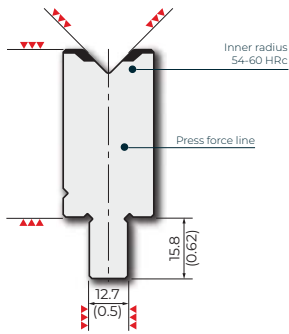
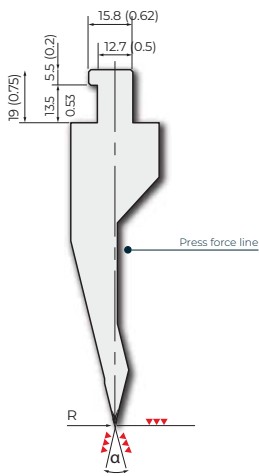


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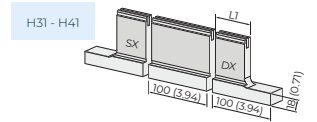
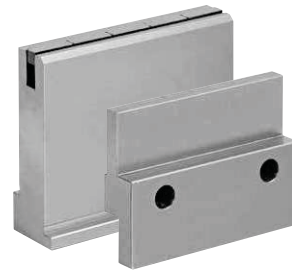
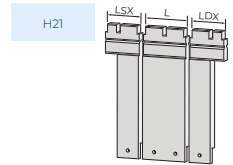
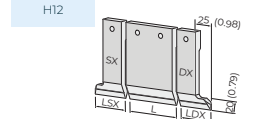
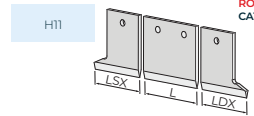
STANDARD TANG

REQUEST **NEW**  
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STANDARD TANG

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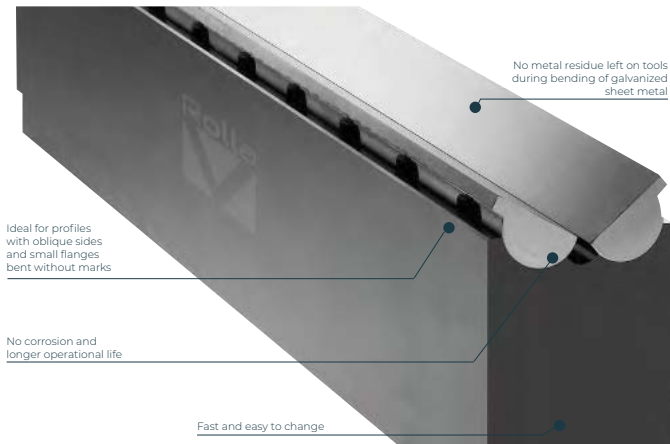




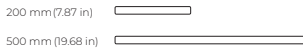
## ROLLERI ROLLA-V ONYX DIES

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### Content Explanation



### STANDARD LENGTH



Rolla-V Ornyx Ref.	Model	Tang (mm)	Tang (in)	Compatibility	Rolleri tools Type
RVP	1, 2, 3	60	2.36	Are compatible with press brake machines from: ACL, Accupress, AM Machinery, Amada, Atlante, Adria, Baykal, BL, Boschert, Bouillon, Bystronic-BeyerleEuro-B, Coastone, Colgar, Dener, Deratech, Durmazlar, Ermakani, Farina, Cade, Casparini, Cizels, Haco, Hindustani, Kurotsupe, Sky, LFK, W.D. Newton, Prima Power, Promecam, Roco, Salvagnini, Schiavi, SMO, Sorg, Sormo, Vicla, Vimercati, Warcom, Yargil, Yawei, Ysid, etc.	R1
RVS	1, 2, 3	14	0.55	Amada single V Style	R1
RVT	1, 2, 3	13	0.51	Are compatible with press brake machines from: Bystronic, Beyerle, Edwards, Safan, SMD, Trumpf	R2, R3
RV190	1, 2, 3	12.7	0.50	Are compatible with press brakes machines from: LVD	R4
RVM	2, 5, 3, 4	Various die holders	Various die holders	All press brake machines (various die holders)	-

### Content Explanation

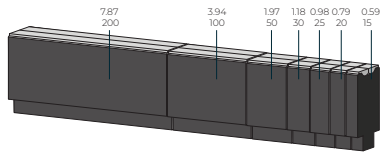
	Equivalent V size mm [in]	Max. tool load [kN/in]	Material Thickness mm [in]	Min. bending angle	Needed press force [kN/in]	Min. outside flange mm [in]	Max. outside radius mm [in]
<b>MODEL 1</b> Max. recommended thickness =15 mm [0.06 in] [2.0 mm / 0.08 in possible]	8 [0.31]	1000	0.70 [0.03]	40°	50	3.0 [0.12]	3.0 [0.12]
		1000	1.10 [0.04]	35°	130	3.9 [0.15]	2.6 [0.10]
		1000	1.50 [0.06]	35°	270	4.2 [0.17]	2.2 [0.09]
<b>MODEL 2</b> Max. recommended thickness =3.0 mm [0.12 in] [4.0 mm/0.15 in possible]	15 [0.59]	1500	2.00 [0.08]	59°	210	8.5 [0.33]	6.0 [0.24]
		1500	3.00 [0.12]	47°	550	9.3 [0.37]	5.0 [0.20]
		1500	3.20 [0.13]	47°	650	9.3 [0.37]	4.8 [0.19]
<b>MODEL 2.5</b> Max. recommended thickness =5.0 mm [0.20 in] [6.35 mm / 0.24 in possible]	28 [1.10]	2500	2.00 [0.08]	46°	100	18.6 [0.73]	13.2 [0.52]
		2500	4.00 [0.16]	46°	470	18.6 [0.73]	12.0 [0.47]
		2500	6.00 [0.24]	55°	1270	18.6 [0.73]	9.8 [0.39]
<b>MODEL 3</b> Max. recommended thickness =6.3 mm [0.25 in] [8.0 mm / 0.31 in possible]	38 [1.50]	2500	2.00 [0.08]	68°	70	22.5 [0.89]	13.9 [0.55]
		2500	4.00 [0.16]	47°	340	22.5 [0.89]	11.9 [0.47]
		2500	6.00 [0.24]	50°	900	22.5 [0.89]	9.9 [0.39]
<b>MODEL 4</b> Max. recommended thickness =16.0 mm [0.63 in]	85 [3.35]	3000	6.00 [0.24]	78°	260	56.6 [2.23]	36.4 [1.43]
		3000	8.00 [0.31]	76°	500	56.6 [2.23]	36.4 [1.43]
		3000	12.00 [0.47]	73°	1290	56.6 [2.23]	36.4 [1.43]



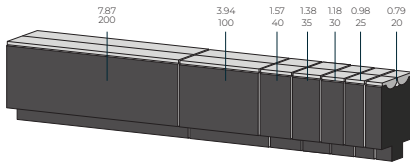
## Content Explanation

### SEGMENTATION

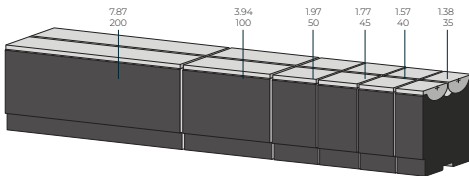
Model 1: 440 mm (17.32 in) - 7 segments



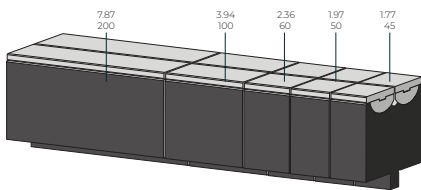
Model 2: 450 mm (17.72 in) - 7 segments



Model 2.5: 470 mm (18.50 in) - 6 segments



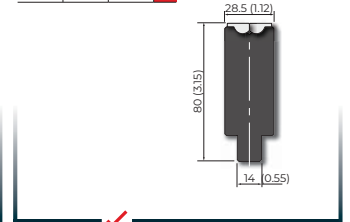
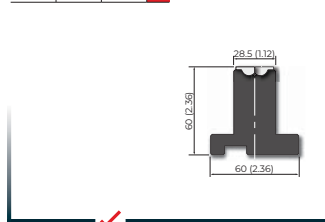
Model 3: 455 mm (17.91 in) - 5 segments



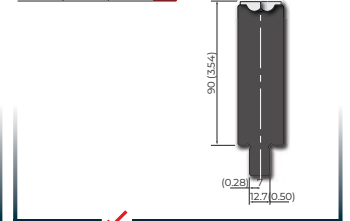
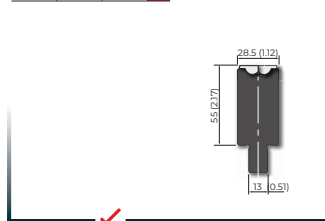
## Rolla-V Onyx Dies - Model 1



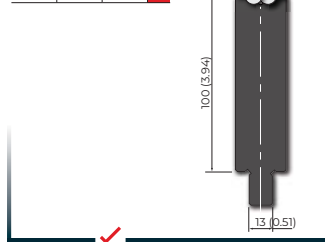
42Cr: 900-1150 N/mm <sup>2</sup> Toolox 44			1000 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup> Toolox 44			1000 kN/m max.
<b>RVP60-1</b>				<b>RVS60-1</b>			
500 mm	16.68 in	6.9 kg		500 mm	16.68 in	6.3 kg	
440 mm	17.32 in	6.1 kg	F	440 mm	17.32 in	5.8 kg	F



42Cr: 900-1150 N/mm <sup>2</sup> Toolox 44			1000 kN/m max.	42Cr: 900-1150 N/mm <sup>2</sup> Toolox 44			1000 kN/m max.
<b>RVT55-1</b>				<b>RVT90-1</b>			
500 mm	16.68 in	5.5 kg		500 mm	16.68 in	9.4 kg	
440 mm	17.32 in	5.0 kg	F	440 mm	17.32 in	7.8 kg	F



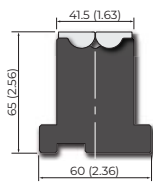
42Cr: 900-1150 N/mm <sup>2</sup> Toolox 44			1000 kN/m max.
<b>RVT100-1</b>			
500 mm	16.68 in	9.4 kg	
440 mm	17.32 in	8.6 kg	F



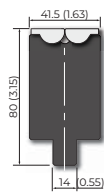
MODEL 1 - Features			
Max. recommended thickness	±15 mm [0.06 in] (2.0 mm / 0.08 in possible)		
Material Thickness mm [in]	0.70 [0.03]	1.10 [0.04]	1.50 [0.06]
Equivalent V size mm [in]	Ø 0.31		
Max. tool load [kN/m]	1000	1000	1000
Min. bending angle	40°	35°	35°
Needed press force mild steel with max. 450 N/mm <sup>2</sup> [kN/m]	50	130	270
Needed press force stainless steel with max. 700 N/mm <sup>2</sup> [kN/m]	70	200	410
Min. outside flange mm [in]	3.0 [0.12]	3.9 [0.15]	4.2 [0.17]
Max. outside radius mm [in]	3.0 [0.12]	2.6 [0.10]	2.2 [0.09]

## Rolla-V Onyx Dies - Model 2

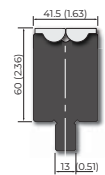
42Cr: 900-1150 N/mm <sup>2</sup>		Toolox 44		1500 kN/m max.	
<b>RVP65-2</b>					
500 mm	16.68 in	79 kg			
450 mm	17.72 in	74 kg	F		



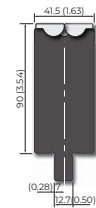
42Cr: 900-1150 N/mm <sup>2</sup>		Toolox 44		1500 kN/m max.	
<b>RVS80-2</b>					
500 mm	16.68 in	8.3 kg			
450 mm	17.72 in	7.8 kg	F		



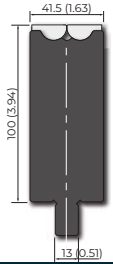
42Cr: 900-1150 N/mm <sup>2</sup>		Toolox 44		1500 kN/m max.	
<b>RVT60-2</b>					
500 mm	16.68 in	79 kg			
450 mm	17.72 in	74 kg	F		



42Cr: 900-1150 N/mm <sup>2</sup>		Toolox 44		1500 kN/m max.	
<b>RVT90-2</b>					
500 mm	16.68 in	11.3 kg			
450 mm	17.72 in	10.6 kg	F		



42Cr: 900-1150 N/mm <sup>2</sup>		Toolox 44		1500 kN/m max.	
<b>RVT100-2</b>					
500 mm	16.68 in	12.4 kg			
450 mm	17.72 in	11.7 kg	F		

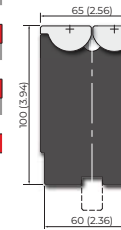


MODEL 2 - Features				
Max. recommended thickness	±3.0 mm [0.12 in] [4.0 mm / 0.15 in possible]			
Material Thickness mm [in]	2.00 [0.08]	3.00 [0.12]	3.20 [0.13]	
Equivalent V size mm [in]	15 [0.59]			
Max. tool load [kN/m]	1500	1500	1500	
Min. bending angle	59°	47°	47°	
Needed press force mild steel with max. 450 N/mm <sup>2</sup> [kN/m]	210	550	650	
Needed press force stainless steel with max. 700 N/mm <sup>2</sup> [kN/m]	320	850	1000	
Min. outside flange mm [in]	8.5 [0.33]	9.3 [0.37]	9.3 [0.37]	
Max. outside radius mm [in]	6.0 [0.24]	5.0 [0.20]	4.8 [0.19]	

## Rolla-V Onyx Dies - Model 2.5



42Cr: 900-1150 N/mm <sup>2</sup>		Toolox 44		2000 kN/m max.	
<b>RVM2.5</b>					
Without tang					
500 mm	16.68 in	22.0 kg			
470 mm	18.50 in	21.0 kg	F		
With tang 0.51 x 0.79 in					
500 mm	16.68 in	23.5 kg			
470 mm	18.50 in	22.4 kg	F		
With tang 0.5 x 0.75 in					
500 mm	16.68 in	23.5 kg			
470 mm	18.50 in	22.4 kg	F		



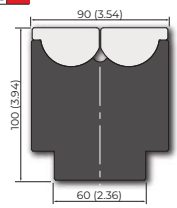
MODEL 2.5 - Features				
Max. recommended thickness	±5.0 mm [0.20 in] [6.35 mm / 0.24 in possible]			
Material Thickness mm [in]	2.00 [0.08]	4.00 [0.16]	6.00 [0.24]	
Equivalent V size mm [in]	28 [1.10]			
Max. tool load [kN/m]	2500	2500	2500	
Min. bending angle	46°	46°	55°	
Needed press force mild steel with max. 450 N/mm <sup>2</sup> [kN/m]	100	470	1270	
Needed press force stainless steel with max. 700 N/mm <sup>2</sup> [kN/m]	150	730	1960	
Min. outside flange mm [in]	18.6 [0.73]	18.6 [0.73]	18.6 [0.73]	
Max. outside radius mm [in]	13.2 [0.52]	12.0 [0.47]	9.8 [0.39]	



### Rolla-V Onyx Dies - Model 3

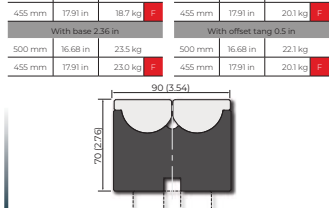
42Cr: 900-1150 N/mm<sup>2</sup> Toolox 33 2500 kN/m max.

RVPI00-3		
500 mm	16.68 in	28.8 kg
455 mm	17.91 in	26.2 kg



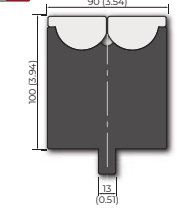
42Cr: 900-1150 N/mm<sup>2</sup> Toolox 33 2500 kN/m max.

