EDITION 19 INT

ROLLERI®
INNOVATIVE TOOLS

BENDING

BENDING SOLUTIONS

ROLLERI®

INT

R1 PUNCHES 1
DIES 2

R2 PUNCHES 3

R3 PUNCHES 4
R2 R3 DIES 5

R4 PUNCHES 6
DIES 7

RX 8

DIES ROLLA-V

ADAPTERS

MARK FREE BENDING

EVOLUTION AND HEAVY DUTY

ACCESSORIES

MORE TOOLS

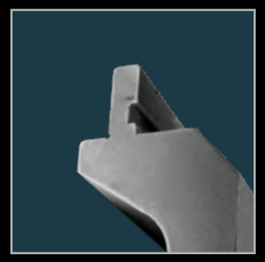
TOOLS SPECIFICATION AND MODIFICATIONS
U-TABLE

ABOUT US

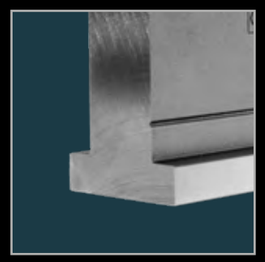
COMPATIBILITY

R1

Check icon R1



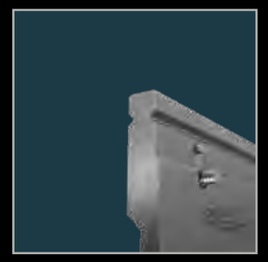
- Accurl
- Accurpress
- ACL
- Adira
- Amada
- Atlantic
- Baykal
- BL
- Boschert
- Boutillon
- Bystronic Beyeler
- Euro-B
- Coastone
- Colgar
- Dener
- Deratech
- Durmazlar
- Ermaksan
- Farina
- Gade
- Gasparini
- Gecko
- Gilardi
- Gizelis
- Haco
- Hindustan
- HPM
- Iturrospe
- Jfy
- JMT
- LFK
- Metfab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



R2

Check icon R2

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

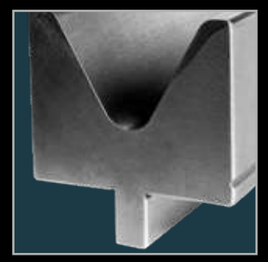


R3

Check icon R3

Bystronic Beyeler:
- RFA
- RF
- R
- S

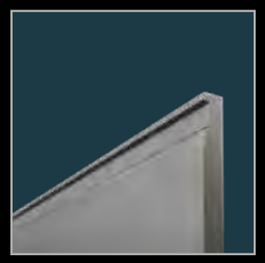
- Bystronic Beyeler
- Darley
- Safan
- SMD
- Trumpf
- Press brake machines with System NSCR

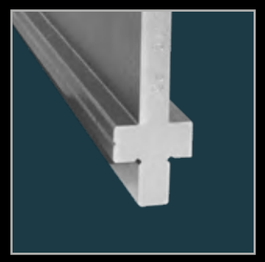


Check icon R4

R4

- LVD





Check icon RX

RX

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

Check icon → Universal compatibility

Check icon PATENT → Patented Product

OTHER ROLLERI CATALOGUES:

- CLAMPING SYSTEMS
  Check icon
- PRESS BRAKE TOOLS
  Check icon R American
- PRESS BRAKE TOOLS
  Check icon R Hämmerle-Bystronic
- PUNCHING TOOLS
  Check icon
- IRON WORKER
  Check icon
- LASER CONSUMABLES
  Check icon
- INDUSTRIAL EQUIPMENT
- CRIMPING MACHINES

PUNCHES ROLLERI TYPE R1

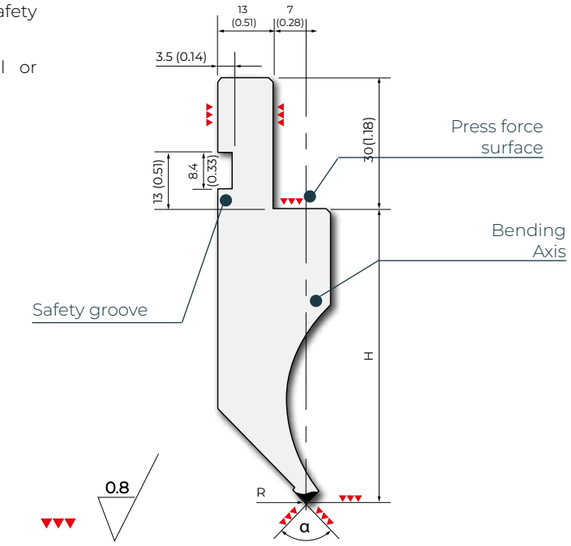
▼ **COMPATIBILITY**

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

Content Explanation	10 - 11
R1 **TOP** Series	
Punches	12 -15
85°	12
75°	13
60°	13
26°	14
28°/24° Hemming Tools	15
Radius Tools	16
R1 **CLASSIC** Series	
Punches	17 - 34
90°	17 - 18
88°	19 - 24
85°	25 - 27
75°	27 - 28
70°	28
60°	29 - 30
45°	30 - 31
35°	31 - 32
30°	33
26°	33 - 3
R1 **A** Series	
Punches	35 - 39
90° - 88°	35 - 38
60°	39
45°	39
30°	39
R1 **AFH** Series	
Punches	40 - 43
85° - 88°	40 - 41
26°	41
Mobile Horns	42
Punches for closed profiles	43
Joggle Tools	44
Radius Tools and Hemming tool	45 - 47

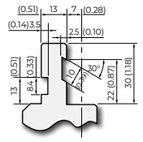
STANDARD TANG

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

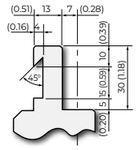


MODIFICATIONS FROM SAFETY GROOVES

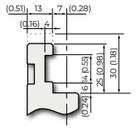
A1
Groove in addition to 8.4 x 3.5 mm
Groove for:
· Pneumatic clamping



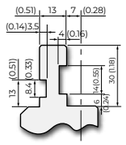
A8
Groove for:
· Hydraulic clamping
Gasparini



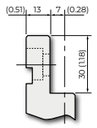
A42
Modified groove for:
· R3
· Bystronic-Beyeler Euro
· Safan



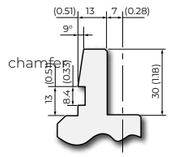
A6
Groove in addition to 8.4 x 3.5 mm
groove for:
· R3
· Bystronic-Beyeler Euro
· Safan



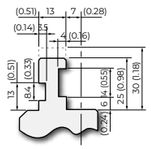
A9
Modified groove for:
· R2
· R3
· RX



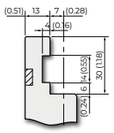
OT
Modification for:
· For Amada fast clamping system



A7
Groove in addition to 8.4 x 3.5 mm
and shortened tang for:
· R3
· Bystronic-Beyeler Euro
· Safan



A41
Modified groove for:
· R3
· Bystronic-Beyeler Euro
· Safan



STANDARD LENGTH

- **TOP**

525 mm (20.67 in)

- **CLASSIC · A · AFH**

415 mm (16.34 in)

835 mm (32.87 in)

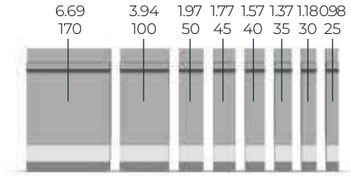
900 mm (35.43 in)

Segmented · On stock · Ask for delivery time

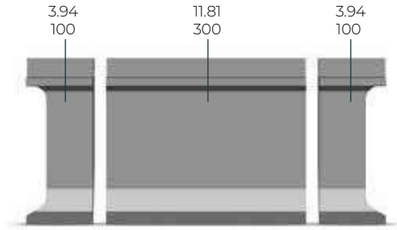
SEGMENTATION

- **TOP**

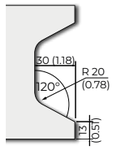
FA: 495 mm (19.49 in) - 8 segments



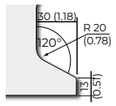
FB: 500 mm (19.68 in) - 3 segments



TOP - Horn types



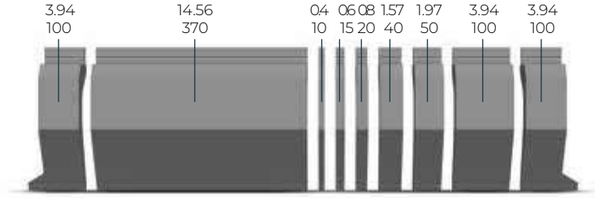
2



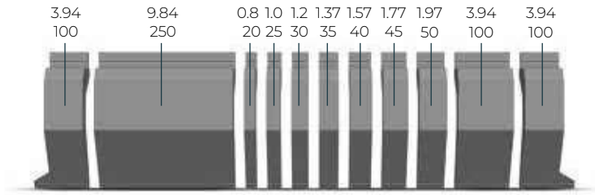
2/A

- **CLASSIC · A · AFH**

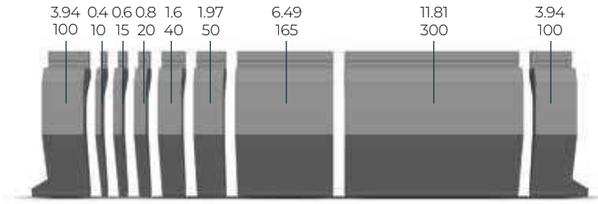
F: 805 mm (31.69 in) - 9 segments



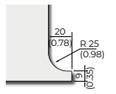
FX: 795 mm (31.29 in) - 11 segments



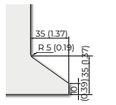
FC: 800 mm (31.50 in) - 9 segments



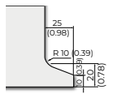
CLASSIC - A - AFH Horn types



1



3
R1-A



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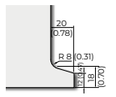
R1-A



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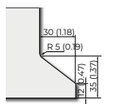
R1-A



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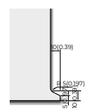
R1-A



7
R1-A

Punches - R1 TOP Series

42Cr: 900-1150 N/mm² — 900 kN/m max.

TOP.175.85.R08

H=145.00 / A=175.00 / R=0.8 [mm]
(H=5.71 / A=6.89 / R=0.031) [in]

525 mm	20.67 in	20.9 kg	
495 mm	19.49 in	19.7 kg	FA
500 mm	19.68 in	19.9 kg	FB

42Cr: 900-1150 N/mm² — 900 kN/m max.

TOP.175.85.R2

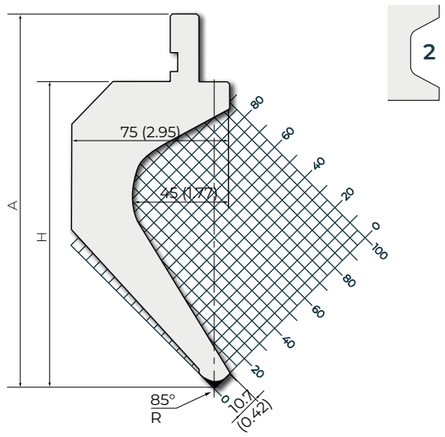
H=144.30 / A=174.30 / R=2.0 [mm]
(H=5.71 / A=6.89 / R=0.031)[in]

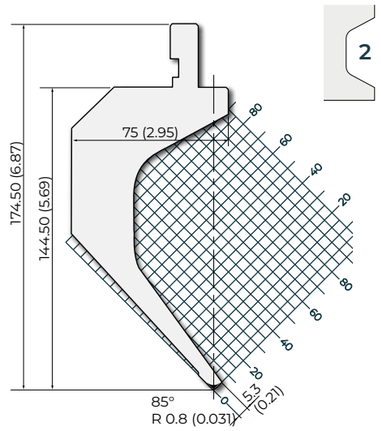
525 mm	20.67 in	20.9 kg	
495 mm	19.49 in	19.7 kg	FA
500 mm	19.68 in	19.9 kg	FB

42Cr: 900-1150 N/mm² — 200 kN/m max.

TOP.175.85.R08.S

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





85°

85°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TOP.205.85.R08

H=175.00 / A=205.00 / R=0.8 [mm]
(H=6.89 / A=8.07 / R=0.031) [in]

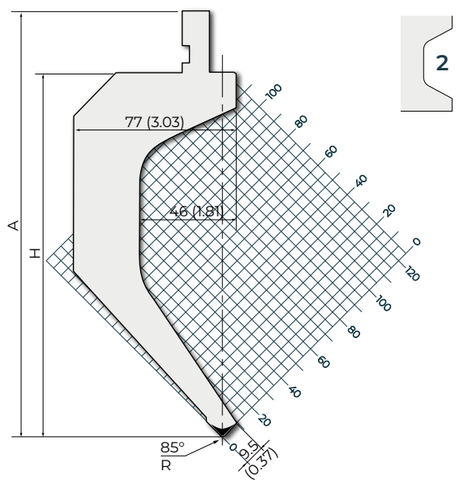
525 mm	20.67 in	24.0 kg	
495 mm	19.49 in	22.6 kg	FA
500 mm	19.68 in	22.9 kg	FB

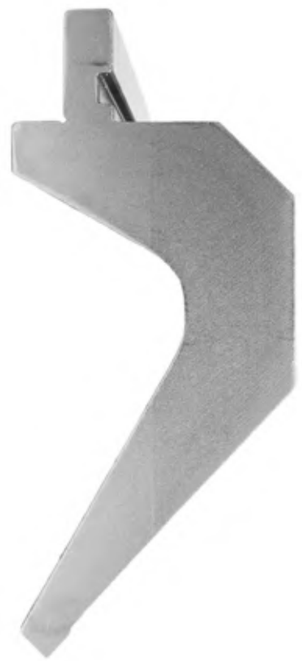
42Cr: 900-1150 N/mm² — 700 kN/m max.

TOP.205.85.R2

H=174.30 / A=204.30 / R=2.0 [mm]
(H=6.86 / A=8.04 / R=0.079) [in]

525 mm	20.67 in	24.0 kg	
495 mm	19.49 in	22.6 kg	FA
500 mm	19.68 in	22.9 kg	FB





85°

Punches - R1 TOP Series

42Cr: 900-1150 N/mm² — 750 kN/m max.

TOP.175.75.R08

H=145.00 / A=175.00 / R=0.8 [mm]
(H=5.71 / A=6.89 / R=0.031) [in]

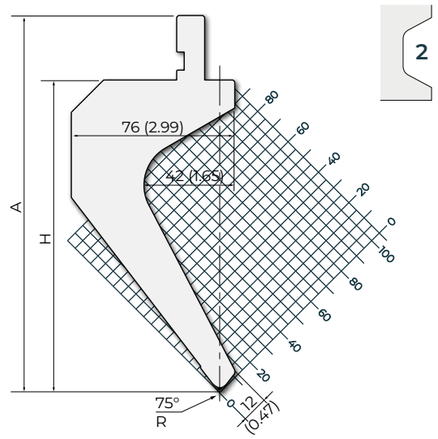
525 mm	20.67 in	21.5 kg	
495 mm	19.49 in	20.3 kg	FA
500 mm	19.68 in	20.5 kg	FB

42Cr: 900-1150 N/mm² — 750 kN/m max.

TOP.175.75.R2

H=144.20 / A=174.30 / R=2.0 [mm]
(H=5.68 / A=6.86 / R=0.079) [in]

525 mm	20.67 in	21.5 kg	
495 mm	19.49 in	20.3 kg	FA
500 mm	19.68 in	20.5 kg	FB



75°

42Cr: 900-1150 N/mm² — 800 kN/m max.

TOP.175.60.R08

H=145.00 / A=175.00 / R=0.8 [mm]
(H=5.71 / A=6.89 / R=0.031) [in]

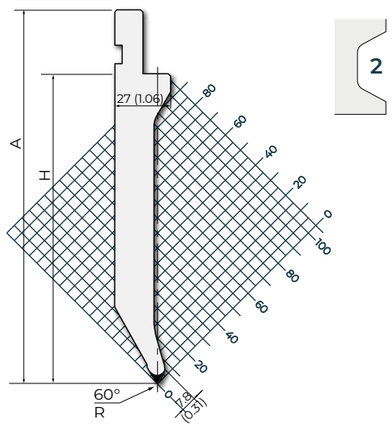
525 mm	20.67 in	12.0 kg	
495 mm	19.49 in	11.3 kg	FA
500 mm	19.68 in	11.4 kg	FB

42Cr: 900-1150 N/mm² — 800 kN/m max.

TOP.175.60.R2

H=143.80 / A=173.80 / R=2.0 [mm]
(H=5.66 / A=6.84 / R=0.079) [in]

525 mm	20.67 in	12.0 kg	
495 mm	19.49 in	12.0 kg	FA
500 mm	19.68 in	11.0 kg	FB

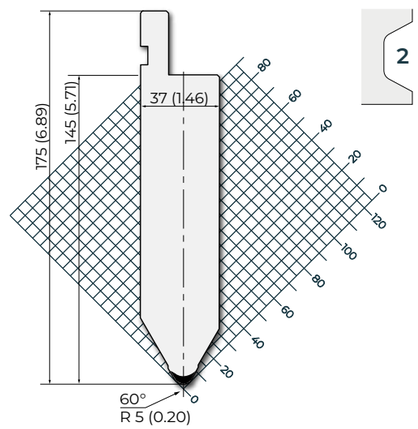


60°

42Cr: 900-1150 N/mm² — 1600 kN/m max.

TOP.175.60.R5

525 mm	20.67 in	21.5 kg	
495 mm	19.49 in	21.0 kg	FA
500 mm	19.68 in	19.0 kg	FB



60°

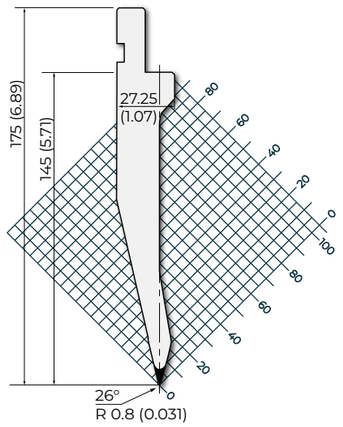
Segmented · On stock · Ask for delivery time

Punches - R1 TOP Series

42Cr: 900-1150 N/mm² — 950 kN/m max.

TOP.175.26.R08

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

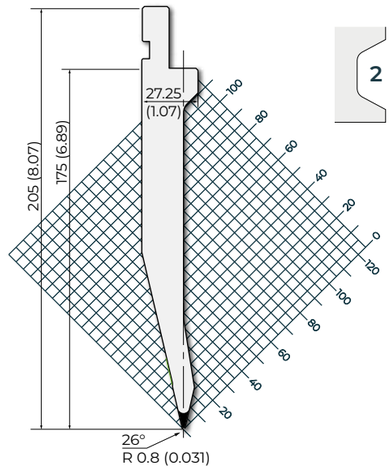


26°

42Cr: 900-1150 N/mm² — 950 kN/m max.

TOP.205.26.R08

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

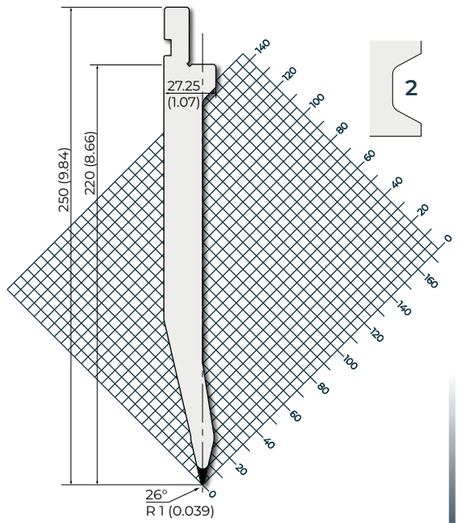


26°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

TOP.250.26.R1

525 mm	20.67 in	17.7 kg	
495 mm	19.49 in	17.7 kg	FA
500 mm	19.68 in	17.7 kg	FB



26°

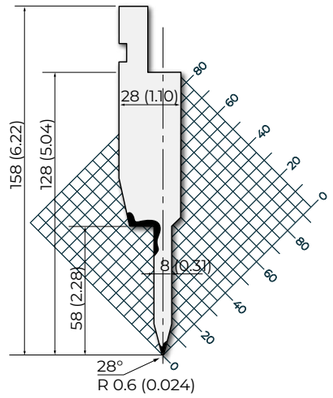
Hemming Tools - R1 TOP Series

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

TOP.SP.134.28.8

525 mm	20.67 in	11.0 kg	
495 mm	19.49 in	10.3 kg	FA

To use with:
▸ TOP.SM-134.28.8 (Page 81)



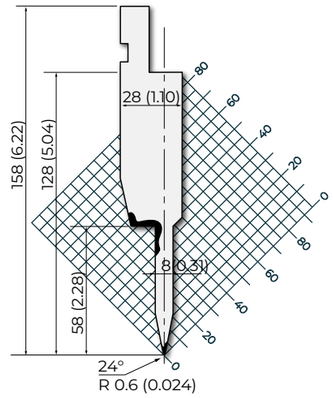
28°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

TOP.SP.134.24.8

525 mm	20.67 in	11.0 kg	
495 mm	19.49 in	10.3 kg	FA

To use with:
▸ TOP.SM-134.24.8 (Page 81)



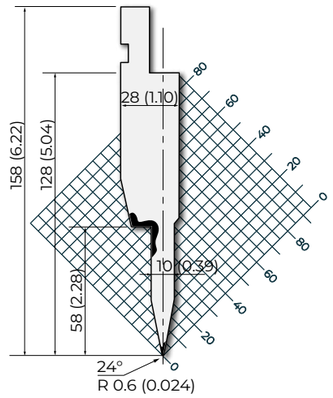
24°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

TOP.SP.134.24.10

525 mm	20.67 in	11.0 kg	
495 mm	19.49 in	10.3 kg	FA

To use with:
▸ TOP.SM-134.24.10 (Page 81)



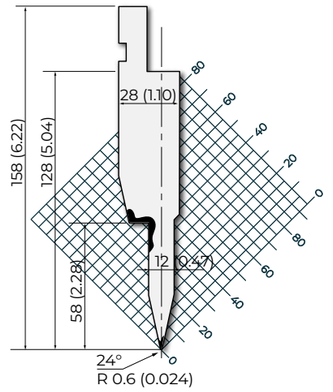
24°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

TOP.SP.134.24.12

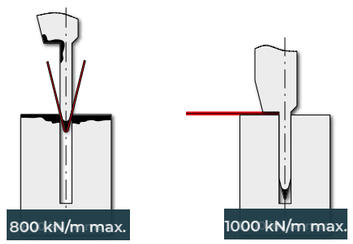
525 mm	20.67 in	11.6 kg	
495 mm	19.49 in	11.0 kg	FA

To use with:
▸ TOP.SM-134.24.12 (Page 81)



24°

Ex. Application ▸



S [mm]	S (in)	A [mm]	A (in)	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	3.0	0.12	90	150
0.8	0.03	3.0	0.12	120	200
1.0	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260

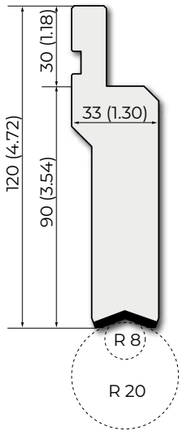
S [mm]	S (in)	A [mm]	A (in)	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	1.2	0.05	230	350
0.8	0.03	1.6	0.06	320	500
1.0	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800

Radius punches - R1 TOP Series

42Cr: 900-1150 N/mm² — 1000 kN/m max.

TOP.PC.120-08

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

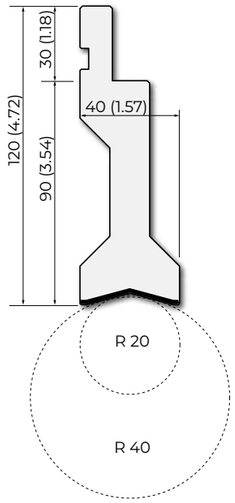


R8 - R20

42Cr: 900-1150 N/mm² — 1000 kN/m max.

TOP.PC.120-20

522 mm	20.67 in	10.5 kg	
495 mm	19.49 in	10.0 kg	FA

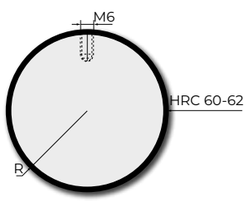


R20 - R40

C53: 610-760 N/mm² — 1000 kN/m max.

Radius punches: R08-R40

Model	R [mm]	R [in]	525 mm (20.67 in)	495 mm (19.49 in)
TOP.C08	8	0.31	0,8 kg	1,9 kg
TOP.C10	10	0.39	1,3 kg	2,7 kg
TOP.C12.5	12,5	0.49	2,0 kg	2,8 kg
TOP.C15	15	0.59	3,0 kg	3,8 kg
TOP.C17.5	17,5	0.69	4,0 kg	4,7 kg
TOP.C20	20	0.79	5,2 kg	6,6 kg
TOP.C22.5	22,5	0.88	6,6 kg	6,6 kg
TOP.C25	25	0.98	8,1 kg	7,5 kg
TOP.C27.5	27,5	1.08	9,8 kg	9,2 kg
TOP.C30	30	1.18	11,7 kg	11,3 kg
TOP.C32.5	32,5	1.28	13,7 kg	12,9 kg
TOP.C35	35	1.138	16,0 kg	15,1 kg
TOP.C37.5	37,5	1.47	18,2 kg	17,2 kg
TOP.C40	40	1.57	20,7 kg	19,5 kg



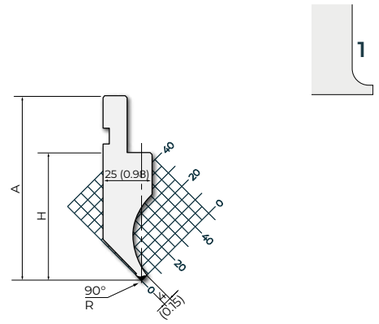
Punches - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 350 kN/m max.

PK.97.90.R06

H=66.80 / A=96.80 / R=0.6 [mm] (H=2.63 / A=3.81 / R=0.024) [in]

835 mm	32.87 in	10.5 kg	
415 mm	16.34 in	5.2 kg	
795 mm	31.29 in	10.1 kg	FX
805 mm	31.69 in	10.1 kg	F



90°

42Cr: 900-1150 N/mm² — 350 kN/m max.

P.97.90.R025

H=66.80 / A=96.80 / R=0.25 [mm] (H=2.63 / A=3.81 / R=0.010) [in]

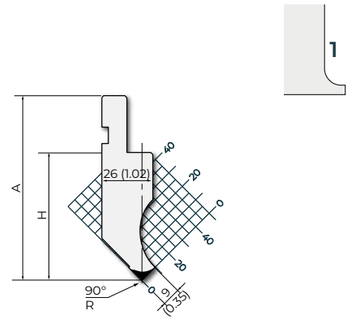
835 mm	32.87 in	10.5 kg	
415 mm	16.34 in	5.2 kg	
795 mm	31.29 in	10.1 kg	FX
805 mm	31.69 in	10.1 kg	F

C45: 560-710 N/mm² — 1000 kN/m max.

PK.97.90.R08

H=66.35 / A=96.35 / R=0.8 [mm] (H=2.61 / A=3.79 / R=0.031) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
805 mm	31.69 in	10.5 kg	F



90°

C45: 560-710 N/mm² — 1000 kN/m max.

PK.97.90.R025

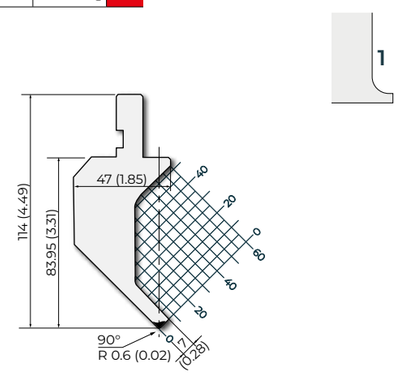
H=66.80 / A=96.80 / R=0.25 [mm] (H=2.62 / A=3.80 / R=0.010) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	11.0 kg	FX
805 mm	31.69 in	11.0 kg	F

42Cr: 900-1150 N/mm² — 200 kN/m max.

PK.114.90.R06

835 mm	32.87 in	14.0 kg	
415 mm	16.34 in	7.0 kg	
795 mm	31.29 in	14.0 kg	FX
805 mm	31.69 in	14.0 kg	F

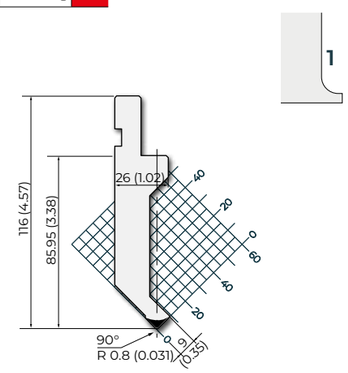


90°

C45: 560-710 N/mm² — 400 kN/m max.

PK.116.90.R08

835 mm	32.87 in	13.0 kg	
415 mm	16.34 in	6.5 kg	
795 mm	31.29 in	13.0 kg	FX
805 mm	31.69 in	13.0 kg	F



90°

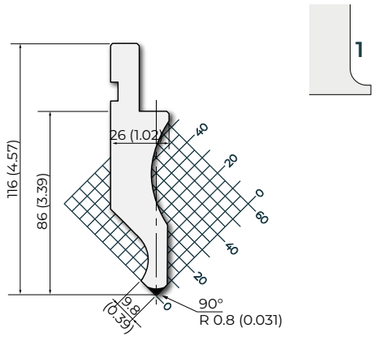
Segmented · On stock · Ask for delivery time

Punches - R1 CLASSIC Series

C45: 560-710 N/mm² — 500 kN/m max.

DK.116.90.R08

835 mm	32.87 in	13.0 kg	
415 mm	16.34 in	6.5 kg	
795 mm	31.29 in	13.0 kg	FX
805 mm	31.69 in	13.0 kg	F



90°

C45: 560-710 N/mm² — 600 kN/m max.

PK.120.90.R08

H=89.35 / A=119.35 / R=0.8 [mm]
(H=3.52 / A=4.70 / R=0.031) [in]

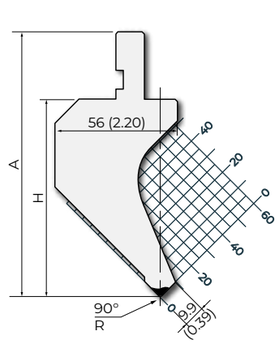
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F

C45: 560-710 N/mm² — 600 kN/m max.

PK.120.90.R025

H=89.60 / A=119.60 / R=0.25 [mm]
(H=3.53 / A=4.71 / R=0.010) [in]

835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F



90°

42Cr: 900-1150 N/mm² — 350 kN/m max.

P.130.90.R06

H=100.00 / A=130.00 / R=0.6 [mm]
(H=3.94 / A=5.12 / R=0.024) [in]

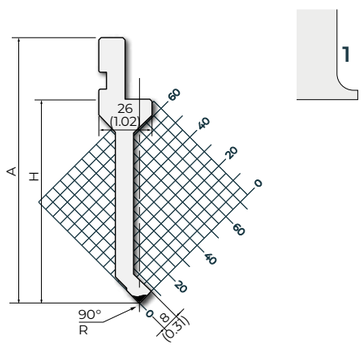
835 mm	32.87 in	11.5 kg	
415 mm	16.34 in	5.7 kg	
795 mm	31.29 in	11.0 kg	FX
805 mm	31.69 in	11.0 kg	F

42Cr: 900-1150 N/mm² — 350 kN/m max.

P.130.90.R025

H=100.00 / A=130.00 / R=0.25 [mm]
(H=3.94 / A=5.12 / R=0.010) [in]

835 mm	32.87 in	11.5 kg	
415 mm	16.34 in	5.7 kg	
795 mm	31.29 in	11.0 kg	FX
805 mm	31.69 in	11.0 kg	F



90°

C45: 560-710 N/mm² — 500 kN/m max.

PK.135.90.R08

H=104.35 / A=134.35 / R=0.8 [mm]
(H=4.11 / A=5.29 / R=0.031) [in]

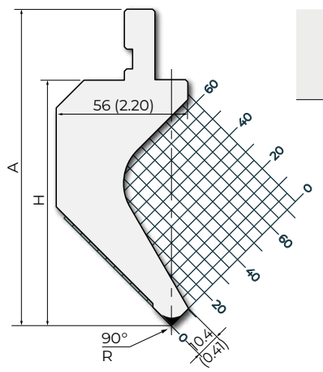
835 mm	32.87 in	22.0 kg	
415 mm	16.34 in	11.5 kg	
795 mm	31.29 in	23.0 kg	FX
805 mm	31.69 in	23.0 kg	F

C45: 560-710 N/mm² — 500 kN/m max.

PK.135.90.R025

H=104.60 / A=134.60 / R=0.25 [mm]
(H=4.12 / A=5.30 / R=0.010) [in]

835 mm	32.87 in	22.0 kg	
415 mm	16.34 in	11.5 kg	
795 mm	31.29 in	23.0 kg	FX
805 mm	31.69 in	23.0 kg	F



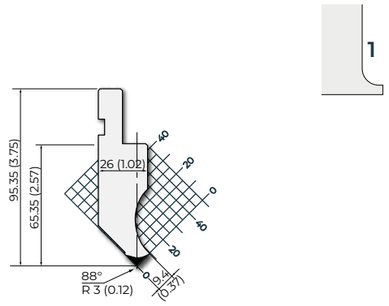
90°

Punches - R1 CLASSIC Series

C45: 560-710 N/mm² — 1000 kN/m max.

P.95.88.R3

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.0 kg	FX
805 mm	31.69 in	10.0 kg	F



88°

42Cr: 900-1150 N/mm² — 350 kN/m max.

P.97.88.R06

H=67.00 / A=97.00 / R=0.6 [mm]
(H=2.64 / A=3.82 / R=0.024) [in]

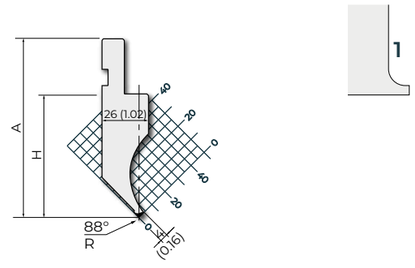
835 mm	32.87 in	9.5 kg	
415 mm	16.34 in	5.0 kg	
795 mm	31.29 in	10.0 kg	FX
805 mm	31.69 in	10.0 kg	F
900 mm	35.43 in	11.0 kg	

42Cr: 900-1150 N/mm² — 350 kN/m max.

P.97.88.R025

H=66.95 / A=96.95 / R=0.25 [mm]
(H=2.64 / A=3.82 / R=0.010) [in]

835 mm	32.87 in	9.5 kg	
415 mm	16.34 in	5.0 kg	
795 mm	31.29 in	9.2 kg	FX
805 mm	31.69 in	9.2 kg	F
900 mm	35.43 in	9.5 kg	



88°

C45: 560-710 N/mm² — 1000 kN/m max.

P.97.88.R08

H=66.65 / A=96.65 / R=0.8 [mm]
(H=2.62 / A=3.81 / R=0.031) [in]

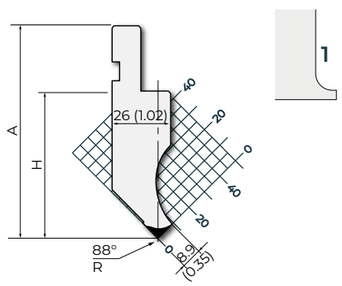
835 mm	32.87 in	11.1 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.6 kg	FX
805 mm	31.69 in	10.6 kg	F
900 mm	35.43 in	11.0 kg	

C45: 560-710 N/mm² — 1000 kN/m max.

PK.97.88.R025

H=66.60 / A=96.60 / R=0.25 [mm]
(H=2.62 / A=3.80 / R=0.010) [in]

835 mm	32.87 in	11.1 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.0 kg	FX
805 mm	31.69 in	10.0 kg	F
900 mm	35.43 in	11.8 kg	

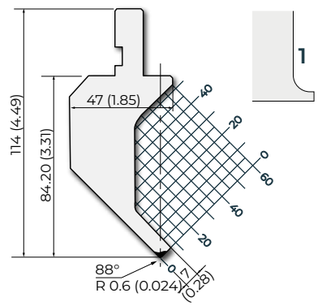


88°

42Cr: 900-1150 N/mm² — 200 kN/m max.

P.114.88.R06

835 mm	32.87 in	15.6 kg	
415 mm	16.34 in	7.7 kg	
795 mm	31.29 in	14.5 kg	FX
805 mm	31.69 in	14.5 kg	F



88°

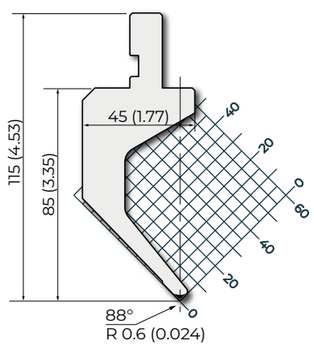
Segmented — On stock — Ask for delivery time

Punches - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 130 kN/m max.

P.115.88.R06

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



88°

C45: 560-710 N/mm² — 500 kN/m max.

D.116.88.R08

H=86.00 / A=116.00 / R=0.8 [mm]
(H=3.39 / A=4.57 / R=0.031) [in]

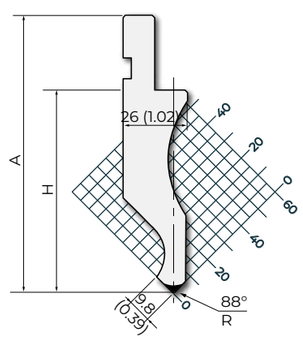
835 mm	32.87 in	11.9 kg	
415 mm	16.34 in	5.8 kg	
795 mm	31.29 in	11.9 kg	FX
805 mm	31.69 in	11.9 kg	F

C45: 560-710 N/mm² — 500 kN/m max.

D.116.88.R3

H=85.00 / A=115.00 / R=3.0 [mm]
(H=3.35 / A=4.53 / R=0.118) [in]

835 mm	32.87 in	11.9 kg	
415 mm	16.34 in	5.9 kg	
795 mm	31.29 in	11.5 kg	FX
805 mm	31.69 in	11.5 kg	F

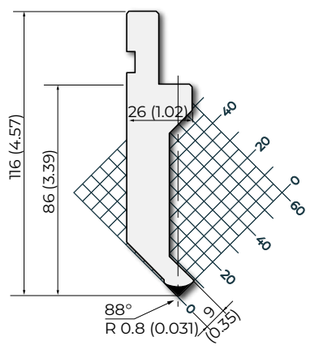


88°

C45: 560-710 N/mm² — 400 kN/m max.

P.116.88.R08

835 mm	32.87 in	12.0 kg	
415 mm	16.34 in	6.0 kg	
795 mm	31.29 in	12.0 kg	FX
805 mm	31.69 in	12.0 kg	F

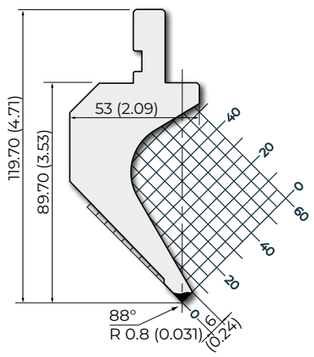


88°

C45: 560-710 N/mm² — 450 kN/m max.

PS.120.88.R08

835 mm	32.87 in	17.0 kg	
415 mm	16.34 in	8.4 kg	
795 mm	31.29 in	16.4 kg	FX
805 mm	31.69 in	16.4 kg	F



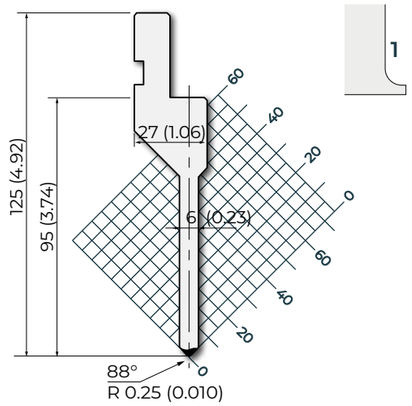
88°

Punches - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 500 kN/m max.

P.125.88.R025

835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm	31.29 in	9.0 kg	FX
805 mm	31.69 in	9.0 kg	F



88°

C45: 560-710 N/mm² — 600 kN/m max.

P.120.88.R08

H=89.65 / A=120.00 / R=0.8 [mm]
(H=3.53 / A=4.72 / R=0.031) [in]

835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	11.0 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F

C45: 560-710 N/mm² — 600 kN/m max.

P.120.88.R3

H=88.50 / A=118.50 / R=3.0 [mm]
(H=3.48 / A=4.67 / R=0.118) [in]

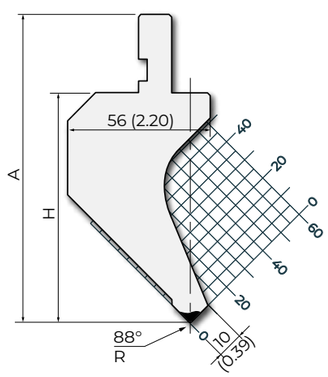
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.4 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F

C45: 560-710 N/mm² — 600 kN/m max.

PK.120.88.R025

H=89.60 / A=120.00 / R=0.25 [mm]
(H=3.53 / A=4.72 / R=0.010) [in]

835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.4 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F



88°

Segmented · On stock · Ask for delivery time

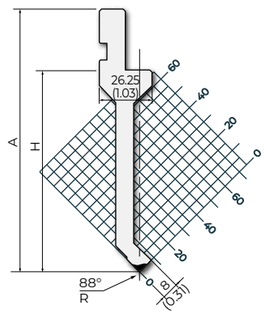
Punches - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 350 kN/m max.

P.130.88.R06

H=100.00 / A=130.00 / R=0.6 [mm]
(H= 3.94 / A=5.12 / R=0.024) [in]

835 mm	32.87 in	9.8 kg	
415 mm	16.34 in	4.9 kg	
795 mm	31.29 in	9.4 kg	FX
805 mm	31.69 in	9.4 kg	F
900 mm	35.43 in	10.5 kg	



88°

42Cr: 900-1150 N/mm² — 350 kN/m max.

PK.130.88.R025

H=99.95 / A=129.95 / R=0.25 [mm]
(H=3.94 / A=5.12 / R=0.010) [in]

835 mm	32.87 in	9.7 kg	
415 mm	16.34 in	4.8 kg	
795 mm	31.29 in	9.3 kg	FX
805 mm	31.69 in	9.3 kg	F
900 mm	35.43 in	10.4 kg	

C45: 560-710 N/mm² — 400 kN/m max.

P.130.88.R08

H=100.00 / A=130.00 / R=0.8 [mm]
(H=3.94 / A=5.12 / R=0.031) [in]

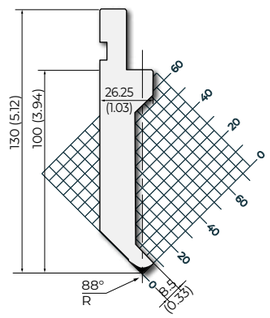
835 mm	32.87 in	14.0 kg	
415 mm	16.34 in	7.0 kg	
795 mm	31.29 in	14.0 kg	FX
805 mm	31.69 in	14.0 kg	F

C45: 560-710 N/mm² — 400 kN/m max.

P.130.88.R025

H=100.00 / A=130.00 / R=0.25 [mm]
(H=3.94 / A=5.12 / R=0.010) [in]

835 mm	32.87 in	13.7 kg	
415 mm	16.34 in	6.8 kg	
795 mm	31.29 in	13.2 kg	FX
805 mm	31.69 in	13.2 kg	F



88°

C45: 560-710 N/mm² — 500 kN/m max.

P.135.88.R08

H=104.65 / A=134.50 / R=0.8 [mm]
(H=4.12 / A=5.30 / R=0.031) [in]

835 mm	32.87 in	22.5 kg	
415 mm	16.34 in	11.2 kg	
795 mm	31.29 in	21.7 kg	FX
805 mm	31.69 in	21.7 kg	F

C45: 560-710 N/mm² — 500 kN/m max.

P.135.88.R3

H=103.40 / A=133.40 / R=3.0 [mm]
(H=4.07 / A=5.25 / R=0.118) [in]

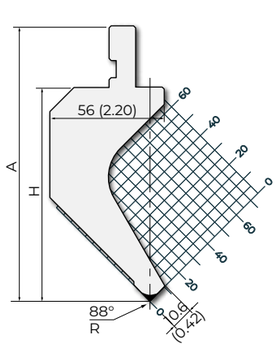
835 mm	32.87 in	22.5 kg	
415 mm	16.34 in	11.2 kg	
795 mm	31.29 in	21.5 kg	FX
805 mm	31.69 in	21.5 kg	F

C45: 560-710 N/mm² — 500 kN/m max.

PK.135.88.R025

H=104.60 / A=134.50 / R=0.25 [mm]
(H=4.12 / A=5.30/ R=0.010) [in]

835 mm	32.87 in	22.7 kg	
415 mm	16.34 in	11.5 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F



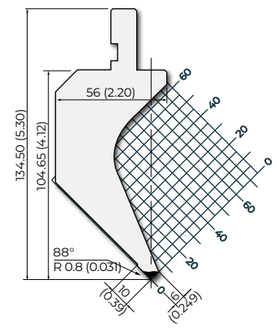
88°

Punches - R1 CLASSIC Series

C45: 560-710 N/mm² — 450 kN/m max.

PS.135.88.R08

835 mm	32.87 in	22.0 kg	
415 mm	16.34 in	12.5 kg	
795 mm	31.29 in	21.5 kg	FX
805 mm	31.69 in	21.5 kg	F

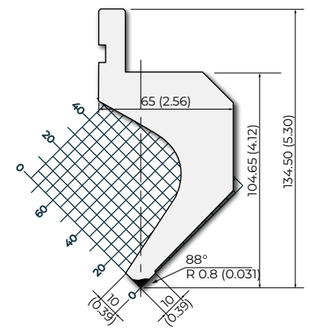


88°

C45: 560-710 N/mm² — 450 kN/m max.

PR.135.88.R08

835 mm	32.87 in	25.0 kg	
415 mm	16.34 in	11.5 kg	
795 mm	31.29 in	24.1 kg	FX
805 mm	31.69 in	24.1 kg	F



88°

42Cr: 900-1150 N/mm² — 500 kN/m max.

P.150.88.R08

H=120.00 / A=150.00 / R=0.8 [mm]
(H=4.72 / A=5.91 / R=0.031) [in]

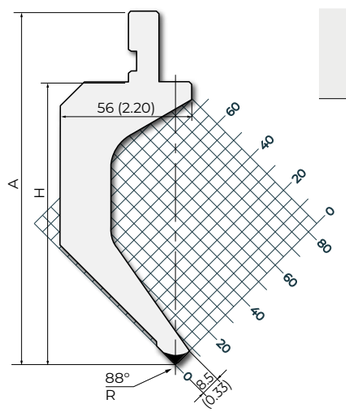
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	20.5 kg	FX
805 mm	31.69 in	20.5 kg	F
900 mm	35.43 in	23.0 kg	

42Cr: 900-1150 N/mm² — 500 kN/m max.

P.150.88.R3

H=119.00 / A=149.00 / R=3.0 [mm]
(H=4.69 / A=5.87 / R=0.118) [in]

835 mm	32.87 in	19.2 kg	
415 mm	16.34 in	15.0 kg	
795 mm	31.29 in	20.0 kg	FX
805 mm	31.69 in	20.0 kg	F
900 mm	35.43 in	22.6 kg	

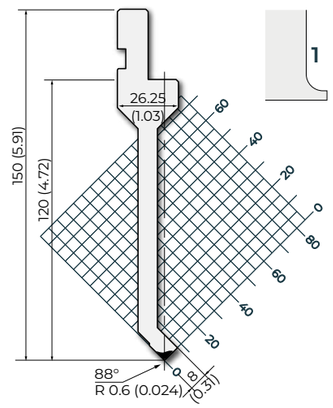


88°

42Cr: 900-1150 N/mm² — 350 kN/m max.

P.150.88.R06

835 mm	32.87 in	12.9 kg	
415 mm	16.34 in	12.9 kg	
795 mm	31.29 in	12.9 kg	FX
805 mm	31.69 in	12.9 kg	F
900 mm	35.43 in	12.9 kg	



88°

Segmented

On stock

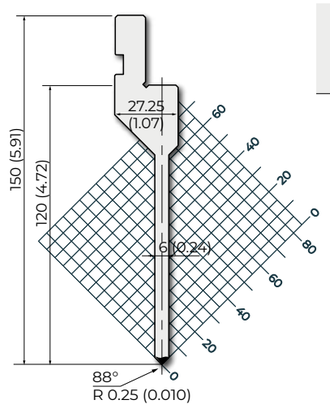
Ask for delivery time

Punches - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 500 kN/m max.

P.150.88.R025

835 mm	32.87 in	10.6 kg	
415 mm	16.34 in	5.3 kg	
795 mm	31.29 in	10.1 kg	FX
805 mm	31.69 in	10.2 kg	F

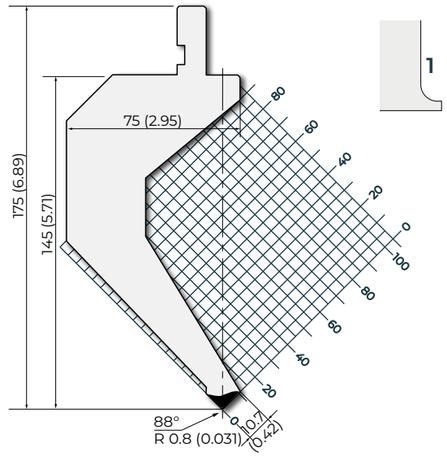


88°

C45: 560-710 N/mm² — 500 kN/m max.

P.175.88.R08

835 mm	32.87 in	35.0 kg	
415 mm	16.34 in	17.5 kg	
795 mm	31.29 in	39.0 kg	FX
805 mm	31.69 in	39.0 kg	F

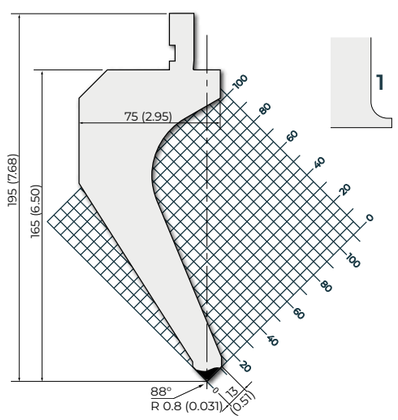


88°

C45: 560-710 N/mm² — 600 kN/m max.

P.195.88.R08

835 mm	32.87 in	41.0 kg	
415 mm	16.34 in	20.4 kg	
795 mm	31.29 in	39.5 kg	FX
805 mm	31.69 in	39.5 kg	F

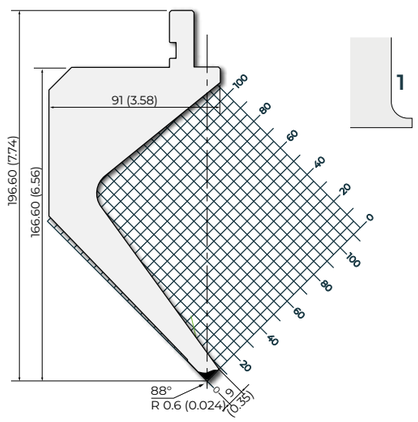


88°

C45: 560-710 N/mm² — 300 kN/m max.

P.196.88.R06

835 mm	32.87 in	41.8 kg	
415 mm	16.34 in	20.8 kg	
795 mm	31.29 in	40.2 kg	FX
805 mm	31.69 in	40.2 kg	F
900 mm	35.43 in	45.0 kg	



88°

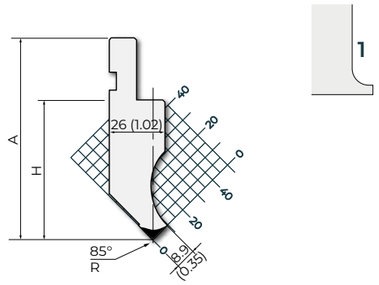
Punches - R1 CLASSIC Series

C45: 560-710 N/mm² — 1000 kN/m max.

P.97.85.R08

H=66.60 / A=96.50 / R=0.8 [mm]
(H=2.62 / A=3.80 / R=0.031) [in]

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



85°

C45: 560-710 N/mm² — 1000 kN/m max.

PK.95.85.R3

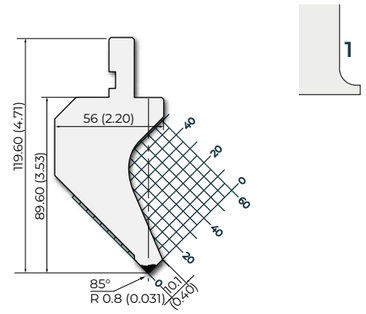
H=65.45 / A=95.45 / R=3.0 [mm]
(H=2.58 / A=3.76 / R=0.118) [in]

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

C45: 560-710 N/mm² — 600 kN/m max.

PK.120.85.R08

835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	21.0 kg	FX
805 mm	31.69 in	21.0 kg	F

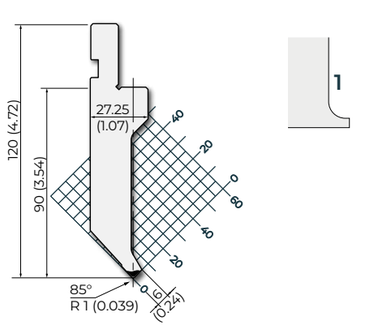


85°

42Cr: 900-1150 N/mm² — 800 kN/m max.

P.120.85.R1

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

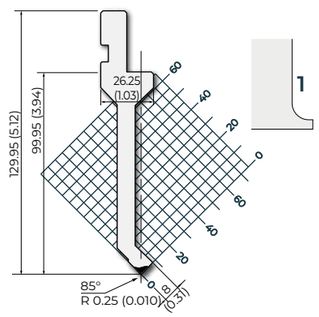


85°

42Cr: 900-1150 N/mm² — 350 kN/m max.

P.130.85.R025

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



85°

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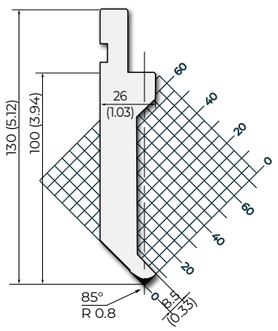
Punches - R1 CLASSIC Series

C45: 560-710 N/mm² — 700 kN/m max.

P.130.85.R08

835 mm	32.87 in	13.7 kg	
415 mm	16.34 in	6.8 kg	
795 mm	31.29 in	13.0 kg	FX
805 mm	31.69 in	13.2 kg	F

NEW

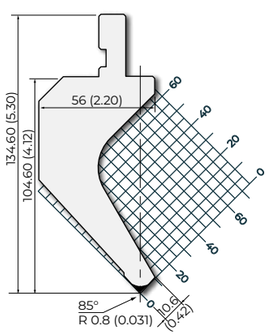


85°

C45: 560-710 N/mm² — 500 kN/m max.

PK.135.85.R08

835 mm	32.87 in	22.2 kg	
415 mm	16.34 in	11.0 kg	
795 mm	31.29 in	21.7 kg	FX
805 mm	31.69 in	21.7 kg	F

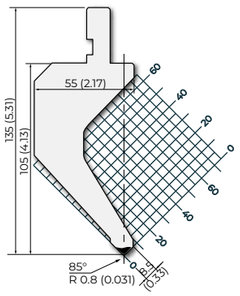


85°

42Cr: 900-1150 N/mm² — 800 kN/m max.

P.135.85.R08

835 mm	32.87 in	20.9 kg	
415 mm	16.34 in	10.4 kg	
795 mm	31.29 in	19.2 kg	FX
805 mm	31.69 in	19.2 kg	F

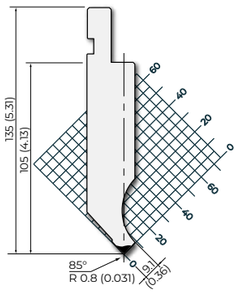


85°

C45: 560-710 N/mm² — 1000 kN/m max.

PS.135.85.R08

835 mm	32.87 in	17.7 kg	
415 mm	16.34 in	8.5 kg	
795 mm	31.29 in	16.0 kg	FX
805 mm	31.69 in	16.0 kg	F



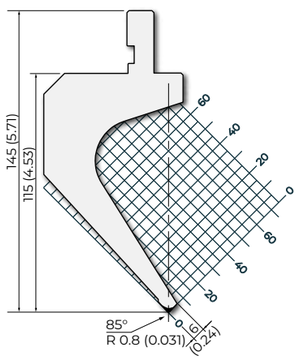
85°

Punches - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 600 kN/m max.

P.145.85.R08

835 mm	32.87 in	22.6 kg	
415 mm	16.34 in	11.2 kg	
795 mm	31.29 in	20.0 kg	FX
805 mm	31.69 in	20.0 kg	F



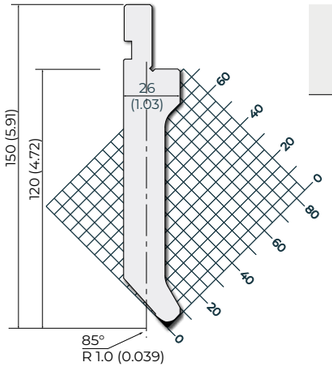
85°

C45: 560-710 N/mm² — 700 kN/m max.

P.150.85.R1

835 mm	32.87 in	17.5 kg	
415 mm	16.34 in	8.7 kg	
795 mm	31.29 in	16.6 kg	FX
805 mm	31.69 in	16.9 kg	F

NEW

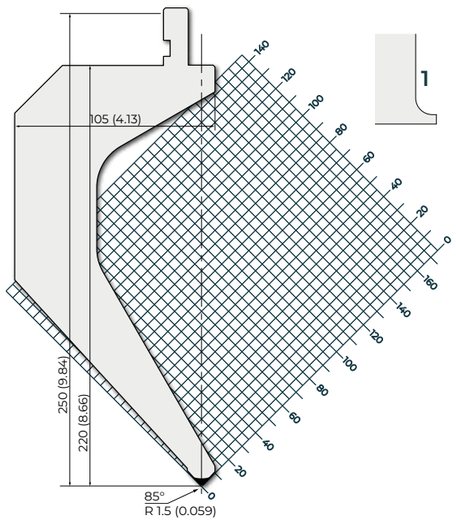


85°

42Cr: 900-1150 N/mm² — 850 kN/m max.

P.250.85.R15

415 mm	16.34 in	33.1 kg	
795 mm	31.29 in	63.3 kg	FX

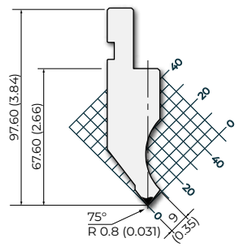


85°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

P.97.75.R08

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	11.0 kg	FX
805 mm	31.69 in	11.0 kg	F



75°

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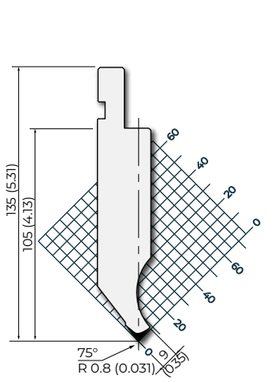
Punches - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 1000 kN/m max.

P.135.75.R08

835 mm	32.87 in	17.5 kg	
415 mm	16.34 in	8.8 kg	
795 mm	31.29 in	17.5 kg	FX
805 mm	31.69 in	17.5 kg	F



1

75°

42Cr: 900-1150 N/mm² — 450 kN/m max.

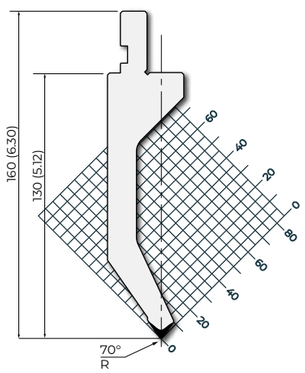
P.160.70.R08

R=0.8 (0.031)			
835 mm	32.87 in	18.0 kg	
415 mm	16.34 in	8.9 kg	
795 mm	31.29 in	17.3 kg	FX
805 mm	31.69 in	17.3 kg	F

42Cr: 900-1150 N/mm² — 450 kN/m max.

P.160.70.R3

R=3.0 (0.118)			
835 mm	32.87 in	18.0 kg	
415 mm	16.34 in	8.9 kg	
795 mm	31.29 in	17.3 kg	FX
805 mm	31.69 in	17.3 kg	F



1

70°

Punches - R1 CLASSIC Series

C45: 560-710 N/mm² — 600 kN/m max.

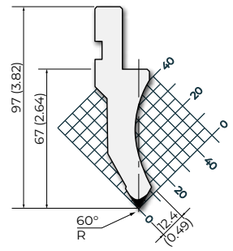
P.97.60.R08

R=0.8 (0.031)			
835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm	31.29 in	9.0 kg	FX
805 mm	31.69 in	9.0 kg	F

C45: 560-710 N/mm² — 600 kN/m max.

P.97.60.R2

R=2.0 (0.079)			
835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	5.0 kg	
795 mm	31.29 in	9.0 kg	FX
805 mm	31.69 in	9.0 kg	F



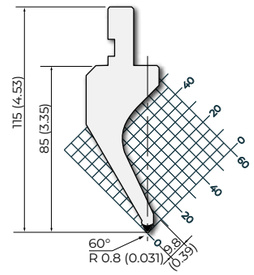
1

60°

42Cr: 900-1150 N/mm² — 400 kN/m max.

P.115.60.R08

835 mm	32.87 in	11.9 kg	
415 mm	16.34 in	5.9 kg	
795 mm	31.29 in	10.7 kg	FX
805 mm	31.69 in	10.7 kg	F



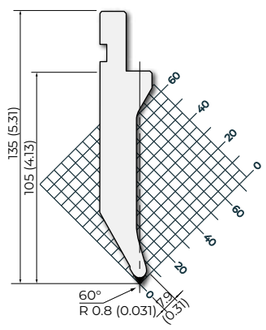
1

60°

42Cr: 900-1150 N/mm² — 800 kN/m max.

P.135.60.R08

835 mm	32.87 in	14.0 kg	
415 mm	16.34 in	7.0 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.5 kg	F



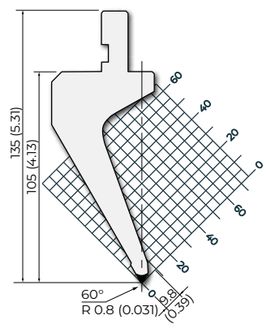
1

60°

42Cr: 900-1150 N/mm² — 700 kN/m max.

