

Compatibility

Punches Roller Type R1 are:

- compatible with press brake machines from:
ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturrospe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- also applicable on all other press brake machines with adapter-systems (see pages 212-217).

Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

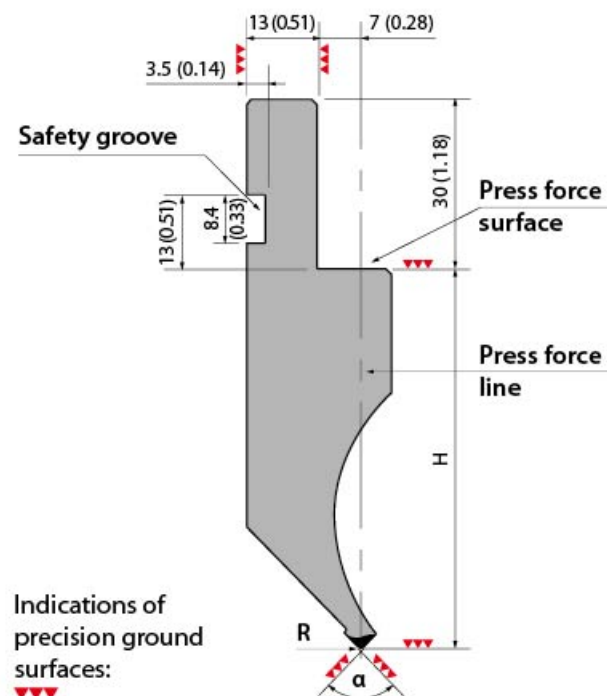
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

Tang

All punches Roller Type R1:

- are standardized with a 8.4 x 3.5 mm (0.331 x 0.138 in) **safety groove**, that keeps the tool from falling out.
- depending on the clamping system: **horizontal** or **vertical**, tool exchange is possible (see pages 198-205)



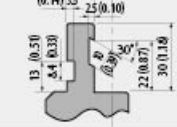
Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 248-249)
- very large stock availability

Modifications from Safety Grooves

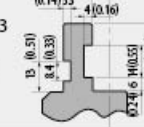
A1

Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
• Pneumatic clamping



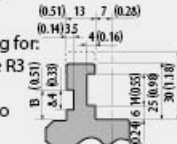
A6

Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
• Roller Type R3
• Bystronic-Beyeler Euro
• Safan



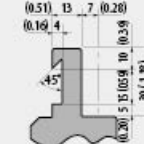
A7

Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
• Roller Type R3
• Bystronic-Beyeler Euro
• Safan



A8

Groove for:
• hydraulic clamping Gasparini



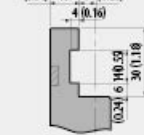
A9

Modified groove for:
• Roller Type R3



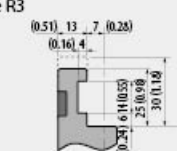
A41

Modified groove for:
• Roller Type R3



A42

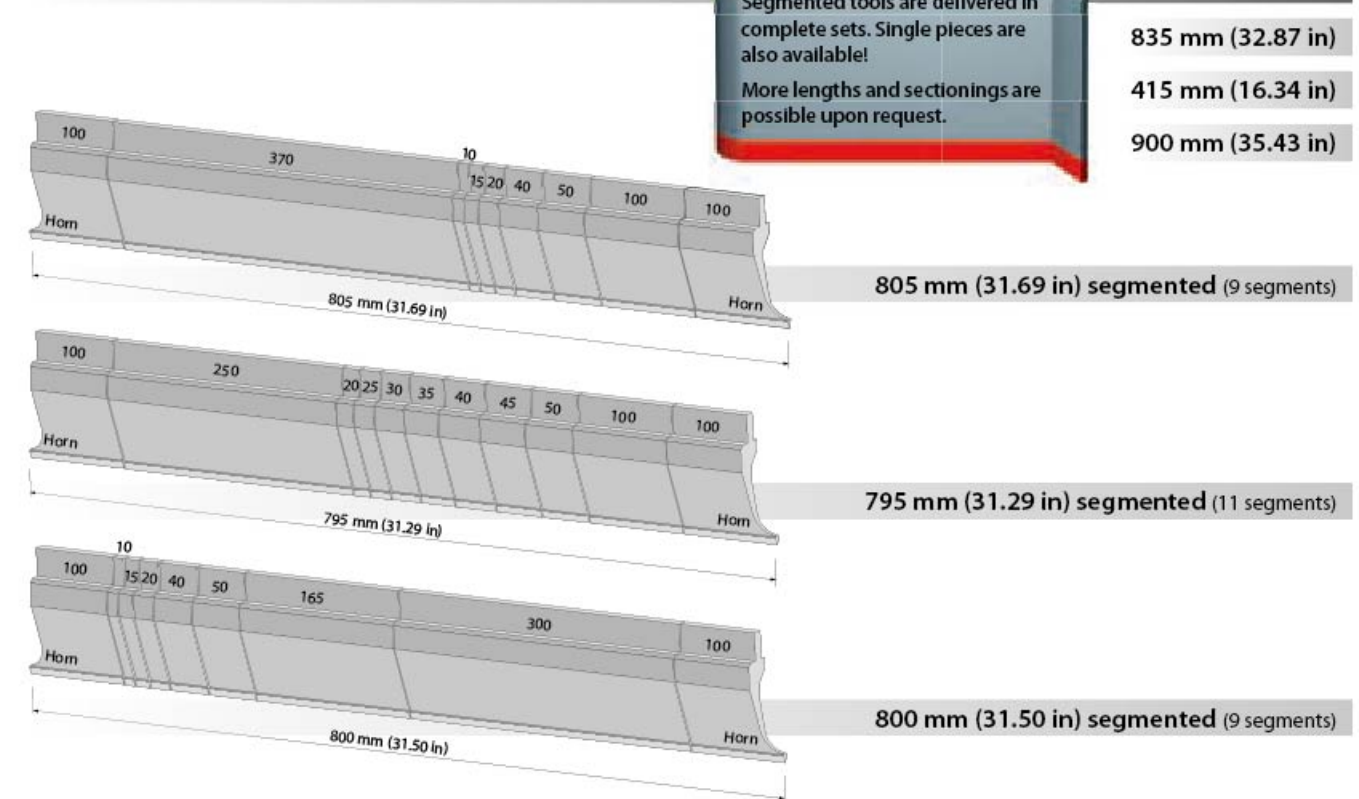
Modified groove for:
• Roller Type R3



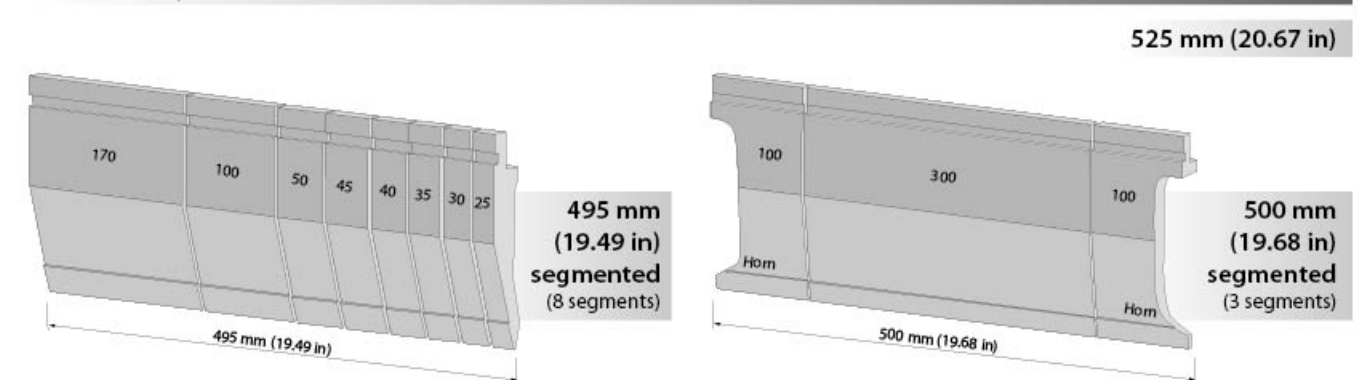
More modifications possible upon your request!
Give us a call or send us an inquiry!

Tool lengths and sectioning

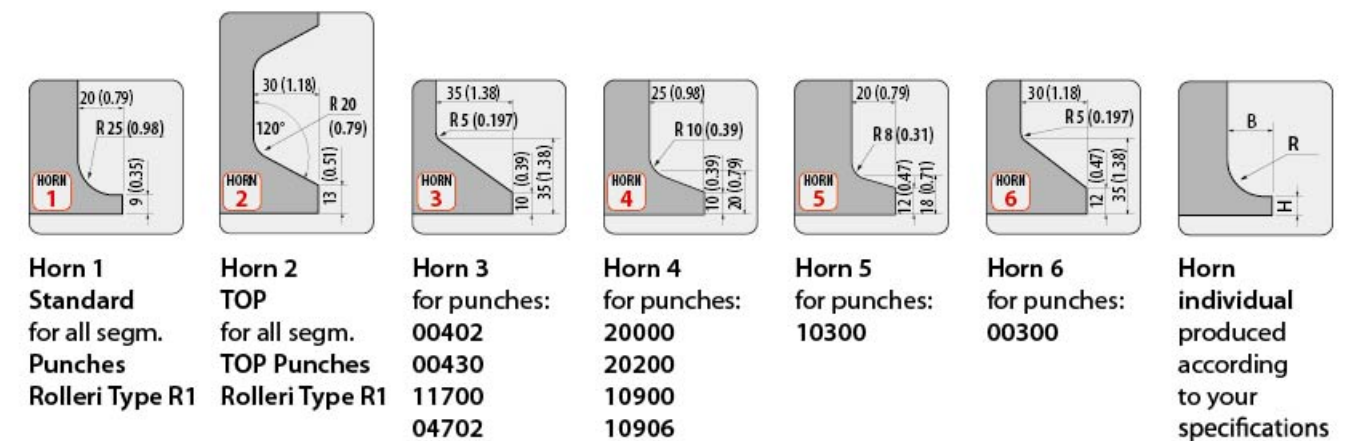
Standard



Rolleri TOP-System

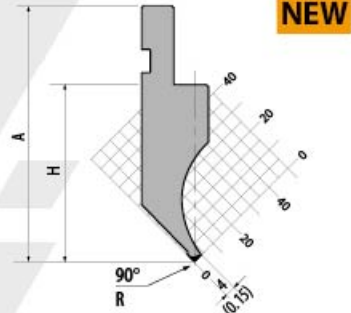


Horn Types



PK.97.90.R06 / P.97.90.R025

350 kN/m max.

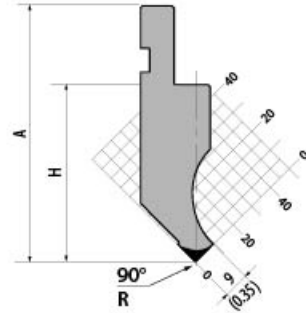


PK.97.90.R06			
H=66.80 / A=96.80 / R=0.6 (H=2.63 / A=3.81 / R=0.024)			
835 mm	32.87 in	10.5 kg	
415 mm	16.34 in	5.2 kg	
795 mm segmented	31.29 in segmented	10.0 kg	
805 mm segmented	31.69 in segmented	10.1 kg	
P.97.90.R025			
H=66.80 / A=96.80 / R=0.25 (H=2.63 / A=3.81 / R=0.010)			
835 mm	32.87 in	10.5 kg	
415 mm	16.34 in	5.2 kg	
795 mm segmented	31.29 in segmented	10.0 kg	
805 mm segmented	31.69 in segmented	10.1 kg	

42Cr: 900-1150 N/mm² **HORN 1**

PK.97.90.R08 / R025

1000 kN/m max.

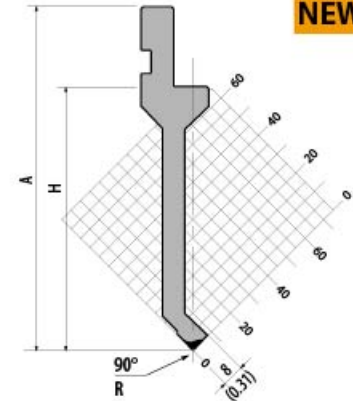


PK.97.90.R08			
H=66.35 / A=96.35 / R=0.8 (H=2.61 / A=3.79 / R=0.031)			
835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm segmented	31.29 in segmented	10.5 kg	
805 mm segmented	31.69 in segmented	10.5 kg	
R025			
H=66.60 / A=96.60 / R=0.25 (H=2.62 / A=3.80 / R=0.010)			
835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm segmented	31.29 in segmented	10.5 kg	
805 mm segmented	31.69 in segmented	10.5 kg	

C45: 560-710 N/mm² **HORN 1**

P.130.90.R06 / R025

350 kN/m max.

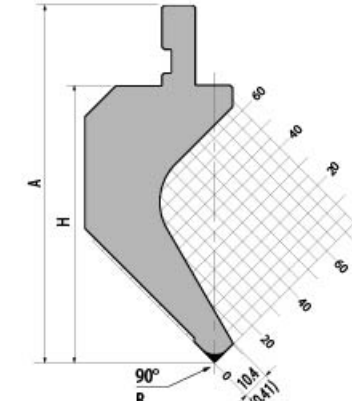


P.130.90.R06			
H=100.00 / A=130.00 / R=0.6 (H=3.94 / A=5.12 / R=0.024)			
835 mm	32.87 in	11.5 kg	
415 mm	16.34 in	5.7 kg	
795 mm segmented	31.29 in segmented	10.9 kg	
805 mm segmented	31.69 in segmented	11.0 kg	
R025			
H=100.00 / A=130.00 / R=0.25 (H=3.94 / A=5.12 / R=0.010)			
835 mm	32.87 in	11.5 kg	
415 mm	16.34 in	5.7 kg	
795 mm segmented	31.29 in segmented	10.9 kg	
805 mm segmented	31.69 in segmented	11.0 kg	

42Cr: 900-1150 N/mm² **HORN 1**

PK.135.90.R08 / R025

500 kN/m max.

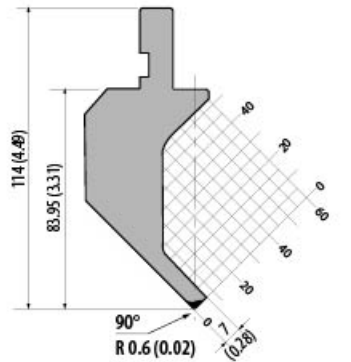


PK.135.90.R08			
H=104.35 / A=134.35 / R=0.8 (H=4.11 / A=5.29 / R=0.031)			
835 mm	32.87 in	23.0 kg	
415 mm	16.34 in	11.5 kg	
795 mm segmented	31.29 in segmented	21.9 kg	
805 mm segmented	31.69 in segmented	22.2 kg	
R025			
H=104.60 / A=134.60 / R=0.25 (H=4.12 / A=5.30 / R=0.010)			
835 mm	32.87 in	23.0 kg	
415 mm	16.34 in	11.5 kg	
795 mm segmented	31.29 in segmented	21.9 kg	
805 mm segmented	31.69 in segmented	22.2 kg	

C45: 560-710 N/mm² **HORN 1**

PK.114.90.R06

200 kN/m max.

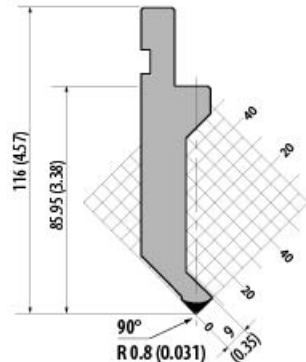


835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

42Cr: 900-1150 N/mm² **HORN 1**

PK.116.90.R08

400 kN/m max.

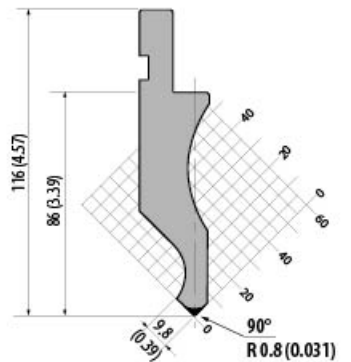


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm² **HORN 1**

DK.116.90.R08

500 kN/m max.

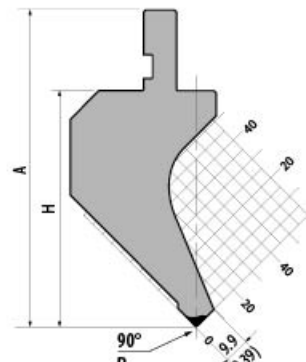


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.4 kg

C45: 560-710 N/mm² **HORN 1**

PK.120.90.R08 / R025

600 kN/m max.



PK.120.90.R08			
H=89.35 / A=119.35 / R=0.8 (H=3.52 / A=4.70 / R=0.031)			
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm segmented	31.29 in segmented	20.0 kg	
805 mm segmented	31.69 in segmented	20.2 kg	
R025			
H=89.60 / A=119.60 / R=0.25 (H=3.53 / A=4.71 / R=0.010)			
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm segmented	31.29 in segmented	20.0 kg	
805 mm segmented	31.69 in segmented	20.2 kg	

C45: 560-710 N/mm² **HORN 1**

Articles on stock – Please note that delivery time varies according to your location.

90° Segmented Punches with Mobile Horns

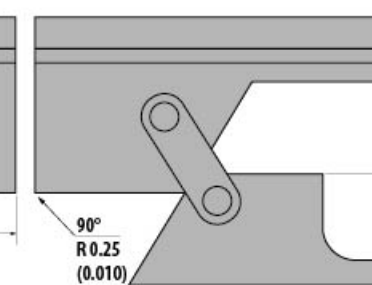
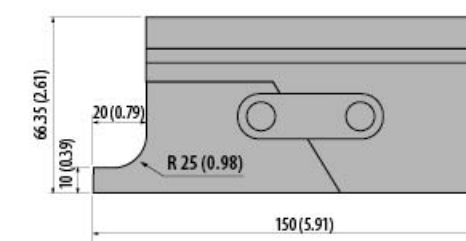


Area of Application

- for easy bending of special box profiles

SCA.M.90.R08

150 kN/m max.

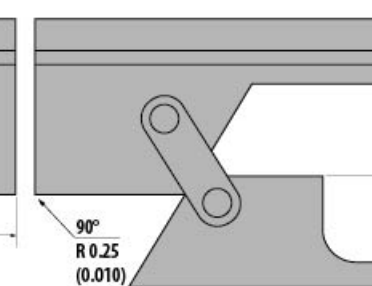
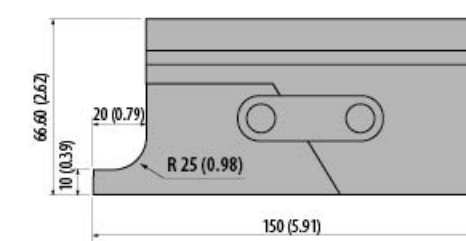


NEW per pair 3.5 kg
1 Pair left/right compatible with PK.97.90.R08

C45: 560-710 N/mm²

SCA.M.90.R025

150 kN/m max.

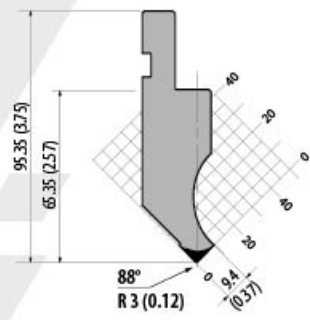


NEW per pair 3.5 kg
1 Pair left/right compatible with PK.97.90.R025

C45: 560-710 N/mm²

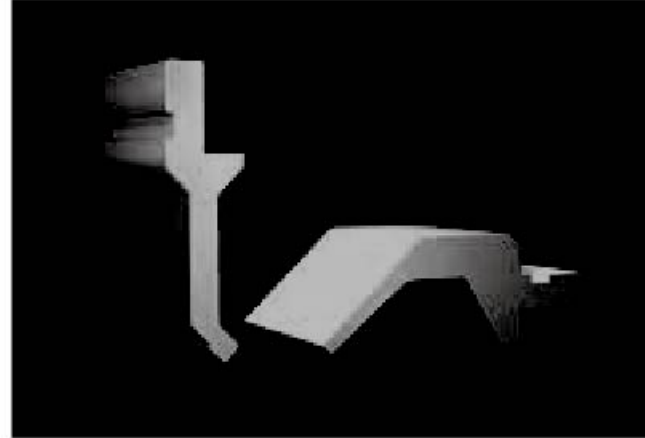
P.95.88.R3

1000 kN/m max.



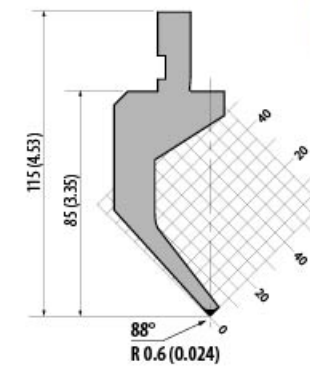
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²



P.115.88.R06

130 kN/m max.



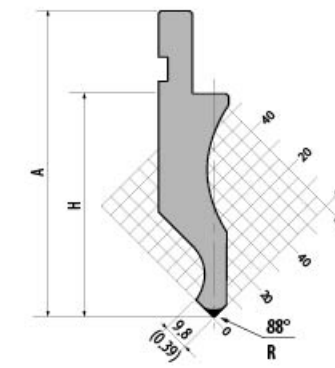
835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.7 kg
805 mm segmented	31.69 in segmented	5.8 kg

42Cr: 900-1150 N/mm²



D.116.88.R08 / R3

500 kN/m max.



H=86.00 / A=116.00 / R=0.8 (H=3.39 / A=4.57 / R=0.031)	835 mm	32.87 in	11.9 kg
	415 mm	16.34 in	5.8 kg
	795 mm segmented	31.29 in segmented	11.3 kg
	805 mm segmented	31.69 in segmented	11.5 kg

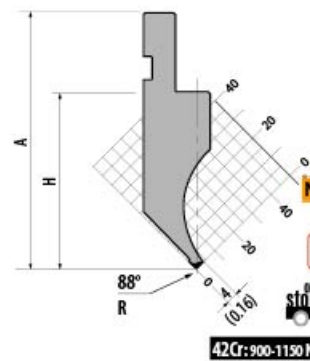
H=85.00 / A=115.00 / R=3.0 (H=3.35 / A=4.53 / R=0.118)	835 mm	32.87 in	11.9 kg
	415 mm	16.34 in	5.9 kg
	795 mm segmented	31.29 in segmented	11.3 kg
	805 mm segmented	31.69 in segmented	11.5 kg

C45: 560-710 N/mm²



P.97.88.R06 / R025

350 kN/m max.



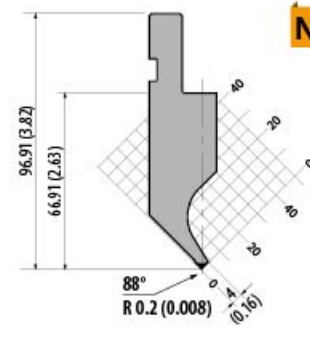
H=67.00 / A=97.00 / R=0.6 (H=2.64 / A=3.82 / R=0.024)	835 mm	32.87 in	9.5 kg
	415 mm	16.34 in	5.0 kg
	795 mm segmented	31.29 in segmented	9.0 kg
	805 mm segmented	31.69 in segmented	9.2 kg
	900 mm	35.43 in	11.0 kg

C45: 560-710 N/mm²



11700

200 kN/m max.



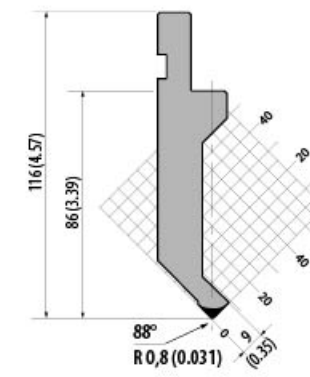
835 mm	32.87 in	10.7 kg
415 mm	16.34 in	5.3 kg
795 mm segmented	31.29 in segmented	10.2 kg
800 mm segmented	31.50 in segmented	10.3 kg

42Cr: 900-1150 N/mm²



P.116.88.R08

400 kN/m max.



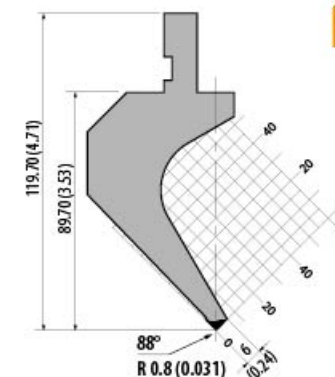
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.4 kg
805 mm segmented	31.69 in segmented	11.5 kg

C45: 560-710 N/mm²



PS.120.88.R08

450 kN/m max.



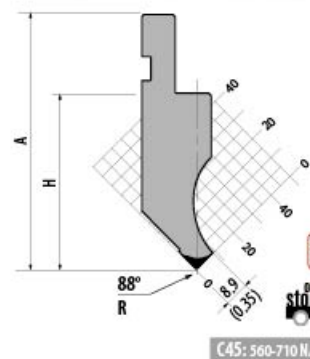
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.4 kg
795 mm segmented	31.29 in segmented	16.2 kg
805 mm segmented	31.69 in segmented	16.4 kg

C45: 560-710 N/mm²



P.97.88.R08 / PK.97.88.R025

1000 kN/m max.



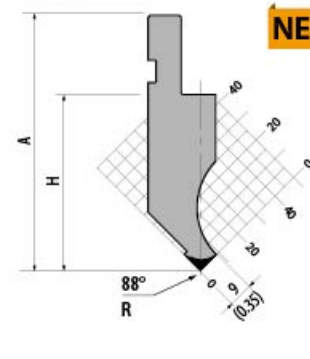
H=66.65 / A=96.65 / R=0.8 (H=2.62 / A=3.81 / R=0.031)	835 mm	32.87 in	11.1 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.6 kg
	805 mm segmented	31.69 in segmented	10.7 kg
	900 mm	35.43 in	11.9 kg

C45: 560-710 N/mm²



00402 / 00430

1000 kN/m max.



H=66.90 / A=96.90 / R=0.2 (H=2.63 / A=3.81 / R=0.008)	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.5 kg
	800 mm segmented	31.50 in segmented	10.5 kg

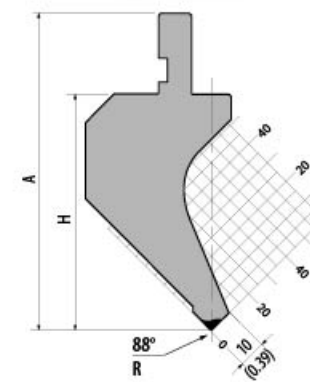
H=65.68 / A=95.68 / R=3 (H=2.59 / A=3.77 / R=0.118)	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.5 kg
	800 mm segmented	31.50 in segmented	10.5 kg

C45: 560-710 N/mm²



P.120.88.R08 / P.120.88. R3 / PK.120.88.R025

600 kN/m max.



H=89.65 / A=120.00 / R=0.8 (H=3.53 / A=4.72 / R=0.031)	835 mm	32.87 in	21.0 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	20.0 kg
	805 mm segmented	31.69 in segmented	20.2 kg

H=88.50 / A=118.50 / R=3.0 (H=3.48 / A=4.67 / R=0.118)	835 mm	32.87 in	21.0 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	20.0 kg
	805 mm segmented	31.69 in segmented	20.2 kg

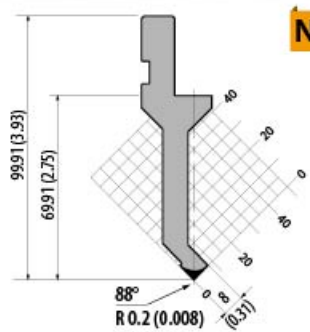
H=89.60 / A=120.00 / R=0.25 (H=3.53 / A=4.72 / R=0.010)	835 mm	32.87 in	21.0 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	20.0 kg
	805 mm segmented	31.69 in segmented	20.2 kg

C45: 560-710 N/mm²



20000

300 kN/m max.



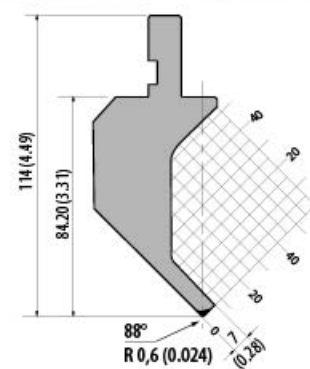
835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.5 kg
800 mm segmented	31.50 in segmented	7.6 kg

42Cr: 900-1150 N/mm²



P.114.88.R06

200 kN/m max.



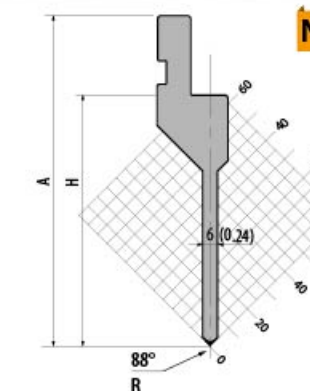
835 mm	32.87 in	15.6 kg
415 mm	16.34 in	7.7 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	15.0 kg

42Cr: 900-1150 N/mm²



10900 / 10906

500 kN/m max.



H=94.91 / A=124.91 / R=0.2 (H=3.74 / A=4.92 / R=0.008)	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	800 mm segmented	31.50 in segmented	8.6 kg

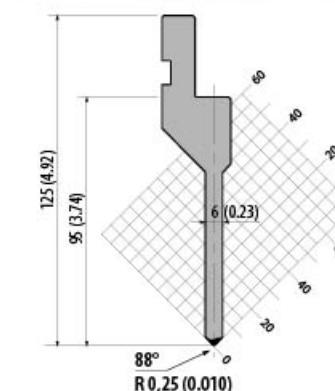
H=94.74 / A=124.74 / R=0.6 (H=3.73 / A=4.91 / R=0.024)	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	800 mm segmented	31.50 in segmented	8.6 kg

42Cr: 900-1150 N/mm²



P.125.88.R025

500 kN/m max.



835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
795 mm segmented	31.29 in segmented	8.5 kg
805 mm segmented	31.69 in segmented	8.6 kg

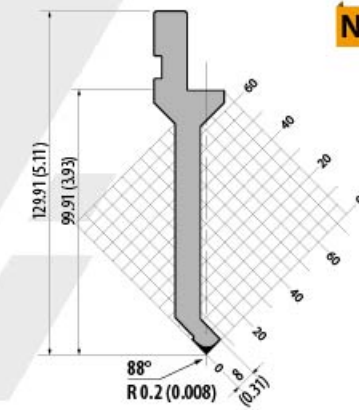
42Cr: 900-1150 N/mm²



20200

300 kN/m max.

NEW



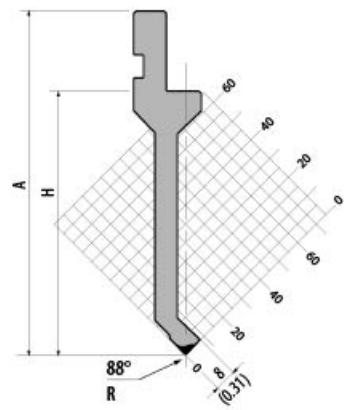
835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.50 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



P.130.88.R06 / PK.130.88.R025

350 kN/m max.



P.130.88.R06	H=100.00 / A=130.00 / R=0.6 (H= 3.94 / A=5.12 / R=0.024)		
	835 mm	32.87 in	9.8 kg
	415 mm	16.34 in	4.9 kg
	795 mm segmented	31.29 in segmented	9.3 kg
	805 mm segmented	31.69 in segmented	9.4 kg
	900 mm	35.43 in	10.5 kg

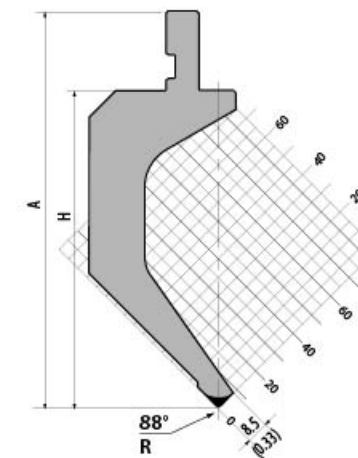
P.K. 130.88.R025	H=99.95 / A=129.95 / R=0.25 (H=3.94 / A=5.12 / R=0.010)		
	835 mm	32.87 in	9.7 kg
	415 mm	16.34 in	4.8 kg
	795 mm segmented	31.29 in segmented	9.2 kg
	805 mm segmented	31.69 in segmented	9.3 kg
	900 mm	35.43 in	10.4 kg

42Cr: 900-1150 N/mm²



P.150.88.R08 / R3

500 kN/m max.