RVM70-3					
Without tang			With tang 0.51 in		
500 mm	16.68 in	20.6 kg	500 mm	16.68 in	22.1 kg
455 mm	17.91 in	18.7 kg	455 mm	17.91 in	20.1 kg
With base 2.36 in			With offset tang 0.5 in		
500 mm	16.68 in	23.5 kg	500 mm	16.68 in	22.1 kg
455 mm	17.91 in	23.0 kg	455 mm	17.91 in	20.1 kg



42Cr: 900-1150 N/mm<sup>2</sup> Toolox 33 2500 kN/m max.

RVT100-3		
500 mm	16.68 in	30.9 kg
455 mm	17.91 in	28.5 kg



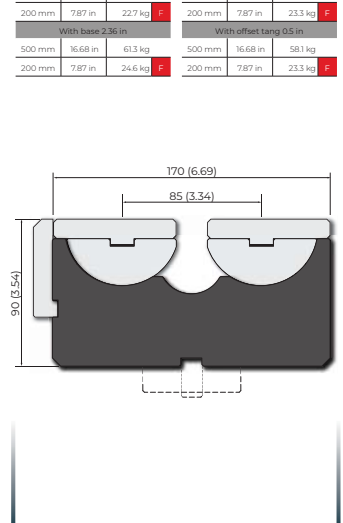
MODEL 3 - Features			
Max. recommended thickness	≈6.3 mm [0.25 in] [8.0 mm / 0.31 in possible]		
Material Thickness mm [in]	2.00 [0.08]	4.00 [0.16]	6.00 [0.24]
Equivalent V size mm [in]	38 [1.50]		
Max. tool load [kN/m]	2500	2500	2500
Min. bending angle	68°	47°	50°
Needed press force mild steel with max. 450 N/mm <sup>2</sup> [kN/m]	70	340	900
Needed press force stainless steel with max. 700 N/mm <sup>2</sup> [kN/m]	110	550	1300
Min. outside flange mm [in]	22.5 [0.89]	22.5 [0.89]	22.5 [0.89]
Max. outside radius	13.9 [0.55]	11.9 [0.47]	9.9 [0.39]

### Rolla-V Onyx Dies - Model 4

- Suitable for thick sheet metal and large-radius bends.
- Material specifications vary greatly, therefore no specific data can be given.
- Minimum flanges depend on the bending angle.
- Distortion of holes near the bending line is substantially decreased, although it depends on the type of the sheet metal.
- Large-radius bends are influenced by sheet metal springback, type of material and flange length.

42Cr: 900-1150 N/mm<sup>2</sup> Toolox 33 3000 kN/m max.

RVM90-4					
Without tang			With tang 0.51 in		
500 mm	16.68 in	56.6 kg	500 mm	16.68 in	58.1 kg
200 mm	7.87 in	22.7 kg	200 mm	7.87 in	23.3 kg
With base 2.36 in			With offset tang 0.5 in		
500 mm	16.68 in	61.3 kg	500 mm	16.68 in	58.1 kg
200 mm	7.87 in	24.6 kg	200 mm	7.87 in	23.3 kg



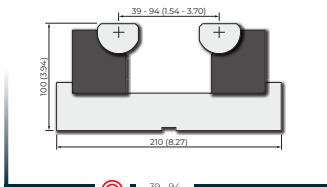
MODEL 4 - Features			
Max. recommended thickness	≈16.0 mm [0.63 in]		
Material Thickness mm [in]	6.00 [0.24]	8.00 [0.31]	12.00 [0.47]
Equivalent V size mm [in]	85 [3.35]		
Max. tool load [kN/m]	3000	3000	3000
Min. bending angle	78°	76°	73°
Needed press force mild steel with max. 450 N/mm <sup>2</sup> [kN/m]	260	500	1290
Needed press force stainless steel with max. 700 N/mm <sup>2</sup> [kN/m]	440	840	2150
Min. outside flange mm [in]	56.6 [2.23]	56.6 [2.23]	56.6 [2.23]
Max. outside radius mm [in]	36.4 [1.43]	36.4 [1.43]	36.4 [1.43]

## Rolla-V Onyx Dies - Adjustable Dies

- ▶ Possibility to bend different thickness ranges without changing tools in the press brake
- ▶ Possibility to bend thick sheet metal (up to 30mm)
- ▶ Reduction or elimination of bending marks in profiles of thick sheet metal
- ▶ Hardened inserts
- ▶ Possibility to mount inserts with different shapes in order to obtain specific profiles prior request to our technicians
- ▶ Ideal for large-radius bends
- ▶ Ideal to bend short flanges
- ▶ Ideal to bend tread plates
- ▶ Possibility to bend sheet metal with oblique sides without deformation
- ▶ Ideal to bend malleable sheet metal like aluminium, bronze
- ▶ Ideal to bend profiles without deforming holes or button holes near the bending line

42Cr: 900-1150 N/mm<sup>2</sup> Toolox 33 2500 kN/m max

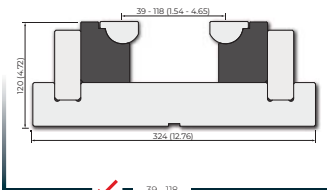
RVPV3		
500 mm	16.68 in	50.0 kg
200 mm	7.87 in	20.0 kg



39 - 94

42Cr: 900-1150 N/mm<sup>2</sup> Toolox 33 3500 kN/m max

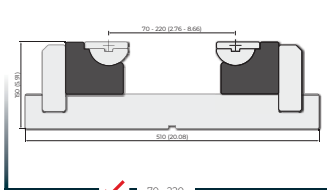
RVHD3		
500 mm	16.68 in	98.0 kg
200 mm	7.87 in	38.1 kg



39 - 118

42Cr: 900-1150 N/mm<sup>2</sup> Toolox 33 3500 kN/m max

RVHD4		
500 mm	16.68 in	200.0 kg
200 mm	7.87 in	80.0 kg

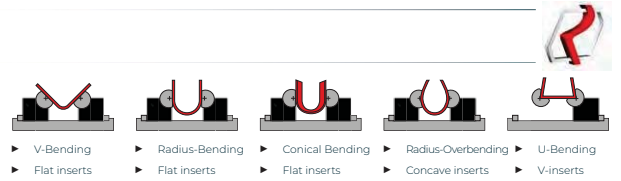
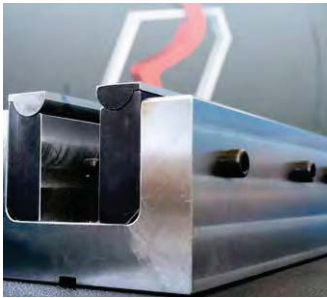
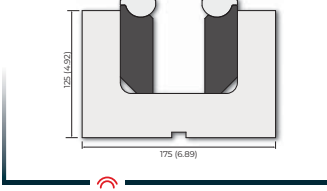


70 - 220

42Cr: 900-1150 N/mm<sup>2</sup> Toolox 33 1500 kN/m max

RVHD2.5		
500 mm	16.68 in	67.5 kg
200 mm	7.87 in	27 kg

NEW





## ROLLER ADAPTERS

<b>PUNCHES - ADAPTERS</b>	206 - 213
Punches - Adapters	206 - 210
Punches - Bolted adapters	211 - 213
<b>DIES - ADAPTERS</b>	214 - 219
Dies - Holders	214 - 218
Dies - Adapters	219

PUNCHES - ADAPTERS



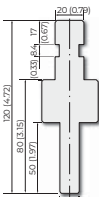
Punches - Adapters



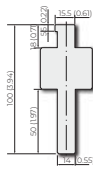
C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.			
<b>AD11</b>					<b>AD22</b>							
150 mm	5.91 in	3.0 kg	R2	R1	150 mm	5.91 in	3.4 kg	R2	R1			
✓					✓							
C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.			
<b>AD3</b>					<b>AD10</b>							
150 mm	5.91 in	3.3 kg	R2	R1	150 mm	5.91 in	3.4 kg	R2	R1			
✓					✓							
C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.	C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.			
<b>AD1</b>					<b>AD13</b>							
AD1-A	150 mm	5.91 in	3.1 kg	R2	A	R1	150 mm	5.91 in	3.0 kg	R2	EHT	R1
AD1-B	150 mm	5.91 in	3.1 kg	R2	B	R1						
AD1-C	150 mm	5.91 in	3.1 kg	R2	C	R1						
AD1-D	150 mm	5.91 in	3.1 kg	R2	D	R1						
✓					✓							

## Punches - Adapters

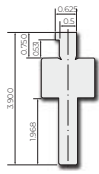
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD14</b>	150 mm	5.91 in	3.2 kg	RX Casparini	R1



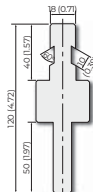
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD15</b>	150 mm	5.91 in	3.0 kg	RX Ajial-Axial	R1



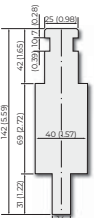
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD16</b>	150 mm	5.91 in	4.0 kg	R American	R1



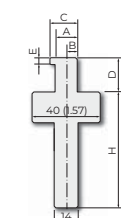
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD12</b>	150 mm	5.91 in	3.0 kg	RX Colgar	R1



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD23</b>	150 mm	5.91 in	5.0 kg	RX Weinbrenner	R1

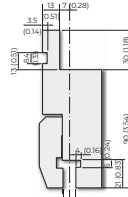


C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>ADX</b>	150 mm	5.91 in	3.5 kg	Type X	R1 Production according to your specifications

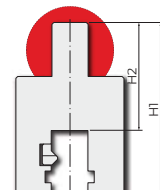


## Punches - Adapters

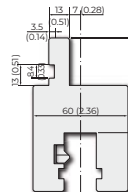
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD19-A</b>	150 mm	5.91 in	6.0 kg	R1	R2



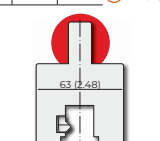
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>ADX2</b>	150 mm	5.91 in	2.4 kg	Type X	R2 Production according to your specifications



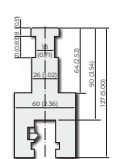
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD20</b>	150 mm	5.91 in	4.0 kg	R1	R2



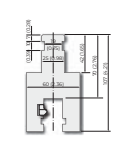
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD20 LVD</b>	150 mm	5.91 in	3.6 kg	R1	R2
AD20 LVD-A	150 mm	5.91 in	3.8 kg	R1	R2
AD20 LVD-B	150 mm	5.91 in	4.0 kg	R1	R2
AD20 LVD-C	150 mm	5.91 in	4.0 kg	R1	R2
AD20 LVD-D	150 mm	5.91 in	4.0 kg	R1	R2



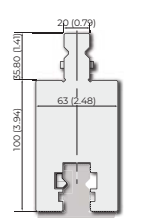
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD28</b>	150 mm	5.91 in	5.0 kg	RX EHT	R2



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.		
<b>AD29</b>	150 mm	5.91 in	4.5 kg	RX Weinbrenner	R2



42Cr: 900-1150 N/mm <sup>2</sup>			1500 kN/m max.		
<b>AD21</b>	150 mm	5.91 in	7.0 kg	R2	R2



## Punches - Adapters

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>INT80-100</b>			
835 mm	32.87 in	25.0 kg	
415 mm	16.34 in	12.5 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>INT67-79</b>			
835 mm	32.87 in	20.5 kg	
415 mm	16.34 in	10.0 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>INT100-A</b>			
150 mm	5.91 in	3.5 kg	
150 mm	5.91 in	5.2 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>INT120-A</b>			
150 mm	5.91 in	5.2 kg	
150 mm	5.91 in	3.5 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>INT100-N (Newton)</b>			
150 mm	5.91 in	3.5 kg	
150 mm	5.91 in	3.5 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>INT100-A (American)</b>			
150 mm	5.91 in	6.0 kg	
150 mm	5.91 in	6.0 kg	

## Punches - Bolted adapters

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AW11</b>			
835 mm	32.87 in	8.4 kg	
415 mm	16.34 in	4.2 kg	
805 mm	31.69 in	8.4 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AW3</b>			
835 mm	32.87 in	3.0 kg	
415 mm	16.34 in	1.5 kg	
805 mm	31.69 in	3.0 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AW10</b>			
835 mm	32.87 in	3.0 kg	
415 mm	16.34 in	1.5 kg	
805 mm	31.69 in	3.0 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AW12</b>			
835 mm	32.87 in	7.0 kg	
415 mm	16.34 in	3.5 kg	
805 mm	31.69 in	6.7 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AW1-A</b>			
835 mm	32.87 in	3.0 kg	
415 mm	16.34 in	1.5 kg	
805 mm	31.69 in	6.7 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AW1-B</b>			
835 mm	32.87 in	7.0 kg	
415 mm	16.34 in	3.5 kg	
805 mm	31.69 in	6.7 kg	

Punches - Bolted adapters

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AWI-C</b>			
835 mm	32.87 in	9.7 kg	
415 mm	16.34 in	4.8 kg	
805 mm	31.69 in	9.4 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AWI-D</b>			
835 mm	32.87 in	11.5 kg	
415 mm	16.34 in	5.7 kg	
805 mm	31.69 in	11.1 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AWI3</b>			
835 mm	32.87 in	12.6 kg	
415 mm	16.34 in	6.3 kg	
805 mm	31.69 in	12.1 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AWI4</b>			
835 mm	32.87 in	8.0 kg	
415 mm	16.34 in	4.0 kg	
805 mm	31.69 in	7.7 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AWI5</b>			
835 mm	32.87 in	3.0 kg	
415 mm	16.34 in	1.5 kg	
805 mm	31.69 in	3.0 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AWI6</b>			
835 mm	32.87 in	5.0 kg	
415 mm	16.34 in	2.5 kg	
805 mm	31.69 in	4.8 kg	

Punches - Bolted adapters



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AWC13.5</b>			
835 mm	32.87 in	4.8 kg	
415 mm	16.34 in	2.4 kg	
805 mm	31.69 in	4.6 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AWX</b>			
835 mm	32.87 in	3.0 kg	Individual
415 mm	16.34 in	1.5 kg	
805 mm	31.69 in	3.0 kg	

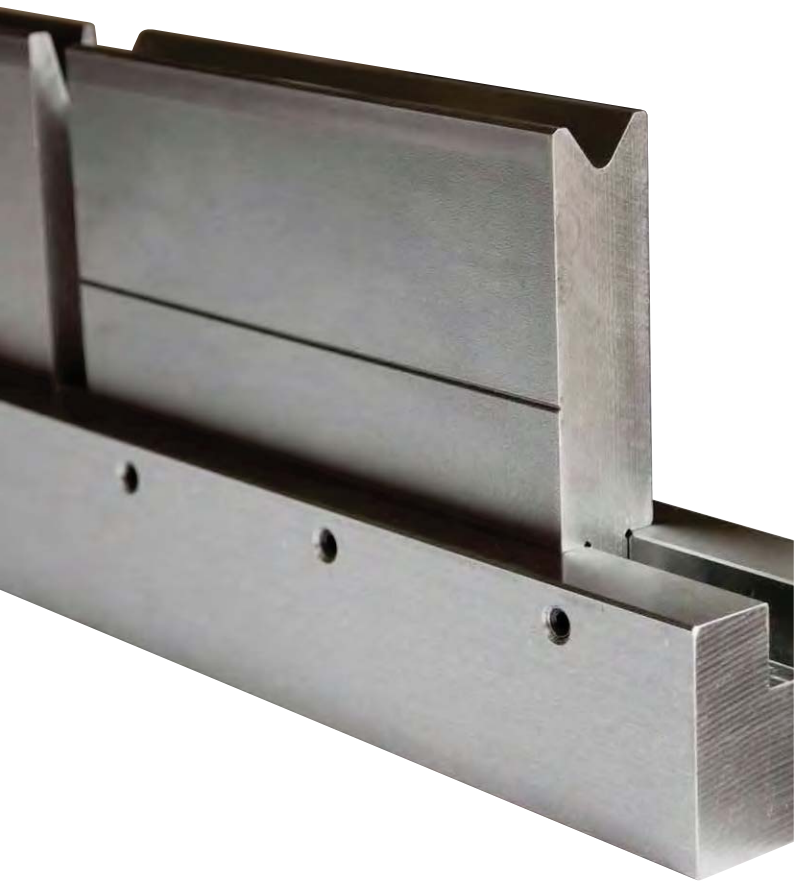
  

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>INT35</b>			
835 mm	32.87 in	4.0 kg	
415 mm	16.34 in	2.5 kg	
805 mm	31.69 in	3.9 kg	