PG.135.60.R08

835 mm	32.87 in	16.5 kg	
415 mm	16.34 in	8.5 kg	
795 mm	31.29 in	16.0 kg	FX
805 mm	31.69 in	16.0 kg	F



1

60°

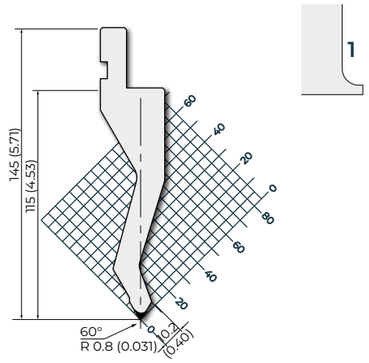
Segmented · On stock · Ask for delivery time

Punches - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 700 kN/m max.

P.145.60.R08

835 mm	32.87 in	15.0 kg	
415 mm	16.34 in	7.5 kg	
795 mm	31.29 in	15.0 kg	FX
805 mm	31.69 in	15.0 kg	F

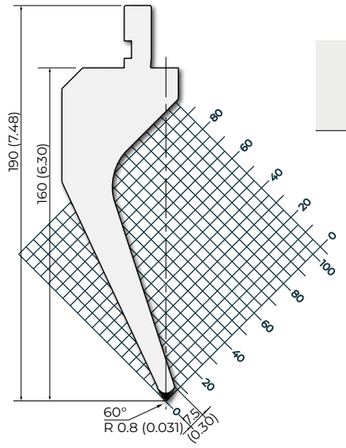


60°

C45: 560-710 N/mm² — 400 kN/m max.

P.190.60.R08

835 mm	32.87 in	27.0 kg	
415 mm	16.34 in	13.5 kg	
795 mm	31.29 in	26.0 kg	FX
805 mm	31.69 in	26.1 kg	F



60°

C45: 560-710 N/mm² — 800 kN/m max.

P.95.45.R08

R=0.8 (0.031)

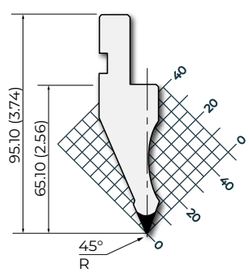
835 mm	32.87 in	9.5 kg	
415 mm	16.34 in	4.2 kg	
795 mm	31.29 in	9.0 kg	FX
805 mm	31.69 in	9.0 kg	F

C45: 560-710 N/mm² — 800 kN/m max.

P.95.45.R15

R=1.5 (0.059)

835 mm	32.87 in	9.5 kg	
415 mm	16.34 in	4.2 kg	
795 mm	31.29 in	9.5 kg	FX
805 mm	31.69 in	9.5 kg	F

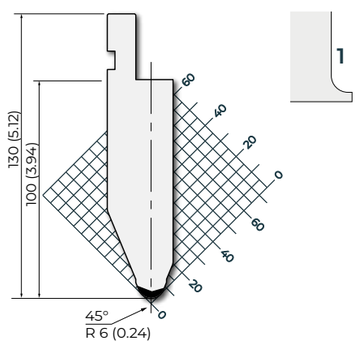


45°

C45: 560-710 N/mm² — 1000 kN/m max.

P.130.45.R6

835 mm	32.87 in	19.5 kg	
415 mm	16.34 in	9.6 kg	
795 mm	31.29 in	18.3 kg	FX
805 mm	31.69 in	18.3 kg	F



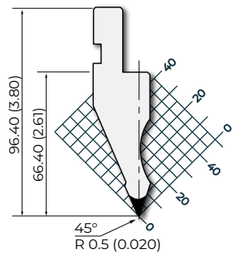
45°

Punches - R1 CLASSIC Series

C45: 560-710 N/mm² — 800 kN/m max.

P.97.45.R05

835 mm	32.87 in	10.2 kg	
415 mm	16.34 in	5.1 kg	
795 mm	31.29 in	10.2 kg	FX
805 mm	31.69 in	10.2 kg	F
900 mm	35.43 in	10.2 kg	

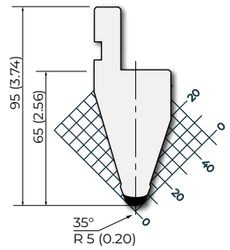


45°

C45: 560-710 N/mm² — 1000 kN/m max.

P.95.35.R5

835 mm	32.87 in	13.5 kg	
415 mm	16.34 in	7.0 kg	
795 mm	31.29 in	14.0 kg	FX
805 mm	31.69 in	14.0 kg	F

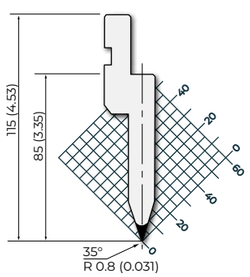


35°

C45: 560-710 N/mm² — 1000 kN/m max.

PU.85.35.R08

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
805 mm	31.69 in	10.5 kg	F



35°

C45: 560-710 N/mm² — 700 kN/m max.

P.116.35.R08

R=0.8 (0.031)

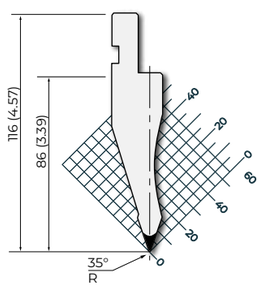
835 mm	32.87 in	10.5 kg	
415 mm	16.34 in	5.7 kg	
795 mm	31.29 in	10.1 kg	FX
805 mm	31.69 in	10.1 kg	F

C45: 560-710 N/mm² — 700 kN/m max.

P.116.35.R15

R=1.5 (0.059)

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.7 kg	
795 mm	31.29 in	10.0 kg	FX
805 mm	31.69 in	10.0 kg	F



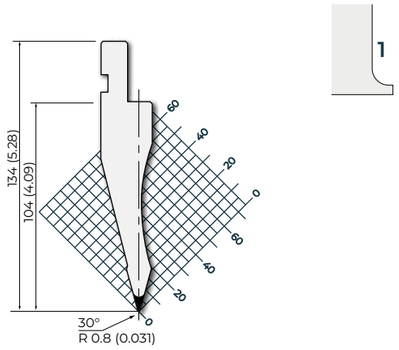
35°

Segmented · On stock · Ask for delivery time

C45: 560-710 N/mm² — 700 kN/m max.

PS.134.30.R08

835 mm	32.87 in	13.3 kg	
415 mm	16.34 in	6.5 kg	
795 mm	31.29 in	12.5 kg	FX
805 mm	31.69 in	12.5 kg	F

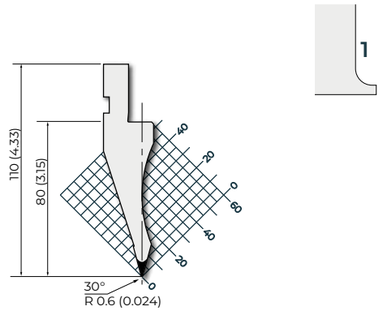


30°

C45: 560-710 N/mm² — 500 kN/m max.

P.110.30.R06

835 mm	32.87 in	10.5 kg	
415 mm	16.34 in	5.2 kg	
795 mm	31.29 in	10.0 kg	FX
805 mm	31.69 in	10.0 kg	F



30°

C45: 560-710 N/mm² — 700 kN/m max.

P.120.35.R08

R=0.8 (0.031)

835 mm	32.87 in	12.3 kg	
415 mm	16.34 in	6.1 kg	
795 mm	31.29 in	11.5 kg	FX
805 mm	31.69 in	11.5 kg	F

C45: 560-710 N/mm² — 700 kN/m max.

P.120.35.R15

R=1.5 (0.059)

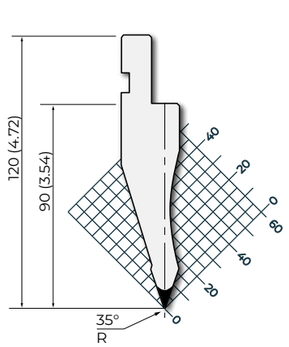
835 mm	32.87 in	12.5 kg	
415 mm	16.34 in	6.0 kg	
795 mm	31.29 in	12.0 kg	FX
805 mm	31.69 in	12.0 kg	F

C45: 560-710 N/mm² — 700 kN/m max.

P.120.35.R3

R=3.0 (0.118)

835 mm	32.87 in	13.0 kg	
415 mm	16.34 in	6.4 kg	
795 mm	31.29 in	12.0 kg	FX
805 mm	31.69 in	12.0 kg	F

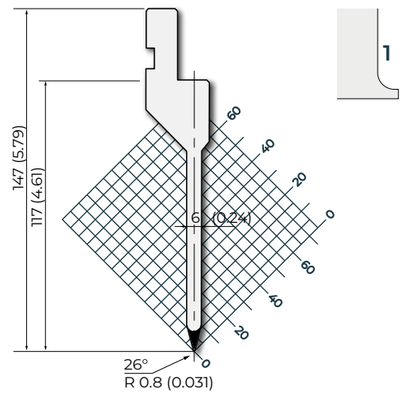


35°

42Cr: 900-1150 N/mm² — 500 kN/m max.

P.147.26.R08

835 mm	32.87 in	9.8 kg	
415 mm	16.34 in	4.9 kg	
795 mm	31.29 in	9.8 kg	FX
805 mm	31.69 in	9.8 kg	F



26°

C45: 560-710 N/mm² — 1000 kN/m max.

PU.117.26.R08

H=117.00 / A=147.00 / R=0.8 [mm]
(H=4.61 / A=5.79 / R=0.031) [in]

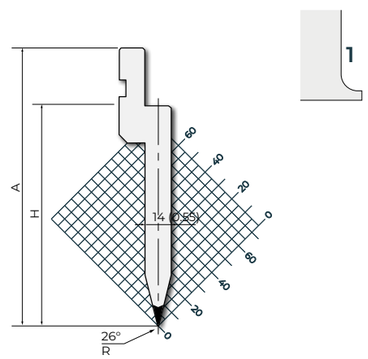
835 mm	32.87 in	13.5 kg	
415 mm	16.34 in	6.5 kg	
795 mm	31.29 in	12.6 kg	FX
805 mm	31.69 in	12.6 kg	F

C45: 560-710 N/mm² — 1000 kN/m max.

PU.117.26.R3

H=109.00 / A=139.00 / R=3.0 [mm]
(H=4.29 / A=5.47 / R=0.118) [in]

835 mm	32.87 in	13.5 kg	
415 mm	16.34 in	6.7 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.5 kg	F



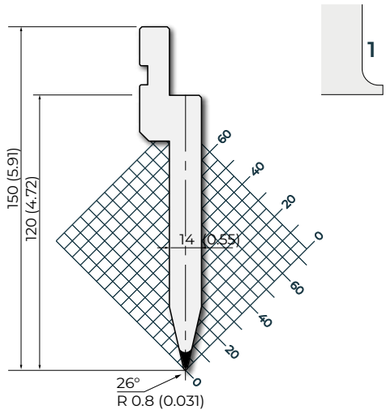
26°

Punches - R1 CLASSIC Series

C45: 560-710 N/mm² — 1000 kN/m max.

PU.150.26.R08.L

900 mm	35.43 in	15.0 kg	
415 mm	16.34 in	6.2 kg	
795 mm	31.29 in	12.0 kg	FX
805 mm	31.69 in	12.0 kg	F



26°

Punches - R1 A Series

C45: 560-710 N/mm² — 1000 kN/m max.

00402

H=66.90 / A=96.90 / R=0.2 / 88° [mm]
(H=2.63 / A=3.81 / R=0.008) [in]

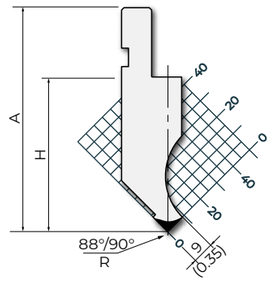
835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
800 mm	31.50 in	10.5 kg	F

C45: 560-710 N/mm² — 1000 kN/m max.

01602

H=66.92 / A=96.92 / R=0.2 / 90° [mm]
(H=2.63 / A=3.81 / R=0.118) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
800 mm	31.50 in	10.5 kg	F



88° - 90°

C45: 560-710 N/mm² — 1000 kN/m max.

00430

H=65.68 / A=95.68 / R=3 / 88° [mm]
(H=2.59 / A=3.77 / R=0.118) [in]

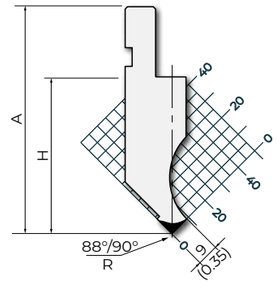
835 mm	32.87 in	11.1 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
800 mm	31.50 in	10.5 kg	FC

C45: 560-710 N/mm² — 1000 kN/m max.

01630

H=65.60 / A=95.60 / R=3 / 90° [mm]
(H=2.58 / A=3.76 / R=0.008) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
800 mm	31.50 in	10.5 kg	FC



88° - 90°

C45: 560-710 N/mm² — 200 kN/m max.

11700

H=66.91 / A=96.91 / 88° [mm]
(H=2.63 / A=3.81) [in]

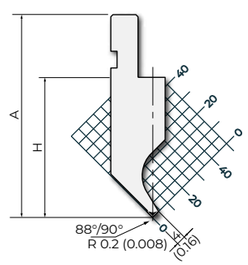
835 mm	32.87 in	10.7 kg	
415 mm	16.34 in	5.3 kg	
795 mm	31.29 in	10.3 kg	FX
800 mm	31.50 in	10.2 kg	FC

C45: 560-710 N/mm² — 200 kN/m max.

11600

H=66.90 / A=96.90 / 90° [mm]
(H=2.63 / A=3.81) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.1 kg	FX
800 mm	31.50 in	11.0 kg	FC



88° - 90°

C45: 560-710 N/mm² — 500 kN/m max.

04502

H=104.91 / A=134.91 / 88° [mm]
(H=4.13 / A=5.31) [in]

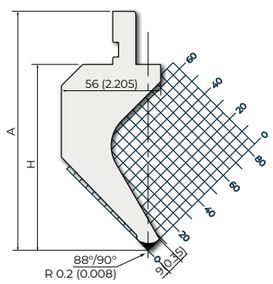
835 mm	32.87 in	22.0 kg	
415 mm	16.34 in	10.9 kg	
795 mm	31.29 in	22.0 kg	FX
800 mm	31.50 in	22.0 kg	FC

C45: 560-710 N/mm² — 500 kN/m max.

04600

H=104.91 / A=134.91 / 90° [mm]
(H=4.13 / A=5.31) [in]

835 mm	32.87 in	22.0 kg	
415 mm	16.34 in	11.0 kg	
795 mm	31.29 in	21.0 kg	FX
800 mm	31.50 in	21.3 kg	FC



88° - 90°

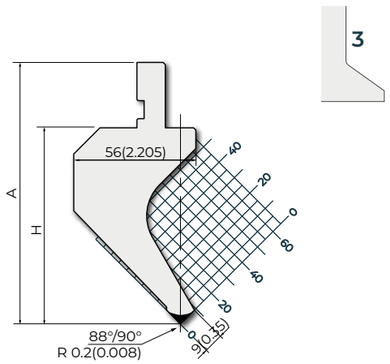
Punches - R1 A Series

42Cr: 900-1150 N/mm²	700 kN/m max.		
45202			
H=89.91 / A=119.91 / 88° [mm] (H=3.54 / A=4.72) [in]			
835 mm	32.87 in	19.6 kg	
415 mm	16.34 in	9.7 kg	
795 mm	31.29 in	18.9 kg	FX
800 mm	31.50 in	18.9 kg	FC

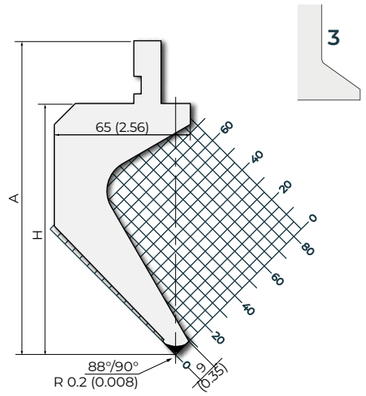
42Cr: 900-1150 N/mm²	700 kN/m max.		
46200			
H=89.91 / A=119.91 / 90° [mm] (H=3.54 / A=4.72) [in]			
835 mm	32.87 in	19.6 kg	
415 mm	16.34 in	9.8 kg	
795 mm	31.29 in	18.7 kg	FX
800 mm	31.50 in	18.9 kg	FC

42Cr: 900-1150 N/mm²	500 kN/m max.		
04702			
H=120.00 / A=150.00 / 88° [mm] (H=4.72 / A=5.90) [in]			
835 mm	32.87 in	25.8 kg	
415 mm	16.34 in	12.9 kg	
795 mm	31.29 in	24.6 kg	FX
800 mm	31.50 in	24.9 kg	FC

42Cr: 900-1150 N/mm²	500 kN/m max.		
04800			
H=120.00 / A=150.00 / 90° [mm] (H=4.72 / A=5.90) [in]			
835 mm	32.87 in	25.9 kg	
415 mm	16.34 in	12.9 kg	
795 mm	31.29 in	24.6 kg	FX
800 mm	31.50 in	24.9 kg	FC



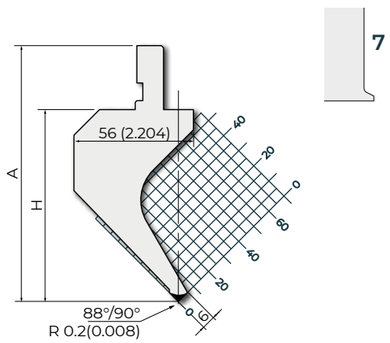
88° - 90°



88° - 90°

42Cr: 900-1150 N/mm²	500 kN/m max.		
45302			
H=89.91 / A=119.91 / 88° [mm] (H=3.54 / A=4.72) [in]			
835 mm	32.87 in	18.6 kg	
415 mm	16.34 in	9.3 kg	
795 mm	31.29 in	17.7 kg	FX
800 mm	31.50 in	17.9 kg	FC

42Cr: 900-1150 N/mm²	500 kN/m max.		
46300			
H=89.91 / A=119.91 / 88° [mm] (H=3.54 / A=4.72) [in]			
835 mm	32.87 in	18.6 kg	
415 mm	16.34 in	9.3 kg	
795 mm	31.29 in	17.7 kg	FX
800 mm	31.50 in	17.9 kg	FC



88° - 90°

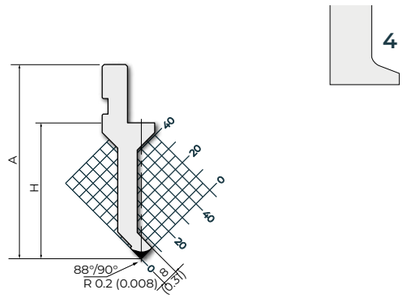
Punches - R1 A Series

42Cr: 900-1150 N/mm²	300 kN/m max.		
20000			
H=69.91 / A=99.91 / 88° [mm] (H=2.75 / A=3.93) [in]			
835 mm	32.87 in	7.9 kg	
415 mm	16.34 in	3.9 kg	
795 mm	31.29 in	7.5 kg	FX
800 mm	31.50 in	7.5 kg	FC

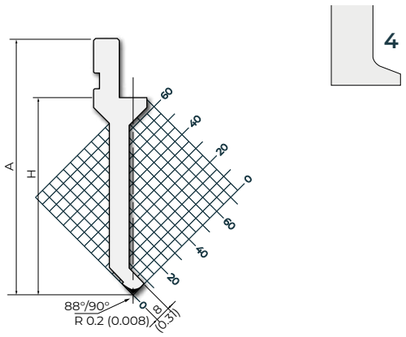
42Cr: 900-1150 N/mm²	300 kN/m max.		
20100			
H=69.91 / A=99.91 / 90° [mm] (H=2.75 / A=3.93) [in]			
835 mm	32.87 in	7.9 kg	
415 mm	16.34 in	3.9 kg	
795 mm	31.29 in	7.6 kg	FX
800 mm	31.50 in	7.7 kg	FC

42Cr: 900-1150 N/mm²	300 kN/m max.		
20200			
H=99.91 / A=129.91 / 88° [mm] (H=3.93 / A=5.11) [in]			
835 mm	32.87 in	10.0 kg	
415 mm	16.34 in	5.0 kg	
795 mm	31.29 in	9.5 kg	FX
800 mm	31.50 in	9.6 kg	FC

42Cr: 900-1150 N/mm²	300 kN/m max.		
20300			
H=99.91 / A=129.91 / 90° [mm] (H=3.93 / A=5.11) [in]			
835 mm	32.87 in	10.0 kg	
415 mm	16.34 in	5.0 kg	
795 mm	31.29 in	9.5 kg	FX
800 mm	31.50 in	9.6 kg	FC



88° - 90°



88° - 90°

Segmented · On stock · Ask for delivery time

Punches - R1 A Series

C45: 560-710 N/mm² — 1000 kN/m max.

00480

H=66.91 / A=96.91 / R=0.2 88° [mm]
(H=2.63 / A=3.82 / R=0.008) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
800 mm	31.50 in	10.5 kg	FC

C45: 560-710 N/mm² — 400 kN/m max.

01680

H=66.91 / A=96.91 / 90° [mm]
(H=2.63 / A=3.82 / R=0.008) [in]

835 mm	32.87 in	10.7 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.2 kg	FX
800 mm	31.50 in	10.3 kg	FC

C45: 560-710 N/mm² — 800 kN/m max.

00490

H=94.91 / A=124.91 / R=0.2 [mm]
(H=3.74 / A=4.92 / R=0.008) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
800 mm	31.50 in	10.6 kg	FC

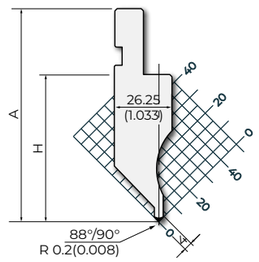
C45: 560-710 N/mm² — 800 kN/m max.

01690

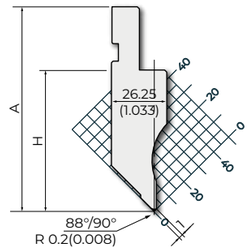
H=94.74 / A=124.74 / R=0.2 [mm]
(H=3.73 / A=4.91 / R=0.008) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
800 mm	31.50 in	10.6 kg	FC

3



3



88° - 90°

88° - 90°

42Cr: 900-1150 N/mm² — 500 kN/m max.

10900

H=94.91 / A=124.91 / R=0.2 88° [mm]
(H=3.74 / A=4.92 / R=0.008) [in]

835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm	31.29 in	8.5 kg	FX
800 mm	31.50 in	8.6 kg	FC

42Cr: 900-1150 N/mm² — 500 kN/m max.

10906

H=94.74 / A=124.74 / R=0.6 / 88° [mm]
(H=3.73 / A=4.91 / R=0.024) [in]

835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm	31.29 in	8.5 kg	FX
800 mm	31.50 in	8.6 kg	FC

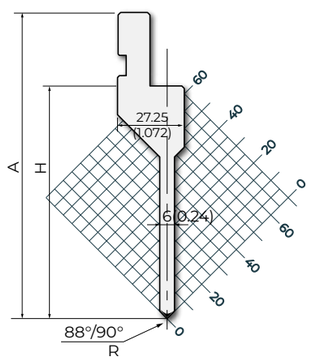
42Cr: 900-1150 N/mm² — 500 kN/m max.

10800

H=94.91 / A=124.91 / R=0.2 / 90° [mm]
(H=3.74 / A=4.92 / R=0.008) [in]

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	8.5 kg	FX
800 mm	31.50 in	8.6 kg	FC

4



88° - 90°

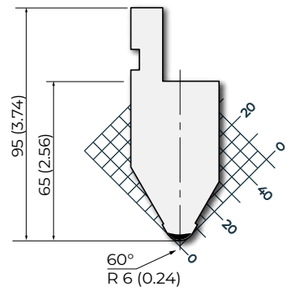
Punches - R1 A Series

C45: 560-710 N/mm² — 1000 kN/m max.

00300

835 mm	32.87 in	15.0 kg	
415 mm	16.34 in	7.5 kg	
795 mm	31.29 in	14.4 kg	FX
800 mm	31.50 in	14.4 kg	FC

6



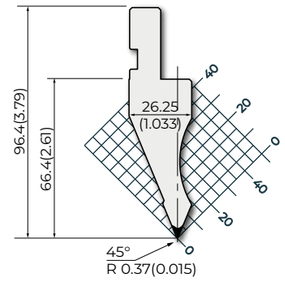
60°

C45: 560-710 N/mm² — 600 kN/m max.

00800

835 mm	32.87 in	9.3 kg	
415 mm	16.34 in	4.6 kg	
795 mm	31.29 in	9.3 kg	FX
800 mm	31.50 in	9.3 kg	FC

5



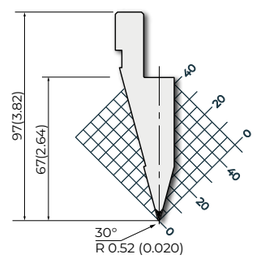
45°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

10300

835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.4 kg	FX
800 mm	31.50 in	10.5 kg	FC

5



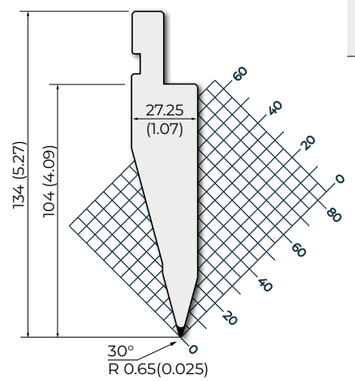
30°

C45: 560-710 N/mm² — 1000 kN/m max.

21000

835 mm	32.87 in	15.3 kg	
415 mm	16.34 in	7.6 kg	
795 mm	31.29 in	14.5 kg	FX
800 mm	31.50 in	14.6 kg	FC

5



30°

Segmented

On stock

Ask for delivery time

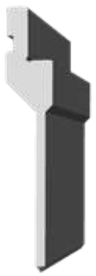
Punches - R1 AFH Series

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

STANDARD

GOOSENECK

SASH



NARROW

ACUTE

Punches - R1 AFH Series

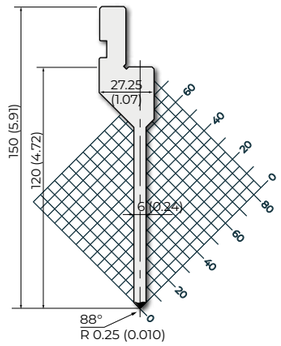
42Cr: 900-1150 N/mm² — 500 kN/m max.

AFH.150.88.R025

900 mm	35.43 in	10.6 kg	
415 mm	16.34 in	5.3 kg	
795 mm	31.29 in	10.1 kg	FX
805 mm	31.69 in	10.2 kg	F

Also available H=85

NEW



88°

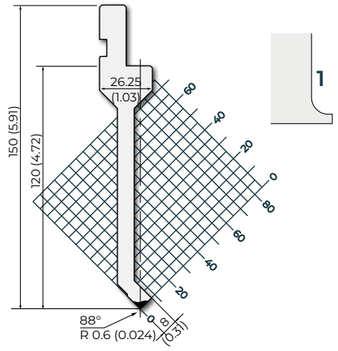
42Cr: 900-1150 N/mm² — 350 kN/m max.

AFH.150.88.R06

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

Also available H=85

NEW



88°

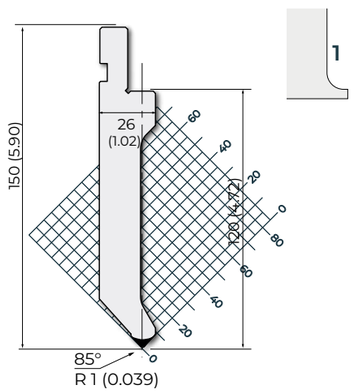
C45: 560-710 N/mm² — 700 kN/m max.

AFH.150.85.R1

835 mm	32.87 in	17.5 kg	
415 mm	16.34 in	8.7 kg	
795 mm	31.29 in	16.6 kg	FX
805 mm	31.69 in	16.9 kg	F

Also available H=85

NEW



85°

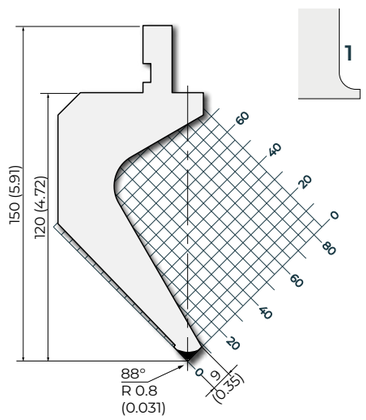
42Cr: 900-1150 N/mm² — 500 kN/m max.

AFH.150.88.R08

835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	20.5 kg	FX
800 mm	31.50 in	20.5 kg	FC

Also available H=85

NEW



88°

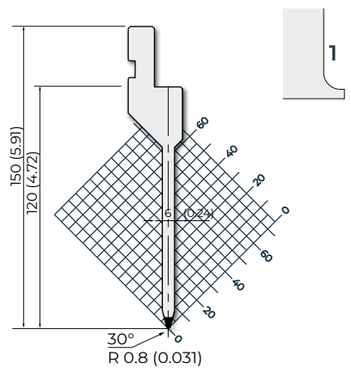
42Cr: 900-1150 N/mm² — 500 kN/m max.

AFH.150.30.R08

900 mm	35.43 in	10.8 kg	
415 mm	16.34 in	4.9 kg	
795 mm	31.29 in	9.5 kg	FX
805 mm	31.69 in	9.6 kg	F

Also available H=85

NEW



30°

Segmented · On stock · Ask for delivery time

Mobile Horns - R1

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

88°	85°	70°	60°	26°
P97.88.R06	TOP.175.85.R08	P.160.70.R08	P.135.60.R08	PU.117.26.R08
P97.88.R08	TOP.205.85.R08		P.145.60.R08	TOP.205.26.R08
P.130.88.R08			TOP.175.60.R08	TOP.175.26.R08
P.150.88.R08				

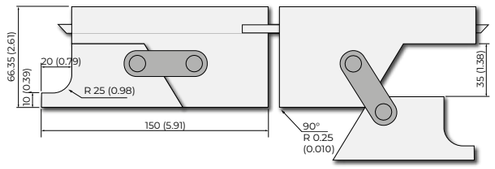
C45: 560-710 N/mm²

150 kN/m max.

SCA.M.90.R08

per pair | 3.5 kg

1 Pair left/right compatible with PK.97.90.R08



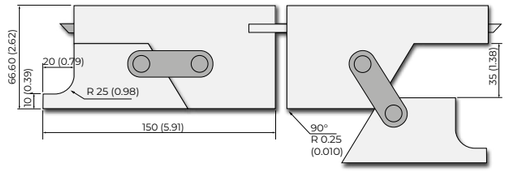
C45: 560-710 N/mm²

150 kN/m max.

SCA.M.90.R025

per pair | 3.5 kg

1 Pair left/right compatible with PK.97.90.R025



90°

90°

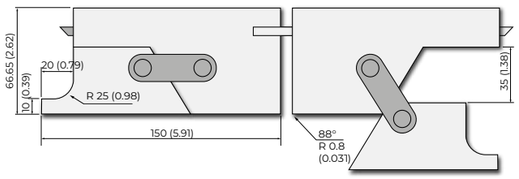
C45: 560-710 N/mm²

150 kN/m max.

SCA.M.88.R08

per pair | 3.5 kg

1 Pair left/right compatible with P.97.88.R08



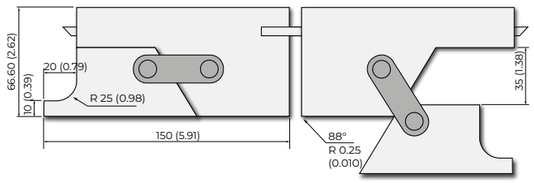
C45: 560-710 N/mm²

150 kN/m max.

SCA.M.88.R025

per pair | 3.5 kg

1 Pair left/right compatible with PK.97.88.R025



88°

88°

Punches for closed profiles - R1

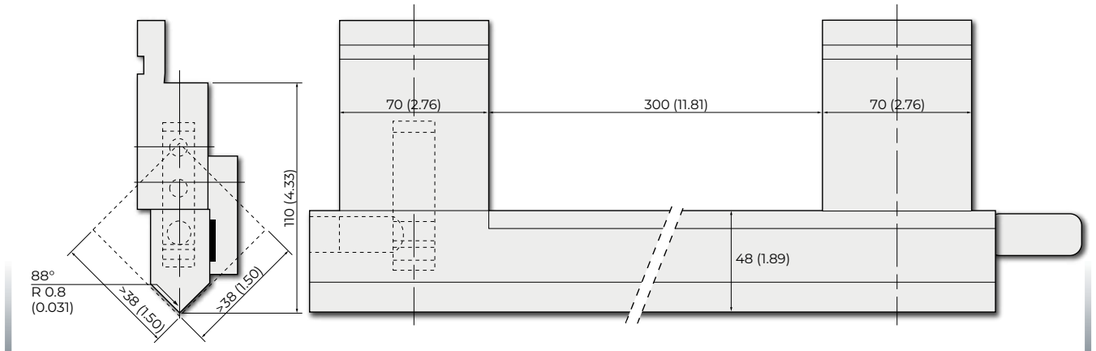
42Cr: 900-1150 N/mm²

150 kN/m max.

SPE.11

7.0 kg

Per piece



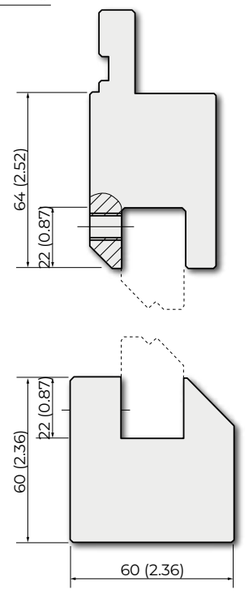
Joggle Tools - R1

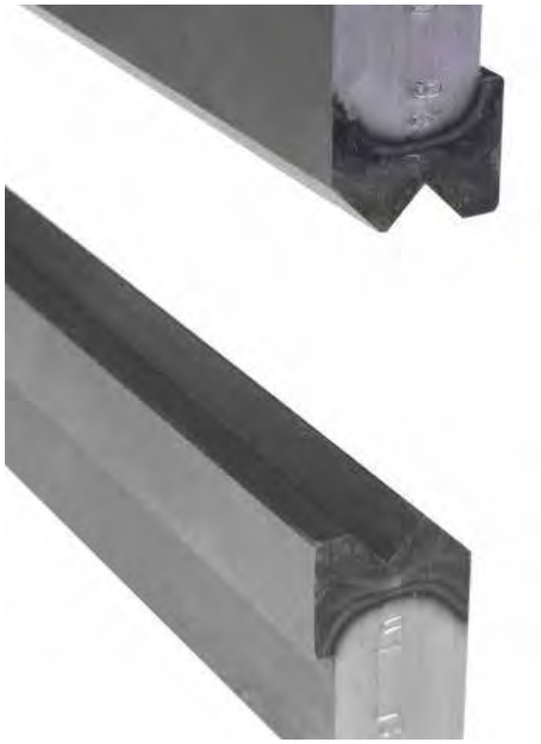
C45: 560-710 N/mm²

1000 kN/m max.

CPZ

835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.7 kg





C45: 560-710 N/mm²

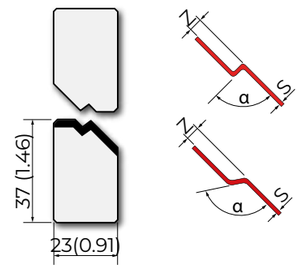
1000 kN/m max.

Joggle Tool Inserts

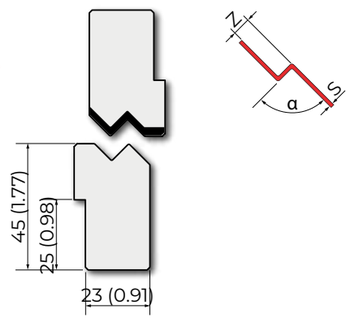
Model	Z [mm]	Z [in]	α	S* [mm]	S* [in]	Weight 835 mm / 32.87 in	Weight 415 mm / 16.34 in	
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg	A
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg	A
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg	A
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg	A
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg	A
CEZ 1.5/90	1.5	0.06	90°	0.3	0.01	11.0 kg	5.5 kg	A
CEZ 2.0/90	2.0	0.08	90°	0.4	0.02	11.0 kg	5.5 kg	A
CEZ 2.5/90	2.5	0.10	90°	0.5	0.02	11.0 kg	5.5 kg	A
CEZ 3.0	3.0	0.12	90°	1.0	0.04	10.3 kg	5.1 kg	A
CEZ 3.5	3.5	0.14	90°	1.0	0.04	10.0 kg	5.0 kg	A
CEZ 4.0	4.0	0.16	90°	1.2	0.05	10.0 kg	5.0 kg	A
CEZ 4.5	4.5	0.18	90°	1.2	0.05	10.0 kg	5.0 kg	A
CEZ 5.0	5.0	0.20	90°	1.3	0.05	10.0 kg	5.0 kg	A
CEZ 5.5	5.5	0.22	90°	1.4	0.06	10.0 kg	5.0 kg	A
CEZ 6.0	6.0	0.24	90°	1.5	0.06	10.0 kg	5.0 kg	A
CEZ 6.5	6.5	0.26	90°	1.5	0.06	10.0 kg	5.0 kg	A
CEZ 7.0	7.0	0.28	90°	1.5	0.06	10.0 kg	5.0 kg	A
CEZ 7.5	7.5	0.30	90°	1.6	0.06	10.0 kg	5.0 kg	A
CEZ 8.0	8.0	0.31	90°	1.6	0.06	10.0 kg	5.0 kg	A
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg	6.5 kg	B
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg	5.0 kg	B
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	5.0 kg	B
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	5.0 kg	B
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	5.0 kg	B
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	5.0 kg	B
CEZ 15.0	15	0.59	90°	2.3	0.09	13.5 kg	5.0 kg	B

* Fe Rmax = 420 N/mm²

A



B



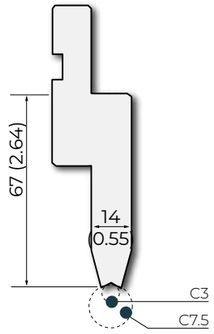
Radius Tools - R1

C45: 560-710 N/mm²

400 kN/m max.

PU.67.14-S

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



C45: 560-710 N/mm²

400 kN/m max.

C3 - C7.5

Model	R [mm]	R [in]	Weight 835 mm / 32.87 in	Weight 415 mm / 16.34 in
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

Segmented

On stock

Ask for delivery time

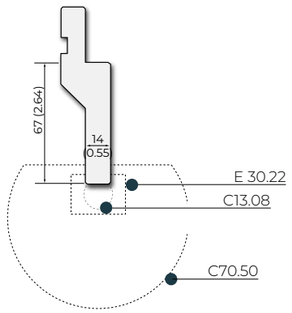
Radius Tools - R1

C45: 560-710 N/mm²

800 kN/m max.

PU.67.14

830 mm	32.68 in	9.0 kg
410 mm	16.14 in	5.0 kg

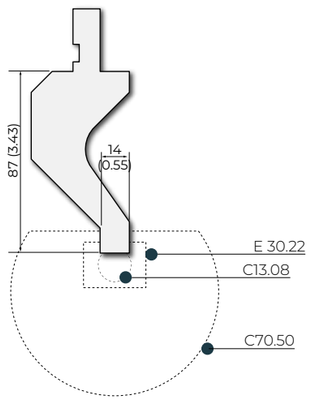


C45: 560-710 N/mm2

500 kN/m max.

PU.87.14

830 mm	32.68 in	9.0 kg
412 mm	16.22 in	4.5 kg

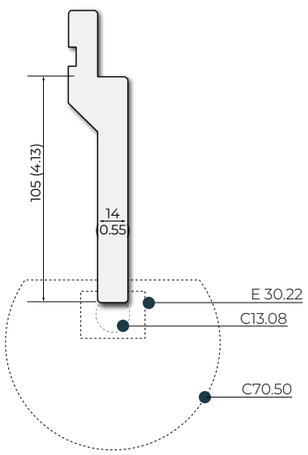


C45: 560-710 N/mm²

800 kN/m max.

PU.105.14

830 mm	32.68 in	12.0 kg
412 mm	16.22 in	6.0 kg



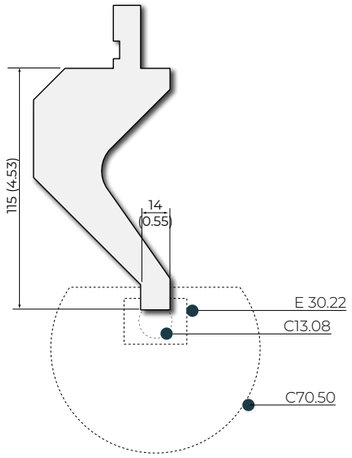
Radius Tools and Hemming tool - R1

C45: 560-710 N/mm²

500 kN/m max.

PU.115.14

830 mm	32.68 in	26.0 kg
412 mm	16.22 in	13.0 kg



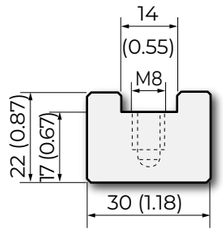
C45: 560-710 N/mm²

800 kN/m max.

E30.22

830 mm	32.68 in	3.5 kg
412 mm	16.22 in	1.7 kg

▸ Hemming tool

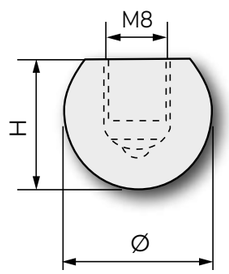


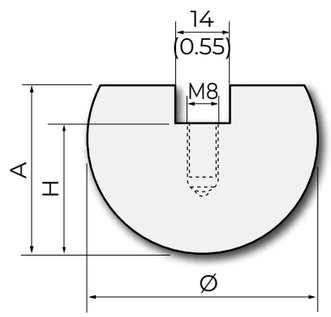
C45: 560-710 N/mm²

800 kN/m max.

Radius tools ø 16 - 100

Model	Z [mm]	Ø [in]	H [mm]	H [in]	A [mm]	A [in]		Weight		Weight
C13.08	16	0.63	13	0.51	-	-	835 mm / 32.87 in	2.0 kg	415 mm / 16.34 in	1.0 kg
C13.09	18	0.71	16	0.63	-	-		2.0 kg		1.0 kg
C16.10	20	0.79	16	0.63	-	-		2.0 kg		1.0 kg
C17.12	25	0.98	17	0.67	22	0.87		2.5 kg		1.2 kg
C20.15	30	1.18	20	0.79	27	1.06		3.7 kg		1.8 kg
C22.17	35	1.38	22	0.87	32	1.26		5.0 kg		2.4 kg
C24.20	40	1.57	24	0.94	34	1.33		7.0 kg		3.5 kg
C25.22	45	1.77	25	0.98	35	1.38		7.5 kg		3.8 kg
C29.25	50	1.97	29	1.14	39	1.53		10.0 kg		4.7 kg
C34.27	55	2.16	34	1.33	44	1.73		12.4 kg		6.2 kg
C34.30	60	2.36	34	1.33	44	1.73		13.5 kg		6.7 kg
C37.32	65	2.56	37	1.46	47	1.85		15.9 kg		7.9 kg
C45.35	70	2.75	45	1.77	55	2.16		20.3 kg		10.0 kg
C42.37	75	2.95	42	1.65	52	2.04		20.5 kg		10.3 kg
C45.40	80	3.15	45	1.77	55	2.16		23.0 kg		11.5 kg
C60.45	90	3.54	60	2.36	70	2.75		34.0 kg		17.0 kg
C70.50	100	3.93	70	2.75	80	3.15		43.5 kg		21.7 kg





DIES ROLLERI TYPE R1

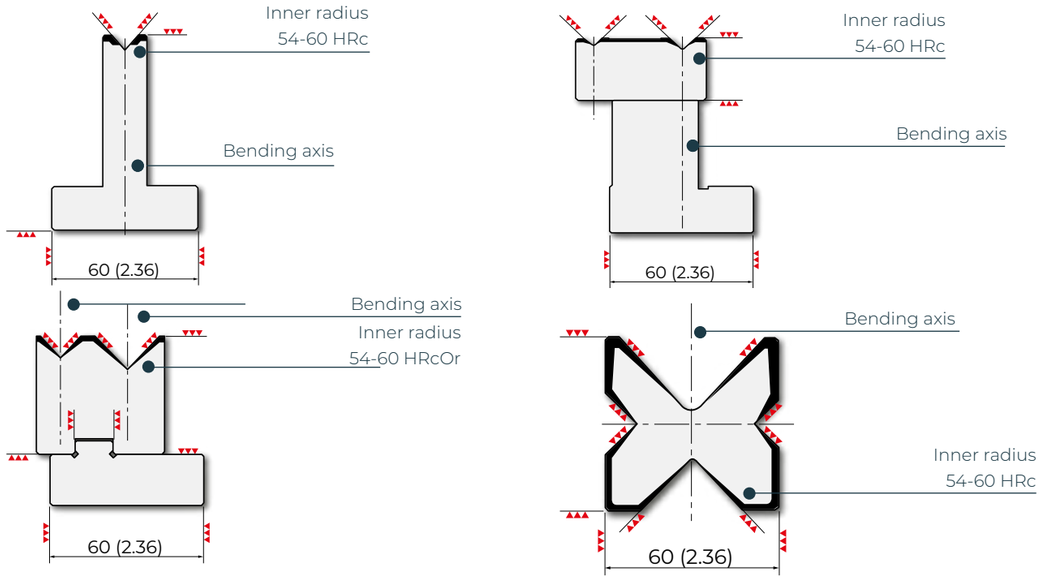
▼ **COMPATIBILITY**

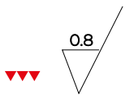
Accurl	Durmazlar	MVD
Accurpress	Ermaksan	Oriance
ACL	Farina	Prima Power
Adira	Gade	Promecam
Amada	Gasparini	Rico
Atlantic	Gecko	Salvagnini
Baykal	Gilardi	Schiavi
BL	Gizelis	SMD
Boschert	Haco	Sorg
Boutillon	Hindustan	Somo
Bystronic Beyeler	HPM	Vicla
Euro-B	Iturrospe	Vimercati
Coastone	Jfy	Warcom
Colgar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

Content explanation	57 - 58
R1 **CLASSIC** Series	
2-V dies and Holders	59 - 61
90°	59
88°	59
60°	60
35°	60
Holders	61
2-V Dies - Self centering and Holders	62 - 63
90°	62
88°	62 - 63
85°	63
30°	63
Holders and Retainer	63
1-V Dies - Self centering and Holders	64 - 65
88°	64
85°	64
30°	65
Holders	65
T-Dies	66 - 74
90°	66
88°	67
85°	68
80°	69
60°	70
45°	71
35°	72
30°	73
26°	74
1-V Dies	75 - 76
85°	75
80°	75 - 76
70°	76
60°	76
45°	76
Multi-V Dies and Holders	70 - 71
Multi-V Dies	70 - 71
Holder	71
R1 **A** Series	
2-V dies	72 - 73
90°	72
88°	72 - 73
Self centering 2-V Dies and Holder	74 - 76
90°	74
88°	75 - 76
Holder	76
Self centering 1-V Dies and Holders	77 - 78
90°, H=30 mm	77
88°, H=30 mm	77
90°, H=60 mm	78
88°, H=60 mm	78
Holders	78
1-V Dies	79 - 80
85°	79
45°	79
30°	79 - 80
Hemming Tools	81
Spring-loaded Hemming Dies	82 - 83
Pneumatic Hemming Dies	84 - 85

STANDARD TANG

All dies R1 have base 60 mm, 90 mm or 120 mm.



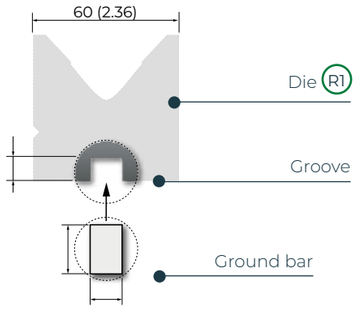


MODIFICATIONS WEDGE/BAR TAIL

To use R1 dies, a 10 mm (0.39 in) groove is milled where a ground bar is mounted.

Wedge Bar / Tail (W x H)	System
13 x 30 mm	R2 R3 Bystronic-Beyeler,Safan,Trumpf,etc.
55 x 55 mm	RX EHT
12.7 x 29 mm	R4
35 x 55 mm	RX Weinbrenner

Mounting example



STANDARD LENGTH

- **TOP**

525 mm (20.67 in)

- **CLASSIC · A**

415 mm (16.34 in)

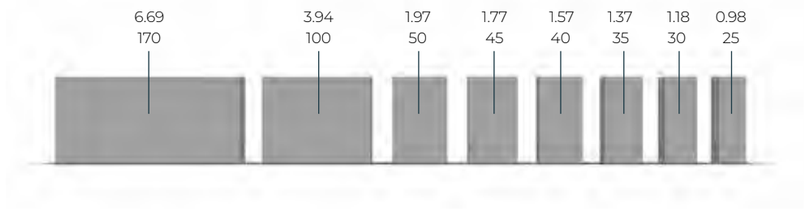
835 mm (32.87 in)

900 mm (35.43 in)

SEGMENTATION

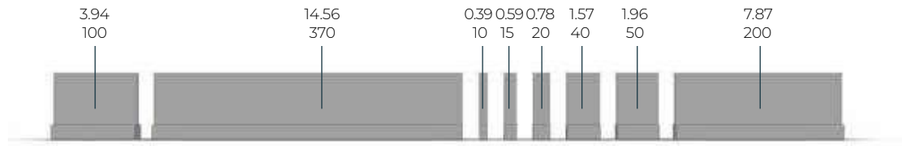
- **TOP**

FC: 495 mm (19.49 in)- 8 segments

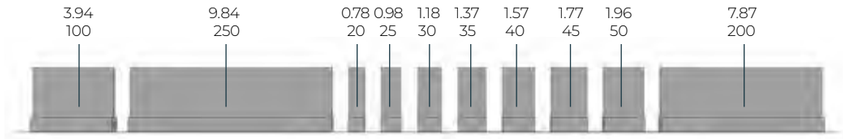


- **CLASSIC · A**

F: 805 mm (31.69 in) - 8 segments



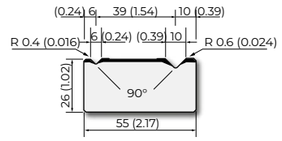
FX: 795 mm (31.29 in) - 10 segments



C45: 560-710 N/mm² — 1000 kN/m max.

M26.90.01

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

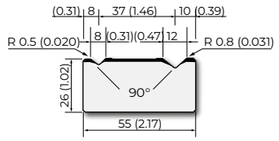


90° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M26.90.02

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

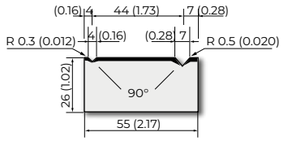


90° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M26.90.03

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

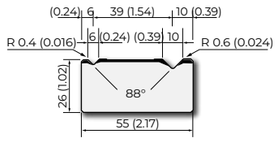


90° ((·))

C45: 560-710 N/mm² — 1000 kN/m max.

M26.88.01

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

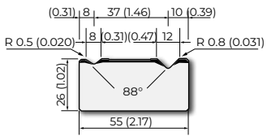


88° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M26.88.02

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

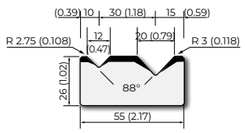


88° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M26.88.03

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

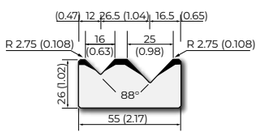


88° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M26.88.04

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

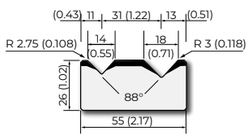


88° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M26.88.05

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



88° ✓

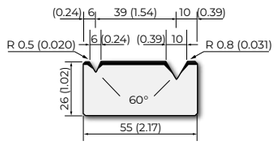
2-V Dies and Holders - R1 CLASSIC Series

R1

C45: 560-710 N/mm² — 600 kN/m max.

M26.60.01

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

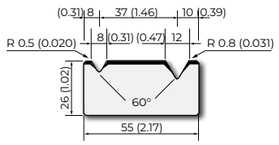


60° ✓

C45: 560-710 N/mm² — 800 kN/m max.

M26.60.02

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

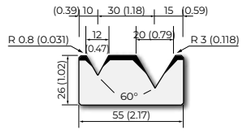


60° ✓

C45: 560-710 N/mm² — 800 kN/m max.

M26.60.03

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

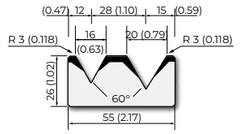


60° ✓

C45: 560-710 N/mm² — 800 kN/m max.

M26.60.05

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

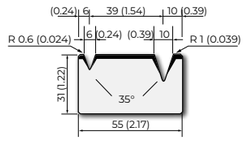


60° ✓

C45: 560-710 N/mm² — 300 kN/m max.

M31.35.01

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

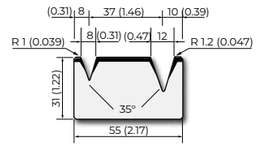


35° ✓

C45: 560-710 N/mm² — 300 kN/m max.

M31.35.02

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

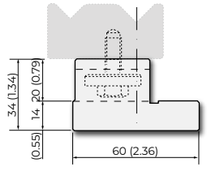


35° ✓

C45: 560-710 N/mm²

SU034

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

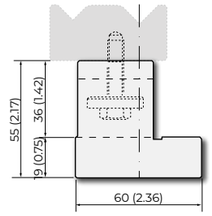


Holder ✓

C45: 560-710 N/mm²

SU055

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

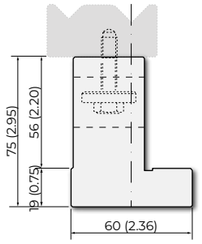


Holder ✓

C45: 560-710 N/mm²

SU075

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

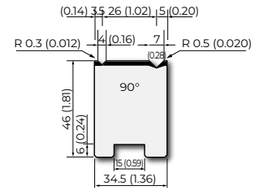


Holder ✓

C45: 560-710 N/mm² — 800 kN/m max.

46-10

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

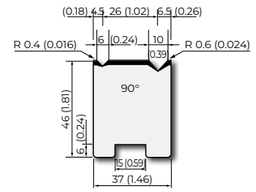


90° ✓

C45: 560-710 N/mm² — 800 kN/m max.

46-11

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

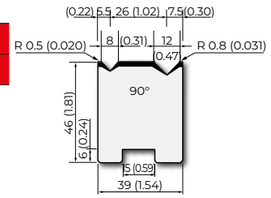


90° ✓

C45: 560-710 N/mm² — 800 kN/m max.

46-12

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

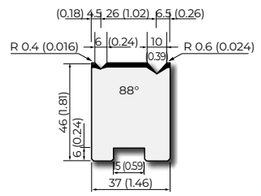


90° ✓

C45: 560-710 N/mm² — 800 kN/m max.

46.11.88

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

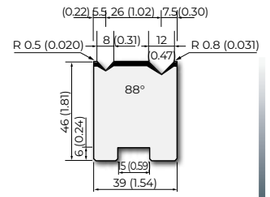


88° ✓

C45: 560-710 N/mm² — 800 kN/m max.

46.13

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

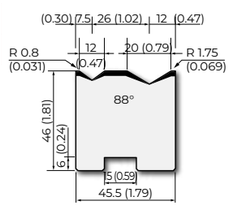


88° ✓

C45: 560-710 N/mm² — 800 kN/m max.

46.14

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

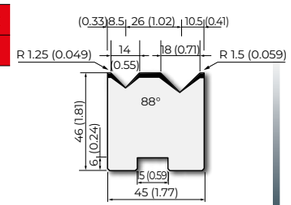


88° ✓

C45: 560-710 N/mm² — 800 kN/m max.

46.15

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



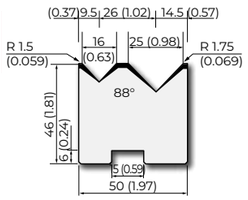
88° ✓

2-V Dies - Self centering and Holders - R1 CLASSIC Series

C45: 560-710 N/mm² — 800 kN/m max.

46.16

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

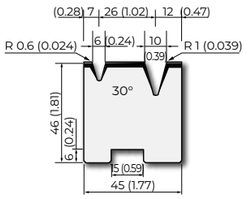


88°

C45: 560-710 N/mm² — 400 kN/m max.

46.17

835 mm	32.87 in	12.2 kg	
415 mm	16.34 in	6.0 kg	
795 mm	31.29 in	12.2 kg	FX
805 mm	31.69 in	12.2 kg	F

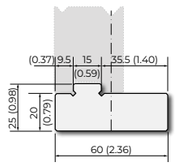


30°

C45: 560-710 N/mm² — 1000 kN/m max.

PM60

835 mm	32.97 in	7.5 kg
415 mm	16.34 in	3.7 kg

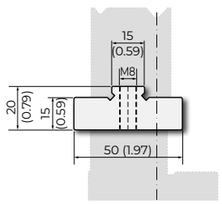


Holder

C45: 560-710 N/mm² — 1000 kN/m max.

PM50.20

835 mm	32.97 in	5.4 kg
415 mm	16.34 in	2.6 kg



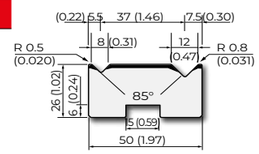
Holder

42Cr: 900-1150 N/mm² — 1000 kN/m max.

M26.85.02

835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm	31.29 in	8.6 kg	FX
805 mm	31.69 in	8.7 kg	F

PM50 + Support is needed

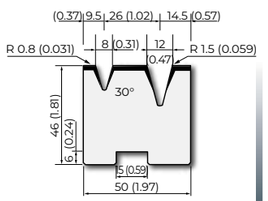


85°

C45: 560-710 N/mm² — 400 kN/m max.

46.18

835 mm	32.87 in	13.2 kg	
415 mm	16.34 in	6.6 kg	
795 mm	31.29 in	13.0 kg	FX
805 mm	31.69 in	13.0 kg	F

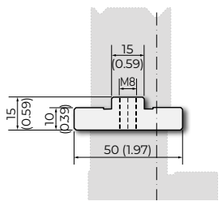


30°

C45: 560-710 N/mm² — 1000 kN/m max.

PM50

835 mm	32.97 in	4.0 kg
415 mm	16.34 in	3.7 kg

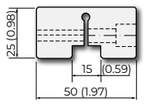


Holder

Fe37

PB60

pair	0.2 kg



Retainer

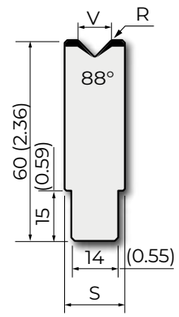
1-V Dies - Self centering and Holder - R1 CLASSIC Series

R1

C45: 560-710 N/mm² — 1000 kN/m max.

H=60 mm / 2.36 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX	795 mm / 31.30 in	Weight	F	805 mm / 31.69 in	Weight
AMR60.04.88	4	0.16	0.6	0.02	14	0.55		5.4 kg		2.7 kg			5.1 kg			5.2 kg
AMR60.06.88	6	0.24	0.8	0.03	14	0.55		5.4 kg		2.7 kg			5.2 kg			5.2 kg
AMR60.08.88	8	0.31	1.0	0.04	14	0.55		5.4 kg		2.7 kg			5.2 kg			5.2 kg
AMR60.10.88	10	0.39	1.2	0.04	18	0.71		5.6 kg		2.8 kg			5.4 kg			5.4 kg
AMR60.12.88	12	0.47	1.5	0.06	18	0.71		6.1 kg		3.0 kg			5.8 kg			5.9 kg
AMR60.16.88	16	0.63	2.0	0.08	24	0.94		7.1 kg		3.5 kg			6.8 kg			6.9 kg
AMR60.20.88	20	0.79	2.0	0.08	30	1.18		8.0 kg		4.0 kg			7.8 kg			7.8 kg
AMR60.25.88	25	0.98	3.0	0.12	35	1.38		9.1 kg		4.6 kg			8.9 kg			8.9 kg

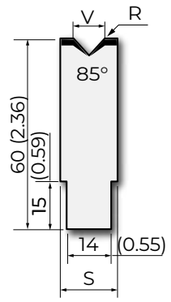


88°

C45: 560-710 N/mm² — 1000 kN/m max.

H=60 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX	795 mm / 31.30 in	Weight	F	805 mm / 31.69 in	Weight
AMR60.04.85	4	0.16	0.6	0.02	14	0.55		5.4 kg		2.7 kg			5.2 kg			5.2 kg
AMR60.06.85	6	0.24	0.8	0.03	14	0.55		5.4 kg		2.7 kg			5.1 kg			5.2 kg
AMR60.08.85	8	0.31	1.0	0.04	14	0.55		5.4 kg		2.7 kg			5.1 kg			5.2 kg
AMR60.10.85	10	0.39	1.2	0.04	18	0.71		5.6 kg		2.8 kg			5.3 kg			5.4 kg
AMR60.12.85	12	0.47	1.5	0.06	18	0.71		6.1 kg		3.0 kg			5.8 kg			5.9 kg
AMR60.16.85	16	0.63	2.0	0.08	24	0.94		7.1 kg		3.5 kg			6.8 kg			6.9 kg
AMR60.20.85	20	0.79	2.0	0.08	30	1.18		8.0 kg		4.0 kg			7.6 kg			7.7 kg
AMR60.25.85	25	0.98	3.0	0.12	35	1.38		9.2 kg		4.6 kg			8.8 kg			8.9 kg



85°

Segmented — On stock — Ask for delivery time

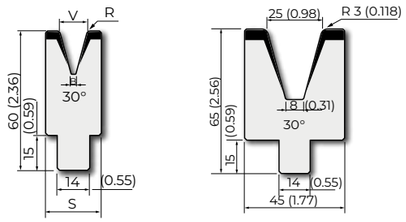
1-V Dies - Self centering and Holder - R1 CLASSIC Series

C45: 560-710 N/mm²

1000 kN/m max.

H=60-65 mm / 2.36-2.56 in

Model	V [mm]	V [in]	R [mm]	R [in]	B [mm]	B [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
AMR60.06.30	6	0.24	0.6	0.02	-	-	14	0.55		5.9 kg		2.9 kg		5.6 kg		5.7 kg
AMR60.08.30	8	0.31	0.8	0.03	2	0.08	18	0.70		6.6 kg		3.3 kg		6.3 kg		6.4 kg
AMR60.10.30	10	0.39	1.0	0.04	2	0.08	24	0.94		7.8 kg		3.9 kg		7.4 kg		7.5 kg
AMR60.12.30	12	0.47	1.5	0.04	2	0.08	24	0.94		7.9 kg		3.9 kg		7.5 kg		7.6 kg
AMR60.16.30	16	0.63	2.0	0.06	5	0.19	30	1.18		8.8 kg		4.7 kg		8.4 kg		9.2 kg
AMR60.20.30	20	0.79	2.5	0.08	5	0.19	35	1.38		15.9 kg		7.9 kg		15.3 kg		15.3 kg
AMR65.25.30	25	0.98	3.0	0.12	8	0.31	45	1.78		13.0 kg		6.3 kg		12.4 kg		12.2 kg



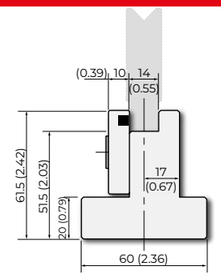
30°

C45: 560-710 N/mm²

1000 kN/m max.