P.150.88.R08	H=120.00 / A=150.00 / R=0.8 (H=4.72 / A=5.91 / R=0.031)		
	835 mm	32.87 in	21.5 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	20.4 kg
	805 mm segmented	31.69 in segmented	20.7 kg
	900 mm	35.43 in	23.1 kg

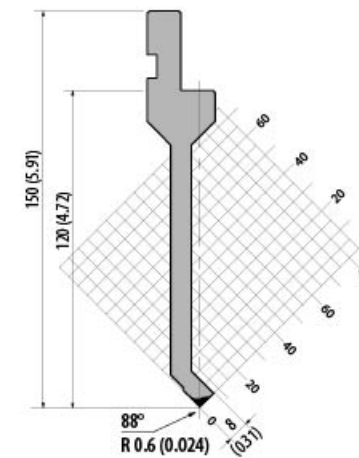
P.150.8&R3	H=119.00 / A=149.00 / R=3.0 (H=4.69 / A=5.87 / R=0.118)		
	835 mm	32.87 in	21.0 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	19.9 kg
	805 mm segmented	31.69 in segmented	20.2 kg
	900 mm	35.43 in	22.6 kg

42Cr: 900-1150 N/mm²



P.150.88.R06

350 kN/m max.



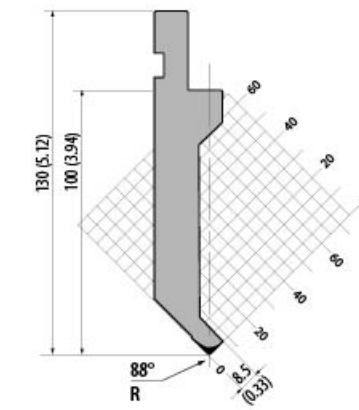
900 mm	35.43 in	12.9 kg
415 mm	16.34 in	5.9 kg
795 mm segmented	31.29 in segmented	12.2 kg
805 mm segmented	31.69 in segmented	12.4 kg

42Cr: 900-1150 N/mm²



P.130.88.R08 / R025

400 kN/m max.



H=100.00 / A=130.00 / R=0.8 (H=3.94 / A=5.12 / R=0.031)		
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.4 kg

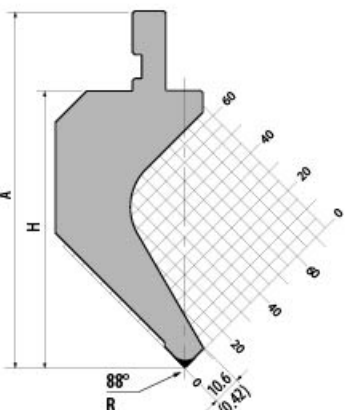
H=100.00 / A=130.00 / R=0.25 (H=3.94 / A=5.12 / R=0.010)		
835 mm	32.87 in	13.7 kg
415 mm	16.34 in	6.8 kg
795 mm segmented	31.29 in segmented	13.0 kg
805 mm segmented	31.69 in segmented	13.2 kg

C45: 560-710 N/mm²



P.135.88.R08 / R3 / PK.135.88.R025

500 kN/m max.



P.135.88.R08	H=104.65 / A=134.50 / R=0.8 (H=4.12 / A=5.30 / R=0.031)		
	835 mm	32.87 in	22.5 kg
	415 mm	16.34 in	11.2 kg
	795 mm segmented	31.29 in segmented	21.4 kg
	805 mm segmented	31.69 in segmented	21.7 kg

P.135.88.R3	H=103.40 / A=133.40 / R=3.0 (H=4.07 / A=5.25 / R=0.118)		
	835 mm	32.87 in	22.5 kg
	415 mm	16.34 in	11.2 kg
	795 mm segmented	31.29 in segmented	21.4 kg
	805 mm segmented	31.69 in segmented	21.7 kg
	H=104.60 / A=134.50 / R=0.25		

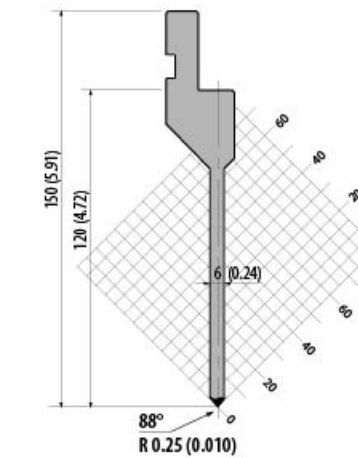
PK.135.88.0025	H=104.60 / A=134.50 / R=0.25 (H=4.12 / A=5.30 / R=0.010)		
	835 mm	32.87 in	22.7 kg
	415 mm	16.34 in	11.5 kg
	795 mm segmented	31.29 in segmented	21.6 kg
	805 mm segmented	31.69 in segmented	21.8 kg

C45: 560-710 N/mm²



P.150.88.R025

500 kN/m max.



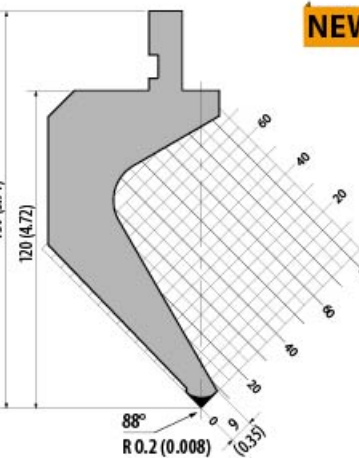
900 mm	32.87 in	10.0 kg
415 mm	16.34 in	4.6 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.69 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



04702

500 kN/m max.



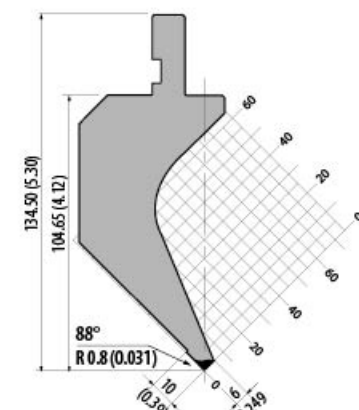
835 mm	32.87 in	26.0 kg
415 mm	16.34 in	12.9 kg
795 mm segmented	31.29 in segmented	24.8 kg
800 mm segmented	31.50 in segmented	24.9 kg

42Cr: 900-1150 N/mm²



PS.135.88.R08

450 kN/m max.



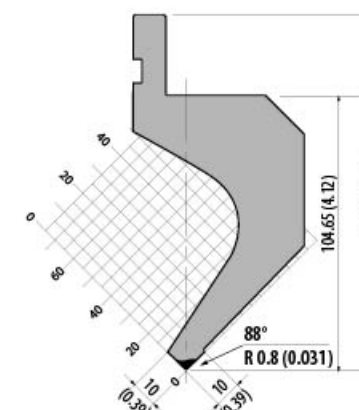
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	12.5 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



PR.135.88.R08

450 kN/m max.



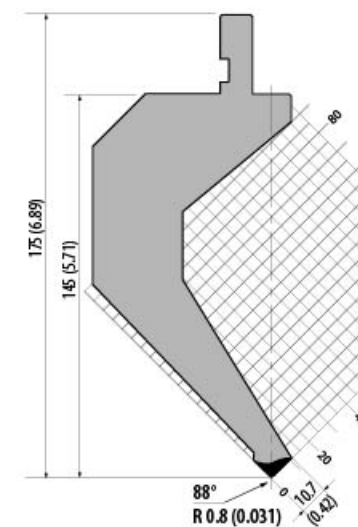
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	11.5 kg
795 mm segmented	31.29 in segmented	23.8 kg
805 mm segmented	31.69 in segmented	24.1 kg

C45: 560-710 N/mm²



P.175.88.R08

500 kN/m max.



835 mm	32.87 in	35.0 kg
415 mm	16.34 in	17.5 kg
795 mm segmented	31.29 in segmented	33.3 kg
805 mm segmented	31.69 in segmented	33.7 kg

C45: 560-710 N/mm²



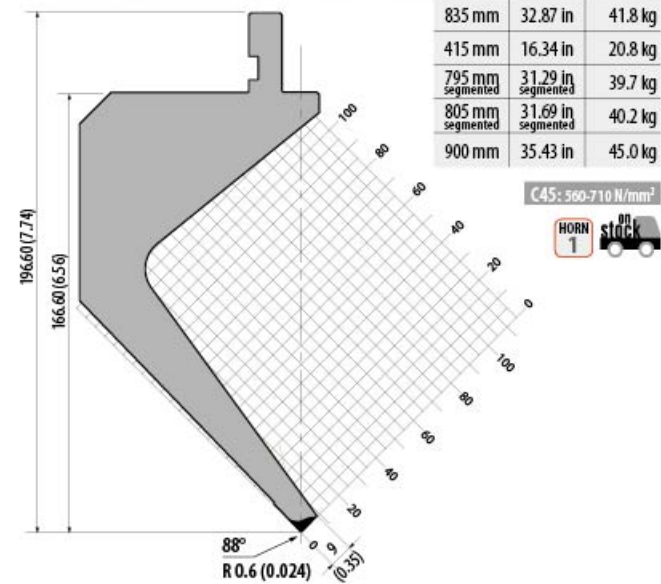
P.195.88.R08

600 kN/m max.



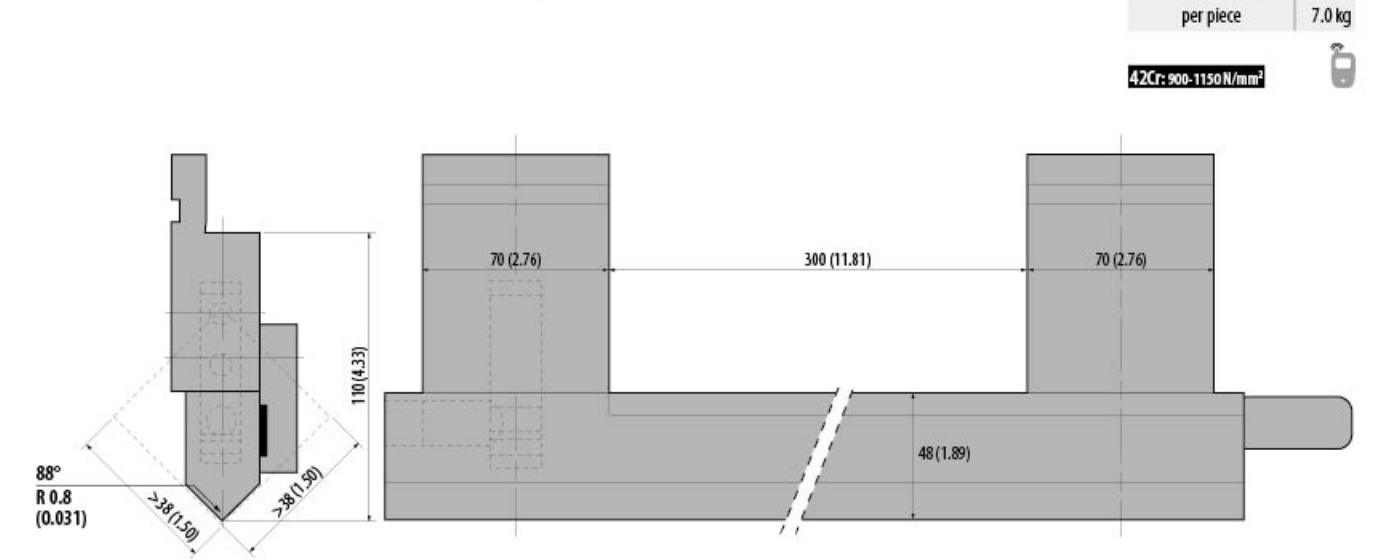
P.196.88.R06

300 kN/m max.



SPE.11

150 kN/m max.

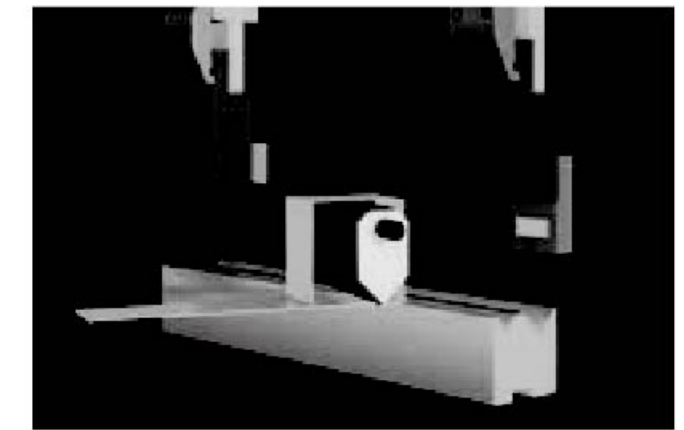
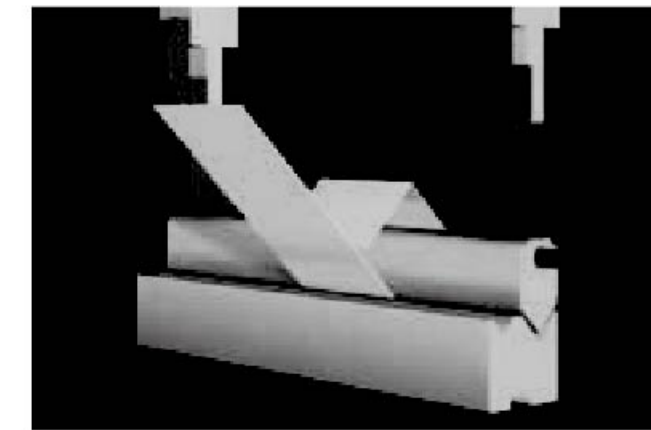


88° Segmented Punches with Mobile Horns



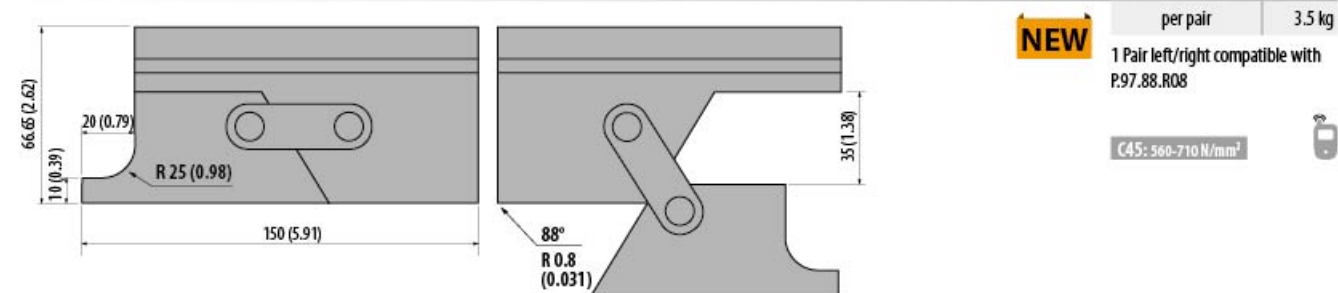
Area of Application

- for easy bending of special box profiles



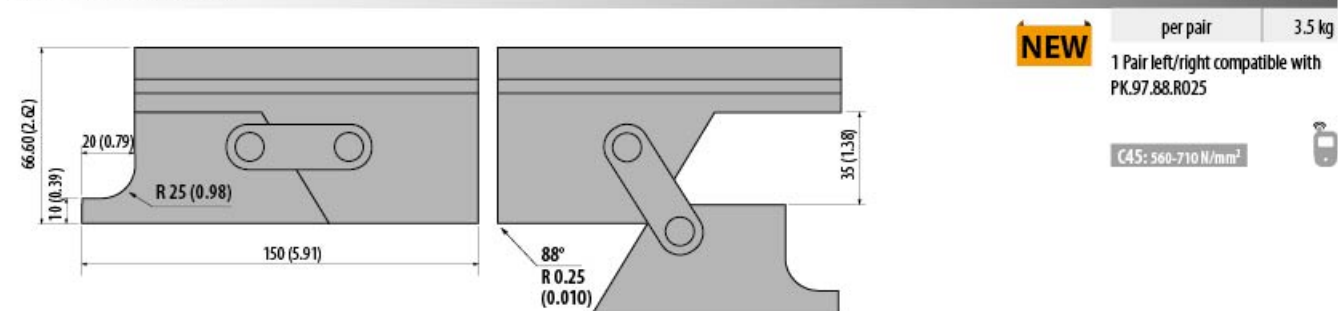
SCA.M.88.R08

150 kN/m max.



SCA.M.88.R025

150 kN/m max.

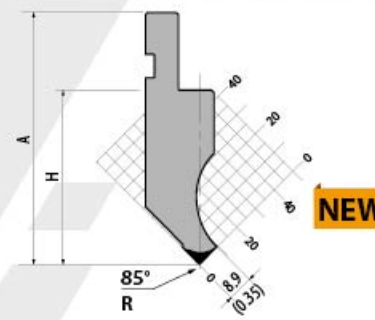


Articles on stock – Please note that delivery time varies according to your location



P.97.85.R08 / PK.95.85.R3

1000 kN/m max.

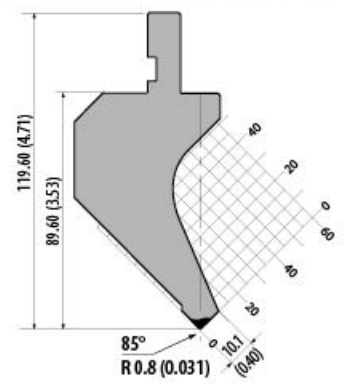


P.97.85.R08	H=66.60 / A=96.50 / R=0.8 (H=2.62 / A=3.80 / R=0.031)	
	835 mm	32.87 in
	415 mm	16.34 in
	795 mm segmented	31.29 in
	805 mm segmented	31.69 in
PK.95.85.R3	H=65.45 / A=95.45 / R=3.0 (H=2.58 / A=3.76 / R=0.118)	
	835 mm	32.87 in
	415 mm	16.34 in
	795 mm segmented	31.29 in
	805 mm segmented	31.69 in

C45: 560-710 N/mm²

PK.120.85.R08

600 kN/m max.



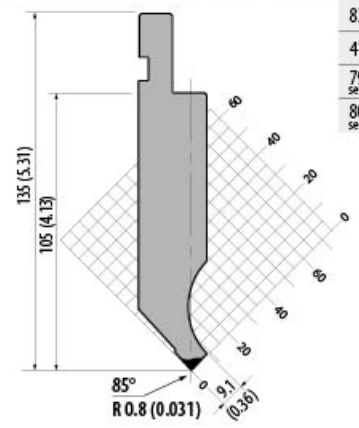
835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in	19.9 kg
805 mm segmented	31.69 in	20.2 kg

C45: 560-710 N/mm²



PS.135.85.R08

1000 kN/m max.



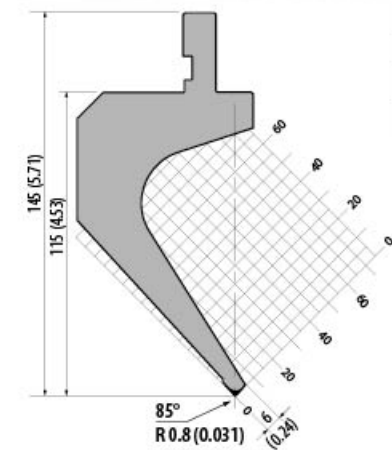
835 mm	32.87 in	17.7 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in	16.8 kg
805 mm segmented	31.69 in	17.0 kg

C45: 560-710 N/mm²



P.145.85.R08

600 kN/m max.



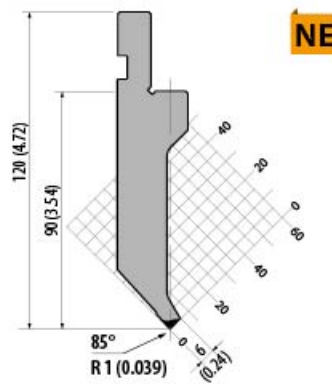
835 mm	32.87 in	22.6 kg
415 mm	16.34 in	11.2 kg
795 mm segmented	31.29 in	21.5 kg
805 mm segmented	31.69 in	21.7 kg

42Cr: 900-1150 N/mm²



P.120.85.R1

800 kN/m max.



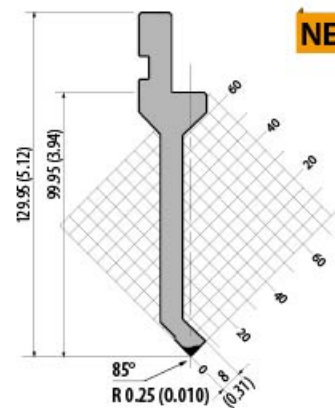
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.7 kg
795 mm segmented	31.29 in	12.9 kg
805 mm segmented	31.69 in	13.0 kg

42Cr: 900-1150 N/mm²



P.130.85.R025

350 kN/m max.



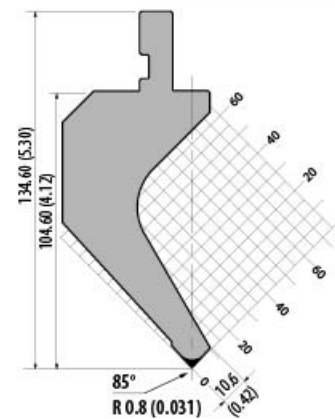
835 mm	32.87 in	11.5 kg
415 mm	16.34 in	5.7 kg
795 mm segmented	31.29 in	10.9 kg
805 mm segmented	31.69 in	11.1 kg

42Cr: 900-1150 N/mm²



PK.135.85.R08

500 kN/m max.



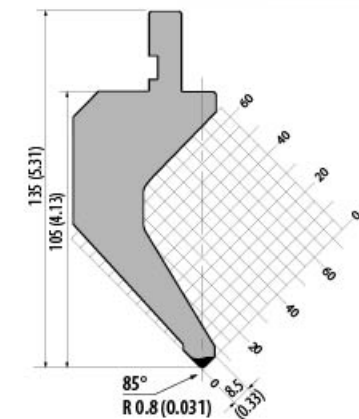
835 mm	32.87 in	22.2 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in	21.1 kg
805 mm segmented	31.69 in	21.4 kg

C45: 560-710 N/mm²



P.135.85.R08

800 kN/m max.



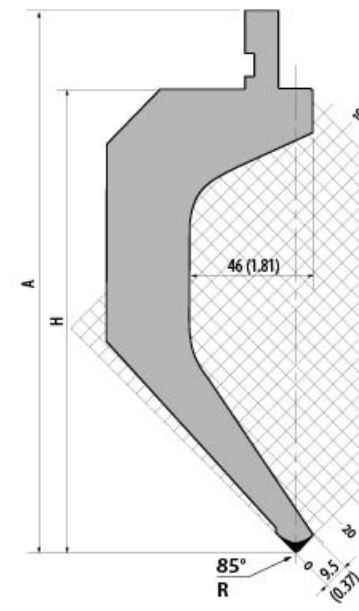
835 mm	32.87 in	20.9 kg
415 mm	16.34 in	10.4 kg
795 mm segmented	31.29 in	19.9 kg
805 mm segmented	31.69 in	20.1 kg

42Cr: 900-1150 N/mm²



TOP.205.85.R08 / R2

700 kN/m max.



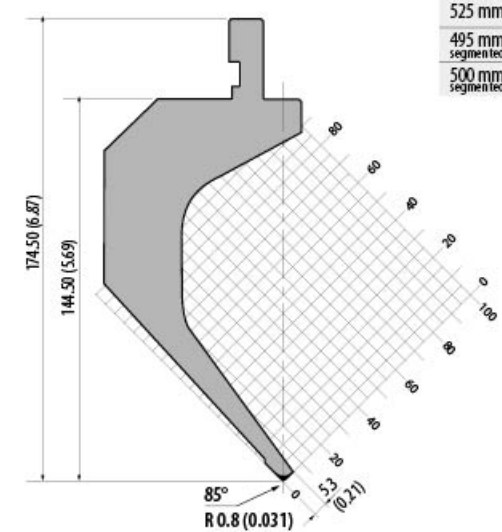
TOP.205.85.R08	H=175.00 / A=205.00 / R=0.8 (H=6.89 / A=8.07 / R=0.031)	
	525 mm	20.67 in
	495 mm segmented	19.49 in
	500 mm segmented	19.68 in
	500 mm segmented	19.9 kg
TOP.205.85.R2	H=174.30 / A=204.30 / R=2.0 (H=6.86 / A=8.04 / R=0.079)	
	525 mm	20.67 in
	495 mm segmented	19.49 in
	500 mm segmented	19.68 in
	500 mm segmented	19.9 kg

42Cr: 900-1150 N/mm²



TOP.175.85.R08.S

200 kN/m max.



525 mm	20.67 in	18.5 kg
495 mm segmented	19.49 in	17.4 kg
500 mm segmented	19.68 in	17.6 kg

42Cr: 900-1150 N/mm²

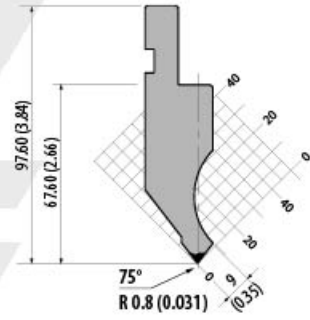


For a rapid vertical tool exchange, punches Rolleri R1 Type can be equipped with the spring-loaded ROL1-System (20% Surcharge).
Retrofitted or new!
See pages 204-205



P.97.75.R08

1000 kN/m max.



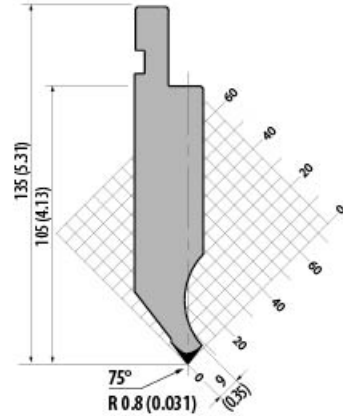
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

42Cr: 900-1150 N/mm²



P.135.75.R08

1000 kN/m max.



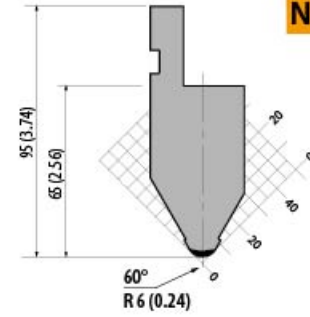
835 mm	32.87 in	17.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	16.7 kg
805 mm segmented	31.69 in segmented	16.9 kg

42Cr: 900-1150 N/mm²



00300

1000 kN/m max.



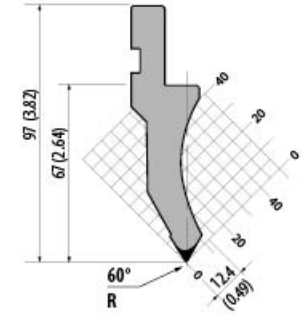
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.2 kg
800 mm segmented	31.50 in segmented	14.4 kg

C45: 560-710 N/mm²



P.97.60.R08 / R2

600 kN/m max.



R=0.8 (0.031)		
P.97.60.R08	835 mm	32.87 in
	415 mm	16.34 in
	795 mm segmented	31.29 in segmented
	805 mm segmented	31.69 in segmented

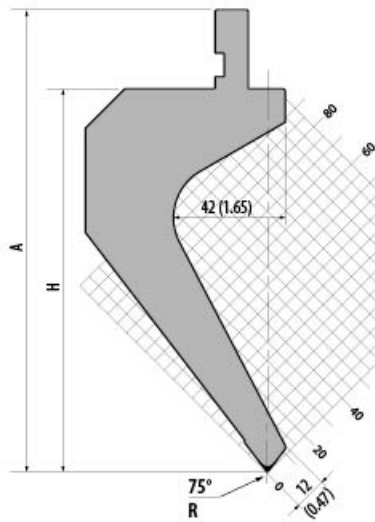
R=2.0 (0.079)		
P.97.60.R2	835 mm	32.87 in
	415 mm	16.34 in
	795 mm segmented	31.29 in segmented
	805 mm segmented	31.69 in segmented

C45: 560-710 N/mm²



TOP.175.75.R08 / R2

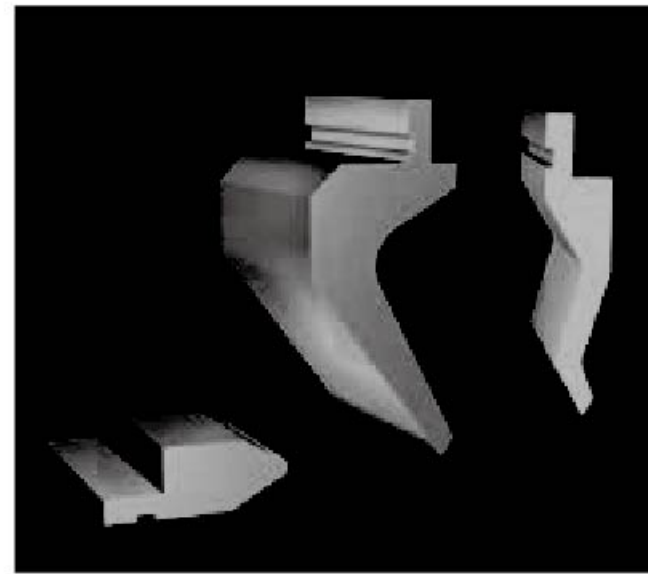
750 kN/m max.



H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
TOP.175.75.R08	525 mm	20.67 in
	495 mm segmented	19.49 in segmented
	500 mm segmented	19.68 in segmented

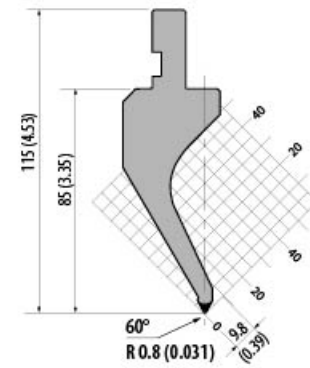
H=144.20 / A=174.20 / R=2.0 (H=5.68 / A=6.86 / R=0.079)		
TOP.175.75.R2	525 mm	20.67 in
	495 mm segmented	19.49 in segmented
	500 mm segmented	19.68 in segmented

42Cr: 900-1150 N/mm²



P.115.60.R08

400 kN/m max.



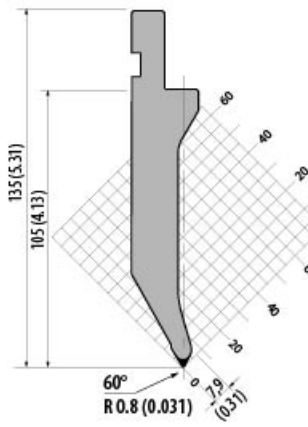
835 mm	32.87 in	11.9 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.3 kg
805 mm segmented	31.69 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



P.135.60.R08

800 kN/m max.



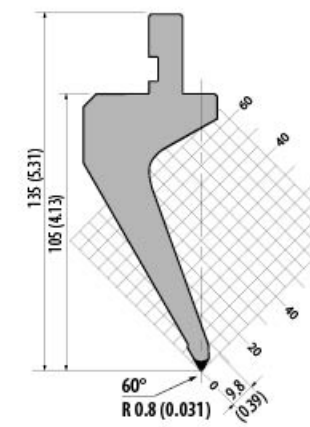
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

42Cr: 900-1150 N/mm²



PG.135.60.R08

700 kN/m max.



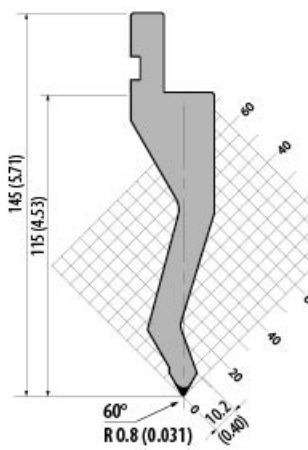
835 mm	32.87 in	16.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	15.7 kg
805 mm segmented	31.69 in segmented	15.9 kg

42Cr: 900-1150 N/mm²



P.145.60.R08

700 kN/m max.



835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	14.4 kg

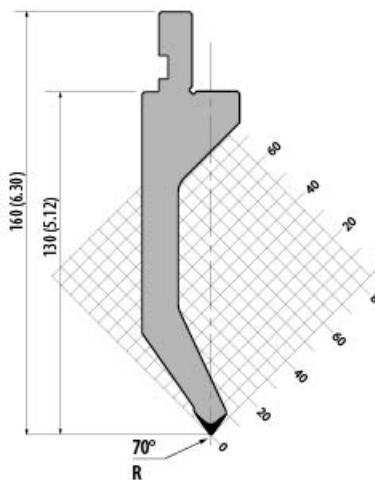
42Cr: 900-1150 N/mm²



70° Punches

P.160.70.R08 / R3

450 kN/m max.