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>INT35-A</b>			
835 mm	32.87 in	5.0 kg	
415 mm	16.34 in	2.5 kg	
805 mm	31.69 in	4.8 kg	

## DIES - ADAPTERS

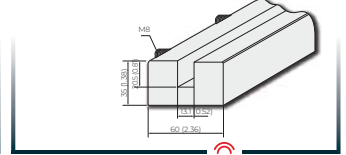
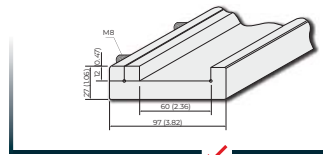


## Dies - Holders



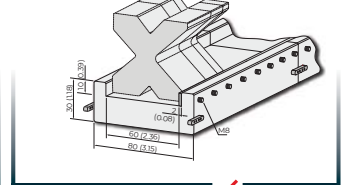
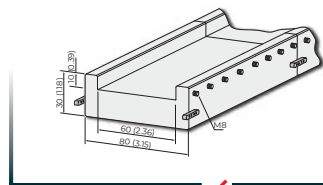
C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.
C 2000/S / C 2500/S / C 3000/S / C 4000/S				
C 2000/S	2100 mm	82.68 in	27.0 kg	
C 2500/S	2600 mm	102.36 in	34.0 kg	
C 3000/S	3100 mm	122.05 in	40.0 kg	
C 4000/S	4100 mm	161.42 in	53.0 kg	

C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.
TC 2000/S / TC 2500/S / TC 3000/S / TC 4000/S				
TC 2000/S	2100 mm	82.68 in	30.0 kg	
TC 2500/S	2600 mm	102.36 in	37.0 kg	
TC 3000/S	3100 mm	122.05 in	44.0 kg	
TC 4000/S	4100 mm	161.42 in	59.0 kg	



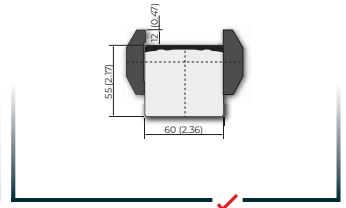
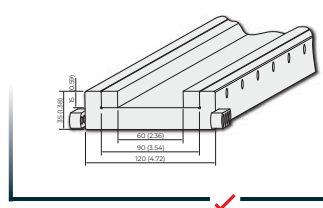
C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.
C 1050/R				
C 1050/R	1050 mm	41.34 in	15.0 kg	
C 1050/R/C	520 mm	20.47 in	7.5 kg	

C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.
C 1050/RS				
C 1050/RS	1050 mm	41.34 in	15.0 kg	
C 1050/RS/C	520 mm	20.47 in	7.5 kg	



C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.
C 1050-90				
C 1050-90	1050 mm	41.34 in	27.2 kg	
C 1050-90/C	520 mm	20.47 in	13.5 kg	

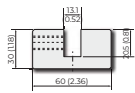
C45: 560-710 N/mm <sup>2</sup>				1000 kN/m max.
CTS60				
CTS60	835 mm	32.87 in	29.0 kg	
	415 mm	16.34 in	14.5 kg	



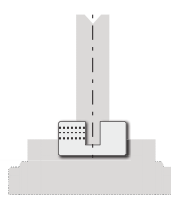


## Dies - Adapters

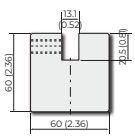
C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AD6</b>			
1000 mm	39.37 in.	12.0 kg	R1 R2 R3
500 mm	19.68 in.	6.0 kg	



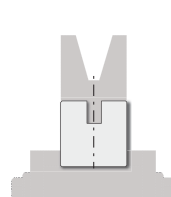
AD6 Example of Application



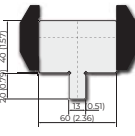
C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AD5</b>			
1000 mm	39.37 in.	26.1 kg	R1 R2 R3
500 mm	19.68 in.	13.0 kg	



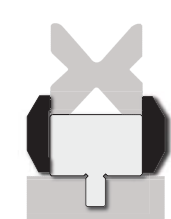
AD5 Example of Application



C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AD7</b>			
835 mm	32.87 in.	25 kg	R2 R3 R1
415 mm	16.34 in.	8.5 kg	

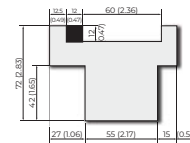


AD7 Example of Application

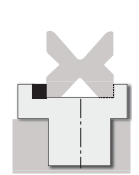


## Dies - Adapters

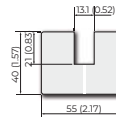
C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AD24</b>			
835 mm	32.87 in.	30 kg	R1 EHT
415 mm	16.34 in.	14.2 kg	



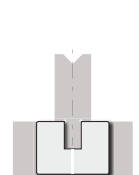
AD24 Example of Application



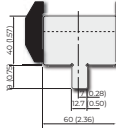
C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AD25</b>			
500 mm	19.68 in.	7.5 kg	R1 EHT R2 R3



AD25 Example of Application



C45: 560-710 N/mm <sup>2</sup>		1000 kN/m max.	
<b>AD9-127</b>			
835 mm	32.87 in.	17.0 kg	R1 R2
415 mm	16.34 in.	8.5 kg	

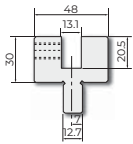


AD9-127 Example of Application

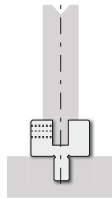


## Dies - Adapters

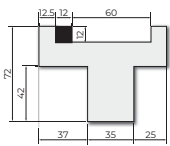
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AD8-12.7</b>			
1000 mm	39.37 in	12.0 kg	RX → R2 R3
500 mm	16.34 in	16.0 kg	



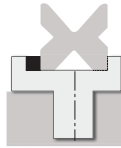
AD8-12.7 Example of Application



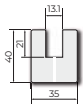
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AD26</b>			
835 mm	32.87 in	23.0 kg	RX Weinbrenner → R1
415 mm	16.34 in	11.4 kg	



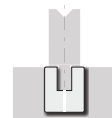
AD26 Example of Application



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AD27</b>			
500 mm	19.68 in	4.5 kg	RX Weinbrenner → R2 R3



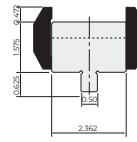
AD27 Example of Application



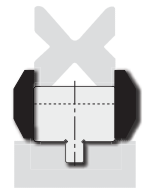
## Dies - Adapters



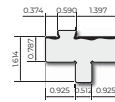
C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AD17</b>			
835 mm	32.87 in	18.0 kg	R American → R1
415 mm	16.34 in	18.0 kg	



AD17 Example of Application



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>AD18</b>			
835 mm	32.87 in	18.0 kg	RX EHT → R2 R3
415 mm	16.34 in	9.0 kg	



AD18 Example of Application





ROLLERI MARK FREE BENDING

<b>ROLL PRIME</b>	222 - 223
<b>ROLFILM</b>	224 - 226
Tensioner	224
Bending Foil	225 - 226
<b>POLYURETHANE</b>	225 - 229
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## Roll Prime 20.17 NEW

Roller's constant research for innovation brought us towards the 3D printing world, the future of manufacturing. Roll Prime is the solution for applications which require mark-free sheet metal, reduced delivery time and dimensional precision: thanks to FDM technology (Fused Deposition Modelling) we are able to produce tools and inserts made of special plastic material, completely adaptable to customer's needs with halved production lead time compared to traditional technology.

- ▶ Totally Mark-free bending
- ▶ Halved production lead time
- ▶ 30-40% lower costs than a classic special tool
- ▶ Ideal for Rapid Prototyping
- ▶ Ideal for small production batches
- ▶ Bending result repeatability
- ▶ Easy handling thanks to 85% lower weight



### Tools

Thanks to an infinite choice of shapes, we are able to study specific solutions for every customer, with the possibility of rapid prototyping.

Roll Prime tools are the right solution to produce small batches or samples, as they have between 30% and 40% lower costs and shorter delivery time than conventional tools.

### Inserts

Roll Prime inserts are an innovation in mark-free bending: thanks to their special composition they can guarantee total absence of marks on sheet metal, giving repeatable and long-lasting results, removing all the annoying problems of classic bending foils.

With our technology we are able to propose highly customizable solutions, so it is possible to design inserts which are fully adaptable to your tools.



## Rolfilm and Tensioner

- Easy handling
- Flexible positioning
- Prevention of bending marks
- Decrease of post-operations of bent parts
- Increased product quality



ROLFILM						
Model	Thickness [mm]	Thickness [in]	Width [mm]	Width [in]	Length [mm]	Length [in]
Rolfilm 3-0.4-100	0.4	0.016	100	3.94	3	118.11
Rolfilm 10-0.4-100	0.4	0.016	100	3.94	10	393.70
Rolfilm 20-0.4-100	0.4	0.016	100	3.94	20	787.40
Rolfilm 30-0.4-100	0.4	0.016	100	3.94	30	1181.10
Rolfilm 3-0.4-150	0.4	0.016	150	5.91	3	118.11
Rolfilm 10-0.4-150	0.4	0.016	150	5.91	10	393.70
Rolfilm 20-0.4-150	0.4	0.016	150	5.91	20	787.40
Rolfilm 30-0.4-150	0.4	0.016	150	5.91	30	1181.10
Rolfilm 3-0.6-150	0.6	0.024	150	5.91	3	118.11
Rolfilm 10-0.6-150	0.6	0.024	150	5.91	10	393.70
Rolfilm 20-0.6-150	0.6	0.024	150	5.91	20	787.40
Rolfilm 30-0.6-150	0.6	0.024	150	5.91	30	1181.10
Rolfilm 3-0.6-200	0.6	0.024	200	7.87	3	118.11
Rolfilm 10-0.6-200	0.6	0.024	200	7.87	10	393.70
Rolfilm 20-0.6-200	0.6	0.024	200	7.87	20	787.40
Rolfilm 30-0.6-200	0.6	0.024	200	7.87	30	1181.10
Rolfilm 3-2-150	2.0	0.079	150	5.91	3	118.11
Rolfilm 10-2-150	2.0	0.079	150	5.91	10	393.70
Rolfilm 20-2-150	2.0	0.079	150	5.91	20	787.40
Rolfilm 30-2-150	2.0	0.079	150	5.91	30	1181.10

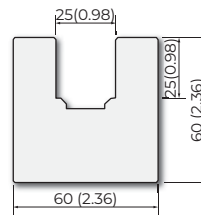


## Polyurethane inserts and holders



C45: 560-710 N/mm<sup>2</sup>

MPG25		
835 mm	32.87 in	18.5 kg
415 mm	16.34 in	9.2 kg



Polyurethane

GM 25X25		
835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg



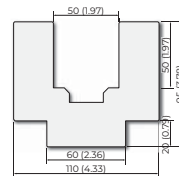
Polyurethane

GM 25X25X10		
835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg



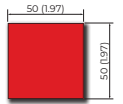
C45: 560-710 N/mm<sup>2</sup>

MPG50		
835 mm	32.87 in	46.0 kg
415 mm	16.34 in	22.5 kg



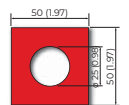
Polyurethane

GM 50X50		
835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg



Polyurethane

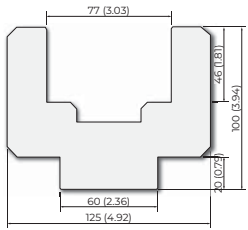
GM 50X50X25		
835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg



## Polyurethane inserts and holders

C45: 560-710 N/mm<sup>2</sup>

MPC75		
835 mm	32.87 in	46.0 kg
415 mm	16.34 in	22.5 kg



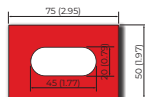
Polyurethane

GM 75X50		
835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg



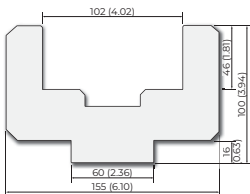
Polyurethane

GM 75X50X20		
835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg



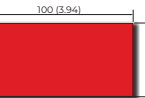
C45: 560-710 N/mm<sup>2</sup>

MPC100		
835 mm	32.87 in	55.0 kg
415 mm	16.34 in	27.5 kg



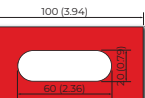
Polyurethane

GM 100X50		
835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg



Polyurethane

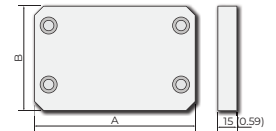
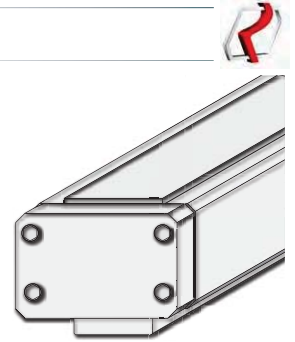
GMF 100X50X20		
835 mm	32.87 in	3.0 kg
415 mm	16.34 in	2.2 kg



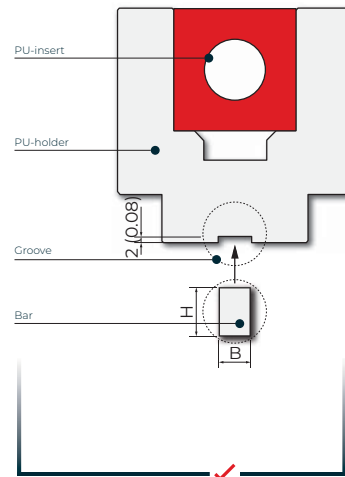
## Cover plate and modifications

C45: 560-710 N/mm<sup>2</sup>

PSTCON - Cover Plate					
Model	A [mm]	A [in]	R [mm]	R [in]	Weight
PSTCON25	58	2.28	58	2.28	1.2 kg
PSTCON50	108	4.25	75	2.95	0.8 kg
PSTCON75	123	4.84	80	3.15	1.0 kg
PSTCON100	153	6.02	80	3.15	1.2 kg

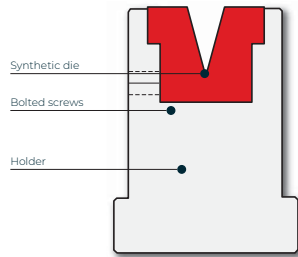


### Tang modification example

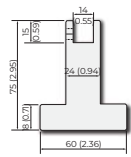


## Synthetic Dies

- Synthetic dies will be adjusted into the housing and secured with bolted screws



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>TN80.14</b>			
835 mm	32.87 in	15.0 kg	(R1)
415 mm	16.34 in	7.5 kg	

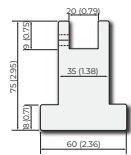


Synthetic			200 kN/m max.
<b>INSI4...</b>			
835 mm	32.87 in	0.30 kg	
415 mm	16.34 in	0.15 kg	



Model	°	V [mm]	V [in]
INSI4.06.88	88°	6	0.24
INSI4.08.88	88°	8	0.31
INSI4.10.88	88°	10	0.39
INSI4.06.60	60°	6	0.24
INSI4.08.60	60°	8	0.31
INSI4.10.60	60°	10	0.39
INSI4.06.45	45°	6	0.24
INSI4.08.45	45°	8	0.31
INSI4.10.45	45°	10	0.39
INSI4.06.30	30°	6	0.24
INSI4.08.30	30°	8	0.31