SU61F

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



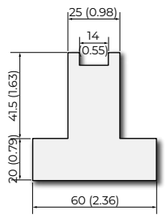
Holder

C45: 560-710 N/mm²

950 kN/m max.

08000

1050 mm	41.34 in	14.0 kg



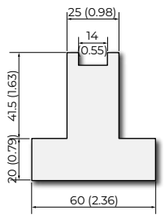
Holder

C45: 560-710 N/mm²

950 kN/m max.

08100

1260 mm	49.61 in	14.0 kg



Holder

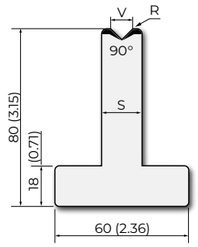
T - Dies - R1 CLASSIC Series

C45: 560-710 N/mm²

1000 kN/m max.

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm/ 31.30 in	Weight	F 805 mm/ 31.69 in	Weight	900 mm / 35.43 in	Weight
T80.06.90	6	0.24	0.4	0.01	14	0.55		13.0 kg		6.5 kg		13.0 kg		13.0 kg		14.0 kg
T80.08.90	8	0.31	0.5	0.02	14	0.55		13.0 kg		6.5 kg		13.0 kg		13.0 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		
T80.12.90	12	0.47	0.8	0.03	18	0.71		15.0 kg		7.5kg		15.0 kg		15.0 kg		



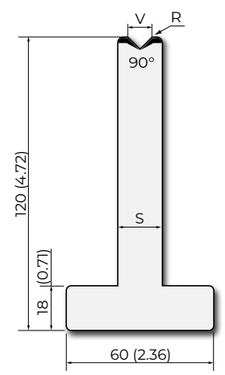
90°

C45: 560-710 N/mm²

1000 kN/m max.

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm/ 31.30 in	Weight	F 805 mm/ 31.69 in	Weight
T120.06.90	6	0.24	0.4	0.01	14	0.55		16.0 kg		8.0 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		16.0 kg		16.0 kg
T120.10.90	10	0.39	0.6	0.02	18	0.71		19.0 kg		9.0 kg		18.1 kg		18.3 kg
T120.12.90	12	0.47	0.8	0.03	18	0.71		18.0 kg		9.0 kg		18.1 kg		18.3 kg



90°

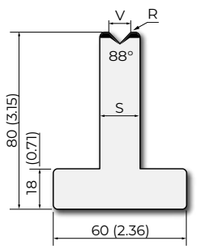
T - Dies - R1 CLASSIC Series

C45: 560-710 N/mm²

1000 kN/m max.

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]		Weight		Weight	FX	Weight	F	Weight
T80.06.88	6	0.24	0.4	0.01	14	0.55	835 mm / 32.87 in	13.0 kg	415 mm / 16.34 in	6.5 kg	795 mm / 31.30 in	12.4 kg	805 mm / 31.69 in	12.5 kg
TR80.06.88	6	0.24	2.75	0.11	14	0.55		13.0 kg		6.5 kg		12.4 kg		12.5 kg
T80.08.88	8	0.31	0.5	0.02	14	0.55		12.6 kg		6.3 kg		12.0 kg		12.1 kg
TR80.08.88	8	0.31	2.75	0.11	14	0.55		13.0 kg		6.5kg		13.0 kg		13.0 kg
T80.10.88	10	0.39	0.8	0.03	18	0.71		14.2 kg		7.0 kg		13.7 kg		13.7 kg
TR80.10.88	10	0.39	2.75	0.11	18	0.71		15.0 kg		7.5 kg		15.0 kg		15.0 kg
T80.12.88	12	0.47	2.75	0.11	18	0.71		14.0 kg		7.0 kg		13.3 kg		13.5 kg
T80.16.88	16	0.63	2.75	0.11	24	0.94		16.6 kg		8.3 kg		16.0 kg		16.0 kg
T80.20.88	20	0.79	3.0	0.12	30	1.18		18.5 kg		9.2 kg		17.8 kg		17.8 kg
T80.25.88	25	0.98	3.0	0.12	35	1.38		20.2 kg		10.0 kg		19.5 kg		19.5 kg



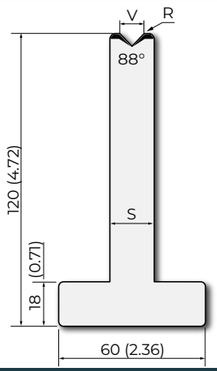
88°

C45: 560-710 N/mm²

1000 kN/m max.

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]		Weight		Weight	FX	Weight	F	Weight
T120.06.88	6	0.24	0.4	0.01	14	0.55	835 mm / 32.87 in	16.5 kg	415 mm / 16.34 in	8.0 kg	795 mm / 31.30 in	16.0 kg	805 mm / 31.69 in	16.0 kg
TR120.06.88	6	0.24	2.75	0.11	14	0.55		16.0 kg		8.0 kg		15.2 kg		16.0 kg
T120.08.88	8	0.31	0.5	0.02	14	0.55		16.0 kg		8.0 kg		16.0 kg		16.0 kg
TR120.08.88	8	0.31	2.75	0.11	14	0.55		16.0 kg		8.0 kg		15.2 kg		16.0 kg
T120.10.88	10	0.39	0.8	0.03	18	0.71		19.0 kg		9.5 kg		19.0 kg		19.0 kg
TR120.10.88	10	0.39	2.75	0.11	18	0.71		18.0 kg		9.0 kg		18.0 kg		18.0 kg
T120.12.88	12	0.47	2.75	0.11	18	0.71		19.0 kg		9.0 kg		18.0 kg		18.0 kg
T120.16.88	16	0.63	2.75	0.11	24	0.94		22.0 kg		11.0 kg		22.0 kg		22.0 kg
T120.20.88	20	0.79	3.0	0.12	30	1.18		27.0 kg		13.5 kg		25.7 kg		26.0 kg
T120.25.88	25	0.98	3.0	0.12	35	1.38		30.0 kg		15.0 kg		30.0 kg		30.0 kg



88°

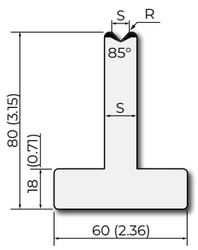
T - Dies - R1 CLASSIC Series

C45: 560-710 N/mm²

1000 kN/m max.

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]		Weight		Weight	FX	Weight	F	Weight
T80.06.85	6	0.24	2.75	0.11	14	0.55	835 mm / 32.87 in	13.0 kg	415 mm / 16.34 in	6.5 kg	795 mm / 31.30 in	13.0 kg	805 mm / 31.69 in	13.0 kg
T80.08.85	8	0.31	2.75	0.11	14	0.55		12.6 kg		6.2 kg		12.0 kg		12.0 kg
T80.10.85	10	0.39	2.75	0.11	18	0.71		14.2 kg		7.0 kg		13.7 kg		14.0 kg
T80.12.85	12	0.47	2.75	0.11	18	0.71		14.1 kg		7.0 kg		14.0 kg		14.0 kg
T80.16.85	16	0.63	2.75	0.11	24	0.94		16.4 kg		8.2 kg		15.8 kg		15.8 kg
T80.20.85	20	0.79	3.0	0.12	30	1.18		19.0 kg		9.5 kg		18.0 kg		18.0 kg
T80.25.85	25	0.98	3.0	0.12	35	1.38		20.0 kg		10.0 kg		19.0 kg		20.0 kg



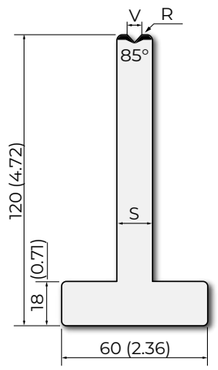
85°

C45: 560-710 N/mm²

1000 kN/m max.

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]		Weight		Weight	FX	Weight	F	Weight
T120.06.85	6	0.24	2.75	0.11	14	0.55	835 mm / 32.87 in	16.3 kg	415 mm / 16.34 in	8.1 kg	795 mm / 31.30 in	15.7 kg	805 mm / 31.69 in	15.7 kg
T120.08.85	8	0.31	2.75	0.11	14	0.55		16.3 kg		8.1 kg		15.7 kg		15.7 kg
T120.10.85	10	0.39	2.75	0.11	18	0.71		19.0 kg		9.5 kg		19.0 kg		19.0 kg
T120.12.85	12	0.47	2.75	0.11	18	0.71		18.9 kg		9.4 kg		18.2 kg		18.2 kg
T120.16.85	16	0.63	2.75	0.11	24	0.94		22.7 kg		11.3 kg		21.9 kg		21.9 kg
T120.20.85	20	0.79	3.0	0.12	30	1.18		26.4 kg		13.0 kg		25.5 kg		25.5 kg
T120.25.85	25	0.98	3.0	0.12	35	1.38		30.0 kg		15.0 kg		30.0 kg		30.0 kg



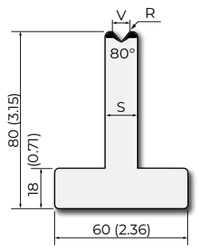
85°

C45: 560-710 N/mm²

950 kN/m max.

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T80.06.80	6	0.24	2.75	0.11	14	0.55		13.0 kg		6.5 kg		13.0 kg		13.0 kg
T80.08.80	8	0.31	2.75	0.11	14	0.55		13.0 kg		6.5 kg		13.0 kg		13.0 kg
T80.10.80	10	0.39	2.75	0.11	18	0.71		13.0 kg		6.5 kg		13.0 kg		13.0 kg
T80.12.80	12	0.47	2.75	0.11	18	0.71		13.0 kg		6.5 kg		13.0 kg		13.0 kg
T80.16.80	16	0.63	2.75	0.11	24	0.94		13.0 kg		6.5 kg		13.0 kg		13.0 kg
T80.20.80	20	0.79	3.0	0.12	30	1.18		17.0 kg		6.5 kg		12.4 kg		12.5 kg
T80.25.80	25	0.98	3.0	0.12	35	1.38		20.0 kg		10.0 kg		20.0 kg		20.0 kg



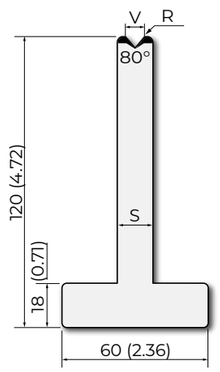
80°

C45: 560-710 N/mm²

950 kN/m max.

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T120.06.80	6	0.24	2.75	0.11	14	0.55		18.0 kg		9.0 kg		17.1 kg		17.4 kg
T120.08.80	8	0.31	2.75	0.11	14	0.55		18.0 kg		18.0 kg		18.0 kg		18.0 kg
T120.10.80	10	0.39	2.75	0.11	18	0.71		18.0 kg		9.0 kg		17.1 kg		17.4 kg
T120.12.80	12	0.47	2.75	0.11	18	0.71		18.0 kg		9.0 kg		17.1 kg		17.4 kg
T120.16.80	16	0.63	2.75	0.11	24	0.94		18.0 kg		18.0 kg		18.0 kg		18.0 kg
T120.20.80	20	0.79	3.0	0.12	30	1.18		26.3 kg		13.0 kg		25.0 kg		25.4 kg
T120.25.80	25	0.98	3.0	0.12	35	1.38		30.0 kg		18.0 kg		18.0 kg		18.0 kg



80°

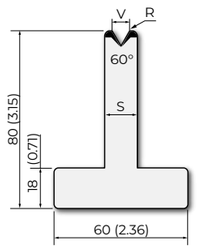
R1

C45: 560-710 N/mm²

600 kN/m max.

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T80.06.60	6	0.24	0.5	0.02	14	0.55		13.0 kg		6.5 kg		12.4 kg		12.5 kg
TR80.06.60	6	0.24	1.5	0.06	14	0.55		13.0 kg		6.5 kg		12.4 kg		12.5 kg
T80.08.60	8	0.31	0.8	0.03	14	0.55		13.0 kg		6.5 kg		13.0 kg		13.0 kg
TR80.08.60	8	0.31	1.5	0.06	14	0.55		13.0 kg		6.5 kg		13.0 kg		13.0 kg
T80.10.60	10	0.39	0.8	0.031	18	0.71		14.5 kg		7.0 kg		13.5 kg		13.5 kg
TR80.10.60	10	0.39	2.75	0.108	18	0.71		15.0 kg		7.5 kg		15.0 kg		15.0 kg
T80.12.60	12	0.47	0.8	0.031	18	0.71		14.0 kg		7.0 kg		13.5 kg		13.5 kg
TR80.12.60	12	0.47	2.75	0.108	18	0.71		15.0 kg		7.5 kg		15.0 kg		15.0 kg
T80.16.60	16	0.63	2.75	0.108	24	0.94		15.6 kg		8.7 kg		16.0 kg		16.0 kg
T80.20.60	20	0.79	3.0	0.118	30	1.18		18.0kg		9.5 kg		19.0 kg		19.0 kg
T80.25.60	25	0.98	3.0	0.118	35	1.38		19.5 kg		10.0 kg		18.8 kg		18.8 kg



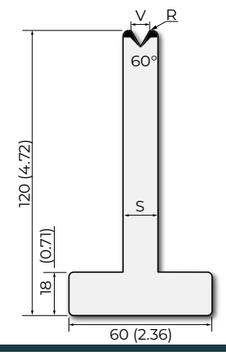
60°

C45: 560-710 N/mm²

600 kN/m max.

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T120.06.60	6	0.24	0.5	0.02	14	0.55		16.0 kg		8.0 kg		16.0 kg		15.4 kg
TR120.06.60	6	0.24	1.5	0.06	14	0.55		16.0 kg		8.0 kg		15.2 kg		15.4 kg
T120.08.60	8	0.31	0.8	0.03	14	0.55		16.0 kg		8.0 kg		16.0 kg		16.0 kg
TR120.08.60	8	0.31	1.5	0.06	14	0.55		16.0 kg		8.0 kg		16.0 kg		16.0 kg
T120.10.60	10	0.39	0.8	0.031	18	0.71		18.8 kg		9.3 kg		18.1 kg		18.1 kg
TR120.10.60	10	0.39	2.75	0.108	18	0.71		18.0 kg		9.0 kg		17.1 kg		17.4 kg
T120.12.60	12	0.47	0.8	0.031	18	0.71		18.0 kg		9.0 kg		18.3 kg		18.3 kg
TR120.12.60	12	0.47	2.75	0.108	18	0.71		18.0 kg		9.0 kg		17.1 kg		17.4 kg
T120.16.60	16	0.63	2.75	0.108	24	0.94		22.4 kg		11.1 kg		21.6 kg		21.6 kg
T120.20.60	20	0.79	3.0	0.118	30	1.18		26.0 kg		13.0 kg		24.8 kg		25.0 kg
T120.25.60	25	0.98	3.0	0.118	35	1.38		29.0 kg		15.0 kg		30.0 kg		30.0 kg



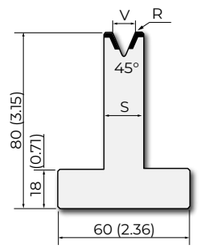
60°

C45: 560-710 N/mm²

500 kN/m max.

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	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		15.0 kg		15.0 kg
T80.10.45	10	0.39	1.2	0.05	18	0.71		14.0 kg		7.0 kg		13.3 kg		13.5 kg
T80.12.45	12	0.47	1.6	0.06	24	0.94		16.3 kg		8.1 kg		15.7 kg		15.7 kg
T80.16.45	16	0.63	2.75	0.11	26	1.02		16.6 kg		8.3 kg		16.0 kg		16.0 kg
T80.20.45	20	0.79	3.0	0.12	30	1.18		18.0 kg		9.0 kg		18.0 kg		18.0 kg
T80.25.45	25	0.98	3.0	0.12	37	1.46		20.0 kg		10.0 kg		20.0 kg		20.0 kg



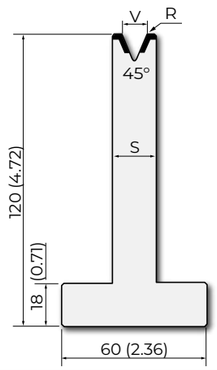
45°

C45: 560-710 N/mm²

500 kN/m max.

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T120.06.45	6	0.24	0.8	0.03	14	0.55		16.0 kg		8.0 kg		16.0 kg		16.0 kg
T120.08.45	8	0.31	1.0	0.04	18	0.71		18.0 kg		9.0 kg		18.0 kg		18.0 kg
T120.10.45	10	0.39	1.2	0.05	18	0.71		18.0 kg		9.0 kg		18.0 kg		18.0 kg
T120.12.45	12	0.47	1.6	0.06	24	0.94		23.0 kg		9.0 kg		18.0 kg		18.0 kg
T120.16.45	16	0.63	2.75	0.11	26	1.02		25.0 kg		12.5 kg		25.0 kg		25.0 kg
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	25	0.79	3.0	0.12	37	1.46		30.0 kg		15.0 kg		28.6 kg		28.9 kg



45°

T - Dies - R1 CLASSIC Series

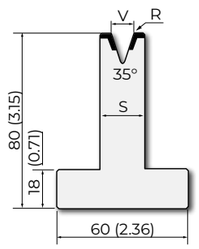
R1

C45: 560-710 N/mm²

See table

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	kN/m max.	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T80.06.35	6	0.24	0.8	0.03	14	0.55	350		12.5 kg		6.5 kg		12.0 kg		12.0 kg
T80.08.35	8	0.31	1.0	0.04	16	0.63	350		13.0 kg		7.0 kg		14.0 kg		14.0 kg
T80.10.35	10	0.39	1.2	0.05	20	0.79	400		15.0 kg		7.5 kg		15.0 kg		15.0 kg
T80.12.35	12	0.47	1.6	0.06	22	0.87	400		15.5 kg		8.0 kg		16.0 kg		16.0 kg
T80.16.35	16	0.63	3.0	0.12	30	1.18	450		18.0 kg		8.5 kg		17.0 kg		17.0 kg
T80.20.35	20	0.79	3.0	0.12	35	1.38	500		19.3 kg		9.0 kg		18.0 kg		18.0 kg
T80.25.35	25	0.98	3.0	0.12	40	1.57	500		20.0 kg		9.9 kg		19.3 kg		19.3 kg



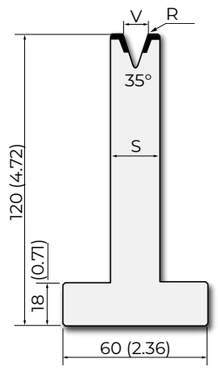
35°

C45: 560-710 N/mm²

See table

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	kN/m max.	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T120.06.35	6	0.24	0.8	0.03	14	0.55	350		16.0 kg		8.0 kg		16.0 kg		16.0 kg
T120.08.35	8	0.31	1.0	0.04	16	0.63	350		18.0 kg		9.0 kg		18.0 kg		18.0 kg
T120.10.35	10	0.39	1.2	0.05	20	0.79	400		19.9 kg		8.5 kg		19.0 kg		19.0 kg
T120.12.35	12	0.47	1.6	0.06	22	0.87	400		21.0 kg		10.0 kg		20.0 kg		20.0 kg
T120.16.35	16	0.63	3.0	0.12	30	1.18	450		25.8 kg		12.8 kg		24.8 kg		24.8 kg
T120.20.35	20	0.79	3.0	0.12	35	1.38	500		28.0 kg		14.0 kg		28.0 kg		28.0 kg
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



35°

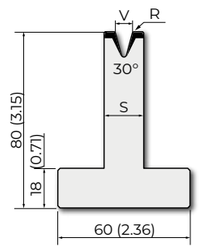
T - Dies - R1 CLASSIC Series

C45: 560-710 N/mm²

See table

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	kN/m max.	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T80.06.30	6	0.24	0.6	0.024	14	0.55	350		12.4 kg		6.5 kg		12.0 kg		12.0 kg
T80.08.30	8	0.31	0.8	0.031	18	0.71	350		13.0 kg		7.0 kg		14.0 kg		14.0 kg
T80.10.30	10	0.39	1.0	0.039	24	0.94	500		16.0 kg		8.0 kg		15.4 kg		15.0 kg
T80.12.30	12	0.47	1.5	0.059	24	0.84	400		16.0 kg		8.0 kg		15.5 kg		15.5 kg
T80.16.30	16	0.63	2.0	0.079	30	1.18	450		18.0 kg		8.9 kg		17.3 kg		17.3 kg
T80.20.30	20	0.79	2.5	0.09	35	1.38	500		19.0 kg		9.5 kg		18.0 kg		18.0 kg
T80.25.30	25	0.98	3.0	0.118	40	1.57	500		20.0 kg		10.0 kg		19.3 kg		19.3 kg



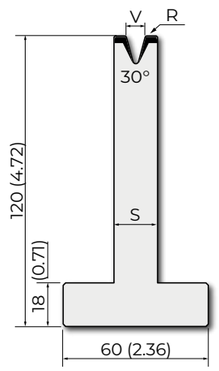
30°

C45: 560-710 N/mm²

See table

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	kN/m max.	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm / 31.30 in	Weight	F 805 mm / 31.69 in	Weight
T120.06.30	6	0.24	0.6	0.024	14	0.55	350		16.0 kg		8.0 kg		16.0 kg		16.0 kg
T120.08.30	8	0.31	0.8	0.031	18	0.71	350		19.0 kg		9.5 kg		19.0 kg		19.0 kg
T120.10.30	10	0.39	1.0	0.039	18	0.71	500		22.0 kg		10.9 kg		14.5 kg		14.5 kg
T120.12.30	12	0.47	1.5	0.059	24	0.94	400		22.0 kg		10.0 kg		20.0 kg		20.0 kg
T120.16.30	16	0.63	2.0	0.079	30	1.18	450		25.8 kg		13.0 kg		25.8 kg		25.8 kg
T120.20.30	20	0.79	2.5	0.09	35	1.38	500		28.0 kg		14.0 kg		28.0 kg		28.0 kg
T120.25.30	25	0.98	3.0	0.118	40	1.57	500		30.5 kg		15.0 kg		30.5 kg		30.5 kg



30°

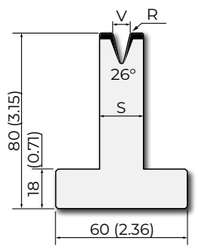
T - Dies - R1 CLASSIC Series

C45: 560-710 N/mm²

200 kN/m max.

H=80 mm / 3.15 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm/31.30 in	Weight	F 805 mm/31.69 in	Weight
T80.06.26	6	0.24	0.8	0.031	16	0.63		14.0 kg		7.0 kg		13.3 kg		13.5 kg
T80.08.26	8	0.31	1.0	0.039	20	0.79		15.0 kg		7.5 kg		14.3 kg		14.5 kg
T80.10.26	10	0.39	1.2	0.047	24	0.94		15.5 kg		8.0 kg		15.5 kg		15.5 kg
T80.12.26	12	0.47	1.6	0.063	26	1.02		16.6 kg		7.5 kg		15.0 kg		16.0 kg



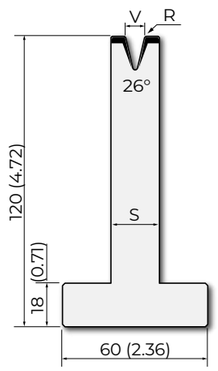
26°

C45: 560-710 N/mm²

200 kN/m max.

H=120 mm / 4.72 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm/31.30 in	Weight	F 805 mm/31.69 in	Weight
T120.06.26	6	0.24	0.8	0.031	16	0.63		18.0 kg		9.0 kg		18.0 kg		18.0 kg
T120.08.26	8	0.31	1.0	0.039	20	0.79		19.0 kg		9.5 kg		19.0 kg		19.0 kg
T120.10.26	10	0.39	1.2	0.047	24	0.94		22.0 kg		11.0 kg		22.0 kg		22.0 kg
T120.12.26	12	0.47	1.6	0.063	26	1.02		22.0 kg		11.0 kg		22.0 kg		22.0 kg

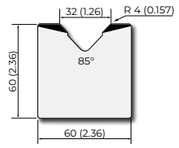


26°

C45: 560-710 N/mm² — 1000 kN/m max.

M60.85.32

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

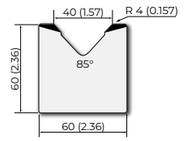


85° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M60.85.40

835 mm	32.87 in	20.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	19.0 kg	FX
805 mm	31.69 in	19.0 kg	F

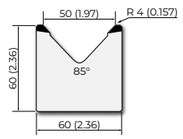


85° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M60.85.50

835 mm	32.87 in	19.0 kg	
415 mm	16.34 in	9.5 kg	
795 mm	31.29 in	19.0 kg	FX
805 mm	31.69 in	19.0 kg	F

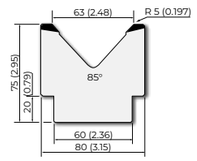


85° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M75.85.63

835 mm	32.87 in	29.2 kg	
415 mm	16.34 in	14.5 kg	
795 mm	31.29 in	28.0 kg	FX
805 mm	31.69 in	28.0 kg	F

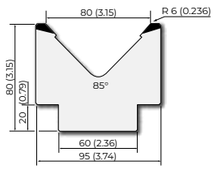


85° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M80.85.80

835 mm	32.87 in	33.5 kg	
415 mm	16.34 in	16.6 kg	
795 mm	31.29 in	32.2 kg	FX
805 mm	31.69 in	32.2 kg	F

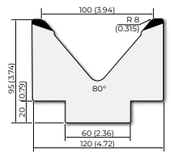


85° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M95.80.100

835 mm	32.87 in	46.2 kg	
415 mm	16.34 in	22.9 kg	
795 mm	31.29 in	44.5 kg	FX
805 mm	31.69 in	44.5 kg	F

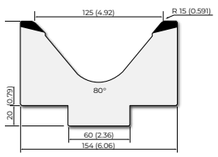


80° ✓

C45: 560-710 N/mm² — 700 kN/m max.

MK103.80.125

835 mm	32.87 in	62.0 kg	
415 mm	16.34 in	31.0 kg	
795 mm	31.29 in	59.8 kg	FX
805 mm	31.69 in	59.8 kg	F

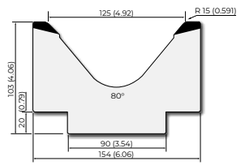


80° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M103.80.125

835 mm	32.87 in	64.9 kg	
415 mm	16.34 in	32.2 kg	
795 mm	31.29 in	62.5 kg	FX
805 mm	31.69 in	62.5 kg	F

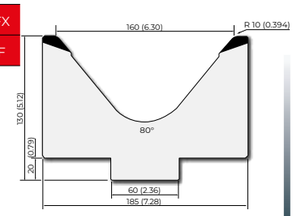


80° ✓

C45: 560-710 N/mm² — 700 kN/m max.

MK130.80.160

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

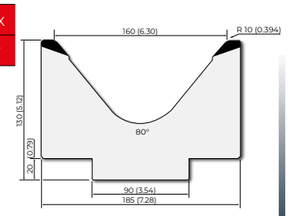


80° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M130.80.160

835 mm	32.87 in	97.0 kg	
415 mm	16.34 in	47.4 kg	
795 mm	31.29 in	88.5 kg	FX
805 mm	31.69 in	89.7 kg	F

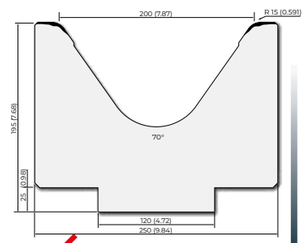


80° ✓

42Cr: 900-1150 N/mm² — 1800 kN/m max.

M195.70.200

415 mm	16.34 in	104.0 kg	

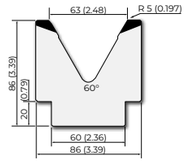


70° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M86.60.63

835 mm	32.87 in	33.3 kg	
415 mm	16.34 in	17.0 kg	
795 mm	31.29 in	34.0 kg	FX
805 mm	31.69 in	34.0 kg	F

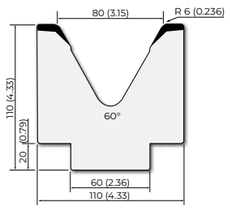


60° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M110.60.80

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

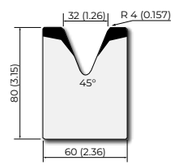


60° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M80.45.32

835 mm	32.87 in	27.5 kg	
415 mm	16.34 in	13.7 kg	
795 mm	31.29 in	27.5 kg	FX
805 mm	31.69 in	27.5 kg	F

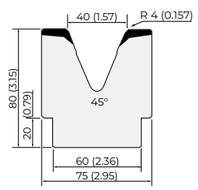


45° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M80.45.40

835 mm	32.87 in	30.9 kg	
415 mm	16.34 in	16.5 kg	
795 mm	31.29 in	30.7 kg	FX
805 mm	31.69 in	30.7 kg	F

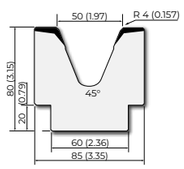


45° ✓

C45: 560-710 N/mm² — 950 kN/m max.

M80.45.50

835 mm	32.87 in	31.0 kg	
415 mm	16.34 in	15.5 kg	
795 mm	31.29 in	31.0 kg	FX
805 mm	31.69 in	31.0 kg	F



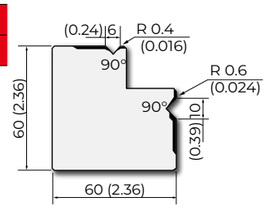
45° ✓

Segmented ✓ On stock — Ask for delivery time

C45: 560-710 N/mm² — 1000 kN/m max.

M60.90.01

835 mm	32.87 in	20.0 kg	
415 mm	16.34 in	10.0 kg	
795 mm	31.29 in	20.0 kg	FX
805 mm	31.69 in	20.0 kg	F

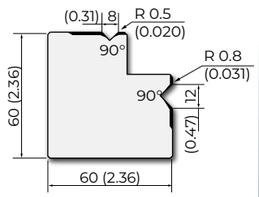


90° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M60.90.02

835 mm	32.87 in	20.0 kg	
415 mm	16.34 in	10.0 kg	
795 mm	31.29 in	20.0 kg	FX
805 mm	31.69 in	20.0 kg	F

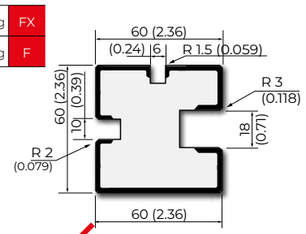


90° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M.360.R

835 mm	32.87 in	20.0 kg	
415 mm	16.34 in	10.0 kg	
795 mm	31.29 in	20.0 kg	FX
805 mm	31.69 in	20.0 kg	F

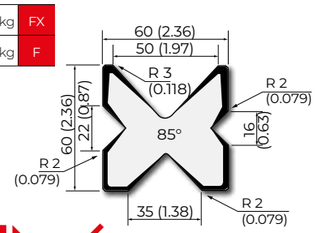


✓

C45: 560-710 N/mm² — 800 kN/m max.

M.460.R

835 mm	32.87 in	15.7 kg	
415 mm	16.34 in	7.7 kg	
795 mm	31.29 in	15.1 kg	FX
805 mm	31.69 in	15.1 kg	F

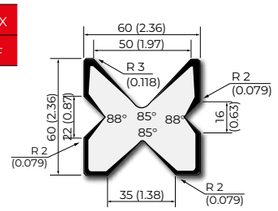


85° ✓

C45: 560-710 N/mm² — 800 kN/m max.

M.460

835 mm	32.87 in	15.7 kg	
415 mm	16.34 in	7.7 kg	
795 mm	31.29 in	15.5 kg	FX
805 mm	31.69 in	15.5 kg	F

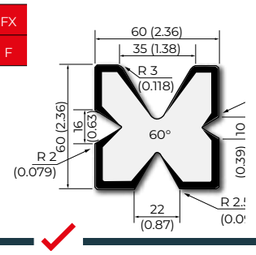


85° 88° ✓

C45: 560-710 N/mm² — 600 kN/m max.

M.460.60

835 mm	32.87 in	18.0 kg	
415 mm	16.34 in	9.0 kg	
795 mm	31.29 in	16.0 kg	FX
805 mm	31.69 in	16.0 kg	F

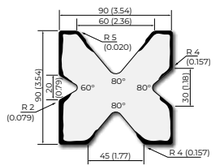


60° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

M.490

835 mm	32.87 in	38.9 kg	
415 mm	16.34 in	20.0 kg	
795 mm	31.29 in	39.0 kg	FX
805 mm	31.69 in	39.0 kg	F

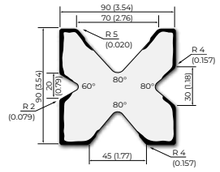


60° 80° ✓

C45: 560-710 N/mm² — 600 kN/m max.

M.490.70

835 mm	32.87 in	35.8 kg	
415 mm	16.34 in	17.9 kg	
795 mm	31.29 in	36.0 kg	FX
805 mm	31.69 in	36.0 kg	F



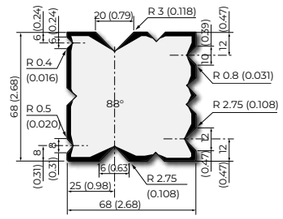
60° 80° ✓

Multi-V Dies - R1 CLASSIC Series

42Cr: 900-1150 N/mm² — 1000 kN/m max.

T70-88

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



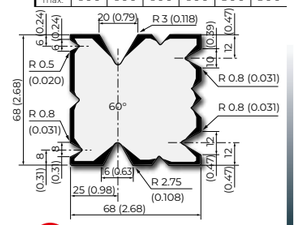
88° ✓

42Cr: 900-1150 N/mm² — See table

T70-60

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

V [mm]	6	8	10	12	16	20
V [in]	0.24	0.31	0.39	0.47	0.63	0.79
kN/m max	600	600	600	600	800	800



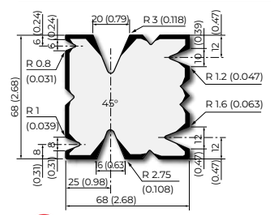
60° ✓

42Cr: 900-1150 N/mm² — See table

T70-45

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

V [mm]	6	8	10	12	16	20
V [in]	0.24	0.31	0.39	0.47	0.63	0.79
kN/m max	400	400	500	500	700	700



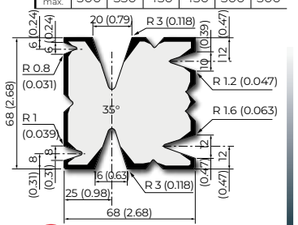
45° ✓

42Cr: 900-1150 N/mm² — See table

T70-35

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

V [mm]	6	8	10	12	16	20
V [in]	0.24	0.31	0.39	0.47	0.63	0.79
kN/m max	300	350	450	450	500	500

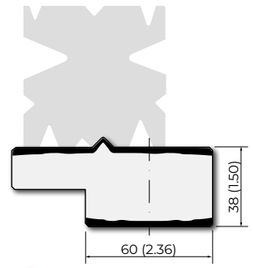


35° ✓

C45: 560-710 N/mm²

SU-T70

525 mm	20.67 in	12.4 kg

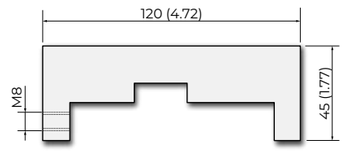


Holder ✓

Fe37

PB-T70

20 mm	0.79 in	0.2 kg



Retainer ✓

Segmented ✓ On stock — Ask for delivery time

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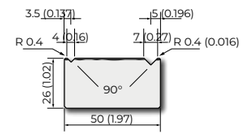
C45: 560-710 N/mm² — 600 kN/m max.

12100

835 mm	32.87 in	8.4 kg
415 mm	16.34 in	4.2 kg

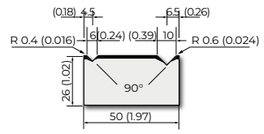


90°

C45: 560-710 N/mm² — 700 kN/m max.

12300

835 mm	32.87 in	8.0 kg
415 mm	16.34 in	3.9 kg

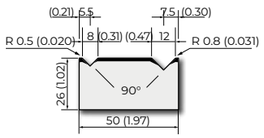


90°

C45: 560-710 N/mm² — 800 kN/m max.

12400

835 mm	32.87 in	8.0 kg
415 mm	16.34 in	3.9 kg

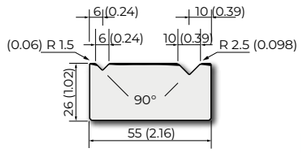


90°

C45: 560-710 N/mm² — 800 kN/m max.

31100

835 mm	32.87 in	9.1 kg
415 mm	16.34 in	4.5 kg

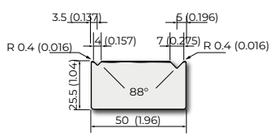


90°

C45: 560-710 N/mm² — 600 kN/m max.

12106

835 mm	32.87 in	8.4 kg
415 mm	16.34 in	7.8 kg

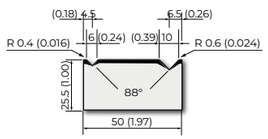


88°

C45: 560-710 N/mm² — 700 kN/m max.

12306

835 mm	32.87 in	8.0 kg
415 mm	16.34 in	3.9 kg

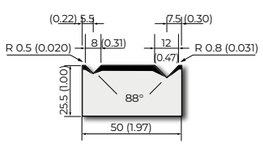


88°

C45: 560-710 N/mm² — 800 kN/m max.

12406

835 mm	32.87 in	8.0 kg
415 mm	16.34 in	3.9 kg

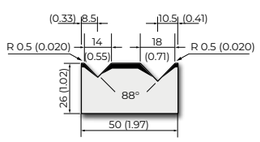


88°

C45: 560-710 N/mm² — 1000 kN/m max.

12500

835 mm	32.87 in	7.7 kg
415 mm	16.34 in	3.8 kg



88°

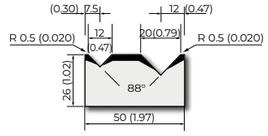
2-V Dies - R1 A Series

R1

C45: 560-710 N/mm² — 1000 kN/m max.

12600

835 mm	32.87 in	7.5 kg
415 mm	16.34 in	3.7 kg

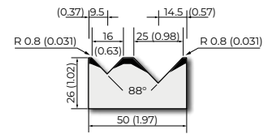


88°

C45: 560-710 N/mm² — 700 kN/m max.

12700

835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.4 kg

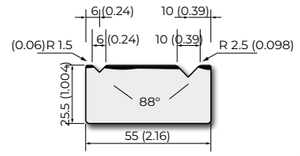


88°

C45: 560-710 N/mm² — 800 kN/m max.

31106

835 mm	32.87 in	8.9 kg
415 mm	16.34 in	4.4 kg

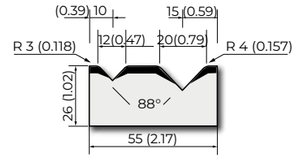


88°

C45: 560-710 N/mm² — 1000 kN/m max.

31400

835 mm	32.87 in	7.5 kg
415 mm	16.34 in	3.7 kg



88°

Segmented

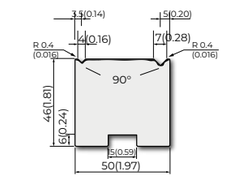
On stock

Ask for delivery time

C45: 560-710 N/mm² — 600 kN/m max.

30148

835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.7 kg	F

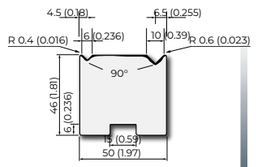


90°

C45: 560-710 N/mm² — 700 kN/m max.

30248

835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.7 kg	F

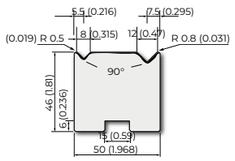


90°

C45: 560-710 N/mm² — 700 kN/m max.

30348

835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.7 kg	F

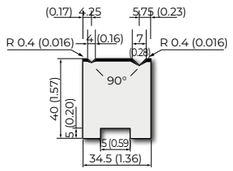


90°

C45: 560-710 N/mm² — 600 kN/m max.

50190

835 mm	32.87 in	9.7 kg	
415 mm	16.34 in	4.8 kg	
795 mm	31.29 in	9.2 kg	FX
805 mm	31.69 in	9.4 kg	F

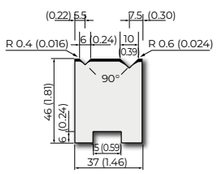


90°

C45: 560-710 N/mm² — 700 kN/m max.

50290

835 mm	32.87 in	10.3 kg	
415 mm	16.34 in	5.2 kg	
795 mm	31.29 in	10.0 kg	FX
805 mm	31.69 in	10.1 kg	F

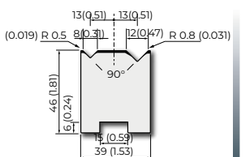


90°

C45: 560-710 N/mm² — 700 kN/m max.

50390

835 mm	32.87 in	10.7 kg	
415 mm	16.34 in	5.3 kg	
795 mm	31.29 in	10.7 kg	FX
805 mm	31.69 in	10.7 kg	F

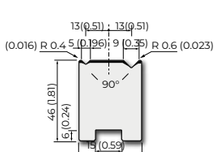


90°

C45: 560-710 N/mm² — 600 kN/m max.

50790

835 mm	32.87 in	10.0 kg	
415 mm	16.34 in	5.0 kg	
795 mm	31.29 in	9.5 kg	FX
805 mm	31.69 in	9.7 kg	F

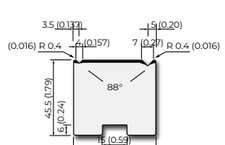


90°

C45: 560-710 N/mm² — 600 kN/m max.

30147

835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.7 kg	F



88°

Segmented

On stock

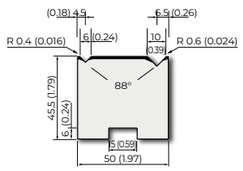
Ask for delivery time

Self centering 2-V Dies - R1 A Series

C45: 560-710 N/mm² — 700 kN/m max.

30247

835 mm	32.87 in	14.0 kg	
415 mm	16.34 in	8.4 kg	
795 mm	31.29 in	16.2 kg	FX
805 mm	31.69 in	16.4 kg	F

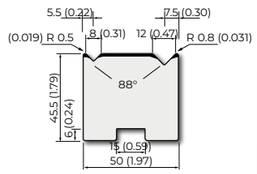


88°

C45: 560-710 N/mm² — 700 kN/m max.

30347

835 mm	32.87 in	14.2 kg	
415 mm	16.34 in	7.1 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.7 kg	F

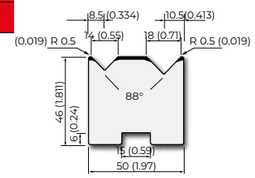


88°

C45: 560-710 N/mm² — 1000 kN/m max.

30448

835 mm	32.87 in	13.5 kg	
415 mm	16.34 in	6.7 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.7 kg	F

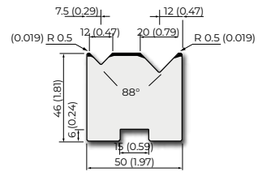


88°

C45: 560-710 N/mm² — 1000 kN/m max.

30548

835 mm	32.87 in	13.5 kg	
415 mm	16.34 in	6.7 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.7 kg	F

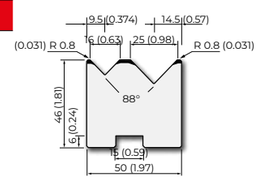


88°

C45: 560-710 N/mm² — 1000 kN/m max.

30648

835 mm	32.87 in	12.9 kg	
415 mm	16.34 in	6.4 kg	
795 mm	31.29 in	13.5 kg	FX
805 mm	31.69 in	13.7 kg	F

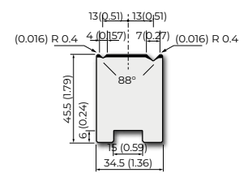


88°

C45: 560-710 N/mm² — 600 kN/m max.

50196

835 mm	32.87 in	9.5 kg	
415 mm	16.34 in	4.8 kg	
795 mm	31.29 in	9.5 kg	FX
805 mm	31.69 in	9.5 kg	F

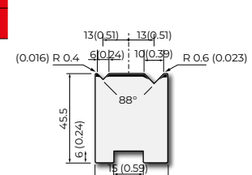


88°

C45: 560-710 N/mm² — 700 kN/m max.

50296

835 mm	32.87 in	10.4 kg	
415 mm	16.34 in	5.2 kg	
795 mm	31.29 in	10.4 kg	FX
805 mm	31.69 in	10.4 kg	F

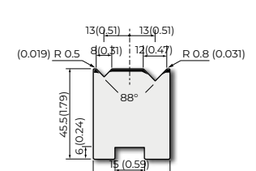


88°

C45: 560-710 N/mm² — 700 kN/m max.

50396

835 mm	32.87 in	10.8 kg	
415 mm	16.34 in	5.3 kg	
795 mm	31.29 in	10.8 kg	FX
805 mm	31.69 in	10.8 kg	F



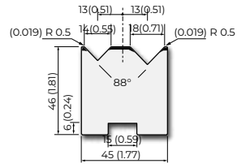
88°

Self centering 2-V Dies - R1 A Series

C45: 560-710 N/mm² — 1000 kN/m max.

50490

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

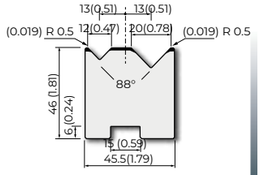


88°

C45: 560-710 N/mm² — 700 kN/m max.

50590

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

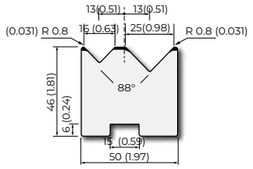


88°

C45: 560-710 N/mm² — 1000 kN/m max.

50690

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

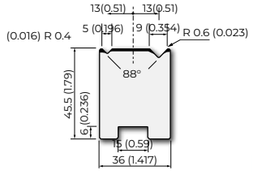


88°

C45: 560-710 N/mm² — 600 kN/m max.

50796

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

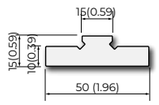


88°

C45: 560-710 N/mm² — 1000 kN/m max.

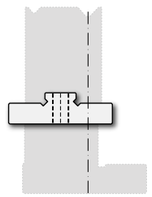
30000

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



Holder

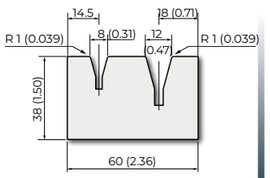
Example of Application



42Cr: 900-1150 N/mm² — 300 kN/m max.

33700

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



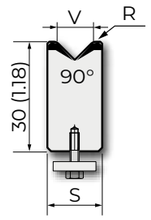
30°

Self centering 1-V Dies - R1 A Series

C45: 560-710 N/mm² — See table

H=30 mm / 3.15 in

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

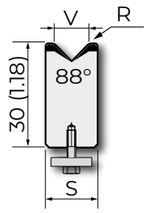


90°

C45: 560-710 N/mm² — See table

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

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

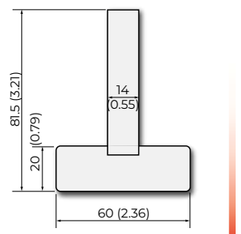


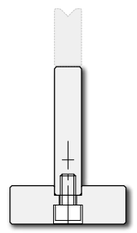
88°

C45: 560-710 N/mm² — 1000 kN/m max.

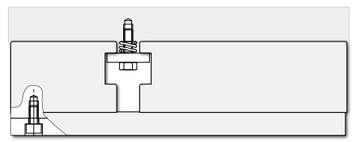
33000

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





Example of Application



Holder

Segmented — On stock — Ask for delivery time

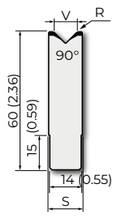
C45: 560-710 N/mm²

950 kN/m max.

H=60 mm / 2.36 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm/31.30 in	Weight	F 805 mm/31.69 in	Weight
07000	6	0.24	1.5	0.059	14	0.55		5.5 kg		2.7 kg		5.2 kg		5.3 kg
07100	8	0.31	1.5	0.059	14	0.55		5.5 kg		2.7 kg		5.2 kg		5.3 kg
07300	10	0.39	2.0	0.079	15	0.59		6.0 kg		3.0 kg		5.3 kg		5.4 kg
07500	12	0.47	2.5	0.09	15	0.59		6.1 kg		3.0 kg		5.8 kg		5.9 kg

For compatible holders see page 58



90°

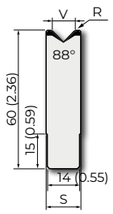
C45: 560-710 N/mm²

950 kN/m max.

H=60 mm / 2.36 in

Model	V [mm]	V [in]	R [mm]	R [in]	S [mm]	S [in]	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	FX 795 mm/31.30 in	Weight	F 805 mm/31.69 in	Weight
07006	6	0.24	1.5	0.059	14	0.55		5.5 kg		2.7 kg		5.2 kg		5.3 kg
07106	8	0.31	1.5	0.059	14	0.55		5.5 kg		2.7 kg		5.2 kg		5.3 kg
07200	10	0.39	2.0	0.079	15	0.59		6.0 kg		3.0 kg		5.4 kg		5.5 kg
07400	12	0.47	2.5	0.09	17	0.67		6.0 kg		3.0 kg		5.8 kg		5.9 kg
07600	14	0.55	2.5	0.09	17	0.67		6.1 kg		3.0 kg		5.8 kg		5.9 kg

For compatible holders see page 58



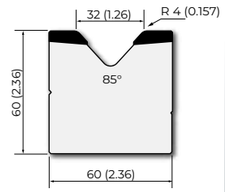
88°

C45: 560-710 N/mm²

1000 kN/m max.

03500

835 mm	32.87 in	21.7 kg	
415 mm	16.34 in	10.8 kg	
795 mm	31.29 in	21.7 kg	FX
805 mm	31.69 in	21.7 kg	F



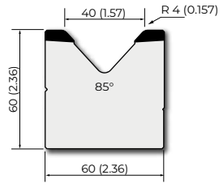
85°

C45: 560-710 N/mm²

1000 kN/m max.

03600

835 mm	32.87 in	20.5 kg	
415 mm	16.34 in	10.2 kg	
795 mm	31.29 in	19.5 kg	FX
805 mm	31.69 in	19.7 kg	F



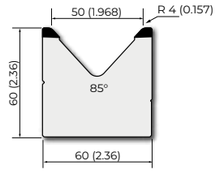
85°

C45: 560-710 N/mm²

1000 kN/m max.

03700

835 mm	32.87 in	18.9 kg	
415 mm	16.34 in	9.4 kg	
795 mm	31.29 in	18.9 kg	FX
805 mm	31.69 in	18.9 kg	F



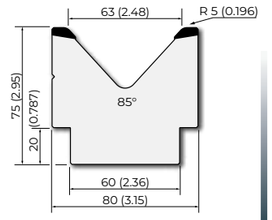
85°

C45: 560-710 N/mm²

1000 kN/m max.

03800

835 mm	32.87 in	29.2 kg	
415 mm	16.34 in	14.5 kg	
795 mm	31.29 in	29.2 kg	FX
805 mm	31.69 in	29.2 kg	F



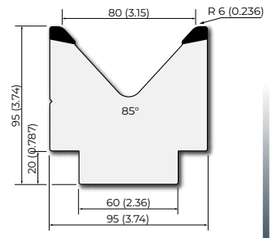
85°

C45: 560-710 N/mm²

700 kN/m max.

01360

835 mm	32.87 in	42.6 kg	
415 mm	16.34 in	21.2 kg	
795 mm	31.29 in	42.6 kg	FX
805 mm	31.69 in	42.6 kg	F



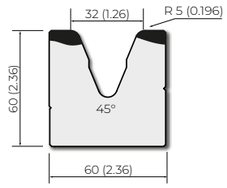
85°

C45: 560-710 N/mm²

400 kN/m max.

34200

835 mm	32.87 in	19.2 kg	
415 mm	16.34 in	9.6 kg	
795 mm	31.29 in	19.2 kg	FX
805 mm	31.69 in	19.2 kg	F



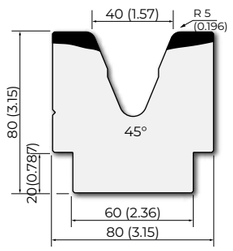
45°

C45: 560-710 N/mm²

700 kN/m max.

34300

835 mm	32.87 in	32.7 kg	
415 mm	16.34 in	16.2 kg	
795 mm	31.29 in	31.1 kg	FX
805 mm	31.69 in	31.5 kg	F



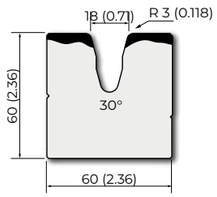
45°

C45: 560-710 N/mm²

800 kN/m max.

34000

835 mm	32.87 in	21.5 kg	
415 mm	16.34 in	10.7 kg	
795 mm	31.29 in	21.5 kg	FX
805 mm	31.69 in	21.5 kg	F



30°

Segmented

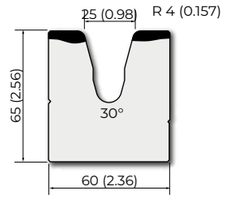
On stock

Ask for delivery time

C45: 560-710 N/mm² — 600 kN/m max.

34100

835 mm	32.87 in	21.7 kg	
415 mm	16.34 in	10.8 kg	
795 mm	31.29 in	21.7 kg	FX
805 mm	31.69 in	21.7 kg	F

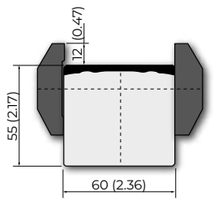


30°

C45: 560-710 N/mm² — 1000 kN/m max.

05500

835 mm	32.87 in	21.7 kg
415 mm	16.34 in	10.8 kg



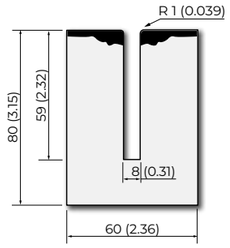
Holder

42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

TOP.SM-134.28.8

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

To use with:
- TOP.SP-134.28.8 (pag. 15)

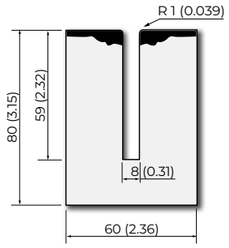


42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

TOP.SM-134.24.8

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

To use with:
- TOP.SP-134.24.8 (page 15)

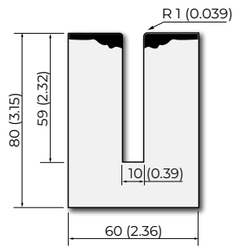


42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

TOP.SM-134.24.10

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

To use with:
- TOP.SP-134.24.10 (page 15)

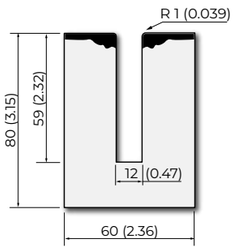


42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

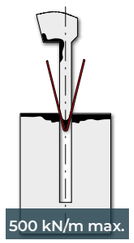
TOP.SM-134.24.12

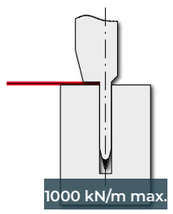
525 mm	20.67 in	16.8 kg
495 mm	19.49 in	15.9 kg

To use with:
- TOP.SP-134.24.12 (page 15)



Ex. of Application ▸





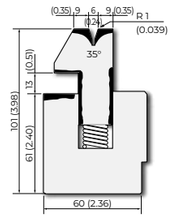
S [mm]	S (in)	A [mm]	A (in)	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	3.0	0.12	90	150
0.8	0.03	3.0	0.12	120	200
1.0	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260

S [mm]	S (in)	A [mm]	A (in)	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	1.2	0.05	230	350
0.8	0.03	1.6	0.06	320	500
1.0	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800

C45: 560-710 N/mm² — 600 kN/m max.

S101.35.06

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

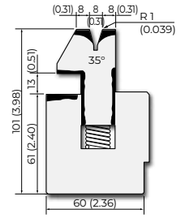


35° ✓

C45: 560-710 N/mm² — 600 kN/m max.

S101.35.08

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

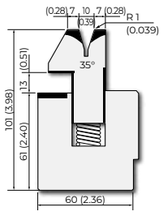


35° ✓

C45: 560-710 N/mm² — 600 kN/m max.

S101.35.10

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

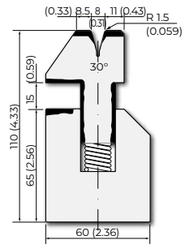


35° ✓

C45: 560-710 N/mm² — 800 kN/m max.

S110.30.08

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

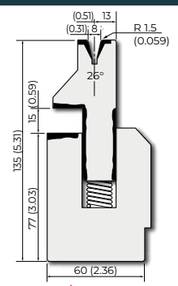


30° ✓

42Cr: 900-1150 N/mm² — 400 kN/m max.

S135.26.08

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

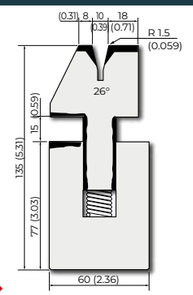


26° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

S135.26.10

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

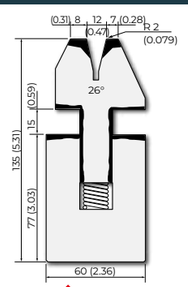


26° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

SA135.26.12

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



26° ✓

Rolleri hemming dies can also be used as standard dies. You only have to secure the screws when the die is closed to prevent springs from moving the mobile part upwards.

Spring-loaded Hemming Dies - R1

S [mm]	S [in]	A [mm]	A [in]	R.420 N/mm² kN/m	R.700 N/mm² kN/m	S [mm]	S [in]	A [mm]	A [in]	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	3.0	0.12	90	150	0.6	0.02	1.2	0.05	230	350
0.8	0.03	3.0	0.12	120	200	0.8	0.03	1.6	0.06	320	500
1.0	0.04	3.5	0.14	150	250	1.0	0.04	1.0	0.04	400	600
1.25	0.05	3.5	0.14	170	260	1.25	0.05	2.5	0.10	500	800
1.5	0.06	4.6	0.18	220	380	1.5	0.06	3.0	0.12	630	950
2.0	0.08	5.5	0.22	300	500	2.0	0.08	4.0	0.16	800	1300
2.5	0.10	6.5	0.26	550	-	2.5	0.10	5.0	0.20	900	-
3.0	0.12	8.0	0.31	700	-	3.0	0.12	6.0	0.24	1000	-

KPN

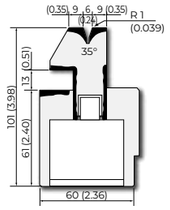
Per piece	1.0 kg

Accessory ✓

C45: 560-710 N/mm² — 600 kN/m max.

S101PN.35.06

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

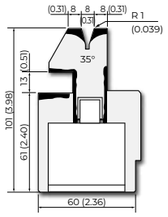


35° ✓

C45: 560-710 N/mm² — 600 kN/m max.

S101PN.35.08

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

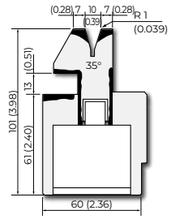


35° ✓

C45: 560-710 N/mm² — 600 kN/m max.

S101PN.35.10

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

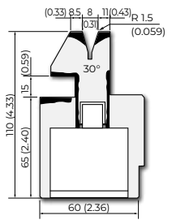


35° ✓

C45: 560-710 N/mm² — 800 kN/m max.

S110PN.30.08

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

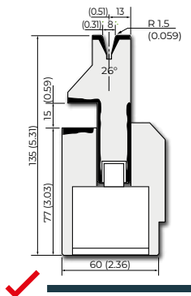


30° ✓

42Cr: 900-1150 N/mm² — 400 kN/m max.

S135PN.26.08

835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.2 kg

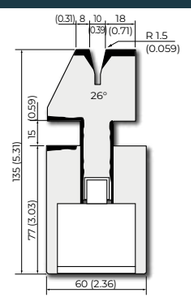


26° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

S135PN.26.10

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

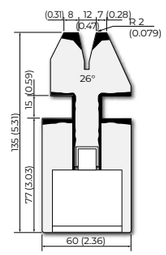


26° ✓

C45: 560-710 N/mm² — 1000 kN/m max.