R=0.8 (0.031)		
P.160.70.R08	835 mm	32.87 in
	415 mm	16.34 in
	795 mm segmented	31.29 in segmented
	805 mm segmented	31.69 in segmented

R=3.0 (0.118)		
P.160.70.R3	835 mm	32.87 in
	415 mm	16.34 in
	795 mm segmented	31.29 in segmented
	805 mm segmented	31.69 in segmented

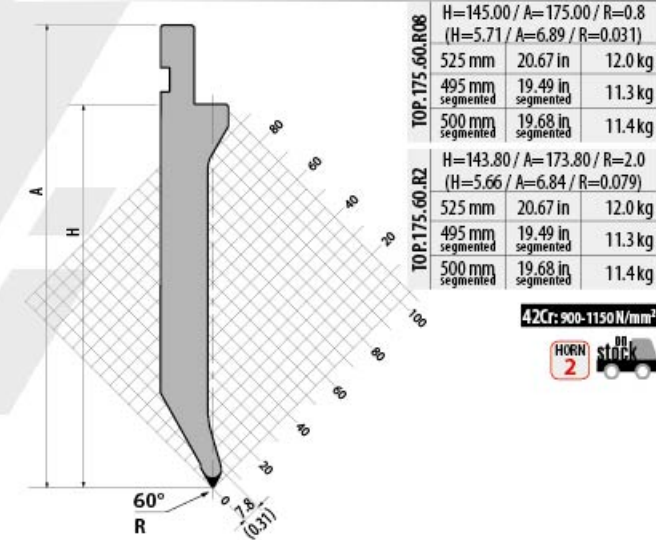
42Cr: 900-1150 N/mm²



Modifications of Standard Tools: rapid and precise, directly from the manufacturer!
See pages 248-253

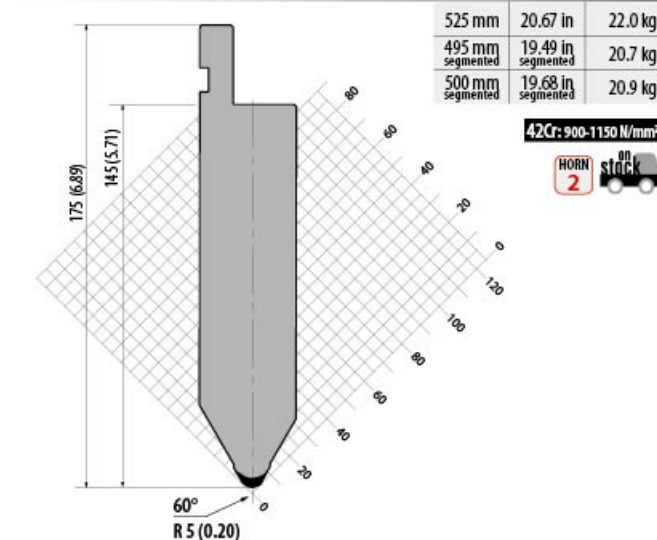
TOP.175.60.R08 / R2

800 kN/m max.



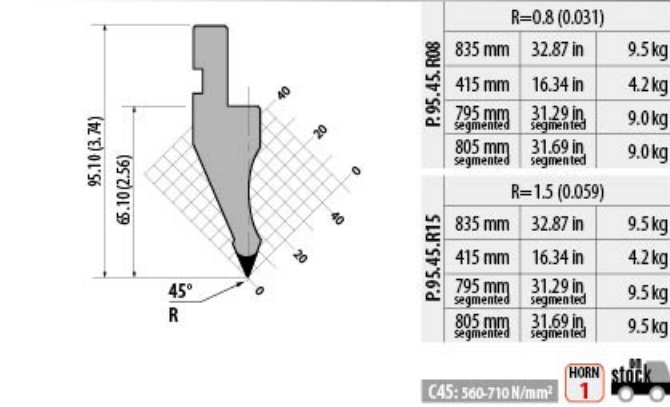
TOP.175.60.R5

1600 kN/m max.



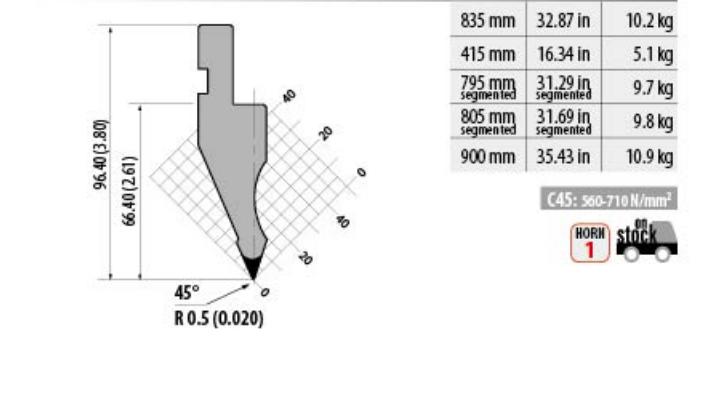
P.95.45.R08 / R15

800 kN/m max.



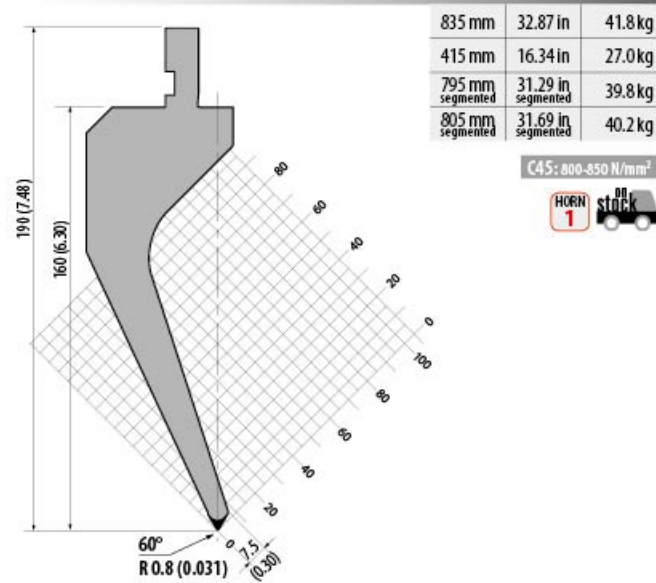
P.97.45.R05

800 kN/m max.



P.190.60.R08

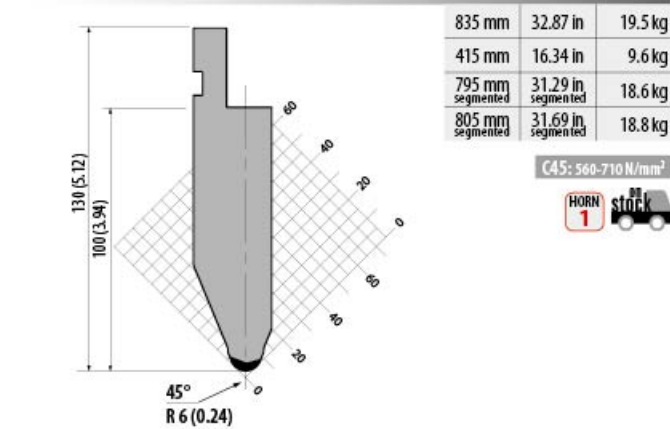
400 kN/m max.



Take advantage of the wide range of Rolleri R1 Type punches by using our extensive number of adapters. See pages 212-217

P.130.45.R6

1000 kN/m max.

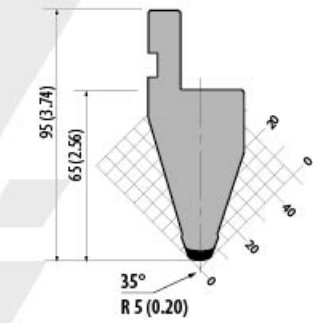


Faster vertical tool exchange with ROL100
See pages 202-203



P.95.35.R5

1000 kN/m max.



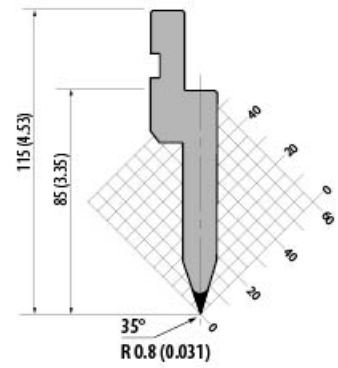
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg

C45: 560-710 N/mm²



PU.85.35.R08

1000 kN/m max.



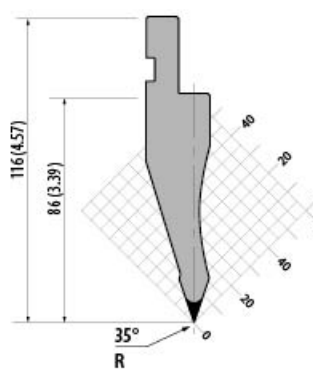
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²



P.116.35.R08 / R15

700 kN/m max.



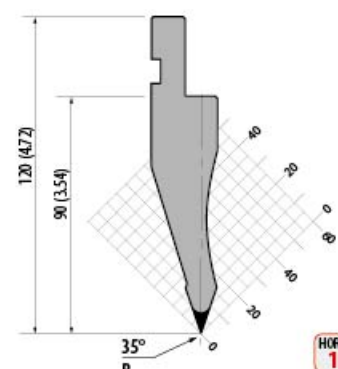
R=0.8 (0.031)		
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.7 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.69 in segmented	10.1 kg
R=1.5 (0.059)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.7 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²



P.120.35.R08 / R15 / R3

700 kN/m max.



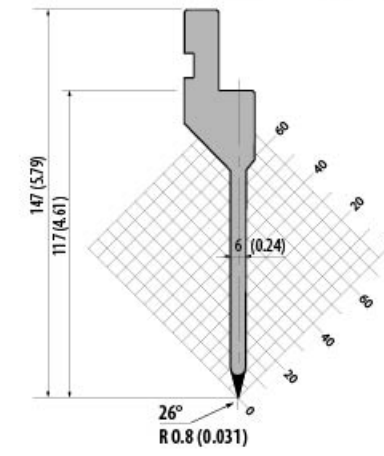
R=0.8 (0.031)		
835 mm	32.87 in	12.3 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.7 kg
805 mm segmented	31.69 in segmented	11.9 kg
R=1.5 (0.059)		
835 mm	32.87 in	12.5 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.9 kg
805 mm segmented	31.69 in segmented	12.1 kg
R=3.0 (0.118)		
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.4 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



P.147.26.R08

500 kN/m max.



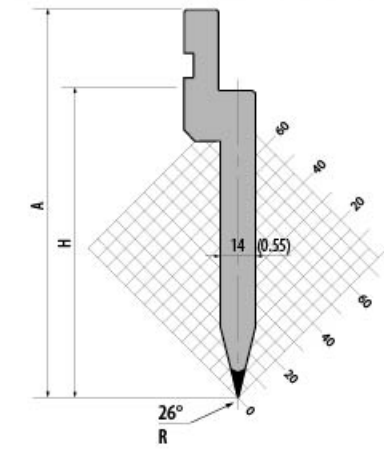
835 mm	32.87 in	9.8 kg
415 mm	16.34 in	4.9 kg
795 mm segmented	31.29 in segmented	9.3 kg
805 mm segmented	31.69 in segmented	9.4 kg

42Cr: 900-1150 N/mm²



PU.117.26.R08 / R3

1000 kN/m max.



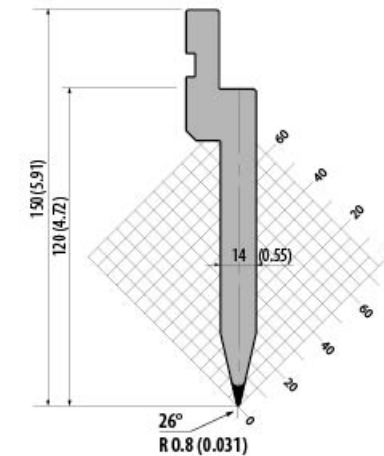
PU.117.26.R08 (H=117.00 / A=147.00 / R=0.8 (H=4.61 / A=5.79 / R=0.031))		
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg
PU.117.26.R3 (H=109.00 / A=139.00 / R=3.0 (H=4.29 / A=5.47 / R=0.118))		
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.7 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg

C45: 560-710 N/mm²



PU.150.26.R08.L

1000 kN/m max.



900 mm	35.43 in	15.0 kg
415 mm	16.34 in	6.2 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	12.5 kg

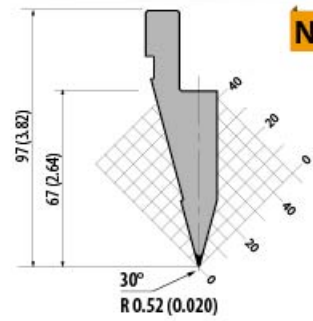
C45: 560-710 N/mm²



30° Punches

10300

1000 kN/m max.



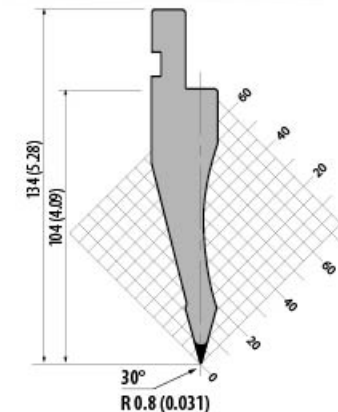
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
800 mm segmented	31.50 in segmented	10.6 kg

42Cr: 900-1150 N/mm²



PS.134.30.R08

700 kN/m max.



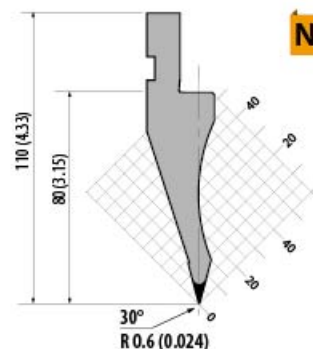
835 mm	32.87 in	13.3 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.6 kg
805 mm segmented	31.69 in segmented	12.8 kg

C45: 560-710 N/mm²



P.110.30.R06

500 kN/m max.



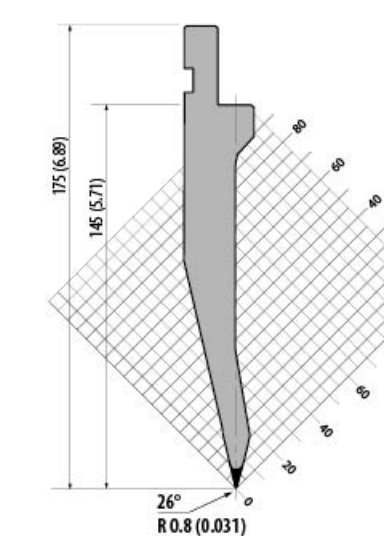
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.50 in segmented	10.1 kg

C45: 560-710 N/mm²



TOP.175.26.R08

950 kN/m max.



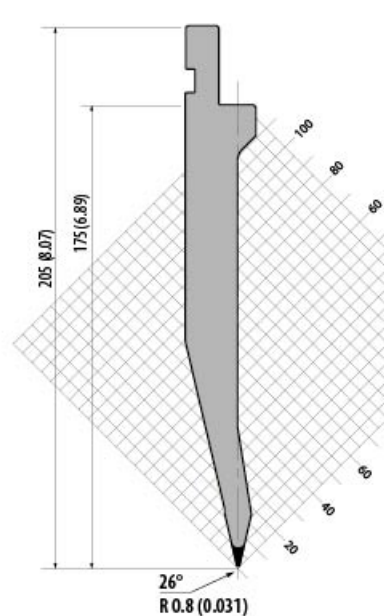
525 mm	20.67 in	11.0 kg
495 mm segmented	19.49 in segmented	10.4 kg
500 mm segmented	19.68 in segmented	10.5 kg

42Cr: 900-1150 N/mm²



TOP.205.26.R08

950 kN/m max.

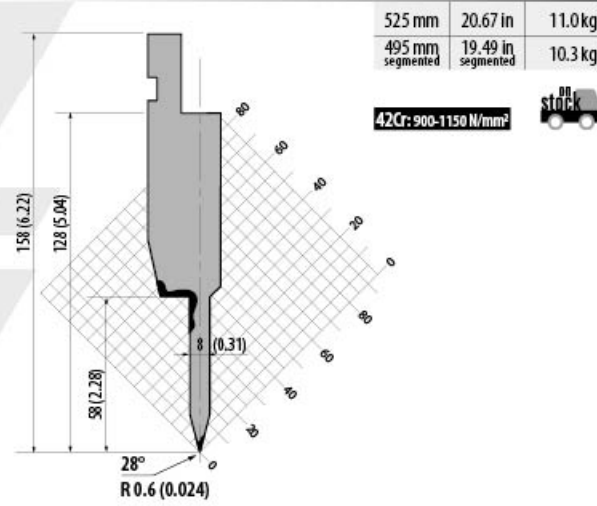


525 mm	20.67 in	14.0 kg
495 mm segmented	19.49 in segmented	13.2 kg
500 mm segmented	19.68 in segmented	13.3 kg

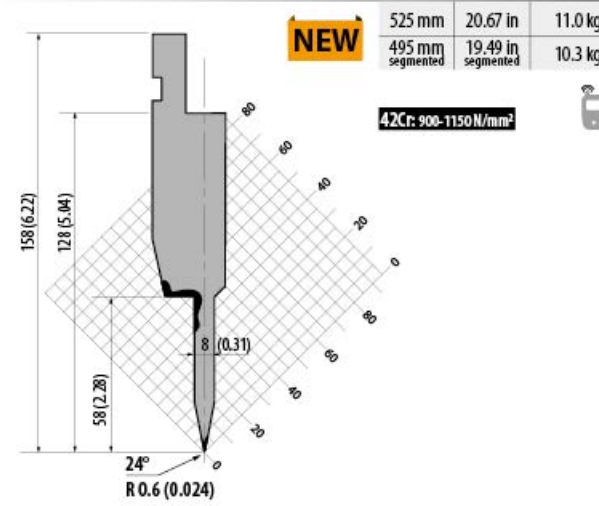
42Cr: 900-1150 N/mm²



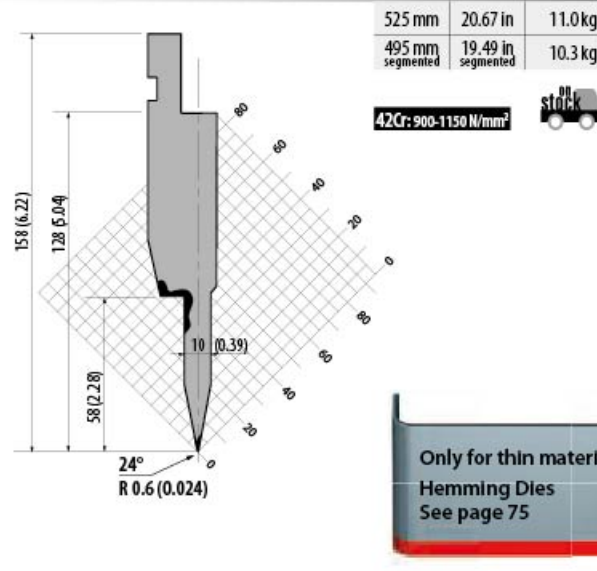
TOP.SP.134.28.8



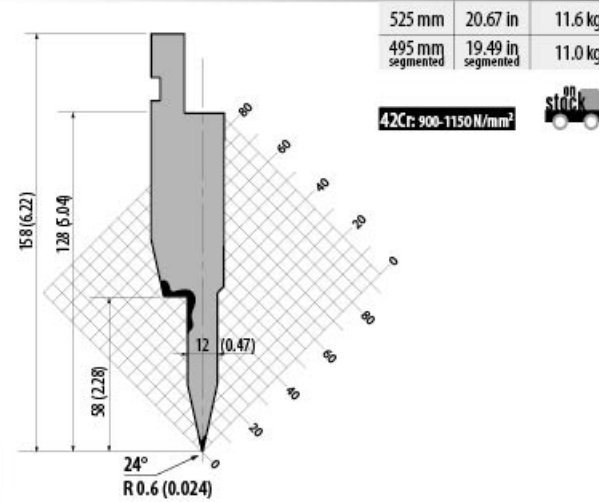
TOP.SP.134.24.8



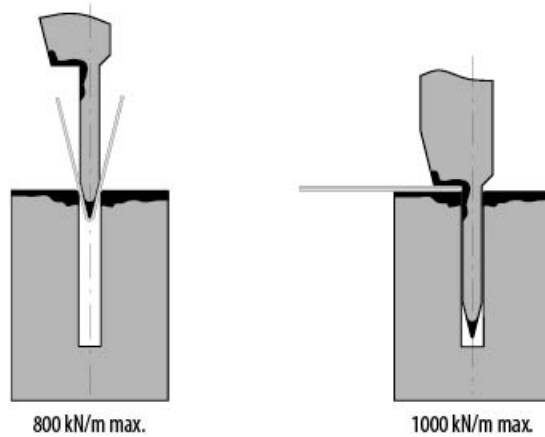
TOP.SP.134.24.10



TOP.SP.134.24.12

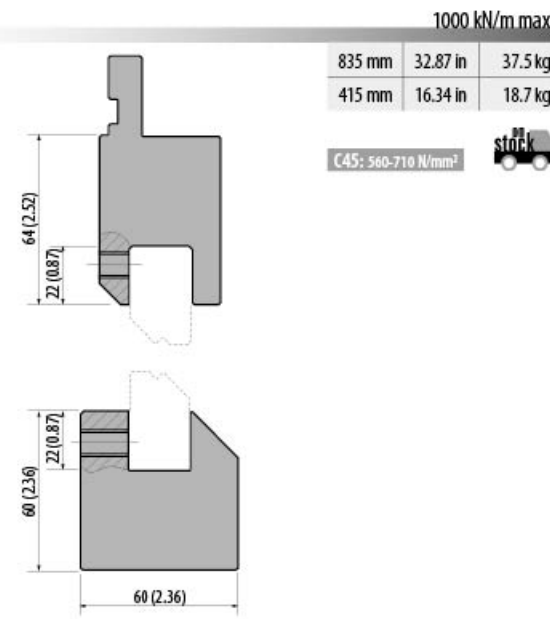


Example of application

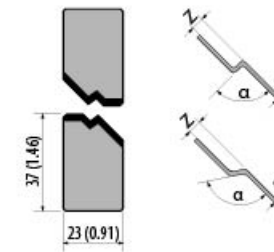


S	S	A	A	R.45	R.70	S	S	A	A	R.45	R.70
mm	in	mm	in	Kg/mm²	Kg/mm²	mm	in	mm	in	Kg/mm²	Kg/mm²
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

CPZ



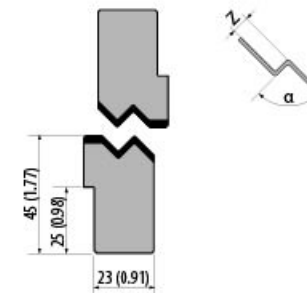
Z-Tool Inserts 160° / 150° / 140° / 90°



Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 2.0/90	2.0	0.08	90°	0.4	0.02	11.0 kg	5.5 kg
CEZ 2.5/90	2.5	0.10	90°	0.5	0.02	11.0 kg	5.5 kg
CEZ 3.0	3.0	0.12	90°	1.0	0.04	10.3 kg	5.1 kg
CEZ 3.5	3.5	0.14	90°	1.0	0.04	10.0 kg	5.0 kg
CEZ 4.0	4.0	0.16	90°	1.2	0.05	10.0 kg	5.0 kg
CEZ 4.5	4.5	0.18	90°	1.2	0.05	10.0 kg	5.0 kg
CEZ 5.0	5.0	0.20	90°	1.3	0.05	10.0 kg	5.0 kg
CEZ 5.5	5.5	0.22	90°	1.4	0.06	10.0 kg	5.0 kg
CEZ 6.0	6.0	0.24	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 6.5	6.5	0.26	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 7.0	7.0	0.28	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 7.5	7.5	0.30	90°	1.6	0.06	10.0 kg	5.0 kg
CEZ 8.0	8.0	0.31	90°	1.6	0.06	10.0 kg	5.0 kg

* Fe Rmax = 42 Kg/mm²

Z-Tool Inserts 90°

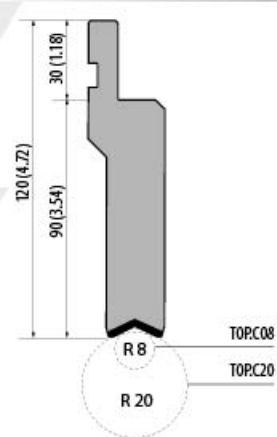


Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	6.5 kg
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	6.5 kg
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	6.5 kg
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	6.5 kg
CEZ 15.0	15	0.59	90°	2.3	0.09	13.5 kg	6.5 kg

* Fe Rmax = 42 Kg/mm²

TOP.PC.120-08

1000 kN/m max.



522 mm	20.55 in	11.0 kg
495 mm segmented	19.49 in segmented	12.0 kg

for Radius tools with R8-R20 (TOP.C08-TOP.C20) see below

42Cr: 900-1150 N/mm²

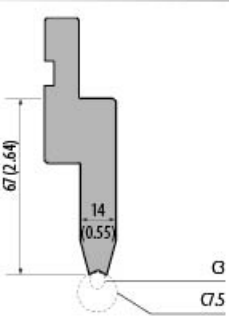


Radius Punches by Rollerl also sectioned on stock! Take advantage of this flexibility!



PU.67.14-S

400 kN/m max.



830 mm	32.68 in	9.7 kg
410 mm	16.14 in	5.0 kg

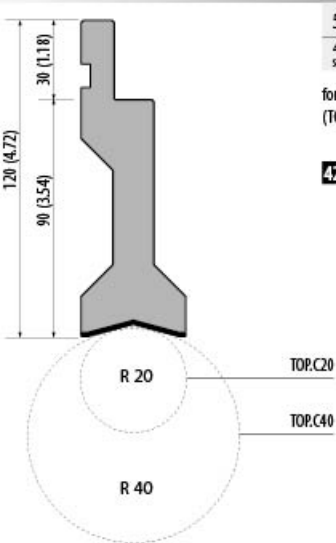
for Radius tools with R3-R7.5 (C3-C7.5) see below

C45: 560-710 N/mm²



TOP.PC.120-20

1000 kN/m max.



522 mm	20.55 in	10.5 kg
495 mm segmented	19.49 in segmented	10.0 kg

for Radius tools with R20-R40 (TOP.PC20-TOP.PC40) see below

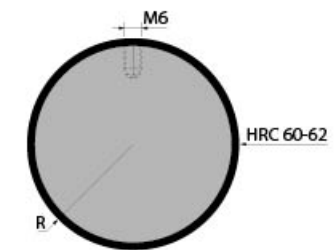
42Cr: 900-1150 N/mm²



Mark-free bending with PU-Upholstery
See pages 226-227

TOP-Radius Tools: R8-40

1000 kN/m max.



Material: C53
Induction hardened 60-62 HRC

C53: 610-760 N/mm²



Model	R mm	R in	Weight	Weight
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.C25	25	0.98	8.1 kg	7.5 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C40	40	1.57	20.7 kg	19.5 kg

C3 - C7.5

400 kN/m max.

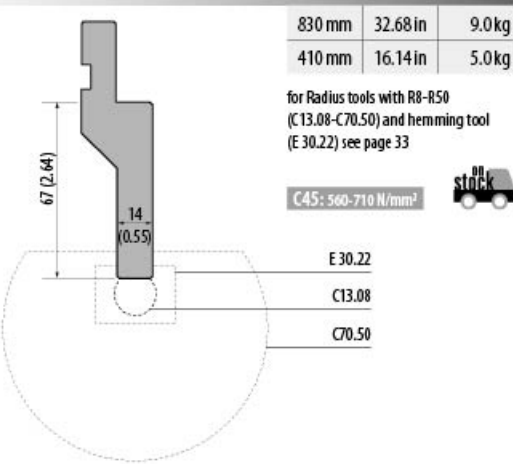


C45: 560-710 N/mm²

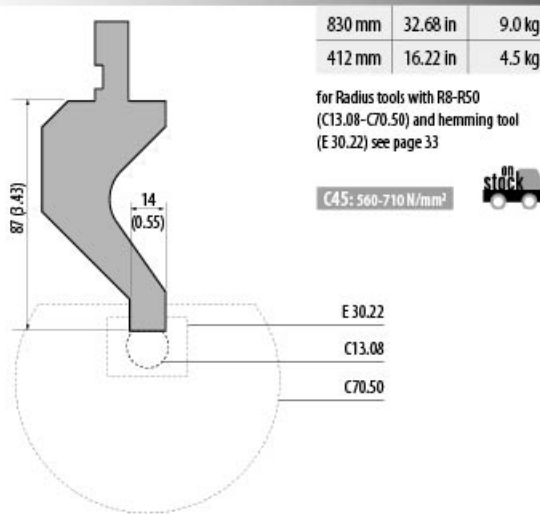


Model	R mm	R in	Weight	Weight
C3	3.0	0.12	0.20 kg	0.10 kg
C3.5	3.5	0.14	0.20 kg	0.10 kg
C4	4.0	0.16	0.35 kg	0.17 kg
C4.5	4.5	0.18	0.50 kg	0.25 kg
C5	5.0	0.20	0.60 kg	0.30 kg
C5.5	5.5	0.22	0.70 kg	0.35 kg
C6	6.0	0.24	0.80 kg	0.40 kg
C6.5	6.5	0.26	1.00 kg	0.50 kg
C7	7.0	0.28	0.80 kg	0.40 kg
C7.5	7.5	0.30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

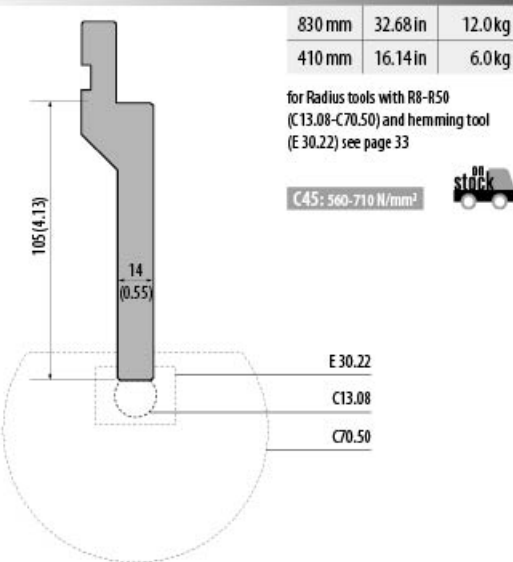
PU.67.14 800 kN/m max.



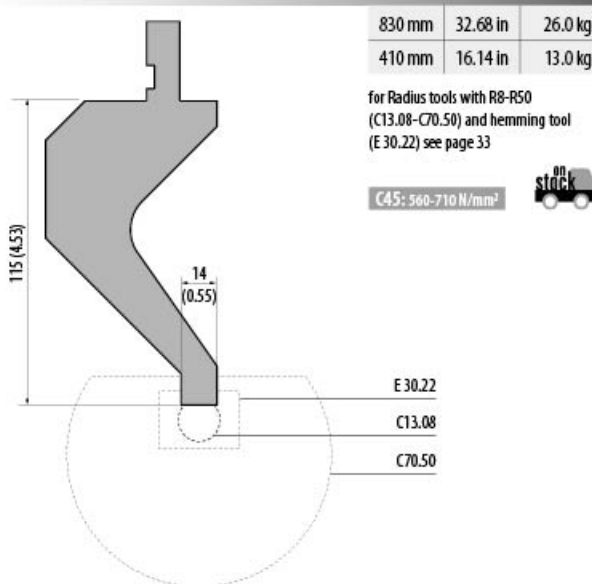
PU.87.14 500 kN/m max.



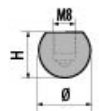
PU.105.14 800 kN/m max.



PU.115.14 500 kN/m max.

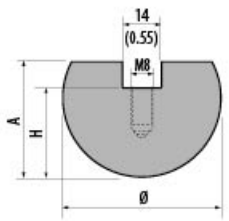


Radius Tool: Ø 16-20 mm (0.63-0.79 in) 800 kN/m max.



Model	Ø mm	Ø in	H mm	H in	Weight	Weight
C13.08	16	0.63	13	0.51	2.00 kg	1.00 kg
C13.09	18	0.71	16	0.63	2.00 kg	1.00 kg
C16.10	20	0.79	16	0.63	2.00 kg	1.00 kg

Radius Tool: Ø 25-100 mm (0.98-3.94) 800 kN/m max.



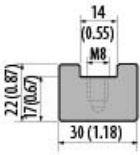
Model	Ø mm	Ø in	H mm	H in	A mm	A in	Weight	Weight
C17.12	25	0.98	17	0.67	22	0.87	2.5 kg	1.2 kg
C20.15	30	1.18	20	0.79	27	1.06	3.7 kg	1.8 kg
C22.17	35	1.38	22	0.87	32	1.26	5.0 kg	2.4 kg
C24.20	40	1.57	24	0.94	34	1.34	7.0 kg	3.5 kg
C29.25	50	1.97	29	1.14	39	1.54	10.0 kg	4.7 kg
C34.30	60	2.36	34	1.34	44	1.73	13.5 kg	6.7 kg
C45.35	70	2.76	45	1.77	55	2.17	20.3 kg	10.0 kg
C45.40	80	3.15	45	1.77	55	2.17	23.0 kg	11.5 kg
C60.45	90	3.54	60	2.36	70	2.76	34.0 kg	17.0 kg
C70.50	100	3.94	70	2.76	80	3.15	43.5 kg	21.7 kg

Articles on stock – Please note that delivery time varies according to your location.