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>TN80.20</b>			
835 mm	32.87 in	19.0 kg	(R1)
415 mm	16.34 in	9.5 kg	



Synthetic			200 kN/m max.
<b>INS20...</b>			
835 mm	32.87 in	0.4 kg	
415 mm	16.34 in	0.2 kg	

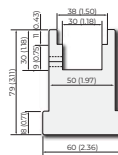


Model	°	V [mm]	V [in]
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

## Synthetic Dies



C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>TN80.30</b>			
835 mm	32.87 in	25.0 kg	(R1)
415 mm	16.34 in	12.5 kg	

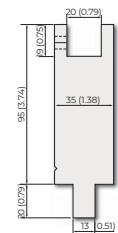


Synthetic			200 kN/m max.
<b>INS30...</b>			
835 mm	32.87 in	0.5 kg	
415 mm	16.34 in	0.3 kg	



Model	°	V [mm]	V [in]
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.97
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16	0.63
INS30.20.60	60°	20	0.79
INS30.06.45	45°	6	0.24
INS30.08.45	45°	8	0.31
INS30.10.45	45°	10	0.39
INS30.12.45	45°	12	0.47
INS30.16.45	45°	16	0.63
INS30.20.45	45°	20	0.79
INS30.06.30	30°	6	0.24
INS30.08.30	30°	8	0.31
INS30.10.30	30°	10	0.39
INS30.12.30	30°	12	0.47
INS30.16.30	30°	16	0.63

C45: 560-710 N/mm <sup>2</sup>			1000 kN/m max.
<b>TMN95.20</b>			
835 mm	32.87 in	12.0 kg	(R2) (R3)
415 mm	16.34 in	6.0 kg	



Synthetic			200 kN/m max.
<b>INS20...</b>			
835 mm	32.87 in	0.4 kg	
415 mm	16.34 in	0.2 kg	



Model	°	V [mm]	V [in]
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39



## ROLLERI EVOLUTION AND HEAVY DUTY

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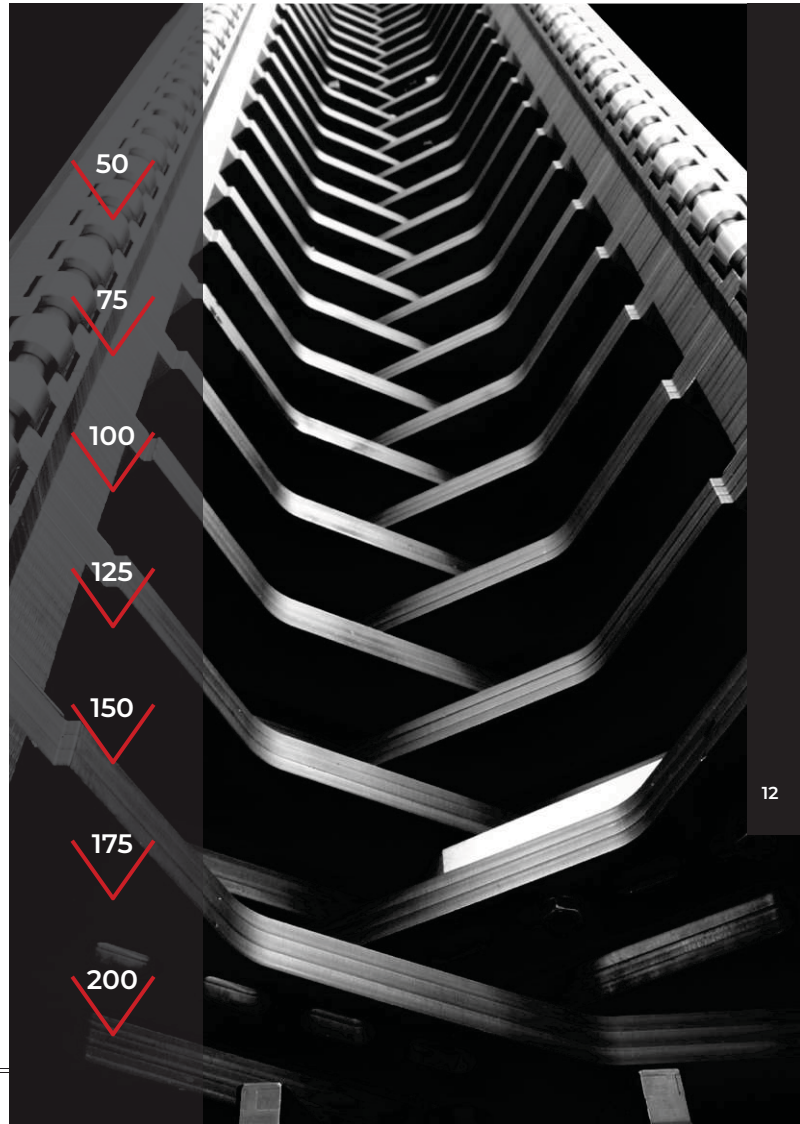
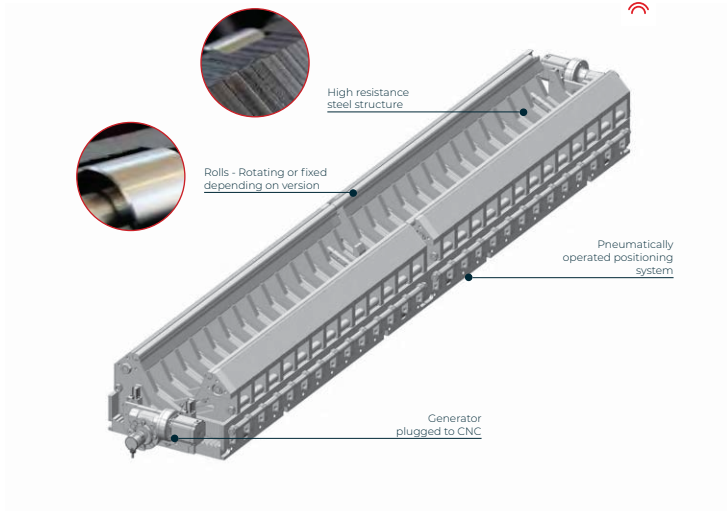


## Rolleri Vario

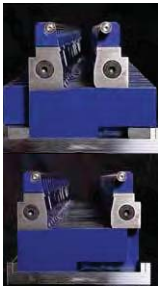


### FEATURES

- ▶ Rolleri Vario can be mounted on any press brake model
- ▶ 7 dies in one single tool
- ▶ Guaranteed rotation and reduction of necessary force of about 25-30% thanks to rollers mounted on pins
- ▶ 250 t/m bearing - resistance and reliability guaranteed
- ▶ In case of excessive wear, rollers can be changed
- ▶ Thanks to a special adapter, it is possible to use VARIO die as an holder for dies with V opening < 50mm
- ▶ Bending angle up to 60°
- ▶ A protective foil is added to the die in order to avoid that rust and residue of material compromise the proper functioning
- ▶ Versions available: manual, semi-automatic, automatic

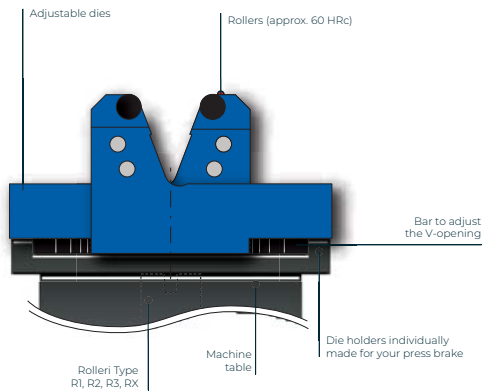


## Adjustable Dies



- ▶ Cover a broad range of V openings, therefore fewer tool changes are required
- ▶ Bending up to 30°, especially ideal for high-tensile materials with large spring back
- ▶ Reduced marking of the sheet metal thanks to hardened rollers
- ▶ Minimum wear of the bending radii because of hardened rollers
- ▶ 10% less press force required
- ▶ Easily modify the internal bending radius by adjusting die opening
- ▶ Reduction of down times by about 30% because adjustment spacer bars are quick and easy to change
- ▶ Minimum maintenance costs
- ▶ Simple design to avoid collision with complicated profiles
- ▶ Can be used on both new and existing press brakes.
- ▶ Modular design; the user can start buying the die length he needs and add extra die modules later as needed
- ▶ High level of precision and consistency over the long term
- ▶ Modular design with interchangeable components gives you the possibility to replace them quickly and easily
- ▶ Very high return of investment
- ▶ Available for all models also easy adjustable protective foil to protect your dies from dust and wear

### Mounting example



## Adjustable dies



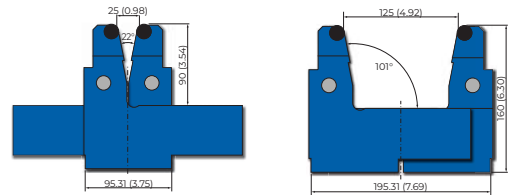
42Cr 900-1150 N/mm

1250 kN/m max. at 90°

### AD25.125

250 mm	9.84 in	34.0 kg
500 mm	19.69 in	64.0 kg
550 mm	21.65 in	72.0 kg
1000 mm	39.37 in	125.0 kg
1050 mm	41.34 in	133.0 kg

- ▶ V=25-125 mm (0.98-4.92 in)
- ▶ Operating angle 30°-180°
- ▶ Radius R=8 mm (0.31 in)



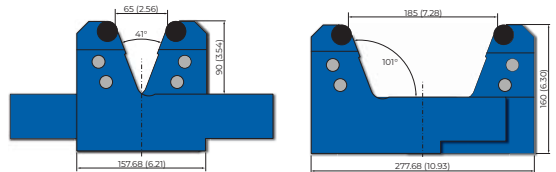
42Cr 900-1150 N/mm

2000 kN/m max. at 90°

### AD65.185

250 mm	9.84 in	44.0 kg
500 mm	19.69 in	86.0 kg
550 mm	21.65 in	96.0 kg
1000 mm	39.37 in	170.0 kg
1050 mm	41.34 in	180.0 kg

- ▶ V=65-185 mm (2.56-7.28 in)
- ▶ Operating angle 60°-180°
- ▶ Radius R=12.5 mm (0.49 in)



## Adjustable Dies

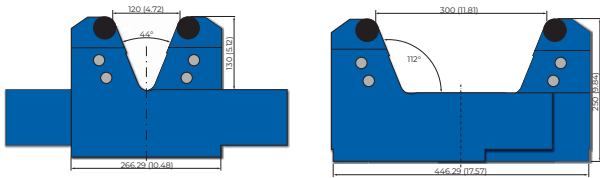
42Cr-900-1150 N/mm<sup>2</sup>

4000 kN/m max. at 90°

### AD120.300

600 mm | 23.62 in | 360.0 kg

- ▶ V=120-300 mm (4.72-11.81 in)
- ▶ Operating angle 60°-180°
- ▶ Radius R=20 mm (0.79 in)



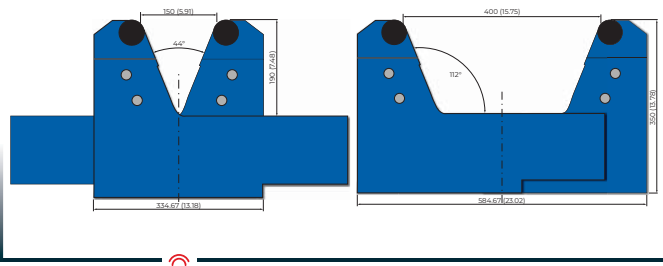
42Cr-900-1150 N/mm<sup>2</sup>

6000 kN/m max. at 90°

### AD150.400

600 mm | 23.62 in | 560.0 kg

- ▶ V=150-400 mm (5.91-15.75 in)
- ▶ operating angle 60°-180°
- ▶ radius R=25 mm (0.98 in)



## Bars



42Cr-900-1150 N/mm<sup>2</sup>

### BAR AD25.185 - AD25.125 + AD65.185

500 mm | 19.69 in | 21.0 kg  
1000 mm | 39.37 in | 42.0 kg  
2000 mm | 78.74 in | 84.0 kg

Set spacer bars width:  
2-5-10-15-20-30-40-50

42Cr-900-1150 N/mm<sup>2</sup>

### BAR AD120.300 - AD120.300

600 mm | 23.62 in | 45.0 kg  
1200 mm | 47.24 in | 90.0 kg  
1800 mm | 70.78 in | 135.0 kg

Set spacer bars width:  
2-5-10-15-20-30-40-50-60



42Cr-900-1150 N/mm<sup>2</sup>

### BAR AD150.400 - AD150.400

600 mm | 23.62 in | 55.0 kg  
1200 mm | 47.24 in | 110.0 kg  
1800 mm | 70.78 in | 165.0 kg

Set spacer bars width:  
5-10-15-20-30-40-50-60



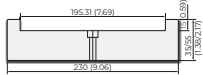
## Holders

42Cr: 900-1150 N/mm<sup>2</sup>

### HAD25.125 - AD25.125

Type A = 35 mm		Type B = 55 mm	
500 mm	19.69 in	20.0 kg	
1000 mm	39.37 in	40.0 kg	
2000 mm	78.74 in	80.0 kg	
3000 mm	118.11 in	120.0 kg	
500 mm	19.69 in	38.0 kg	
1000 mm	39.37 in	76.0 kg	
2000 mm	78.74 in	152.0 kg	
3000 mm	118.11 in	228.0 kg	

Holders, available with flat bottom and with tang



42Cr: 900-1150 N/mm<sup>2</sup>

### HAD65.185 - AD65.185

Type A = 35 mm		Type B = 55 mm	
500 mm	19.69 in	28.0 kg	
1000 mm	39.37 in	56.0 kg	
2000 mm	78.74 in	112.0 kg	
3000 mm	118.11 in	168.0 kg	
500 mm	19.69 in	53.0 kg	
1000 mm	39.37 in	106.0 kg	
2000 mm	78.74 in	212.0 kg	
3000 mm	118.11 in	324.0 kg	

Holders, available with flat bottom and with tang

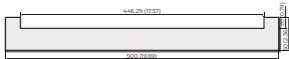


42Cr: 900-1150 N/mm<sup>2</sup>

### HAD120.300 - AD120.300

600 mm	23.62 in	99.0 kg
1200 mm	47.24 in	198.0 kg
2400 mm	94.49 in	396.0 kg
3000 mm	118.11 in	495.0 kg

Holder, available with flat bottom



42Cr: 900-1150 N/mm<sup>2</sup>

### HAD150.400 - AD150.400

600 mm	23.62 in	230.0 kg
1200 mm	47.24 in	460.0 kg
2400 mm	94.49 in	920.0 kg
3000 mm	118.11 in	1150.0 kg

Holder, available with flat bottom



## Dies with Rollers

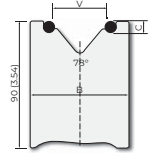


42Cr: 900-1150 N/mm<sup>2</sup>

Roller: CS3: 610-760 N/mm<sup>2</sup>

### MR90

	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight
MR90.20.78	20	0.79	45	1.77	6	0.24	835	32.87	15.0 kg
MR90.24.78	24	0.94	49	1.93	6	0.24	835	32.87	17.0 kg
MR90.30.78	30	1.18	60	2.36	8	0.31	835	32.87	21.0 kg
MR90.40.78	40	1.57	70	2.76	8	0.31	835	32.87	24.0 kg
MR90.50.78	50	1.97	84	3.31	10	0.39	835	32.87	28.0 kg
MR90.60.78	60	2.36	94	3.70	10	0.39	835	32.87	31.0 kg
MR90.70.78	70	2.76	104	4.09	10	0.39	835	32.87	35.0 kg