SA135PN.26.12

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



26° ✓

Pneumatic Hemming Dies - R1

S [mm]	S [in]	A [mm]	A [in]	R.45 Kgf/mm² kN/m	R.70 Kgf/mm² kN/m
0.6	0.02	3.0	0.12	90	150
0.8	0.03	3.0	0.12	120	200
1.0	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260
1.5	0.06	4.6	0.18	220	380
2.0	0.08	5.5	0.22	300	500
2.5	0.10	6.5	0.26	550	-
3.0	0.12	8.0	0.31	700	-

S [mm]	S [in]	A [mm]	A [in]	R.45 Kgf/mm² kN/m	R.70 Kgf/mm² kN/m
0.6	0.02	1.2	0.05	230	350
0.8	0.03	1.6	0.06	320	500
1.0	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800
1.5	0.06	3.0	0.12	630	950
2.0	0.08	4.0	0.16	800	1300
2.5	0.10	5.0	0.20	900	-
3.0	0.12	6.0	0.24	1000	-

PUNCHES ROLLERI TYPE R2

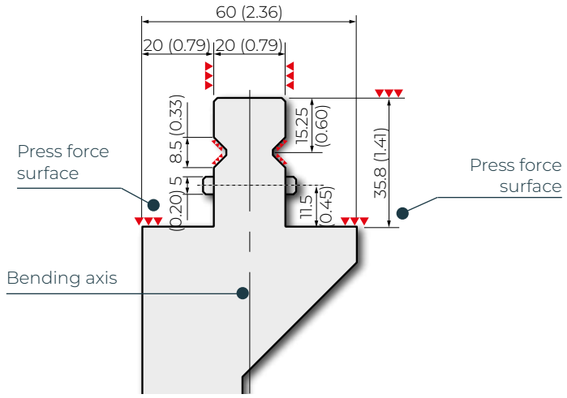
▼ **COMPATIBILITY**

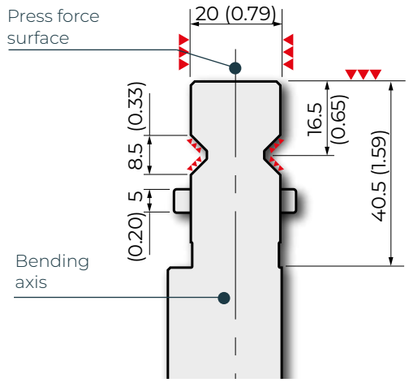
Darley
LVD
Safan
Trumpf
Press brake machines with System NSCL

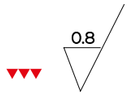
Content explanation	88 - 91
Punches	92 - 97
90°	92
86°	92 - 94
80°	94
60°	95 - 96
28°	96 - 97
Hemming Punches	98
Joggle Tools	99
Radius Tools and Hemming tool	100 - 101

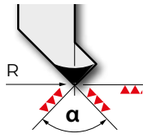
STANDARD TANG

: Press force surface



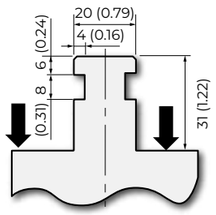




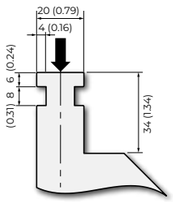


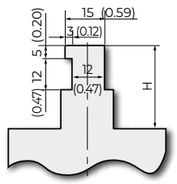
MODIFICATIONS FROM SAFETY GROOVES

Modification of R2 punch with shoulder bearing



Modification of R2 punch with head bearing





STANDARD LENGTH

100 mm (3.93 in)

250 mm (9.84 in)

500 mm (19.68 in)

515 mm (20.28 in)

525 mm (20.67 in)

Segmented

On stock

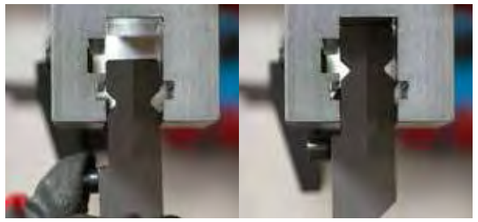
Ask for delivery time

CLAMPING SYSTEMS

QuickLock (Standard)

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

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



Safety Pins (Standard)

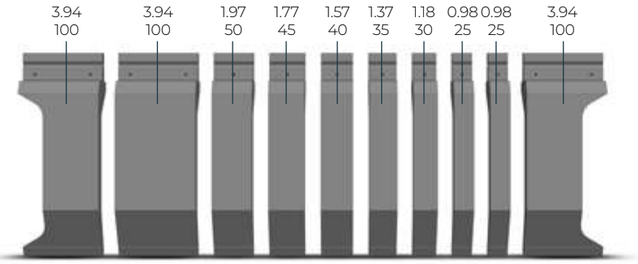
- Horizontal tool change

ROLI-System

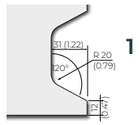
- Vertical tool change through spring-loaded ball bearings, which are mounted in the punch
- Increased longevity
- Easy handling
- To be used in hardened clamping systems only
- Applicable on tools < 12.5 kg

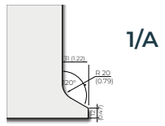
SEGMENTATION

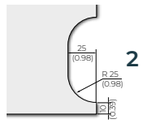
FW: 550 mm (21.65 in) - 10 segments



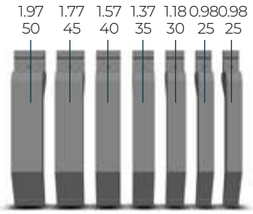
Horn types



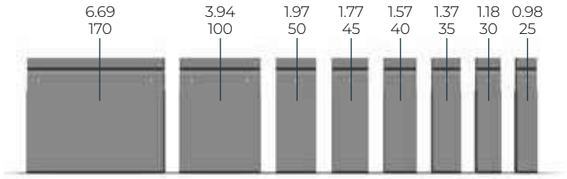




FC: 250 mm (9.84 in) - 7 segments



F: 495 mm (19.49 in) - 8 segments



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

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

Available on request

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

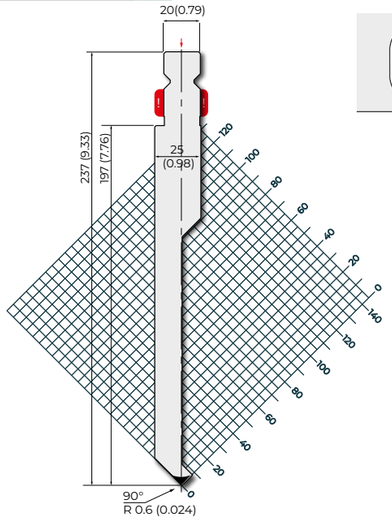
Length mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94) Horn l.	100 (3.94) Horn r.	100 (3.94)	200 (7.87)	300 (11.81)	500 (19.68)
1250 (49.21)	2	1	1	1	1	1	1	1	1	2	1	0
2050 (80.71)	2	1	1	1	1	1	1	1	1	1	1	2
2550 (100.39)	2	1	1	1	1	1	1	1	1	1	1	3
3050 (120.08)	2	1	1	1	1	1	1	1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

Available on request

42Cr: 900-1150 N/mm² — 600 kN/m max.

TPR237.90.R06

100 mm	3.93 in	3.4 kg	
250 mm	9.84 in	8.5 kg	
515 mm	20.82 in	17.5 kg	
550 mm	21.65 in	18.7 kg	FW



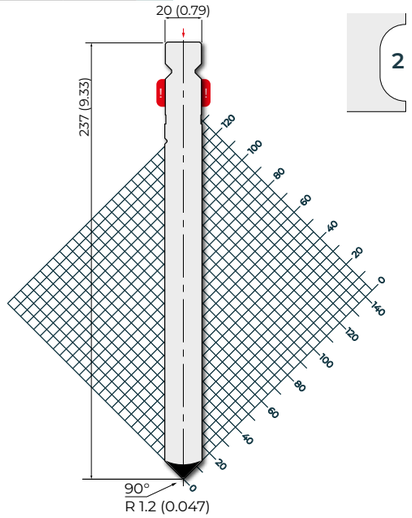
2

90°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

TPR237.90.R12

100 mm	3.93 in	3.7 kg	
250 mm	9.84 in	9.2 kg	
515 mm	20.82 in	19.0 kg	
550 mm	21.65 in	20.3 kg	FW



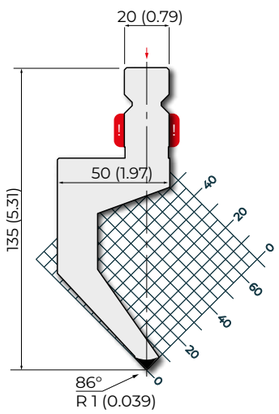
2

90°

42Cr: 900-1150 N/mm² — 650 kN/m max.

TPR135.86.R1

100 mm	3.93 in	2.4 kg	
250 mm	9.84 in	6.0 kg	
515 mm	20.82 in	12.3 kg	
550 mm	21.65 in	13.1 kg	FW



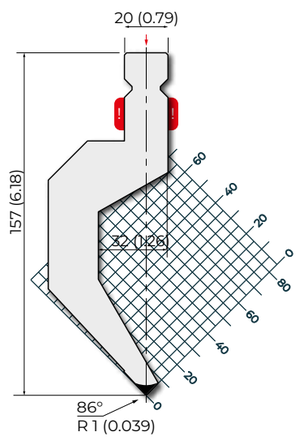
1/A

86°

42Cr: 900-1150 N/mm² — 800 kN/m max.

TPR157.86.R1

100 mm	3.93 in	3.0 kg	
500 mm	19.68 in	14.0 kg	
250 mm	9.84 in	7.5 kg	FC
550 mm	21.65 in	15.0 kg	FW



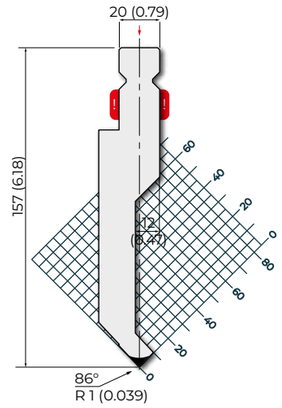
1/A

86°

42Cr: 900-1150 N/mm² — 800 kN/m max.

TPR157.86.R1-A

100 mm	3.93 in	2.5 kg	
500 mm	19.68 in	12.5 kg	
250 mm	9.84 in	6.2 kg	FC
550 mm	21.65 in	12.5 kg	FW



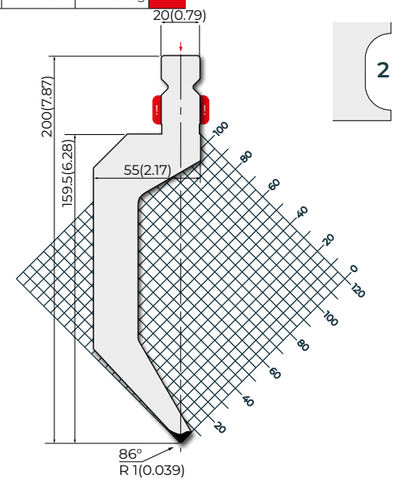
1/A

86°

42Cr: 900-1150 N/mm² — 500 kN/m max.

TPR200.86.R1

100 mm	3.93 in	3.7 kg	
250 mm	9.84 in	6.1 kg	
515 mm	20.82 in	19.1 kg	
550 mm	21.65 in	20.4 kg	FW



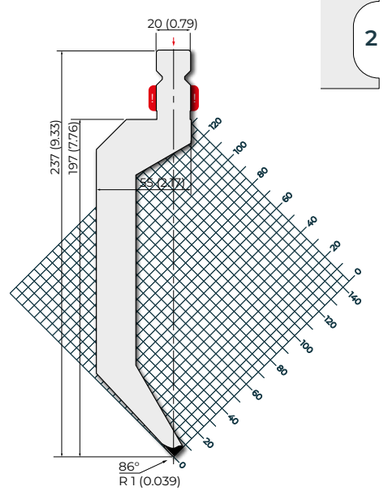
2

86°

42Cr: 900-1150 N/mm² — 500 kN/m max.

TPR237.86.R1

100 mm	3.93 in	4.5 kg	
250 mm	9.84 in	11.2 kg	
515 mm	20.82 in	23.0 kg	
550 mm	21.65 in	24.6 kg	FW



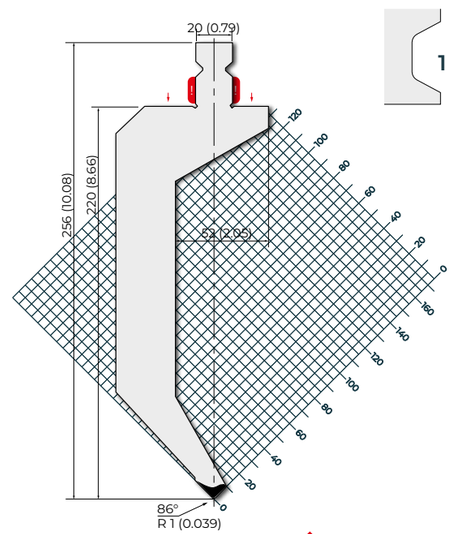
2

86°

42Cr: 900-1150 N/mm² — 800 kN/m max.

TPR256.86.R1

100 mm	3.93 in	6.5 kg	
500 mm	19.68 in	33.0 kg	
250 mm	9.84 in	16.5 kg	FC
550 mm	21.65 in	33.0 kg	FW



1

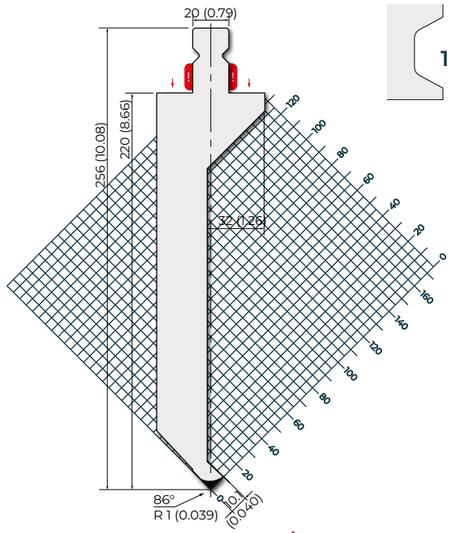
86°

Segmented · On stock · Ask for delivery time

42Cr: 900-1150 N/mm² — 800 kN/m max.

TPR256.86.R1-A

100 mm	3.93 in	4.7 kg	
500 mm	19.68 in	28.5 kg	
250 mm	9.84 in	12.5 kg	FC
550 mm	21.65 in	28.5 kg	FW

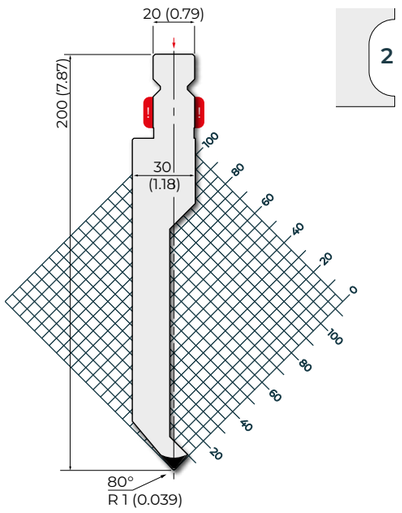


86°

42Cr: 900-1150 N/mm² — 800 kN/m max.

TPR200.80.R1

100 mm	3.93 in	3.7 kg	
250 mm	9.84 in	9.2 kg	
515 mm	20.82 in	19.0 kg	
550 mm	21.65 in	21.0 kg	FW

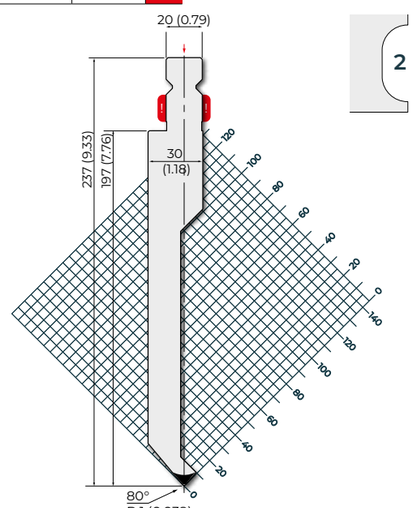


80°

42Cr: 900-1150 N/mm² — 800 kN/m max.

TPR237.80.R1

100 mm	3.93 in	3.8 kg	
250 mm	9.84 in	9.6 kg	
515 mm	20.82 in	19.7 kg	
550 mm	21.65 in	21.0 kg	FW

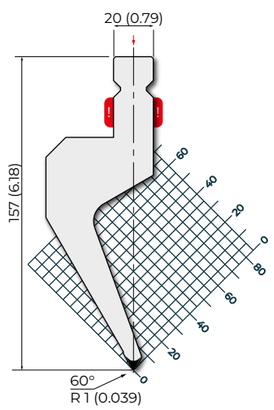


80°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TPR157.60.R1

100 mm	3.93 in	3.0 kg	
500 mm	19.68 in	15.0 kg	
250 mm	9.84 in	7.5 kg	FC
550 mm	21.65 in	16.5 kg	FW



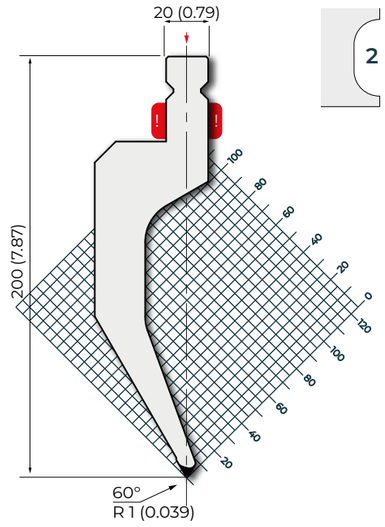
60°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TPR200.60.R1

100 mm	3.93 in	3.7 kg	
500 mm	19.68 in	18.3 kg	
250 mm	9.84 in	9.2 kg	FC
550 mm	21.65 in	20.2 kg	FW

NEW



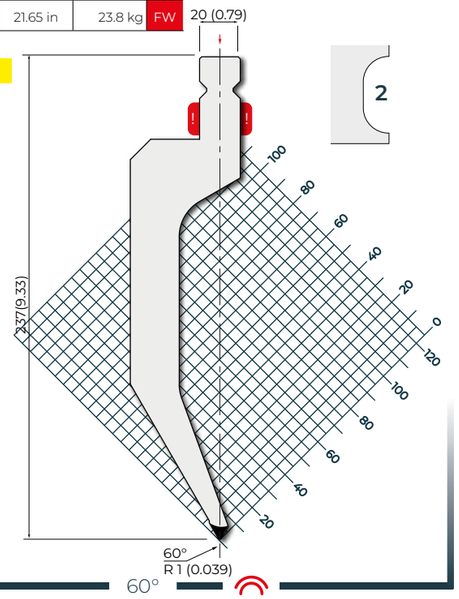
60°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TPR237.60.R1

100 mm	3.93 in	4.3 kg	
500 mm	19.68 in	21.6 kg	
250 mm	9.84 in	10.8 kg	FC
550 mm	21.65 in	23.8 kg	FW

NEW

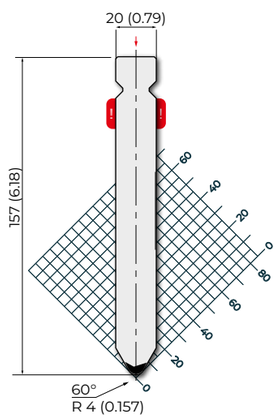


60°

42Cr: 900-1150 N/mm² — 1300 kN/m max.

TPR157.60.R4

100 mm	3.93 in	2.4 kg	
500 mm	19.68 in	12.0 kg	
250 mm	9.84 in	6.0 kg	FC
550 mm	21.65 in	12.0 kg	FW

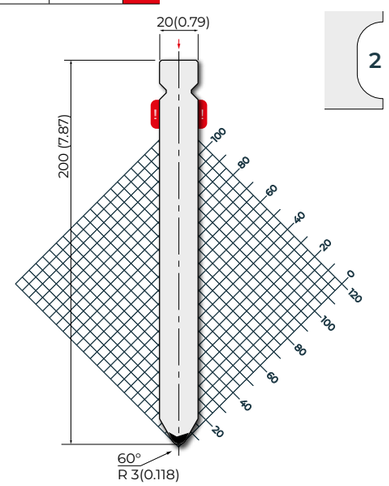


60°

42Cr: 900-1150 N/mm² — 1300 kN/m max.

TPR200.60.R3

100 mm	3.93 in	3.0 kg	
250 mm	9.84 in	7.6 kg	
515 mm	20.82 in	15.6 kg	
550 mm	21.65 in	16.7 kg	FW



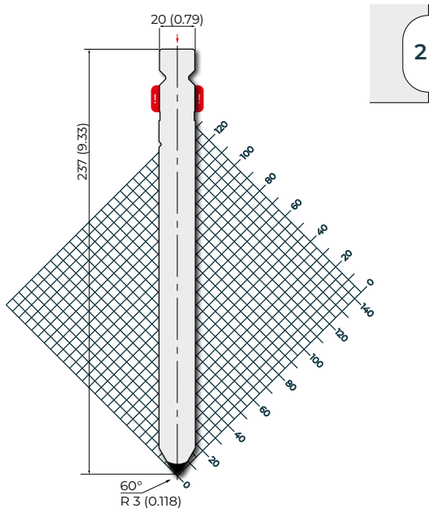
60°

Segmented — On stock — Ask for delivery time

42Cr: 900-1150 N/mm² — 1300 kN/m max.

TPR237.60.R3

100 mm	3.93 in	3.6 kg	
250 mm	9.84 in	9.1 kg	
515 mm	20.82 in	18.8 kg	
550 mm	21.65 in	20.1 kg	FW

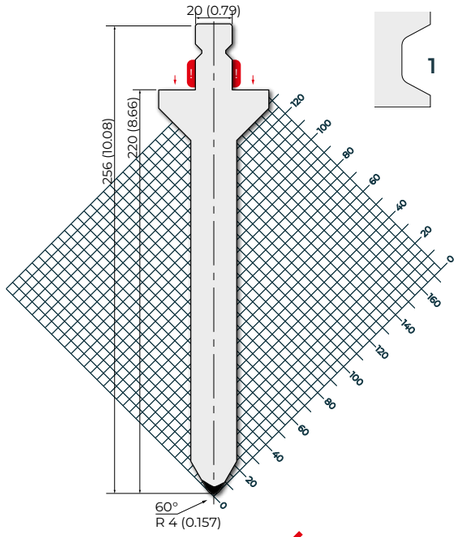


60°

42Cr: 900-1150 N/mm² — 1300 kN/m max.

TPR256.60.R4

100 mm	3.93 in	5.2 kg	
500 mm	19.68 in	26.1 kg	
250 mm	9.84 in	13.5 kg	FC
550 mm	21.65 in	27.0 kg	FW

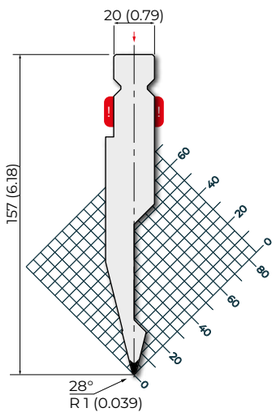


60°

42Cr: 900-1150 N/mm² — 600 kN/m max.

TPR157.28.R1

100 mm	3.93 in	2.0 kg	
500 mm	19.68 in	10.0 kg	
250 mm	9.84 in	5.0 kg	FC
550 mm	21.65 in	10.0 kg	FW

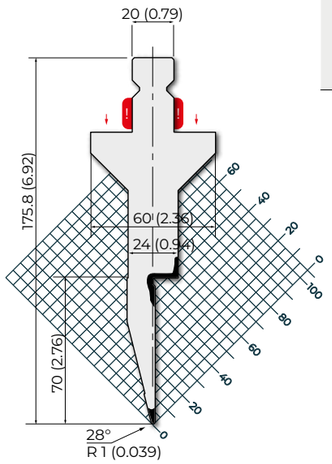


28°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TPR176.28.R1

100 mm	3.93 in	3.0 kg	
500 mm	19.68 in	15.0 kg	
250 mm	9.84 in	7.5 kg	FC
550 mm	21.65 in	10.0 kg	FW



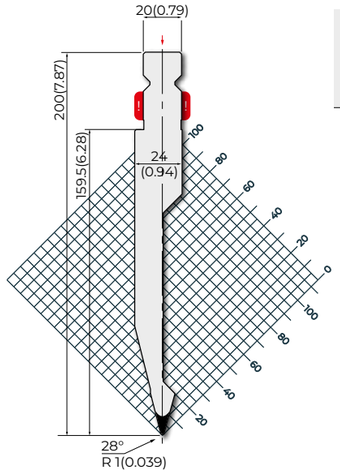
28°

Segmented · On stock · Ask for delivery time

42Cr: 900-1150 N/mm² — 600 kN/m max.

TPR200.28.R1

100 mm	3.93 in	2.4 kg	
250 mm	9.84 in	6.1 kg	
515 mm	20.82 in	12.6 kg	
550 mm	21.65 in	13.5 kg	FW

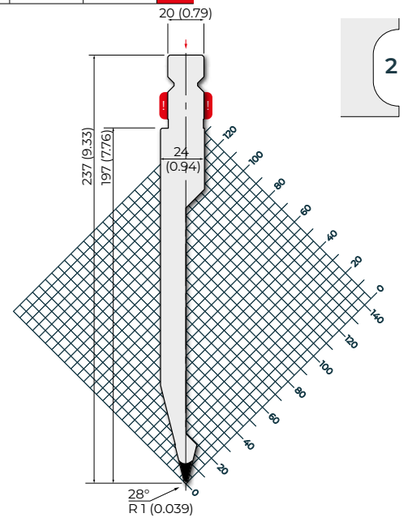


28°

42Cr: 900-1150 N/mm² — 600 kN/m max.

TPR237.28.R1

100 mm	3.93 in	2.9 kg	
250 mm	9.84 in	7.3 kg	
515 mm	20.82 in	15.0 kg	
550 mm	21.65 in	16.0 kg	FW

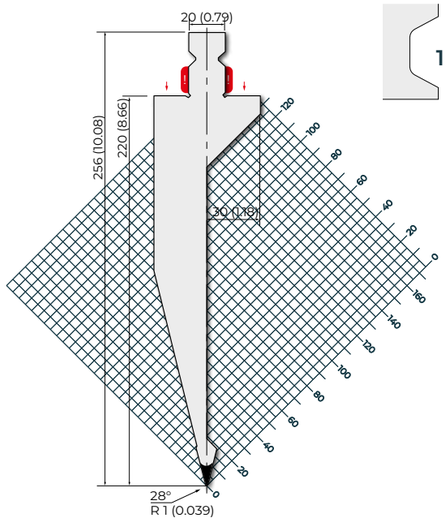


28°

42Cr: 900-1150 N/mm² — 600 kN/m max.

TPR256.28.R1

100 mm	3.93 in	5.0 kg	
500 mm	19.68 in	25.0 kg	
250 mm	9.84 in	12.5 kg	FC
550 mm	21.65 in	28.0 kg	FW

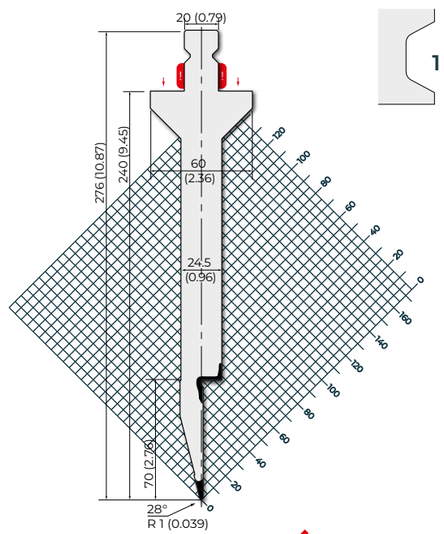


28°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TPR276.28.R1

100 mm	3.93 in	4.8 kg	
500 mm	19.68 in	24.0 kg	
250 mm	9.84 in	12.0 kg	FC
550 mm	21.65 in	26.4 kg	FW



28

R2

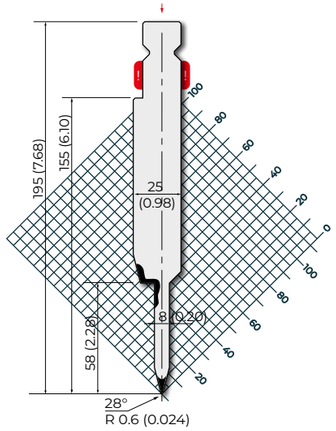
Hemming Punches - R2

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

TPR.SP.195.28.8

100 mm	3.93 in	2.9 kg
525 mm	20.67 in	15.1 kg
495 mm	19.49 in	8.9 kg F

To use with:
- TPR.SM.195.28.8 (page 142)



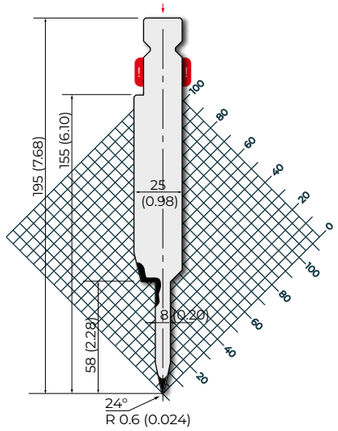
28°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

TPR.SP.195.24.8

100 mm	3.93 in	2.9 kg
525 mm	20.67 in	15.0 kg
495 mm	19.49 in	8.9 kg F

To use with:
- TPR.SM.195.24.8 (page 142)



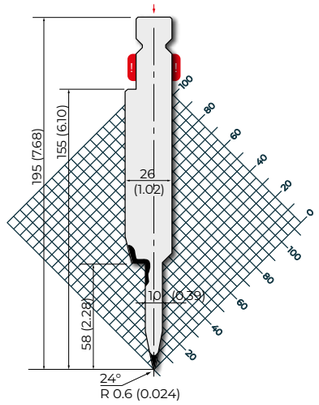
24°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

TPR.SP.195.24.10

100 mm	3.93 in	3.0 kg
525 mm	20.67 in	15.5 kg
495 mm	19.49 in	9.3 kg F

To use with:
- TPR.SM.195.24.10 (page 142)



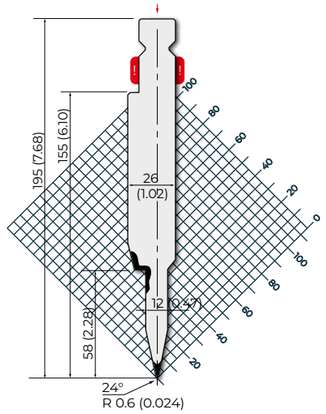
24°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

TPR.SP.195.24.12

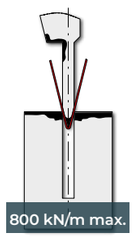
100 mm	3.93 in	3.0 kg
525 mm	20.67 in	16.0 kg
495 mm	19.49 in	9.5 kg F

To use with:
- TPR.SM.195.24.12 (page 142)

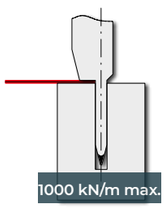


24°

Ex. Application



800 kN/m max.



1000 kN/m max.

S [mm]	S (in)	A [mm]	A (in)	R.420 kN/mm² kN/m	R.700 kN/mm² kN/m
0.6	0.02	3.0	0.12	90	150
0.8	0.03	3.0	0.12	120	200
1.0	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260

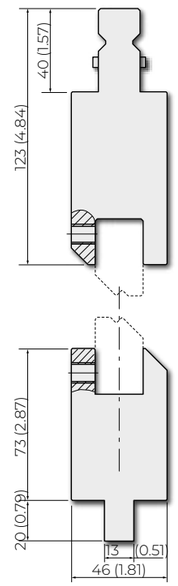
S [mm]	S (in)	A [mm]	A (in)	R.420 kN/mm² kN/m	R.700 kN/mm² kN/m
0.6	0.02	1.2	0.05	230	350
0.8	0.03	1.6	0.06	320	500
1.0	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800

Joggle Tools - R2

C45: 560-710 N/mm² — 1000 kN/m max.

TPZ

835 mm	32.87 in	46.7 kg
415 mm	16.34 in	23.2 kg

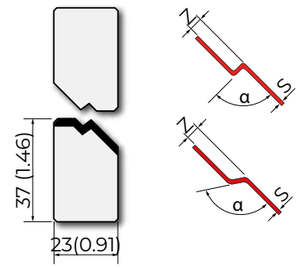


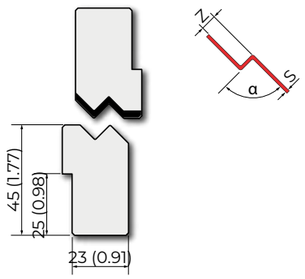
C45: 560-710 N/mm² — 1000 kN/m max.

Joggle Tool Inserts

	Z [mm]	Z (in)	α	S* [mm]	S* (in)	835 mm / 32.87 in	415 mm / 16.34 in	
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg	A
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg	A
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg	A
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg	A
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg	A
CEZ 1.5/90	1.5	0.06	90°	0.3	0.01	11.0 kg	5.5 kg	A
CEZ 2.0/90	2.0	0.08	90°	0.4	0.02	11.0 kg	5.5 kg	A
CEZ 2.5/90	2.5	0.10	90°	0.5	0.02	11.0 kg	5.5 kg	A
CEZ 3.0	3.0	0.12	90°	1.0	0.04	10.3 kg	5.1 kg	A
CEZ 3.5	3.5	0.14	90°	1.0	0.04	10.0 kg	5.0 kg	A
CEZ 4.0	4.0	0.16	90°	1.2	0.05	10.0 kg	5.0 kg	A
CEZ 4.5	4.5	0.18	90°	1.2	0.06	10.0 kg	5.0 kg	A
CEZ 5.0	5.0	0.20	90°	1.3	0.06	10.0 kg	5.0 kg	A
CEZ 5.5	5.5	0.22	90°	1.4	0.06	10.0 kg	5.0 kg	A
CEZ 6.0	6.0	0.24	90°	1.5	0.06	10.0 kg	5.0 kg	A
CEZ 6.5	6.5	0.26	90°	1.5	0.06	10.0 kg	5.0 kg	A
CEZ 7.0	7.0	0.28	90°	1.5	0.06	10.0 kg	5.0 kg	A
CEZ 7.5	7.5	0.30	90°	1.6	0.06	10.0 kg	5.0 kg	A
CEZ 8.0	8.0	0.31	90°	1.6	0.06	10.0 kg	5.0 kg	A
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg	6.5 kg	B
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg	5.0 kg	B
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	5.0 kg	B
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	5.0 kg	B
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	5.0 kg	B
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	5.0 kg	B
CEZ 15.0	15	0.59	90°	2.3	0.09	13.5 kg	5.0 kg	B

* Fe Rmax = 420 N/mm²



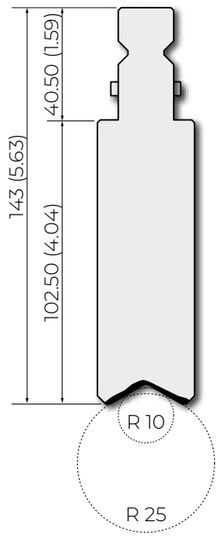


Radius punches - R2

42Cr: 900-1150 N/mm² — 1000 kN/m max.

TPR143.10

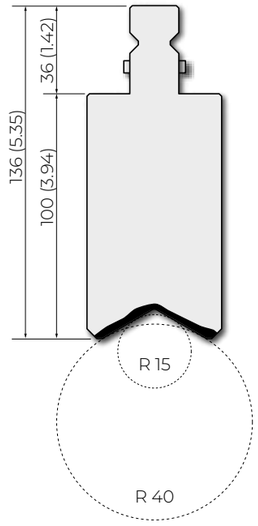
525 mm	20.67 in	18.0 kg	
495 mm	19.49 in	17.0 kg	F



42Cr: 900-1150 N/mm² — 1000 kN/m max.

TPR136.15

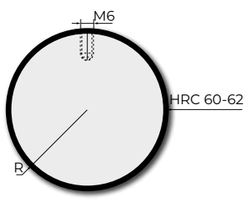
525 mm	20.67 in	25.0 kg	
495 mm	19.49 in	23.7 kg	F



C53: 610-760 N/mm² — 1000 kN/m max.

Radius punches: R10-R40

	R [mm]	R (in)				
TOP.C10	10	0.39	525 mm / 20.67 in	1.3 kg	495 mm / 16.34 in	2.7 kg
TOP.C12.5	12.5	0.49		2.0 kg		2.8 kg
TOP.C15	15	0.59		3.0 kg		3.8 kg
TOP.C17.5	17.5	0.69		4.0 kg		4.7 kg
TOP.C20	20	0.79		5.2 kg		6.6 kg
TOP.C22.5	22.5	0.88		6.6 kg		6.6 kg
TOP.C25	25	0.98		8.1 kg		7.5 kg
TOP.C27.5	27.5	1.08		9.8 kg		9.2 kg
TOP.C30	30	1.18		11.7 kg		11.3 kg
TOP.C32.5	32.5	1.28		13.7 kg		12.9 kg
TOP.C35	35	1.38		16.0 kg		15.1 kg
TOP.C37.5	37.5	1.47		18.2 kg		17.2 kg
TOP.C40	40	1.57		20.7 kg		19.5 kg

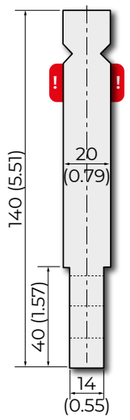


Radius Tools and Hemming tool - R2

C45: 560-710 N/mm² — 800 kN/m max.

TPR140-14

830 mm	32.69 in	17.0 kg
412 mm	16.22 in	9.0 kg

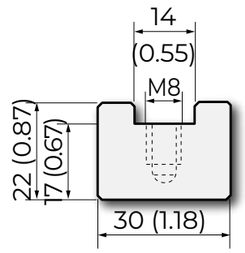


C45: 560-710 N/mm² — 800 kN/m max.

E30.22

830 mm	32.69 in	3.5 kg
412 mm	16.22 in	1.7 kg

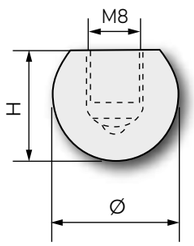
▸ Hemming tool

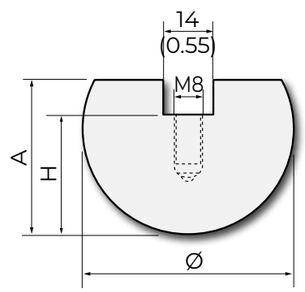


C45: 560-710 N/mm² — 800 kN/m max.

Radius tool: ø 16 - 100

	Ø [mm]	Ø (in)	A [mm]	A (in)	H [mm]	H (in)			
C13.08	16	0.63	13	0.51	-	-	835 mm / 32.87 in	2.0 kg	415 mm / 16.34 in	1.0 kg
C13.09	18	0.71	16	0.63	-	-		2.0 kg		1.0 kg
C16.10	20	0.79	16	0.63	-	-		2.0 kg		1.0 kg
C17.12	25	0.98	17	0.67	22	0.86		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	0.86	32	1.26		5.0 kg		2.4 kg
C24.20	40	1.57	24	0.94	34	1.33		7.0 kg		3.5 kg
C25.22	45	1.78	25	0.98	35	1.33		7.5 kg		3.8 kg
C29.25	50	1.97	29	1.14	39	1.53		10.0 kg		4.7 kg
C34.27	55	2.16	34	1.33	44	1.73		12.4 kg		6.2 kg
C34.30	60	2.36	34	1.33	44	1.73		13.5 kg		6.7 kg
C37.32	65	2.56	37	1.45	47	1.85		15.9 kg		7.9 kg
C45.35	70	2.75	45	1.77	55	2.16		20.3 kg		10.0 kg
C42.37	75	2.95	42	1.65	52	2.04		20.5 kg		10.3 kg
C45.40	80	3.15	45	1.78	55	2.16		23.0 kg		11.5 kg
C60.45	90	3.54	60	2.36	70	2.75		34.0 kg		17.0 kg
C70.50	100	3.93	70	2.75	80	3.15		43.5 kg		21.7 kg





PUNCHES ROLLERI TYPE R3

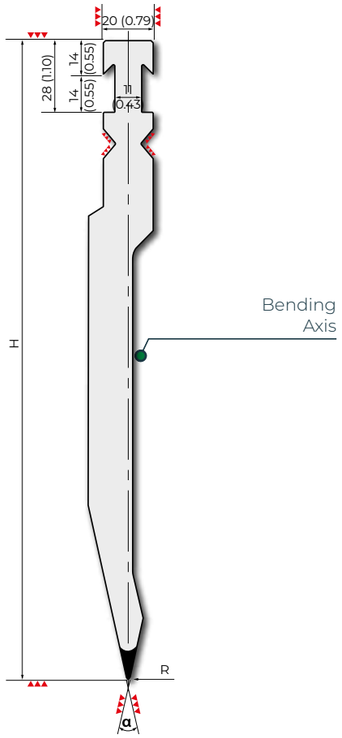
▼ **COMPATIBILITY**

Bystronic Beyeler:
RFA
RF
R
S

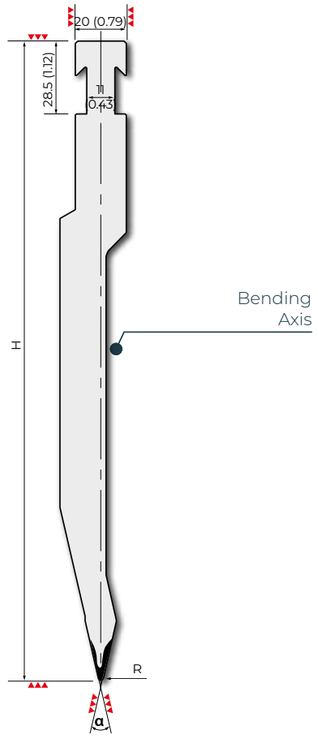
Content Expalanation	104 - 105
Punches	106 - 115
Bystronic-Beyeler R3 RFA	106 - 108
Bystronic-Beyeler R3 RFA Hemming Tools	109
Bystronic-Beyeler R3 RF	110
Bystronic-Beyeler R3 R	111 - 113
Bystronic-Beyeler R3 S	114 - 115
Joggle Tools	116 - 117
Radius Tools and Hemming Tool	118 - 121

STANDARD TANG

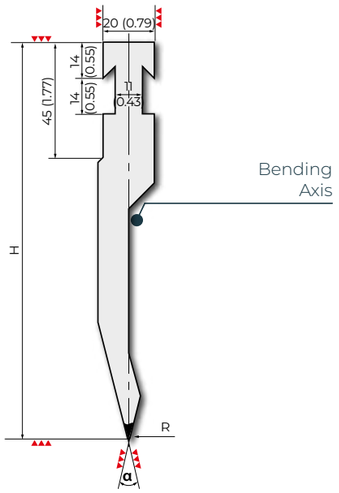
R3 RFA



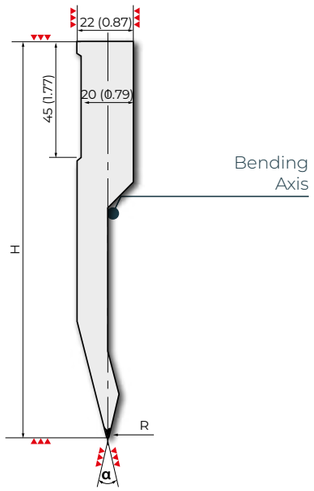
R3 RF

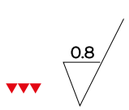


R3 R



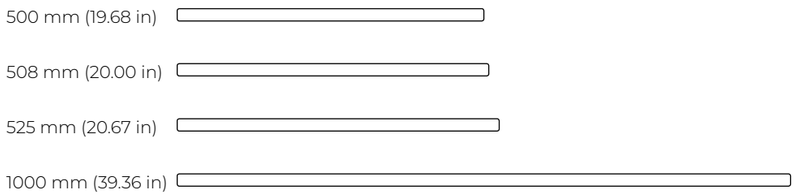
R3 S





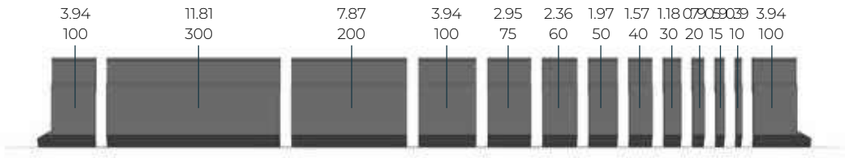
R3

STANDARD LENGTH



SEGMENTATION

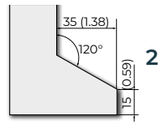
F - Punches BP: 1100 mm (43.30 in)- 13 segments



Horn types

1

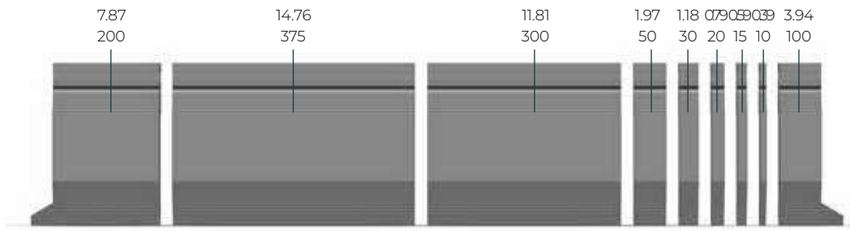
R3 BP

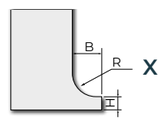


2

R3 BPR

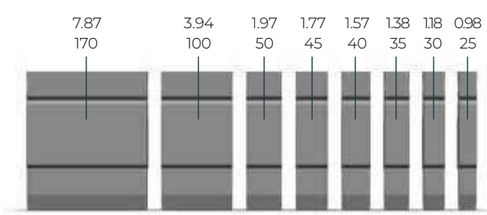
F - Punches BPR: 1100 mm (43.30 in) - 9 segments





Production according to your specifications

F: 495 mm (19.48 in) - 8 segments



Segmented

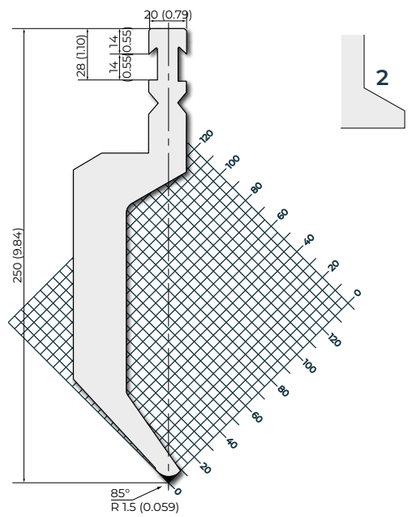
On stock

Ask for delivery time

42Cr: 900-1150 N/mm² — 900 kN/m max.

BPR250.P4-RFA

508 mm	20.00 in	27.4 kg
1100 mm	43.31 in	59.0 kg F



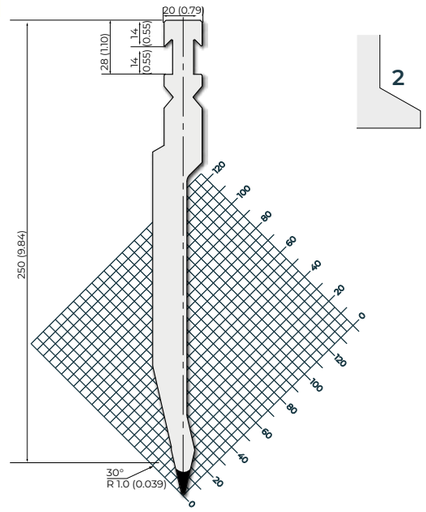
85°

42Cr: 900-1150 N/mm² — 750 kN/m max.

BPR250.P5.30-RFA

508 mm	20.00 in	13.2 kg
1100 mm	43.31 in	28.6 kg F

NEW



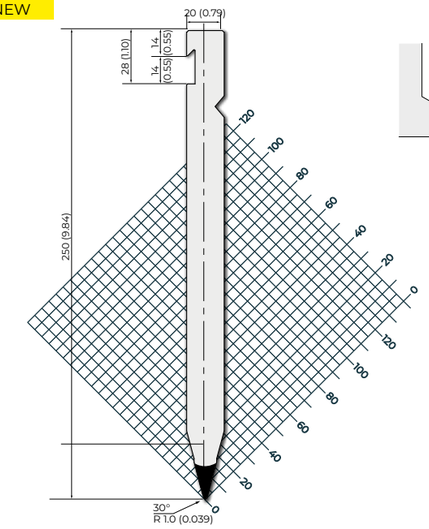
30°

42Cr: 900-1150 N/mm² — 1400 kN/m max.

BPR.250.P6-RFA

508 mm	20.00 in	17.8 kg
1100 mm	43.31 in	38.5 kg F

NEW



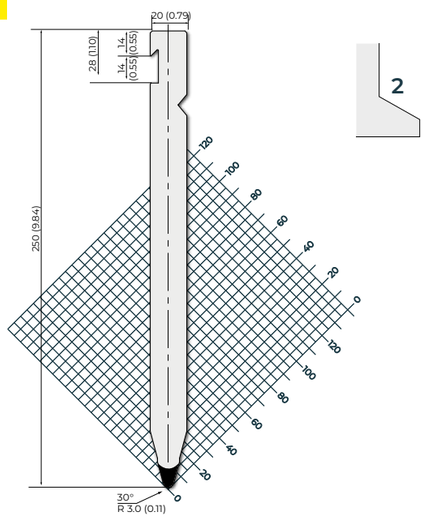
30°

42Cr: 900-1150 N/mm² — 1400 kN/m max.

BPR.250.P7-RFA

508 mm	20.00 in	18.5 kg
1100 mm	43.31 in	40.1 kg F

NEW

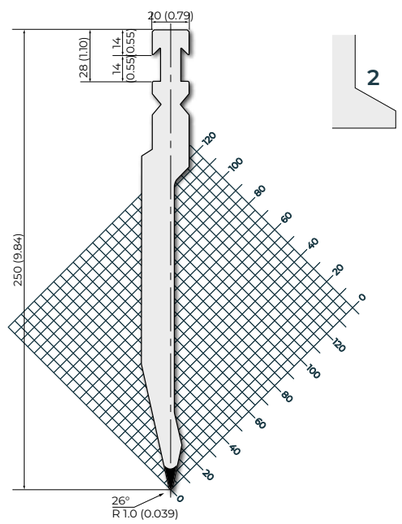


30°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

BPR250.P5-RFA

508 mm	20.00 in	26.0 kg
1100 mm	43.31 in	57.0 kg F



26°

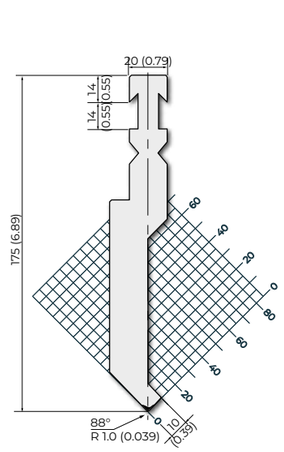
R3

Segmented · On stock · Ask for delivery time

42Cr: 900-1150 N/mm² — 1000 kN/m max.

BP175.88.R1-A-RFA

1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm	43.31 in	25.3 kg F

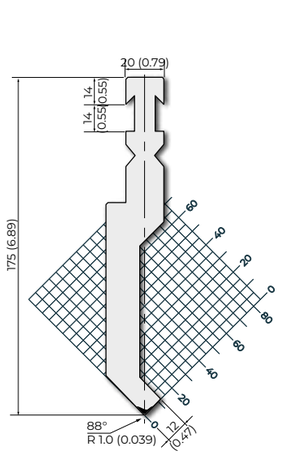


88°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

BP175.88.R1-B-RFA

1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm	43.31 in	25.3 kg F

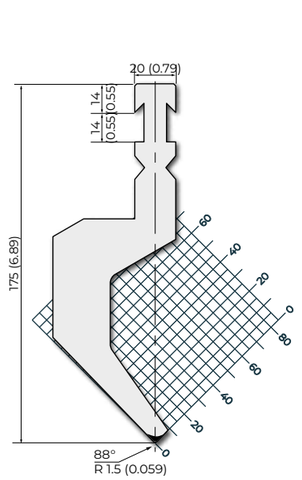


88°

42Cr: 900-1150 N/mm² — 500 kN/m max.

BP175.88.R15-RFA

1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm	43.31 in	23.0 kg F

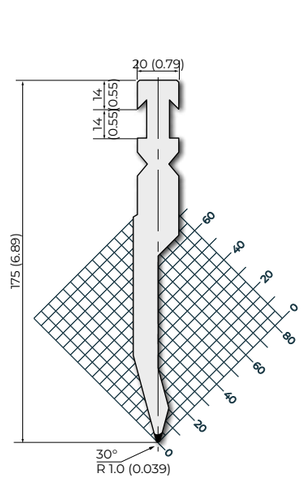


85°

42Cr: 900-1150 N/mm² — 900 kN/m max.

BP175.30.R1-RFA

1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm	43.31 in	16.0 kg F



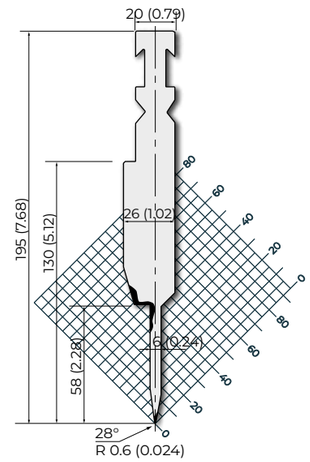
30°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

BPR.SP-195.28.6

525 mm	20.67 in	8.7 kg
495 mm	19.49 in	8.2 kg F

To use with:
- BPR.SM.195.28.6 (page 142)



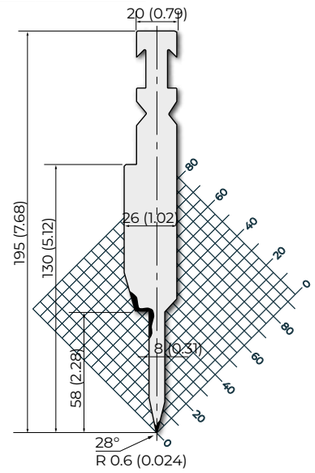
28°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

BPR.SP-195.28.8

525 mm	20.67 in	8.7 kg
495 mm	19.49 in	8.2 kg F

To use with:
- BPR.SM.195.28.8 (page 142)



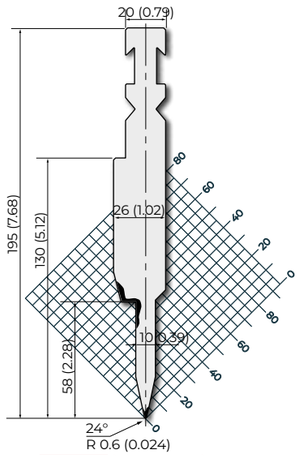
28°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

BPR.SP-195.24.10

525 mm	20.67 in	8.7 kg
495 mm	19.49 in	8.2 kg F

To use with:
- BPR.SM.195.24.10 (page 142)



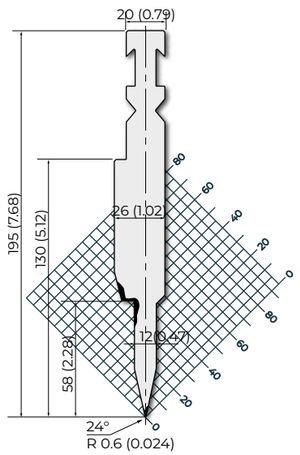
24°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

BPR.SP-195.24.12

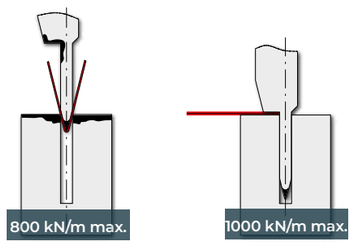
525 mm	20.67 in	8.7 kg
495 mm	19.49 in	8.2 kg F

To use with:
- BPR.SM.195.24.12 (page 142)



24°

Ex. Application



S [mm]	S (in)	A [mm]	A (in)	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	3.0	0.12	90	150
0.8	0.03	3.0	0.12	120	200
1.0	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260

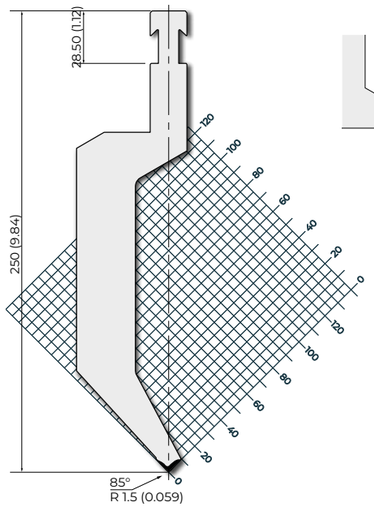
S [mm]	S (in)	A [mm]	A (in)	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	1.2	0.05	230	350
0.8	0.03	1.6	0.06	320	500
1.0	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800

R3

42Cr: 900-1150 N/mm² — 1000 kN/m max.

BPR250.P4-RF

508 mm	20.00 in	27.6 kg
1100 mm	43.31 in	51.0 kg F



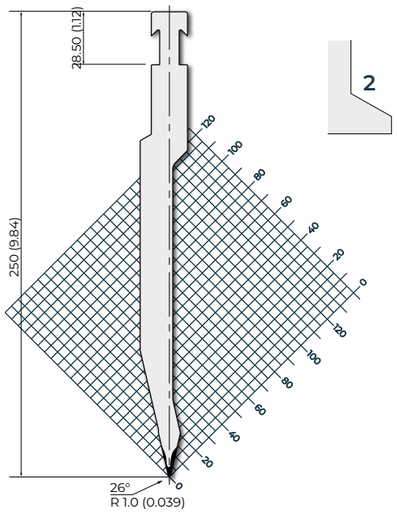
2

85°

42Cr: 900-1150 N/mm² — 900 kN/m max.

BPR250.P5-RF

508 mm	20.00 in	16.6 kg
1100 mm	43.31 in	35.0 kg F



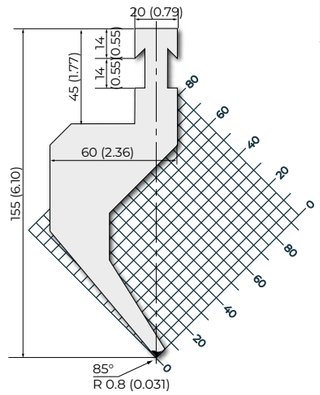
2

26°

42Cr: 900-1150 N/mm² — 500 kN/m max.

BP155.85.R08-R

1000 mm	39.37 in	22.0 kg
500 mm	19.68 in	12.5 kg
1100 mm	43.31 in	21.5 kg F



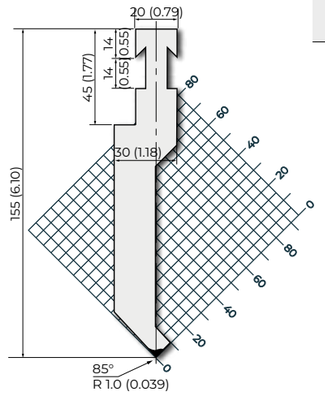
1

85°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

BP155.85.R1-R

1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm	43.31 in	23.0 kg F



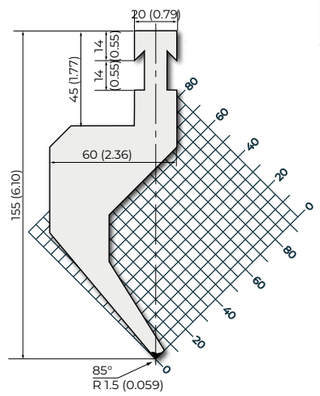
1

85°

42Cr: 900-1150 N/mm² — 500 kN/m max.

BP155.85.R15-R

1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm	43.31 in	32.0 kg F



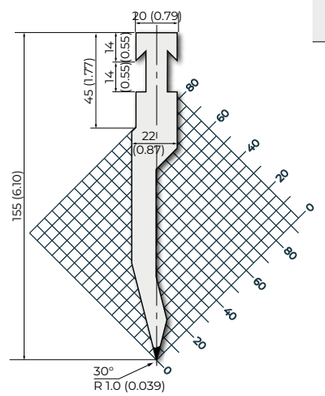
1

85°

42Cr: 900-1150 N/mm² — 800 kN/m max.

BP155.30.R1-R

1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm	43.31 in	18.0 kg F



1

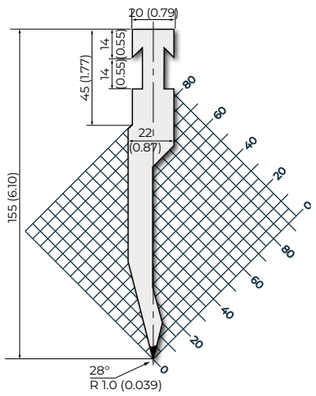
30°

R3

42Cr: 900-1150 N/mm² — 800 kN/m max.

BP155.28.R1-R

1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm	43.31 in	17.5 kg F

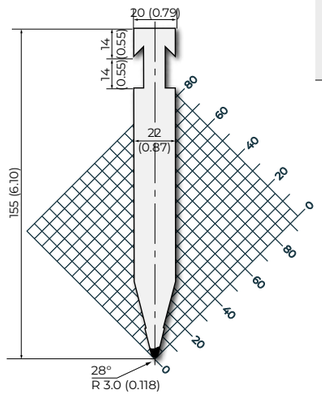


28°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

BP155.28.R3-R

1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	11.0 kg
1100 mm	43.31 in	23.5 kg F



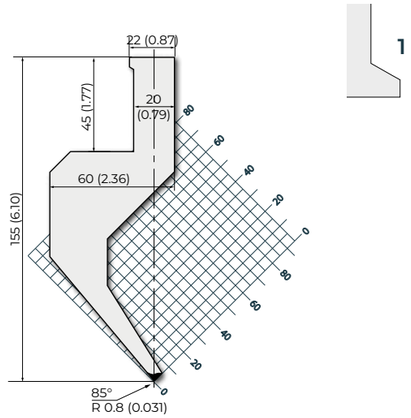
28°

R3

42Cr: 900-1150 N/mm² — 500 kN/m max.

BP155.85.R08-S

1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm	43.31 in	17.5 kg F

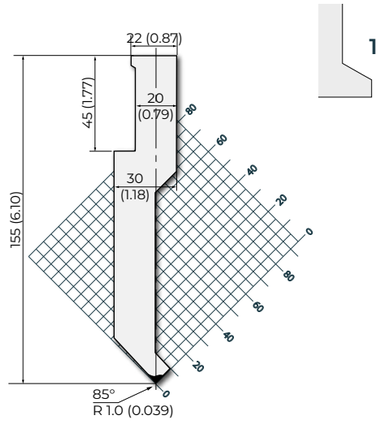


85°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

BP155.85.R1-S

1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm	43.31 in	35.2 kg F

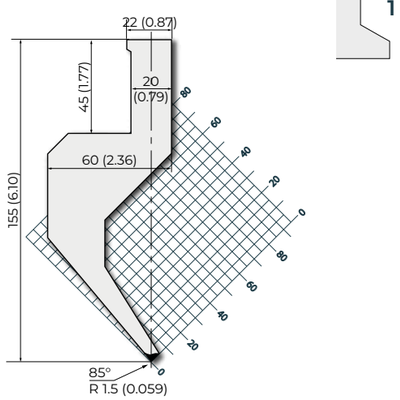


85°

42Cr: 900-1150 N/mm² — 500 kN/m max.

BP155.85.R15-S

1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.5 kg
1100 mm	43.31 in	32.0 kg F

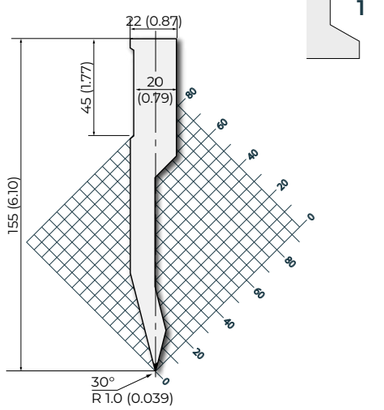


85°

42Cr: 900-1150 N/mm² — 800 kN/m max.

BP155.30.R1-S

1000 mm	39.37 in	17.5 kg
500 mm	19.68 in	9.0 kg
1100 mm	43.31 in	17.5 kg F



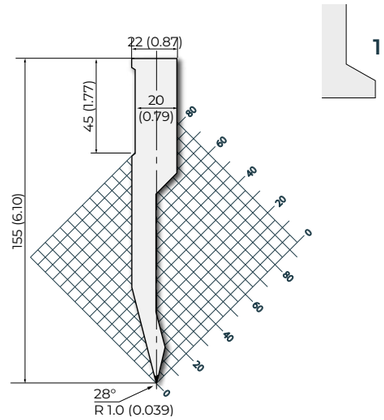
30°

Punches - Bystronic-Beyeler R3 S

42Cr: 900-1150 N/mm² — 500 kN/m max.

BP155.28.R1-S

1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm	43.31 in	17.5 kg F

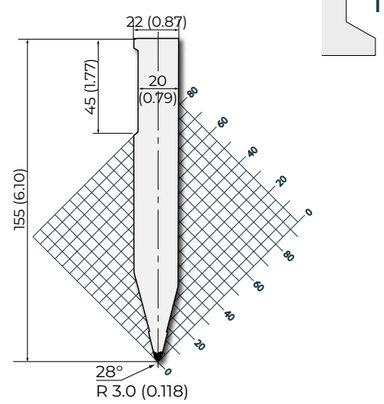


28°

C45: 560-710 N/mm² — 1000 kN/m max.