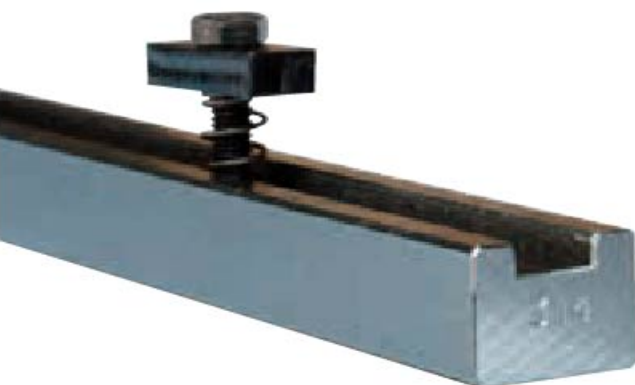
Hemming Tool

E30.22 800 kN/m max.



835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

C45: 560-710 N/mm²



Compatibility

Dies Roller Type R1 are:

- compatible with press brake machines (60 mm clamping-width) from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- also applicable on all other press brake machines with Adapter-Systems and Adapter Rails (see pages 218-221).

Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

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	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

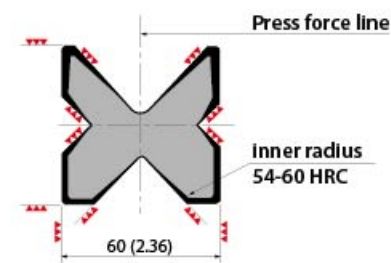
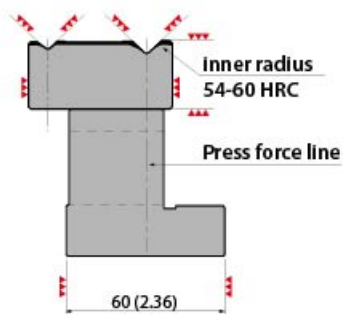
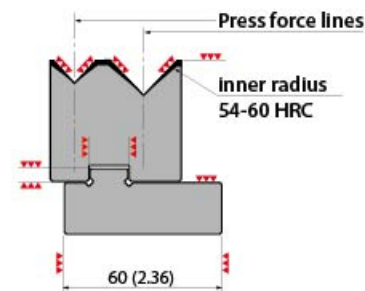
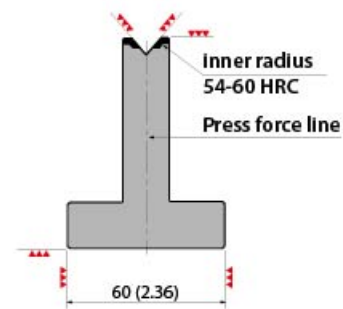
- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

Tang

All dies Roller Type R1 are standardized with a **60 mm (2.36 in) tang**. (Differing data see each tool.)

Indications of precision ground surfaces:

▼▼▼



Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 250-253)
- very large stock availability

Tool lengths and sectioning

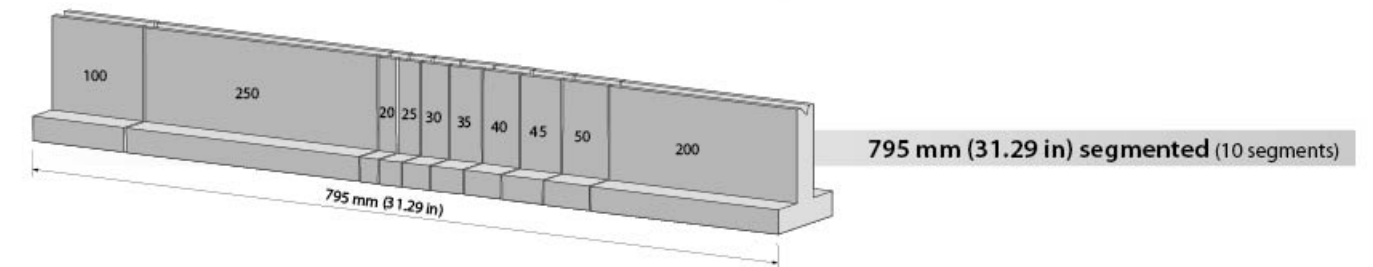
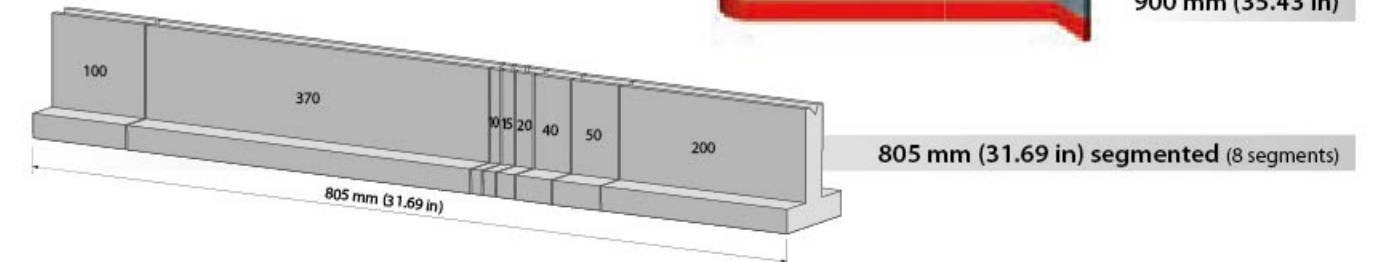
Standard

Segmented tools are delivered in complete sets. Single pieces are also available!
More lengths and sectionings are possible upon request.

835 mm (32.87 in)

415 mm (16.34 in)

900 mm (35.43 in)



Rolleri TOP-System

525 mm (20.67 in)



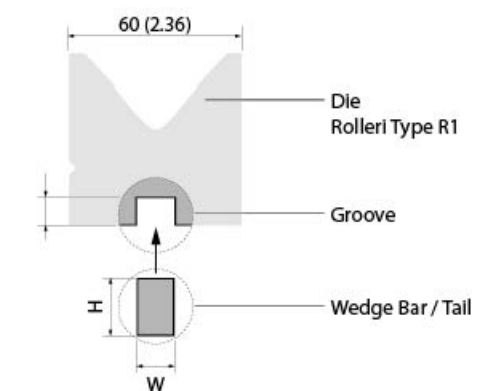
Modification: Wedge Bar / Tail

To use the dies Roller Type R1 on other press brake machines a 10 mm (0.39 in) groove is milled and a grounded wedge bar /tail is needed in the correct size.

Wedge Bar / Tail (W x H)	System
13 x 30 mm (0.51 x 1.18 in)	Rolleri Type R2 and R3 (Bystronic-Beyeler/Safan/Trumpf etc.)
55 x 55 mm (2.17 x 2.17 in)	Rolleri Type RX EHT
12.7 x 29 mm (0.50 x 1.14 in)	Rolleri Type RX LVD
35 x 55 mm (1.38 x 2.17 in)	Rolleri Type RX Weinbrenner

Specific information and prizes are found in the Roller Service / Modifications Chapter (see page 252)

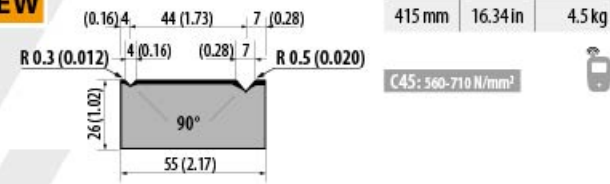
Mounting example



M26.90.03

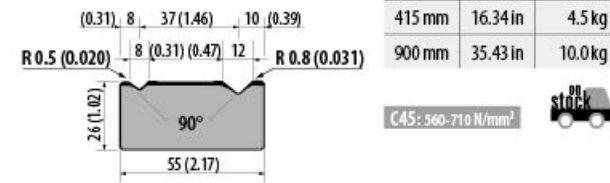
1000 kN/m max.

NEW



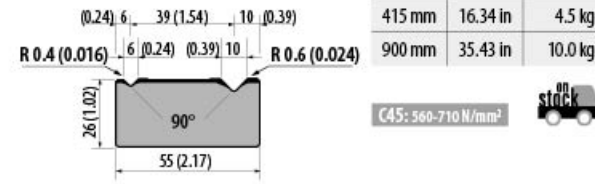
M26.90.02

1000 kN/m max.



M26.90.01

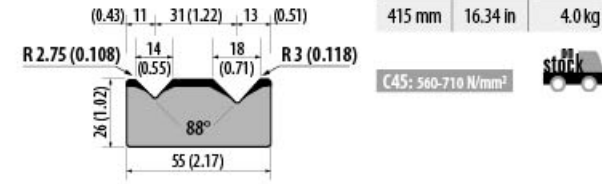
1000 kN/m max.



Die Holders for 2-V
Dies see page 43

M26.88.05

1000 kN/m max.

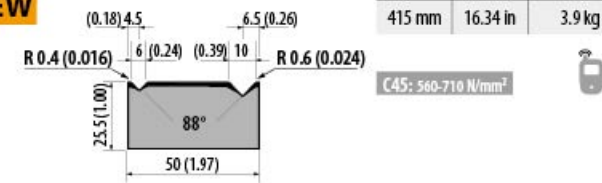


Take advantage of our
adapters on pages
218-221 when using
dies Roller Type R1.

12306

700 kN/m max.

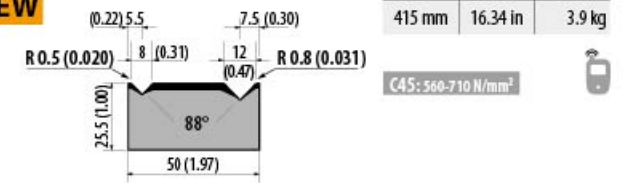
NEW



12406

800 kN/m max.

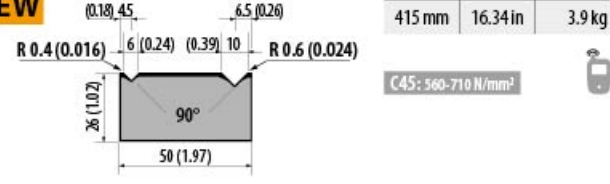
NEW



12300

700 kN/m max.

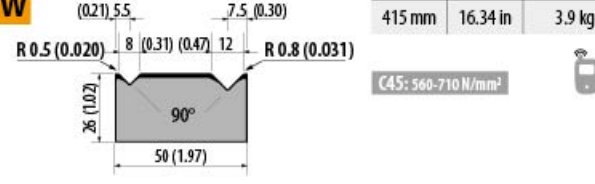
NEW



12400

800 kN/m max.

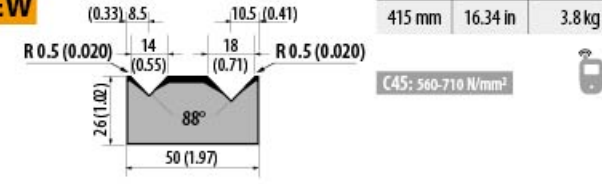
NEW



12500

1000 kN/m max.

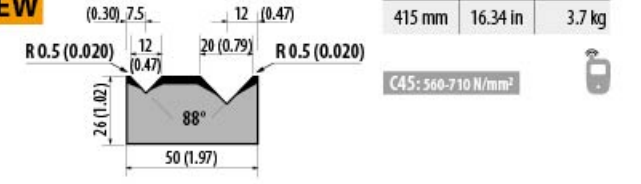
NEW



12600

1000 kN/m max.

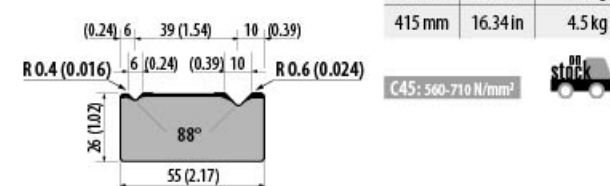
NEW



2-V Dies 88°

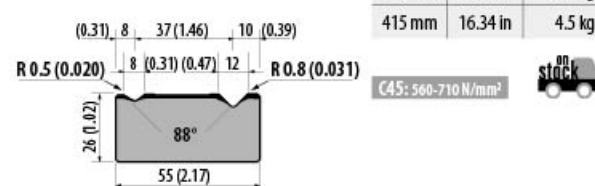
M26.88.01

1000 kN/m max.



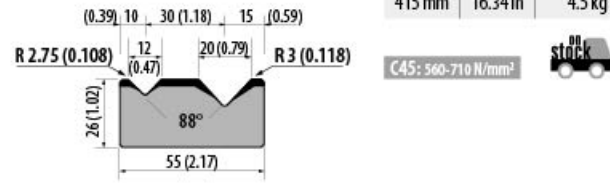
M26.88.02

1000 kN/m max.



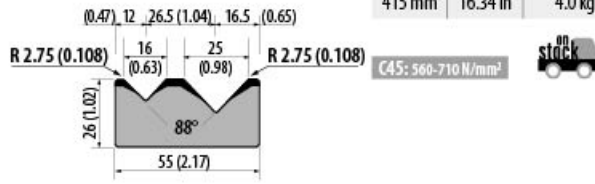
M26.88.03

1000 kN/m max.



M26.88.04

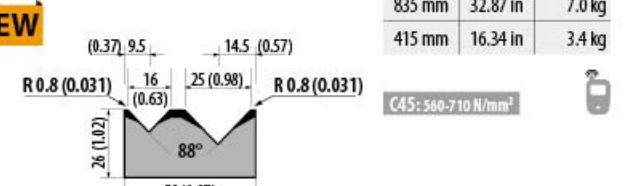
1000 kN/m max.



12700

700 kN/m max.

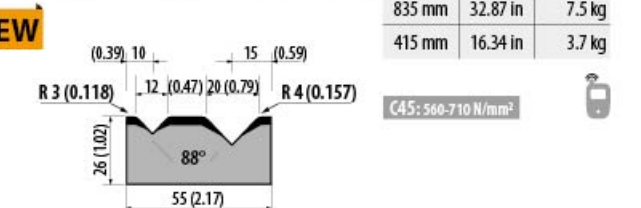
NEW



31400

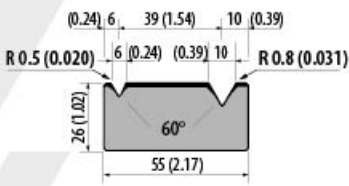
1000 kN/m max.

NEW



M26.60.01

600 kN/m max.



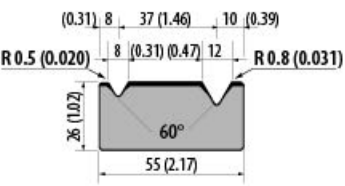
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
900 mm	35.43 in	10.0 kg

C45: 560-710 N/mm²



M26.60.02

800 kN/m max.

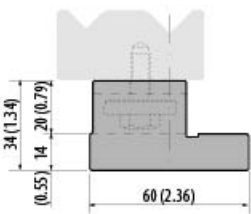


835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



SU034



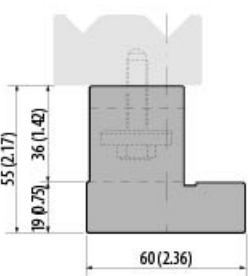
830 mm	32.68 in	9.0 kg
410 mm	16.14 in	4.5 kg

for all 2-V Dies
pages 40-42

C45: 560-710 N/mm²



SU055



830 mm	32.68 in	14.5 kg
410 mm	16.14 in	7.2 kg

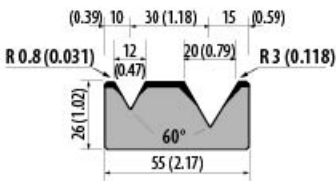
for all 2-V Dies
pages 40-42

C45: 560-710 N/mm²



M26.60.03

800 kN/m max.



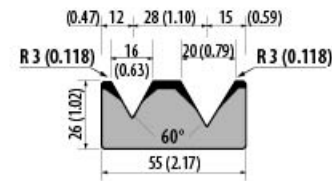
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg

C45: 560-710 N/mm²



M26.60.05

800 kN/m max.

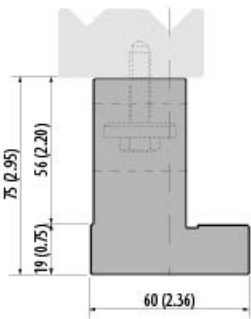


835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg

C45: 560-710 N/mm²



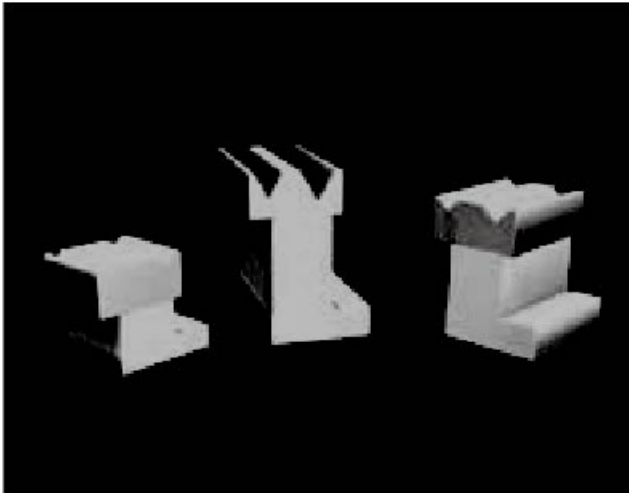
SU075



830 mm	32.68 in	20.5 kg
410 mm	16.14 in	10.0 kg

for all 2-V Dies
pages 40-42

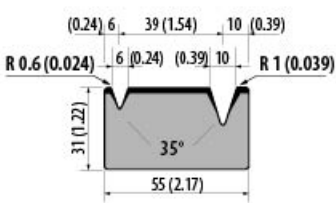
C45: 560-710 N/mm²



2-V Dies 35°

M31.35.01

300 kN/m max.



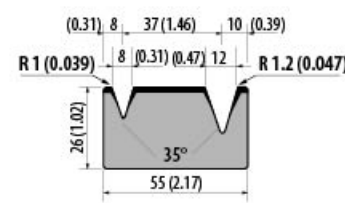
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg

C45: 560-710 N/mm²



M31.35.02

300 kN/m max.



835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg

C45: 560-710 N/mm²



Articles on stock – Please
note that delivery
time varies
according to
your location.

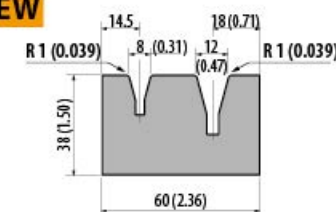


2-V Dies 30°

33700

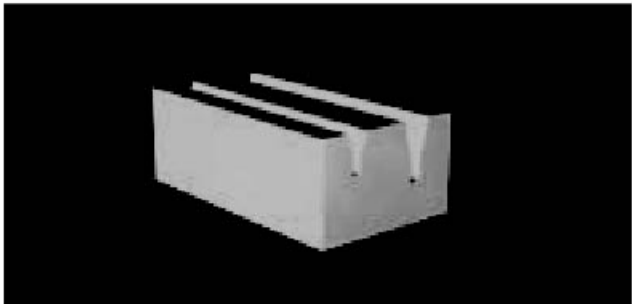
300 kN/m max.

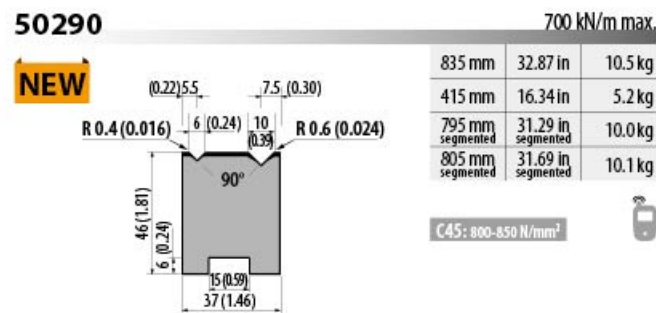
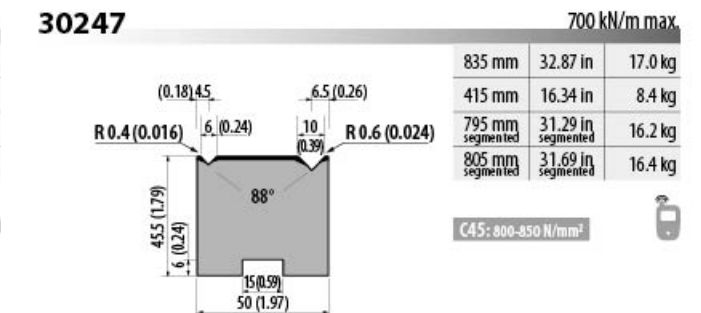
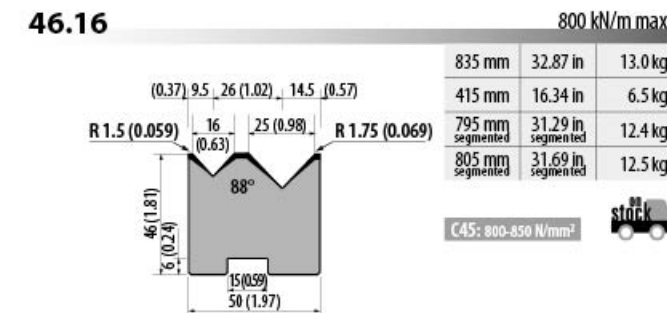
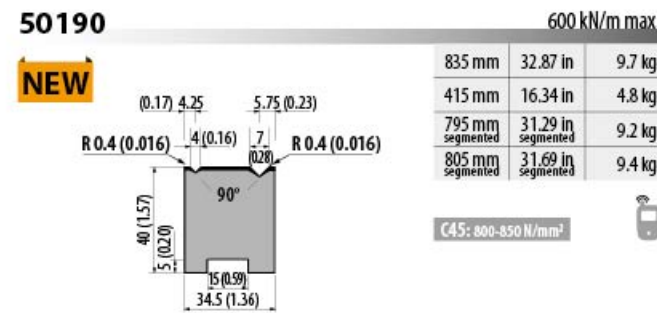
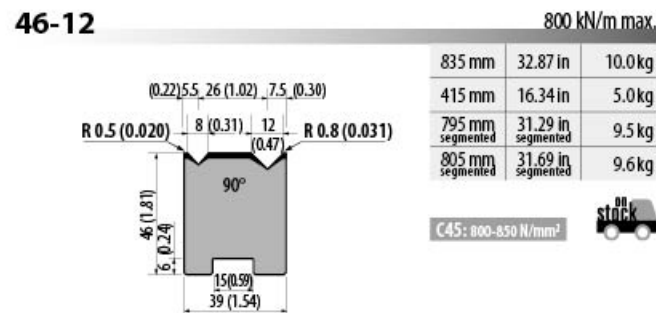
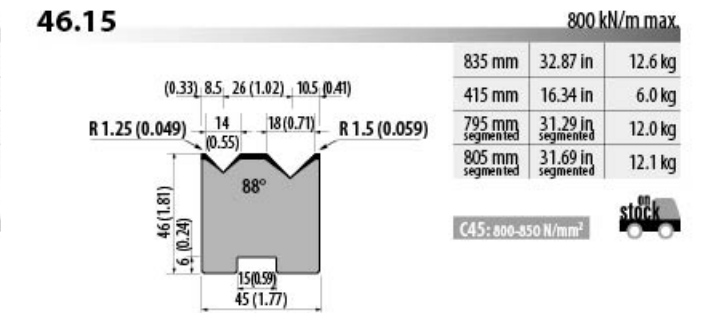
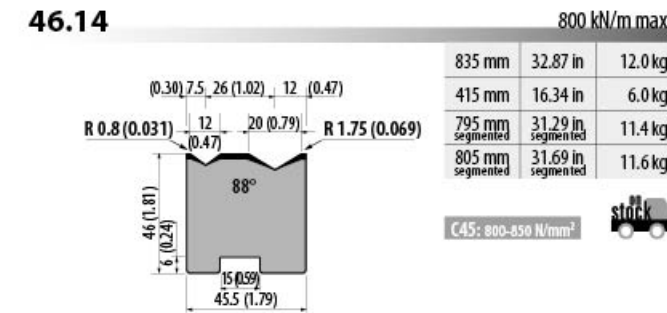
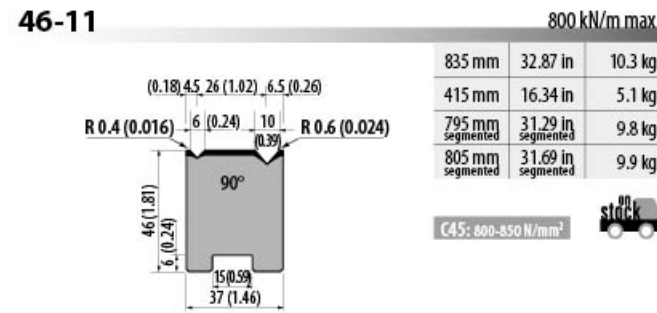
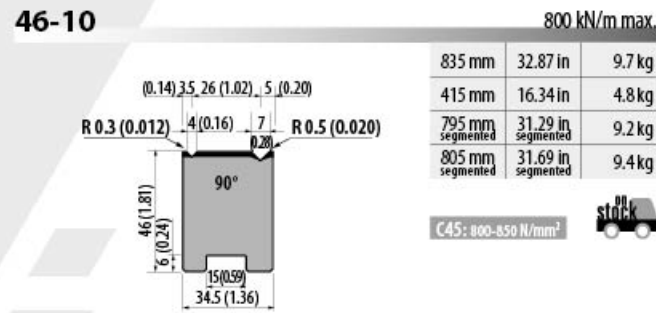
NEW



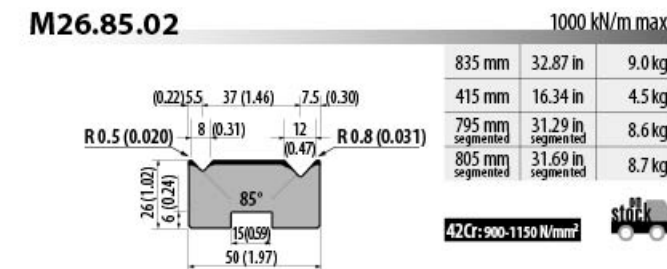
835 mm	32.87 in	13.3 kg
415 mm	16.34 in	5.6 kg

42Cr: 900-1150 N/mm²

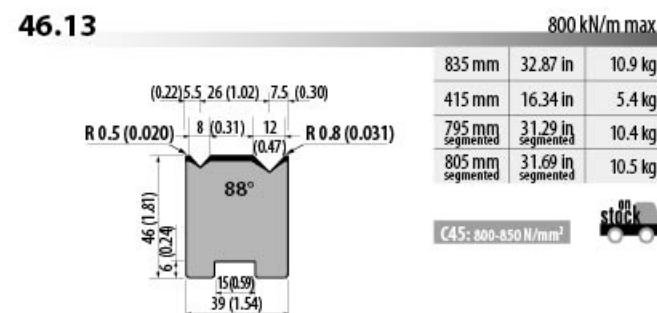
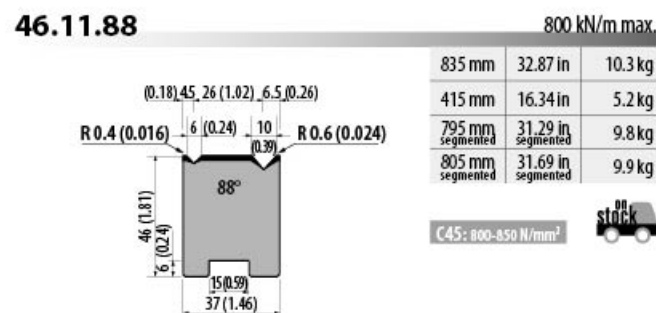




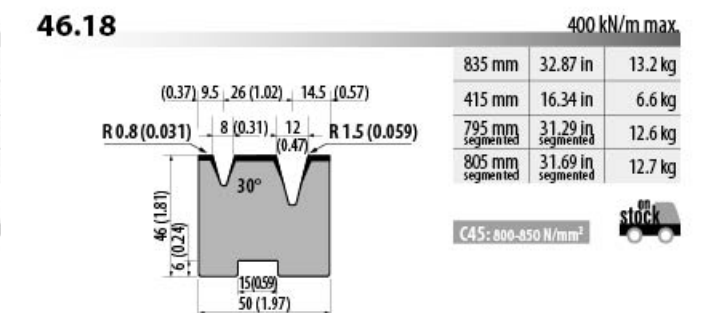
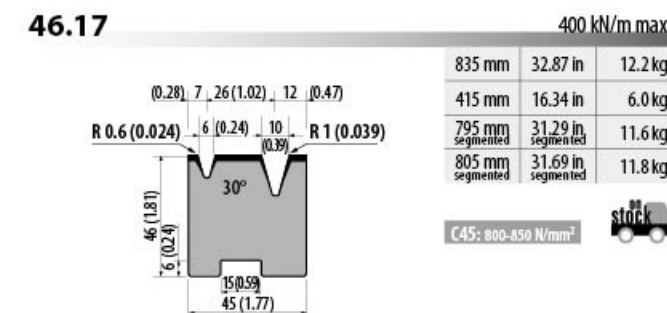
Self Centering 2-V Dies 85°

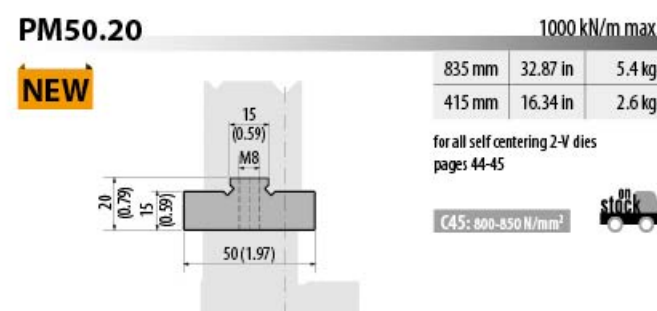
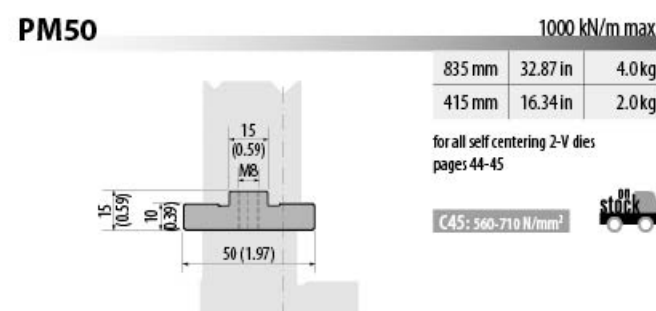
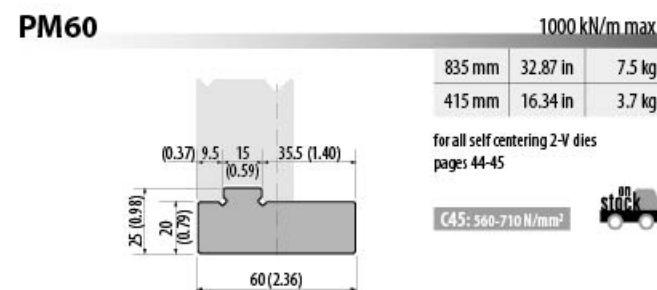


Self Centering 2-V Dies 88°



Self Centering 2-V Dies 30°





The following options are available to prevent bending marks on the surfaces:

- Protective Sheets
- PU-Upholstery
- Synthetic Dies

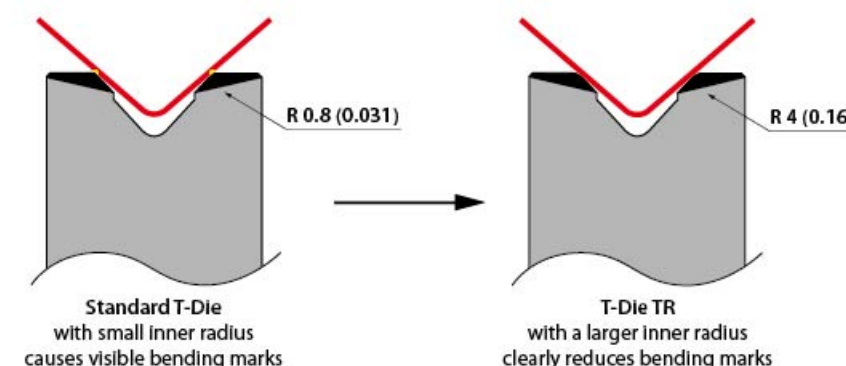
The alternative to these options mentioned above, is a modification of the dies:

- enlargement of the dies' inner radius
(Retrofitting of new or existing dies)

This solution is available on stock for some of our T-Dies under the Article No.: TR

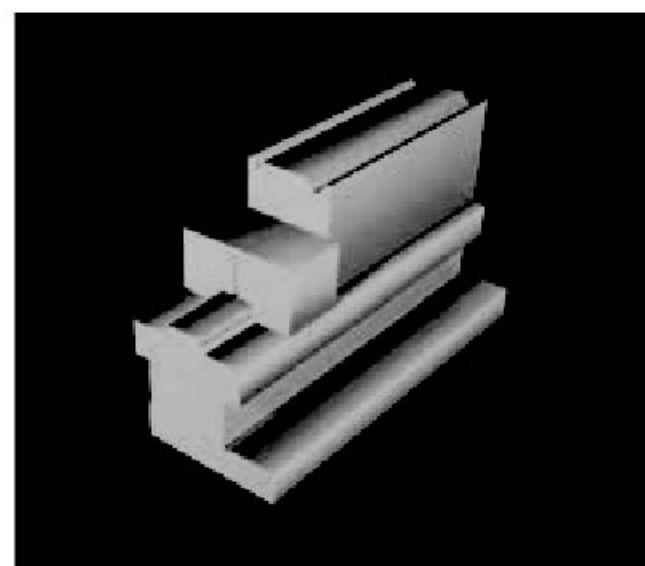
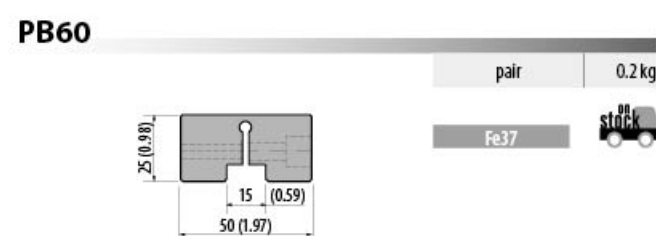
Our Advantages – Your Convenience

- Prevention of streaks and markings on the bended sheet metals
- No post processing necessary and therefore, time- and cost efficient.
- No contact of bending pieces
- increases product quality
- easy handling



Specific information
for mark-free bending
see pages 222-229

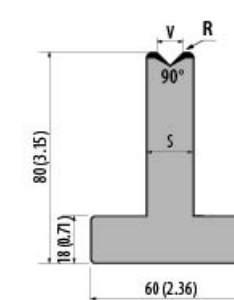
Clamping Piece for Self Centering 2-V Dies



Articles on stock – Please note that delivery time varies according to your location.