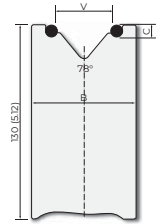


42Cr: 900-1150 N/mm<sup>2</sup>

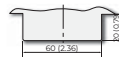
Roller: CS3: 610-760 N/mm<sup>2</sup>

### MR130

	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight
MR130.20.78	20	0.79	45	1.77	6	0.24	835	32.87	22.0 kg
MR130.24.78	24	0.94	49	1.93	6	0.24	835	32.87	26.0 kg
MR130.30.78	30	1.18	60	2.36	8	0.31	835	32.87	28.0 kg
MR130.40.78	40	1.57	70	2.76	8	0.31	835	32.87	34.0 kg
MR130.50.78	50	1.97	84	3.31	10	0.39	835	32.87	40.0 kg
MR130.60.78	60	2.36	94	3.70	10	0.39	835	32.87	45.0 kg
MR130.75.78	75	2.95	108	4.65	16	0.63	835	32.87	50.0 kg
MR130.80.78	80	3.15	123	4.84	16	0.63	835	32.87	55.0 kg
MR130.90.78	90	3.54	133	5.24	16	0.63	835	32.87	60.0 kg
MR130.100.78	100	3.94	143	5.63	16	0.63	835	32.87	66.0 kg
MR130.120.78	120	4.72	163	6.42	16	0.63	835	32.87	70.0 kg



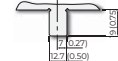
A10



A11



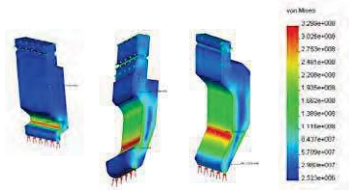
A13



## Heavy Duty Tools

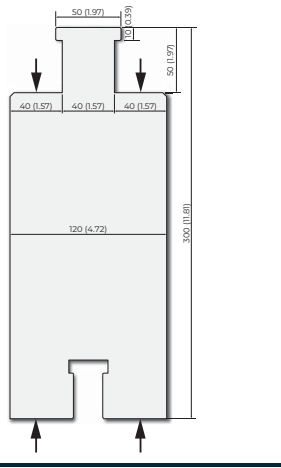
Highly resistant materials such as Weldox, hardox, etc require to be bent with very special tools. Rollerli has taken up this challenge developing a dedicated range of tools called "heavy duty".

Such tools have a resistance up to 4000kN/m; thanks to this capacity it is possible to produce very complex profiles with thick materials.



See table

RHD.300					
Rolleri	Length (mm)	Length (ft)	Weight	KN/m max	Material
RHD.300-250	500	19.68	122.0 kg	2500	42Cr. 900-1150 N/mm²
RHD.300-400	500	19.68	122.0 kg	4000	1.267. 1100-1320 N/mm²

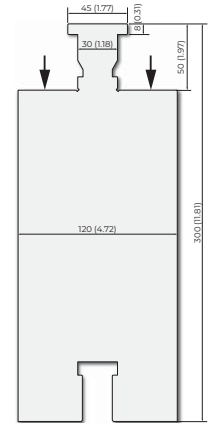


## Heavy Duty Tools



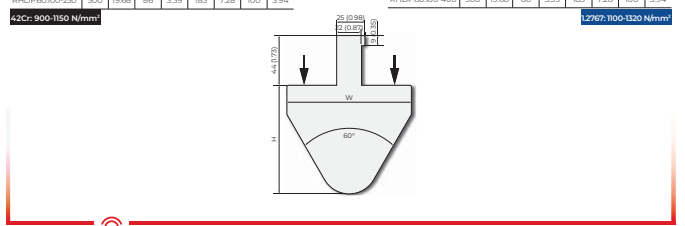
See table

RHD.300 HYD					
Rolleri	Length (mm)	Length (ft)	Weight	KN/m max	Material
RHD.300-250	500	19.68	120.0 kg	2500	42Cr. 900-1150 N/mm²
RHD.300-400	500	19.68	120.0 kg	4000	1.267. 1100-1320 N/mm²



2500 KN/m max. RHD.250 / 4000 KN/m max. RHD.400

RHDP.60									
Model	L (mm)	L (ft)	H (mm)	H (ft)	W (mm)	W (ft)	D (mm)	D (ft)	R (mm)
RHDP.60.20-250	500	19.68	96	3.78	110	4.33	20	0.79	
RHDP.60.25-250	500	19.68	96	3.78	110	4.33	25	0.98	
RHDP.60.30-250	500	19.68	96	3.78	110	4.33	30	1.18	
RHDP.60.40-250	500	19.68	96	3.78	110	4.33	40	1.57	
RHDP.60.50-250	500	19.68	96	3.78	110	4.33	50	1.97	
RHDP.60.60-250	500	19.68	96	3.78	110	4.33	60	2.36	
RHDP.60.70-250	500	19.68	86	3.39	140	5.51	70	2.76	
RHDP.60.80-250	500	19.68	86	3.39	150	5.91	80	3.15	
RHDP.60.90-250	500	19.68	86	3.39	165	6.50	90	3.54	
RHDP.60.100-250	500	19.68	86	3.39	185	7.28	100	3.94	



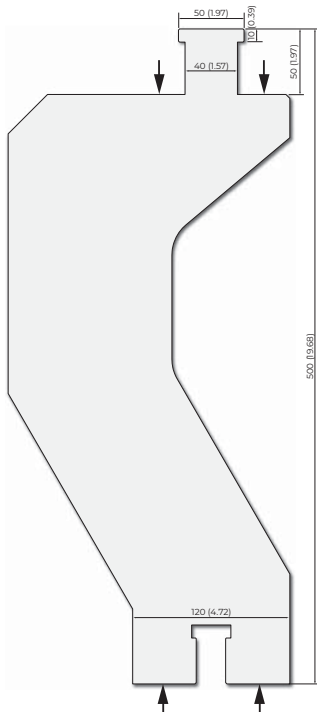
## Heavy Duty Tools

42Cr-900-1150 N/mm<sup>2</sup>

2000 kN/m max.

**RHD.500-200**

150 mm | 19.68 in | 253.0 kg



## Special Tools



SPECIAL TOOLING FOR:

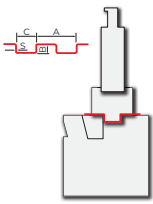
- ▶ Z-Profiles
- ▶ Omega-Profiles
- ▶ Trapezoidal Profiles
- ▶ Coining
- ▶ Special hemming
- ▶ Hinges
- ▶ Large-radius bends
- ▶ Special Profiles
- ▶ etc.



Special Tools examples

SPE1

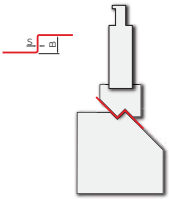
SPE1 Example of Application



SPE2

→ Z-Profiles

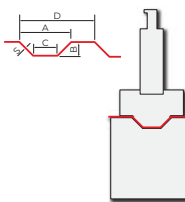
SPE2 Example of Application



SPE3

→ Trapezoidal Profiles

SPE3 Example of Application

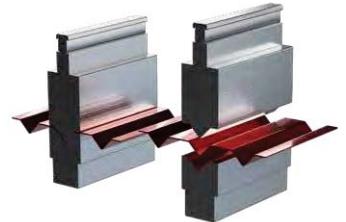
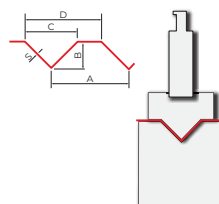


Special Tools examples



SPE4

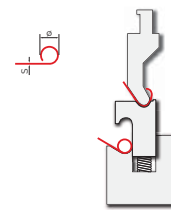
SPE4 Example of Application



SPE5

→ Hinges

SPE5 Example of Application



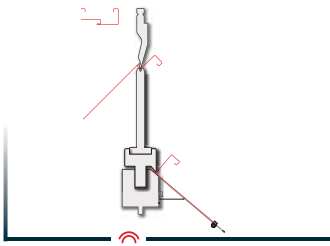
SPE-P4

SPE-P4 Example of Application



Special Tools examples

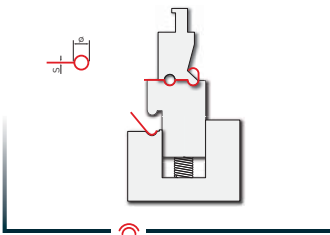
Pre-bending and flattening



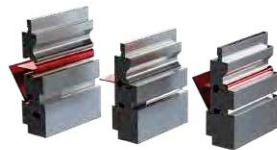
Example of Application



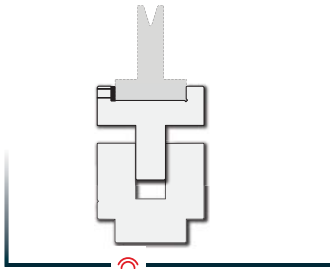
SPE6



SPE6 Example of Application



SPE9



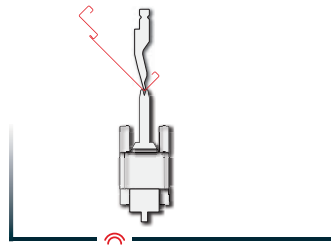
SPE9 Example of Application



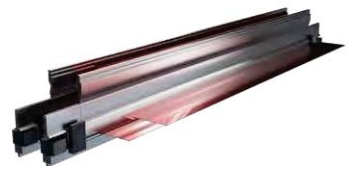
Special Tools examples



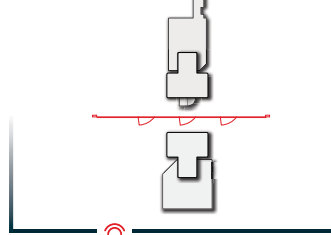
Special-Profile Doorframe



Example of Application



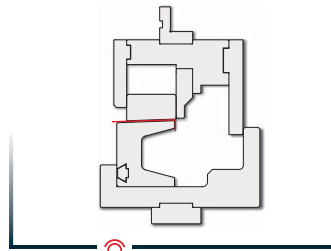
SPE10



SPE10 Example of Application



SPE12



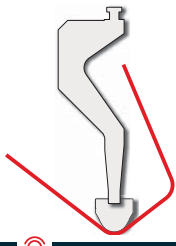
SPE12 Example of Application





Special Tools examples

Special-Profile



Example of Application



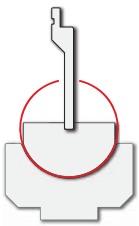
Special-Profile - Conical pole



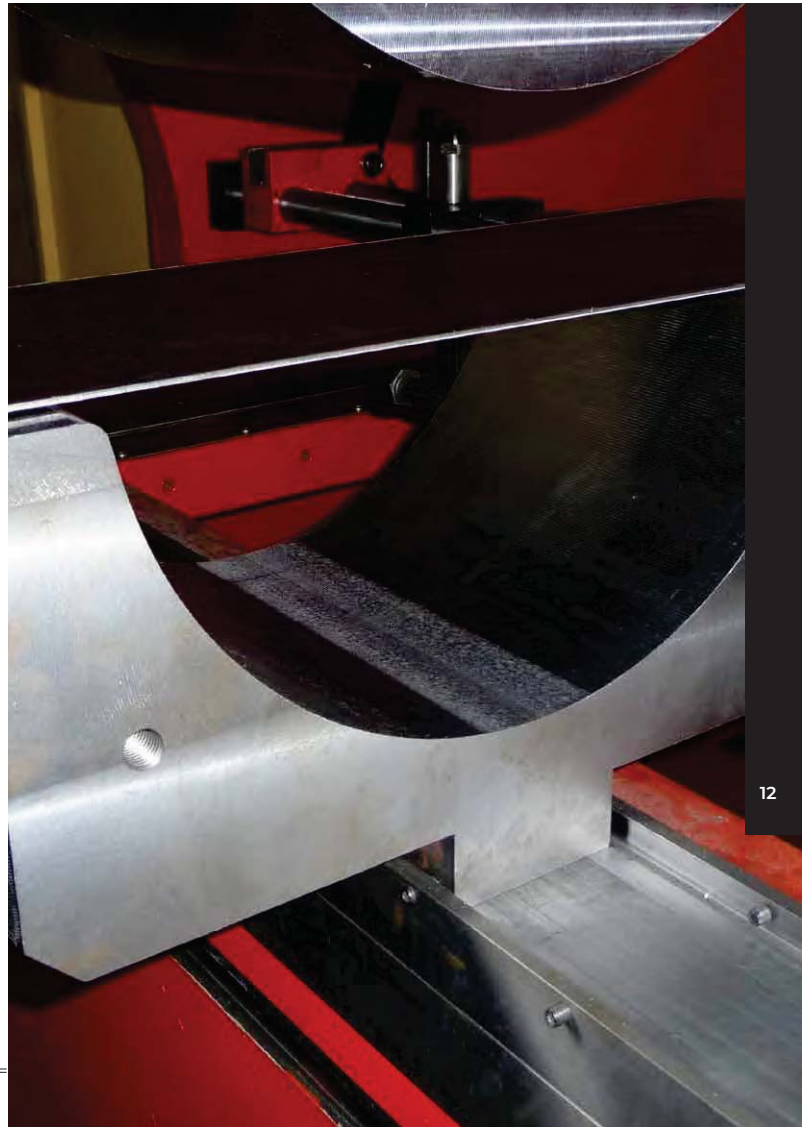
Example of Application



Special-Profile - Circular pole



Example of Application



Special Tools examples

Special-Profile



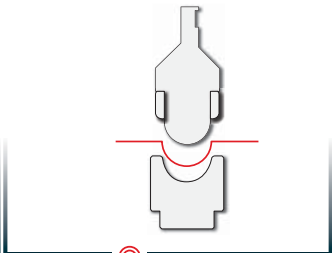
Special-Profile - Kitchen Hoods



Special-Profile



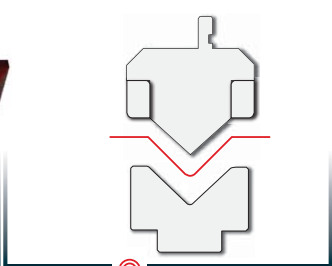
Large radii



Special-Profile - Kitchen Hoods



Pressing





## ROLLERI ACCESSORIES

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## Features

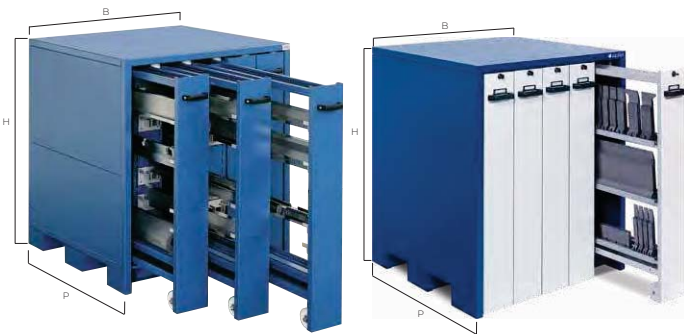
- Protection against contamination and damage
- Easy access to tools
- Clear and tidy storage
- Grooves in the construction to position easily the cabinet by means of fork lift trucks
- Shelves with variable positioning into drawers
- Two different lines: Standard and Top
- Various colorations available on request

### STANDARD Series

- 1.5 mm (0.59 in) thickness structure
- Payload: 250-280 kg for each drawer

### TOP Series

- 3 mm (0.118 in) thickness structure
- Payload: 900 kg for each drawer
- Compatible for every kind of bending tools
- All drawers are individually lockable and are equipped with labeling fields
- Boreholes in a 25 mm (0.98 in) pattern allow the variable mounting of tool retainers