BP155.28.R3-S

1000 mm	39.37 in	23.5 kg
500 mm	19.68 in	12.0 kg
1100 mm	43.31 in	23.5 kg F



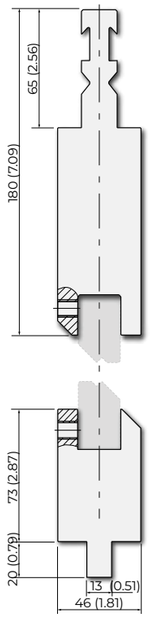
28°

C45: 560-710 N/mm²

1000 kN/m max.

BPZ-RFA

835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.7 kg

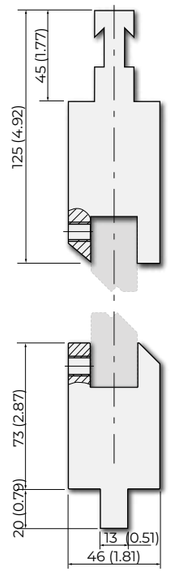


C45: 560-710 N/mm²

1000 kN/m max.

BPZ-R

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

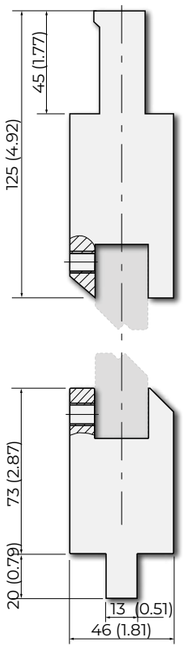


C45: 560-710 N/mm²

1000 kN/m max.

BPZ-S

835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.5 kg



Joggle Tools - R3

C45: 560-710 N/mm²

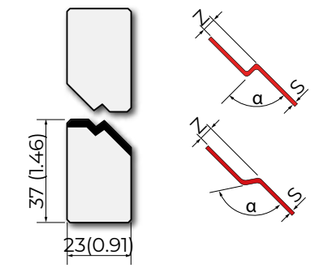
1000 kN/m max.

Joggle Tool Inserts

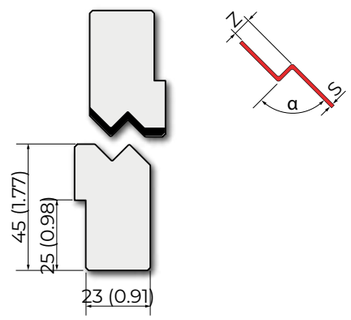
	Z [mm]	Z [in]	α	S* [mm]	S* [in]				
CEZ 1.0	1.0	0.04	160°	1.2	0.05	835 mm / 32.87 in	11.0 kg	415 mm / 16.34 in 5.5 kg	A
CEZ 1.5	1.5	0.06	160°	1.5	0.06		11.0 kg	5.5 kg	A
CEZ 2.0	2.0	0.08	150°	1.4	0.06		11.0 kg	5.5 kg	A
CEZ 2.5	2.5	0.10	140°	1.3	0.05		11.0 kg	5.5 kg	A
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01		11.0 kg	5.5 kg	A
CEZ 1.5/90	1.5	0.06	90°	0.3	0.01		11.0 kg	5.5 kg	A
CEZ 2.0/90	2.0	0.08	90°	0.4	0.02		11.0 kg	5.5 kg	A
CEZ 2.5/90	2.5	0.10	90°	0.5	0.02		11.0 kg	5.5 kg	A
CEZ 3.0	3.0	0.12	90°	1.0	0.04		10.3 kg	5.1 kg	A
CEZ 3.5	3.5	0.14	90°	1.0	0.04		10.0 kg	5.0 kg	A
CEZ 4.0	4.0	0.16	90°	1.2	0.05		10.0 kg	5.0 kg	A
CEZ 4.5	4.5	0.18	90°	1.2	0.05		10.0 kg	5.0 kg	A
CEZ 5.0	5.0	0.20	90°	1.3	0.05		10.0 kg	5.0 kg	A
CEZ 5.5	5.5	0.22	90°	1.4	0.06		10.0 kg	5.0 kg	A
CEZ 6.0	6.0	0.24	90°	1.5	0.06		10.0 kg	5.0 kg	A
CEZ 6.5	6.5	0.26	90°	1.5	0.06		10.0 kg	5.0 kg	A
CEZ 7.0	7.0	0.28	90°	1.5	0.06		10.0 kg	5.0 kg	A
CEZ 7.5	7.5	0.30	90°	1.6	0.06		10.0 kg	5.0 kg	A
CEZ 8.0	8.0	0.31	90°	1.6	0.06		10.0 kg	5.0 kg	A
CEZ 9.0	9	0.35	90°	1.8	0.07		13.5 kg	6.5 kg	B
CEZ 10.0	10	0.39	90°	1.8	0.07		13.5 kg	5.0 kg	B
CEZ 11.0	11	0.43	90°	2	0.08		13.5 kg	5.0 kg	B
CEZ 12.0	12	0.47	90°	2	0.08		13.5 kg	5.0 kg	B
CEZ 13.0	13	0.51	90°	2	0.08		13.5 kg	5.0 kg	B
CEZ 14.0	14	0.55	90°	2	0.08		13.5 kg	5.0 kg	B
CEZ 15.0	15	0.59	90°	2.3	0.09		13.5 kg	5.0 kg	B

* Fe Rmax = 420 N/mm²

A



B

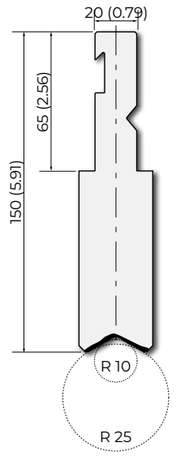


R3

42Cr: 900-1150 N/mm² — 1000 kN/m max.

BPR150.P10.10-RFA

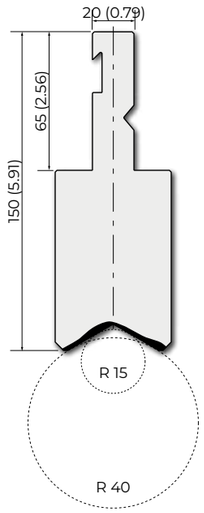
522 mm	20.55 in	16.5 kg
495 mm	19.49 in	16.0 kg



42Cr: 900-1150 N/mm² — 1000 kN/m max.

BPR150.P10.15-RFA

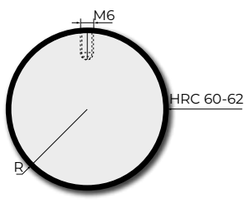
522 mm	20.55 in	23.0 kg
495 mm	19.49 in	21.7 kg



C53: 610-760 N/mm² — 1000 kN/m max.

Radius punches: R08-R40

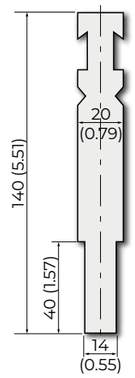
	R [mm]	R [in]	525 mm / 20.67 in	495 mm / 16.34 in
TOP.C08	8	0.31	0,8 kg	1,9 kg
TOP.C10	10	0.39	1,3 kg	2,7 kg
TOP.C12.5	12.5	0.49	2,0 kg	2,8 kg
TOP.C15	15	0.59	3,0 kg	3,8 kg
TOP.C17.5	17.5	0.69	4,0 kg	4,7 kg
TOP.C20	20	0.79	5,2 kg	6,6 kg
TOP.C22.5	22.5	0.88	6,6 kg	6,6 kg
TOP.C25	25	0.98	8,1 kg	7,5 kg
TOP.C27.5	27.5	1.08	9,8 kg	9,2 kg
TOP.C30	30	1.18	11,7 kg	11,3 kg
TOP.C32.5	32.5	1.28	13,7 kg	12,9 kg
TOP.C35	35	1.38	16,0 kg	15,1 kg
TOP.C37.5	37.5	1.47	18,2 kg	17,2 kg
TOP.C40	40	1.57	20,7 kg	19,5 kg



C45: 560-710 N/mm² — 800 kN/m max.

BPU-RFA

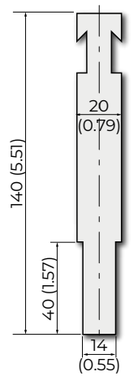
830 mm	32.68 in	15.3 kg
410 mm	16.14 in	7.6 kg



C45: 560-710 N/mm² — 800 kN/m max.

BPU-R

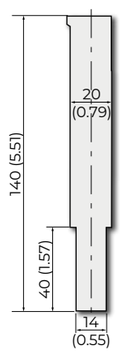
830 mm	32.68 in	15.8 kg
410 mm	16.14 in	7.8 kg



C45: 560-710 N/mm² — 800 kN/m max.

BPU-S

830 mm	32.68 in	16.8 kg
410 mm	16.14 in	8.3 kg

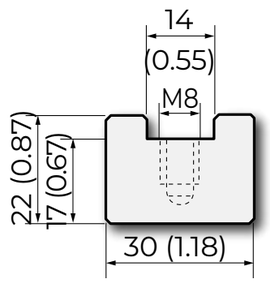


C45: 560-710 N/mm²

800 kN/m max.

E30.22

830 mm	32.87 in	3.5 kg	▸ Hemming tool
412 mm	16.34 in	1.7 kg	

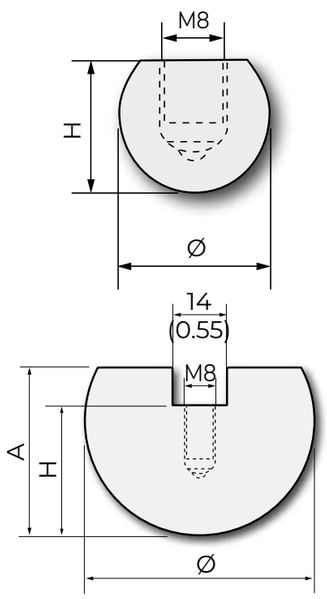


C45: 560-710 N/mm²

800 kN/m max.

Radius tools ø 16 - 100

	ø [mm]	ø [in]	H [mm]	A [mm]	A [in]	835 mm / 32.87 in	415 mm / 16.34 in
C13.08	16	0.63	13	-	-	2.0 kg	1.0 kg
C13.09	18	0.71	16	-	-	2.0 kg	1.0 kg
C16.10	20	0.79	16	-	-	2.0 kg	1.0 kg
C17.12	25	0.98	17	22	0.87	2.5 kg	1.2 kg
C20.15	30	1.18	20	27	1.06	3.7 kg	1.8 kg
C22.17	35	1.39	22	32	1.26	5.0 kg	2.4 kg
C24.20	40	1.57	24	34	1.34	7.0 kg	3.5 kg
C25.22	45	1.77	25	35	1.37	7.5 kg	3.8 kg
C29.25	50	1.97	29	39	1.54	10.0 kg	4.7 kg
C34.27	55	1.65	34	44	1.73	12.4 kg	6.2 kg
C34.30	60	2.36	34	44	1.73	13.5 kg	6.7 kg
C37.32	65	2.56	37	47	1.85	15.9 kg	7.9 kg
C45.35	70	2.76	45	55	2.17	20.3 kg	10.0 kg
C42.37	75	2.96	42	52	2.04	20.5 kg	10.3 kg
C45.40	80	3.15	45	55	2.17	23.0 kg	11.5 kg
C60.45	90	3.54	60	70	2.76	34.0 kg	17.0 kg
C70.50	100	3.94	70	80	3.15	43.5 kg	21.7 kg



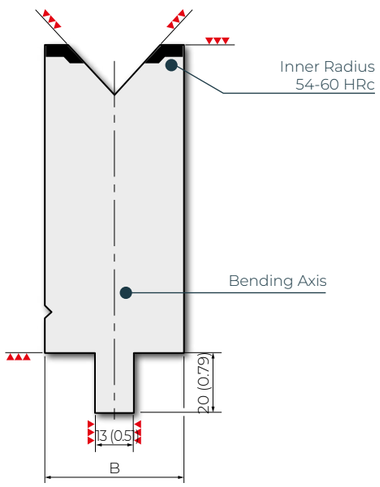
DIES ROLLERI TYPE R2-R3

▼ **COMPATIBILITY**

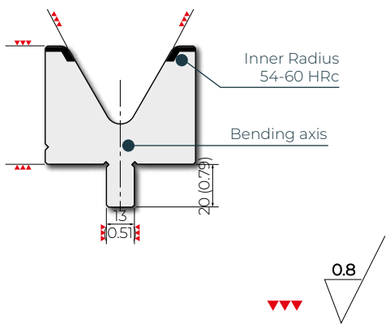
Bystronic Beyeler
Darley
Safan
SMD
Trumpf
Press brake machines with System NSCR

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

STANDARD TANG



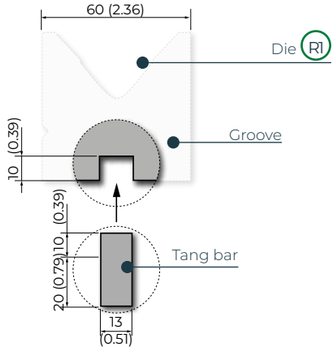
All Rolleri R2 type dies have got 13 x 20 mm tang



MODIFICATIONS WEDGE/BAR TAIL

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

A30 [Example]



STANDARD LENGTH

100 mm (3.93 in)

500 mm (19.69 in)

515 mm (20.28 in)

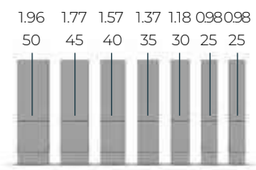
525 mm (20.67 in)

1000 mm (39.37 in)

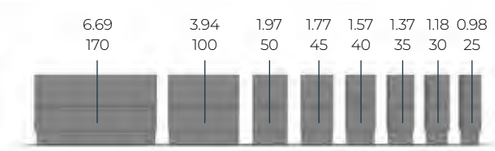
R2
R3

SEGMENTATION

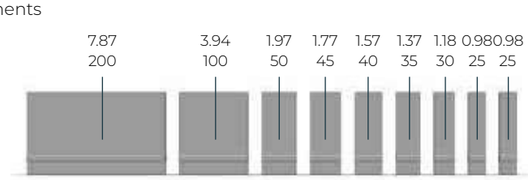
FC: 250 mm (9.84 in)- 7 segments



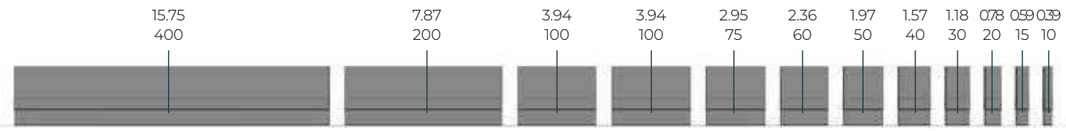
F: 495 mm (19.49 in) - 8 segments



FW: 550 mm (21.65 in) - 9 segments



F: 1100 mm (43.31 in) - 12 segments



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

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

Available on request

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

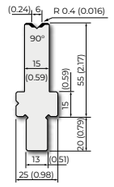
Length mm [in]	25 [0.98]	30 [1.18]	35 [1.38]	40 [1.57]	45 [1.77]	50 [1.97]	100 [3.94]	200 [7.87]	300 [11.81]	500 [19.68]
1250 [49.21]	2	1	1	1	1	1	3	2	1	0
2050 [80.71]	2	1	1	1	1	1	3	1	1	2
2550 [100.39]	2	1	1	1	1	1	3	1	1	3
3050 [120.08]	2	1	1	1	1	1	3	1	1	4
4050 [159.45]	2	1	1	1	1	1	3	1	1	6

Available on request

42Cr: 900-1150 N/mm² — 1150 kN/m max.

BMR55.06.90

1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm	43.31 in	8.5 kg F

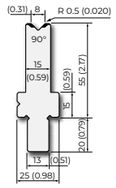


90° ✓

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.08.90

1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm	43.31 in	8.5 kg F

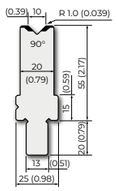


90° ✓

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.10.90

1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm	43.31 in	10.0 kg F

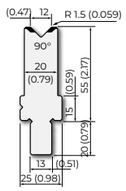


90° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.12.90

1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm	43.31 in	10.0 kg F

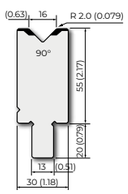


90° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.16.90

1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm	43.31 in	14.0 kg F

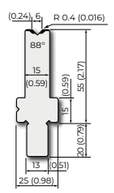


90° ✓

42Cr: 900-1150 N/mm² — 1150 kN/m max.

BMR55.06.88

1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm	43.31 in	8.5 kg F

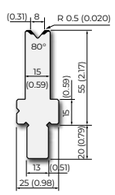


88° ✓

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.08.88

1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.2 kg
1100 mm	43.31 in	8.5 kg F

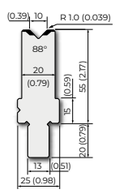


88°

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.10.88

1000 mm	39.37 in	11.0 kg
500 mm	19.68 in	5.0 kg
1100 mm	43.31 in	12.0 kg F

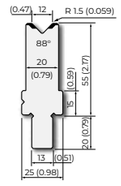


88° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.12.88

1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm	43.31 in	10.0 kg F

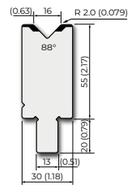


88° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.16.88

1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm	43.31 in	14.0 kg F

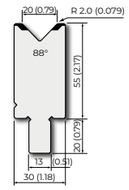


88° ✓

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.20.88

1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm	43.31 in	14.0 kg F

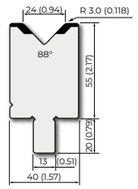


88° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.24.88

1000 mm	39.37 in	18.5 kg
500 mm	19.68 in	9.2 kg
1100 mm	43.31 in	18.0 kg F

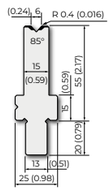


88° ✓

42Cr: 900-1150 N/mm² — 1150 kN/m max.

BMR55.06.85

1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm	43.31 in	8.5 kg F

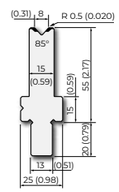


85°

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.08.85

1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm	43.31 in	8.5 kg F

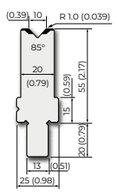


85° ✓

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.10.85

1000 mm	39.37 in	11.0 kg
500 mm	19.68 in	5.0 kg
1100 mm	43.31 in	12.0 kg F

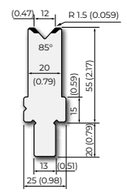


85°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.12.85

1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm	43.31 in	10.0 kg F



85°

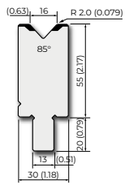
R2
R3

Segmented ✓ On stock Ask for delivery time

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.16.85

1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm	43.31 in	14.0 kg F

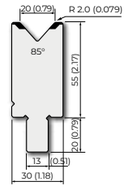


85°

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.20.85

1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm	43.31 in	14.0 kg F

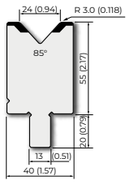


85°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.24.85

1000 mm	39.37 in	18.5 kg
500 mm	19.68 in	9.2 kg
1100 mm	43.31 in	18.0 kg F

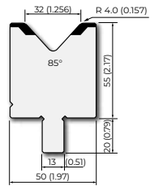


85°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.32.85

1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	10.5 kg
1100 mm	43.31 in	20.5 kg F

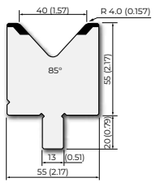


85°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.40.85

1000 mm	39.37 in	21.5 kg
500 mm	19.68 in	10.7 kg
1100 mm	43.31 in	25.0 kg F

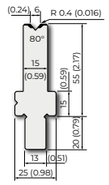


85°

42Cr: 900-1150 N/mm² — 1150 kN/m max.

BMR55.06.80

1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm	43.31 in	8.5 kg F

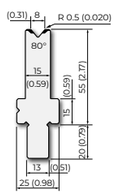


80°

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.08.80

1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm	43.31 in	8.5 kg F

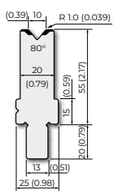


80°

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.10.80

1000 mm	39.37 in	11.0 kg
500 mm	19.68 in	5.0 kg
1100 mm	43.31 in	12.0 kg F



80°

Segmented

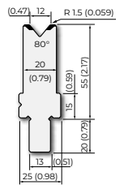
On stock

Ask for delivery time

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.12.80

1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm	43.31 in	10.0 kg F

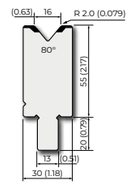


80°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.16.80

1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm	43.31 in	14.0 kg F

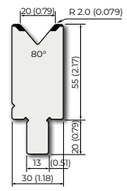


80°

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR55.20.80

1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm	43.31 in	14.0 kg F

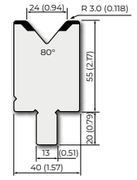


80°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.24.80

1000 mm	39.37 in	18.5 kg
500 mm	19.68 in	9.2 kg
1100 mm	43.31 in	18.0 kg F

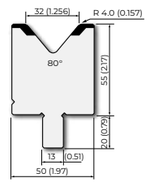


80°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.32.80

1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	10.5 kg
1100 mm	43.31 in	20.5 kg F

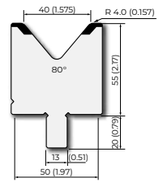


80°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.40.80

1000 mm	39.37 in	21.5 kg
500 mm	19.68 in	10.7 kg
1100 mm	43.31 in	25.0 kg F

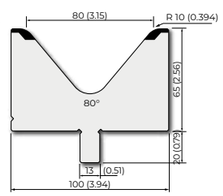


80°

42Cr: 900-1150 N/mm² — 1700 kN/m max.

BMR65.80.80

1000 mm	39.37 in	39.0 kg
500 mm	19.68 in	20.0 kg
1100 mm	43.31 in	43.0 kg F

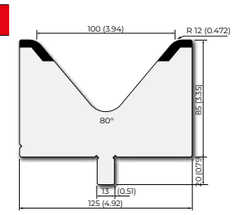


80°

42Cr: 900-1150 N/mm² — 2300 kN/m max.

BMR85.100.80

1000 mm	39.37 in	62.0 kg
500 mm	19.68 in	31.0 kg
1100 mm	43.31 in	69.0 kg F



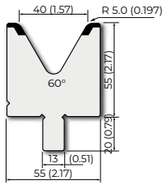
80°

R2
R3

42Cr: 900-1150 N/mm² — 1300 kN/m max.

BMR55.40.60

1000 mm	39.37 in	20.3 kg
500 mm	19.68 in	10.5 kg
1100 mm	43.31 in	22.3 kg F

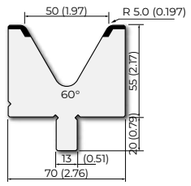


60° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

BMR55.50.60

1000 mm	39.37 in	24.0 kg
500 mm	19.68 in	12.0 kg
1100 mm	43.31 in	21.0 kg F

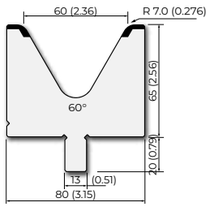


60° ✓

42Cr: 900-1150 N/mm² — 1100 kN/m max.

BMR65.60.60

1000 mm	39.37 in	31.0 kg
500 mm	19.68 in	15.5 kg
1100 mm	43.31 in	34.1 kg F

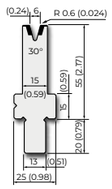


60° ✓

42Cr: 900-1150 N/mm² — 350 kN/m max.

BMR55.06.30

1000 mm	39.37 in	8.0 kg
500 mm	19.68 in	4.0 kg
1100 mm	43.31 in	9.0 kg F

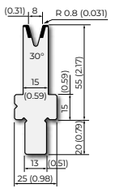


30° ✓

42Cr: 900-1150 N/mm² — 200 kN/m max.

BMR55.08.30

1000 mm	39.37 in	9.2 kg
500 mm	19.68 in	4.0 kg
1100 mm	43.31 in	10.1 kg F

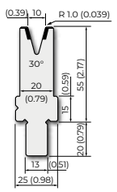


30° ✓

42Cr: 900-1150 N/mm² — 350 kN/m max.

BMR55.10.30

1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm	43.31 in	11.0 kg F

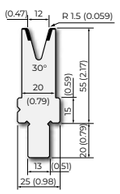


30° ✓

42Cr: 900-1150 N/mm² — 300 kN/m max.

BMR55.12.30

1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm	43.31 in	11.0 kg F

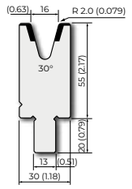


30° ✓

42Cr: 900-1150 N/mm² — 450 kN/m max.

BMR55.16.30

1000 mm	39.37 in	13.5 kg
500 mm	19.68 in	6.7 kg
1100 mm	43.31 in	14.9 kg F

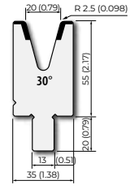


30° ✓

42Cr: 900-1150 N/mm² — 500 kN/m max.

BMR55.20.30

1000 mm	39.37 in	14.0 kg
500 mm	19.68 in	7.0 kg
1100 mm	43.31 in	13.5 kg F

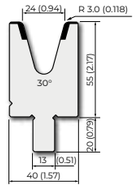


30° ✓

42Cr: 900-1150 N/mm² — 550 kN/m max.

BMR55.24.30

1000 mm	39.37 in	15.5 kg
500 mm	19.68 in	7.8 kg
1100 mm	43.31 in	17.0 kg F

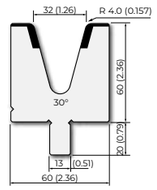


30° ✓

42Cr: 900-1150 N/mm² — 650 kN/m max.

BMR60.32.30

1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm	43.31 in	22.5 kg F

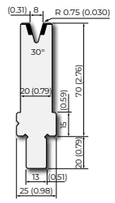


30° ✓

42Cr: 900-1150 N/mm² — 200 kN/m max.

BMR70.08.30

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

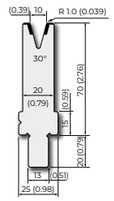


30° ✓

42Cr: 900-1150 N/mm² — 350 kN/m max.

BMR70.10.30

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

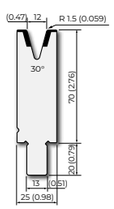


30° ✓

42Cr: 900-1150 N/mm² — 300 kN/m max.

BMR70.12.30

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

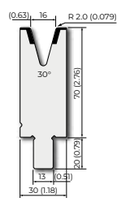


30° ✓

42Cr: 900-1150 N/mm² — 450 kN/m max.

BMR70.16.30

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



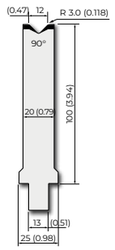
30° ✓

R2
R3

42Cr: 900-1150 N/mm² — 1200 kN/m max.

WMR100.12.90

100 mm	39.37 in	1.7 kg	
515 mm	20.28 in	9.0 kg	
550 mm	21.65 in	9.6 kg	FW

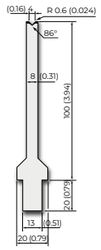


90° ✓

42Cr: 900-1150 N/mm² — 250 kN/m max.

TMR100.04.86

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

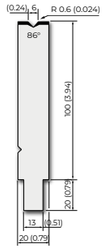


86° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.06.86

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

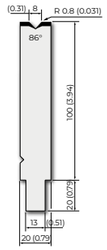


86° ✓

42Cr: 900-1150 N/mm² — 1150 kN/m max.

TMR100.08.86

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

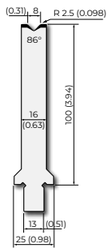


86° ✓

42Cr: 900-1150 N/mm² — 400 kN/m max.

WMR100.08.86

100 mm	39.37 in	1.5 kg	
515 mm	20.28 in	7.7 kg	
550 mm	43.31 in	8.2 kg	FW

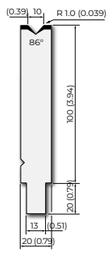


86°

42Cr: 900-1150 N/mm² — 1100 kN/m max.

TMR100.10.86

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

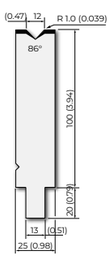


86° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.12.86

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

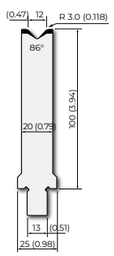


86° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

WMR100.12.86

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

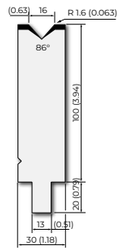


86°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.16.86

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

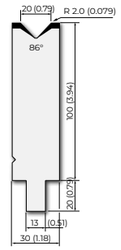


86° ✓

42Cr: 900-1150 N/mm² — 1150 kN/m max.

TMR100.20.86

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

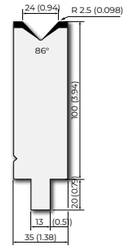


86° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.24.86

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

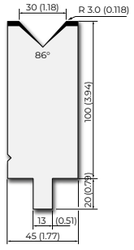


86° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.30.86

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

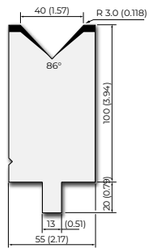


86° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.40.86

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

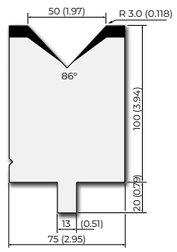


86° ✓

42Cr: 900-1150 N/mm² — 1500 kN/m max.

TMR100.50.86

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

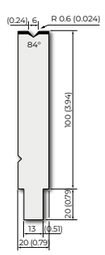


86° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.06.84

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

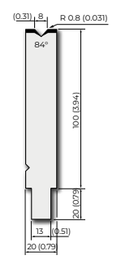


84° ✓

42Cr: 900-1150 N/mm² — 1150 kN/m max.

TMR100.08.84

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



84° ✓

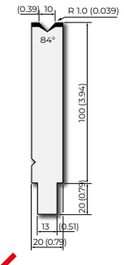
R2
R3

Segmented ✓ On stock Ask for delivery time

42Cr: 900-1150 N/mm² — 1100 kN/m max.

TMR100.10.84

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

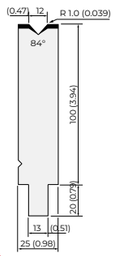


84° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.12.84

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

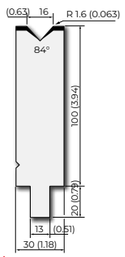


84° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.16.84

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

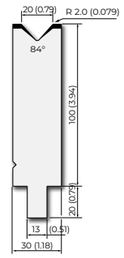


84° ✓

42Cr: 900-1150 N/mm² — 1150 kN/m max.

TMR100.20.84

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

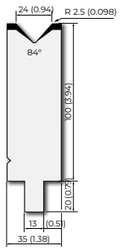


84° ✓

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR100.24.84

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

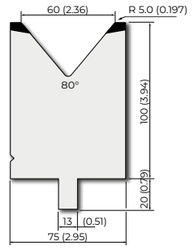


84° ✓

42Cr: 900-1150 N/mm² — 1500 kN/m max.

TMR100.60.80

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

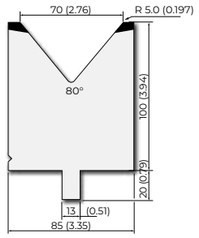


80° ✓

42Cr: 900-1150 N/mm² — 1500 kN/m max.

TMR100.70.80

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

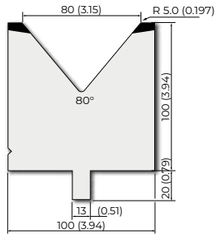


80° ✓

42Cr: 900-1150 N/mm² — 1500 kN/m max.

TMR100.80.80

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



80° ✓

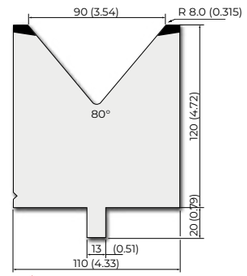
Segmented ✓ On stock Ask for delivery time

Dies - R2 R3

42Cr: 900-1150 N/mm² — 1500 kN/m max.

TMR120.90.80

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

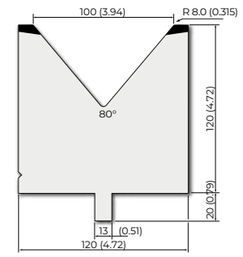


80° ✓

42Cr: 900-1150 N/mm² — 1500 kN/m max.

TMR120.100.80

100 mm	3.94 in	9.0 kg	
500 mm	19.68 in	44.7 kg	
250 mm	9.84 in	22.4 kg	FC
550 mm	21.65 in	49.2 kg	FW

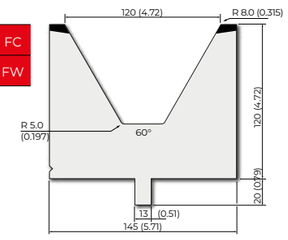


80° ✓

42Cr: 900-1150 N/mm² — 1600 kN/m max.

TMR120.120.60

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

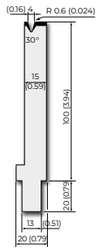


60°

42Cr: 900-1150 N/mm² — 150 kN/m max.

TMR100.04.30

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

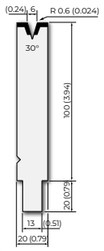


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR100.06.30

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

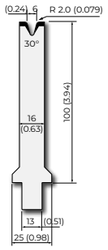


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

WMR100.06.30

100 mm	39.37 in	1.5 kg	
515 mm	20.28 in	7.7 kg	
550 mm	43.31 in	8.2 kg	FW

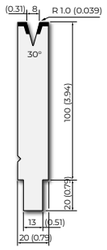


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR100.08.30

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

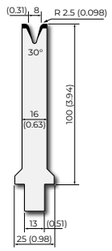


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

WMR100.08.30

100 mm	39.37 in	2.8 kg	
515 mm	20.28 in	14.0 kg	
550 mm	43.31 in	15.4 kg	FW

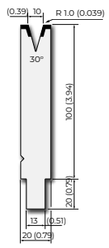


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR100.10.30

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

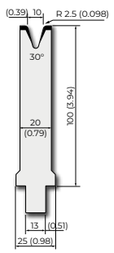


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

WMR100.10.30

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

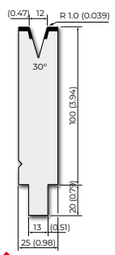


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR100.12.30

100 mm	3.94 in	2.0 kg	
500 mm	19.68 in	10.3 kg	
250 mm	9.84 in	5.1 kg	FC
550 mm	21.65 in	11.3 kg	FW



30°

Segmented

On stock

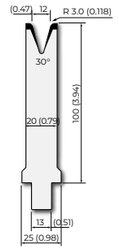
Ask for delivery time

Dies - R2 R3

42Cr: 900-1150 N/mm² — 400 kN/m max.

WMR100.12.30

100 mm	39.37 in	1.7 kg	
515 mm	20.28 in	8.9 kg	
550 mm	43.31 in	9.5 kg	FW

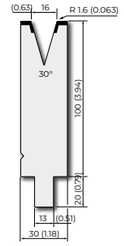


30°

42Cr: 900-1150 N/mm² — 500 kN/m max.

TMR100.16.30

100 mm	3.94 in	2.4 kg	
500 mm	19.68 in	11.8 kg	
250 mm	9.84 in	6.0 kg	FC
550 mm	21.65 in	13.0 kg	FW

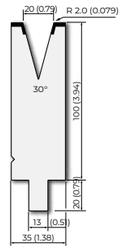


30°

42Cr: 900-1150 N/mm² — 600 kN/m max.

TMR100.20.30

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

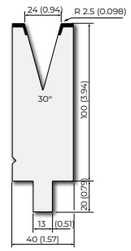


30°

42Cr: 900-1150 N/mm² — 650 kN/m max.

TMR100.24.30

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

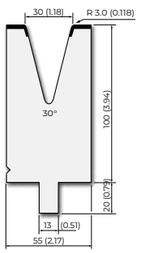


30°

42Cr: 900-1150 N/mm² — 900 kN/m max.

TMR100.30.30

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

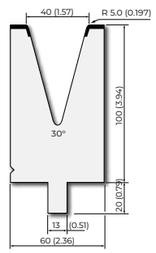


30°

42Cr: 900-1150 N/mm² — 900 kN/m max.

TMR100.40.30

100 mm	3.94 in	3.7 kg	
500 mm	19.68 in	18.3 kg	
250 mm	9.84 in	9.3 kg	FC
550 mm	21.65 in	20.1 kg	FW

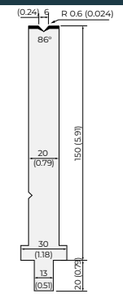


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR150.06.86

100 mm	3.94 in	2.64 kg	
500 mm	19.68 in	13.1 kg	
250 mm	9.84 in	6.6 kg	FC
550 mm	21.65 in	14.3 kg	FW

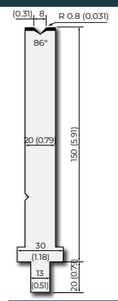


86°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR150.08.86

100 mm	3.94 in	2.6 kg	
500 mm	19.68 in	13.1 kg	
250 mm	9.84 in	6.6 kg	FC
550 mm	21.65 in	14.4 kg	FW

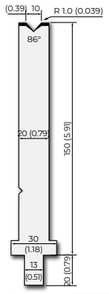


86°

42Cr: 900-1150 N/mm² — 500 kN/m max.

TMR150.10.86

100 mm	3.94 in	2.6 kg	
500 mm	19.68 in	13.0 kg	
250 mm	9.84 in	6.5 kg	FC
550 mm	21.65 in	14.3 kg	FW

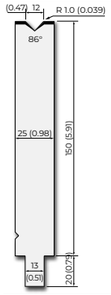


86°

42Cr: 900-1150 N/mm² — 500 kN/m max.

TMR150.12.86

100 mm	3.94 in	3.1 kg	
500 mm	19.68 in	15.5 kg	
250 mm	9.84 in	7.8 kg	FC
550 mm	21.65 in	17.0 kg	FW

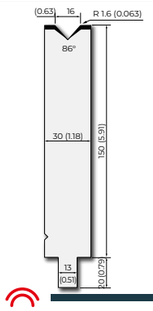


86°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TMR150.16.86

100 mm	3.94 in	3.7 kg	
500 mm	19.68 in	18.4 kg	
250 mm	9.84 in	9.2 kg	FC
550 mm	21.65 in	20.2 kg	FW

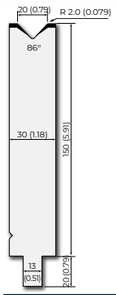


86°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TMR150.20.86

100 mm	3.94 in	3.7 kg	
500 mm	19.68 in	18.3 kg	
250 mm	9.84 in	9.1 kg	FC
550 mm	21.65 in	20.0 kg	FW

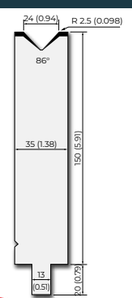


86°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TMR150.24.86

100 mm	3.94 in	4.2 kg	
500 mm	19.68 in	20.9 kg	
250 mm	9.84 in	10.5 kg	FC
550 mm	21.65 in	23.0 kg	FW

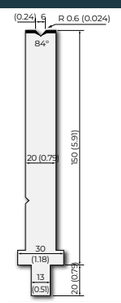


86°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR150.06.84

100 mm	3.94 in	2.6 kg	
515 mm	19.68 in	13.1 kg	
250 mm	9.84 in	6.6 kg	FC
550 mm	21.65 in	14.3 kg	FW

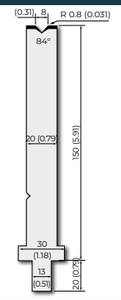


84°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR150.08.84

100 mm	3.94 in	2.6 kg	
500 mm	19.68 in	13.1 kg	
250 mm	9.84 in	6.6 kg	FC
550 mm	21.65 in	14.3 kg	FW

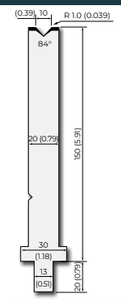


84°

42Cr: 900-1150 N/mm² — 500 kN/m max.

TMR150.10.84

100 mm	3.94 in	2.6 kg	
500 mm	19.68 in	13.0 kg	
250 mm	9.84 in	6.5 kg	FC
550 mm	21.65 in	14.3 kg	FW

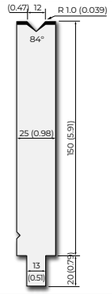


84°

42Cr: 900-1150 N/mm² — 500 kN/m max.

TMR150.12.84

100 mm	3.94 in	3.1 kg	
500 mm	19.68 in	15.5 kg	
250 mm	9.84 in	7.8 kg	FC
550 mm	21.65 in	17.0 kg	FW

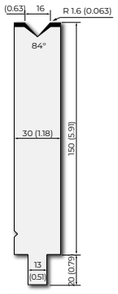


84°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TMR150.16.84

100 mm	3.94 in	3.7 kg	
500 mm	19.68 in	18.4 kg	
250 mm	9.84 in	9.2 kg	FC
550 mm	21.65 in	20.2 kg	FW

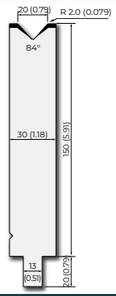


84°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TMR150.20.84

100 mm	3.94 in	3.7 kg	
500 mm	19.68 in	18.3 kg	
250 mm	9.84 in	9.1 kg	FC
550 mm	21.65 in	20.0 kg	FW

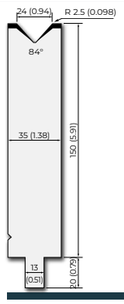


84°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TMR150.24.84

100 mm	3.94 in	4.2 kg	
500 mm	19.68 in	20.9 kg	
250 mm	9.84 in	10.4 kg	FC
550 mm	21.65 in	22.9 kg	FW

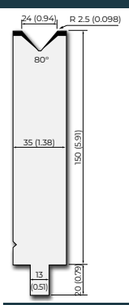


84°

42Cr: 900-1150 N/mm² — 700 kN/m max.

TMR150.24.80

100 mm	3.94 in	4.2 kg	
500 mm	19.68 in	20.9 kg	
250 mm	9.84 in	10.4 kg	FC
550 mm	21.65 in	22.9 kg	FW

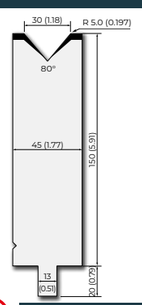


80°

42Cr: 900-1150 N/mm² — 900 kN/m max.

TMR150.30.80

100 mm	3.94 in	5.3 kg	
500 mm	19.68 in	26.3 kg	
250 mm	9.84 in	13.1 kg	FC
550 mm	21.65 in	28.9 kg	FW



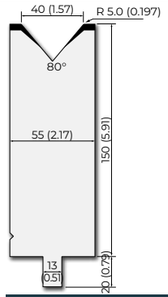
80°

R2
R3

42Cr: 900-1150 N/mm² — 1200 kN/m max.

TMR150.40.80

100 mm	3.94 in	6.3 kg	
500 mm	19.68 in	31.3 kg	
250 mm	9.84 in	15.6 kg	FC
550 mm	21.65 in	34.4 kg	FW

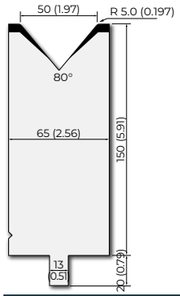


80°

42Cr: 900-1150 N/mm² — 1500 kN/m max.

TMR150.50.80

100 mm	3.94 in	7.3 kg	
500 mm	19.68 in	36.0 kg	
250 mm	9.84 in	18.0 kg	FC
550 mm	21.65 in	39.6 kg	FW

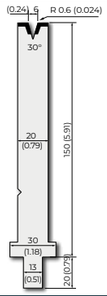


80°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR150.06.30

100 mm	3.94 in	2.6 kg	
500 mm	19.68 in	13.0 kg	
250 mm	9.84 in	6.5 kg	FC
550 mm	21.65 in	14.3 kg	FW

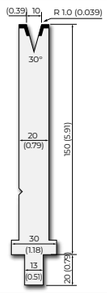


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR150.08.30

100 mm	3.94 in	2.8 kg	
500 mm	19.68 in	13.0 kg	
250 mm	9.84 in	6.5 kg	FC
550 mm	21.65 in	14.3 kg	FW

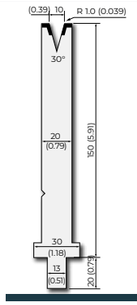


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR150.10.30

100 mm	3.94 in	2.6 kg	
500 mm	19.68 in	12.8 kg	
250 mm	9.84 in	6.4 kg	FC
550 mm	21.65 in	13.9 kg	FW

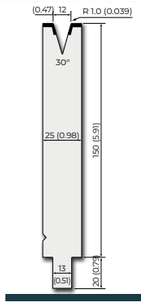


30°

42Cr: 900-1150 N/mm² — 400 kN/m max.

TMR150.12.30

100 mm	3.94 in	3.0 kg	
500 mm	19.68 in	15.2 kg	
250 mm	9.84 in	7.6 kg	FC
550 mm	21.65 in	16.7 kg	FW

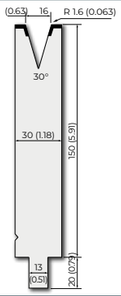


30°

42Cr: 900-1150 N/mm² — 500 kN/m max.

TMR150.16.30

100 mm	3.94 in	3.5 kg	
500 mm	19.68 in	17.7 kg	
250 mm	9.84 in	8.9 kg	FC
550 mm	21.65 in	19.5 kg	FW

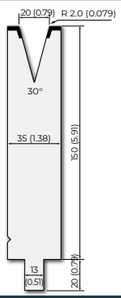


30°

42Cr: 900-1150 N/mm² — 600 kN/m max.

TMR150.20.30

100 mm	3.94 in	4.0 kg	
515 mm	19.68 in	20.1 kg	
250 mm	9.84 in	10.0 kg	FC
550 mm	21.65 in	22.0 kg	FW



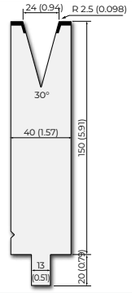
30°

Dies - R2 R3

42Cr: 900-1150 N/mm² — 650 kN/m max.

TMR150.24.30

100 mm	3.94 in	4.5 kg	
500 mm	19.68 in	22.3 kg	
250 mm	9.84 in	11.2 kg	FC
550 mm	21.65 in	24.5 kg	FW

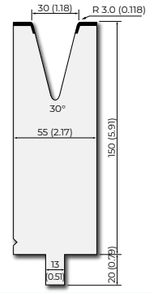


30°

42Cr: 900-1150 N/mm² — 900 kN/m max.

TMR150.30.30

100 mm	3.94 in	6.0 kg	
500 mm	19.68 in	30.0 kg	
250 mm	9.84 in	15.0 kg	FC
550 mm	21.65 in	33.0 kg	FW

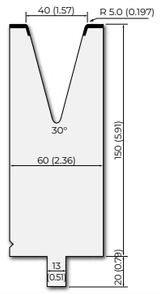


30°

42Cr: 900-1150 N/mm² — 900 kN/m max.

TMR150.40.30

100 mm	3.94 in	6.0 kg	
500 mm	19.68 in	30.1 kg	
250 mm	9.84 in	15.1 kg	FC
550 mm	21.65 in	33.1 kg	FW



30°

R2
R3

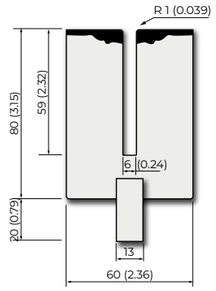
Hemming Dies - R2 R3

42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

BPR.SM.195.28.6

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

To use with:
- BPR.SP-195.28.6 (pag. 109)

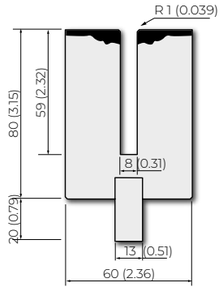


42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

BPR.SM.195.28.8 - TPR.SM.195.28.8 - TPR.SM.195.24.8

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

To use with:
- BPR.SP-195.28.8 (pag. 109)
- TPR.SP.195.28.8 (pag. 98)
- TPR.SP.195.24.8 (pag. 98)

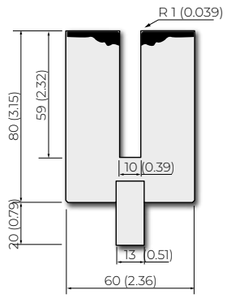


42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

BPR.SM.195.24.10 - TPR.SM.195.24.10

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

To use with:
- BPR.SP-195.24.10 (pag. 109)
- TPR.SP-195.24.10 (pag. 98)

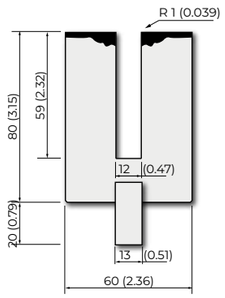


42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

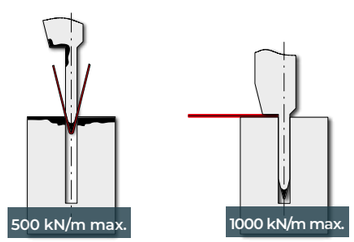
BPR.SM.195.24.12 - TPR.SM.195.24.12

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

To use with:
- BPR.SP-195.24.12 (pag. 109)
- TPR.SP.195.24.12 (pag. 98)



Ex. of application



S [mm]	S [in]	A [mm]	A [in]	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	3.0	0.12	90	150
0.8	0.03	3.0	0.12	120	200
1.0	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260

S [mm]	S [in]	A [mm]	A [in]	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	1.2	0.05	230	350
0.8	0.03	1.6	0.06	320	500
1.0	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800

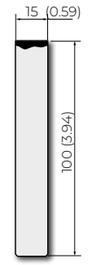
Hemming dies for movable table - R2 R3

- For press brakes with movable table

C45: 560-710 N/mm² — 1300 kN/m max.

TMI100

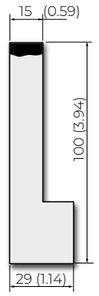
100 mm	3.94 in	1.0 kg	
500 mm	19.68 in	5.0 kg	
250 mm	9.84 in	2.5 kg	FC
550 mm	21.65 in	5.5 kg	FX



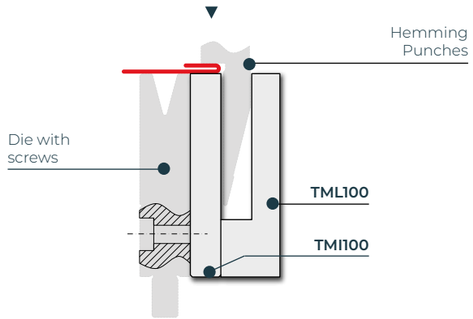
C45: 560-710 N/mm² — 1200 kN/m max.

TML100

100 mm	3.94 in	1.0 kg	
500 mm	19.68 in	5.0 kg	
250 mm	9.84 in	2.5 kg	FC
550 mm	21.65 in	5.5 kg	FW



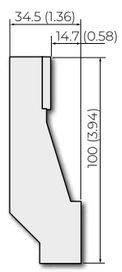
TMI100 + TML100 Example of application



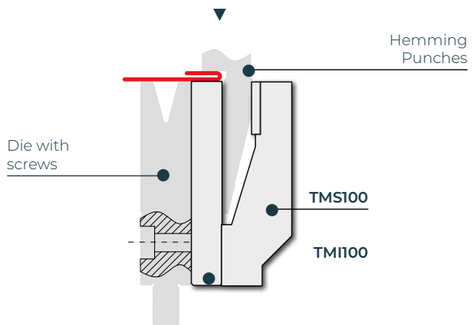
C45: 560-710 N/mm² — 1300 kN/m max.

TMS100

100 mm	3.94 in	1.0 kg	
500 mm	19.68 in	5.0 kg	
250 mm	9.84 in	2.5 kg	FC
550 mm	21.65 in	5.5 kg	FX



TMI100 + TMS100 Example of application



PUNCHES ROLLERI TYPE R4

▼ **COMPATIBILITY**

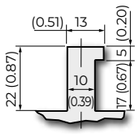
LVD

Content Explanation	146 - 147
R4 **CLASSIC** Series	
Punches	148 - 149
78°	148
26°	149
R4 **W** Series	
Punches	150 - 151
78°	150
26°	151
R4 **NEW W** Series	
Punches	152 - 155
78°	152 -154
26°	153 - 155
Hemming Tools	156

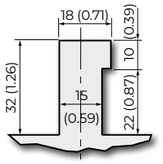
Content Explanation - R4

STANDARD TANG

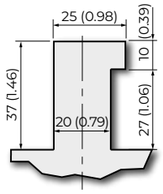
Tang R4 A



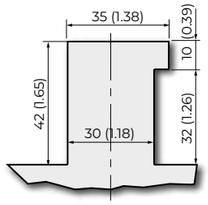
Tang R4 B



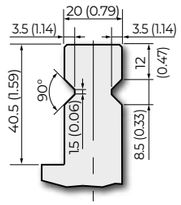
Tang R4 C



Tang R4 D



Tang R4 W



STANDARD LENGTH

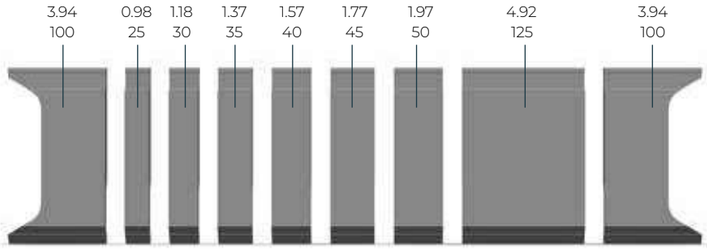
508 mm (20.00 in)

525 mm (20.67 in) Hemming punches

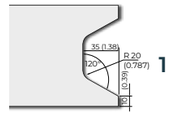
Content Explanation - R4

SEGMENTED

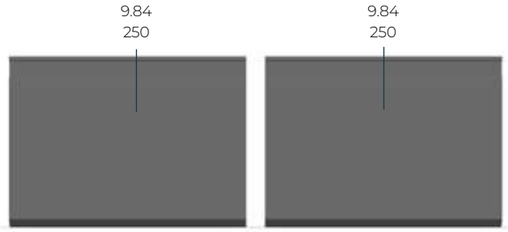
▶ **Punches**



Horn types

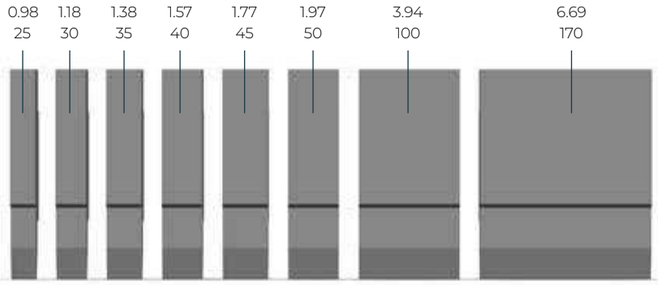


500 mm (21.65 in) - 2 segments

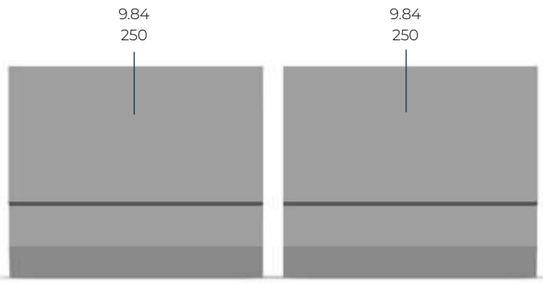


▶ **Hemming punches**

495 mm (19.49 in) - 8 segments



500 mm (21.65 in) - 2 segments



R4

42Cr: 900-1150 N/mm² — 700 kN/m max.

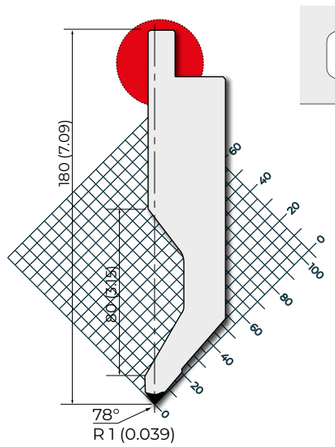
LP180.78.R1-A

508 mm	20.00 in	22.0 kg	
550 mm	21.65 in	23.8 kg	F
2x250 mm	2x9.84 in	21.7 kg	FC

CLASSIC Series
- Tang A: LPA180.78.R1-A
- Tang B: LPB180.78.R1-A
- Tang C: LPC180.78.R1-A
- Tang D: LPD180.78.R1-A

508 mm	20.00 in	22.0 kg	
550 mm	21.65 in	23.8 kg	F
2x250 mm	2x9.84 in	21.7 kg	FC

W Series
- Tang W: LPW196.78.R1-A



78°

42Cr: 900-1150 N/mm² — 450 kN/m max.

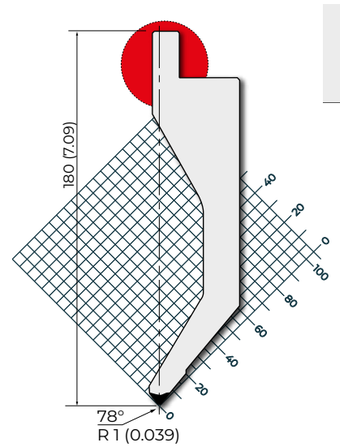
LP180.78.R1-B

508 mm	20.00 in	22.0 kg	
550 mm	21.65 in	24.0 kg	F
2x250 mm	2x9.84 in	21.7 kg	FC

CLASSIC Series
- Tang A: LPA180.78.R1-B
- Tang B: LPB180.78.R1-B
- Tang C: LPC180.78.R1-B
- Tang D: LPD180.78.R1-B

508 mm	20.00 in	22.0 kg	
550 mm	21.65 in	23.8 kg	F
2x250 mm	2x9.84 in	21.7 kg	FC

W Series
- Tang W: LPW196.78.R1-B



78°

42Cr: 900-1150 N/mm² — 500 kN/m max.

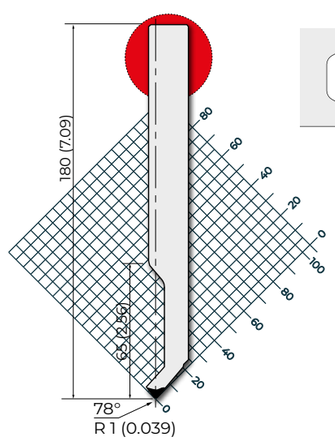
LP180.78.R1-C

508 mm	20.00 in	11.0 kg	
550 mm	21.65 in	12.0 kg	F
2x250 mm	2x9.84 in	10.0 kg	FC

CLASSIC Series
- Tang A: LPA180.78.R1-C
- Tang B: LPB180.78.R1-C
- Tang C: LPC180.78.R1-C
- Tang D: LPD180.78.R1-C

508 mm	20.00 in	22.0 kg	
550 mm	21.65 in	23.8 kg	F
2x250 mm	2x9.84 in	21.7 kg	FC

W Series
- Tang W: LPW196.78.R1-C



78°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

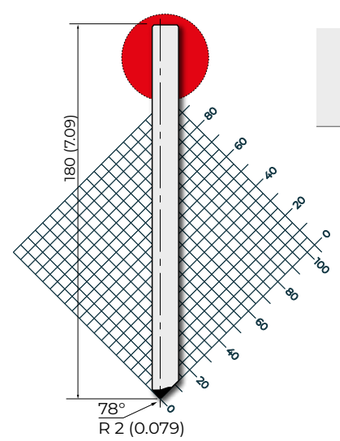
LP180.78.R2

508 mm	20.00 in	9.0 kg	
550 mm	21.65 in	9.7 kg	F
2x250 mm	2x9.84 in	8.9 kg	FC

CLASSIC Series
- Tang A: LPA180.78.R2
- Tang B: LPB180.78.R2
- Tang C: LPC180.78.R2
- Tang D: LPD180.78.R2

508 mm	20.00 in	22.0 kg	
550 mm	21.65 in	23.8 kg	F
2x250 mm	2x9.84 in	21.7 kg	FC

W Series
- Tang W: LPW196.78.R2



78°

Punches - R4 CLASSIC Series and W Series

42Cr: 900-1150 N/mm² — 500 kN/m max.

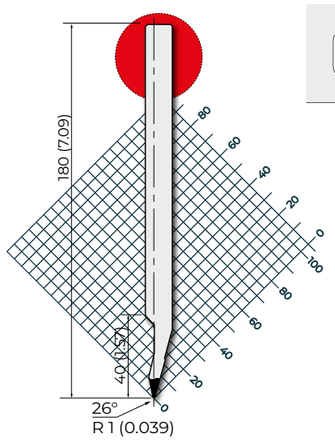
LP180.26-R1

508 mm	20.00 in	9.0 kg	
550 mm	21.65 in	10.0 kg	F
2x250 mm	2x9.84 in	8.9 kg	FC

CLASSIC Series
- Tang A: LPA180.26.R1
- Tang B: LPB180.26.R1
- Tang C: LPC180.26.R1
- Tang D: LPD180.26.R1

508 mm	20.00 in	9.0 kg	
550 mm	21.65 in	10.0 kg	F
2x250 mm	2x9.84 in	8.9 kg	FC

W Series
- Tang W: LPW196.26.R1



26°

42Cr: 900-1150 N/mm² — 400 kN/m max.

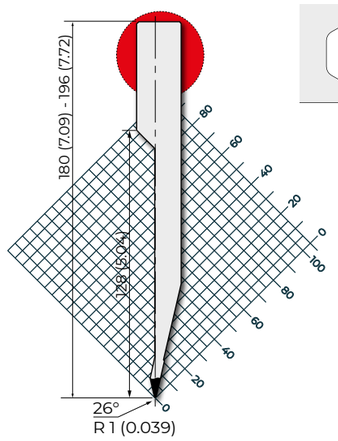
LP180.26.R1-A

508 mm	20.00 in	12.5 kg	
550 mm	21.65 in	13.5 kg	F
2x250 mm	2x9.84 in	12.3 kg	FC

CLASSIC Series
- Tang A: LPA180.26.R1-A
- Tang B: LPB180.26.R1-A
- Tang C: LPC180.26.R1-A
- Tang D: LPD180.26.R1-A

508 mm	20.00 in	12.5 kg	
550 mm	21.65 in	13.5 kg	F
2x250 mm	2x9.84 in	12.3 kg	FC

W Series
- Tang W: LPW196.26.R1-A



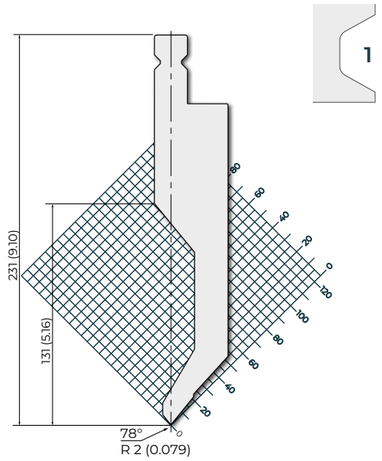
26°

R4

42Cr: 900-1150 N/mm² — 800 kN/m max.