T-Dies 90°, H=80 (3.15), H=120 (4.72)

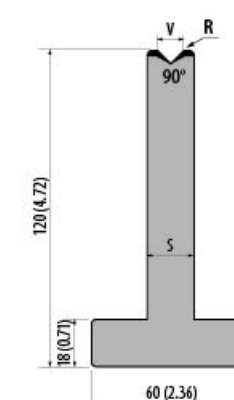
T-Dies 90°, H=80 mm (3.15 in)



1000 kN/m max.											
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight	Weight
T80.06.90	6	0.24	0.4	0.02	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg	14.0 kg
T80.08.90	8	0.31	0.5	0.02	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg	14.0 kg
T80.10.90	10	0.39	0.6	0.02	18	0.71	14.2 kg	7.0 kg	13.5 kg	13.7 kg	14.5 kg
T80.12.90	12	0.47	0.8	0.03	18	0.71	15.0 kg	7.5 kg	14.3 kg	14.5 kg	15.0 kg

C45: 560-710 N/mm²

T-Dies 90°, H=120 mm (4.72 in)

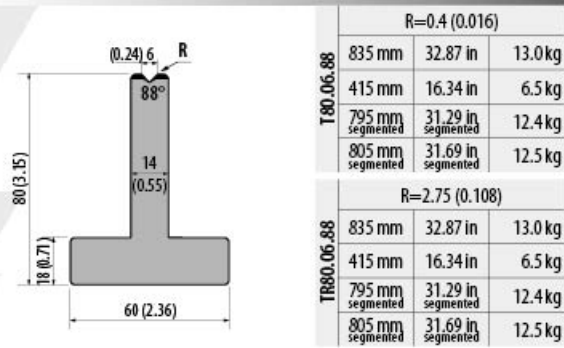


1000 kN/m max.											
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight	Weight
T120.06.90	6	0.24	0.4	0.02	14	0.55	16.0 kg	8.0 kg	15.2 kg	15.2 kg	15.4 kg
T120.08.90	8	0.31	0.5	0.02	14	0.55	16.0 kg	8.0 kg	15.2 kg	15.2 kg	15.4 kg
T120.10.90	10	0.39	0.6	0.02	18	0.71	19.0 kg	9.0 kg	18.1 kg	18.1 kg	18.3 kg
T120.12.90	12	0.47	0.8	0.03	18	0.71	19.0 kg	9.0 kg	18.1 kg	18.1 kg	18.3 kg

C45: 560-710 N/mm²

T80.06.88 / TR80.06.88

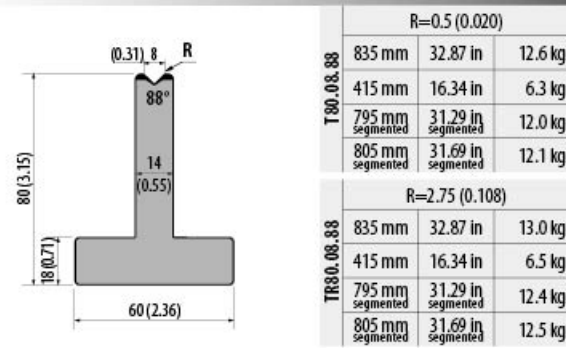
1000 kN/m max.



C45: 560-710 N/mm²

T80.08.88 / TR80.08.88

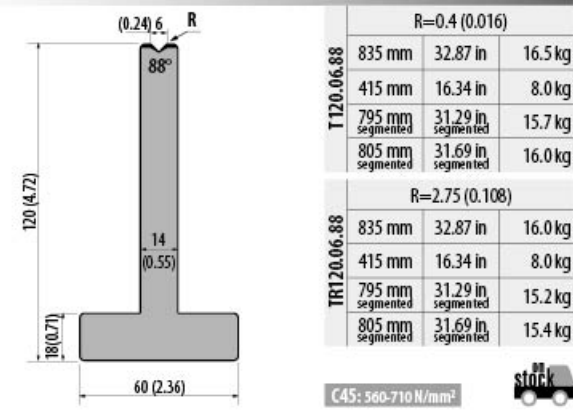
1000 kN/m max.



C45: 560-710 N/mm²

T120.06.88 / TR120.06.88

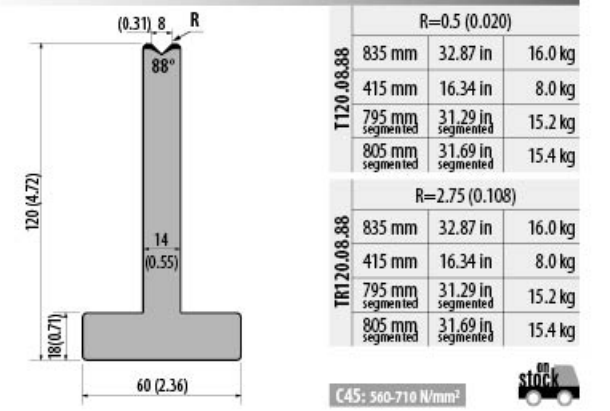
1000 kN/m max.



C45: 560-710 N/mm²

T120.08.88 / TR120.08.88

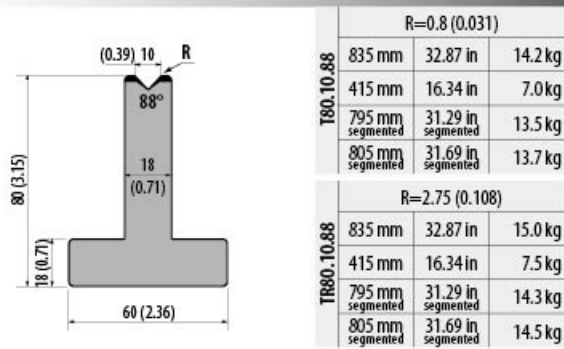
1000 kN/m max.



C45: 560-710 N/mm²

T80.10.88 / TR80.10.88

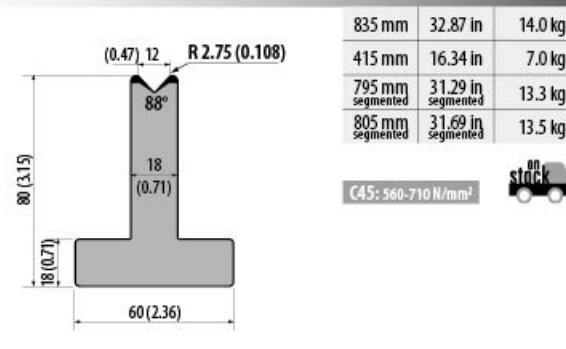
1000 kN/m max.



C45: 560-710 N/mm²

T80.12.88

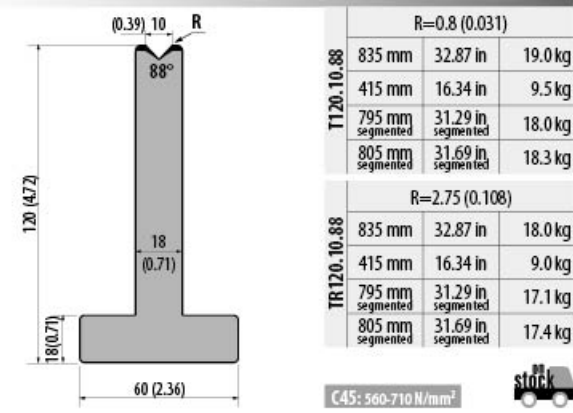
1000 kN/m max.



C45: 560-710 N/mm²

T120.10.88 / TR120.10.88

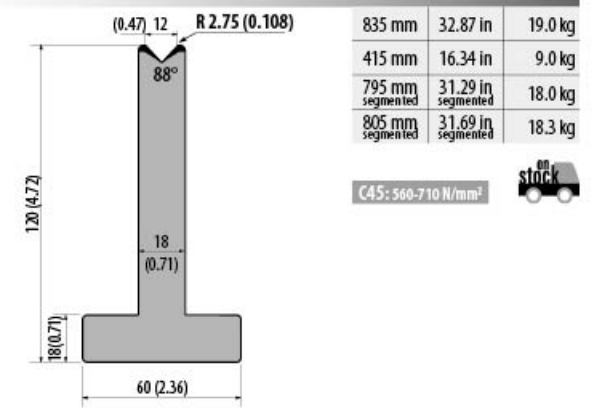
1000 kN/m max.



C45: 560-710 N/mm²

T120.12.88

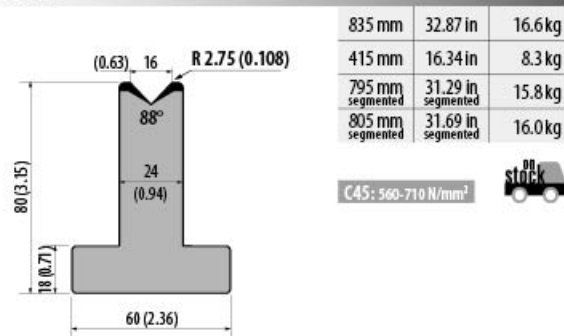
1000 kN/m max.



C45: 560-710 N/mm²

T80.16.88

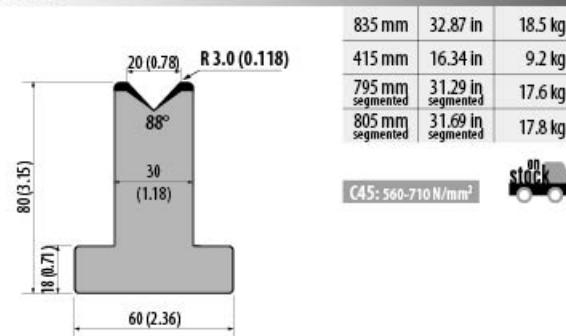
1000 kN/m max.



C45: 560-710 N/mm²

T80.20.88

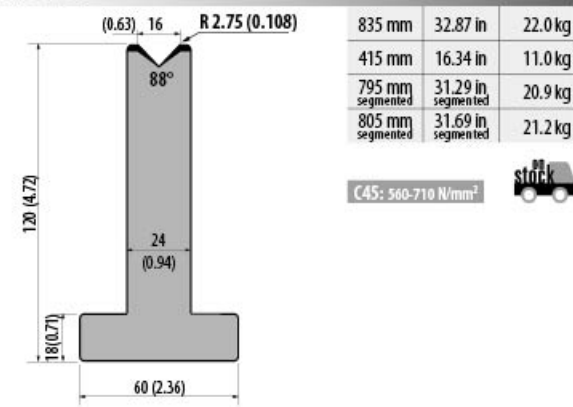
1000 kN/m max.



C45: 560-710 N/mm²

T120.16.88

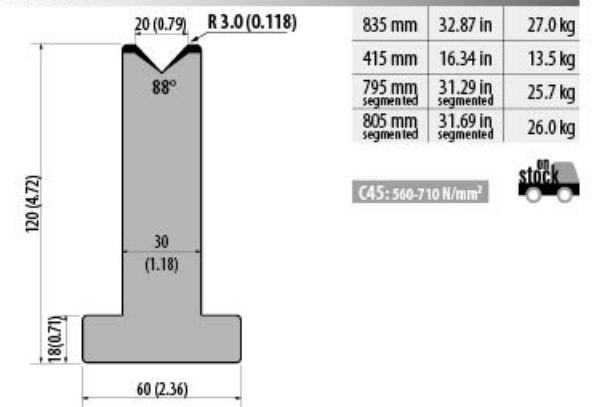
1000 kN/m max.



C45: 560-710 N/mm²

T120.20.88

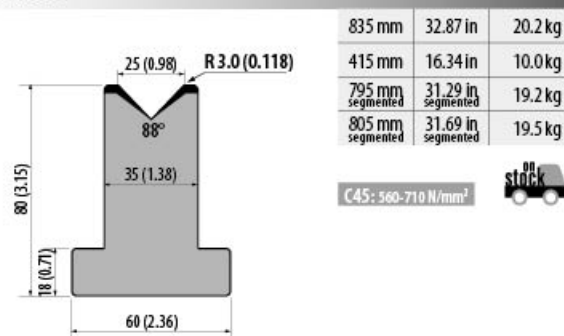
1000 kN/m max.



C45: 560-710 N/mm²

T80.25.88

1000 kN/m max.

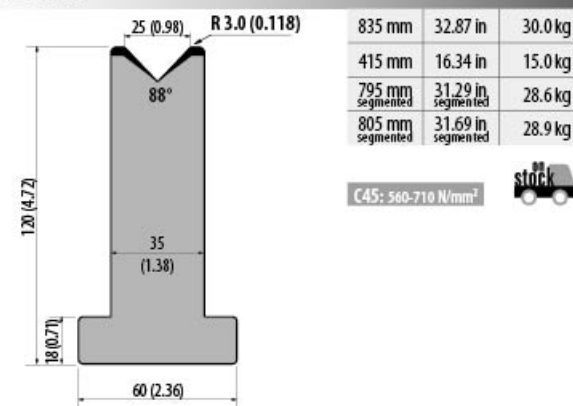


C45: 560-710 N/mm²

Articles on stock – Please note that delivery time varies according to your location.

T120.25.88

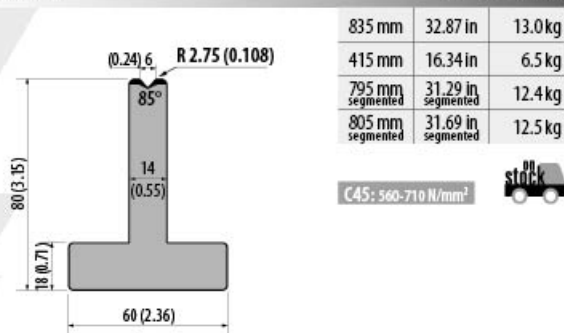
1000 kN/m max.



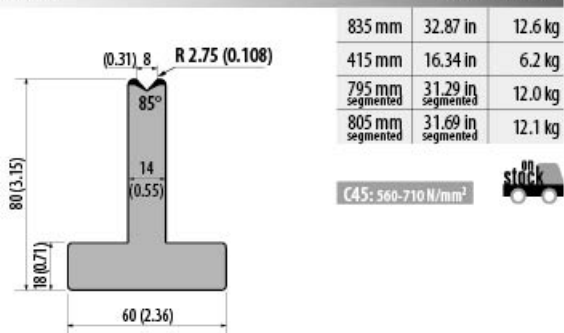
C45: 560-710 N/mm²

Visit our Homepage at:
www.rolleritools.com

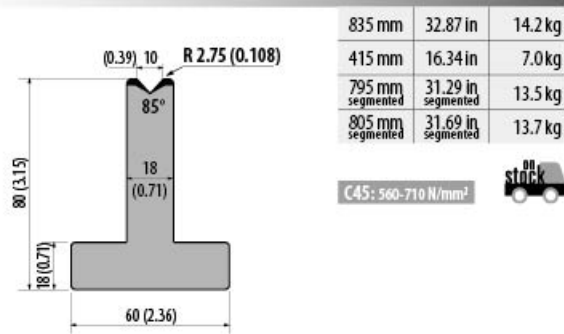
T80.06.85 1000 kN/m max.



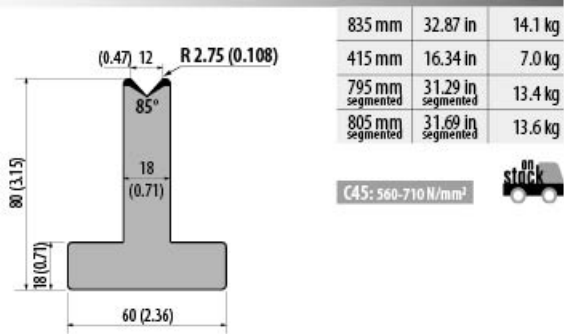
T80.08.85 1000 kN/m max.



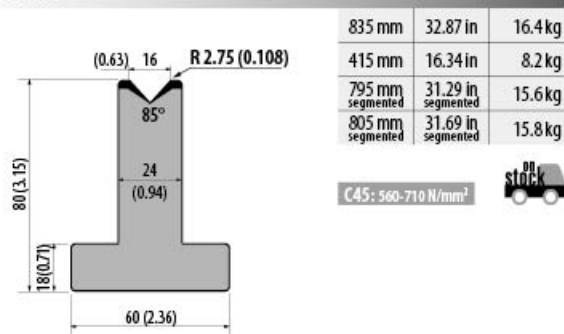
T80.10.85 1000 kN/m max.



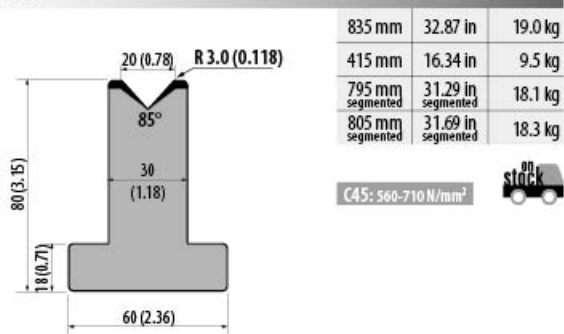
T80.12.85 1000 kN/m max.



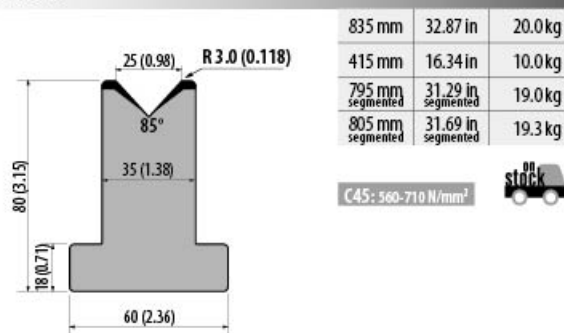
T80.16.85 1000 kN/m max.



T80.20.85 1000 kN/m max.

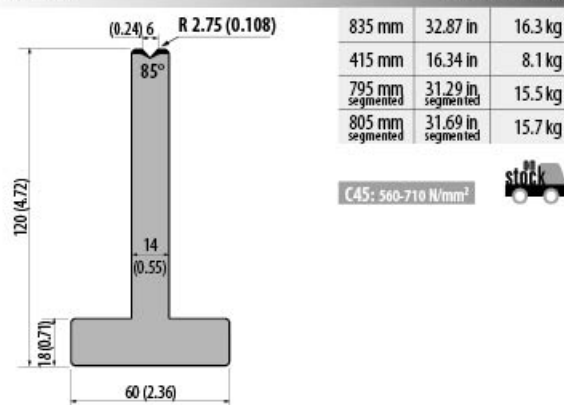


T80.25.85 1000 kN/m max.

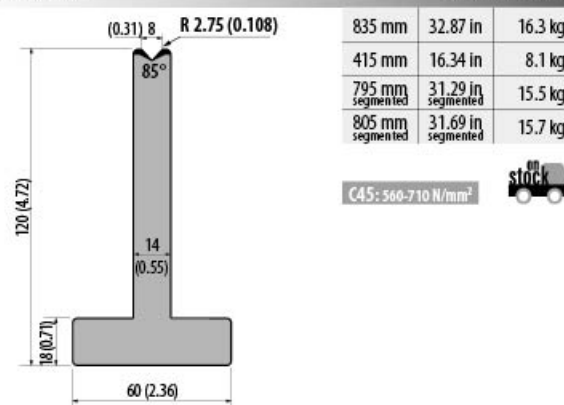


Do you have queries about delivery times, operational areas, and other possibilities? Give us a call!

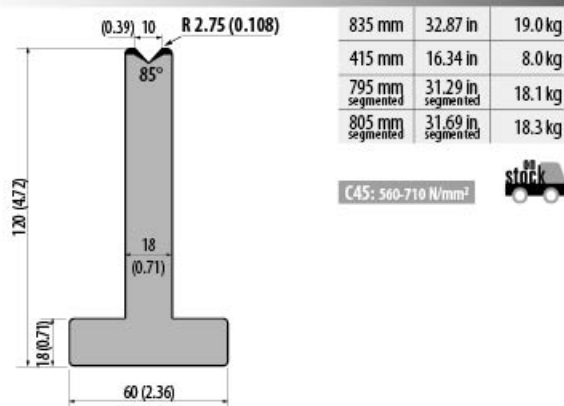
T120.06.85 1000 kN/m max.



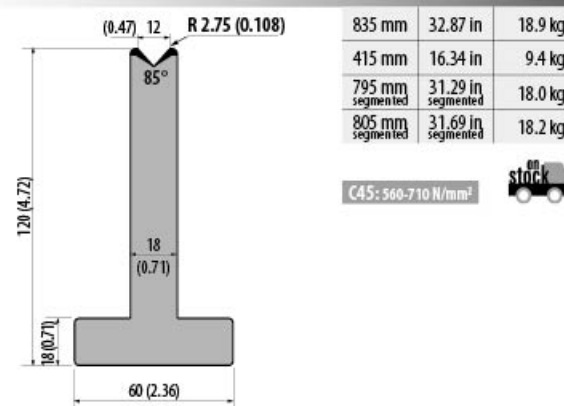
T120.08.85 1000 kN/m max.



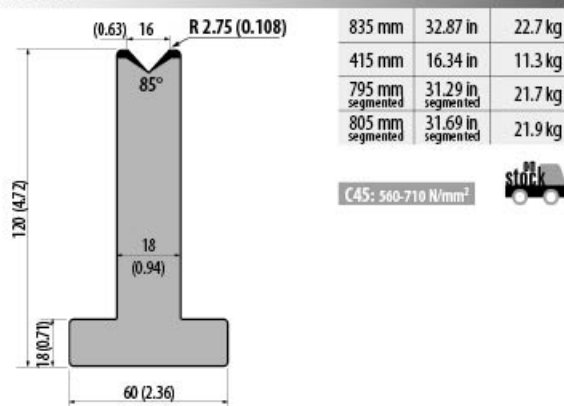
T120.10.85 1000 kN/m max.



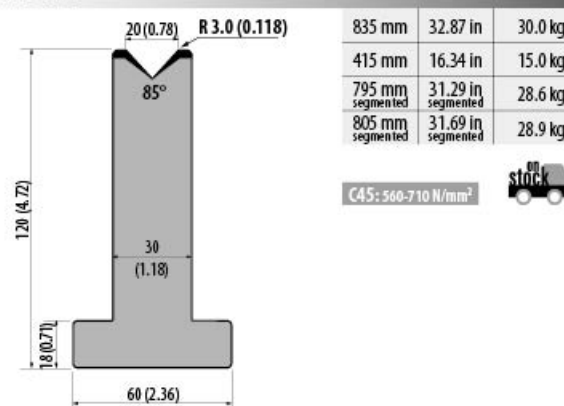
T120.12.85 1000 kN/m max.



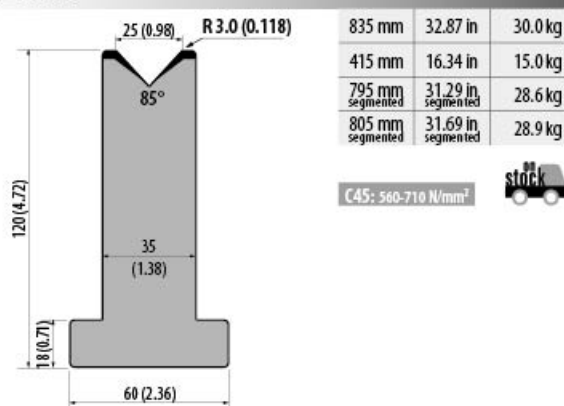
T120.16.85 1000 kN/m max.



T120.20.85 1000 kN/m max.

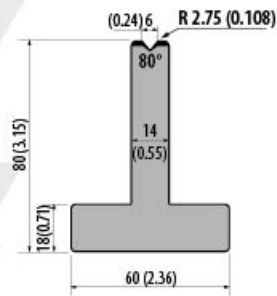


T120.25.85 1000 kN/m max.



T80.06.80

950 kN/m max.



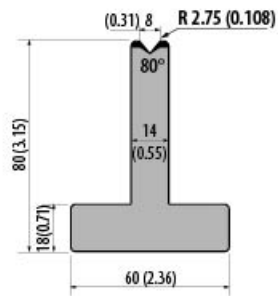
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.08.80

950 kN/m max.



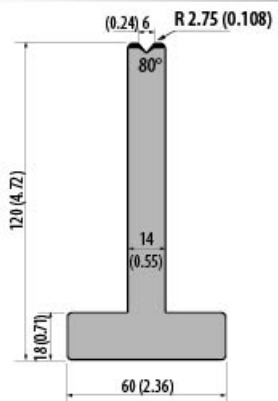
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T120.06.80

950 kN/m max.



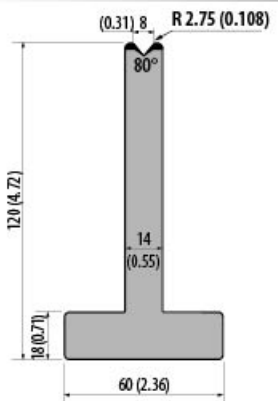
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.08.80

950 kN/m max.



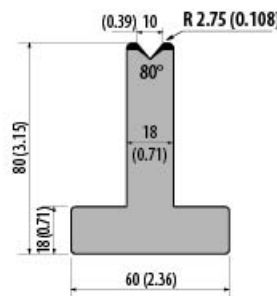
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T80.10.80

950 kN/m max.



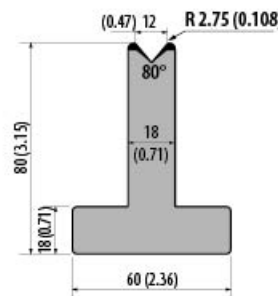
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.12.80

950 kN/m max.



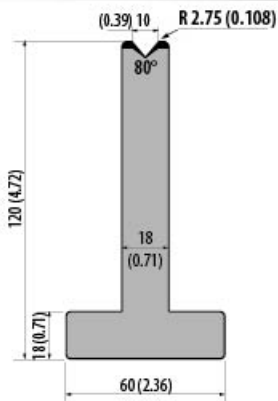
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T120.10.80

950 kN/m max.



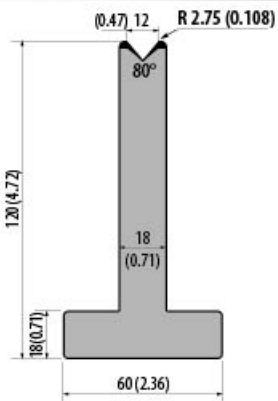
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.12.80

950 kN/m max.



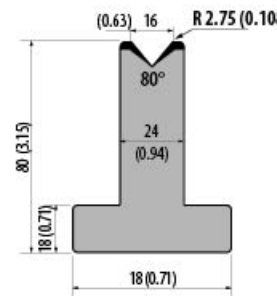
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T80.16.80

950 kN/m max.



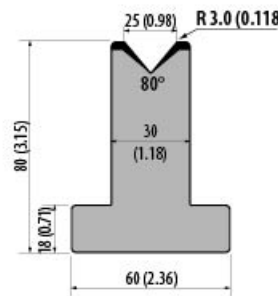
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.20.80

950 kN/m max.



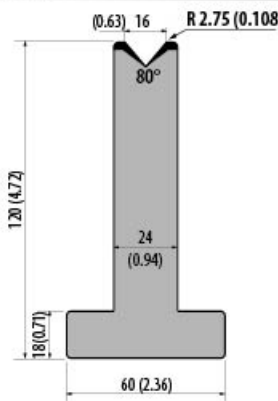
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T120.16.80

950 kN/m max.



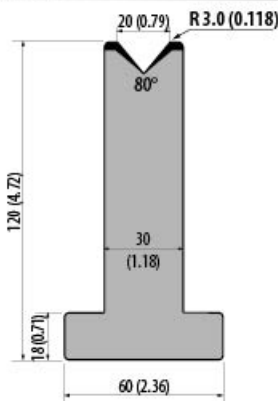
835 mm	32.87 in	18.8 kg
415 mm	16.34 in	9.3 kg
795 mm segmented	31.29 in segmented	17.9 kg
805 mm segmented	31.69 in segmented	18.1 kg

C45: 560-710 N/mm²



T120.20.80

950 kN/m max.



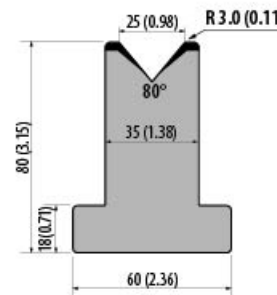
835 mm	32.87 in	26.3 kg
415 mm	16.34 in	13.0 kg
795 mm segmented	31.29 in segmented	25.0 kg
805 mm segmented	31.69 in segmented	25.4 kg

C45: 560-710 N/mm²



T80.25.80

950 kN/m max.



835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

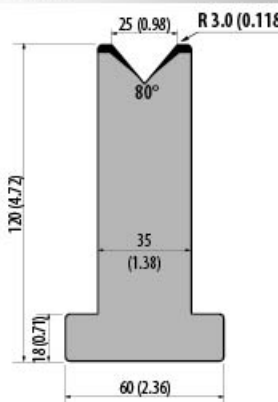
C45: 560-710 N/mm²



More than 20.000 tools
are available for you in
our warehouse!

T120.25.80

950 kN/m max.



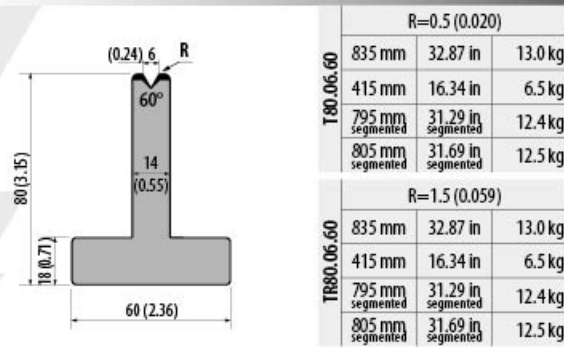
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	18.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

C45: 560-710 N/mm²



T80.06.60 / TR80.06.60

600 kN/m max.

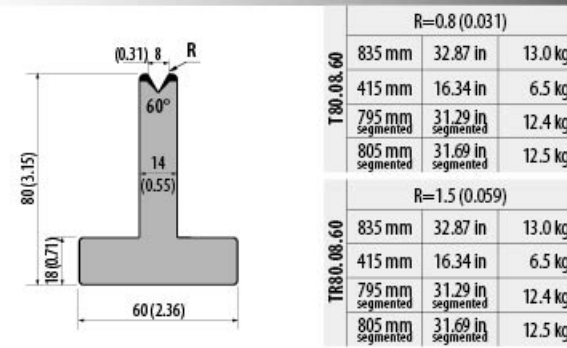


C45: 560-710 N/mm²



T80.08.60 / TR80.08.60

600 kN/m max.

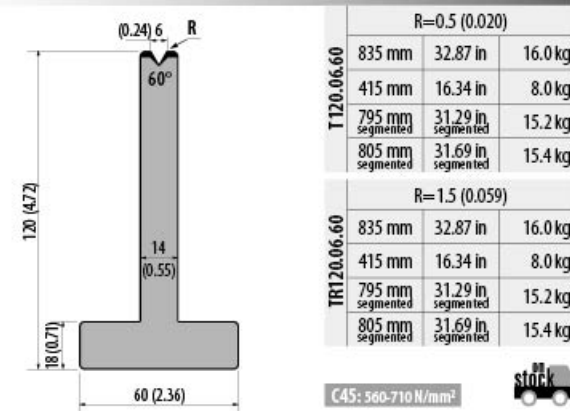


C45: 560-710 N/mm²



T120.06.60 / TR120.06.60

600 kN/m max.