## Tooling cabinets - STANDARD Series



Approx. 20 m of tools		Max. tool length: 835 mm (32.87 in)		280 kg max./drawer	
<b>ARM 835-4</b>					
Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 835-4	850 [33.46]	1240 [48.82]	1050 [41.34]	4 [CS-1]	271.0 kg

N° Shelves	Rolleri Ref.	Tools tang [mm]	Tools tang [in]
16	UC-13-1	13	0.51
4	UL-13-3	13	0.51

Approx. 25 m of tools		Max. tool length: 835 mm (32.87 in)		280 kg max./drawer	
<b>ARM 835-5</b>					
Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 835-5	1040 [40.94]	1240 [48.82]	1050 [41.34]	5 [CS-1]	350.0 kg

N° Shelves	Rolleri Ref.	Tools tang [mm]	Tools tang [in]
20	UC-13-1	13	0.51
5	UL-13-3	13	0.51



Approx. 26/29 m of tools		Max. tool length: 1.060 mm (41.73 in)		250 kg max./drawer	
<b>ARM 1060-4.13</b>					
Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 1060-4.13	850 [33.46]	1240 [48.82]	1360 [53.54]	4 [CS-2]	340.0 kg

N° Shelves	Rolleri Ref.	Tools tang [mm]	Tools tang [in]
20	UL-13-4	13	0.51

Approx. 31.5/32 m of tools		Max. tool length: 1.060 mm (41.73 in)		250 kg max./drawer	
<b>ARM 1060-5.13</b>					
Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 1060-5.13	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 [CS-2]	400.0 kg

N° Shelves	Rolleri Ref.	Tools tang [mm]	Tools tang [in]
25	UL-13-4	13	0.51



Tooling cabinets - **STANDARD Series**

Approx. 26/29 m of tools Max. tool length: 1060 mm (41.73 in) 250 kg max./drawer

ARM 1060-4 / -CV					
Rolleri Ref.	B [mm] [in]	H [mm] [in]	P [mm] [in]	Drawers	Weight
ARM 1060-4	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	3400 kg
ARM 1060-4-CV	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	3510 kg
N° Shelves	Rolleri Ref.	Tools Tang [in]	N° Shelves	Rolleri Ref.	Tools Tang [in]
ARM 1060-4					
16	UC-20-2	20 mm [0.79]	20	UC-20-1	20 mm [0.79]
ARM 1060-4-CV					
4	UL-20-4	20 mm [0.79]	10	UL-20-4	20 mm [0.79]

Approx. 22,5/22 m of tools Max. tool length: 1060 mm (41.73 in) 250 kg max./drawer

ARM 1060-5 / -CV					
Rolleri Ref.	B [mm] [in]	H [mm] [in]	P [mm] [in]	Drawers	Weight
ARM 1060-5	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-2)	4000 kg
ARM 1060-5-CV	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-2)	4900 kg
N° Shelves	Rolleri Ref.	Tools Tang [in]	N° Shelves	Rolleri Ref.	Tools Tang [in]
ARM 1060-5					
20	UC-20-2	20 mm [0.79]	30	UC-20-1	20 mm [0.79]
ARM 1060-5-CV					
5	UL-20-4	20 mm [0.79]	10	UL-20-4	20 mm [0.79]



Approx. 20,8/21,2 m of tools Max. tool length: 1060 mm (41.73 in) 250 kg max./drawer

ARM 1060-4-T / -CV					
Rolleri Ref.	B [mm] [in]	H [mm] [in]	P [mm] [in]	Drawers	Weight
ARM 1060-4-T	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	3400 kg
ARM 1060-4-T-CV	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	3950 kg
N° Shelves	Rolleri Ref.	Tools Tang [in]	N° Shelves	Rolleri Ref.	Tools Tang [in]
ARM 1060-4-T					
8	UL-13-4	13 mm [0.51]	16	UC-13-1	13 mm [0.51]
ARM 1060-4-T-CV					
8	UT-4	13 mm [0.51]	8	UT-4	13 mm [0.51]

Approx. 26/41,6 m of tools Max. tool length: 1060 mm (41.73 in) 250 kg max./drawer

ARM 1060-5-T / -CV					
Rolleri Ref.	B [mm] [in]	H [mm] [in]	P [mm] [in]	Drawers	Weight
ARM 1060-5-T	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-2)	4000 kg
ARM 1060-5-T-CV	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-2)	4000 kg
N° Shelves	Rolleri Ref.	Tools Tang [in]	N° Shelves	Rolleri Ref.	Tools Tang [in]
ARM 1060-5-T					
10	UL-13-4	13 mm [0.51]	24	UC-13-1	13 mm [0.51]
ARM 1060-5-T-CV					
10	UT-4	13 mm [0.51]	8	UT-4	13 mm [0.51]



Cabinets equipment and Accessories - **STANDARD Series**



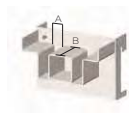
**UC-Shelves**

Model	L [mm]	L [in]	A [mm]	A [in]	B [mm]	B [in]	Weight
UC-13-1	125	4.92	13	0.51	76	2.99	0.5 kg
UC-13-2	250	9.84	13	0.51	232	9.13	1.0 kg
UC-20-1	125	4.92	20	0.79	76	2.99	0.5 kg
UC-20-2	250	9.84	20	0.79	232	9.13	1.0 kg

**UL-Shelves**

Model	L [mm]	L [in]	B [mm]	B [in]	Weight
UL-13-1	270	10.63	13	0.51	1.2 kg
UL-13-2	580	22.83	13	0.51	2.5 kg
UL-13-3	1050	41.34	13	0.51	4.6 kg
UL-13-4	1360	53.54	13	0.51	6.0 kg
UL-20-1	270	10.63	20	0.79	1.4 kg
UL-20-2	580	22.83	20	0.79	3.2 kg
UL-20-3	1050	41.34	20	0.79	5.8 kg
UL-20-4	1360	53.54	20	0.79	7.5 kg

2 Pieces



Holder



Holder

**UT-Shelves**

Model	L [mm]	L [in]	Weight
UT1	270	10.63	1.4 kg
UT2	580	22.83	3.2 kg
UT3	1050	41.34	5.8 kg
UT4	1360	53.54	7.5 kg

**UV-Shelves**

Model	L [mm]	L [in]	Weight
UV-1	270	10.63	1.0 kg
UV-2	580	22.83	2.0 kg
UV-3	1050	41.34	4.3 kg
UV-4	1360	53.54	5.5 kg

Suitable for punches with safety pins



Holder



Holder

**CS-Drawers**

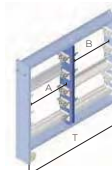
Model	T [mm]	T [in]	L [mm]	L [in]	Weight
CS-1	1050	41.34	856	33.70	22.0 kg
CS-2	1360	53.34	1166	45.91	25.0 kg

**CV-Drawers**

Model	T [mm]	T [in]	A [mm]	A [in]	L [mm]	L [in]	Weight
CV-1	1050	41.34	580	22.83	270	10.63	7.0 kg
CV-2	1360	53.34	580	22.83	580	22.83	7.0 kg



Holder



Holder

## Tooling cabinets - TOP Series

Approx. 16 m of tools Max. tool length: 850 mm (33.46 in) 900 kg max./drawer

WKS013 Set A						
Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight	
WKS013 Set A	660 [25.98]	1240 [48.81]	1050 [41.33]	3	300.0 kg	

N°	WKS013 Set A
9	Tool retainer WKH102
3	Tool retainer WEB360
12	Partition plate TRB360



Approx. 44 m of tools Max. tool length: 1050 mm (41.34 in) 900 kg max./drawer

WKS006 Set A						
Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight	
WKS006 Set A	1040 [40.94]	2140 [84.25]	1300 [51.18]	5	720.0 kg	

N°	WKS006 Set A
20	Tool retainer WKH103
10	Universal trays
60	Storage boxes KLP2000 (m)
1	Perforated panel WKH430



Approx. 26/33 m of tools Max. tool length: 850 mm (33.46 in) 900 kg max./drawer

WKS001 Set A - WKS003 Set A						
Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight	
WKS001 Set A	1040 [40.94]	1240 [48.82]	1050 [41.33]	5	330.0 kg	
WKS003 Set A	1040 [40.94]	1240 [48.82]	1360 [53.54]	5	590.0 kg	

N°	WKS001 Set A	N°	WKS003 Set A
15	Tool retainer WKH102	15	Tool retainer WKH103
5	Tool retainer WEB360	5	Tool retainer WEB366
25	Partition plate TRB360	25	Partition plate TRB360



Approx. 44 m of tools Max. tool length: 850 mm (33.46 in) 900 kg max./drawer

WKS035 Set A						
Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight	
WKS035 Set A	1040 [40.94]	1620 [63.78]	1050 [41.33]	5	590.0 kg	

N°	WKS035 Set A
20	Tool retainer WKH103
5	Tool retainer WEB366
25	Partition plate TRB360



## Cabinets equipment and Accessories - TOP Series



WKH102 - WKH103

Model	L mm [in]	P mm [in]	001	003	006	013	035
WKH102	180 [7.08]	1050 [41.33]	●	●	●	●	●
WKH103	180 [7.08]	1300 [51.18]	●	●	●	●	●

WKH502 - WKH504

Model	L mm [in]	P mm [in]	001	003	006	013	035
WKH502	180 [7.08]	1050 [41.33]	●	●	●	●	●
WKH504	180 [7.08]	1300 [51.18]	●	●	●	●	●

Bending tools retainer



Universal trays



WEB360 - WEB366

Model	L mm [in]	P mm [in]	001	003	006	013	035
WEB360	180 [7.08]	1050 [41.33]	●	●	●	●	●
WEB366	180 [7.08]	1300 [51.18]	●	●	●	●	●

TRB360

Model	L [mm]	P [mm]	001	003	006	013	035
TRB360	-	-	●	●	●	●	●

Retainer for measurements tools and small parts



Partition plates



### Accessories

KIT OF MAGNETIC HOLDERS

2 pieces | 44 L x 68 H x 40.2 P



KIT OF HOLDERS FOR SPACERS

2 pieces | 167.5 L x 68 H x 65.1 P



HANGABLE SHELF

1 piece | 450 L x 245 H x 65 P





## Tooling Trolley

Approx. 26/29 m of tools		Max. tool length: 1060 mm (43.73 in)		250 kg max./shelf	
<b>A Trolley</b>					
B mm [in]	H mm [in]	P mm [in]	Shelves	Weight	
1060 [41.73]	1520 [59.84]	1160 [45.67]	30	108.0 kg <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">21</span>	

Approx. 26/29 m of tools		Max. tool length: 1060 mm (43.73 in)		250 kg max./shelf	
<b>T Trolley</b>					
B mm [in]	H mm [in]	P mm [in]	Shelves	Weight	
1060 [41.73]	1520 [59.84]	1160 [45.67]	21	175.0 kg <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">22</span>	

Approx. 26/29 m of tools		Max. tool length: 1060 mm (43.73 in)		250 kg max./shelf	
<b>B Trolley</b>					
B mm [in]	H mm [in]	P mm [in]	Shelves	Weight	
1060 [41.73]	1520 [59.84]	1160 [45.67]	21	135.0 kg <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">23</span>	



## Tooling Trolley



250 kg max./shelf			
<b>WKW582</b>			
L mm [in]	H mm [in]	P mm [in]	
582 [22.91]	922 [36.30]	922 [36.30]	

250 kg max./shelf			
<b>WSW583 Plus</b>			
L mm [in]	H mm [in]	P mm [in]	
582 [22.91]	922 [36.30]	922 [36.30]	



Included	
Sloped shelves	2
Non-slip mat	1
Drawer	1
Fixed castors	2
Guided rollers with brake	2

Included	
Sloped shelves	2
Tools retainer	3
Drawer	1
Fixed castors	2
Guided rollers with brake	2

## Bending Box

### Bending Box

Per piece	1,6 kg
-----------	--------

Retainer for measurements tools and small parts:  
 ▶ PRECISION DIGITAL CALIBER  
 ▶ SET SQUARE  
 ▶ ANGLE MEASURING DEVICE



## Squaring Arms

### MSA - magnetic

MSAD	Right	per piece	1,4 kg
MSAS	Left	per piece	1,4 kg

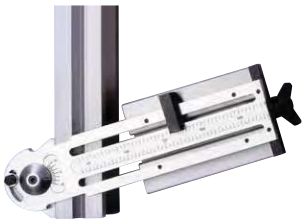




## Supporting Arms and Back Gauge

### AS

Per piece 35 kg



### AS FIX

Per piece 30 kg



### RIF-Supporting Arm

Roller Ref.	L (mm)	L (in)	Weight
RIF500	500	19.68	70 kg
RIF1000	1000	39.37	120 kg
RIF1500	1500	59.05	170 kg

- ▶ To position big sheet metal correctly
- ▶ Greater surface guarantees a trouble-free support for sheet metals
- ▶ Easy handling

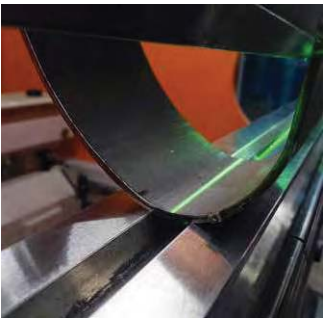
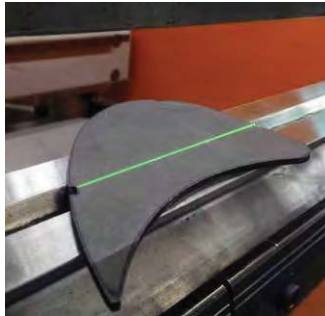
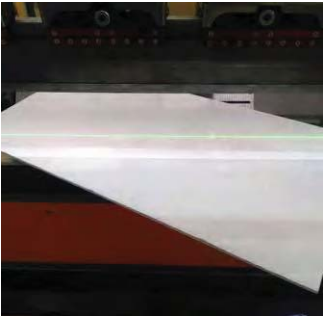


### Laser Tracker

- There will be no need of some steps of programming and the accuracy will be instantly millimetric
- Execution speed and accuracy
- Universal simple installation
- Compact and functional design
- Reliable result also in multi-station

Ideal for:

- Rolling
- Conic bending (funnels and hoppers)
- Dressing cycle (transverse stiffeners for thin panels)
- Irregular profiles difficult to be leant to posterior backgauges
- Marked bending (e.g. laser marking or other reference with marks)



	L [mm]	L [in]	Weight
Smart Holder	600	23.62	3.0 kg
Laser Tracker	-	-	3.0 kg





## MORE ROLLERI TOOLS

CLAMPING SYSTEMS	270 - 271
SHEAR BLADES	272 - 273
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LASER CONSUMABLES	276 - 277

Clamping Systems



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TOOLS	CLAMPING ROLLERI	UPPER SIDE	LOWER SIDE	VERTICAL CHANGE	HORIZONTAL CHANGE	PNEUMATIC VERSION	HYDRAULIC VERSION	MANUAL VERSION
	ROL200 KDS	●	-	●	●	●	●	-
	ROL200	●	-	●	-	●	●	●
	ROL4	●	-	-	●	-	●	●
	FAST CLAMP	●	-	●	●	-	-	●
	DOUBLE FAST CLAMP	●	-	●	●	-	-	●
	EASY CLAMP	●	-	-	●	-	-	●
	DOUBLE EASY CLAMP	●	-	-	●	-	-	●
	ROL2	-	●	-	-	●	●	●
	W ROL	●	-	●	●	●	●	-
	W ROL 2	-	●	-	-	●	●	-
	ROL3	●	-	●	●	-	●	-
	UNIVERSAL FAST CLAMP	●	-	●	-	-	-	●
	UNIVERSAL EASY CLAMP	●	-	-	●	-	-	●



## Shear Blades

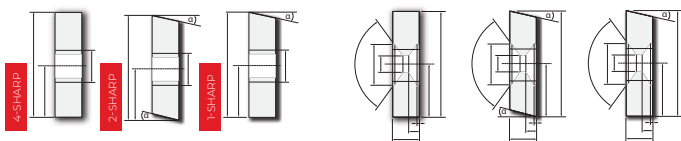
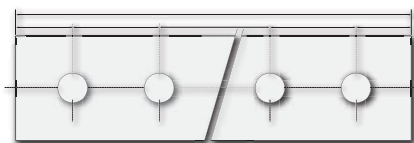


Rolleri has been producing shear blades for more than 20 years, using high quality steel to guarantee reliability and wear resistance.