LPW231.78.R2-A

508 mm	20.00 in	27.6 kg	
550 mm	21.65 in	29.9 kg	F
2x250 mm	2x9.84 in	27.2 kg	FC

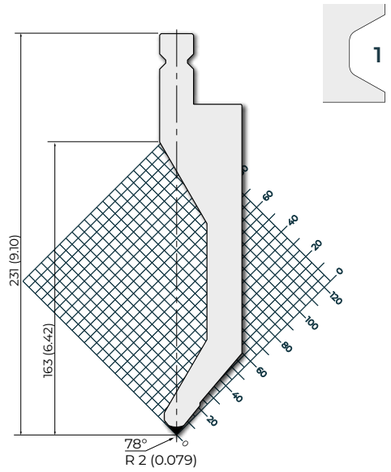


78°

42Cr: 900-1150 N/mm² — 750 kN/m max.

LPW231.78.R2-B

508 mm	20.00 in	23.4 kg	
550 mm	21.65 in	25.4 kg	F
2x250 mm	2x9.84 in	23.1 kg	FC

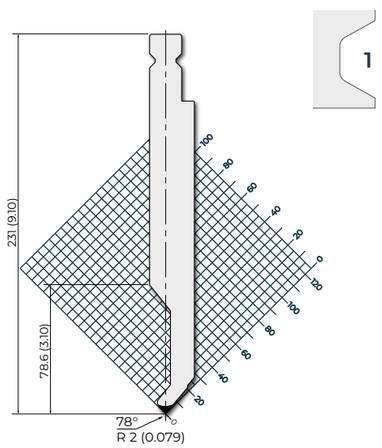


78°

42Cr: 900-1150 N/mm² — 500 kN/m max.

LPW231.78.R2-C

508 mm	20.00 in	19.1 kg	
550 mm	21.65 in	20.7 kg	F
2x250 mm	2x9.84 in	18.8 kg	FC

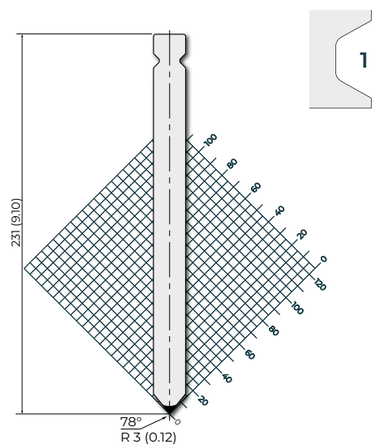


78°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

LPW231.78-R3

508 mm	20.00 in	18.3 kg	
550 mm	21.65 in	19.8 kg	F
2x250 mm	2x9.84 in	18.0 kg	FC

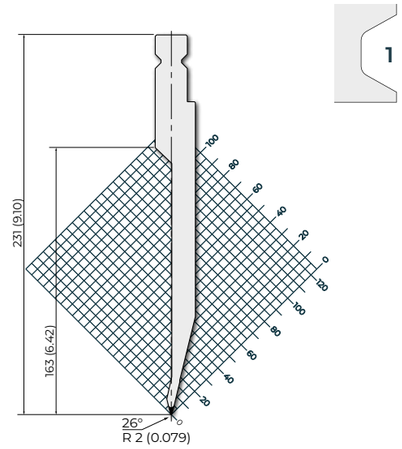


78°

42Cr: 900-1150 N/mm² — 500 kN/m max.

LPW231.26.R2-A

508 mm	20.00 in	9.0 kg	
550 mm	21.65 in	10.0 kg	F
2x250 mm	2x9.84 in	8.9 kg	FC

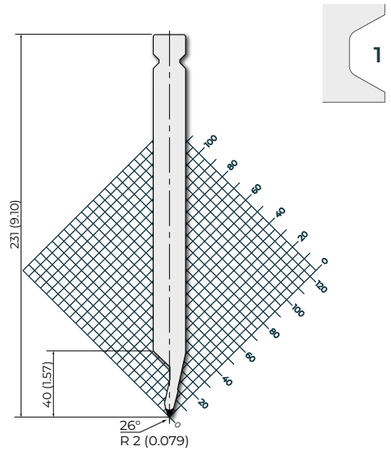


26°

42Cr: 900-1150 N/mm² — 500 kN/m max.

LPW231.26.R2

508 mm	20.00 in	16.3 kg	
550 mm	21.65 in	17.6 kg	F
2x250 mm	2x9.84 in	16.0 kg	FC



26°

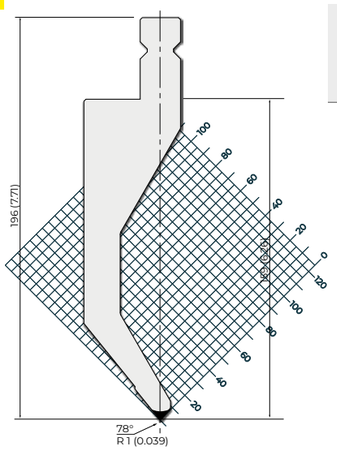
R4

42Cr: 900-1150 N/mm² — 400 kN/m max.

LPW196.D10-R1

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

NEW



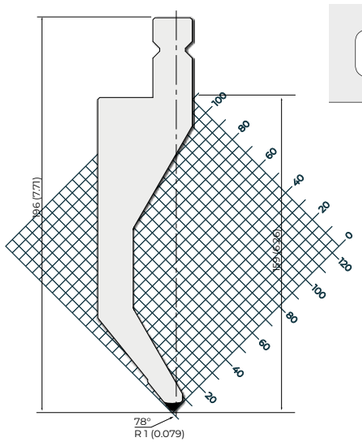
78°

42Cr: 900-1150 N/mm² — 750 kN/m max.

LPW196.D10-R2

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

NEW



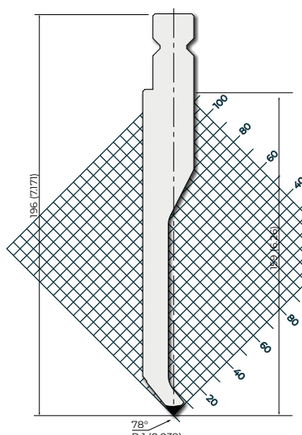
78°

42Cr: 900-1150 N/mm² — 400 kN/m max.

LPW196.E10-R1

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

NEW



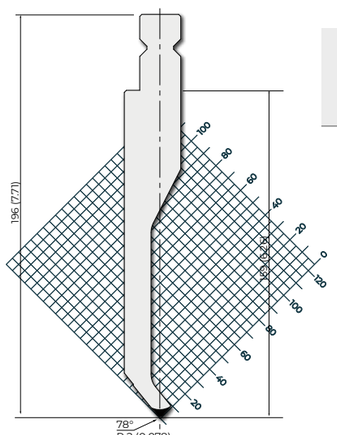
78°

42Cr: 900-1150 N/mm² — 680 kN/m max.

LPW196.E10-R2

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

NEW



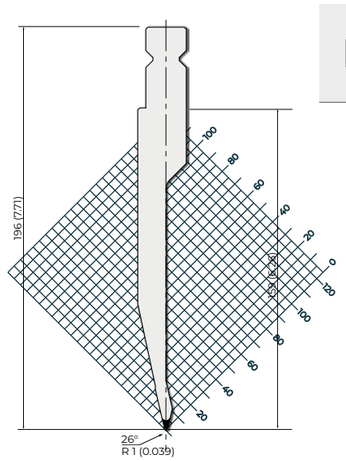
78°

42Cr: 900-1150 N/mm² — 400 kN/m max.

LPW196.J10-R1

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

NEW



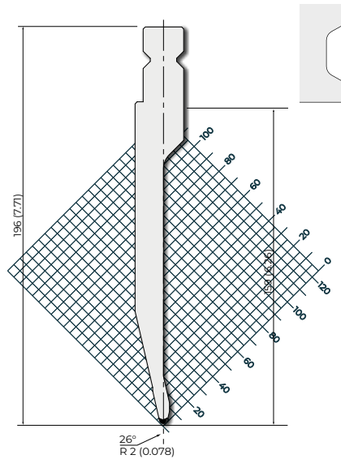
26°

42Cr: 900-1150 N/mm² — 600 kN/m max.

LPW196.J10-R2

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

NEW



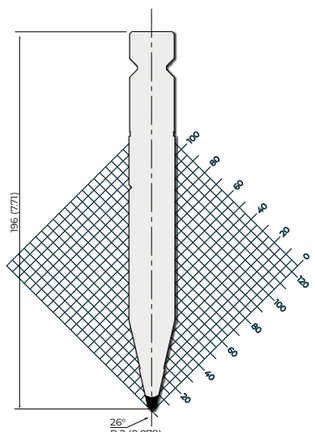
26°

42Cr: 900-1150 N/mm² — 800 kN/m max.

LPW196.R10-R2

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

NEW



26°

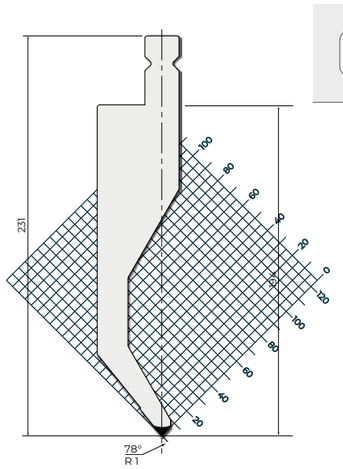
R4

42Cr: 900-1150 N/mm² — 400 kN/m max.

LPW231.D15-R1

510 mm	20.07 in	20.1 kg	
550 mm	21.65 in	21.7 kg	F
2x250 mm	2x9.84 in	19.8 kg	FC

NEW



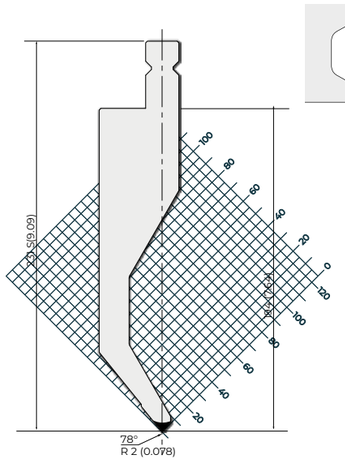
78°

42Cr: 900-1150 N/mm² — 750 kN/m max.

LPW231.D15-R2

510 mm	20.07 in	21.9 kg	
550 mm	21.65 in	23.7 kg	F
2x250 mm	2x9.84 in	21.4 kg	FC

NEW



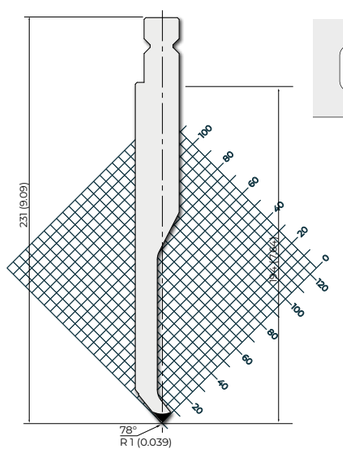
78°

42Cr: 900-1150 N/mm² — 400 kN/m max.

LPW231.E15-R1

510 mm	20.07 in	16.5 kg	
550 mm	21.65 in	17.9 kg	F
2x250 mm	2x9.84 in	16.3 kg	FC

NEW



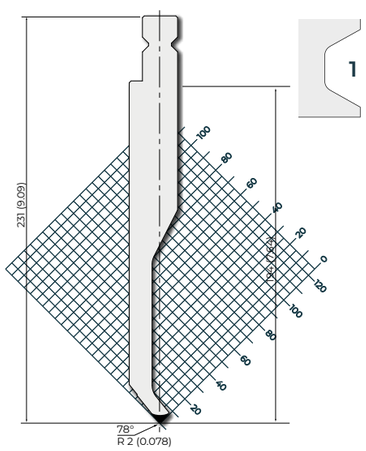
78°

42Cr: 900-1150 N/mm² — 680 kN/m max.

LPW231.E15-R2

510 mm	20.07 in	17.6 kg	
550 mm	21.65 in	19.0 kg	F
2x250 mm	2x9.84 in	17.4 kg	FC

NEW



78°

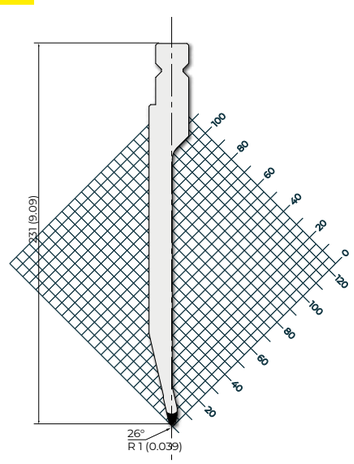
Segmented · On stock · Ask for delivery time

42Cr: 900-1150 N/mm² — 400 kN/m max.

LPW231.J15-R1

510 mm	20.07 in	13.3 kg	
550 mm	21.65 in	14.5 kg	F
2x250 mm	2x9.84 in	13.1 kg	FC

NEW



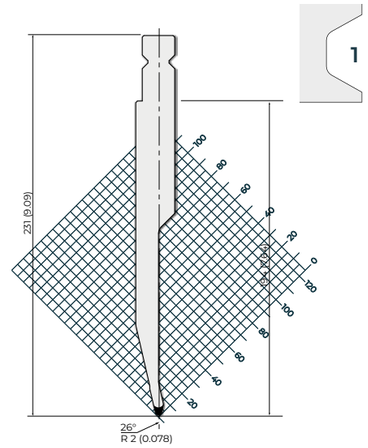
26°

42Cr: 900-1150 N/mm² — 600 kN/m max.

LPW231.J15-R2

510 mm	20.07 in	12.2 kg	
550 mm	21.65 in	13.2 kg	F
2x250 mm	2x9.84 in	12.0 kg	FC

NEW



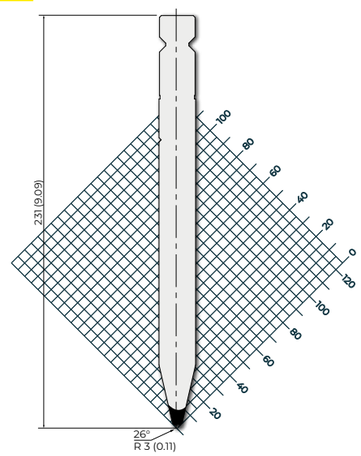
26°

42Cr: 900-1150 N/mm² — 1200 kN/m max.

LPW231.R15-R3

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

NEW



26°

R4

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

LP.SP-190.20.8

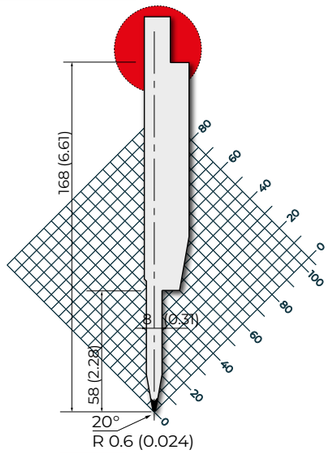
525 mm	20.67 in	13.4 kg	
495 mm	19.49 in	12.6 kg	F
2x250 mm	2x9.84 in	12.8 kg	FC

CLASSIC Series
- Tang A: LPA.SP-190.20.8
- Tang B: LPB.SP-190.20.8
- Tang C: LPC.SP-190.20.8
- Tang D: LPD.SP-190.20.8

525 mm	20.67 in	13.4 kg	
495 mm	19.49 in	12.6 kg	F
2x250 mm	2x9.84 in	12.8 kg	FC

W Series
- Tang W: LPW.SP-190.20.8

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



20°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

LP.SP-190.20.10

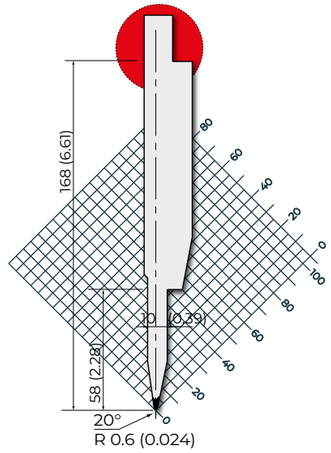
525 mm	20.67 in	13.1 kg	
495 mm	19.49 in	12.3 kg	F
2x250 mm	2x9.84 in	12.5 kg	FC

CLASSIC Series
- Tang A: LPA.SP-190.20.10
- Tang B: LPB.SP-190.20.10
- Tang C: LPC.SP-190.20.10
- Tang D: LPD.SP-190.20.10

525 mm	20.67 in	13.1 kg	
495 mm	19.49 in	12.3 kg	F
2x250 mm	2x9.84 in	12.5 kg	FC

W Series
- Tang W: LPW.SP-190.20.10

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



20°

42Cr: 900-1150 N/mm² — 800 kN/m max. - 1000 kN/m max.

LP.SP-190.20.12

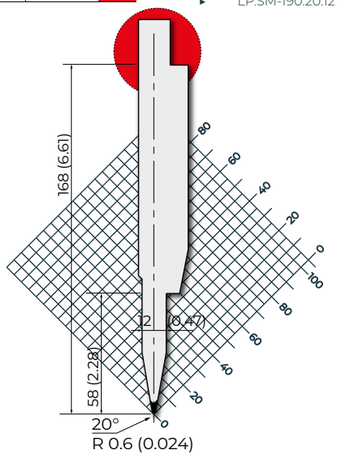
525 mm	20.67 in	13.6 kg	
495 mm	19.49 in	12.8 kg	F
2x250 mm	2x9.84 in	13.0 kg	FC

CLASSIC Series
- Tang A: LPA.SP-190.20.12
- Tang B: LPB.SP-190.20.12
- Tang C: LPC.SP-190.20.12
- Tang D: LPD.SP-190.20.12

525 mm	20.67 in	13.6 kg	
495 mm	19.49 in	12.8 kg	F
2x250 mm	2x9.84 in	13.0 kg	FC

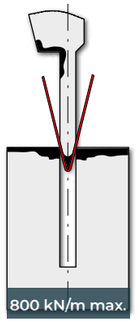
W Series
- Tang W: LPW.SP-190.20.12

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

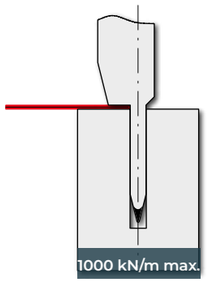


20°

Example of Application



800 kN/m max.



1000 kN/m max.

S [mm]	S (in)	A [mm]	A (in)	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	3.0	0.12	90	150
0.8	0.03	3.0	0.12	120	200
1.0	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260

S [mm]	S (in)	A [mm]	A (in)	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	1.2	0.05	230	350
0.8	0.03	1.6	0.06	320	500
1.0	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800

Segmented — On stock — Ask for delivery time

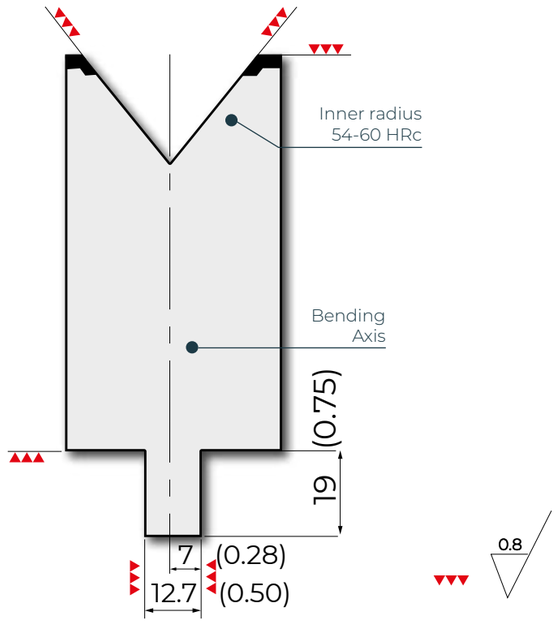
DIES ROLLERI TYPE R4

▼ **COMPATIBILITY**

LVD

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

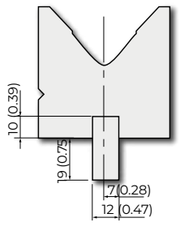
STANDARD TANG



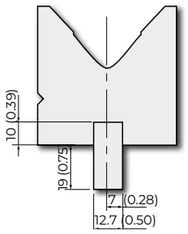
MODIFICATIONS FROM SAFETY GROOVES

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

A31



A32



STANDARD LENGTH

- **Dies**

508 mm (20.00 in)

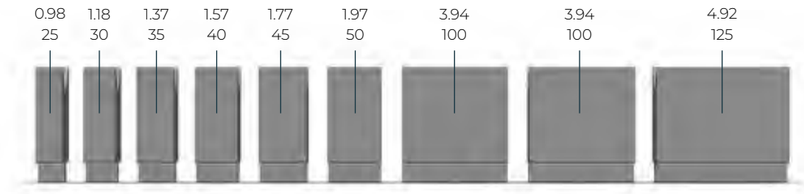
- **Hemming Dies**

525 mm (20.67 in)

SEGMENTATION

- **Dies**

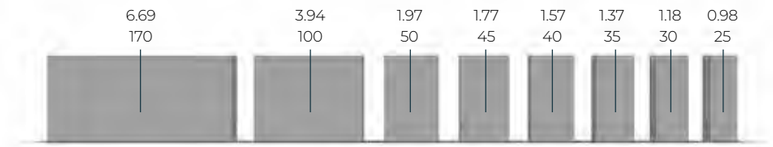
550 mm (21.65 in) - 9 segments



500 mm (19.68 in) - 2 segments

- **Hemming dies**

495 mm (19.48 in) - 8 segments



500 mm (19.68 in) - 2 segments

R4

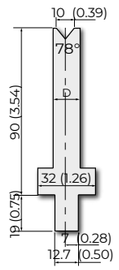
42Cr: 900-1150 N/mm²

See table

H=90 mm / 3.54 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.			F		FC	
LM90.06.78	6	0.23	1.0	0.03	12	0.47	400	508 mm / 20.00 in	8.0 kg	550 mm / 21.65 in	8.6 kg	2x250 mm / 2x9.84 in	7.9 kg
LM90.08.78	8	0.31	1.0	0.03	12	0.47	400		8.0 kg		8.6 kg		7.9 kg
LM90.10.78	10	0.39	1.0	0.03	14	0.55	500		8.0 kg		8.6 kg		7.9 kg
LM90.12.78	12	0.47	2.0	0.07	18	0.70	600		8.0 kg		8.6 kg		7.9 kg
LM90.16.78	16	0.62	2.5	0.09	25	0.98	800		10.0 kg		10.8 kg		9.9 kg

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



78°

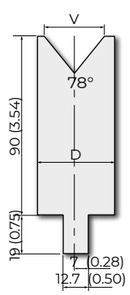
42Cr: 900-1150 N/mm²

See table

H=90 mm / 3.54 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.			F		FC	
LM90.20.78	20	0.70	3.0	0.11	32	1.25	1000	508 mm / 20.00 in	11.9 kg	550 mm / 21.65 in	12.8 kg	2x250 mm / 2x9.84 in	11.8 kg
LM90.24.78	24	0.94	3.0	0.11	32	1.25	1000		10.0 kg		10.8 kg		9.9 kg
LM90.30.78	30	1.18	3.0	0.11	40	1.57	1100		12.0 kg		13.0 kg		11.8 kg
LM90.40.78	40	1.57	4.0	0.15	50	1.96	1300		13.0 kg		14.0 kg		12.8 kg
LM90.50.78	50	1.96	4.0	0.15	60	2.36	1500		19.5 kg		21.0 kg		19.2 kg
LM90.60.78	60	2.36	5.0	0.19	70	2.75	1500		23.0 kg		24.9 kg		22.7 kg
LM90.80.78	80	3.14	5.0	0.19	90	3.54	1500		25.5 kg		27.6 kg		25.1 kg
LM90.100.78	100	3.93	8.0	0.31	120	4.72	1200		31.0 kg		33.5 kg		30.6 kg

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



78°

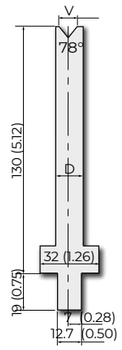
42Cr: 900-1150 N/mm²

See table

H=130 mm / 5.11 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.			F		FC	
LM130.06.78	6	0.23	1.0	0.03	12	0.47	400	508 mm / 20.00 in	8.3 kg	550 mm / 21.65 in	9.0 kg	2x250 mm / 2x9.84 in	8.2 kg
LM130.08.78	8	0.31	1.0	0.03	12	0.47	400		8.4 kg		9.1 kg		8.3 kg
LM130.10.78	10	0.39	1.0	0.03	14	0.55	500		10.1 kg		11.0 kg		10.0 kg
LM130.12.78	12	0.47	2.0	0.07	18	0.70	600		11.1 kg		12.0 kg		10.9 kg
LM130.16.78	16	0.62	2.5	0.09	25	0.98	800		14.3 kg		15.5 kg		14.1 kg

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



78°

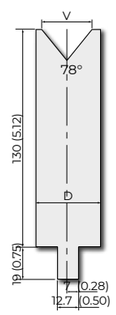
42Cr: 900-1150 N/mm²

See table

H=130 mm / 5.11 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.			F		FC	
LM130.20.78	20	0.78	3.0	0.11	32	1.25	1000	508 mm / 20.00 in	17.5 kg	550 mm / 21.65 in	19.0 kg	2x250 mm / 2x9.84 in	17.2 kg
LM130.24.78	24	0.94	3.0	0.11	32	1.25	1000		17.0 kg		18.5 kg		16.8 kg
LM130.30.78	30	1.18	3.0	0.11	40	1.57	1100		20.7 kg		22.4 kg		20.4 kg
LM130.40.78	40	1.57	4.0	0.15	50	1.96	1300		26.6 kg		28.9 kg		26.2 kg
LM130.50.78	50	1.96	4.0	0.15	60	2.36	1500		34.2 kg		37.0 kg		33.6 kg
LM130.60.78	60	2.36	5.0	0.19	70	2.75	1500		34.2 kg		37.0 kg		33.6 kg
LM130.80.78	80	3.14	5.0	0.19	90	3.54	1500		42.3 kg		45.8 kg		41.6 kg

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



78°

R4

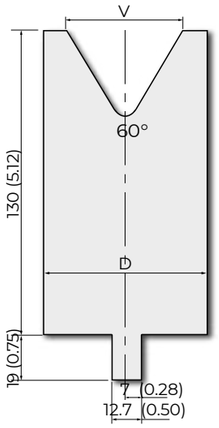
42Cr: 900-1150 N/mm²

See table

H=130 mm / 5..11 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.	508 mm / 20.00 in	F	550 mm/ 21.65 in	FC	2x250 mm/2x9.84 in
LM130.30.60	30	1.18	3.0	0.11	40	1.57	500	20.4 kg	22.1 kg		20.1 kg	
LM130.40.60	40	1.57	5.0	0.19	55	2.16	660	26.8 kg	29.1 kg		26.4 kg	
LM130.50.60	50	1.96	5.0	0.19	70	2.75	1050	33.0 kg	35.7 kg		32.5 kg	
LM130.60.60	60	2.36	7.0	0.27	80	3.14	1200	36.5 kg	39.6 kg		36.0 kg	
LM130.80.60	80	3.14	8.0	0.31	102	4.01	1750	43.0 kg	46.6 kg		42.4 kg	
LM130.100.60	100	3.93	8.0	0.31	120	4.72	1600	47.6 kg	51.5 kg		46.8 kg	
LM130.120.60	120	4.72	8.0	0.31	145	5.70	1300	51.0 kg	55.2 kg		50.2 kg	

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



60°

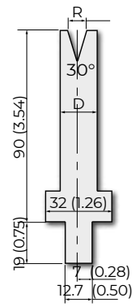
42Cr: 900-1150 N/mm²

See table

H=90 mm / 3.54 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.	508 mm / 20.00 in	F	550 mm/ 21.65 in	FC	2 x 250 mm 2x9.84 in
LM90.06.30	6	0.23	0.8	0.03	16	0.62	200	8.0 kg	8.6 kg		7.9 kg	
LM90.08.30	8	0.31	1.0	0.03	18	0.70	220	8.0 kg	8.6 kg		7.9 kg	
LM90.10.30	10	0.39	1.2	0.07	25	0.98>	300	8.0 kg	8.6 kg		7.9 kg	

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



30°

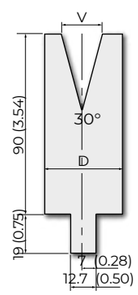
42Cr: 900-1150 N/mm²

See table

H=90 mm / 3.54 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.	508 mm / 20.00 in	F	550 mm/ 21.65 in	FC	2 x 250 mm 2x9.84 in
LM90.12.30	12	0.47	1.2	0.04	32	1.25	380	11.9 kg	12.6 kg		11.8 kg	
LM90.16.30	16	0.62	3.0	0.11	32	1.25	380	11.5 kg	12.4 kg		11.4 kg	
LM90.20.30	20	0.78	3.0	0.11	40	1.57	380	13.8 kg	15.0 kg		13.6 kg	
LM90.24.30	24	0.94	3.0	0.11	50	1.96	550	13.0 kg	14.0 kg		12.8 kg	

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



30°

R4

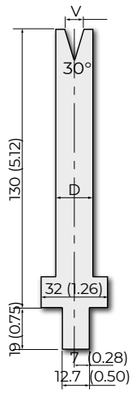
42Cr: 900-1150 N/mm²

See table

H=130 mm / 5.11 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.	508 mm / 20.00 in	F	550 mm / 21.65 in	FC	2 x 250 mm 2 x 9.84 in
LM130.06.30	6	0.23	0.8	0.03	16	0.62	200	10.0 kg	10.8 kg			9.8 kg
LM130.08.30	8	0.31	1.0	0.03	18	0.70	220	10.9 kg	11.8 kg			10.7 kg
LM130.10.30	10	0.39	1.2	0.04	25	0.98	300	14.0 kg	15.1 kg			13.8 kg

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



30°

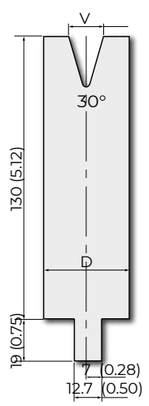
42Cr: 900-1150 N/mm²

See table

H=130 mm / 5.11 in

	V [mm]	V [in]	R [mm]	R [in]	D [mm]	D [in]	kN/m max.	508 mm / 20.00 in	F	550 mm/21.65 in	FC	2 x 250 mm 2 x 9.84in
LM130.12.30	12	0.47	2.0	0.07	32	1.25	380	17.1 kg	18.5 kg			16.9 kg
LM130.16.30	16	0.62	3.0	0.11	32	1.25	380	20.8 kg	22.6 kg			20.5 kg
LM130.20.30	20	0.78	3.0	0.11	40	4.57	380	20.3 kg	22.0 kg			20.0 kg
LM130.24.30	24	0.94	3.0	0.11	50	1.96	550	24.4 kg	26.4 kg			24.0 kg

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



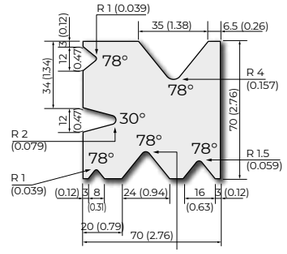
30°

42Cr: 900-1150 N/mm²

LM70

508 mm	20.00 in	16.8 kg	
550 mm	21.65 in	18.2 kg	F

V [mm]	12	12	35	24	16	8
V [in]	0.47	0.47	1.37	0.94	0.62	0.31
R	30°	78°	78°	78°	78°	78°
kN/m max.	1300	600	1300	1200	950	950



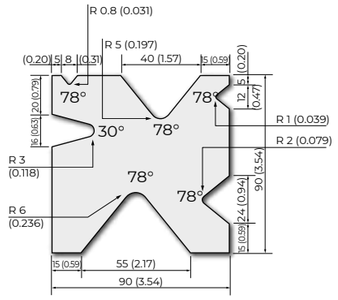
30° 78°

42Cr: 900-1150 N/mm²

LM90

508 mm	20.00 in	25.4 kg	
550 mm	21.65 in	27.5 kg	F

V [mm]	8	40	12	24	55	16
V [in]	0.31	1.57	0.47	0.94	2.16	0.62
R	78°	78°	78°	78°	78°	30°
kN/m max.	550	1400	550	650	1000	1000



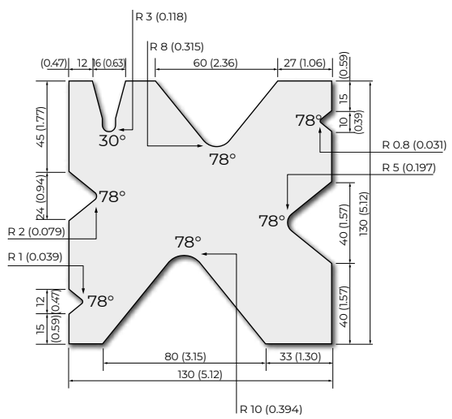
30° 78°

42Cr: 900-1150 N/mm²

LM130

508 mm	20.00 in	51.8 kg	
550 mm	21.65 in	56.1 kg	F

V [mm]	16	60	10	80	40	12	24
V [in]	0.62	2.36	0.39	3.14	1.57	0.47	0.94
R	30°	78°	78°	78°	78°	78°	78°
kN/m max.	650	1500	650	1250	1500	480	1500



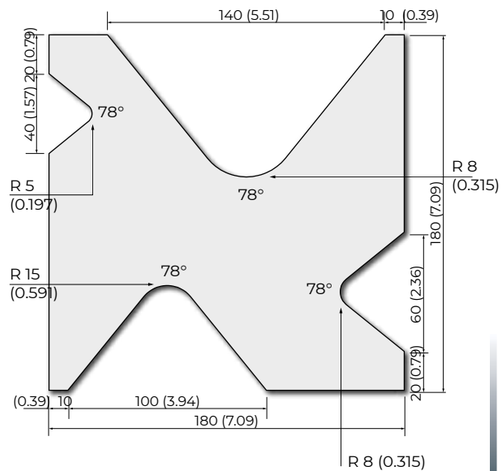
30° 78°

42Cr: 900-1150 N/mm²

LM180

508 mm	20.00 in	25.4 kg	
550 mm	21.65 in	27.5 kg	F

V [mm]	140	60	100	40
V [in]	5.51	2.36	3.94	1.57
R	78°	78°	78°	78°
kN/m max.	550	650	700	320



78°

Segmented

On stock

Ask for delivery time

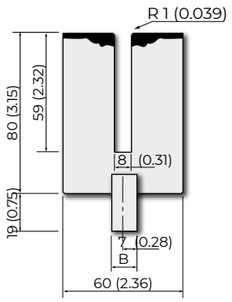
42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

LP.SM-190.20.8-12.7 / -12

525 mm	20.67 in	18.7 kg		B=12.7 mm
495 mm	19.49 in	17.7 kg	F	
2x250 mm	2x9.84 in	17.8 kg	FC	

525 mm	20.67 in	18.7 kg		B=12 mm
495 mm	19.49 in	17.7 kg	F	
2x250 mm	2x9.84 in	17.8 kg	FC	

To use with:
- LP.SP-190.20.8 (pag. 156)



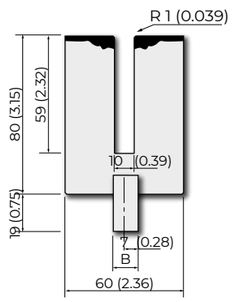
42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

LP.SM-190.20.10-12.7 / -12

525 mm	20.67 in	18.3 kg		B=12.7 mm
495 mm	19.49 in	17.2 kg	F	
2x250 mm	2x9.84 in	17.4 kg	FC	

525 mm	20.67 in	18.3 kg		B=12 mm
495 mm	19.49 in	17.2 kg	F	
2x250 mm	2x9.84 in	17.4 kg	FC	

Tu use with:
- LP.SP-190.20.10 (pag. 156)



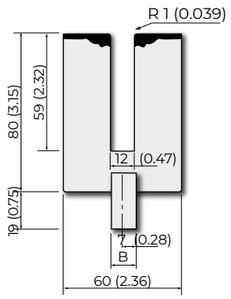
42Cr: 900-1150 N/mm² — 500 kN/m max. - 1000 kN/m max.

LP.SM-190.20.12-12.7 / -12

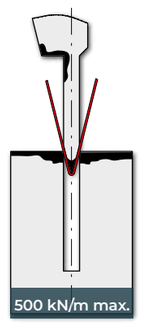
525 mm	20.67 in	13.6 kg		B=12.7 mm
495 mm	19.49 in	12.8 kg	F	
2x250 mm	2x9.84 in	13.0 kg	FC	

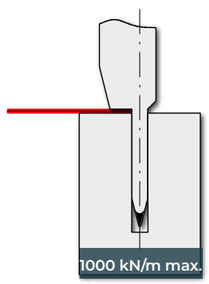
525 mm	20.67 in	13.6 kg		B=12 mm
495 mm	19.49 in	12.8 kg	F	
2x250 mm	2x9.84 in	13.0 kg	FC	

To use with:
- LP.SP-190.20.12 (pag. 156)



Example of Application





S [mm]	S [in]	A [mm]	A [in]	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	3.0	0.11	90	150
0.8	0.03	3.0	0.11	120	200
1.0	0.03	3.5	0.13	150	250
1.25	0.04	3.5	0.13	170	260

S [mm]	S [in]	A [mm]	A [in]	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	0.02	1.2	0.04	230	350
0.8	0.03	1.6	0.06	320	500
1.0	0.03	1.0	0.03	400	600
1.25	0.04	2.5	0.09	500	800

Segmented — On stock — Ask for delivery time

ROLLERI TOOLS TYPE RX

▼ **COMPATIBILITY**

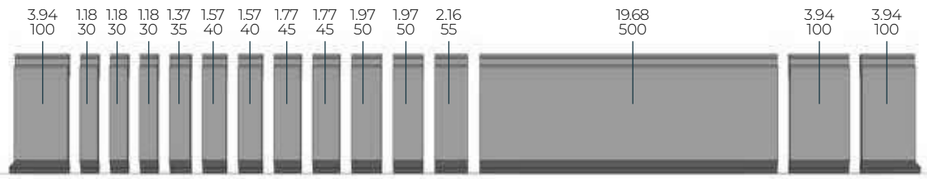
American
Ajail-Axial
Colly
Colgar
EHT
Gasparini
Hämmerle - Bystronic
Ursviken
Weinbrenner

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

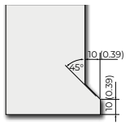
STANDARD LENGTH AND SEGMENTED

1020 mm (40.16 in)

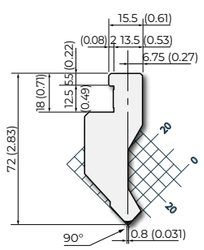
Total Length 1250 mm (49.21 in)



Horn types

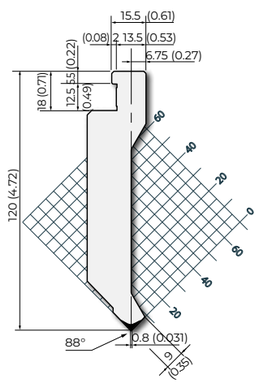


C45: 560-710 N/mm²		700 kN/m max.
CP72.90.08		
1020 mm	40.16 in	10.2 kg
1250 mm	49.21 in	12.5 kg F



90°

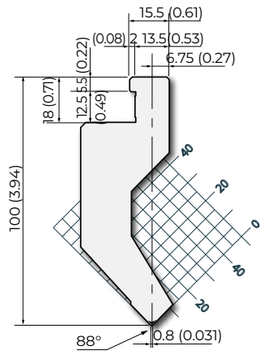
C45: 560-710 N/mm²		700 kN/m max.
CP120.88.08		
1020 mm	40.16 in	18.5 kg
1250 mm	49.21 in	22.6 kg F



88°

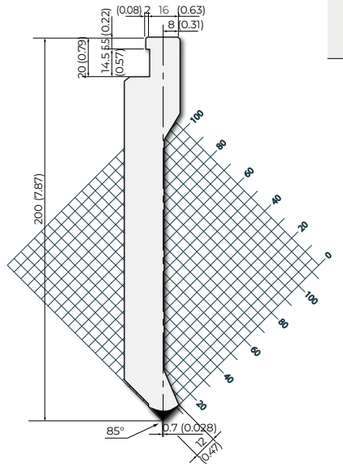
Punches RX Colly

42Cr: 900-1150 N/mm²		500 kN/m max.
CP100.88.08-A		
1020 mm	40.16 in	16.7 kg
1250 mm	49.21 in	20.4 kg F



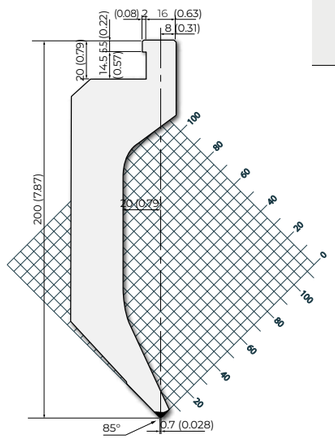
88°

42Cr: 900-1150 N/mm²		1000 kN/m max.
CP200.85.07		
1020 mm	40.16 in	31.6 kg
1250 mm	49.21 in	39.0 kg F



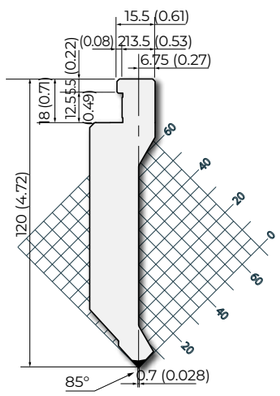
85°

42Cr: 900-1150 N/mm²		750 kN/m max.
CP200.85.07-A		
1020 mm	40.16 in	49.0 kg
1250 mm	49.21 in	60.0 kg F



85°

C45: 560-710 N/mm²		700 kN/m max.
CP120.85.07		
1020 mm	40.16 in	17.9 kg
1250 mm	49.21 in	21.9 kg F



85°

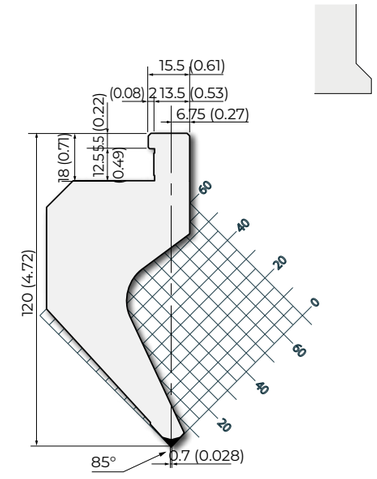
RX

Segmented · On stock · Ask for delivery time

C45: 560-710 N/mm² — 450 kN/m max.

CP120.85.07-A

1020 mm	40.16 in	25.5 kg	
1250 mm	49.21 in	49.0 kg	F

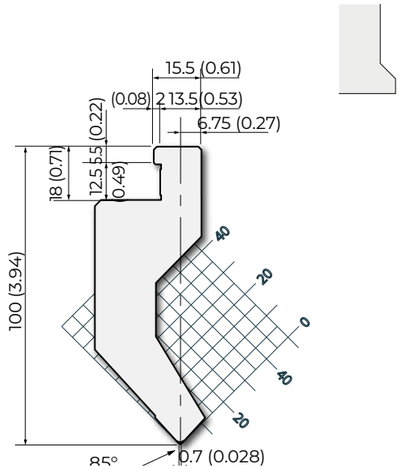


85°

C45: 560-710 N/mm² — 500 kN/m max.

CP100.85.07-A

1020 mm	40.16 in	17.0 kg	
1250 mm	49.21 in	49.0 kg	F

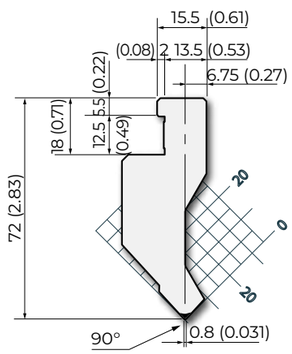


85°

C45: 560-710 N/mm² — 700 kN/m max.

CP72.85.07

1020 mm	40.16 in	10.0 kg	
1250 mm	49.21 in	49.0 kg	F

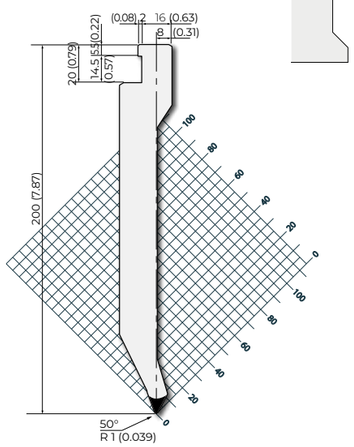


85°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

CP200.50.R1

1020 mm	40.16 in	49.0 kg	
1250 mm	49.21 in	38.0 kg	F

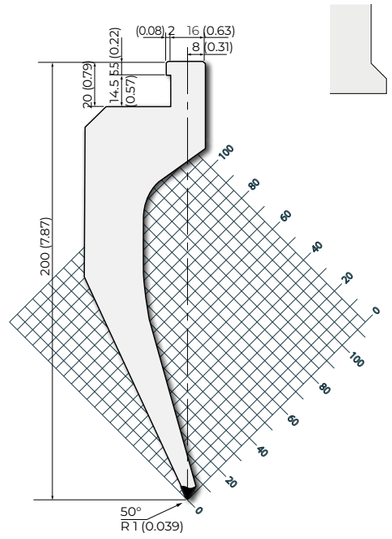


50°

42Cr: 900-1150 N/mm² — 550 kN/m max.

CP200.50.R1-A

1020 mm	40.16 in	52.0 kg	
1250 mm	49.21 in	47.0 kg	F

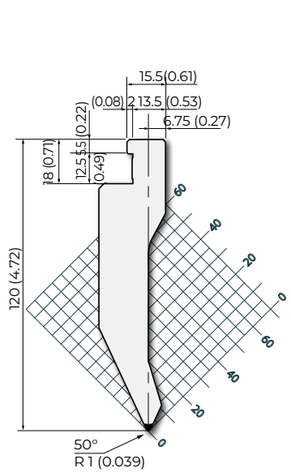


50°

C45: 560-710 N/mm² — 1000 kN/m max.

CP120.50.R1

1020 mm	40.16 in	17.0 kg	
1250 mm	49.21 in	38.0 kg	F

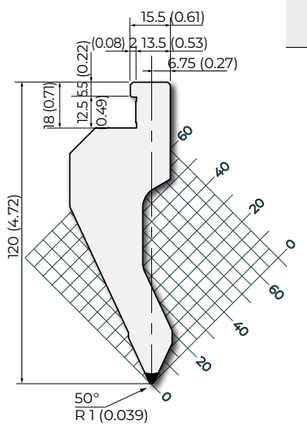


50°

42Cr: 900-1150 N/mm² — 550 kN/m max.

CP120.50.R1-A

1020 mm	40.16 in	21.0 kg	
1250 mm	49.21 in	38.0 kg	F

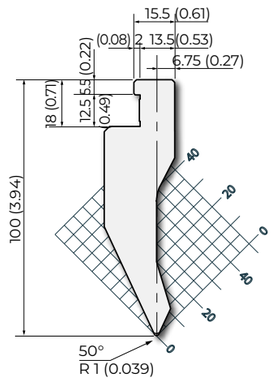


50°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

CP100.50.R1

1020 mm	40.16 in	13.0 kg	
1250 mm	49.21 in	38.0 kg	F



50°

RX

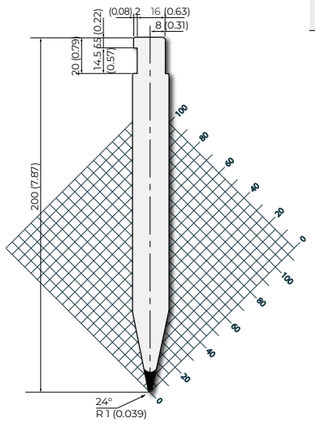
Segmented — On stock — Ask for delivery time

C45: 560-710 N/mm²

1300 kN/m max.

CP200.24.R1

1020 mm	40.16 in	49.0 kg
1250 mm	49.21 in	38.0 kg F

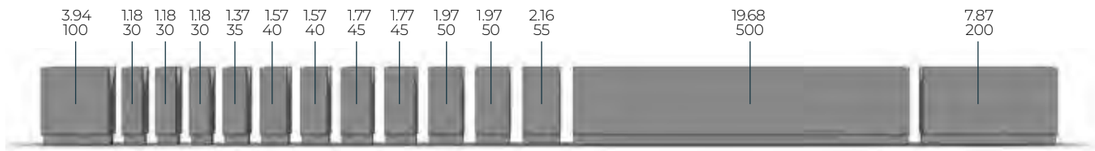


24°

STANDARD LENGTH AND SEGMENTED

1020 mm ((40.61 in)

Total Length 1250 mm (49.21 in)

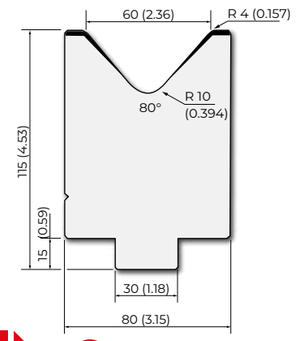


C45: 560-710 N/mm²

1200 kN/m max.

M115.80.60

1020 mm	40.16 in	60.0 kg
1250 mm	49.21 in	73.6 kg F



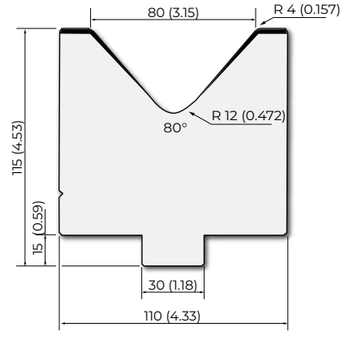
80°

C45: 560-710 N/mm²

1000 kN/m max.

M115.80.80

1020 mm	40.16 in	80.0 kg
1250 mm	49.21 in	98.0 kg F



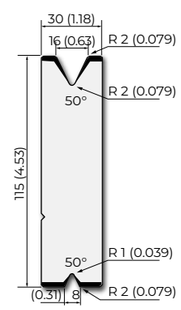
80°

C45: 560-710 N/mm²

600 kN/m max.

M115.50.16

1020 mm	40.16 in	26.5 kg
1250 mm	49.21 in	32.4 kg F



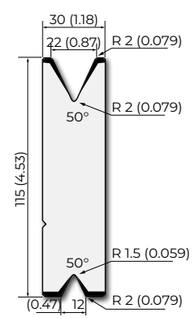
50°

C45: 560-710 N/mm²

500 kN/m max.

M115.50.22

1020 mm	40.16 in	25.5 kg
1250 mm	49.21 in	31.2 kg F



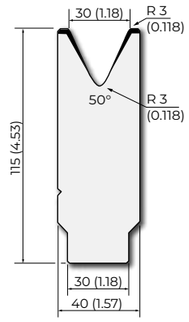
50°

RX

C45: 560-710 N/mm² — 400 kN/m max.

M115.50.30

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

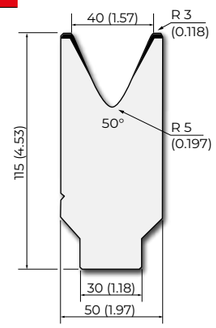


50°

C45: 560-710 N/mm² — 400 kN/m max.

M115.50.40

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

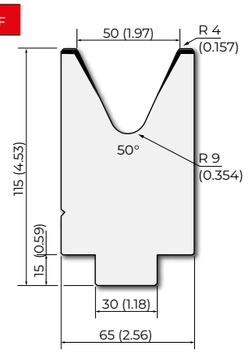


50°

C45: 560-710 N/mm² — 600 kN/m max.

M115.50.50

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

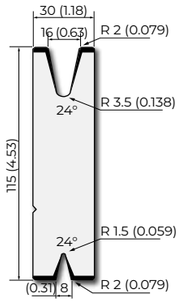


50°

C45: 560-710 N/mm² — 8: 700 kN/m max. - 16: 300 kN/m max.

M115.24.16

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



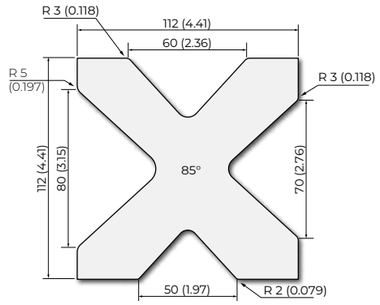
24°

C45: 560-710 N/mm² — See table

MC112.3050

3050 mm	120.08 in	188.0 kg

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



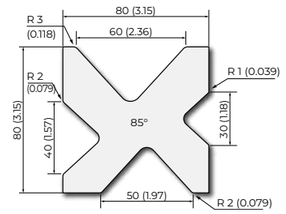
85°

C45: 560-710 N/mm² — See table

MC80.2050 / MC80.3050

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

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



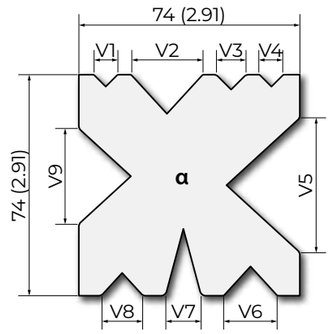
85°

C45: 560-710 N/mm² — See table

MC74.2050 / MC74.3050

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

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

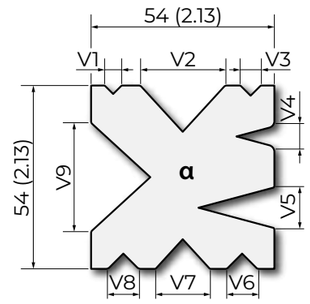


C45: 560-710 N/mm² — See table

MC54.2050 / MC54.3050

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

	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm [in]	6 [0.24]	25 [0.98]	6 [0.24]	6 [0.24]	12 [0.47]	9 [0.35]	16 [0.63]	9 [0.35]	32 [1.26]
Angle	90°	85°	90°	30°	30°	90°	85°	90°	85°
R mm [in]	0.5 [0.02]	1.0 [0.039]	0.5 [0.02]	2.0 [0.079]	0.5 [0.02]	1.0 [0.039]	0.5 [0.02]	1.5 [0.059]	1.0 [0.039]
kN/m max.	500	600	600	500	550	500	550	550	550



RX

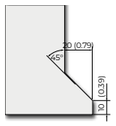
Punches RX Ajial-Axial

STANDARD LENGTH AND SEGMENTED

1020 mm (40.61 in)

Total Length 990 mm (39.98 in)

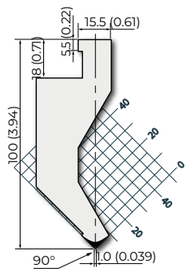
Horn types



C45: 560-710 N/mm² — 1000 kN/m max.

AXP.100.90.1

1020 mm	40.16 in	16.3 kg	
990 mm	38.98 in	15.2 kg	F

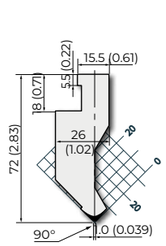


90°

C45: 560-710 N/mm² — 1000 kN/m max.

AXP.72.90.1

1020 mm	40.16 in	10.0 kg	
990 mm	38.98 in	9.7 kg	F

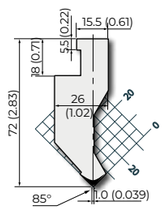


90°

C45: 560-710 N/mm² — 1000 kN/m max.

AXP.72.85.1

1020 mm	40.16 in	10.0 kg	
990 mm	38.98 in	9.7 kg	F

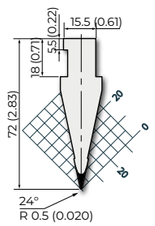


85°

C45: 560-710 N/mm² — 1000 kN/m max.

AXP.72.24.R05

1020 mm	40.16 in	7.1 kg	
990 mm	38.98 in	6.9 kg	F



24°

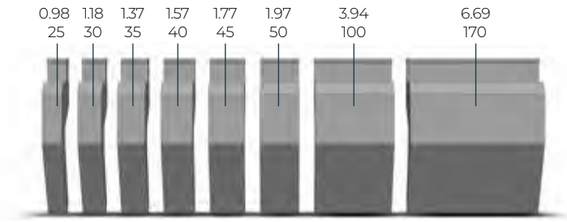
Punches RX Gasparini

STANDARD LENGTH AND SEGMENTED

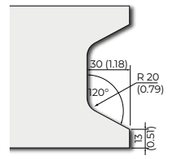
▸ PUNCHES

525 mm (20.67 in)

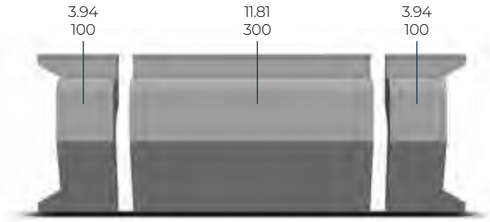
Total Length 495 mm (19.49 in)



Horn types



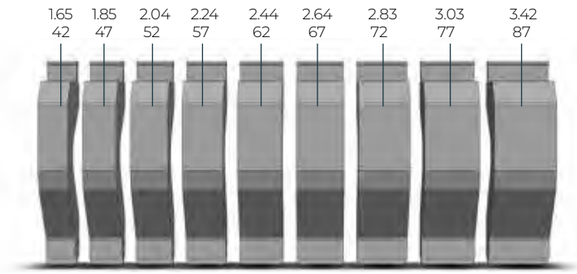
Total Length 500 mm (19.678 in)



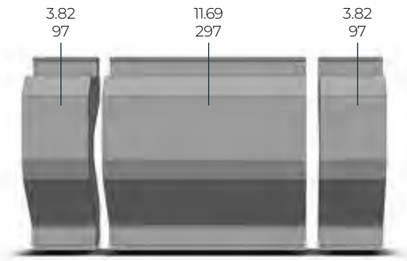
▸ RADIUS TOOLS HOLDER

522 mm (20.55 in)

Total Length 563 mm (22.17 in)



Total Length 491 mm (19.33 in)

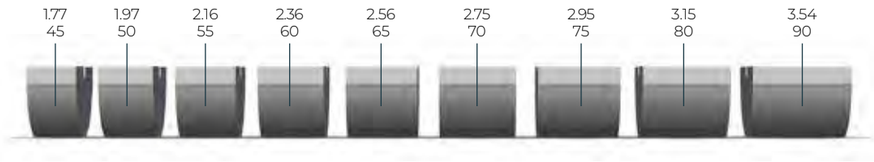


RX

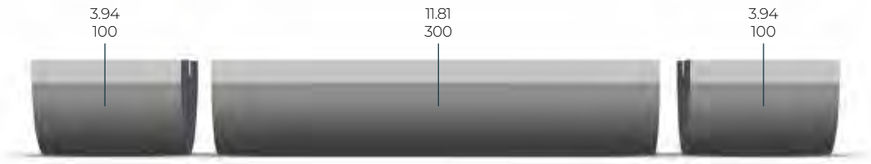
▸ RADIUS TOOLS

525 mm (20.67 in)

Total Length 590 mm (23.23 in)



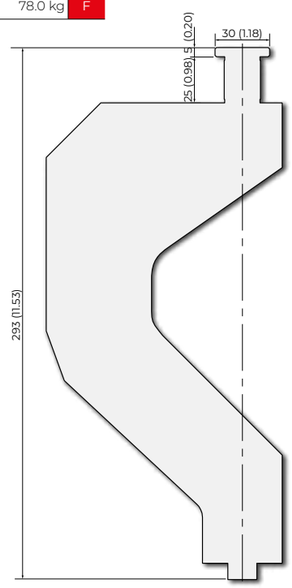
Total Length 500 mm (19.68 in)



C45: 560-710 N/mm² — 1000 kN/m max.

GASP293-16

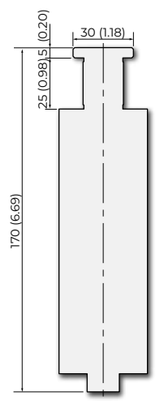
522 mm	20.55 in	83.0 kg	
563 mm	22.17 in	89.5 kg	F
491 mm	19.33 in	78.0 kg	F



C45: 560-710 N/mm² — 1800 kN/m max.

GASP170-16

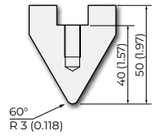
522 mm	20.55 in	24.0 kg	
563 mm	22.17 in	4.5 kg	F
491 mm	19.33 in	4.5 kg	F



C45: 560-710 N/mm² — 1000 kN/m max.

GASP40.60.03

525 mm	20.67 in	4.7 kg	
590 mm	23.23 in	5.3 kg	FX
491 mm	19.33 in	4.5 kg	F

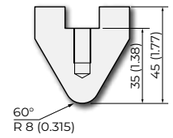


60°

C45: 560-710 N/mm² — 1000 kN/m max.

GASP35.60.08

525 mm	20.67 in	4.7 kg	
590 mm	23.23 in	5.3 kg	FX
491 mm	19.33 in	4.5 kg	F

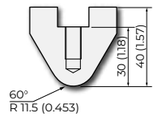


60°

C45: 560-710 N/mm² — 1000 kN/m max.

GASP30.60.11.5

525 mm	20.67 in	4.2 kg	
590 mm	23.23 in	4.7 kg	FX
500 mm	19.68 in	4.0 kg	F

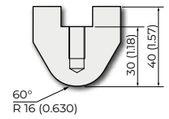


60°

C45: 560-710 N/mm² — 1000 kN/m max.

GASP30.60.16

525 mm	20.67 in	4.7 kg	
590 mm	23.23 in	5.3 kg	FX
500 mm	19.68 in	4.5 kg	F

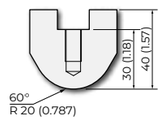


60°

C45: 560-710 N/mm² — 1000 kN/m max.

GASP30.60.20

525 mm	20.67 in	5.0 kg	
590 mm	23.23 in	5.6 kg	FX
500 mm	19.68 in	4.3 kg	F

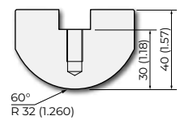


60°

C45: 560-710 N/mm² — 1000 kN/m max.

GASP30.60.32

525 mm	20.67 in	7.0 kg	
590 mm	23.23 in	7.8 kg	FX
500 mm	19.68 in	6.7 kg	F

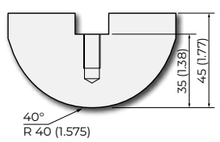


60°

C45: 560-710 N/mm² — 1500 kN/m max.

GASP35.40.40

525 mm	20.67 in	10.5 kg	
590 mm	23.23 in	11.8 kg	FX
500 mm	19.68 in	10.0 kg	F

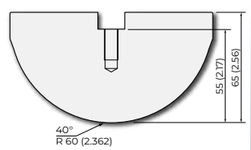


40°

C45: 560-710 N/mm² — 1800 kN/m max.