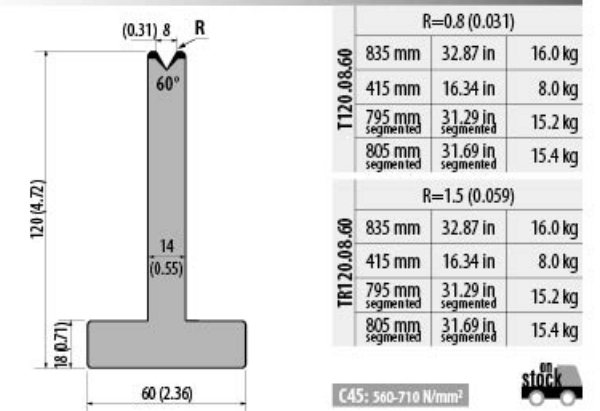


C45: 560-710 N/mm²



T120.08.60 / TR120.08.60

600 kN/m max.

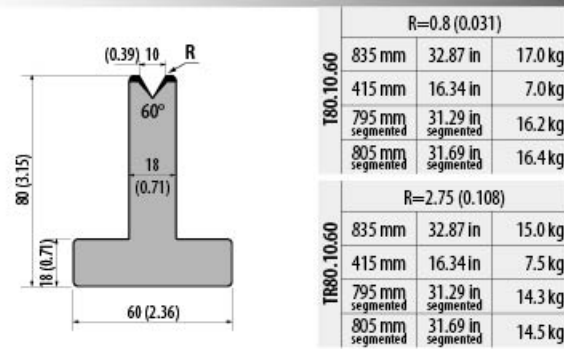


C45: 560-710 N/mm²



T80.10.60 / TR80.10.60

600 kN/m max.

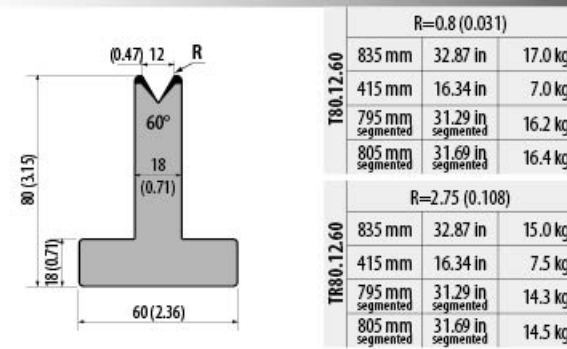


C45: 560-710 N/mm²



T80.12.60 / TR80.12.60

600 kN/m max.

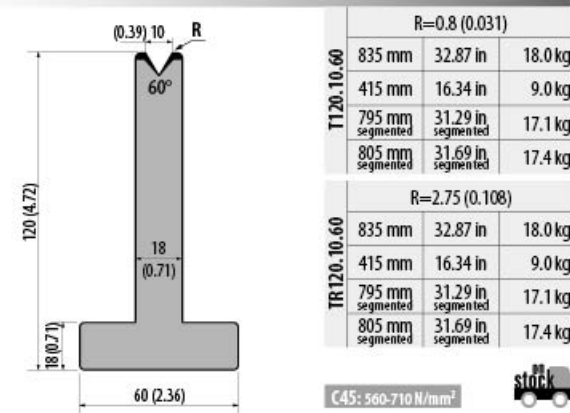


C45: 560-710 N/mm²



T120.10.60 / TR120.10.60

600 kN/m max.

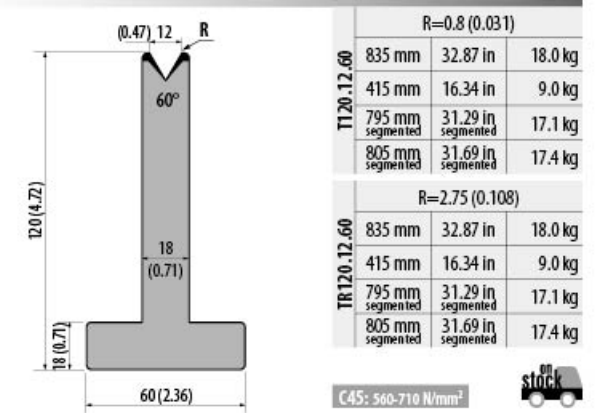


C45: 560-710 N/mm²



T120.12.60 / TR120.12.60

600 kN/m max.

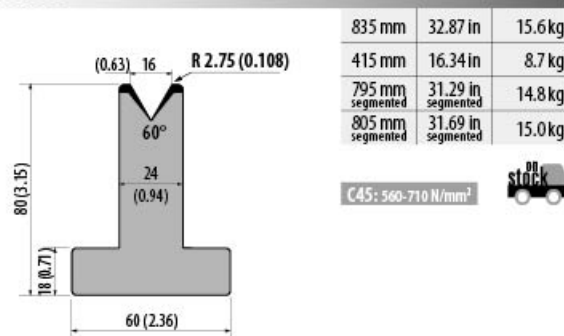


C45: 560-710 N/mm²



T80.16.60

600 kN/m max.

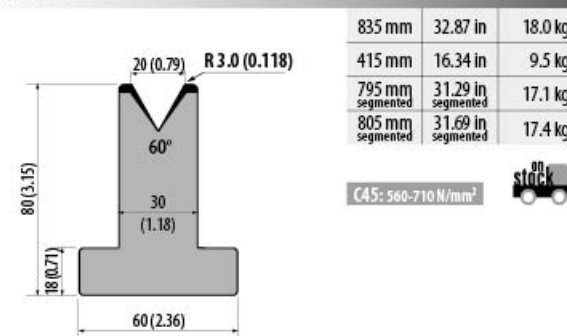


C45: 560-710 N/mm²



T80.20.60

600 kN/m max.

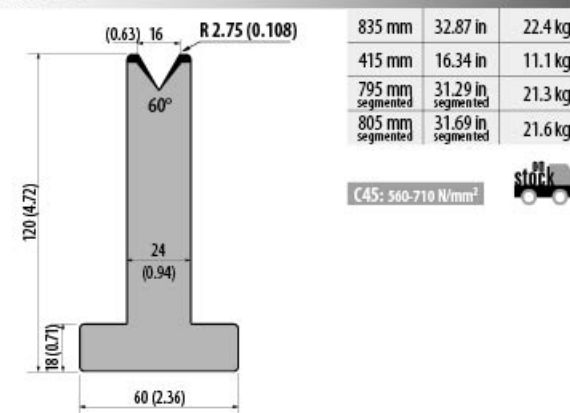


C45: 560-710 N/mm²



T120.16.60

600 kN/m max.

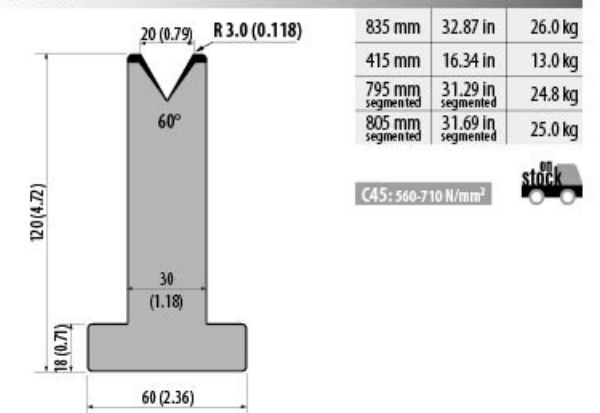


C45: 560-710 N/mm²



T120.20.60

600 kN/m max.

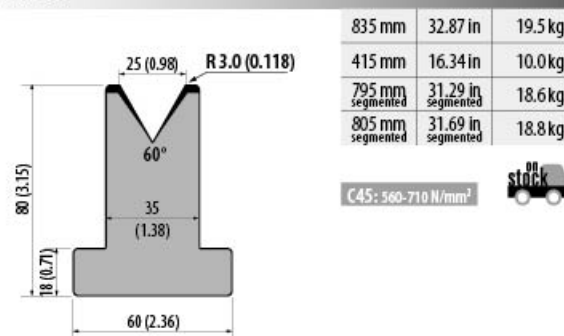


C45: 560-710 N/mm²



T80.25.60

600 kN/m max.

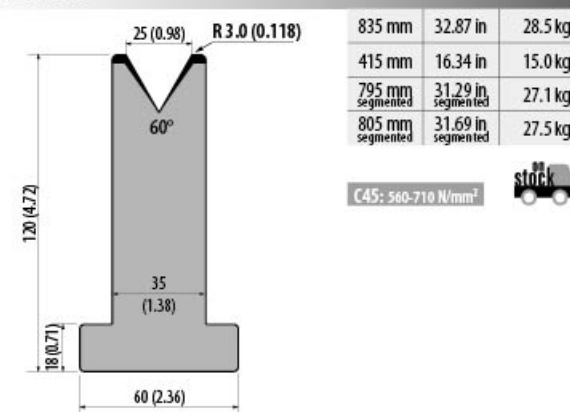


C45: 560-710 N/mm²



T120.25.60

600 kN/m max.

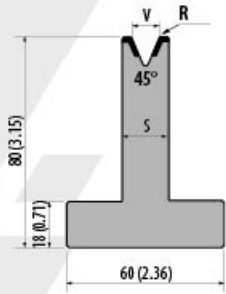


C45: 560-710 N/mm²



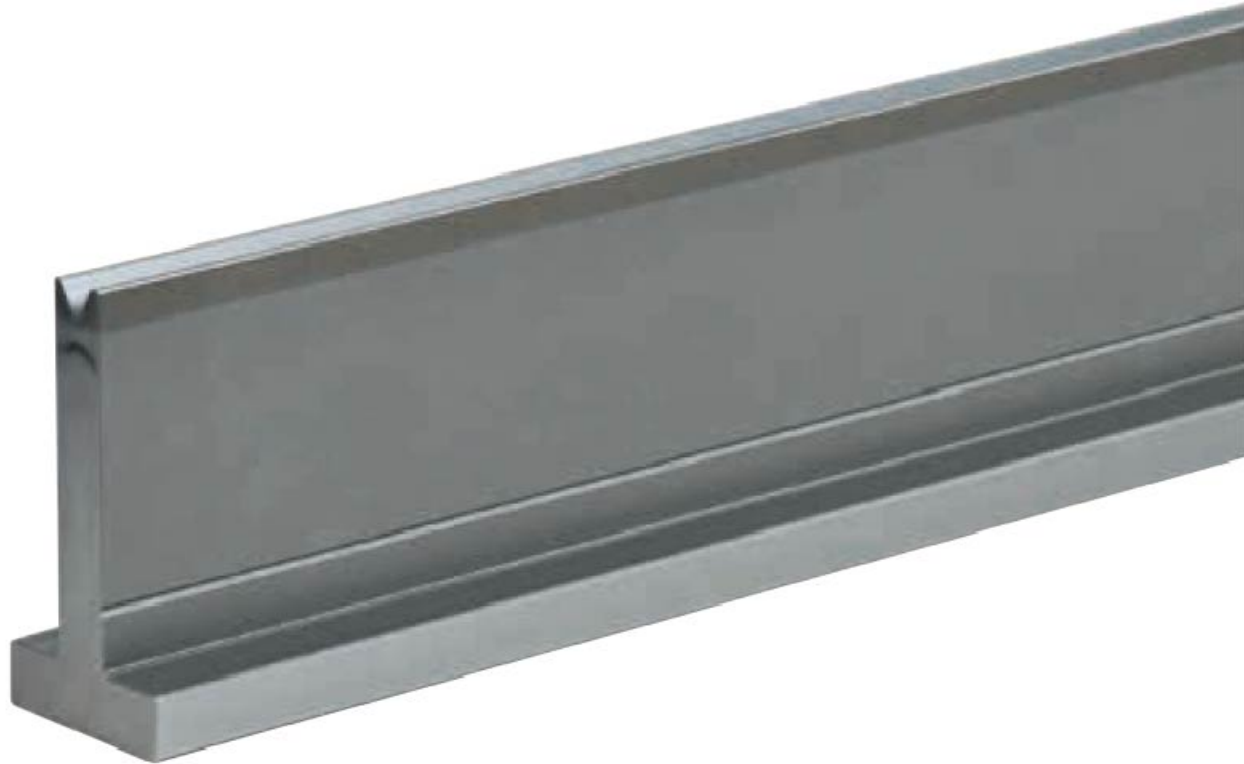
For modifications
on dies
see pages 250-253

T-Dies 45°, H=80 mm (3.15 in)

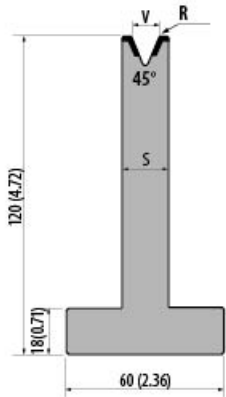


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight
T80.06.45	6	0.24	0.8	0.03	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.08.45	8	0.31	1.0	0.04	18	0.71	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.10.45	10	0.39	1.2	0.05	18	0.71	14.0 kg	7.0 kg	13.3 kg	13.5 kg
T80.12.45	12	0.47	1.6	0.06	24	0.94	16.3 kg	8.1 kg	15.5 kg	15.7 kg
T80.16.45	16	0.63	2.75	0.11	26	1.02	16.6 kg	8.3 kg	15.8 kg	16.0 kg
T80.20.45	20	0.79	3.0	0.12	30	1.18	18.0 kg	9.0 kg	17.1 kg	17.3 kg
T80.25.45	25	0.98	3.0	0.12	37	1.46	20.0 kg	10.0 kg	19.0 kg	19.3 kg

C45: 560-710 N/mm²

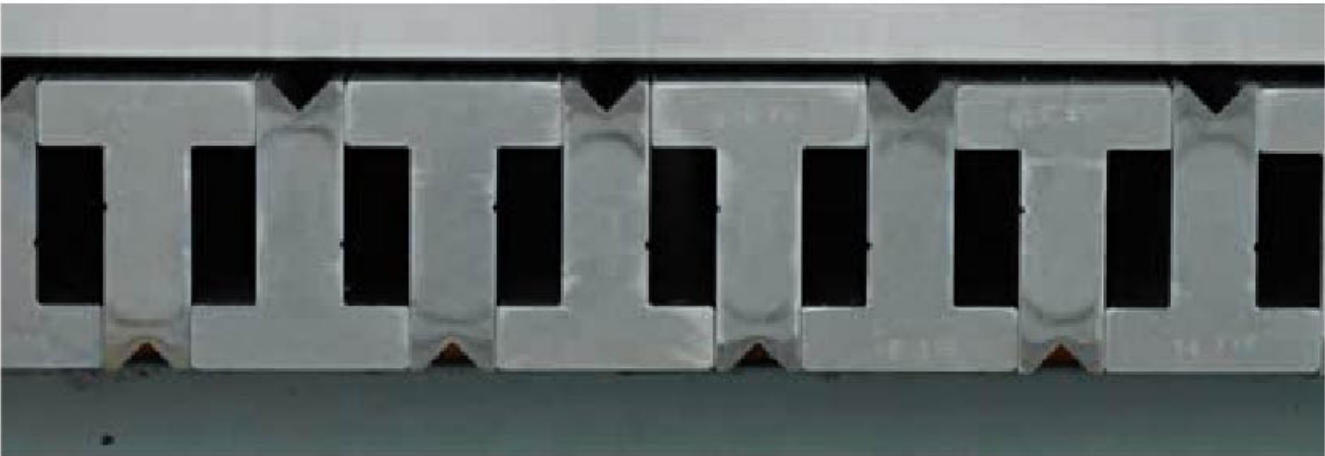


T-Dies 45°, H=120 mm (4.72 in)

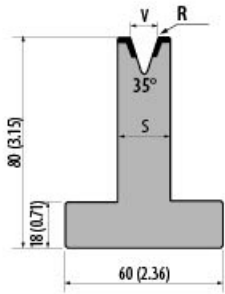


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight
T120.06.45	6	0.24	0.8	0.03	14	0.55	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T120.08.45	8	0.31	1.0	0.04	18	0.71	18.0 kg	9.0 kg	17.1 kg	17.3 kg
T120.10.45	10	0.39	1.2	0.05	18	0.71	18.0 kg	9.0 kg	17.1 kg	17.3 kg
T120.12.45	12	0.47	1.6	0.06	24	0.94	18.0 kg	9.0 kg	17.1 kg	17.3 kg
T120.16.45	16	0.63	2.75	0.11	26	1.02	25.0 kg	12.5 kg	23.8 kg	24.1 kg
T120.20.45	20	0.79	3.0	0.12	30	1.18	26.0 kg	13.5 kg	24.8 kg	25.0 kg
T120.25.45	20	0.79	3.0	0.12	37	1.46	30.0 kg	15.0 kg	28.6 kg	28.9 kg

C45: 560-710 N/mm²



T-Dies 35°, H=80 mm (3.15 in)

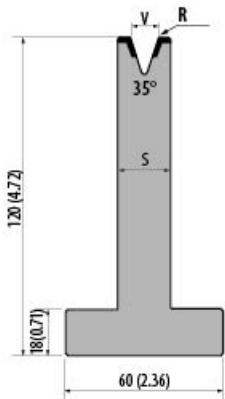


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	kN/m max.	Weight	Weight	Weight	Weight
T80.06.35	6	0.24	0.8	0.03	14	0.55	350	12.5 kg	6.5 kg	11.9 kg	12.0 kg
T80.08.35	8	0.31	1.0	0.04	16	0.63	350	13.0 kg	7.0 kg	12.4 kg	12.6 kg
T80.10.35	10	0.39	1.2	0.05	20	0.79	400	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.12.35	12	0.47	1.6	0.06	22	0.87	400	15.5 kg	8.0 kg	14.8 kg	15.0 kg
T80.16.35	16	0.63	3.0	0.12	30	1.18	450	18.0 kg	8.5 kg	17.1 kg	17.3 kg
T80.20.35	20	0.79	3.0	0.12	35	1.38	500	19.3 kg	9.0 kg	18.4 kg	18.6 kg
T80.25.35	25	0.98	3.0	0.12	40	1.57	500	20.0 kg	9.9 kg	19.0 kg	19.3 kg

C45: 560-710 N/mm²



T-Dies 35°, H=120 mm (4.72 in)



Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	kN/m max.	Weight	Weight	Weight	Weight
T120.06.35	6	0.24	0.8	0.03	14	0.55	350	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T120.08.35	8	0.31	1.0	0.04	16	0.63	350	18.0 kg	9.0 kg	17.1 kg	17.3 kg
T120.10.35	10	0.39	1.2	0.05	20	0.79	400	19.9 kg	8.5 kg	18.9 kg	19.1 kg
T120.12.35	12	0.47	1.6	0.06	22	0.87	400	21.0 kg	10.0 kg	20.0 kg	20.2 kg
T120.16.35	16	0.63	3.0	0.12	30	1.18	450	25.8 kg	12.8 kg	24.6 kg	24.8 kg
T120.20.35	20	0.79	3.0	0.12	35	1.38	500	28.0 kg	14.0 kg	26.7 kg	27.0 kg
T120.25.35	25	0.98	3.0	0.12	40	1.57	500	30.5 kg	15.2 kg	29.0 kg	29.4 kg

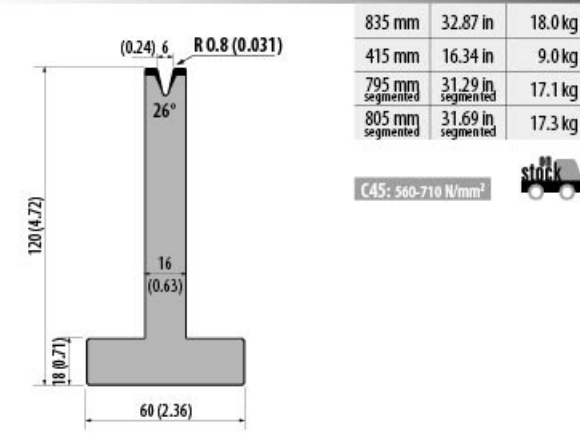
C45: 560-710 N/mm²





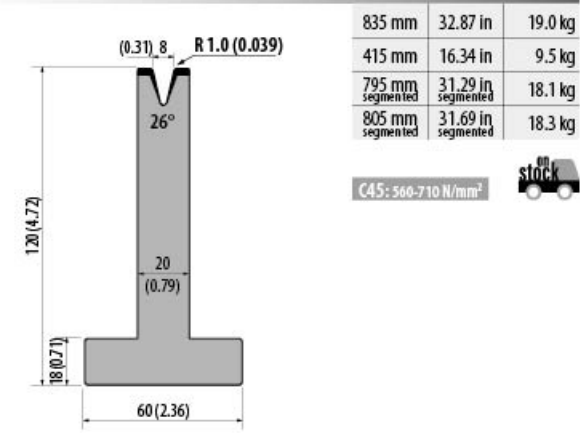
T120.06.26

200 kN/m max.



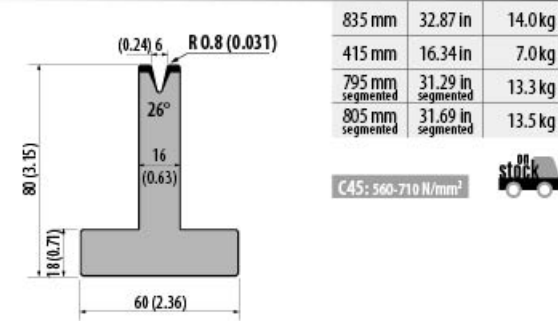
T120.08.26

200 kN/m max.



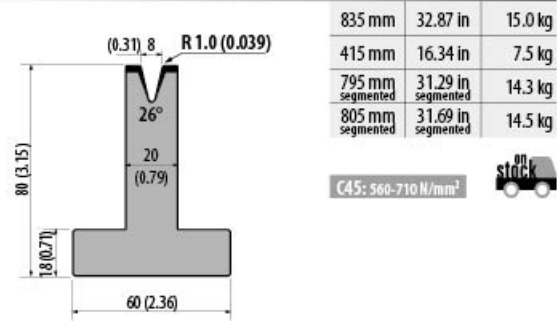
T80.06.26

200 kN/m max.



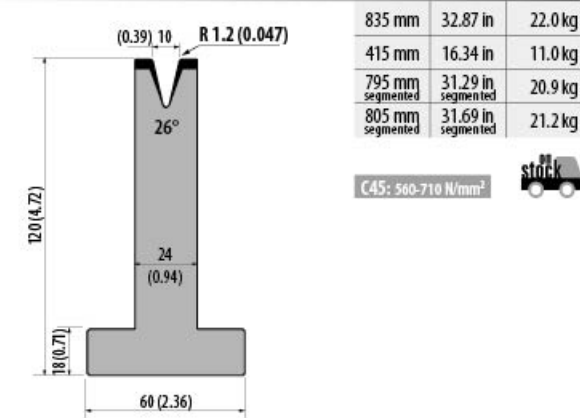
T80.08.26

200 kN/m max.



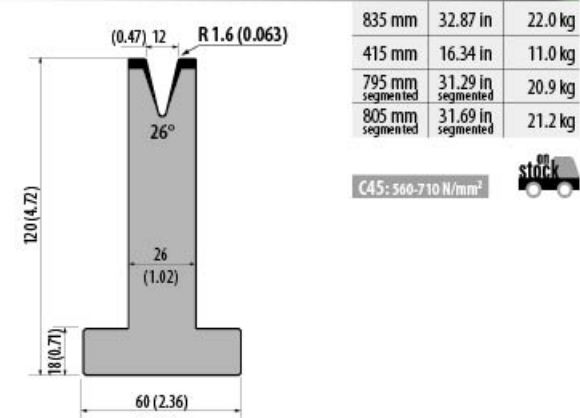
T120.10.26

200 kN/m max.



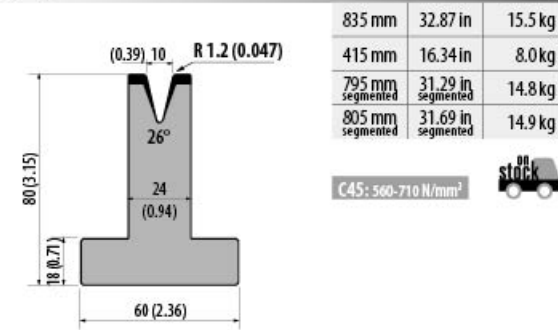
T120.12.26

200 kN/m max.



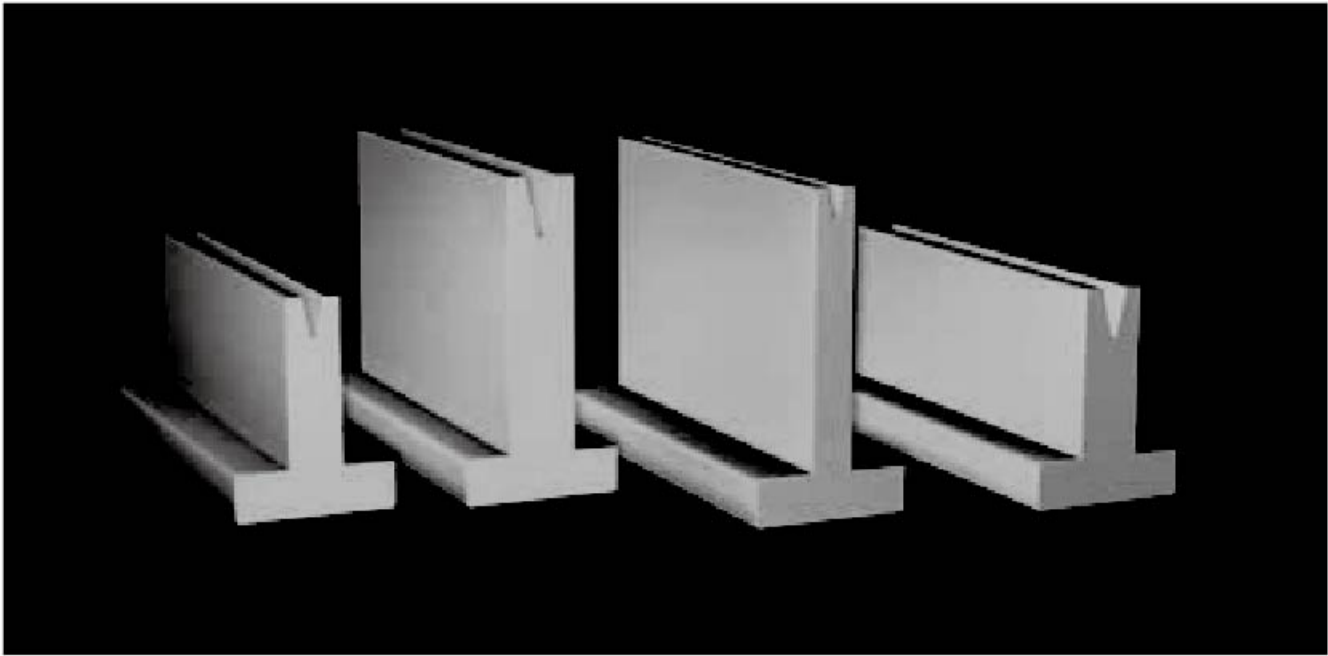
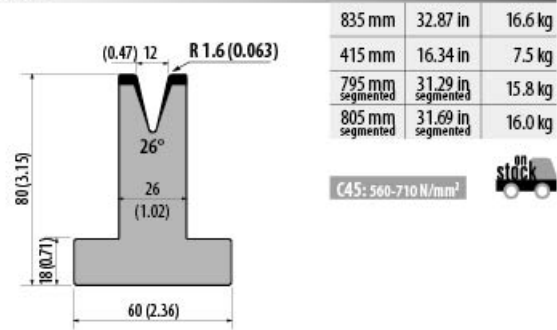
T80.10.26

200 kN/m max.



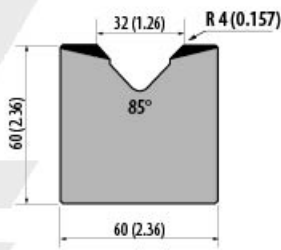
T80.12.26

200 kN/m max.



M60.85.32

1000 kN/m max.



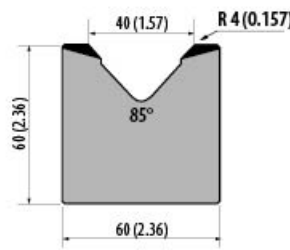
835 mm	32.87 in	21.6 kg
415 mm	16.34 in	10.7 kg
795 mm segmented	31.29 in segmented	20.6 kg
805 mm segmented	31.69 in segmented	20.8 kg

C45: 560-710 N/mm²



M60.85.40

1000 kN/m max.



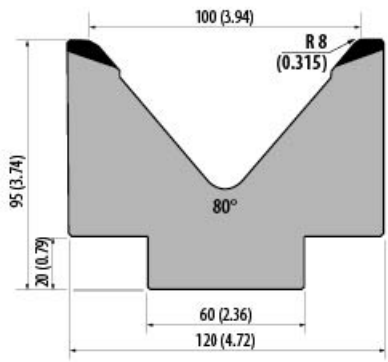
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M95.80.100

1000 kN/m max.



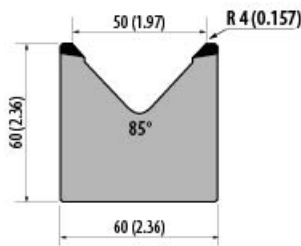
835 mm	32.87 in	46.2 kg
415 mm	16.34 in	22.9 kg
795 mm segmented	31.29 in segmented	44.0 kg
805 mm segmented	31.69 in segmented	44.5 kg

C45: 560-710 N/mm²



M60.85.50

1000 kN/m max.



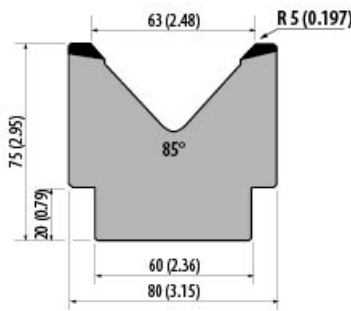
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



M75.85.63

1000 kN/m max.



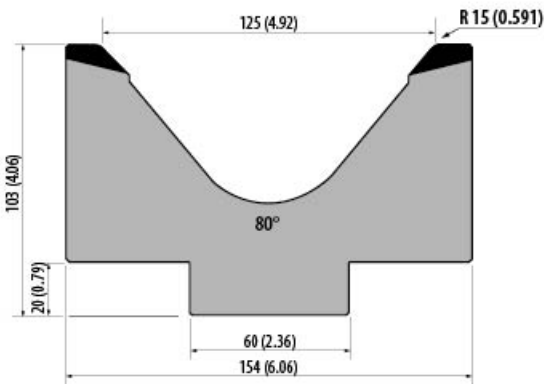
835 mm	32.87 in	29.2 kg
415 mm	16.34 in	14.5 kg
795 mm segmented	31.29 in segmented	27.8 kg
805 mm segmented	31.69 in segmented	28.0 kg

C45: 560-710 N/mm²



MK103.80.125

700 kN/m max.



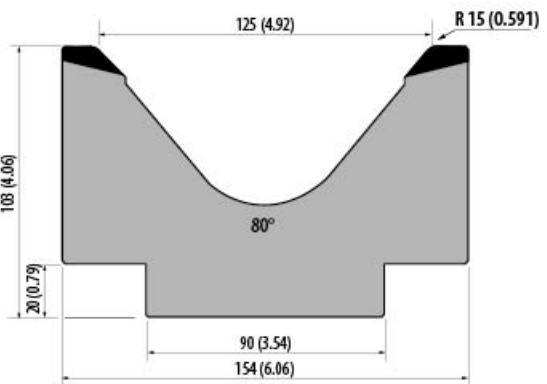
835 mm	32.87 in	62.0 kg
415 mm	16.34 in	31.0 kg
795 mm segmented	31.29 in segmented	59.0 kg
805 mm segmented	31.69 in segmented	59.8 kg



C45: 560-710 N/mm²

M103.80.125

1000 kN/m max.



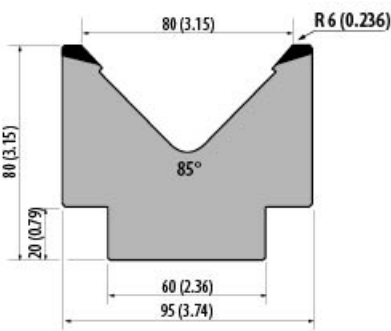
835 mm	32.87 in	64.9 kg
415 mm	16.34 in	32.2 kg
795 mm segmented	31.29 in segmented	61.4 kg
805 mm segmented	31.69 in segmented	62.5 kg



C45: 560-710 N/mm²

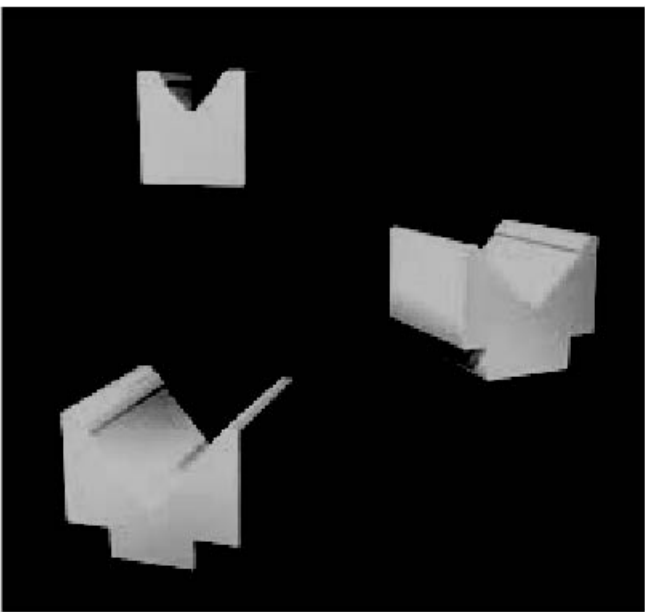
M80.85.80

1000 kN/m max.