Each product is studied on customer's needs: material to cut, holes and hardening upon your request. Blades with 1, 2 or 4 cutting edges with threaded holes or dimpled holes.

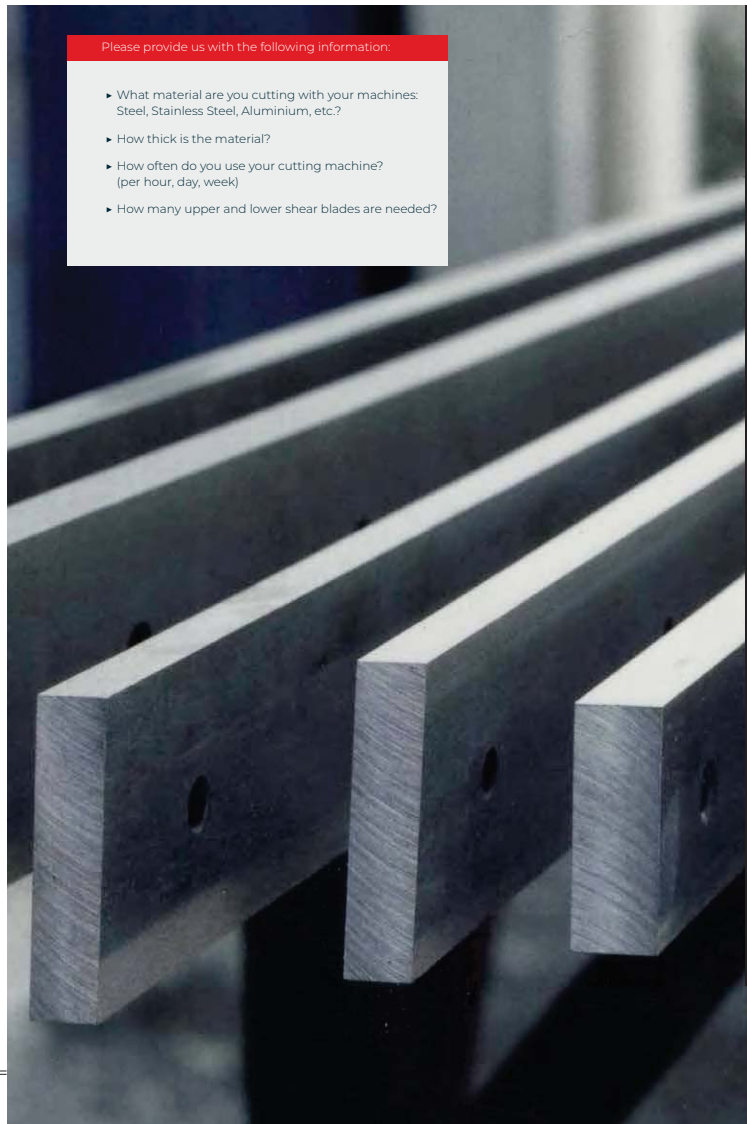
### Available sizes mm (in)

50 (1.97)	55 (2.17)	60 (2.36)	65 (2.56)	70 (2.76)	75 (2.95)	80 (3.15)	85 (3.35)	90 (3.54)	100 (3.94)
50x10 (1.97x0.39)									
50x11 (1.97x0.43)									
50x12 (1.97x0.47)	55x12 (2.17x0.47)	60x12 (2.36x0.47)							
50x13 (1.97x0.51)	55x13 (2.17x0.51)	60x13 (2.36x0.51)	65x13 (2.56x0.51)	70x13 (2.76x0.51)					
50x14 (1.97x0.55)	55x14 (2.17x0.55)	60x14 (2.36x0.55)	65x14 (2.56x0.55)	70x14 (2.76x0.55)					
50x15 (1.97x0.59)	55x15 (2.17x0.59)	60x15 (2.36x0.59)	65x15 (2.56x0.59)	70x15 (2.76x0.59)	75x15 (2.95x0.59)				
	55x16 (2.17x0.63)	60x16 (2.36x0.63)	65x16 (2.56x0.63)	70x16 (2.76x0.63)	75x16 (2.95x0.63)	80x16 (3.15x0.63)			
	55x17 (2.17x0.67)	60x17 (2.36x0.67)	65x17 (2.56x0.67)	70x17 (2.76x0.67)	75x17 (2.95x0.67)				
	55x18 (2.17x0.71)	60x18 (2.36x0.71)	65x18 (2.56x0.71)	70x18 (2.76x0.71)	75x18 (2.95x0.71)	80x18 (3.15x0.71)	85x18 (3.35x0.71)		
	55x19 (2.17x0.75)	60x19 (2.36x0.75)	65x19 (2.56x0.75)	70x19 (2.76x0.75)	75x19 (2.95x0.75)	80x19 (3.15x0.75)	85x19 (3.35x0.75)		
	55x20 (2.17x0.79)	60x20(2.36x0.79)	65x20(2.56x0.79)	70x20(2.76x0.79)	75x20(2.95x0.79)	80x20 (3.15x0.79)	85x20(3.35x0.79)	90x20(3.54x0.79)	100x20(3.94x0.79)
					75x21 (2.95x0.83)	80x21 (3.15x0.83)	85x21 (3.35x0.83)	90x21(3.54x0.87)	
					75x22 (2.95x0.87)	80x22 (3.15x0.87)	85x22 (3.35x0.87)	90x22(3.54x0.87)	100x22(3.94x0.87)
					75x23 (2.95x0.91)	80x23 (3.15x0.91)	85x23 (3.35x0.91)	90x23 (3.54x0.91)	
					75x24(2.95x0.94)	80x24 (3.15x0.94)	85x24(3.35x0.94)	90x24(3.54x0.94)	
					75x25 (2.95x0.98)	80x25 (3.15x0.98)	85x25(3.35x0.98)	90x25(3.54x0.98)	100x25(3.94x0.98)
									100x26(3.94x1.02)
									100x27(3.94x1.06)
									100x28(3.94x1.10)
									100x29(3.94x1.14)
									100x30(3.94x1.18)



Please provide us with the following information:

- ▶ What material are you cutting with your machines: Steel, Stainless Steel, Aluminium, etc.?
- ▶ How thick is the material?
- ▶ How often do you use your cutting machine? (per hour, day, week)
- ▶ How many upper and lower shear blades are needed?



## Panel bending tools

- ▶ In-house construction (no reseller or dealer)
- ▶ Production according to your specifications
- ▶ Every single tool is traceable thanks to a unique serial number stamped after the first quality control
- ▶ Precision grinding (tolerance of +/-0.01 mm)
- ▶ Exact parallelism
- ▶ Use of the best materials, guaranteed high resistance and tensile strength



## Punching Tools



**ROLLERI TYPE R1** → Compatible with OEM: Amada, Amada ABS, Wilson HP, Wilson HP WLS and Mate Ultra Tec

- ▶ A-E Station
- ▶ Multitools
- ▶ Accessories

**ROLLERI TYPE R2** → Compatible with OEM: Trumpf

- ▶ Standard Tools
- ▶ Multitools
- ▶ Slitting Tools
- ▶ Accessories

**ROLLERI TYPE R5** → Compatible with OEM: Salvagnini

- ▶ Type 3 Tools

**ROLLERI TYPE R4** → Compatible with OEM: Geka, Peddinghaus, Mubéa-Sunrise, Seifer, Alfra, Imac, Ficep, Kingsland

- ▶ Ironworker

**SPECIAL TOOLS** → Fully compatible with Thick Turret punching machine



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## Laser consumables



### CO2 LASER LENSES

- ROLLERI Type A Lenses
- <math>0.2\%</math> absorption
- Extended life
- Guaranteed quality
- Meniscus and plano-convex lenses

### ROLLERI Type C Lenses

- <math>0.13\%</math> absorption
- Extended life
- Suitable for high-power lasers
- Compatible with HeNe lasers beam
- Meniscus and plano-convex lenses

### FIBER LASER LENSES

- Made of fused silica for high power
- Minimal absorption percentage
- Coated surface

### PROTECTIVE WINDOWS

- Better results
- Better quality-price ratio
- Surface coated
- Low absorption

### NOZZLES

- Compatible with most OEM lasers
- Tight production tolerance
- Normal and chromed nozzles for CO2 lasers
- Nozzles for fiber lasers
- Ceramics
- Accessories and spare parts



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TOOLS SPECIFICATION AND MODIFICATIONS

<b>SPECIFICATION OF ROLLER TOOLING</b>	280 - 281
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### Specification of Rolleri tooling

- ▶ Every single tool is traceable thanks to a unique serial number stamped after the first quality control
- ▶ All tools with batch number and therefore a complete tool traceability
- ▶ All tools induction hardened to 54-60 HRC
- ▶ Precision grinding (tolerance of +/-0.01 mm)
- ▶ ISO 9001:2015 Certification
- ▶ Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

### Standard Tools material

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4 42Cr: 900-1150 N/mm <sup>2</sup>	900-1150 N/mm <sup>2</sup>	291 - 36.9 HRC	54 - 60 HRC
C45 C45: 560-710 N/mm <sup>2</sup>	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC

Specifications for the maximum press force kN/m are indicated as such, 1 t = 10 kN.

### Rolla-V Dies material

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1/2 / 2.5 / 3 / 4	42CrMo4 42Cr: 900-1150 N/mm <sup>2</sup>	900-1150 N/mm <sup>2</sup>	55 HRC
Inserts	1/2 / 2.5	Toolox 44	1450 N/mm <sup>2</sup>	through hardened 44 HRC
Inserts	3 / 4	Toolox 33	1100 N/mm <sup>2</sup>	55 HRC

Specifications for the maximum press force kN/m are indicated as such, 1 t = 10 kN.

### Special and Heavy duty Tools material

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4 42Cr: 900-1150 N/mm <sup>2</sup>	900-1150 N/mm <sup>2</sup>	291 - 36.9 HRC	54 - 60 HRC
C45 C45: 560-710 N/mm <sup>2</sup>	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC
12767 12767: 1100-1320 N/mm <sup>2</sup>	1100-1320 N/mm <sup>2</sup>	36 - 42 HRC	54 - 60 HRC
CS3 CS3: 610-760 N/mm <sup>2</sup>	610-760 N/mm <sup>2</sup>	16 - 19 HRC	60 - 62 HRC

Specifications for the maximum press force kN/m are indicated as such, 1 t = 10 kN.

### Specification of Rolleri tooling



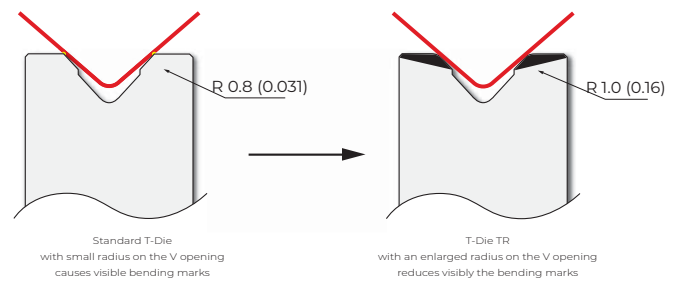
### Prevention or Reduction of Bending Marks

One of the challenges of bending is preventing the profile from having bending marks, such as scratches and abrasions on the surface areas. Especially profiles made of:

- ▶ Stainless Steel
- ▶ Aluminium
- ▶ Painted metal panels

Often because of friction between sheet metal and die, after bending process, you could see some marks on material. In order to avoid this inconvenience, Rolleri suggests you some possible solutions:

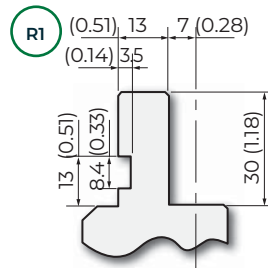
- ▶ Bending Foil
- ▶ Polyurethane inserts
- ▶ Synthetic Dies
- ▶ Rolla-V
- ▶ Roll Prime **NEW**
- ▶ Enlarged radius on the V opening of a die



## Tools modifications

### Modified Tangs

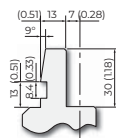
- Roller Punches Type R1, R2, and R3 can be used on other press brake machines by modifying the tang
- Precision ground (Tolerance of +/-0.01 mm)
- Exact parallelism



### OT

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

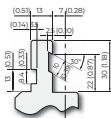
For:  
Amada fast clamping system



### A1

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove in addition to 8.4 x 3.5 mm  
(0.33 x 0.14 in) groove for:  
Pneumatic clamping system

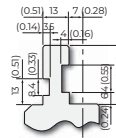


### A6

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove in addition to 8.4 x 3.5 mm  
(0.33 x 0.14 in) groove for:

- Bystronic-Beyeler Euro
- Safan

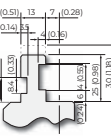


### A7

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove in addition to 8.4 x 3.5 mm  
(0.33 x 0.14 in) groove and shortened tang for:

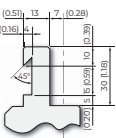
- Bystronic-Beyeler Euro
- Safan



### A8

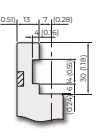
835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove for:  
Hydraulic clamping system  
Casparini



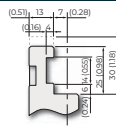
### A41

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in



### A42

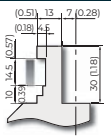
835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in



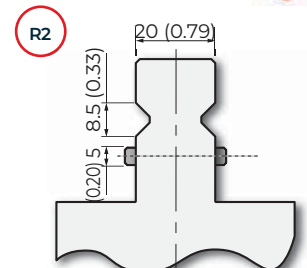
### A43

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove with steel bar:  
Segmented punches

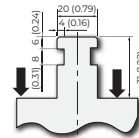


## Tools modifications



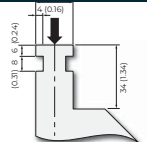
### Example 1

Modification of R2 punch with  
shoulder bearing

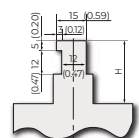


### Example 2

Modification of R2 punch with  
head bearing



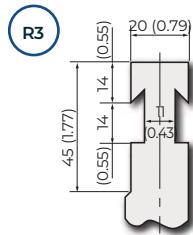
### Example 3



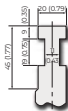
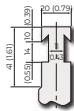
## Tools modifications



Example 1



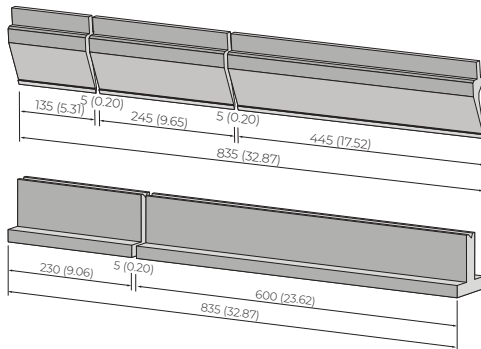
Example 2



### Special Sectioning

- ▶ Individual sectioning of your punches and dies
- ▶ Every cut wastes about 5 mm material
- ▶ Production according to your specifications

Example:

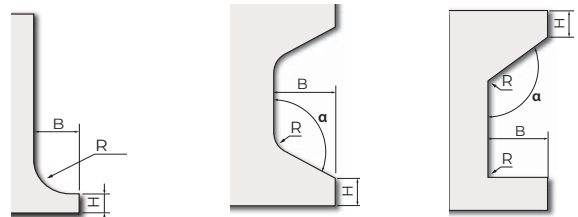


## Tools modifications



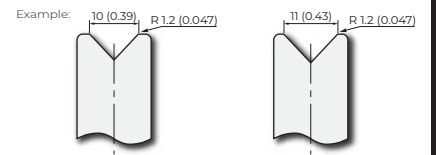
### Horn Pieces

- ▶ Individual horn pieces on punches and dies
- ▶ On one or both sides



### Modifying the V-Opening

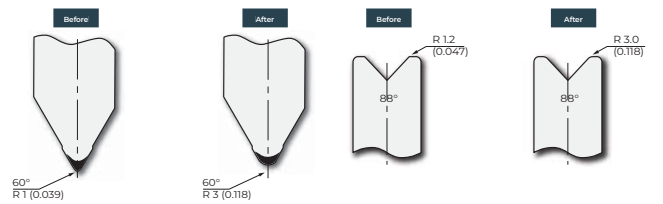
- ▶ Individual modification for dies
- ▶ Production according to your specifications



### Radius Modifications

- ▶ Production according to your specifications

Example:

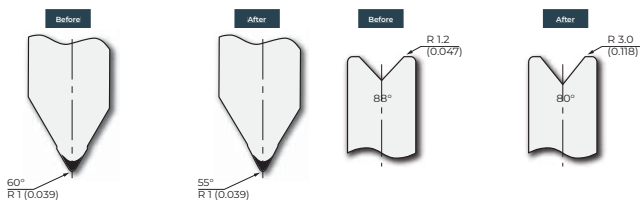


## Tools modifications

### Angle Modifications

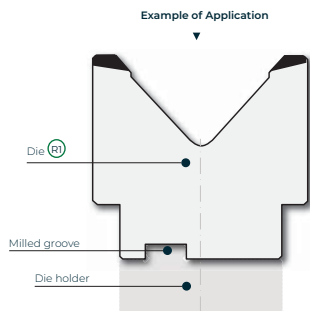
- Production according to your specifications

Example:



### Grooves for Dies

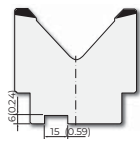
- Milling of grooves to use in other press brakes



#### A28

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

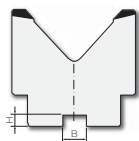
Groove for die holder



#### A29

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove production according to your specifications



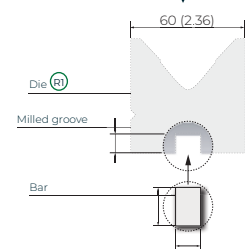
## Tools modifications



### Modified Tangs

Rolleri can mill a groove in the die base and insert a bar of the correct dimensions to use the die in a different clamping system.

#### Example of Application

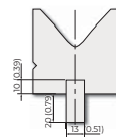


#### A30

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove Bars: 13 x 30 mm (0.51 x 1.18 in) for

- R2
- R3

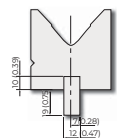


#### A31

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove Bars: 12 x 29 mm (0.47 x 1.14 in) for

- R4

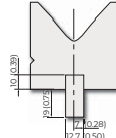


#### A32

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove Bars: 12.7 x 29 mm (0.50 x 1.14 in) for

- R4

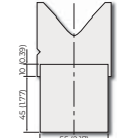


#### A44

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove Bars: 55 x 55 mm (2.17 x 2.17 in) for

- RX EHT

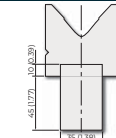


#### A45

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove Bars: 35 x 55 mm (1.38 x 2.17 in) for

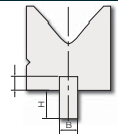
- RX Weinbrenner



#### AX

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Individual Groove Bars for other systems

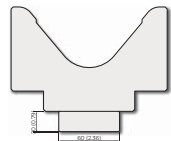


#### A60

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Plate for (R) Dies:

- M103.80.125
- M130.80.160
- M195.70.200



#### A90

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Plate for:

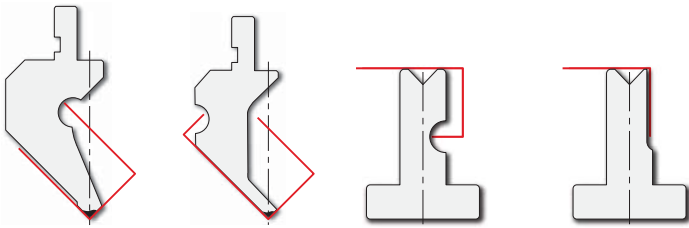
- M195.70.200 (R)
- RVM90-4 Rolla-V die



## Tools modifications

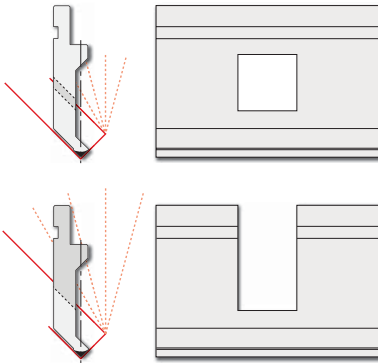
### Gaps

- Production according to your specifications



### Windows

- Production according to your specifications



## Special Treatments



### Rolleri BLACKFIRE

Rolleri BLACKFIRE is a particular tool coating which guarantees corrosion resistance and special design. This chemical treatment is a long-lasting solution to surface oxidation. During the phosphatising process, the metal surface of tools changes because of phosphatic crystals formation, which are chemically bound to the tool steel. We can take advantage of these chemical compounds to increase corrosion resistance, so that your tools will have longer operational life. The glossy black colour of BLACKFIRE represents a new technology which combines usage advantages and better aesthetics. Tools with BLACKFIRE treatment have different delivery time than standard tools.



### Rolleri FREEZINC

Take advantage of Rolleri new and special surface treatment. This new improvement gives you the following big advantages:

- No metal residue left on tools during bending of galvanized sheet metal or other sheet metal that tends to leave residue
- No need to clean tools from residue
- Down-time reduction due to tool cleaning and consequently increase in productivity
- Tool protection from oxidation
- Tools aesthetically stand out
- Reduced tool wear and consequently longer operational life
- Lower chances to damage the sheet metal
- Lower risk that the sheet metal gets stuck in the V die opening.

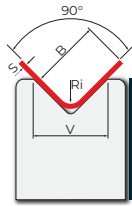


### Press Force Table

The press force table works exactly in the same way as the bending ruler and is very useful to those who deal with sheet metal profiles. It can assist you from the design of profiles, to technical construction, to the buying of tools, and to the finished profile made with a press brake.

In the first column on the left the thickness of the sheet metal is marked as (S). In the three first lines you can find the die V opening (V), the minimum internal edge (B), and the ideal inner profile radius (Ri).

By crossing the thickness with the die opening, you will find the necessary press force per meter. As you can see, for each sheet metal thickness you can choose among 5 different V openings. At the bottom of the page you can find correction factors.



S = Thickness  
V = Die V opening  
B = Min. internal edge  
Ri = Inner Profile Radius

		420 N/mm <sup>2</sup>																				
		4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V	
s (mm)		3.0	3.5	4.0	5.5	6.5	8.0	10.5	13.0	16.5	21.0	26.0	32.5	41.0	52.0	65.0	81.5	104.0	130.0	163.0	B	
		0.5	0.7	0.8	1.0	1.3	1.5	2.0	2.5	3.2	4.4	5.0	6.5	8.0	10.0	12.0	15.0	20.0	25.0	37.0	Ri	
0.6	60	50	30	20																		
0.8	120	90	70	50	40																	
1.0		150	110	80	60	50																
1.2			180	120	90	70	50															
1.5				210	150	120	80	60														
2.0					300	230	160	120	90													
2.5						390	270	200	140	110												
3.0							430	310	230	160	120											
4.0								600	440	320	230	180										
5.0									760	540	390	290	220									
6.0										850	620	450	330	250								
8.0											1210	880	700	460	350							
10.0												1510	1090	790	580	440						
12.0													1730	1240	910	660	500					
15.0														2130	1550	1130	810	620				
20.0															3020	2200	1580	1150	890			
25.0																3780	2690	1970	1440			

F  
kN/m

30°	B x 1.6	R=200 N/mm <sup>2</sup>	r x 0.8	Al
60°	B x 1.1			
90°	B x 1.0	R=420 N/mm <sup>2</sup>	r x 1.0	Fe
120°	B x 0.9			
150°	B x 0.7	R=700 N/mm <sup>2</sup>	r x 1.4	INOX











ABOUT US



- ▶ Since 1987 we have been producing standard and special tooling. The family owned company (Francesco and Marco Rolleri) can nowadays be considered one of the largest press brake tooling manufacturers in Europe. We offer a fast and reliable service through our partners all over Europe.
- ▶ The reorganization of our sales force, happened in 2012, has guaranteed a widespread presence of our products in every single market.
- ▶ For this reason, our production was enlarged considerably with an additional hall and many new machines in the year 2016.



ROLLERI WORLD  
Today



- |                              |           |                          |           |
|------------------------------|-----------|--------------------------|-----------|
| Rolleri S.p.A. – Head Office | <b>IT</b> | Rolleri France           | <b>FR</b> |
| Rolleri Baltic               | <b>BA</b> | Rolleri Deutschland GmbH | <b>DE</b> |
| Rolleri Benelux              | <b>BE</b> | Rolleri Polska           | <b>PL</b> |
| Rolleri Do Brasli            | <b>BR</b> | Rolleri Slovensko        | <b>SK</b> |
| Rolleri Trad. Co. China      | <b>CN</b> | Rolleri Ukraine LLC      | <b>UA</b> |
| Rolleri Česká Republika      | <b>CZ</b> | Rolleri USA              | <b>US</b> |
| Rolleri Iberica              | <b>ES</b> | Rolleri UK               | <b>GB</b> |
| Rolleri Finland              | <b>FI</b> |                          |           |



OUR PRODUCTION  
Warehouse, Manufacturing and Quality

► Manufacturing

Besides manufacturing many special tools, our research and development team also designs fast clamping systems in order to increase your productivity.

Technicians and engineers develop for you convenient and practical solutions.

We work with highly complex 3D simulation models and we are able to create bending samples of various profiles.



► Quality

Rolleri is ISO 9001:2015 certified.

For us, being your supplier means helping you to find the best and most convenient tool and to develop a large number of bending solutions. Furthermore, we offer training for your bending department employees.

Our quality control department checks and tests every single tool after a complete production cycle. After a careful inspection, every tool is marked with a serial number and a batch number. This process guarantees complete tool traceability.

Rolleri also guarantees accurate reproduction, high-quality material, induction hardening and precision grinding.



OUR PRODUCTION  
Raw Material and Production

► Raw Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.



► Rolleri Tools

Every tool is manufactured in Rolleri's production facilities. This enables us to guarantee high quality, repeatability and parallelism thanks to high precision grinding.

We use induction hardening at 54-60 HRC for all tools to get the best results for your punches and dies.

Each tool is subjected to quality control and then provided with a serial number to guarantee its traceability.





## OUR PRODUCTION Machinery

### ► Warehouse

With more than 20,000 press brake tools on stock, we hold one of the largest warehouses in Europe. Thanks to this, a large amount of tools is ready to be shipped all around the world.



### ► CNC-Milling

With our state-of-the-art milling centers we can quickly modify tools with high precision.

Very flexible tilting machine heads can carry out a wide variety of processes. This is where grooves, relieves, and other machining types are carried out.



### ► CNC-Profile Grinding

Our CNC-Professional grinding machines guarantee high precision (tolerance of +/-0.01 mm), accurate parallelism and repeatability.

Here you can also retrofit induction hardened and core hardened tools. Radius and angle modifications are precisely carried out upon request.



## OUR PRODUCTION Machinery

### ► Hardening

Tool working areas are exposed to the highest mechanical stress, because press brake force is concentrated on small surfaces. For this reason, press force on tool working areas is very high and it results in high friction between tools and sheet metal to be bent.

In order to have more resistant tools, their surface is hardened. Rollerli uses induction hardening, which penetrates about 3 mm into the tool steel, to guarantee high wear resistance and to offer customers the best solution to competitive prices.



### ► EDM

By using electro-discharge machines, Rollerli can machine hardened and tough materials. This process is based on the definition of the tool shape with a high precision CAD software and the manufacturing of simple and complicated shapes.



### ► 3D printer

The introduction of new "Additive" machines with the possibility of constructing any object with materials similar to steel starting from a 3D design. Thanks to this technology it's possible to reduce the production time of very complex tools and to have fast delivery times.

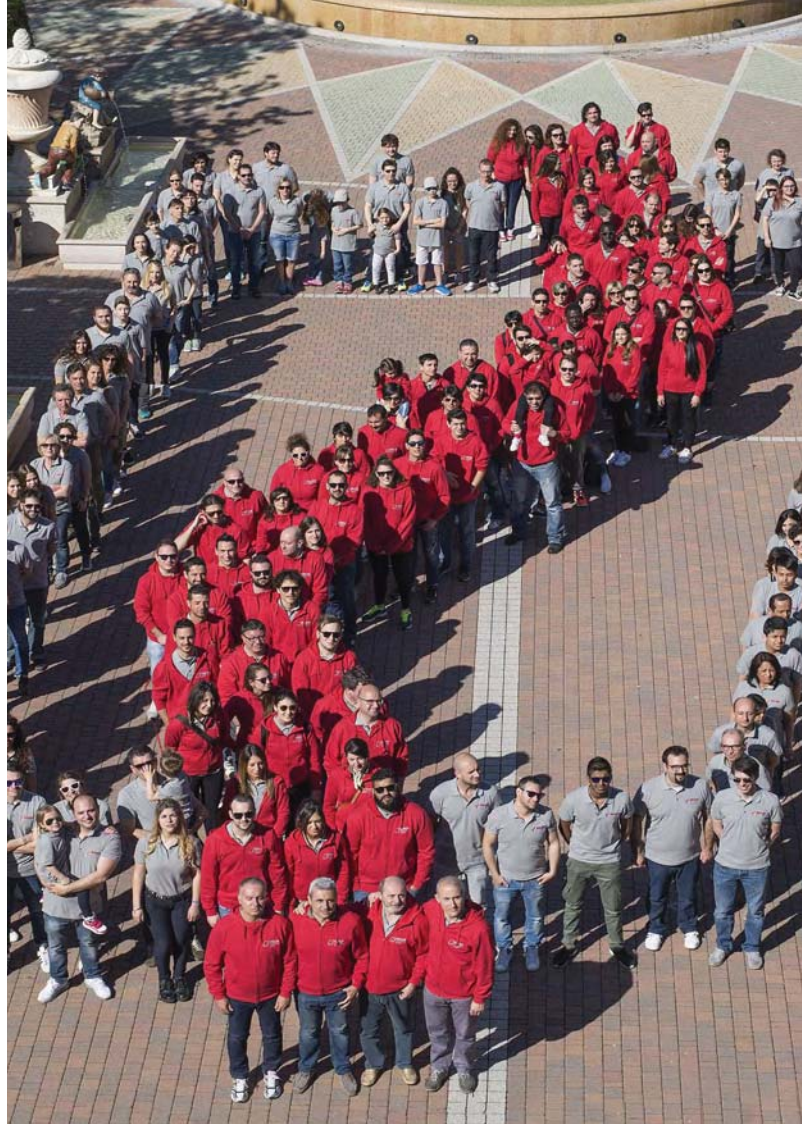




**ROLLER!**  
**BENDING APP**







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