GASP55.40.60

525 mm	20.67 in	24.4 kg	
590 mm	23.23 in	27.4 kg	FX
500 mm	19.68 in	23.2 kg	F



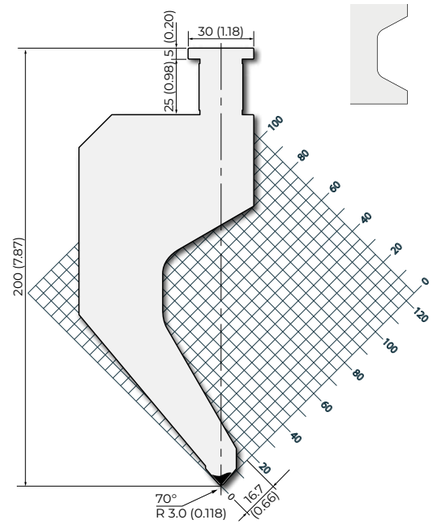
40°

RX

42Cr: 900-1150 N/mm² — 1000 kN/m max.

GASP200.70.R3-30

525 mm	20.67 in	31.8 kg	
495 mm	19.48 in	30.0 kg	F
500 mm	19.68 in	30.3 kg	F

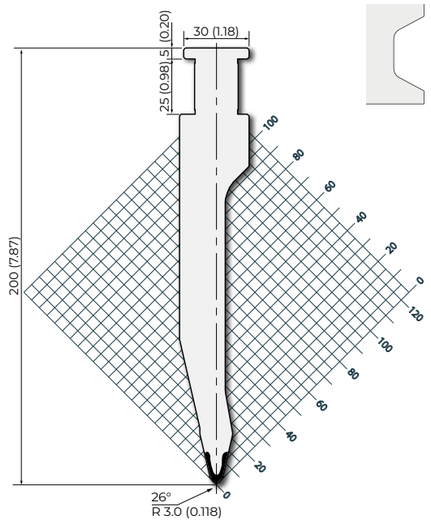


70°

42Cr: 900-1150 N/mm² — 1300 kN/m max.

GASP200.26.R3-30

525 mm	20.67 in	16.9 kg	
495 mm	19.48 in	10.6 kg	F
500 mm	19.68 in	10.7 kg	F

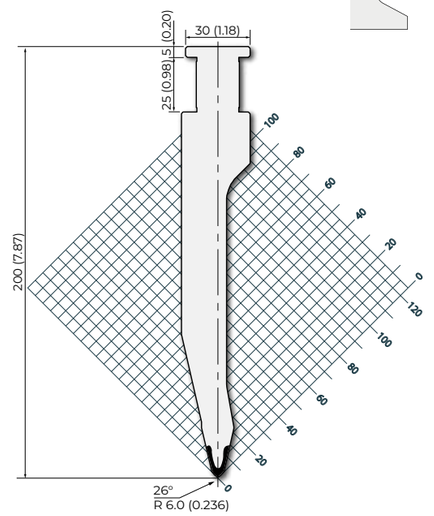


26°

42Cr: 900-1150 N/mm² — 1300 kN/m max.

GASP200.26.R6-30

525 mm	20.67 in	16.9 kg	
495 mm	19.48 in	10.6 kg	F
500 mm	19.68 in	10.7 kg	F

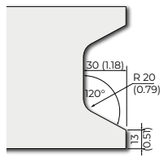


26°

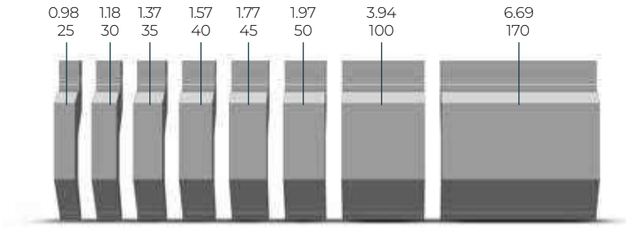
STANDARD LENGTH AND SEGMENTED

525 mm (20.67 in)

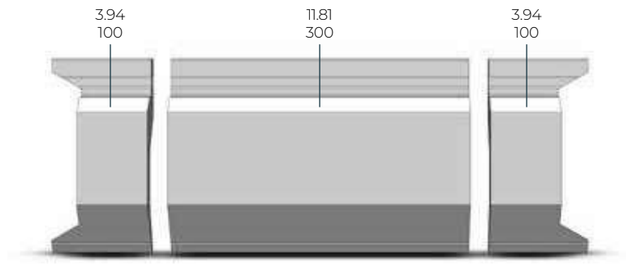
Horn types



Total Length 495 mm (19.49 in)



Total Length 500 mm (19.68 in)



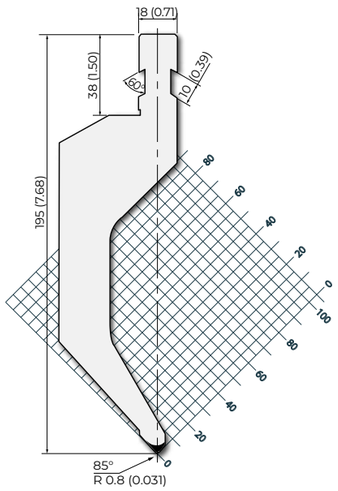
RX

Segmented · On stock · Ask for delivery time

42Cr: 900-1150 N/mm² — 1000 kN/m max.

PAC195.85.R08

525 mm	20.67 in	20.6 kg	
495 mm	19.48 in	19.4 kg	F
500 mm	19.68 in	19.6 kg	F

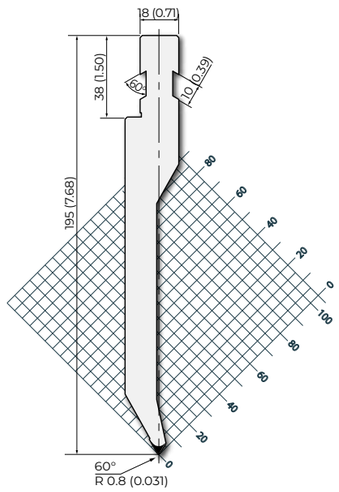


85°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

PAC195.60.R08

525 mm	20.67 in	12.0 kg	
495 mm	19.48 in	11.3 kg	F
500 mm	19.68 in	11.4 kg	F

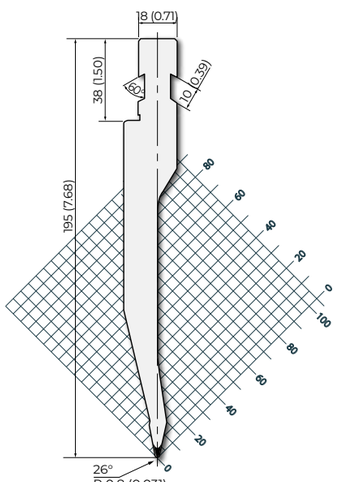


60°

42Cr: 900-1150 N/mm² — 1000 kN/m max.

PAC195.26.R08

525 mm	20.67 in	12.0 kg	
495 mm	19.48 in	11.3 kg	F
500 mm	19.68 in	11.4 kg	F

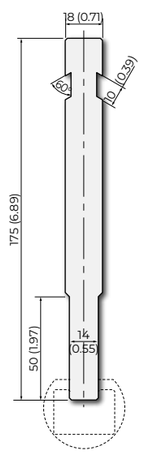


26°

C45: 560-710 N/mm² — 1000 kN/m max.

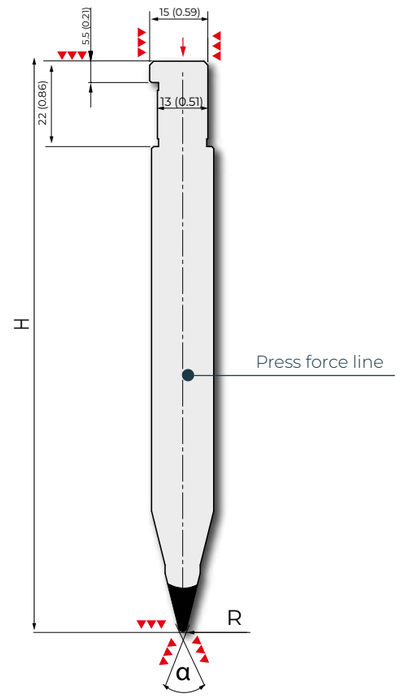
PAC175.14

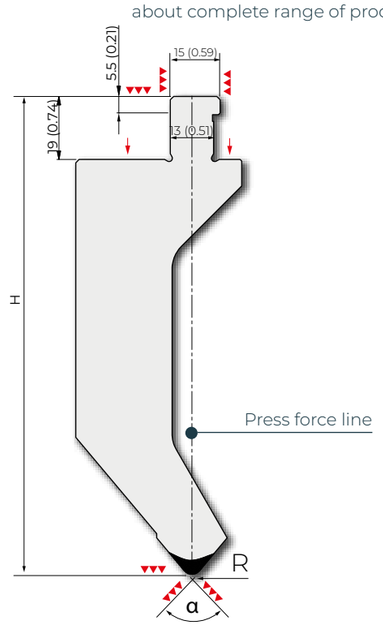
830 mm	32.68 in	18.0 kg
412 mm	16.22 in	9.0 kg

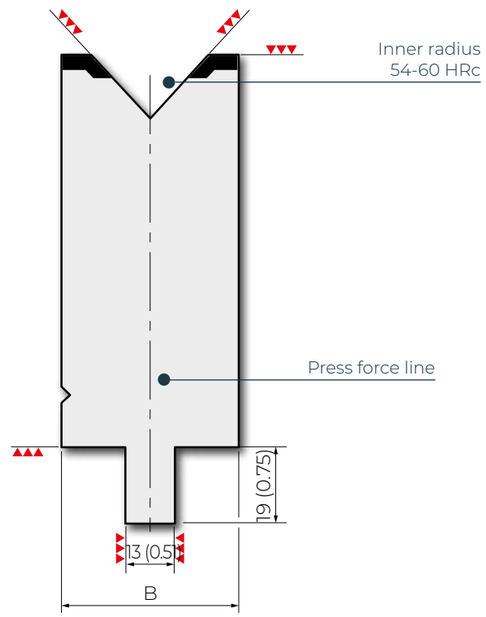


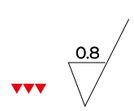
STANDARD TANG

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





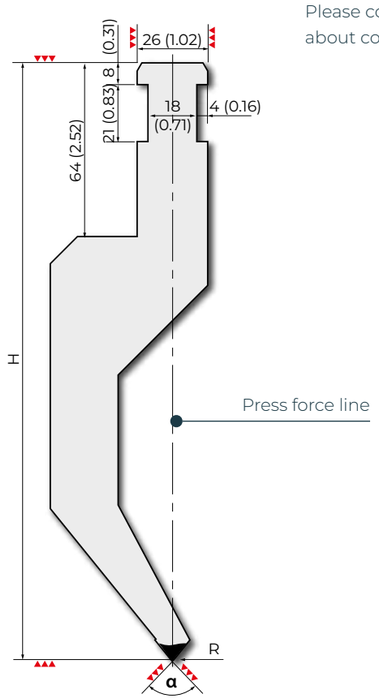


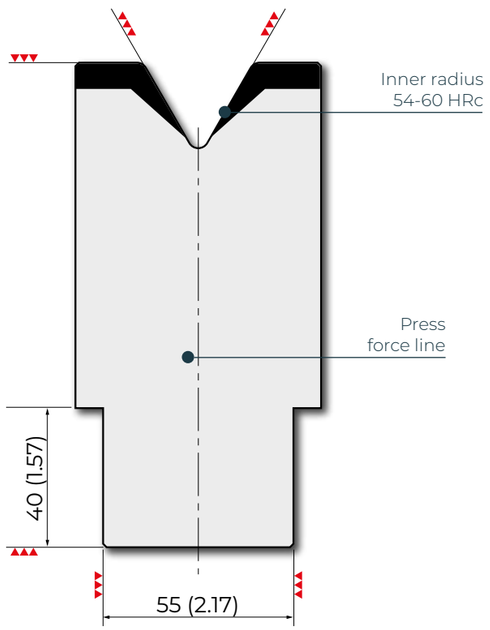


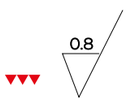
RX

STANDARD TANG

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

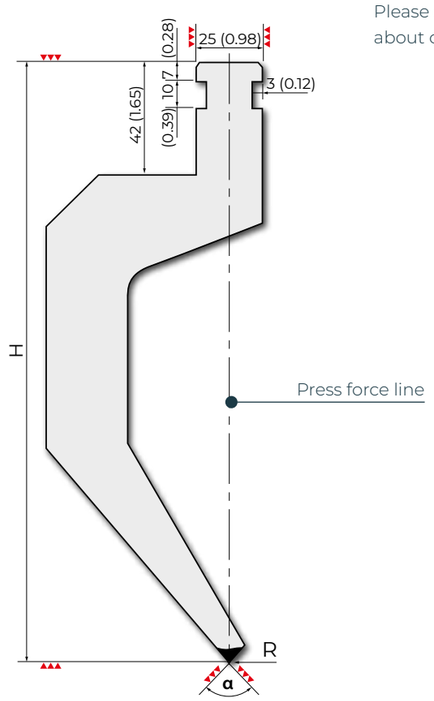


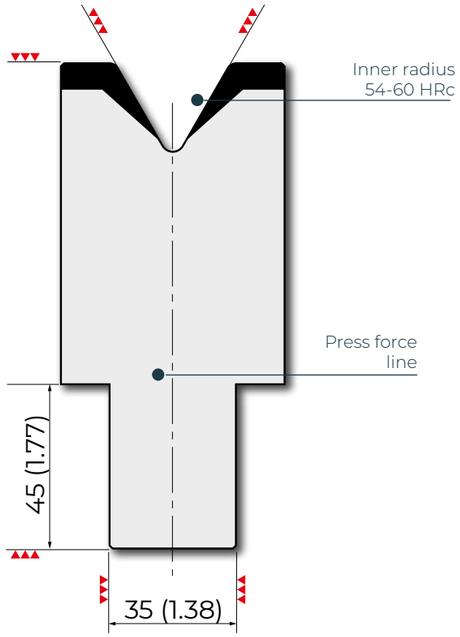


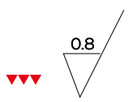


STANDARD TANG

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







RX

STANDARD TANG

REQUEST NEW
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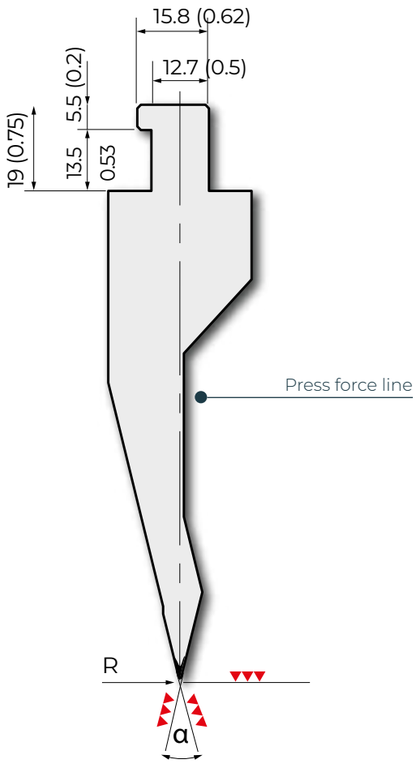
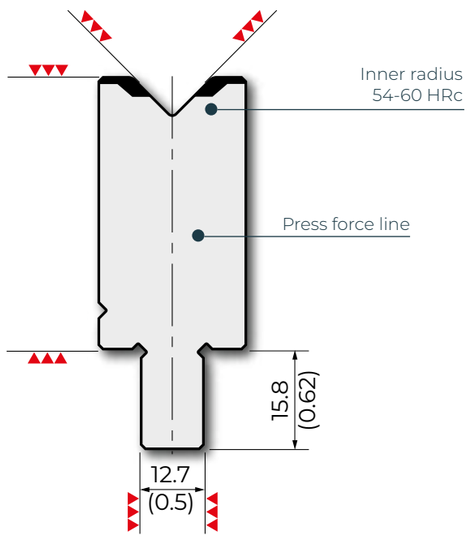
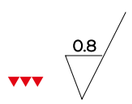
CATALOGUE



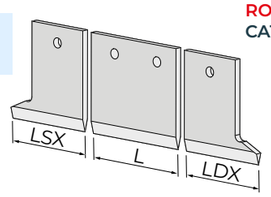




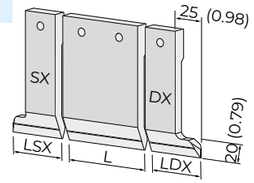
STANDARD TANG

REQUEST NEW
ROLLERI COMPLETE
CATALOGUE

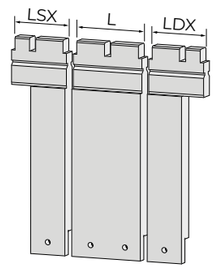
H11



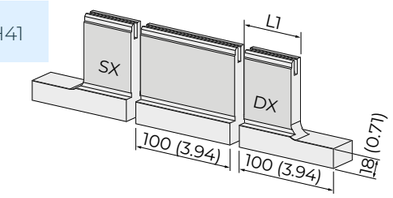
H12



H21



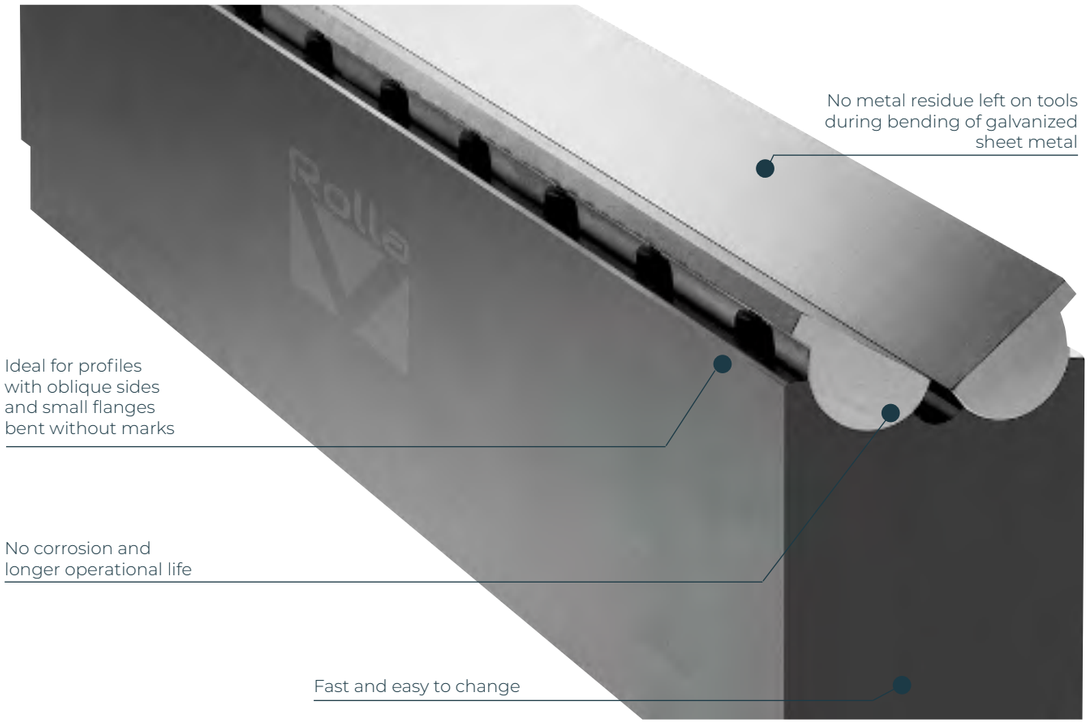
H31 - H41



RX

ROLLERI ROLLA-V ONYX DIES

Content Explanation	194 - 196
Rolla-V Onyx dies	197 - 201
Model 1	197
Model 2	198
Model 2.5	199
Model 3	200
Model 4	201
Adjustable Dies	202 - 203



STANDARD LENGTH

200 mm (7.87 in)

500 mm (19.68 in)

Rolla-V Onyx Ref.	Model	Tang (mm)	Tang (in)	Compatibility	Rolleri tools Type
RVP	1, 2, 3	60	2.36	Are compatible with press brake machines from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-BeyelerEuro-B, Coastone, Colgar, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturrospe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.	R1
RVS	1, 2, 3	14	0.55	Amada single V Style	R1
RVT	1, 2, 3	13	0.51	Are compatible with press brake machines from: Bystronic, Beyeler, Edwards, Safan, SMD, Trumpf	R2 R3
RVT90	1, 2, 3	12.7	0.50	Are compatible with press brakes machines from: LVD	R4
RVM	2.5, 3, 4	Various die holders	Various die holders	All press brake machines (various die holders)	-

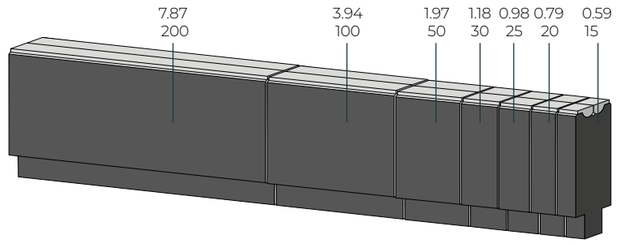
Content Explanation

	Equivalent V size mm [in]	Max. tool load [kN/m]	Material Thickness mm [in]		Min. bending angle	Needed press force [kN/m]	Min. outside flange mm [in]		Max. outside radius mm [in]	
MODEL 1 Max. recommended thickness =1.5 mm [0.06 in] [2.0 mm / 0.08 in possible]	8 [0.31]	1000	0.70	[0.03]	40°	50	3.0	[0.12]	3.0	[0.12]
		1000	1.10	[0.04]	35°	130	3.9	[0.15]	2.6	[0.10]
		1000	1.50	[0.06]	35°	270	4.2	[0.17]	2.2	[0.09]
MODEL 2 Max. recommended thickness =3.0 mm [0.12 in] [4.0 mm/0.15 in possible]	15 [0.59]	1500	2.00	[0.08]	59°	210	8.5	[0.33]	6.0	[0.24]
		1500	3.00	[0.12]	47°	550	9.3	[0.37]	5.0	[0.20]
		1500	3.20	[0.13]	47°	650	9.3	[0.37]	4.8	[0.19]
MODEL 2.5 Max. recommended thickness =5.0 mm [0.20 in] [6.35 mm / 0.24 in possible]	28 [1.10]	2500	2.00	[0.08]	46°	100	18.6	[0.73]	13.2	[0.52]
		2500	4.00	[0.16]	46°	470	18.6	[0.73]	12.0	[0.47]
		2500	6.00	[0.24]	55°	1270	18.6	[0.73]	9.8	[0.39]
MODEL 3 Max. recommended thickness =6.3 mm [0.25 in] [8.0 mm / 0.31 in possible]	38 [1.50]	2500	2.00	[0.08]	68°	70	22.5	[0.89]	13.9	[0.55]
		2500	4.00	[0.16]	47°	340	22.5	[0.89]	11.9	[0.47]
		2500	6.00	[0.24]	50°	900	22.5	[0.89]	9.9	[0.39]
MODEL 4 Max. recommended thickness =16.0 mm [0.63 in]	85 [3.35]	3000	6.00	[0.24]	78°	260	56.6	[2.23]	36.4	[1.43]
		3000	8.00	[0.31]	76°	500	56.6	[2.23]	36.4	[1.43]
		3000	12.00	[0.47]	73°	1290	56.6	[2.23]	36.4	[1.43]

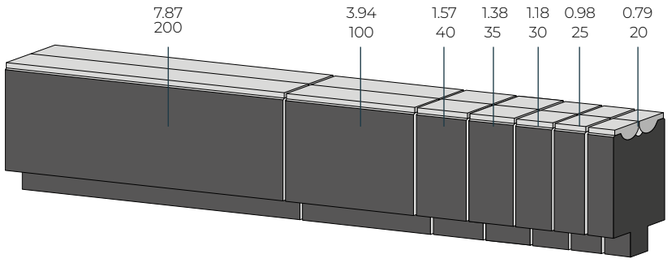
Content Explanation

SEGMENTATION

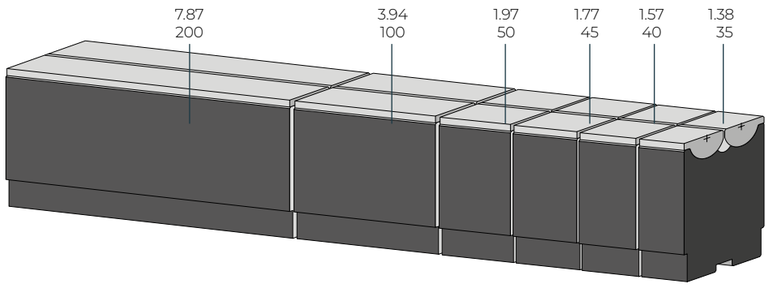
Model 1: 440 mm (17.32 in)- 7 segments



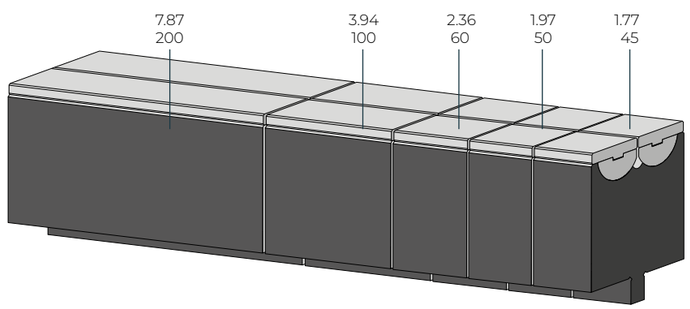
Model 2: 450 mm (17.72 in) - 7 segments



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

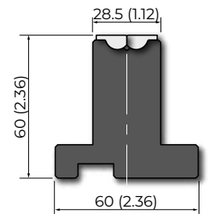


Model 3: 455 mm (17.91 in) - 5 segments

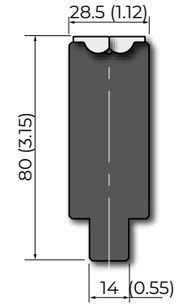


Rolla-V Onyx Dies - Model 1

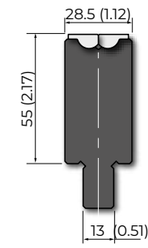
42Cr: 900-1150 N/mm²	Toolox 44	1000 kN/m max.
RVP60-1		
500 mm	16.68 in	6.9 kg
440 mm	17.32 in	6.1 kg F



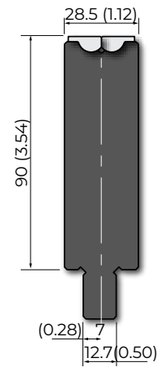
42Cr: 900-1150 N/mm²	Toolox 44	1000 kN/m max.
RVS80-1		
500 mm	16.68 in	6.3 kg
440 mm	17.32 in	5.8 kg F



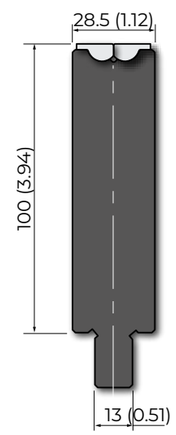
42Cr: 900-1150 N/mm²	Toolox 44	1000 kN/m max.
RVT55-1		
500 mm	16.68 in	5.5 kg
440 mm	17.32 in	5.0 kg F



42Cr: 900-1150 N/mm²	Toolox 44	1000 kN/m max.
RVT90-1		
500 mm	16.68 in	9.4 kg
440 mm	17.32 in	7.8 kg F



42Cr: 900-1150 N/mm²	Toolox 44	1000 kN/m max.
RVT100-1		
500 mm	16.68 in	9.4 kg
440 mm	17.32 in	8.6 kg F



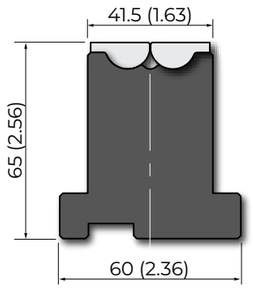
MODEL 1 - Features			
Max. recommended thickness	=1.5 mm [0.06 in] [2.0 mm / 0.08 in possible]		
Material Thickness mm [in]	0.70 [0.03]	1.10 [0.04]	1.50 [0.06]
Equivalent V size mm [in]	8 [0.31]		
Max. tool load (kN/m)	1000	1000	1000
Min. bending angle	40°	35°	35°
Needed press force mild steel with max. 450 N/mm² (kN/m)	50	130	270
Needed press force stainless steel with max. 700 N/mm² (kN/m)	70	200	410
Min. outside flange mm [in]	3.0 [0.12]	3.9 [0.15]	4.2 [0.17]
Max. outside radius mm [in]	3.0 [0.12]	2.6 [0.10]	2.2 [0.09]

Rolla-V Onyx Dies - Model 2

42Cr: 900-1150 N/mm² | Toolox 44 | 1500 kN/m max.

RVP65-2

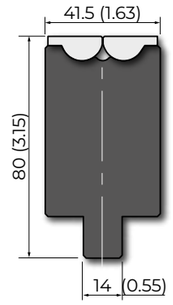
500 mm	16.68 in	7.9 kg	
450 mm	17.72 in	7.4 kg	F



42Cr: 900-1150 N/mm² | Toolox 44 | 1500 kN/m max.

RVS80-2

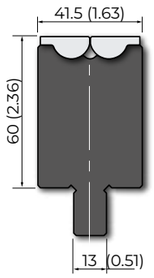
500 mm	16.68 in	8.3 kg	
450 mm	17.72 in	7.8 kg	F



42Cr: 900-1150 N/mm² | Toolox 44 | 1500 kN/m max.

RVT60-2

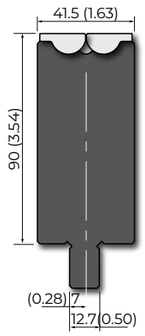
500 mm	16.68 in	7.9 kg	
450 mm	17.72 in	7.4 kg	F



42Cr: 900-1150 N/mm² | Toolox 44 | 1500 kN/m max.

RVT90-2

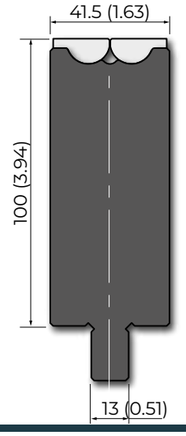
500 mm	16.68 in	11.3 kg	
450 mm	17.72 in	10.6 kg	F



42Cr: 900-1150 N/mm² | Toolox 44 | 1500 kN/m max.

RVT100-2

500 mm	16.68 in	12.4 kg	
450 mm	17.72 in	11.7 kg	F



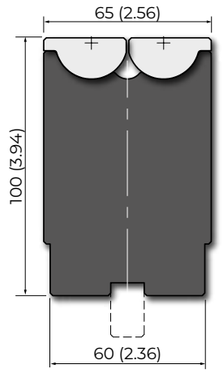
MODEL 2 - Features			
Max. recommended thickness	=3.0 mm [0.12 in] [4.0 mm / 0.15 in possible]		
Material Thickness mm [in]	2.00 [0.08]	3.00 [0.12]	3.20 [0.13]
Equivalent V size mm [in]	15 [0.59]		
Max. tool load (kN/m)	1500	1500	1500
Min. bending angle	59°	47°	47°
Needed press force mild steel with max. 450 N/mm² (kN/m)	210	550	650
Needed press force stainless steel with max. 700 N/mm² (kN/m)	320	850	1000
Min. outside flange mm [in]	8.5 [0.33]	9.3 [0.37]	9.3 [0.37]
Max. outside radius mm [in]	6.0 [0.24]	5.0 [0.20]	4.8 [0.19]

Rolla-V Onyx Dies - Model 2.5

42Cr: 900-1150 N/mm² | Toolox 44 | 2000 kN/m max.

RVM2.5

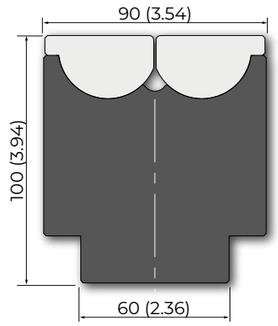
Without tang		
500 mm	16.68 in	22.0 kg
470 mm	18.50 in	21.0 kg F
With tang 0.51 x 0.79 in		
500 mm	16.68 in	23.5 kg
470 mm	18.50 in	22.4 kg F
With tang 0.5 x 0.75 in		
500 mm	16.68 in	23.5 kg
470 mm	18.50 in	22.4 kg F



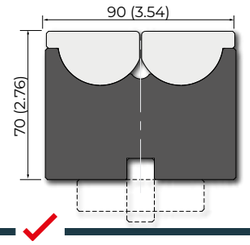
MODEL 2.5 - Features			
Max. recommended thickness	=5.0 mm [0.20 in] [6.35 mm / 0.24 in possible]		
Material Thickness mm [in]	2.00 [0.08]	4.00 [0.16]	6.00 [0.24]
Equivalent V size mm [in]	28 [1.10]		
Max. tool load (kN/m)	2500	2500	2500
Min. bending angle	46°	46°	55°
Needed press force mild steel with max. 450 N/mm² (kN/m)	100	470	1270
Needed press force stainless steel with max. 700 N/mm² (kN/m)	150	730	1960
Min. outside flange mm [in]	18.6 [0.73]	18.6 [0.73]	18.6 [0.73]
Max. outside radius mm [in]	13.2 [0.52]	12.0 [0.47]	9.8 [0.39]

Rolla-V Onyx Dies - Model 3

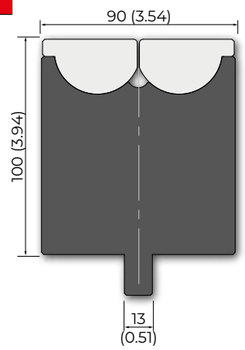
42Cr: 900-1150 N/mm²	Toolox 33	2500 kN/m max.
RVP100-3		
500 mm	16.68 in	28.8 kg
455 mm	17.91 in	26.2 kg F



42Cr: 900-1150 N/mm²	Toolox 33	2500 kN/m max.
RVM70-3		
Without tang		
500 mm	16.68 in	20.6 kg
455 mm	17.91 in	18.7 kg F
With base 2.36 in		
500 mm	16.68 in	23.5 kg
455 mm	17.91 in	23.0 kg F
With tang 0.51 in		
500 mm	16.68 in	22.1 kg
455 mm	17.91 in	20.1 kg F
With offset tang 0.5 in		
500 mm	16.68 in	22.1 kg
455 mm	17.91 in	20.1 kg F



42Cr: 900-1150 N/mm²	Toolox 33	2500 kN/m max.
RVT100-3		
500 mm	16.68 in	30.9 kg
455 mm	17.91 in	28.5 kg F

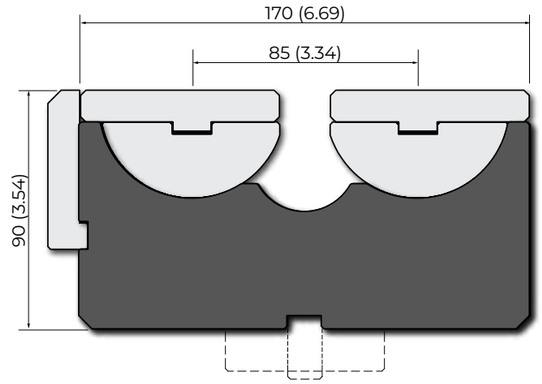


MODEL 3 - Features			
Max. recommended thickness	=6.3 mm [0.25 in] [8.0 mm / 0.31 in possible]		
Material Thickness mm [in]	2.00 [0.08]	4.00 [0.16]	6.00 [0.24]
Equivalent V size mm [in]	38 [1.50]		
Max. tool load (kN/m)	2500	2500	2500
Min. bending angle	68°	47°	50°
Needed press force mild steel with max. 450 N/mm² (kN/m)	70	340	900
Needed press force stainless steel with max. 700 N/mm² (kN/m)	110	550	1300
Min. outside flange mm [in]	22.5 [0.89]	22.5 [0.89]	22.5 [0.89]
Max. outside radius	13.9 [0.55]	11.9 [0.47]	9.9 [0.39]

Rolla-V Onyx Dies - Model 4

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

42Cr: 900-1150 N/mm²	Toolox 33	3000 kN/m max.
RVM90-4		
Without tang		
500 mm	16.68 in	56.6 kg
200 mm	7.87 in	22.7 kg F
With base 2.36 in		
500 mm	16.68 in	61.3 kg
200 mm	7.87 in	24.6 kg F
With tang 0.51 in		
500 mm	16.68 in	58.1 kg
200 mm	7.87 in	23.3 kg F
With offset tang 0.5 in		
500 mm	16.68 in	58.1 kg
200 mm	7.87 in	23.3 kg F



MODEL 4 - Features			
Max. recommended thickness	=16.0 mm [0.63 in]		
Material Thickness mm [in]	6.00 [0.24]	8.00 [0.31]	12.00 [0.47]
Equivalent V size mm [in]	85 [3.35]		
Max. tool load (kN/m)	3000	3000	3000
Min. bending angle	78°	76°	73°
Needed press force mild steel with max. 450 N/mm² (kN/m)	260	500	1290
Needed press force stainless steel with max. 700 N/mm² (kN/m)	440	840	2150
Min. outside flange mm [in]	56.6 [2.23]	56.6 [2.23]	56.6 [2.23]
Max. outside radius mm [in]	36.4 [1.43]	36.4 [1.43]	36.4 [1.43]

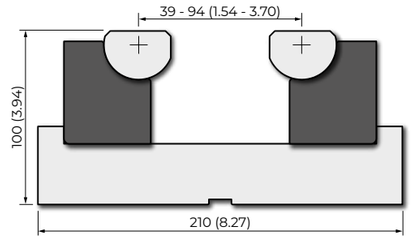
Rolla-V Onyx Dies - Adjustable Dies

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

42Cr: 900-1150 N/mm² | Toolox 33 | 2500 kN/m max.

RVPV3

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



39 - 94

42Cr: 900-1150 N/mm² | Toolox 33 | 3500 kN/m max.

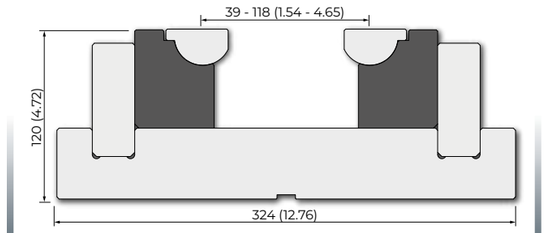
RVHD3

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

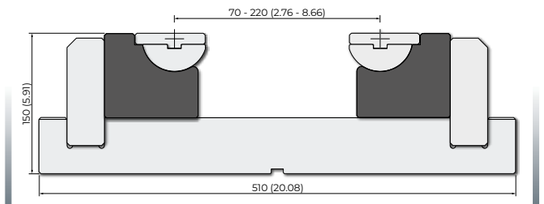
42Cr: 900-1150 N/mm² | Toolox 33 | 3500 kN/m max.

RVHD4

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



39 - 118



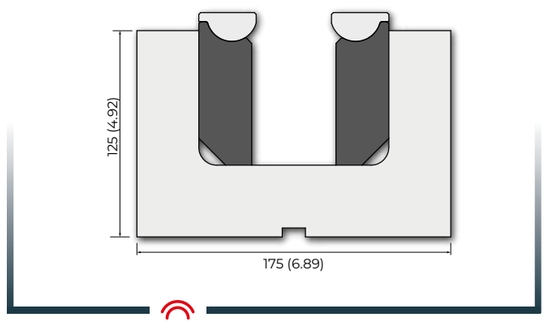
70 - 220

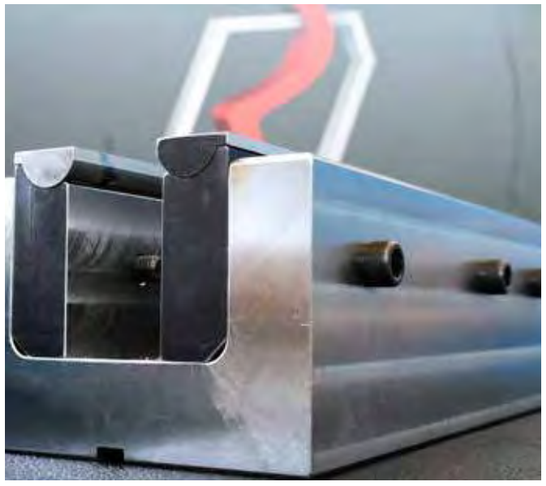
42Cr: 900-1150 N/mm² | Toolox 33 | 1500 kN/m max.

RVHD2.5

500 mm	16.68 in	67.5 kg	
200 mm	7.87 in	27 kg	F

NEW





- V-Bending
- Flat inserts

- Radius-Bending
- Flat inserts

- Conical Bending
- Flat inserts

- Radius-Overbending
- Concave inserts

- U-Bending
- V-inserts

ROLLERI ADAPTERS

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

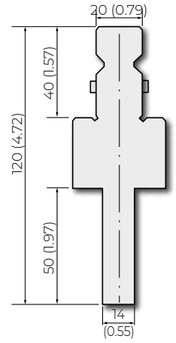
PUNCHES - ADAPTERS

Punches - Adapters

C45: 560-710 N/mm² — 1000 kN/m max.

AD11

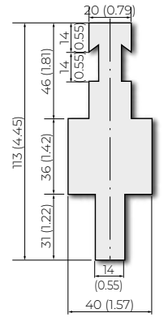
150 mm	5.91 in	3.0 kg	R2 → R1



C45: 560-710 N/mm² — 1000 kN/m max.

AD22

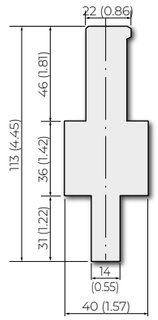
150 mm	5.91 in	3.4 kg	R3 R → R1



C45: 560-710 N/mm² — 1000 kN/m max.

AD3

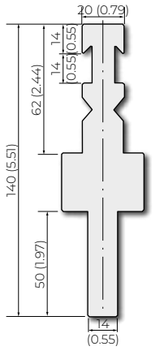
150 mm	5.91 in	3.3 kg	R3 S → R1



C45: 560-710 N/mm² — 1000 kN/m max.

AD10

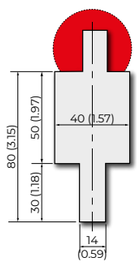
150 mm	5.91 in	3.4 kg	R3 RFA → R1

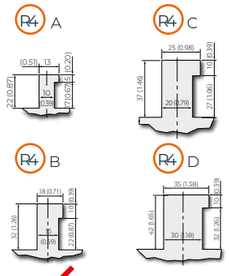


C45: 560-710 N/mm² — 1000 kN/m max.

AD1

AD1-A	150 mm	5.91 in	3.1 kg	R4 A → R1
AD1-B	150 mm	5.91 in	3.1 kg	R4 B → R1
AD1-C	150 mm	5.91 in	3.1 kg	R4 C → R1
AD1-D	150 mm	5.91 in	3.1 kg	R4 D → R1

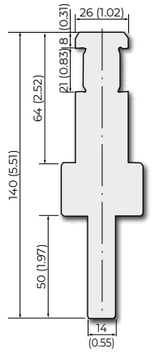




C45: 560-710 N/mm² — 1000 kN/m max.

AD13

150 mm	5.91 in	3.0 kg	RX EHT → R1

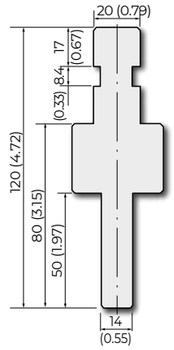


10

C45: 560-710 N/mm² — 1000 kN/m max.

AD14

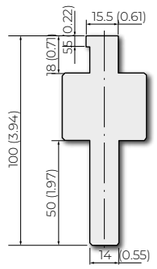
150 mm	5.91 in	3.2 kg	RX Gasparini → R1



C45: 560-710 N/mm² — 1000 kN/m max.

AD15

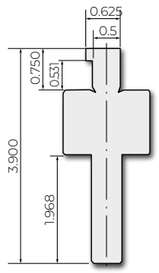
150 mm	5.91 in	3.0 kg	RX Ajial-Axial → R1



C45: 560-710 N/mm² — 1000 kN/m max.

AD16

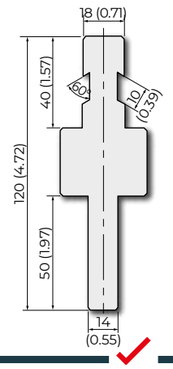
150 mm	5.91 in	4.0 kg	R American → R1



C45: 560-710 N/mm² — 1000 kN/m max.

AD12

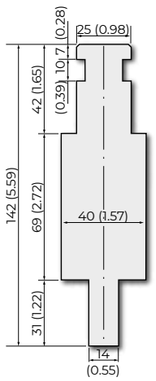
150 mm	5.91 in	3.0 kg	RX Colgar → R1



C45: 560-710 N/mm² — 1000 kN/m max.

AD23

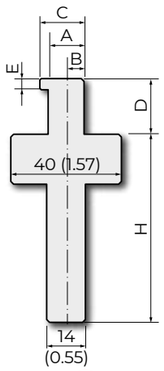
150 mm	5.91 in	5.0 kg	RX Weinbrenner → R1



C45: 560-710 N/mm² — 1000 kN/m max.

ADX

150 mm	5.91 in	3.5 kg	Type X → R1 Production according to your specifications

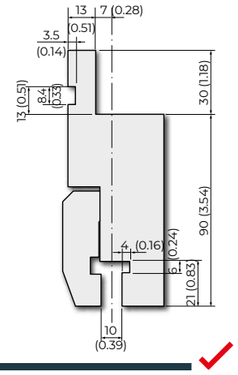


Punches - Adapters

C45: 560-710 N/mm² — 1000 kN/m max.

AD19-A

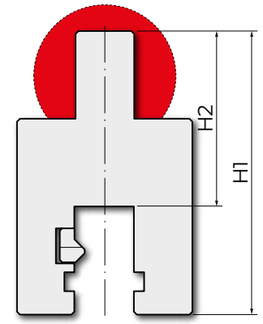
150 mm	5.91 in	6.0 kg	R1 → R4



C45: 560-710 N/mm²

ADX2

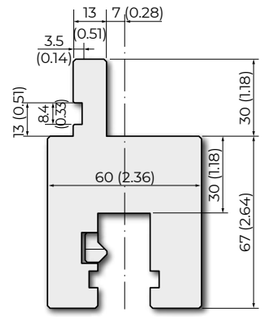
150 mm	5.91 in	2.4 kg	Type X → R2 Production according to your specifications



C45: 560-710 N/mm² — 1000 kN/m max.

AD20

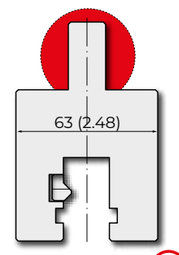
150 mm	5.91 in	4.0 kg	R1 → R2



C45: 560-710 N/mm² — 1000 kN/m max.

AD20 LVD

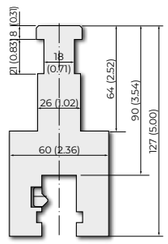
AD20 LVD-A	150 mm	5.91 in	3.6 kg	R4 A → R1
AD20 LVD-B	150 mm	5.91 in	3.8 kg	R4 B → R1
AD20 LVD-C	150 mm	5.91 in	4.0 kg	R4 C → R1
AD20 LVD-D	150 mm	5.91 in	4.0 kg	R4 D → R1



C45: 560-710 N/mm² — 1000 kN/m max.

AD28

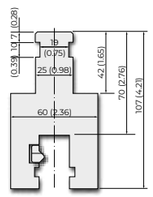
150 mm	5.91 in	5.0 kg	RX EHT → R2



C45: 560-710 N/mm² — 1000 kN/m max.

AD29

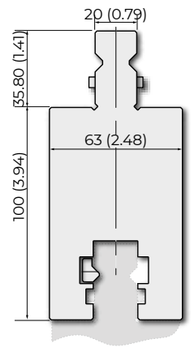
150 mm	5.91 in	4.5 kg	RX Weinbrenner → R2



42Cr: 900-1150 N/mm² — 1500 kN/m max.

AD21

150 mm	5.91 in	7.0 kg	R2 → R2



10

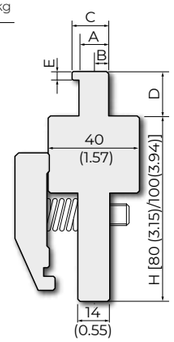
Segmented — On stock — Ask for delivery time

Punches - Adapters

C45: 560-710 N/mm² — 1000 kN/m max.

INT80-100

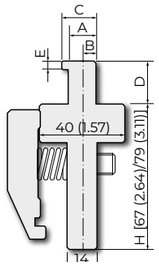
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg



C45: 560-710 N/mm² — 1000 kN/m max.

INT67-79

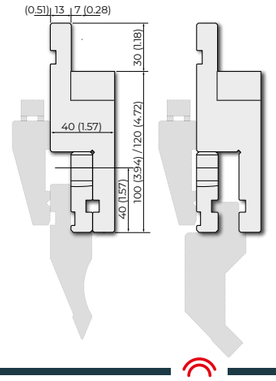
835 mm	32.87 in	20.5 kg
415 mm	16.34 in	10.0 kg



C45: 560-710 N/mm² — 1000 kN/m max.

INT100-A

150 mm	5.91 in	3.5 kg



C45: 560-710 N/mm² — 1000 kN/m max.

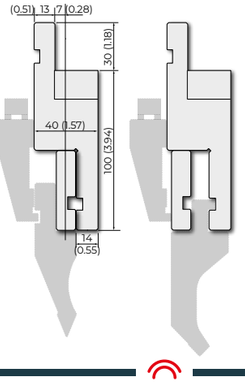
INT120-A

150 mm	5.91 in	5.2 kg

C45: 560-710 N/mm² — 1000 kN/m max.

INT100-N (Newton)

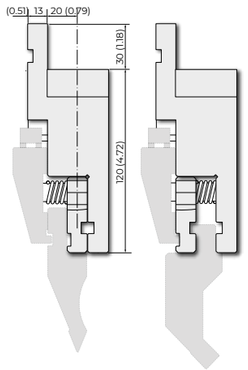
150 mm	5.91 in	3.5 kg



C45: 560-710 N/mm² — 1000 kN/m max.

INT120-40-A

150 mm	5.91 in	6.0 kg

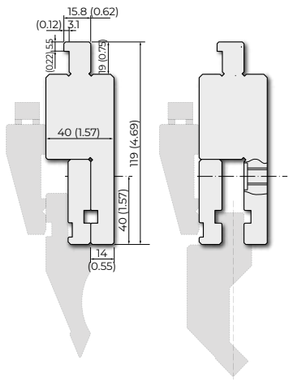


C45: 560-710 N/mm² — 1000 kN/m max.

INT100-A (American)

150 mm	5.91 in	3.5 kg

X → R1 X → X



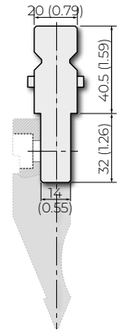
Punches - Bolted adapters

C45: 560-710 N/mm² — 1000 kN/m max.

AW11

835 mm	32.87 in	8.4 kg
415 mm	16.34 in	4.2 kg
805 mm	31.69 in	8.4 kg

R2 → R1

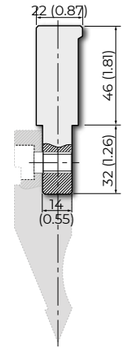


C45: 560-710 N/mm² — 1000 kN/m max.

AW3

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm	31.69 in	3.0 kg

R3 Beyeler S → R1

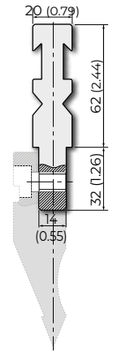


C45: 560-710 N/mm² — 1000 kN/m max.

AW10

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm	31.69 in	3.0 kg

R3 Beyeler RFA → R1

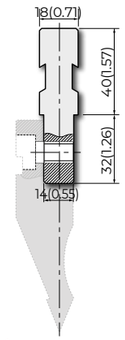


C45: 560-710 N/mm² — 1000 kN/m max.

AW12

835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.5 kg
805 mm	31.69 in	6.7 kg

RX Colgar → R1

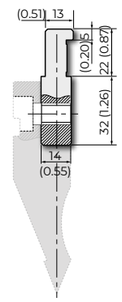


C45: 560-710 N/mm² — 1000 kN/m max.

AW1-A

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm	31.69 in	6.7 kg

R4 A → R1

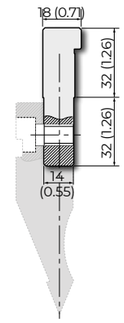


C45: 560-710 N/mm² — 1000 kN/m max.

AW1-B

835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.5 kg
805 mm	31.69 in	6.7 kg

R4 B → R1



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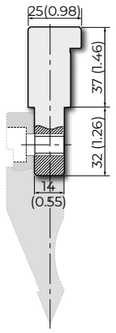
C45: 560-710 N/mm² — 1000 kN/m max.

AW1-C

835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
805 mm	31.69 in	9.4 kg

R4 C → R1

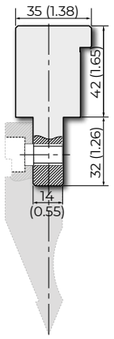


C45: 560-710 N/mm² — 1000 kN/m max.

AW1-D

835 mm	32.87 in	11.5 kg
415 mm	16.34 in	5.7 kg
805 mm	31.69 in	11.1 kg

R4 D → R1

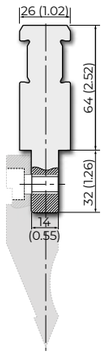


C45: 560-710 N/mm² — 1000 kN/m max.

AW13

835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.3 kg
805 mm	31.69 in	12.1 kg

RX EHT → R1

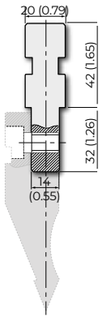


C45: 560-710 N/mm² — 1000 kN/m max.

AW14

835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
805 mm	31.69 in	7.7 kg

RX Gasparini → R1

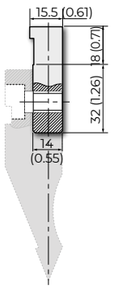


C45: 560-710 N/mm² — 1000 kN/m max.

AW15

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm	31.69 in	3.0 kg

RX Ajial-Axial → R1

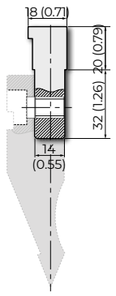


C45: 560-710 N/mm² — 1000 kN/m max.

AWC16

835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm	31.69 in	4.8 kg

RX Colly → R1



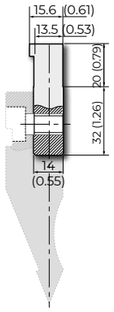
Punches - Bolted adapters

C45: 560-710 N/mm² — 1000 kN/m max.

AWC13.5

835 mm	32.87 in	4.8 kg
415 mm	16.34 in	2.4 kg
805 mm	31.69 in	4.6 kg

RX Colly → R1

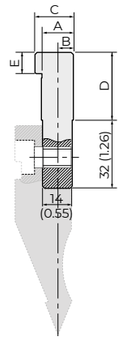


C45: 560-710 N/mm² — 1000 kN/m max.

AWX

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm	31.69 in	3.0 kg

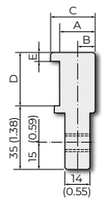
Individual → R1



C45: 560-710 N/mm² — 1000 kN/m max.

INT35

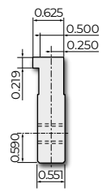
835 mm	32.87 in	4.0 kg
415 mm	16.34 in	2.5 kg
805 mm	31.69 in	3.9 kg



C45: 560-710 N/mm² — 1000 kN/m max.

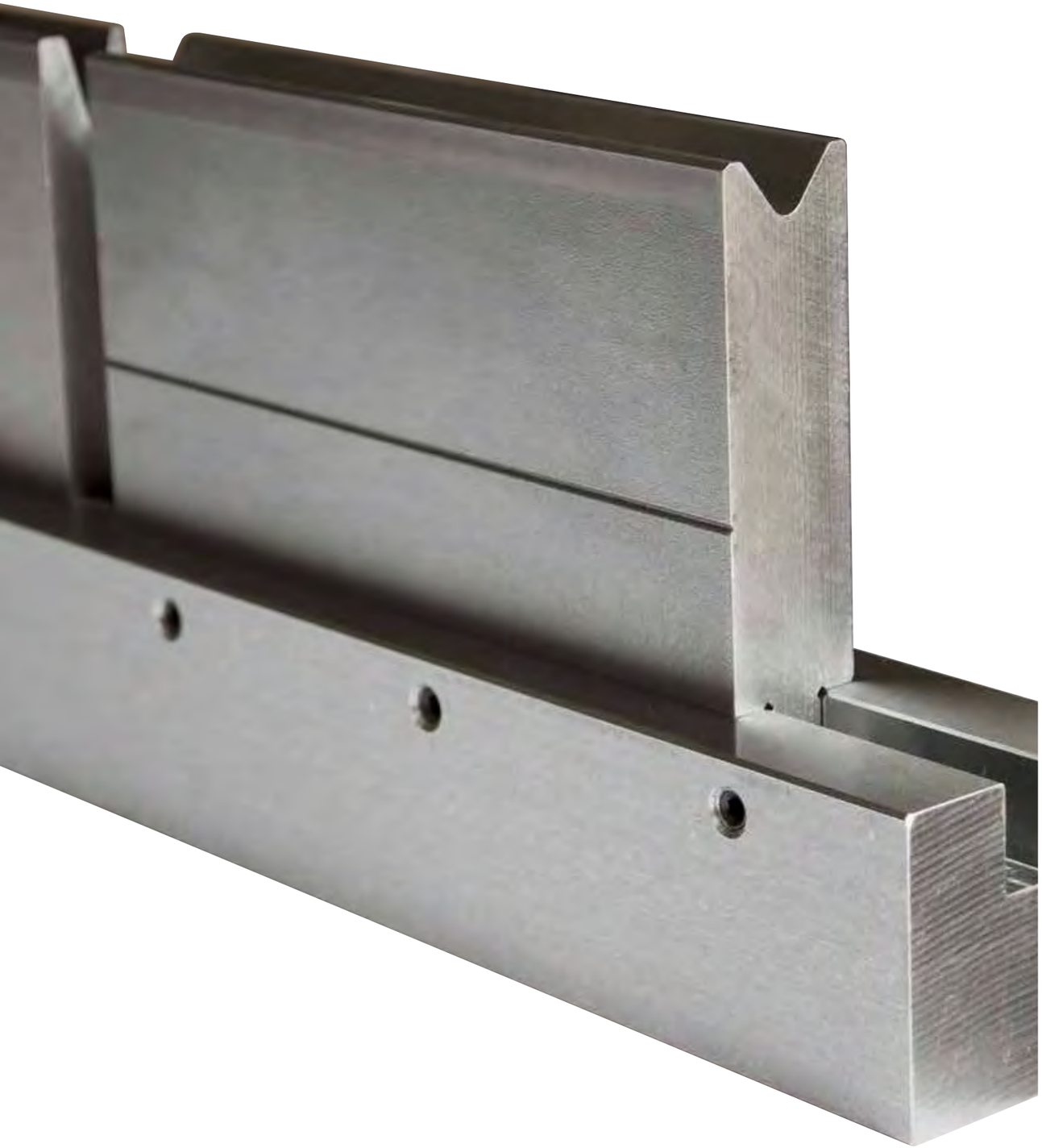
INT35-A

835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm	31.69 in	4.8 kg



10

DIES - ADAPTERS



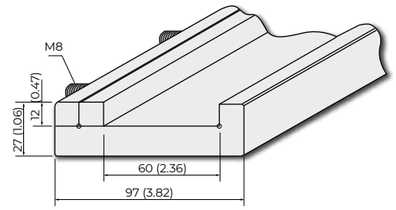
Dies - Holders

C45: 560-710 N/mm²

1000 kN/m max.

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

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

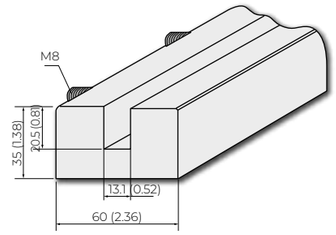


C45: 560-710 N/mm²

1000 kN/m max.

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

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

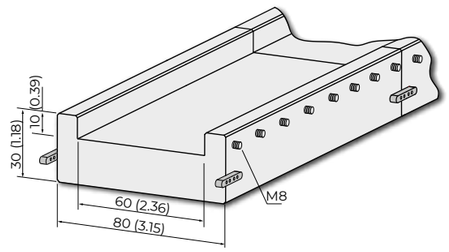


C45: 560-710 N/mm²

1000 kN/m max.

C 1050/R

C 1050/R	1050 mm	41.34 in	15.0 kg
C 1050/R/C	520 mm	20.47 in	7.5 kg

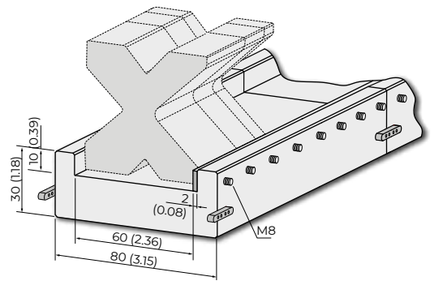


C45: 560-710 N/mm²

1000 kN/m max.

C 1050/RS

C 1050/RS	1050 mm	41.34 in	15.0 kg
C 1050/RS/C	520 mm	20.47 in	7.5 kg

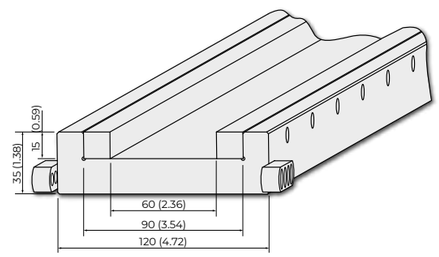


C45: 560-710 N/mm²

1000 kN/m max.

C 1050-90

C 1050-90	1050 mm	41.34 in	27.2 kg
C 1050-90/C	520 mm	20.47 in	13.5 kg

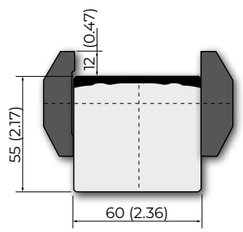


C45: 560-710 N/mm²

1000 kN/m max.

CTS60

835 mm	32.87 in	29.0 kg
415 mm	16.34 in	14.5 kg



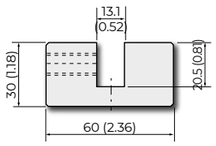
10

C45: 560-710 N/mm²

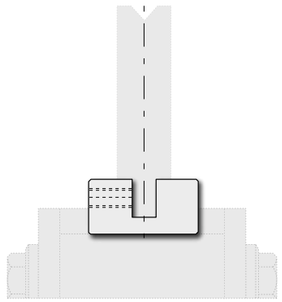
1000 kN/m max.