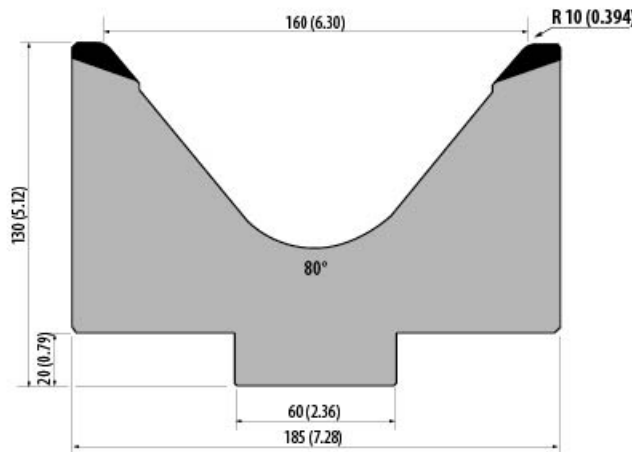
835 mm	32.87 in	33.5 kg
415 mm	16.34 in	16.6 kg
795 mm segmented	31.29 in segmented	31.9 kg
805 mm segmented	31.69 in segmented	32.2 kg

C45: 560-710 N/mm²



MK130.80.160

700 kN/m max.



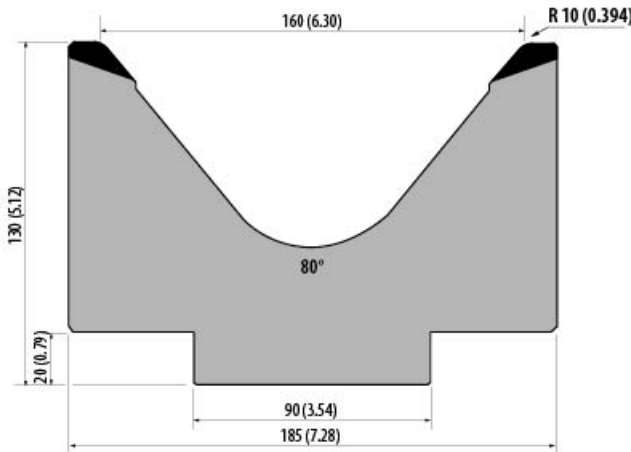
835 mm	32.87 in	93.0 kg
415 mm	16.34 in	46.5 kg
795 mm segmented	31.29 in segmented	88.5 kg
805 mm segmented	31.69 in segmented	89.7 kg



C45: 560-710 N/mm²

M130.80.160

1000 kN/m max.

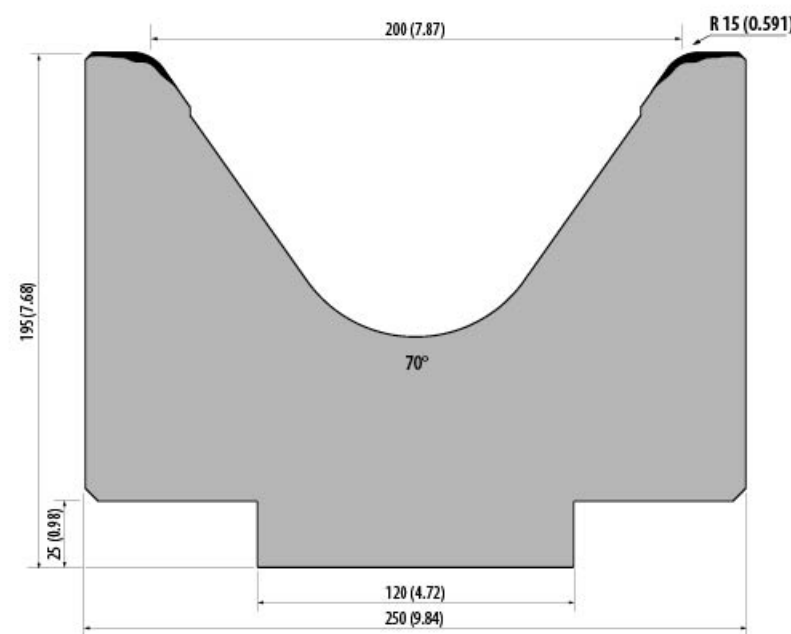


835 mm	32.87 in	93.0 kg
415 mm	16.34 in	46.2 kg
795 mm segmented	31.29 in segmented	88.5 kg
805 mm segmented	31.69 in segmented	89.7 kg



C45: 560-710 N/mm²

M195.70.200



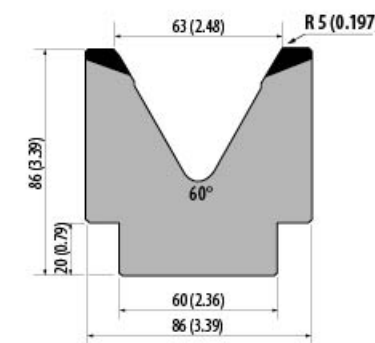
1800 kN/m max.

415 mm 16.34 in 104.0 kg

42Cr: 900-1150 N/mm²



M86.60.63



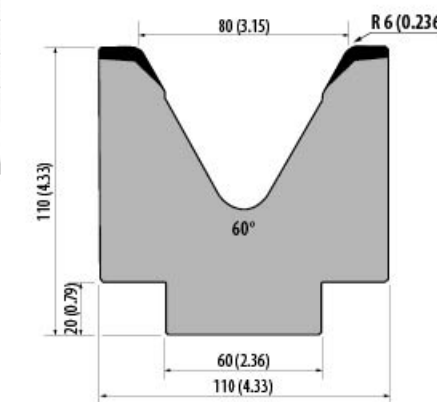
1000 kN/m max.

835 mm	32.87 in	34.0 kg
415 mm	16.34 in	17.0 kg
795 mm segmented	31.29 in segmented	32.4 kg
805 mm segmented	31.69 in segmented	32.8 kg

C45: 560-710 N/mm²



M110.60.80



1000 kN/m max.

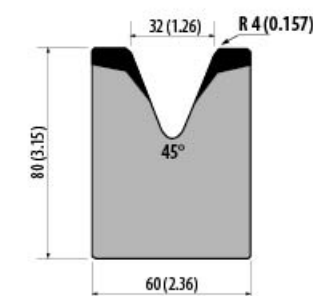
835 mm	32.87 in	53.0 kg
415 mm	16.34 in	26.5 kg
795 mm segmented	31.29 in segmented	50.5 kg
805 mm segmented	31.69 in segmented	51.1 kg

C45: 560-710 N/mm²



1-V Dies, 45°

M80.45.32



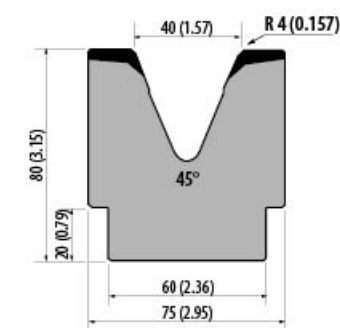
1000 kN/m max.

835 mm	32.87 in	27.5 kg
415 mm	16.34 in	13.7 kg
795 mm segmented	31.29 in segmented	26.2 kg
805 mm segmented	31.69 in segmented	26.5 kg

C45: 560-710 N/mm²



M80.45.40



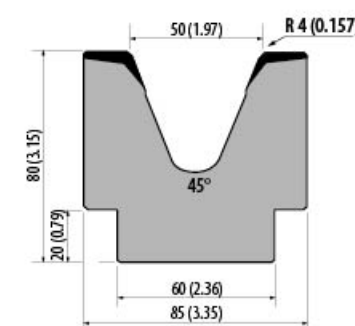
1000 kN/m max.

835 mm	32.87 in	30.9 kg
415 mm	16.34 in	16.5 kg
795 mm segmented	31.29 in segmented	29.4 kg
805 mm segmented	31.69 in segmented	29.8 kg

C45: 560-710 N/mm²



M80.45.50



950 kN/m max.

835 mm	32.87 in	31.0 kg
415 mm	16.34 in	15.5 kg
795 mm segmented	31.29 in segmented	29.5 kg
805 mm segmented	31.69 in segmented	29.9 kg

C45: 560-710 N/mm²

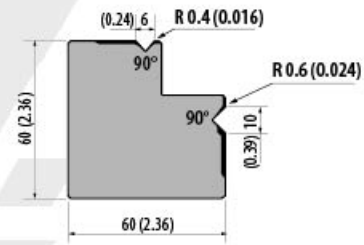


For the application of dies Roller Type R1 use the adapters on pages 218-221



M60.90.01

1000 kN/m max.



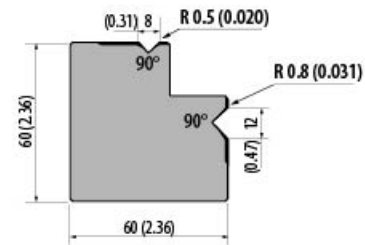
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M60.90.02

800 kN/m max.



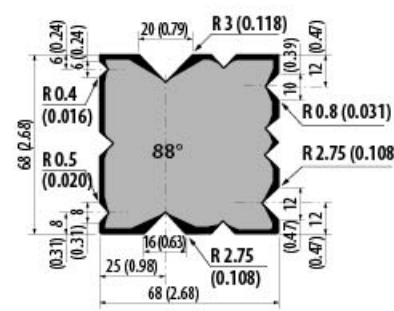
835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	20.0 kg
805 mm segmented	31.69 in segmented	20.2 kg

C45: 560-710 N/mm²



T70-88

1000 kN/m max.



525 mm	20.67 in	17.5 kg
495 mm segmented	19.49 in segmented	16.5 kg

42Cr: 900-1150 N/mm²



T70-60

525 mm	20.67 in	16.8 kg
495 mm segmented	19.49 in segmented	15.8 kg

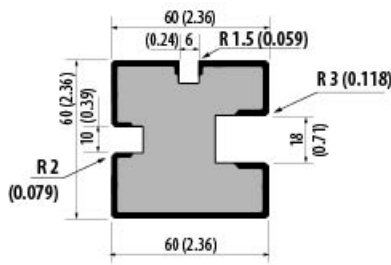
42Cr: 900-1150 N/mm²



V (mm)	6	8	10	12	16	20
kN/m max.	600	600	600	600	800	800

M.360.R

1000 kN/m max.



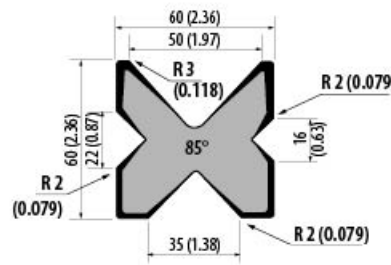
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M.460.R

800 kN/m max.



835 mm	32.87 in	15.7 kg
415 mm	16.34 in	7.7 kg
795 mm segmented	31.29 in segmented	14.9 kg
805 mm segmented	31.69 in segmented	15.1 kg

C45: 560-710 N/mm²



T70-45

525 mm	20.67 in	16.1 kg
495 mm segmented	19.49 in segmented	15.2 kg

42Cr: 900-1150 N/mm²



V (mm)	6	8	10	12	16	20
kN/m max.	400	400	500	500	700	700

T70-35

525 mm	20.67 in	15.3 kg
495 mm segmented	19.49 in segmented	14.4 kg

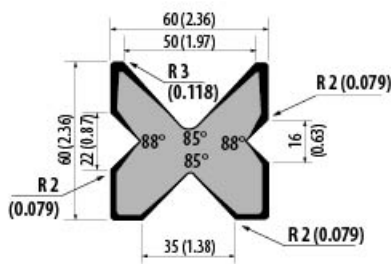
42Cr: 900-1150 N/mm²



V (mm)	6	8	10	12	16	20
kN/m max.	300	350	450	450	500	500

M.460

800 kN/m max.



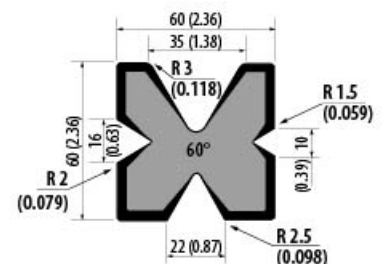
835 mm	32.87 in	15.8 kg
415 mm	16.34 in	7.8 kg
795 mm segmented	31.29 in segmented	15.0 kg
805 mm segmented	31.69 in segmented	15.2 kg

C45: 560-710 N/mm²



M.460.60

600 kN/m max.



835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



SU-T70

525 mm	20.67 in	12.4 kg
--------	----------	---------

C45: 560-710 N/mm²



PB-T70

20 mm	0.79 in	0.2 kg
-------	---------	--------

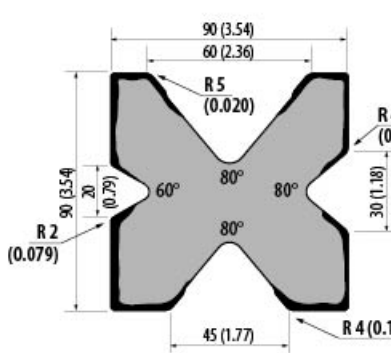
per pair

Fe37



M.490

1000 kN/m max.



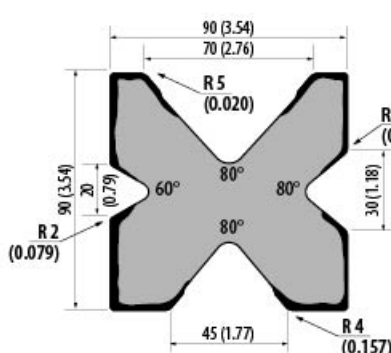
835 mm	32.87 in	38.9 kg
415 mm	16.34 in	20.0 kg
795 mm segmented	31.29 in segmented	37.0 kg
805 mm segmented	31.69 in segmented	37.5 kg

C45: 560-710 N/mm²



M.490.70

600 kN/m max.



835 mm	32.87 in	35.9 kg
415 mm	16.34 in	18.0 kg
795 mm segmented	31.29 in segmented	34.2 kg
805 mm segmented	31.69 in segmented	34.6 kg

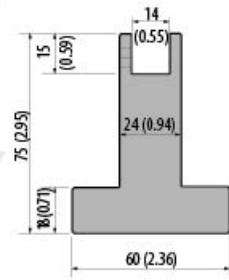
C45: 560-710 N/mm²



Special Punches
and Dies
see pages 236-241

TN80.14

1000 kN/m max.



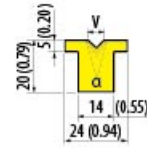
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg

C45: 560-710 N/mm²



INS14...

200 kN/m max.



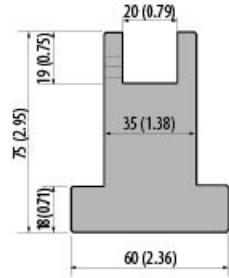
Model	α	V (mm)	V (in)
INS14.06.88	88°	6	0.24
INS14.08.88	88°	8	0.31
INS14.10.88	88°	10	0.39
INS14.06.60	60°	6	0.24
INS14.08.60	60°	8	0.31
INS14.10.60	60°	10	0.39

Model	α	V (mm)	V (in)
INS14.06.45	45°	6	0.24
INS14.08.45	45°	8	0.31
INS14.10.45	45°	10	0.39
INS14.06.30	30°	6	0.24
INS14.08.30	30°	8	0.31



TN80.20

1000 kN/m max.



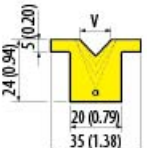
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg

C45: 560-710 N/mm²



INS20...

200 kN/m max.



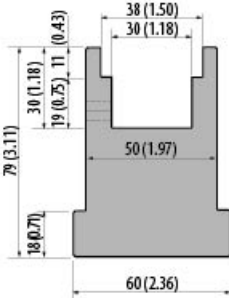
Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	α	V (mm)	V (in)
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



TN80.30

1000 kN/m max.



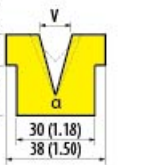
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg

C45: 560-710 N/mm²



INS30...

200 kN/m max.

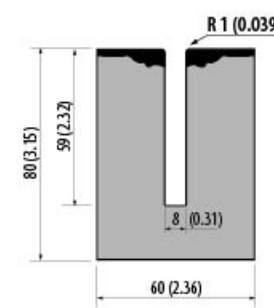


Model	α	V (mm)	V (in)
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.47
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16	0.63
INS30.20.60	60°	20	0.79

Model	α	V (mm)	V (in)
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



TOP.SM-134.28.8 / TOP.SM-134.24.8

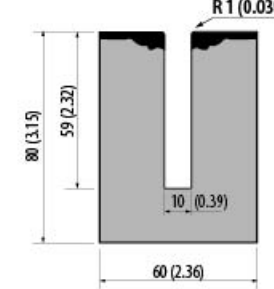


525 mm	20.67 in	17.5 kg
495 mm segmented	19.49 in segmented	16.5 kg

42Cr: 900-1150 N/mm²



TOP.SM-134.24.10

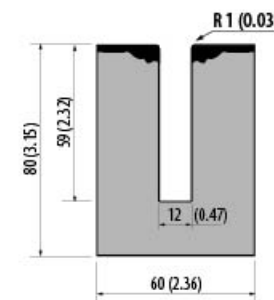


525 mm	20.67 in	18.0 kg
495 mm segmented	19.49 in segmented	16.9 kg

42Cr: 900-1150 N/mm²



TOP.SM-134.24.12



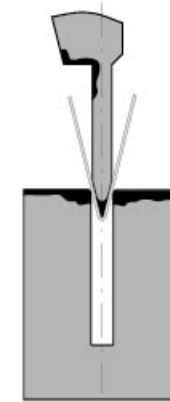
525 mm	20.67 in	16.8 kg
495 mm segmented	19.49 in segmented	15.9 kg

42Cr: 900-1150 N/mm²

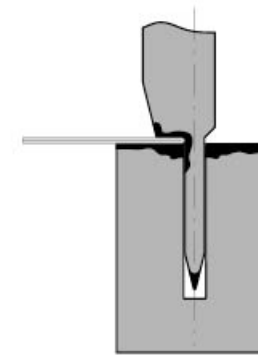


Compatible
Hemming Punches
see page 28

Example of application



500 kN/m max.



1000 kN/m max.

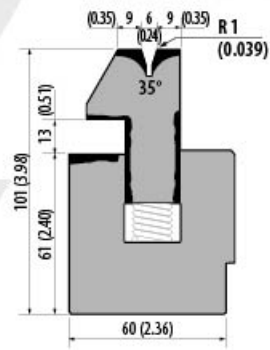


S mm	S in	A mm	A in	R.45 Kg/mm ² t/m	R.70 Kg/mm ² t/m	S mm	S in	A mm	A in	R.45 Kg/mm ² t/m	R.70 Kg/mm ² t/m
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

For advantages and
mounting examples see
Mark-Free bending
Chapter on pages 228-229

S101.35.06

600 kN/m max.



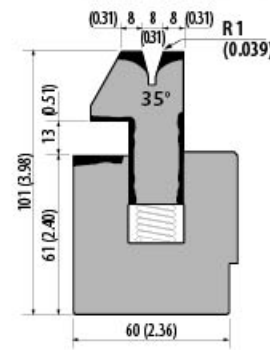
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.4 kg

C45: 800-850 N/mm²



S101.35.08

600 kN/m max.



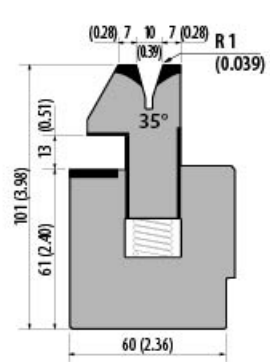
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

C45: 800-850 N/mm²



S101.35.10

600 kN/m max.



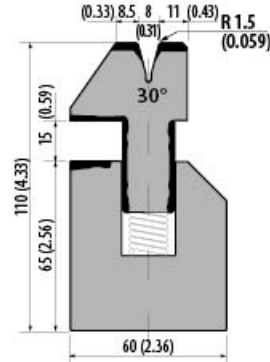
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

C45: 800-850 N/mm²



S110.30.08

800 kN/m max.



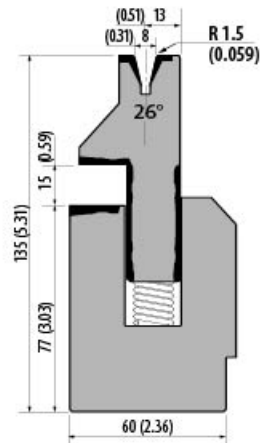
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

C45: 800-850 N/mm²



S135.26.08

400 kN/m max.



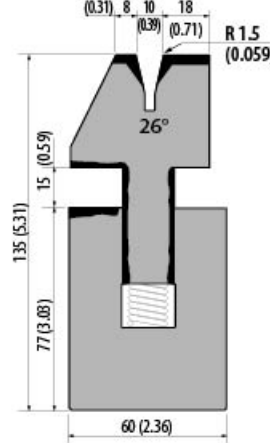
835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.0 kg

C45: 800-850 N/mm²



S135.26.10

1000 kN/m max.



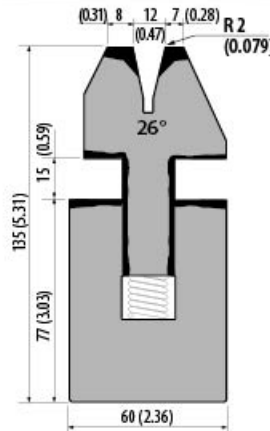
835 mm	32.87 in	41.5 kg
415 mm	16.34 in	20.7 kg

C45: 800-850 N/mm²



SA135.26.12

1000 kN/m max.



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

C45: 800-850 N/mm²



Our Advantage – Your Convenience

The Hemming Dies can also be used as standard dies. Therefore, the spring is secured with help of a mechanical system.



KPN



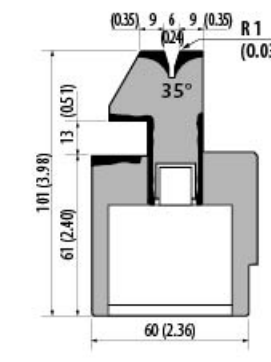
per piece 1.0 kg
Accessories for pneumatic hemming dies



S	S	A	A	R.45	R.70	S	S	A	A	R.45	R.70
mm	in	mm	in	Kg/mm ²	Kg/mm ²	mm	in	mm	in	Kg/mm ²	Kg/mm ²
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80
1.5	0.06	4.6	0.18	22	38	1.5	0.06	3.0	0.12	63	95
2.0	0.08	5.5	0.22	30	50	2.0	0.08	4.0	0.16	80	130
2.5	0.10	6.5	0.26	55	-	2.5	0.10	5.0	0.20	90	-
3.0	0.12	8.0	0.31	70	-	3.0	0.12	6.0	0.24	100	-

S101PN.35.06

600 kN/m max.



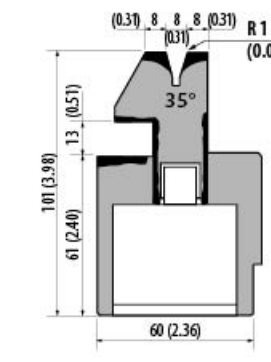
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S101PN.35.08

600 kN/m max.



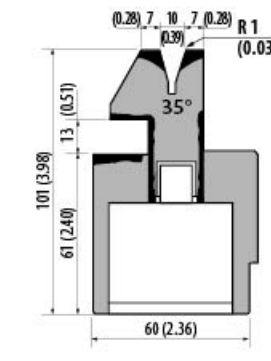
835 mm	32.87 in	31.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S101PN.35.10

600 kN/m max.



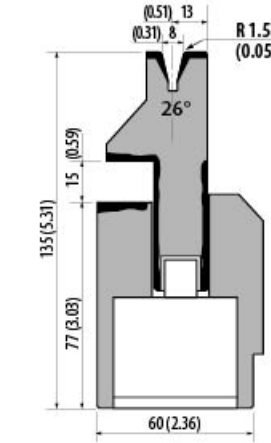
835 mm	32.87 in	29.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S135PN.26.08

400 kN/m max.



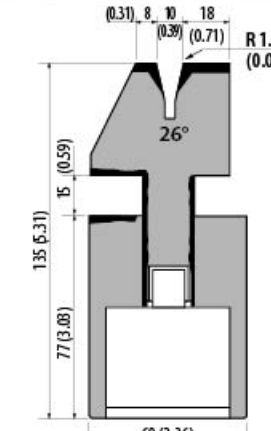
835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.0 kg

42Cr: 900-1150 N/mm²



S135PN.26.10

1000 kN/m max.



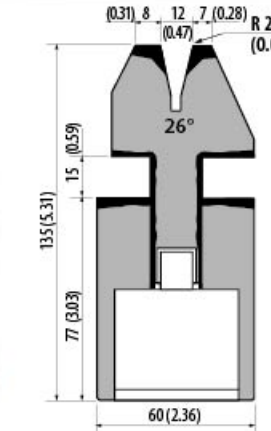
835 mm	32.87 in	41.5 kg
415 mm	16.34 in	20.7 kg

C45: 560-710 N/mm²



SA135PN.26.12

1000 kN/m max.



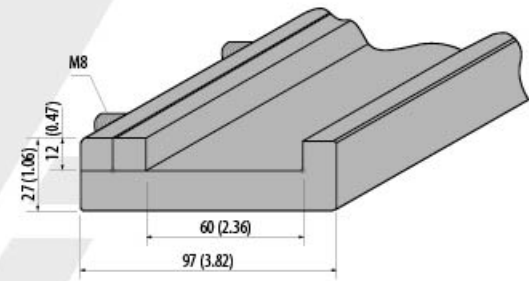
835 mm	32.87 in	41.0 kg
415 mm	16.34 in	20.5 kg

C45: 560-710 N/mm²



The complete pneumatic system is located within the die.

C 2000/S / C 2500/S / C 3000/S / C 4000/S



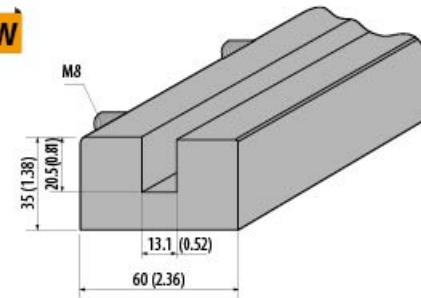
Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



C45: 560-710 N/mm²

TC 2000/S / TC 2500/S / TC 3000/S / TC 4000/S

NEW

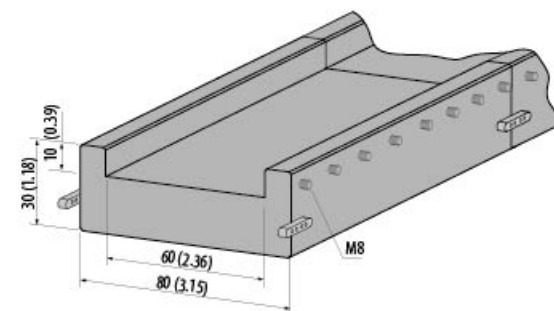


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



C45: 560-710 N/mm²

C 1050/R

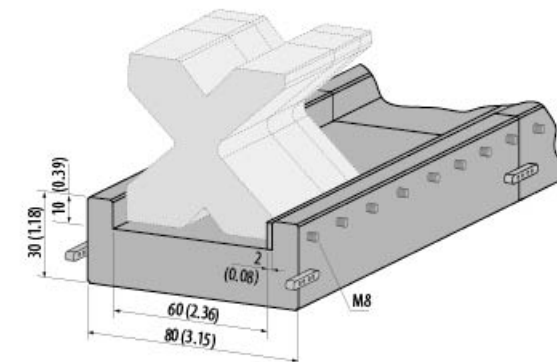


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg



C45: 560-710 N/mm²

C 1050/RS

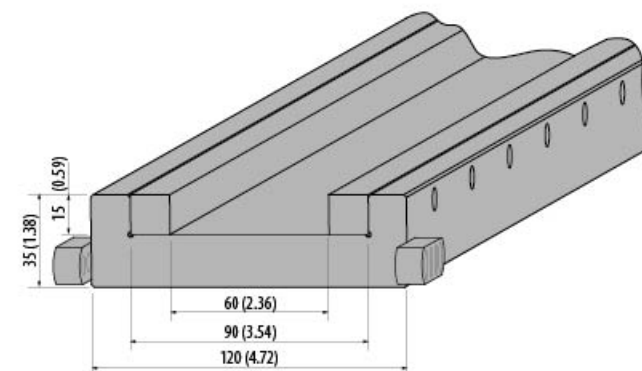


Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



C45: 560-710 N/mm²

C 1050-90

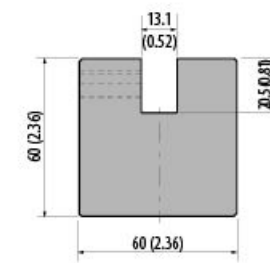


Model	Length (mm)	Length (in)	Weight
C 1050-90	1050	41.34	27.2 kg
C 1050-90/C	520	20.47	13.5 kg



C45: 560-710 N/mm²

AD5



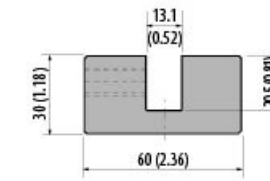
1000 kN/m max.		
1000 mm	39.37 in	26.1 kg
500 mm	19.68 in	13.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD6



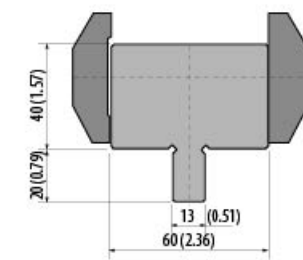
1000 kN/m max.		
1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD7



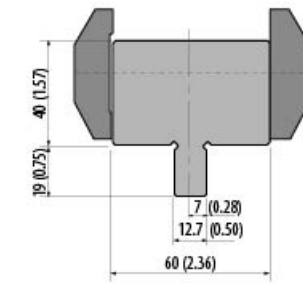
1000 kN/m max.		
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²



AD9-12.7



1000 kN/m max.		
835 mm	32.87 in	19.6 kg
415 mm	16.34 in	9.7 kg

Rolleri Type RX LVD
→ Rolleri Type R1

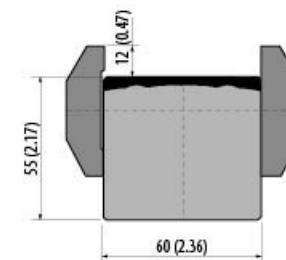
C45: 560-710 N/mm²



Do you have further queries about delivery times, operational areas, and other options?
Give us a call!

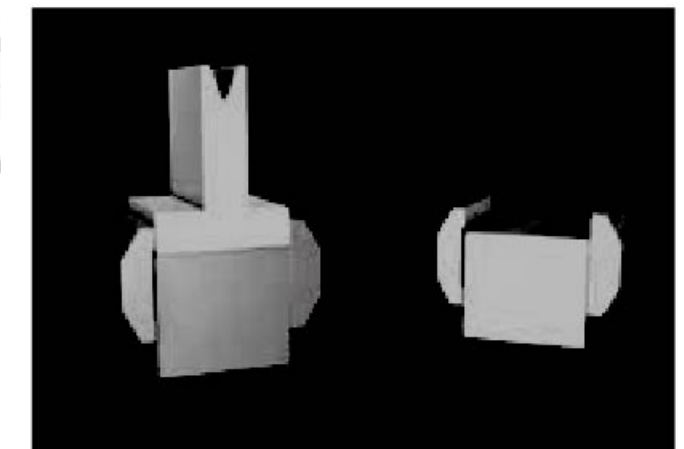
Die Extensions

CTS60



1000 kN/m max.		
835 mm	32.87 in	29.0 kg
415 mm	16.34 in	14.5 kg

C45: 560-710 N/mm²



■ Clamping Systems

QuickLock (Standard)

- vertical tool exchange
- easy handling
- substantial savings on equipment costs
- applicable on tools < 12.0 kg
- applicable on tools > 12.0 kg through special sectioning possible



Safety Pins (Standard)

- horizontal tool exchange



ROL1-System

- vertical tool exchange through spring-loaded balls, which are built into the tool
- increased longevity
- easy handling
- requires hardened tang
- applicable on tools < 12.5 kg



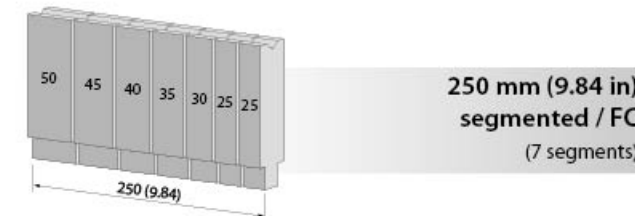
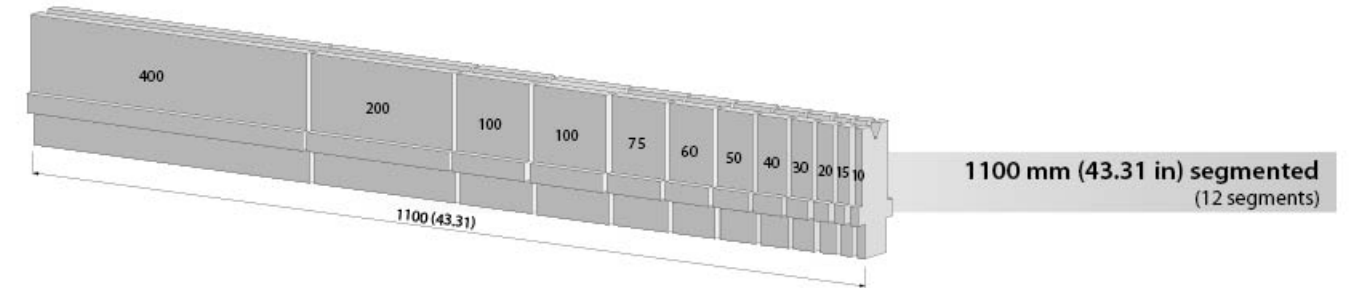
■ Tool lengths and sectioning

Standard

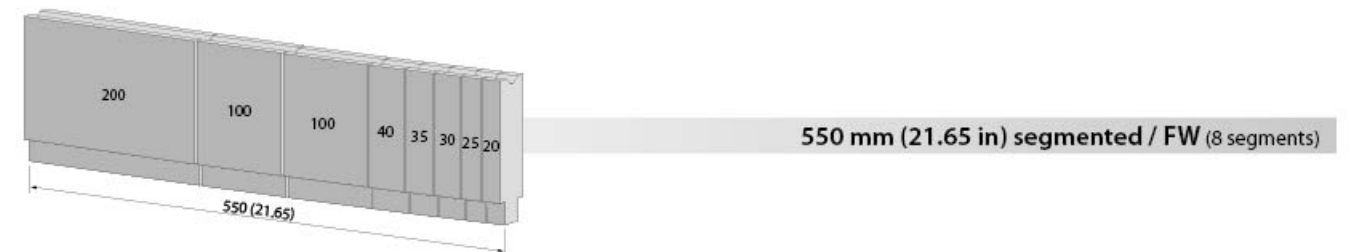
1000 mm (39.37 in)

500 mm (19.68 in)

525 mm (20.67 in)

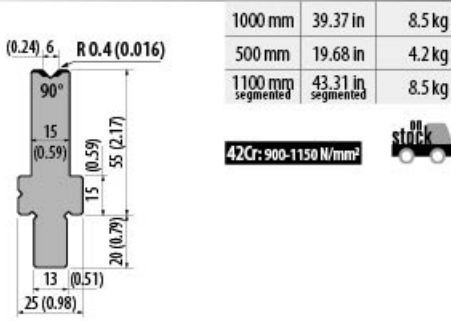


Segmented tools are delivered in complete sets. Single pieces are also available!
More lengths and sectionings are possible upon request.



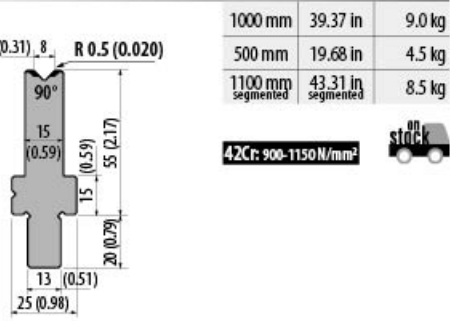
BMR55.06.90

1150 kN/m max.



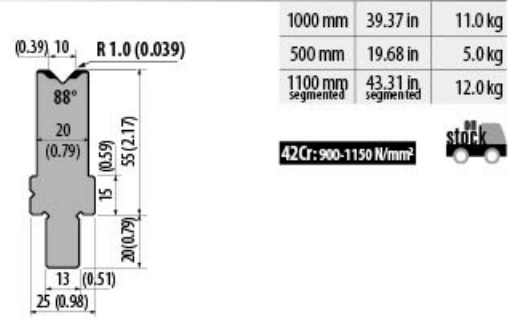
BMR55.08.90

1100 kN/m max.



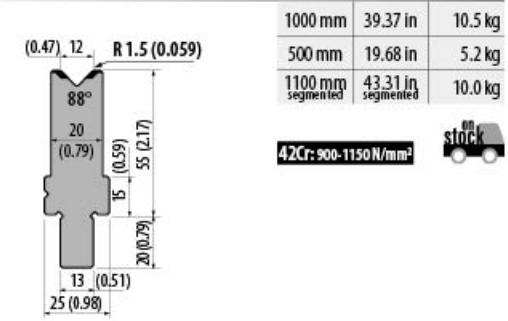
BMR55.10.88

1100 kN/m max.



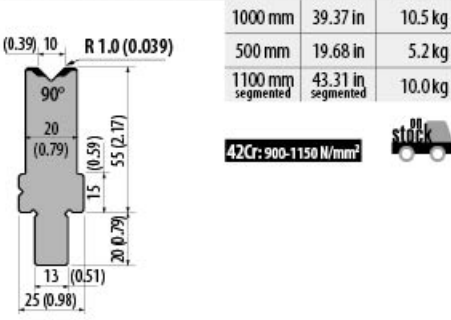
BMR55.12.88

1200 kN/m max.



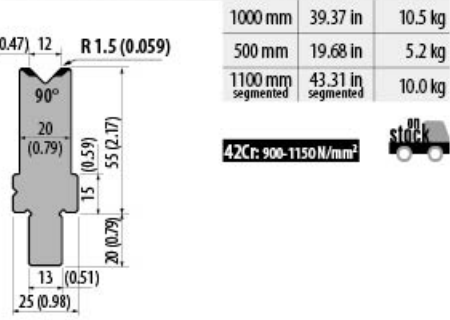
BMR55.10.90

1100 kN/m max.



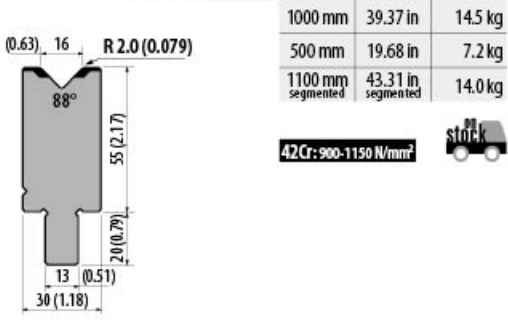
BMR55.12.90

1200 kN/m max.



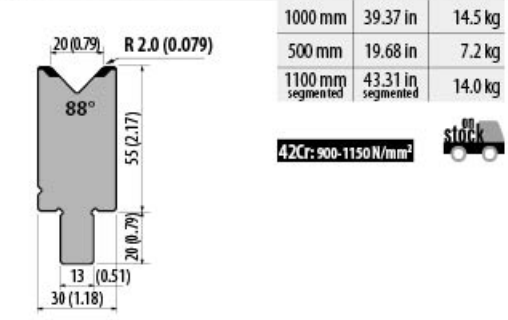
BMR55.16.88

1200 kN/m max.



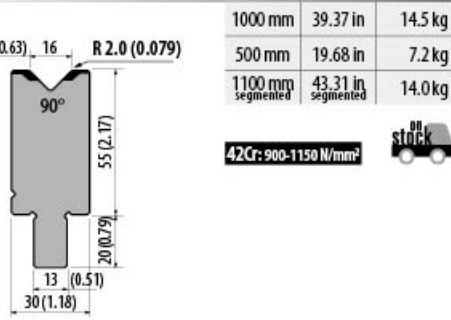
BMR55.20.88

1100 kN/m max.



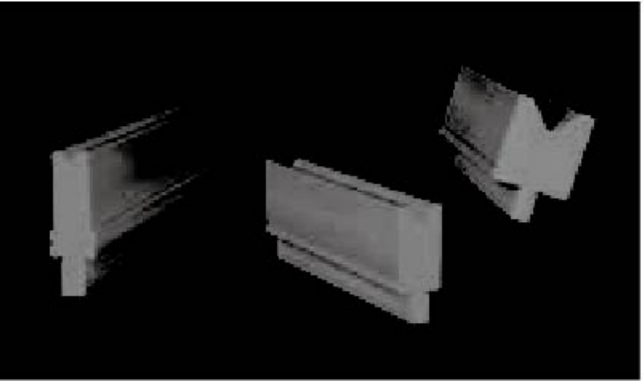
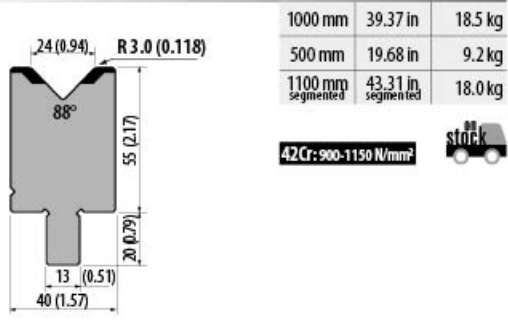
BMR55.16.90

1200 kN/m max.



BMR55.24.88

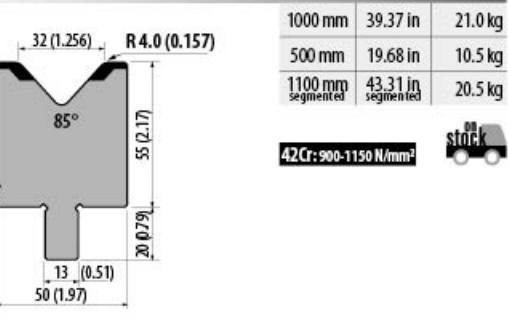
1200 kN/m max.



Dies 85°, H=55 (2.17)

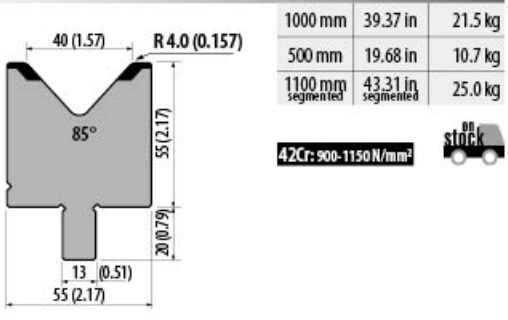
BMR55.32.85

1200 kN/m max.



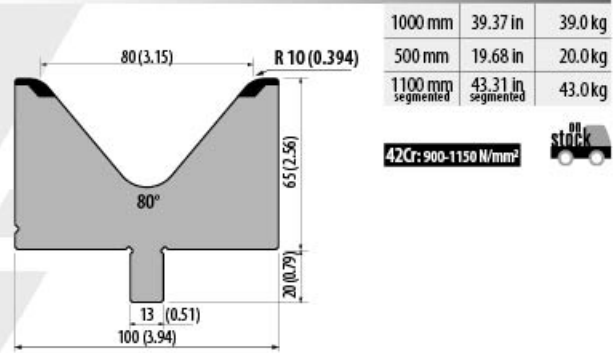
BMR55.40.85

1200 kN/m max.



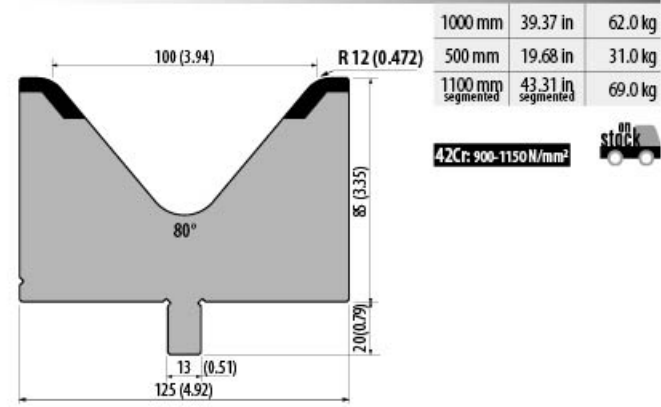
BMR65.80.80

1700 kN/m max.



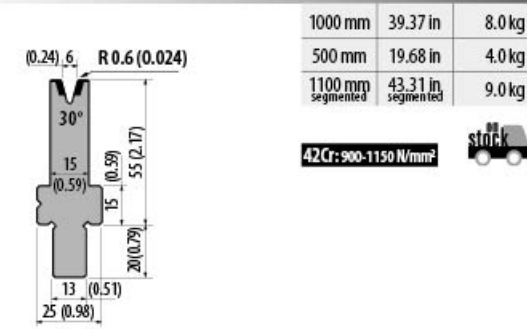
BMR85.100.80

2300 kN/m max.



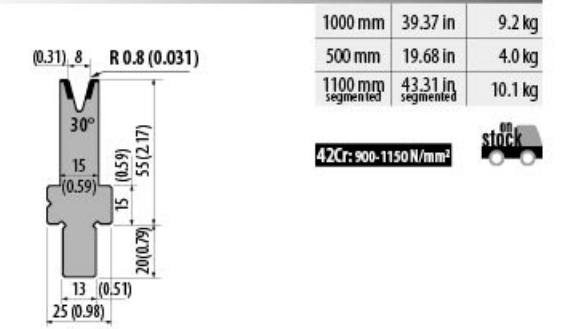
BMR55.06.30

350 kN/m max.



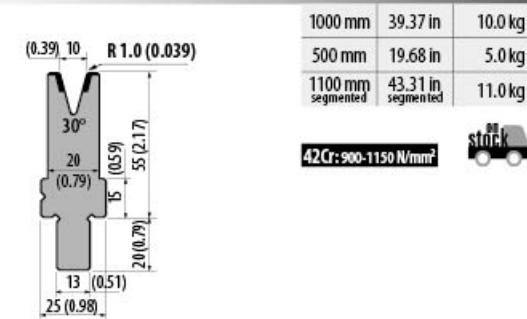
BMR55.08.30

200 kN/m max.



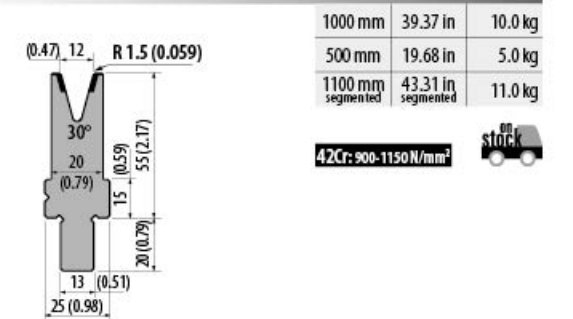
BMR55.10.30

350 kN/m max.



BMR55.12.30

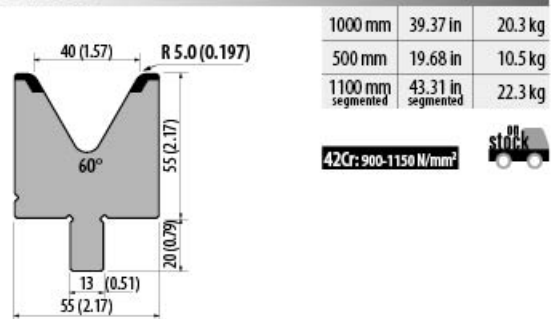
300 kN/m max.



Dies 60°, H=55 (2.17), H=65 (2.56)

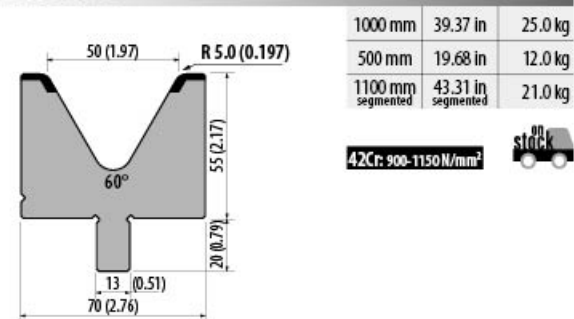
BMR55.40.60

1300 kN/m max.



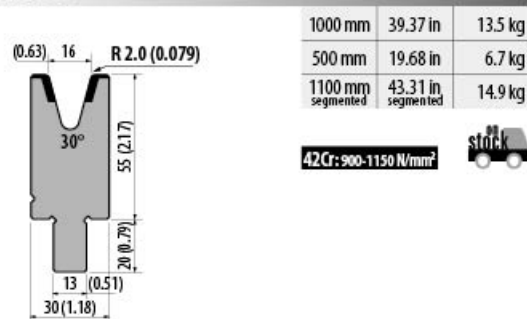
BMR55.50.60

1200 kN/m max.



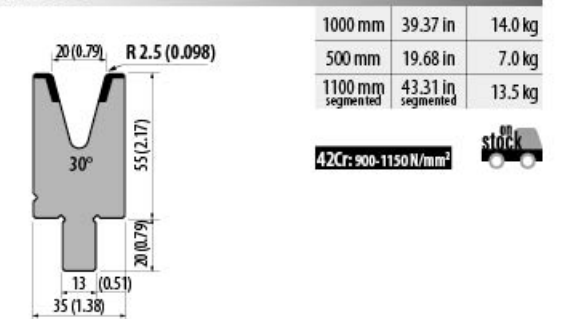
BMR55.16.30

450 kN/m max.



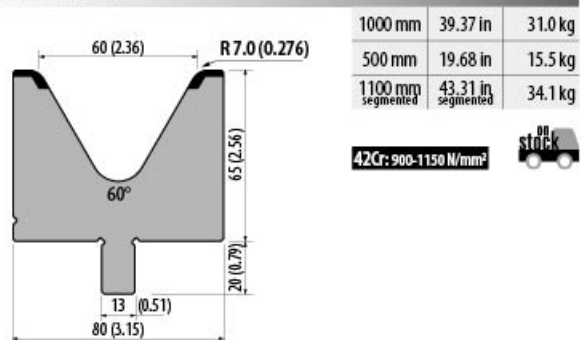
BMR55.20.30

500 kN/m max.



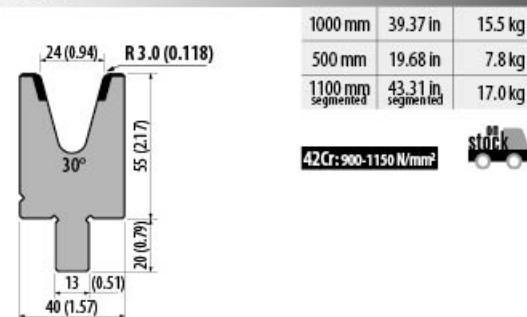
BMR65.60.60

1100 kN/m max.



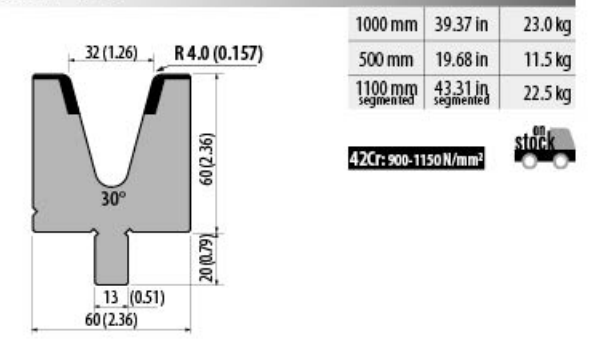
BMR55.24.30

550 kN/m max.



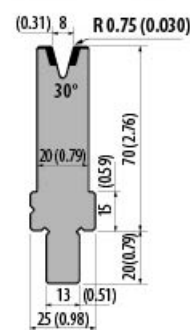
BMR60.32.30

650 kN/m max.



BMR70.08.30

200 kN/m max.



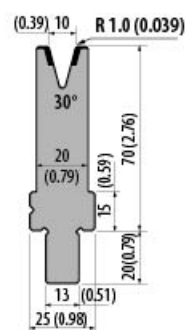
1000 mm	39.37 in	13.1 kg
500 mm	19.68 in	6.5 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR70.10.30

350 kN/m max.



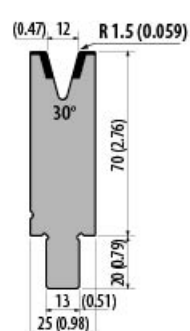
1000 mm	39.37 in	12.8 kg
500 mm	19.68 in	6.4 kg
1100 mm segmented	43.31 in segmented	12.4 kg

42Cr: 900-1150 N/mm²



BMR70.12.30

300 kN/m max.



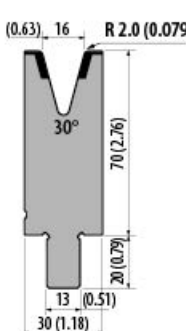
1000 mm	39.37 in	14.7 kg
500 mm	19.68 in	7.3 kg
1100 mm segmented	43.31 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



BMR70.16.30

450 kN/m max.

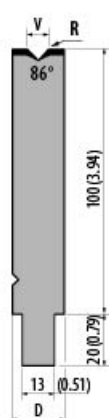


1000 mm	39.37 in	16.7 kg
500 mm	19.68 in	8.3 kg
1100 mm segmented	43.31 in segmented	16.2 kg

42Cr: 900-1150 N/mm²



86° Dies, H=100 (3.94)



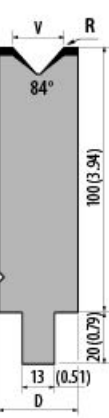
Individual drawings,
available lengths
and prices see pages
101-103



42Cr: 900-1150 N/mm²

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.86	4	0.16	0.6	0.02	20	0.79	450
TMR100.06.86	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.86	8	0.31	0.8	0.03	20	0.79	1150
WMR100.08.86	8	0.31	2.5	0.10	25	0.98	400
TMR100.10.86	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.86	12	0.47	1.0	0.04	25	0.98	1200
WMR100.12.86	12	0.47	2.5	0.10	25	0.98	500
TMR100.16.86	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.86	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.86	24	0.94	2.5	0.10	35	1.38	1200
TMR100.30.86	30	1.18	3.0	0.12	45	1.77	1200
TMR100.40.86	40	1.57	3.0	0.12	55	2.17	1200
TMR100.50.86	50	1.97	3.0	0.12	75	2.95	1500

84° Dies, H=100 (3.94)



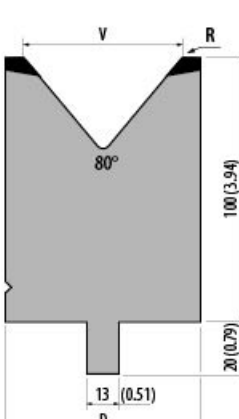
Individual drawings,
available lengths
and prices see pages
103-104

42Cr: 900-1150 N/mm²



Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.06.84	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.84	8	0.31	0.8	0.03	20	0.79	1150
TMR100.10.84	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.84	12	0.47	1.0	0.04	25	0.98	1200
TMR100.16.84	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.84	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.84	24	0.94	2.5	0.10	35	1.38	1200

80° Dies, H=100 (3.94) / H=120 (4.72)



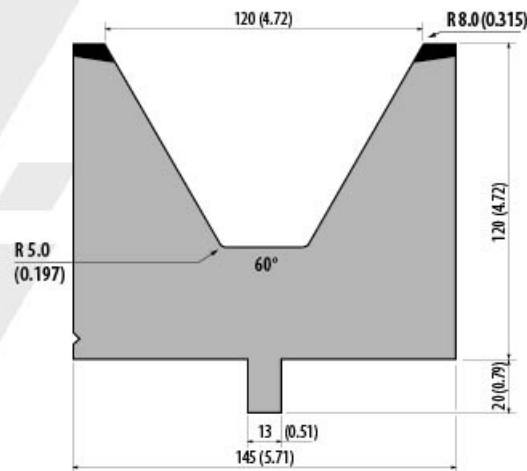
Individual drawings,
available lengths
and prices see page 105

42Cr: 900-1150 N/mm²



Model	V (mm)	V (in)	H (mm)	H (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.60.80	60	2.36	100	3.94	5.0	0.20	75	2.95	1500
TMR100.70.80	70	2.76	100	3.94	5.0	0.20	85	3.35	1500
TMR100.80.80	80	3.15	100	3.94	5.0	0.20	100	3.94	1500
TMR120.90.80	90	3.54	120	4.72	8.0	0.31	110	4.33	1500
TMR120.100.80	100	3.94	120	4.72	8.0	0.31	120	4.72	1500

60° Die, H=120 (4.72)



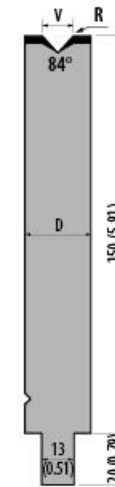
Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR120.120.60	120	4.72	8.0	0.31	145	5.71	1000

42Cr: 900-1150 N/mm²



Individual drawings,
available lengths and
prices see page 106

84° Dies, H=150 (5.91)



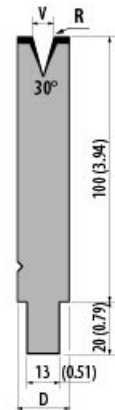
Individual drawings,
available lengths
and prices see pages
110-111

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.84	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.84	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.84	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.84	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.84	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.84	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.84	24	0.94	2.5	0.10	35	1.38	700

42Cr: 900-1150 N/mm²



30° Dies, H=100 (3.94)



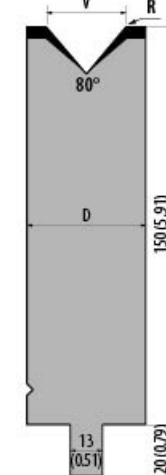
Individual drawings,
available lengths
and prices see pages
106-108

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.30	4	0.16	0.6	0.02	20	0.79	150
TMR100.06.30	6	0.24	0.6	0.02	20	0.79	400
WMR100.06.30	6	0.24	2.0	0.08	20	0.79	400
TMR100.08.30	8	0.31	1.0	0.04	20	0.79	400
WMR100.08.30	8	0.31	2.5	0.10	20	0.79	400
TMR100.10.30	10	0.39	1.0	0.04	20	0.79	400
WMR100.10.30	10	0.39	2.5	0.10	25	0.98	400
TMR100.12.30	12	0.47	1.0	0.04	25	0.98	400
WMR100.12.30	12	0.47	3.0	0.12	25	0.98	400
TMR100.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR100.20.30	20	0.79	2.0	0.08	30	1.18	600
TMR100.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR100.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR100.40.30	40	1.57	5.0	0.20	60	2.36	900

42Cr: 900-1150 N/mm²



80° Dies, H=150 (5.91)



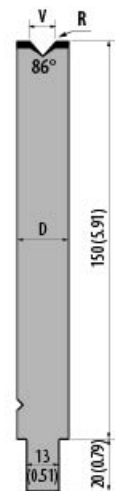
Individual drawings,
available lengths
and prices see page 112

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.24.80	24	0.94	2.5	0.10	35	1.38	700
TMR150.30.80	30	1.18	5.0	0.20	45	1.77	900
TMR150.40.80	40	1.57	5.0	0.20	55	2.17	1200
TMR150.50.80	50	1.97	5.0	0.20	65	2.56	1500

42Cr: 900-1150 N/mm²



86° Dies, H=150 (5.91)



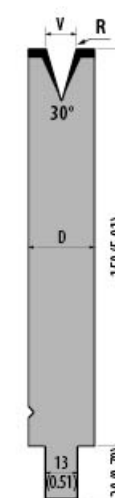
Individual drawings,
available lengths
and prices see pages
109-110

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.86	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.86	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.86	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.86	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.86	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.86	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.86	24	0.94	2.5	0.10	35	1.38	700

42Cr: 900-1150 N/mm²



30° Dies, H=150 (5.91)



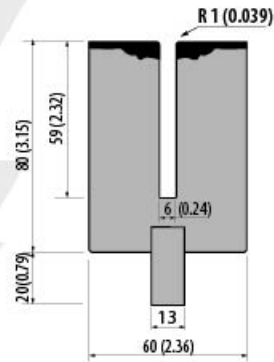
Individual drawings,
available lengths
and prices see pages
113-114

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.30	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.30	8	0.31	1.0	0.04	20	0.79	400
TMR150.10.30	10	0.39	1.0	0.04	20	0.79	400
TMR150.12.30	12	0.47	1.0	0.04	25	0.98	400
TMR150.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR150.20.30	20	0.79	2.0	0.08	35	1.38	600
TMR150.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR150.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR150.40.30	40	1.57	5.0	0.20	55	2.17	900

42Cr: 900-1150 N/mm²



BPR.SM.195.28.6



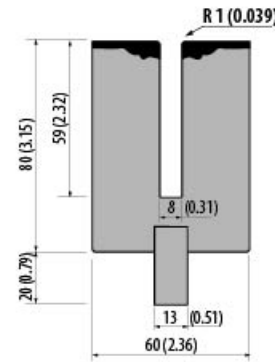
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



Only for thin material!
Hemming punches
see page 126

BPR.SM.195.28.8

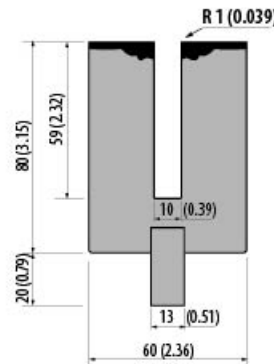


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



BPR.SM.195.24.10

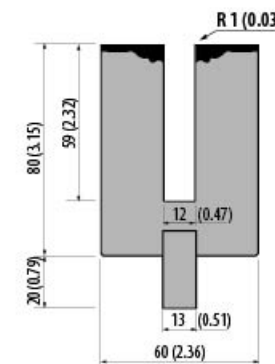


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm²



BPR.SM.195.24.12



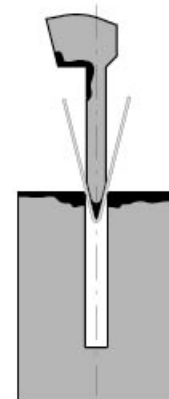
525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	10.8 kg

42Cr: 900-1150 N/mm²

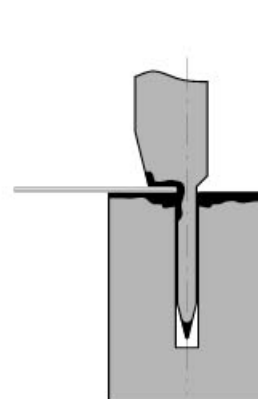


Example of Application

S	S	A	A	R.45	R.70	S	S	A	A	R.45	R.70
mm	in	mm	in	Kgf/mm ²	Kgf/mm ²	mm	in	mm	in	Kgf/mm ²	Kgf/mm ²
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80



500 kN/m max.



1000 kN/m max.

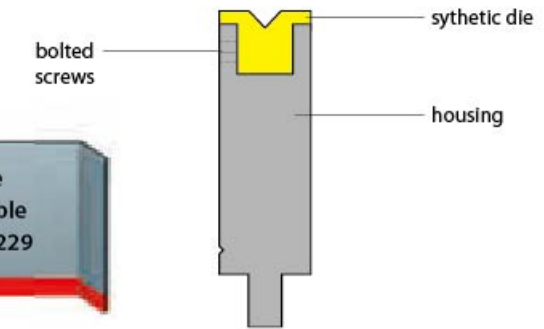
Our Advantages – Your Convenience

- easy handling
- faster and easier exchange
- preventing bending marks
- decrease of post-processing of bended profiles
- no contact of materials
- higher product quality

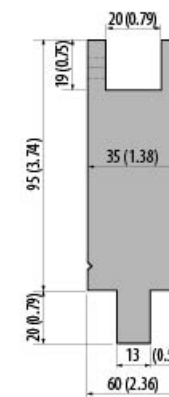
More mark-free
bending available
see pages 222-229

Mounting example

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



TMN95.20

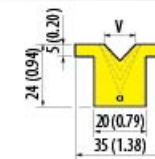


835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

C45: 560-710 N/mm²



INS20...



835 mm	32.87 in	0.40 kg
415 mm	16.34 in	0.20 kg

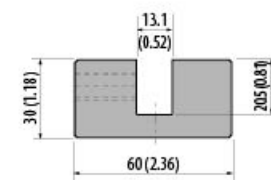


Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	α	V (mm)	V (in)
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

Die Adapters

AD6



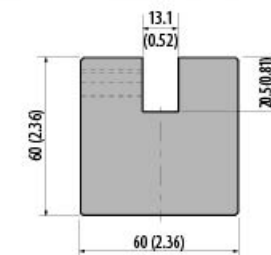
1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD5



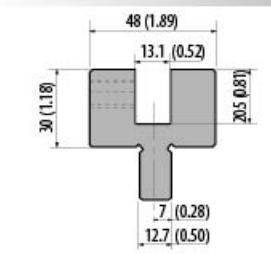
1000 mm	39.37 in	26.1 kg
500 mm	19.68 in	13.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD8-12.7



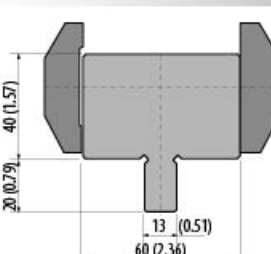
1000 mm	39.37 in	15.0 kg
500 mm	19.68 in	7.5 kg

Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD7



835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²