AD6

1000 mm	39.37 in	12.0 kg	R1 → R2 R3
500 mm	19.68 in	6.0 kg	



AD6 Example of Application

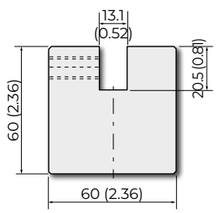


C45: 560-710 N/mm²

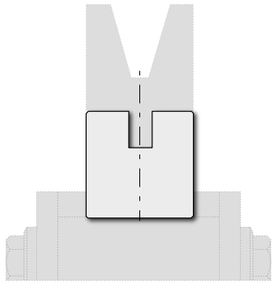
1000 kN/m max.

AD5

1000 mm	39.37 in	26.1 kg	R1 → R2 R3
500 mm	19.68 in	13.0 kg	



AD5 Example of Application

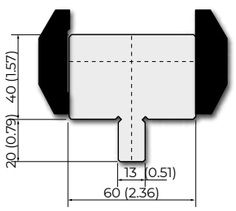


C45: 560-710 N/mm²

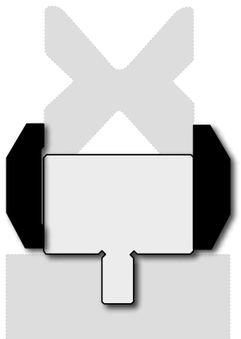
1000 kN/m max.

AD7

835 mm	32.87 in	25 kg	R2 R3 → R1
415 mm	16.34 in	8.5 kg	



AD7 Example of Application



Segmented

On stock

Ask for delivery time

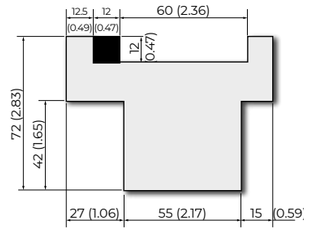
Dies - Adapters

C45: 560-710 N/mm²

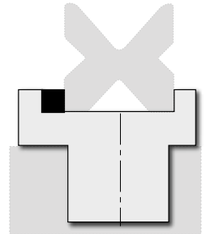
1000 kN/m max.

AD24

835 mm	32.87 in	30 kg	RX EHT → R1
415 mm	16.34 in	14.2 kg	



AD24 Example of Application

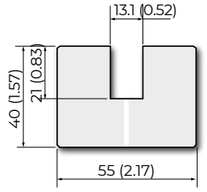


C45: 560-710 N/mm²

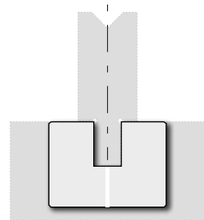
1000 kN/m max.

AD25

500 mm	19.68 in	7.5 kg	RX EHT → R2 R3



AD25 Example of Application

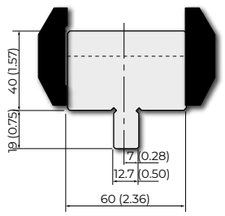


C45: 560-710 N/mm²

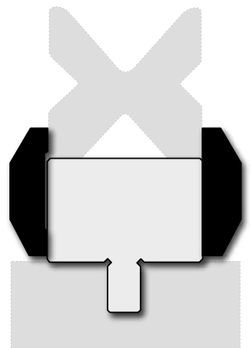
1000 kN/m max.

AD9-12.7

835 mm	32.87 in	17.0 kg	R4 → R1
415 mm	16.34 in	8.5 kg	



AD9-12.7 Example of Application



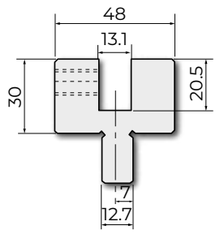
10

C45: 560-710 N/mm²

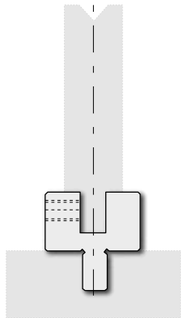
1000 kN/m max.

AD8-12.7

1000 mm	39.37 in	12.0 kg	R4 → R2 R3
500 mm	16.34 in	16.0 kg	



AD8-12.7 Example of Application

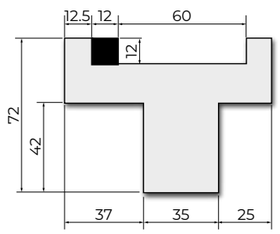


C45: 560-710 N/mm²

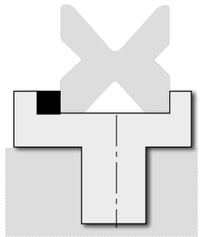
1000 kN/m max.

AD26

835 mm	32.87 in	23.0 kg	RX Weinbrenner → R1
415 mm	16.34 in	11.4 kg	



AD26 Example of Application

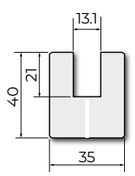


C45: 560-710 N/mm²

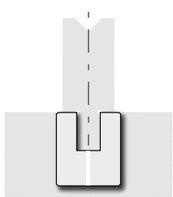
1000 kN/m max.

AD27

500 mm	19.68 in	4.5 kg	RX Weinbrenner → R2 R3



AD27 Example of Application



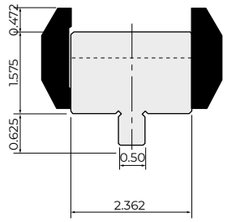
Dies - Adapters

C45: 560-710 N/mm²

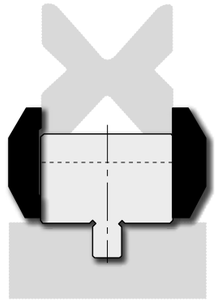
1000 kN/m max.

AD17

835 mm	32.87 in	18.0 kg	R American → R1
415 mm	16.34 in	18.0 kg	



AD17 Example of Application

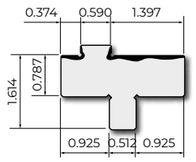


C45: 560-710 N/mm²

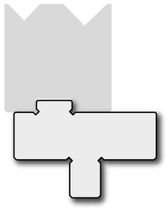
1000 kN/m max.

AD18

835 mm	32.87 in	18.0 kg	RX EHT → R2 R3
415 mm	16.34 in	9.0 kg	



AD18 Example of Application



ROLLERI MARK FREE BENDING

ROLL PRIME	222 - 223
ROLFILM	224 - 226
Tensioner	224
Bending Foil	225 - 226
POLYURETHANE	225 - 229
Inserts and holders	225 - 226
Cover plate and modifications	227
SYNTHETIC DIES	228 - 229
Inserts and holders	228 - 229

Roll Prime 20.17 NEW

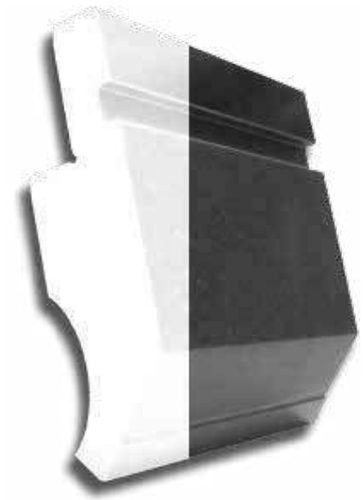
Rolleri's constant research for innovation brought us towards the 3D printing world, the future of manufacturing. Roll Prime is the solution for applications which require mark-free sheet metal,reduced delivery time and dimensional precision: thanks to FDM technology (Fused Deposition Modelling) we are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

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

Tools

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

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



Inserts

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

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

Rolfilm and Tensioner

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

CT

6.0 kg Per piece

ROLFILM

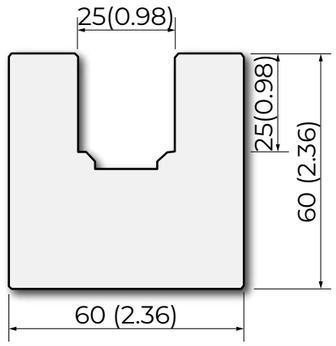
Model	Thickness [mm]	Thickness [in]	Width [mm]	Width [in]	Length [mm]	Length [in]
Rolfilm 3-0.4-100	0.4	0.016	100	3.94	3	118.11
Rolfilm 10-0.4-100	0.4	0.016	100	3.94	10	393.70
Rolfilm 20-0.4-100	0.4	0.016 0.016	100	3.94	20	787.40
Rolfilm 30-0.4-100	0.4	0.016	100	3.94	30	1181.10
Rolfilm 3-0.4-150	0.4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

Polyurethane inserts and holders

C45: 560-710 N/mm²

MPG25

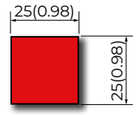
835 mm	32.87 in	18.5 kg
415 mm	16.34 in	9.2 kg



Polyurethane

GM 25X25

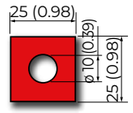
835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg



Polyurethane

GM 25X25X10

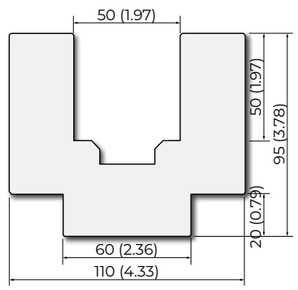
835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg



C45: 560-710 N/mm²

MPG50

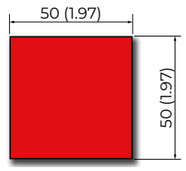
835 mm	32.87 in	46.0 kg
415 mm	16.34 in	22.5 kg



Polyurethane

GM 50X50

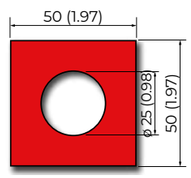
835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg



Polyurethane

GM 50X50X25

835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg



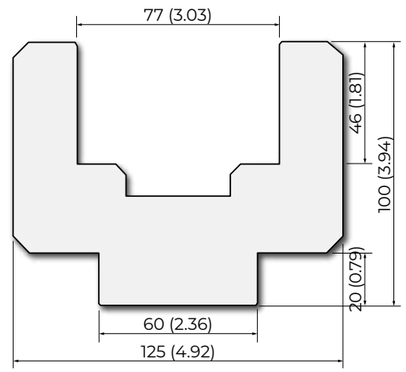
11

Polyurethane inserts and holders

C45: 560-710 N/mm²

MPG75

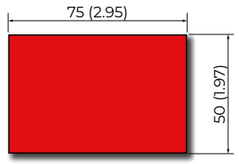
835 mm	32.87 in	46.0 kg
415 mm	16.34 in	22.5 kg



Polyurethane

GM 75X50

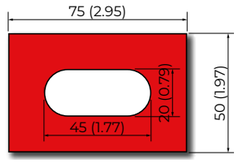
835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg



Polyurethane

GM 75X50X20

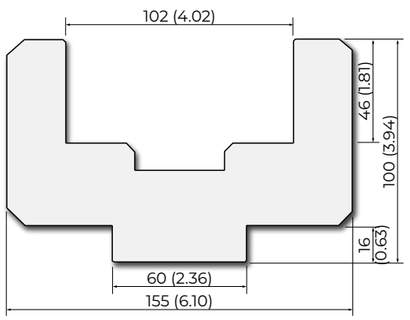
835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg



C45: 560-710 N/mm²

MPG100

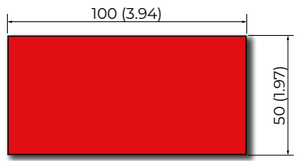
835 mm	32.87 in	55.0 kg
415 mm	16.34 in	27.5 kg



Polyurethane

GM 100X50

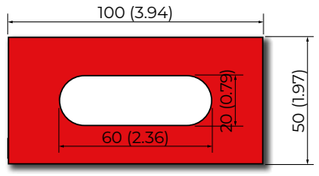
835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg



Polyurethane

GMF 100X50X20

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	2.2 kg

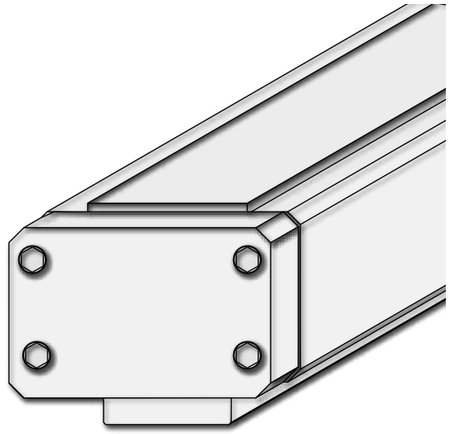


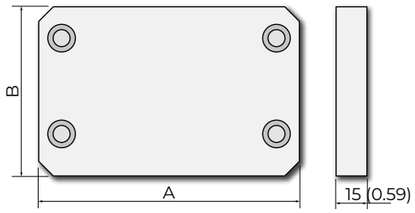
Cover plate and modifications

C45: 560-710 N/mm²

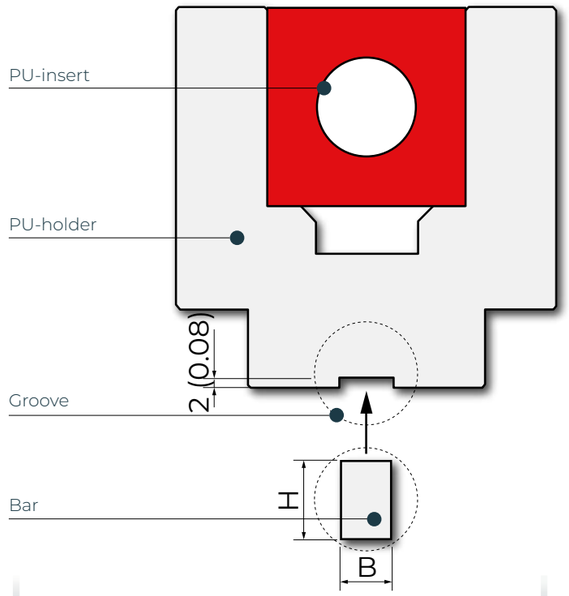
PSTCON - Cover Plate

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



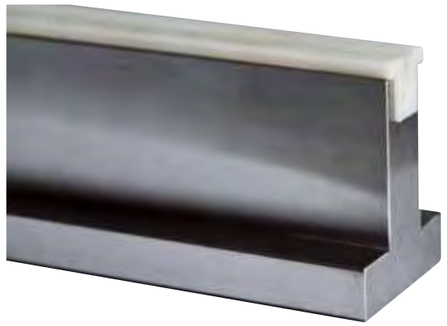


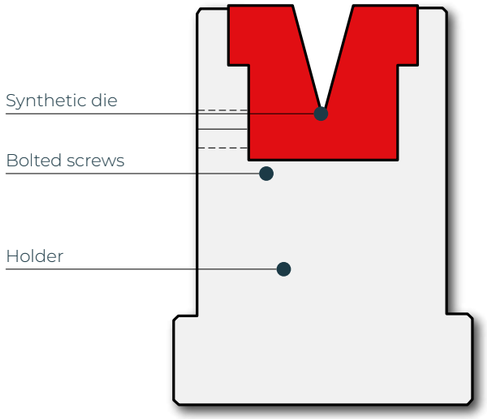
Tang modification example



11

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





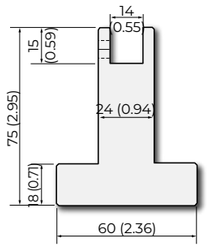
C45: 560-710 N/mm²

1000 kN/m max.

TN80.14

R1

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

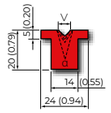


Synthetic

200 kN/m max.

INS14...

835 mm	32.87 in	0.30 kg
415 mm	16.34 in	0.15 kg



Model	°	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
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

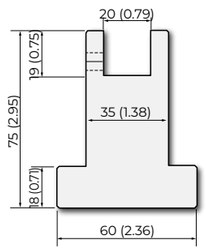
C45: 560-710 N/mm²

1000 kN/m max.

TN80.20

R1

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

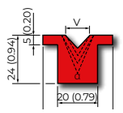


Synthetic

200 kN/m max.

INS20...

835 mm	32.87 in	0.4 kg
415 mm	16.34 in	0.2 kg



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

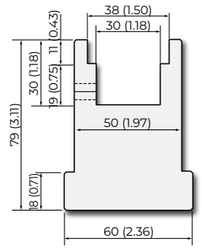
C45: 560-710 N/mm²

1000 kN/m max.

TN80.30

R1

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

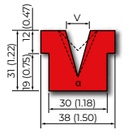


Synthetic

200 kN/m max.

INS30...

835 mm	32.87 in	0.5 kg
415 mm	16.34 in	0.3 kg



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

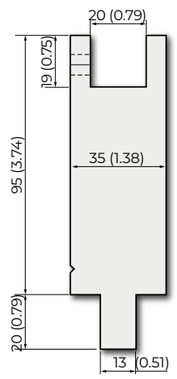
C45: 560-710 N/mm²

1000 kN/m max.

TMN95.20

R2 R3

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

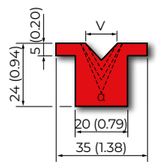


Synthetic

200 kN/m max.

INS20...

835 mm	32.87 in	0.4 kg
415 mm	16.34 in	0.2 kg



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

ROLLERI EVOLUTION AND HEAVY DUTY

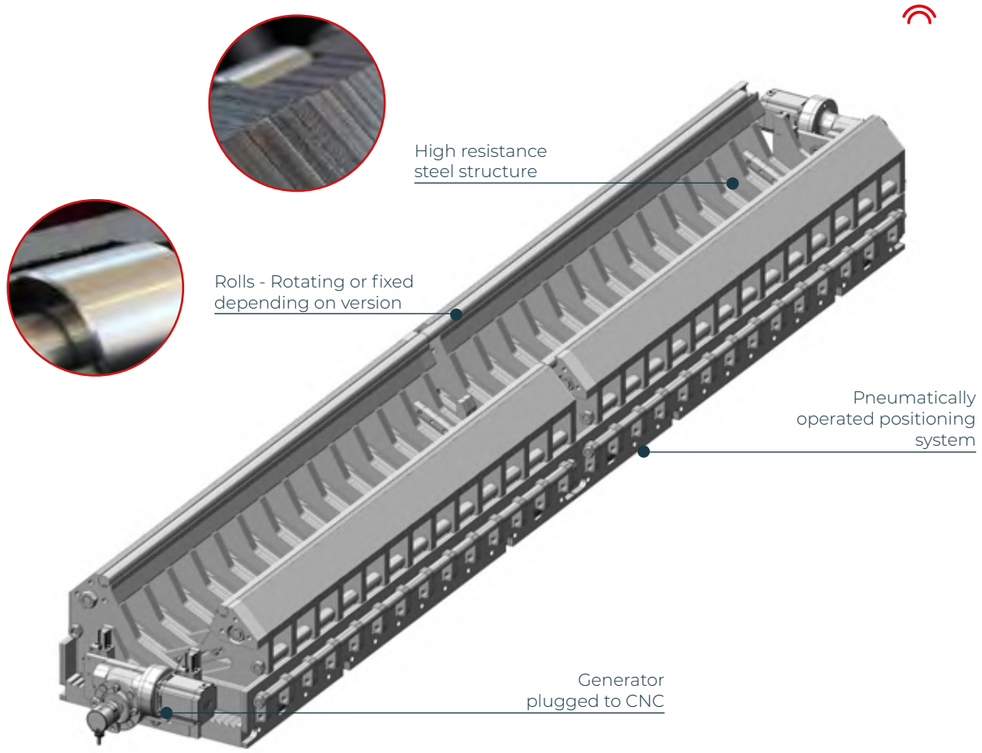
Rolleri Evolution	232 - 233
Rolleri Vario	232 - 233
Adjustable Dies and Holders	234 - 238
Adjustable Dies	234- 236
Bars and Holders	237 - 238
Dies with Rollers	239
Heavy Duty Tools	240 - 242
Special Tools	243 - 251

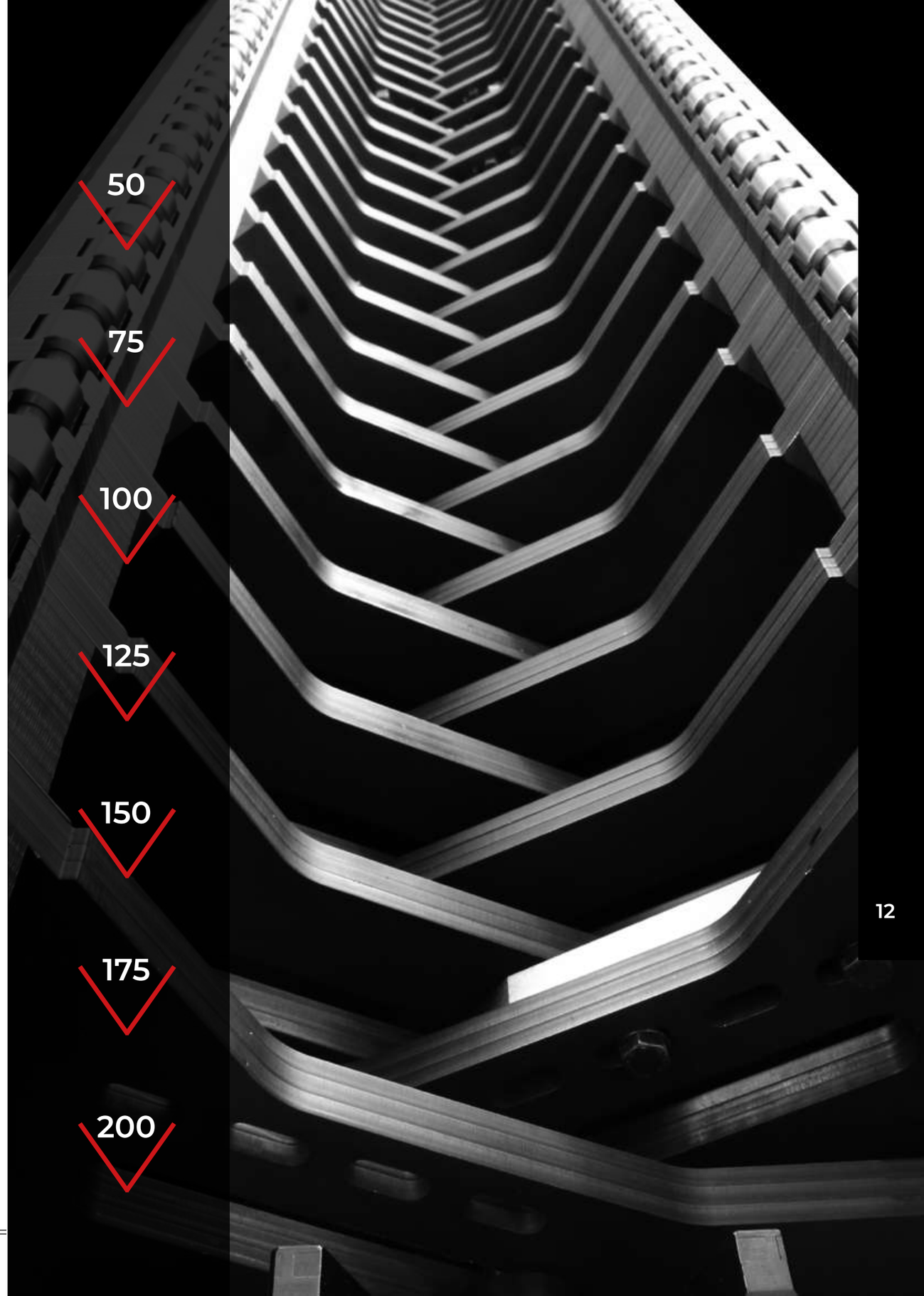
Rolleri Vario

PATENT

FEATURES

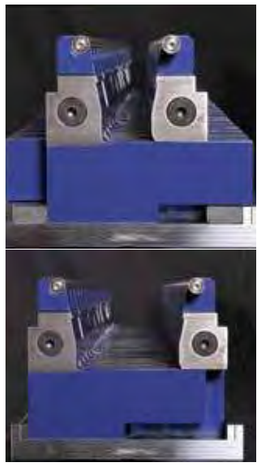
- Rolleri Vario can be mounted on any press brake model
- 7 dies in one single tool
- Guaranteed rotation and reduction of necessary force of about 25-30% thanks to rollers mounted on pins
- 250 t/m bearing - resistance and reliabilty guaranteed
- In case of excessive wear, rollers can be changed
- Thanks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





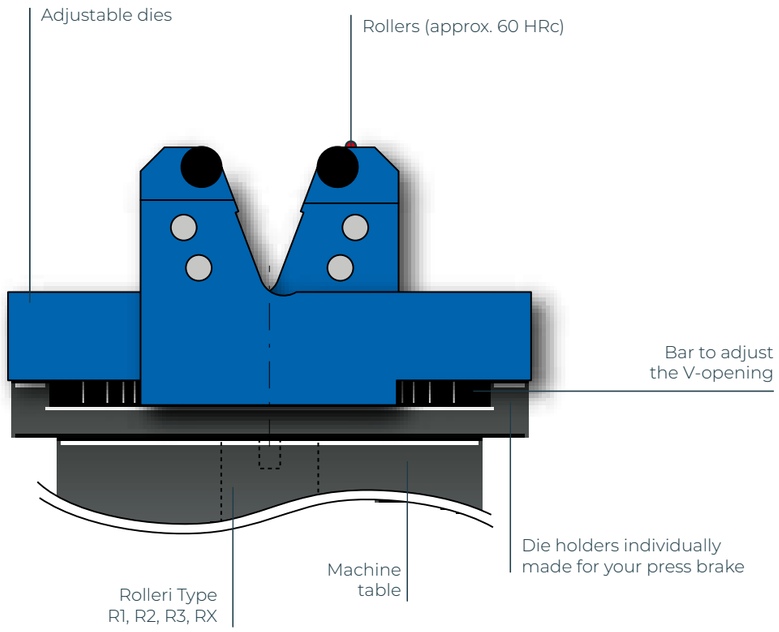
On stock Ask for delivery time

Adjustable Dies



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

Mounting example



Adjustable dies

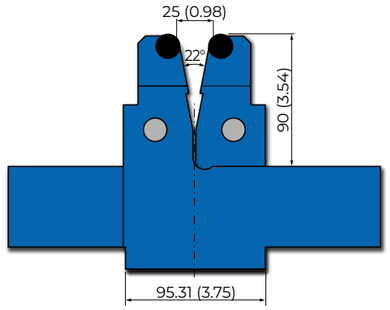
42Cr: 900-1150 N/mm²

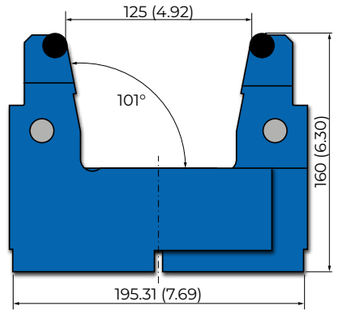
1250 kN/m max. at 90°

AD25.125

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

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





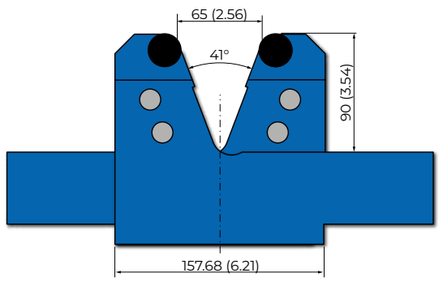
42Cr: 900-1150 N/mm²

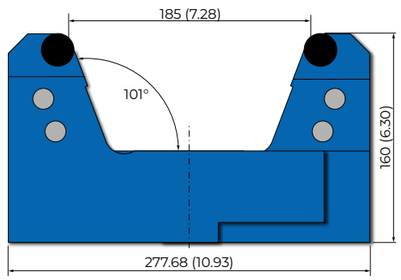
2000 kN/m max. at 90°

AD65.185

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

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





12

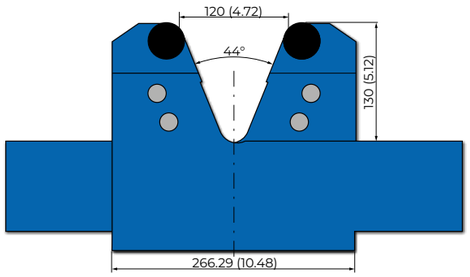
42Cr: 900-1150 N/mm²

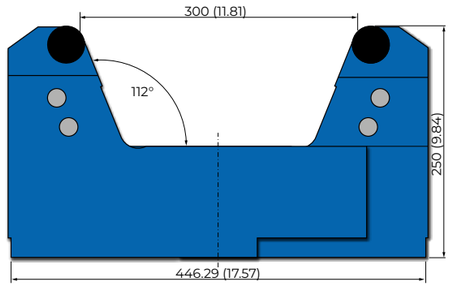
4000 kN/m max. at 90°

AD120.300

600 mm	23.62 in	360.0 kg

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





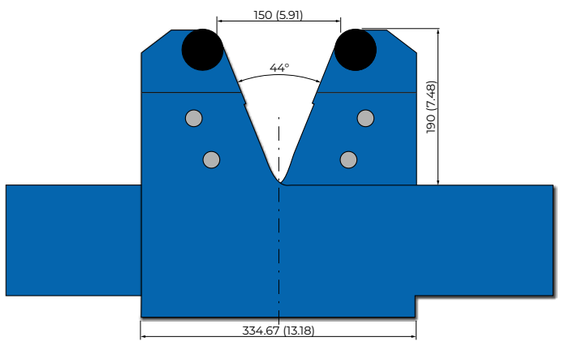
42Cr: 900-1150 N/mm²

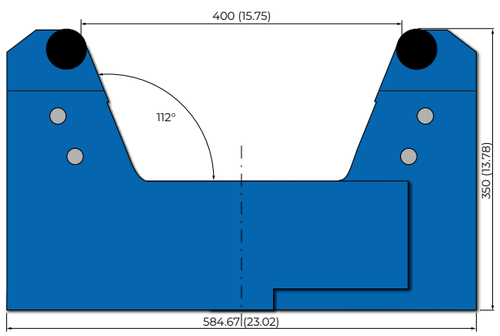
6000 kN/m max. at 90°

AD150.400

600 mm	23.62 in	560.0 kg

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





42Cr: 900-1150 N/mm²

BAR AD25.185 » AD25.125 + AD65.185

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

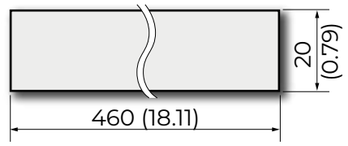
Set spacer bars width:
2-5-10-15-20-30-40-50

42Cr: 900-1150 N/mm²

BAR AD120.300 » AD120.300

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

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



42Cr: 900-1150 N/mm²

BAR AD150.400 » AD150.400

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

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

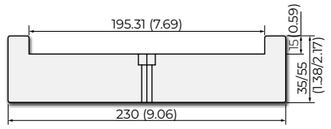
Holders

42Cr: 900-1150 N/mm²

HAD25.125 » AD25.125

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

Holders, available with flat bottom and with tang

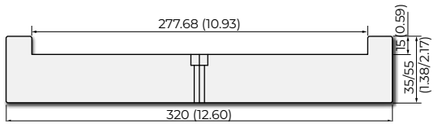


42Cr: 900-1150 N/mm²

HAD65.185 » AD65.185

Type A = 35 mm			Type B = 55 mm		
500 mm	19.69 in	28.0 kg	500 mm	19.69 in	53.0 kg
1000 mm	39.37 in	56.0 kg	1000 mm	39.37 in	106.0 kg
2000 mm	78.74 in	112.0 kg	2000 mm	78.74 in	212.0 kg
3000 mm	118.11 in	168.0 kg	3000 mm	118.11 in	424.0 kg

Holders, available with flat bottom and with tang

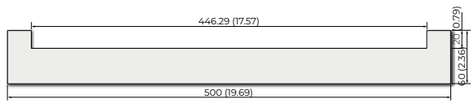


42Cr: 900-1150 N/mm²

HAD120.300 » AD120.300

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

Holder, available with flat bottom

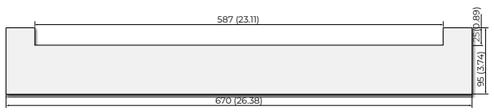


42Cr: 900-1150 N/mm²

HAD150.400 » AD150.400

600 mm	23.62 in	230.0 kg
1200 mm	47.24 in	460.0 kg
2400 mm	94.49 in	920.0 kg
3000 mm	118.11 in	1.150.0 kg

Holder, available with flat bottom

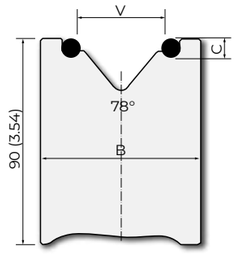


Dies with Rollers

42Cr: 900-1150 N/mm² Roller: C53: 610-760 N/mm²

MR90

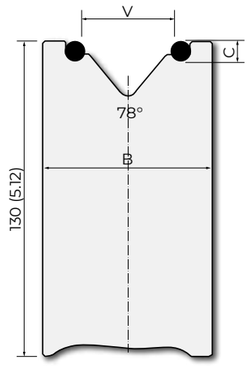
	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight
MR90.20.78	20	0.79	45	1.77	6	0.24	835	32.87	15.0 kg
MR90.24.78	24	0.94	49	1.93	6	0.24	835	32.87	17.0 kg
MR90.30.78	30	1.18	60	2.36	8	031	835	32.87	21.0 kg
MR90.40.78	40	1.57	70	2.76	8	0.31	835	32.87	24.0 kg
MR90.50.78	50	1.97	84	3.31	10	0.39	835	32.87	28.0 kg
MR90.60.78	60	2.36	94	3.70	10	0.39	835	32.87	31.0 kg
MR90.70.78	70	2.76	104	4.09	10	0.39	835	32.87	35.0 kg



42Cr: 900-1150 N/mm² Roller: C53: 610-760 N/mm²

MR130

	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight
MR130.20.78	20	0.79	45	1.77	6	0.24	835	32.87	22.0 kg
MR130.24.78	24	0.94	49	1.93	6	0.24	835	32.87	25.0 kg
MR130.30.78	30	1.18	60	2.36	8	031	835	32.87	28.0 kg
MR130.40.78	40	1.57	70	2.76	8	0.31	835	32.87	34.0 kg
MR130.50.78	50	1.97	84	3.31	10	0.39	835	32.87	40.0 kg
MR130.60.78	60	2.36	94	3.70	10	0.39	835	32.87	45.0 kg
MR130.75.78	75	2.95	118	4.65	16	0.63	835	32.87	50.0 kg
MR130.80.78	80	3.15	123	4.84	16	0.63	835	32.87	55.0 kg
MR130.90.78	90	3.54	133	5.24	16	0.63	835	32.87	60.0 kg
MR130.100.78	100	3.94	143	5.63	16	0.63	835	32.87	65.0 kg
MR130.120.78	120	4.72	163	6.42	16	0.63	835	32.87	70.0 kg



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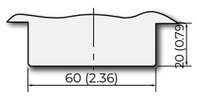
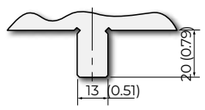
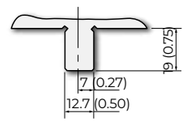
A10



A11



A13



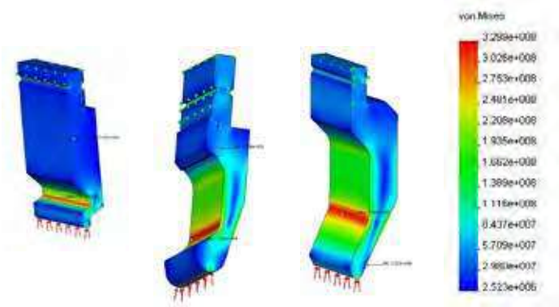
On stock

Ask for delivery time

Heavy Duty Tools

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

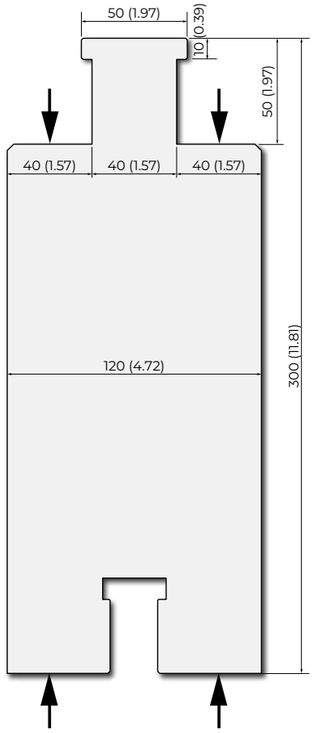
Such tools have a resistance up to 4000Kn/m; thanks to this capacity it is possible to produce very complex profiles with thick materials.



See table

RHD.300

Rolleri	Length [mm]	Length [in]	Weight	kN/m max.	Material
RHD.300-250	500	19.68	122.0 kg	2500	42Cr: 900-1150 N/mm²
RHD.300-400	500	19.68	122.0 kg	4000	1.2767: 1100-1320 N/mm²



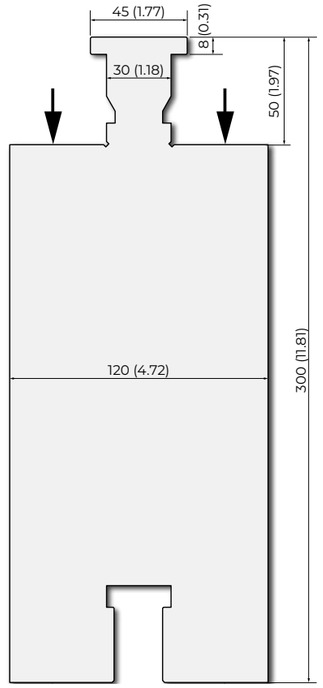
On stock

Ask for delivery time

See table

RHD.300 HYD

Rolleri	Length (mm)	Length (in)	Weight	kN/m max.	Material
RHD.300-250	500	19.68	120.0 kg	2500	42Cr: 900-1150 N/mm²
RHD.300-400	500	19.68	120.0 kg	4000	1.2767: 1100-1320 N/mm²



2500 kN/m max. RHDP-250 / 4000 kN/m max. RHDP-400

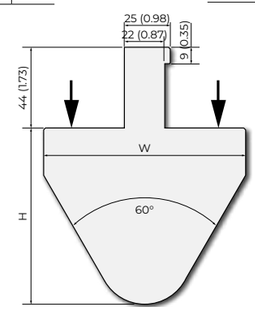
RHDP.60

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

42Cr: 900-1150 N/mm²

Model	L (mm)	L (in)	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)
RHDP.60.20-400	500	19.68	96	3.78	110	4.33	20	0.79
RHDP.60.25-400	500	19.68	96	3.78	110	4.33	25	0.98
RHDP.60.30-400	500	19.68	96	3.78	110	4.33	30	1.18
RHDP.60.40-400	500	19.68	96	3.78	110	4.33	40	1.57
RHDP.60.50-400	500	19.68	96	3.78	110	4.33	50	1.97
RHDP.60.60-400	500	19.68	96	3.78	110	4.33	60	2.36
RHDP.60.70-400	500	19.68	86	3.39	140	5.51	70	2.76
RHDP.60.80-400	500	19.68	86	3.39	150	5.91	80	3.15
RHDP.60.90-400	500	19.68	86	3.39	165	6.50	90	3.54
RHDP.60.100-400	500	19.68	86	3.39	185	7.28	100	3.94

1.2767: 1100-1320 N/mm²

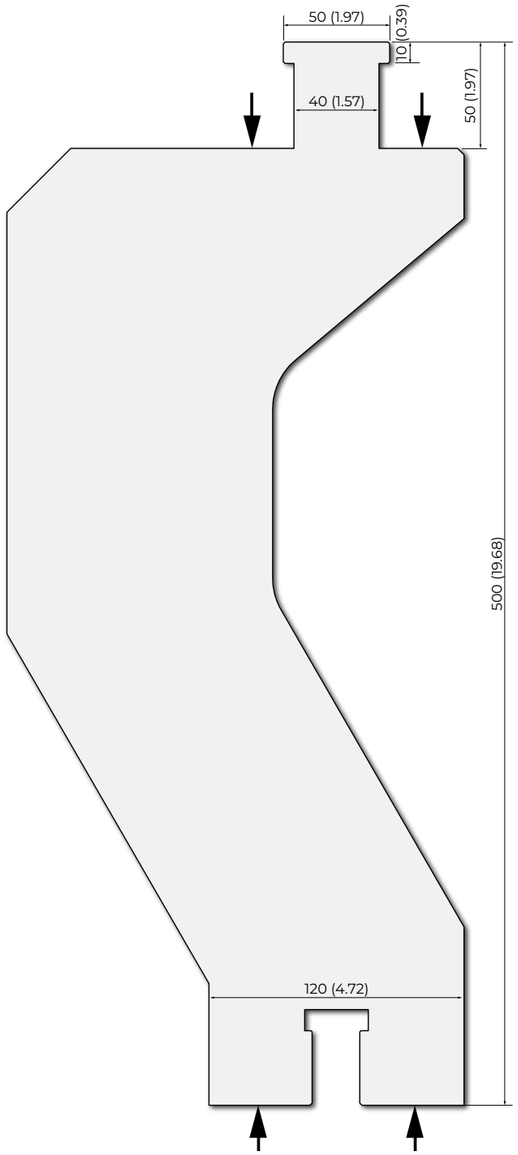


42Cr: 900-1150 N/mm²

2000 kN/m max.

RHD.500-200

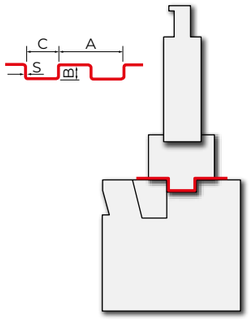
150 mm	19.68 in	253.0 kg



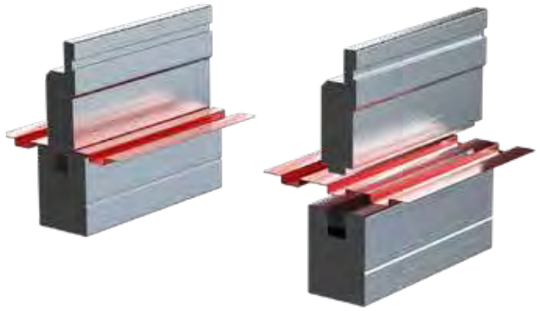
SPECIAL TOOLING FOR:

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

SPE1

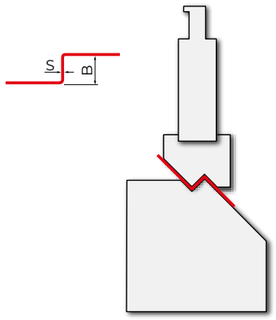


SPE1 Example of Application



SPE2

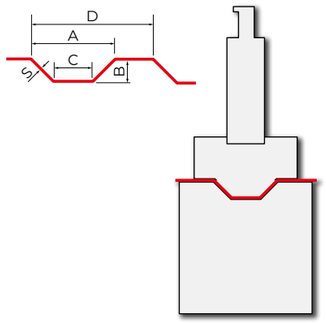
→ Z-Profiles



SPE2 Example of Application

SPE3

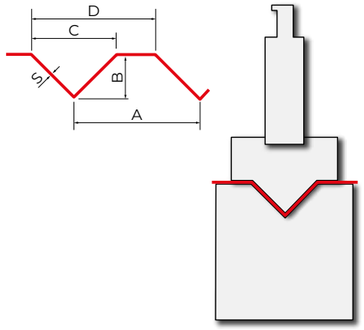
→ Trapezoidal Profiles



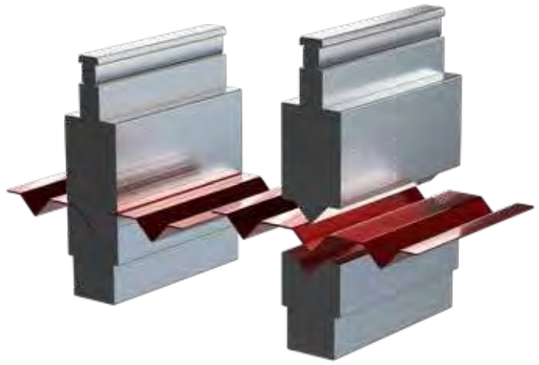
SPE3 Example of Application

Special Tools examples

SPE4

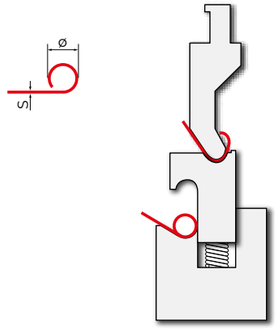


SPE4 Example of Application



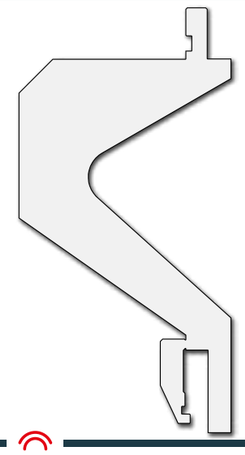
SPE5

→ Hinges



SPE5 Example of Application

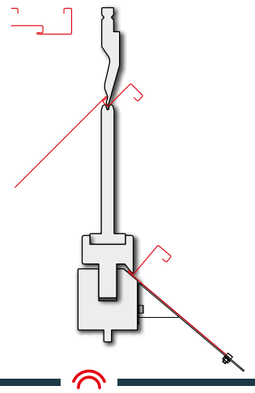
SPE-P4



SPE-P4 Example of Application

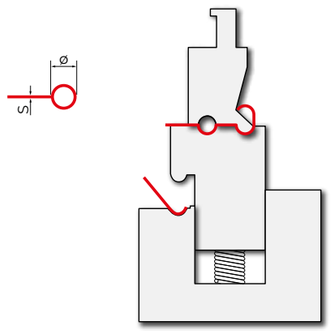
12

Pre-bending and flattening

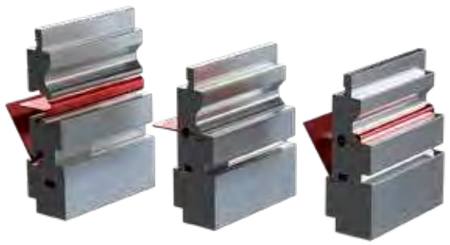


Example of Application

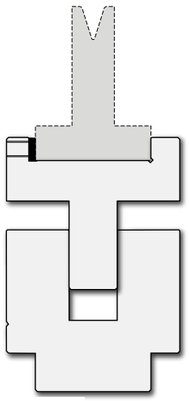
SPE6



SPE6 Example of Application



SPE9



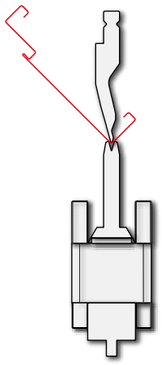
SPE9 Example of Application

On stock

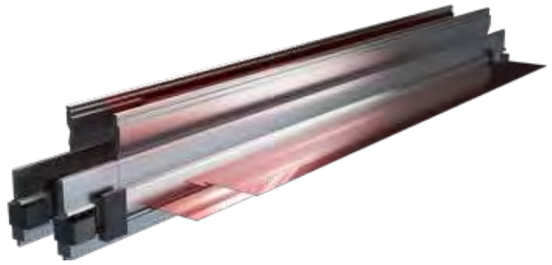
Ask for delivery time

Special Tools examples

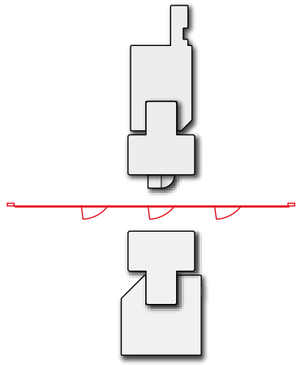
Special-Profile Doorframe



Example of Application

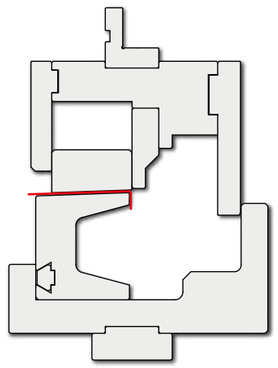


SPE10



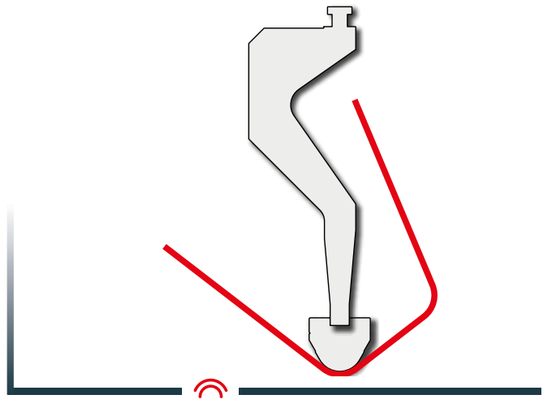
SPE10 Example of Application

SPE12



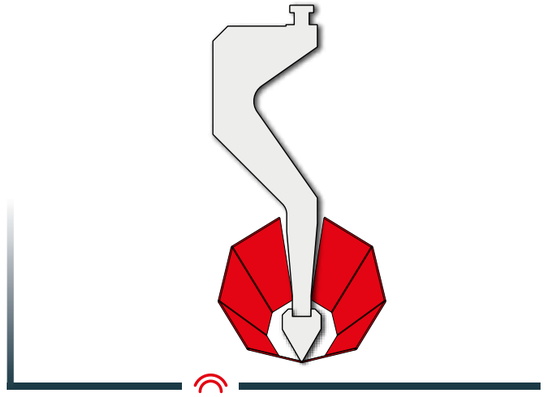
SPE12 Example of Application

Special-Profile



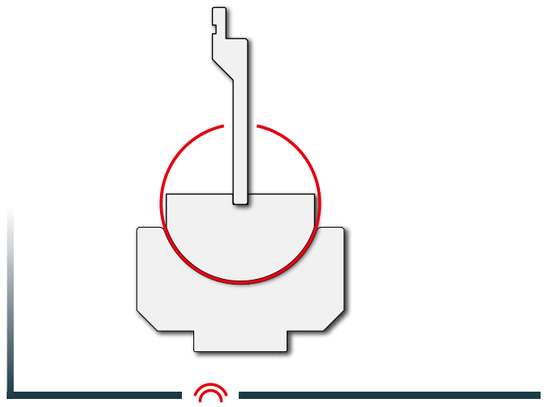
Example of Application

Special-Profile - Conical pole



Example of Application

Special-Profile - Circular pole



Example of Application

On stock Ask for delivery time

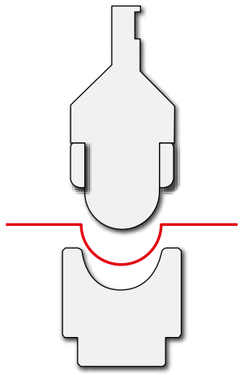
Special Tools examples

Special-Profile

Special-Profile - Kitchen Hoods

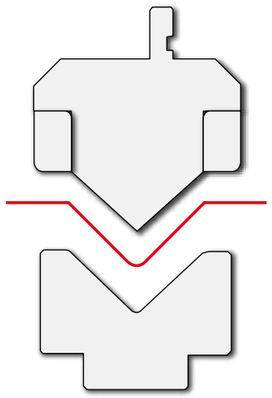
Special-Profile

Large radii



Special-Profile - Kitchen Hoods

Pressing



On stock Ask for delivery time

ROLLERI ACCESSORIES

Tooling cabinets	254 - 259
Features	254
STANDARD Series	
Tooling cabinets	255 - 257
Tooling cabinets	255 - 256
Cabinets equipment and Accessories	257
TOP Series	
Tooling cabinets	258 - 259
Tooling cabinets	258
Cabinets equipment and Accessories	259
Tooling Trolley	260 - 261
Bending Box	262
Squaring Arms	263
Supporting Arms and Back Gauge	264
Laser tracker	266 - 267

Features

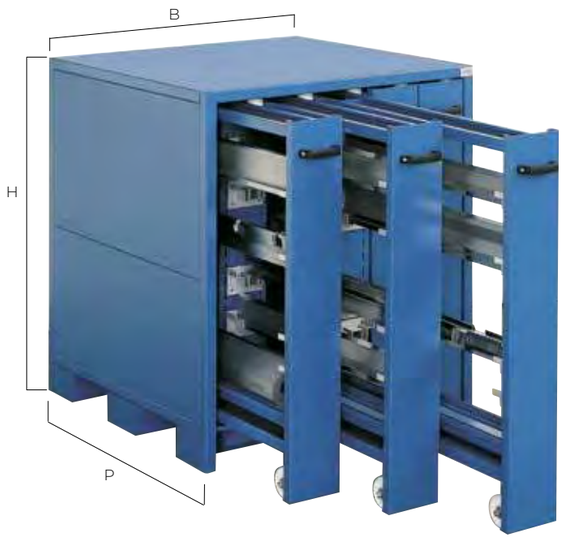
- Protection against contamination and damage
- Easy access to tools
- Clear and tidy storage
- Grooves in the construction to position easily the cabinet by means of fork lift trucks
- Shelves with variable positioning into drawers
- Two different lines: Standard and Top
- Various colorations available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

STANDARD Series

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

TOP Series

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



Tooling cabinets - STANDARD Series

Approx. 20 m of tools | **Max. tool length: 835 mm (32.87 in)** | 280 kg max./drawer

ARM 835-4

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 835-4	850 [33.46]	1240 [48.82]	1050 [41.34]	4 (CS-1)	271.0 kg

R1

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

Approx. 25 m of tools | **Max. tool length: 835 mm (32.87 in)** | 280 kg max./drawer

ARM 835-5

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 835-5	1040 [40.94]	1240 [48.82]	1050 [41.34]	5 (CS-1)	350.0 kg

R1

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

Approx. 26/39 m of tools | **Max. tool length: 1.060 mm (41.73 in)** | 250 kg max./drawer

ARM 1060-4.13

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 1060-4.13	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	340.0 kg

R1

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

Approx. 32.5/52 m of tools | **Max. tool length: 1.060 mm (41.73 in)** | 250 kg max./drawer

ARM 1060-5.13

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 1060-5.13	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-1)	400.0 kg

R1

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

Tooling cabinets - **STANDARD** Series

Approx. 26/39 m of tools | Max. tool length: 1.060 mm (41.73 in) | 250 kg max./drawer

ARM 1060-4 / -CV

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 1060-4	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	340.0 kg
ARM 1060-4-CV	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	351.0 kg

R2 R3

N° Shelves	Rolleri Ref	Tools Tang [in]	N° Shelves	Rolleri Ref	Tools Tang [in]
ARM 1060-4			ARM 1060-4-CV		
16	UC-20-2	20 mm [0.79]	20	UC-20-1	20 mm [0.79]
4	UL-20-4	20 mm [0.79]	10	UL-20-4	20 mm [0.79]

Approx. 32.5/52 m of tools | Max. tool length: 1.060 mm (41.73 in) | 250 kg max./drawer

ARM 1060-5 / -CV

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 1060-5	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-2)	400.0 kg
ARM 1060-5-CV	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-2)	490.0 kg

R2 R3

N° Shelves	Rolleri Ref	Tools Tang [in]	N° Shelves	Rolleri Ref	Tools Tang [in]
ARM 1060-5			ARM 1060-5-CV		
20	UC-20-2	20 mm [0.79]	30	UC-20-1	20 mm [0.79]
5	UL-20-4	20 mm [0.79]	10	UL-20-4	20 mm [0.79]

Approx. 20.8/31.2 m of tools | Max. tool length: 1.060 mm (41.73 in) | 250 kg max./drawer

ARM 1060-4-T / -CV

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 1060-4-T	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	340.0 kg
ARM 1060-4-T-CV	850 [33.46]	1240 [48.82]	1360 [53.54]	4 (CS-2)	395.0 kg

R2 R3

N° Shelves	Rolleri Ref	Tools Tang [in]	N° Shelves	Rolleri Ref	Tools Tang [in]
ARM 1060-4-T			ARM 1060-4-T-CV		
8	UL-13-4	13 mm [0.51]	16	UC-13-1	13 mm [0.51]
8	UT-4	13 mm [0.51]	8	UT-4	13 mm [0.51]

Approx. 26/41.6 m of tools | Max. tool length: 1.060 mm (41.73 in) | 250 kg max./drawer

ARM 1060-5-T / -CV

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
ARM 1060-5-T	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-2)	400.0 kg
ARM 1060-5-T-CV	1040 [40.94]	1240 [48.82]	1360 [53.54]	5 (CS-2)	400.0 kg

R2 R3

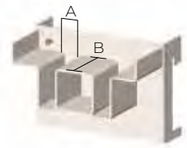
N° Shelves	Rolleri Ref	Tools Tang [in]	N° Shelves	Rolleri Ref	Tools Tang [in]
ARM 1060-5-T			ARM 1060-5-T-CV		
10	UL-13-4	13 mm [0.51]	24	UC-13-1	13 mm [0.51]
10	UT-4	13 mm [0.51]	8	UT-4	13 mm [0.51]

Cabinets equipment and Accessories - **STANDARD** Series

UC-Shelves

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

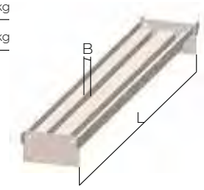
2 Pieces



Holder

UL-Shelves

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



Holder

UT-Shelves

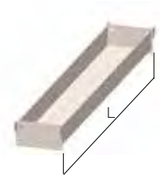
Model	L [mm]	L [in]	Weight
UT-1	270	10.63	1.4 kg
UT-2	580	22.83	3.2 kg
UT-3	1050	41.34	5.8 kg
UT-4	1360	53.54	7.5 kg

Suitable for punches
with safety pins

Holder

UV-Shelves

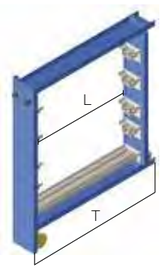
Model	L [mm]	L [in]	Weight
UV-1	270	10.63	1.0 kg
UV-2	580	22.83	2.0 kg
UV-3	1050	41.34	4.3 kg
UV-4	1360	53.54	5.5 kg



Holder

CS-Drawers

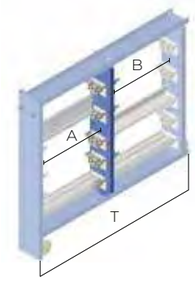
Model	T [mm]	T [in]	L [mm]	L [in]	Weight
CS-1	1050	41.34	856	33.70	22.0 kg
CS-2	1360	53.34	1.166	45.91	25.0 kg



Holder

CV-Drawers

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



Holder

13

Tooling cabinets - **TOP** Series

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

WKS013 Set A

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

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

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

WKS006 Set A

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

N°	WKS006 Set A
20	Tool retainer WKH 103
10	Universal trays
60	Storage boxes KLP200 (N°211)
1	Perforated panel WKH830

Approx. 26/33 m of tools | Max. tool length: 850 mm (33.46 in) Max. tool length: 1050 mm (41.34 in) | 900 kg max./drawer

WKS001 Set A - WKS003 Set A

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
WKS001 Set A	1040 [40.94]	1240 [48.82]	1050 [41.33]	5	330.0 kg
WKS003 Set A	1040 [40.94]	1240 [48.82]	1360 [53.54]	5	510.0 kg

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

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

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

WKS035 Set A

Rolleri Ref.	B mm [in]	H mm [in]	P mm [in]	Drawers	Weight
WKS0035 Set A	1040 [40.94]	1.620 [63.78]	1050 [41.33]	5	590.0 kg

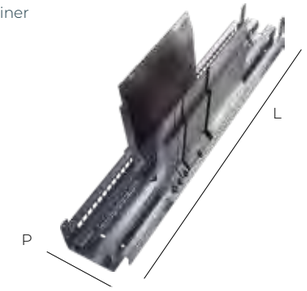
N°	WKS035 Set A
20	Tool retainer WKH103
5	Tool retainer WEB366
25	Partition plate TRB360

Cabinets equipment and Accessories - **TOP** Series

WKH102 - WKH103

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

Bending tools retainer



Holder

WKH502 - WKH504

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

Universal trays

Holder

WEB360 - WEB366

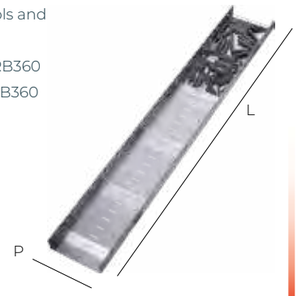
Model	L mm [in]	P mm [in]	001	003	006	013	035
WEB360	180 [7.08]	1050 [41.33]	●			●	
WEB366	180 [7.08]	1300 [51.18]		●	●		●

TRB360

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

Retainer for measurements tools and small parts

- WEB360 included: n° 4 TRB360
- WEB366 included: n° 5 TRB360



Holder

Partition plates

Accessories

R2

KIT OF MAGNETIC HOLDERS

2 pieces	44 L x 68 H x 40.2 P

KIT OF HOLDERS FOR SPACERS

2 pieces	167.5 L x 68 H x 65.1 P

HANGABLE SHELF

1 piece	450 L x 245 H x 65 P

13

Approx. 26/39 m of tools | Max. tool length: 1.060 mm (41.73 in) | 250 kg max./shelf

A Trolley

R1

B mm [in]	H mm [in]	P mm [in]	Shelves	Weight
1060 [41.73]	1520 [59.84]	1160 [45.67]	30	108.0 kg

Approx. 26/39 m of tools | Max. tool length: 1.060 mm (41.73 in) | 250 kg max./shelf

T Trolley

R2

B mm [in]	H mm [in]	P mm [in]	Shelves	Weight
1060 [41.73]	1520 [59.84]	1160 [45.67]	21	175.0 kg

Approx. 26/39 m of tools | Max. tool length: 1.060 mm (41.73 in) | 250 kg max./shelf

B Trolley

R3

B mm [in]	H mm [in]	P mm [in]	Shelves	Weight
1060 [41.73]	1520 [59.84]	1160 [45.67]	21	135.0 kg

250 kg max./shelf

WKW582

	L mm [in]	H mm [in]	P mm [in]
WKW582	582 [22.91]	922 [36.30]	922 [36.30]

250 kg max./shelf

WSW583 Plus

	L mm [in]	H mm [in]	P mm [in]
WSW583 Plus	582 [22.91]	922 [36.30]	922 [36.30]

Included	
Sloped shelves	2
Non-slip mat	1
Drawer	1
Fixed castors	2
Guided rollers with brake	2

Included	
Sloped shelves	2
Tools retainer	3
Drawer	1
Fixed castors	2
Guided rollers with brake	2

13

On stock · Ask for delivery time

Bending Box

Per piece	1.6 kg

Retainer for measurements tools
and small parts.

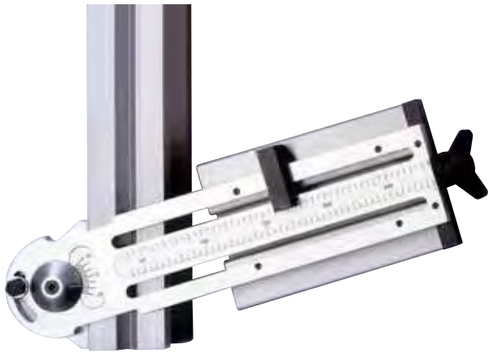
- PRECISION DIGITAL CALIBER
- SET SQUARE
- ANGLE MEASURING DEVICE

MSA - magnetic

MSA.D	Right	per piece	1.4 kg
MSA.S	Left	per piece	1.4 kg

AS

Per piece	3.5 kg



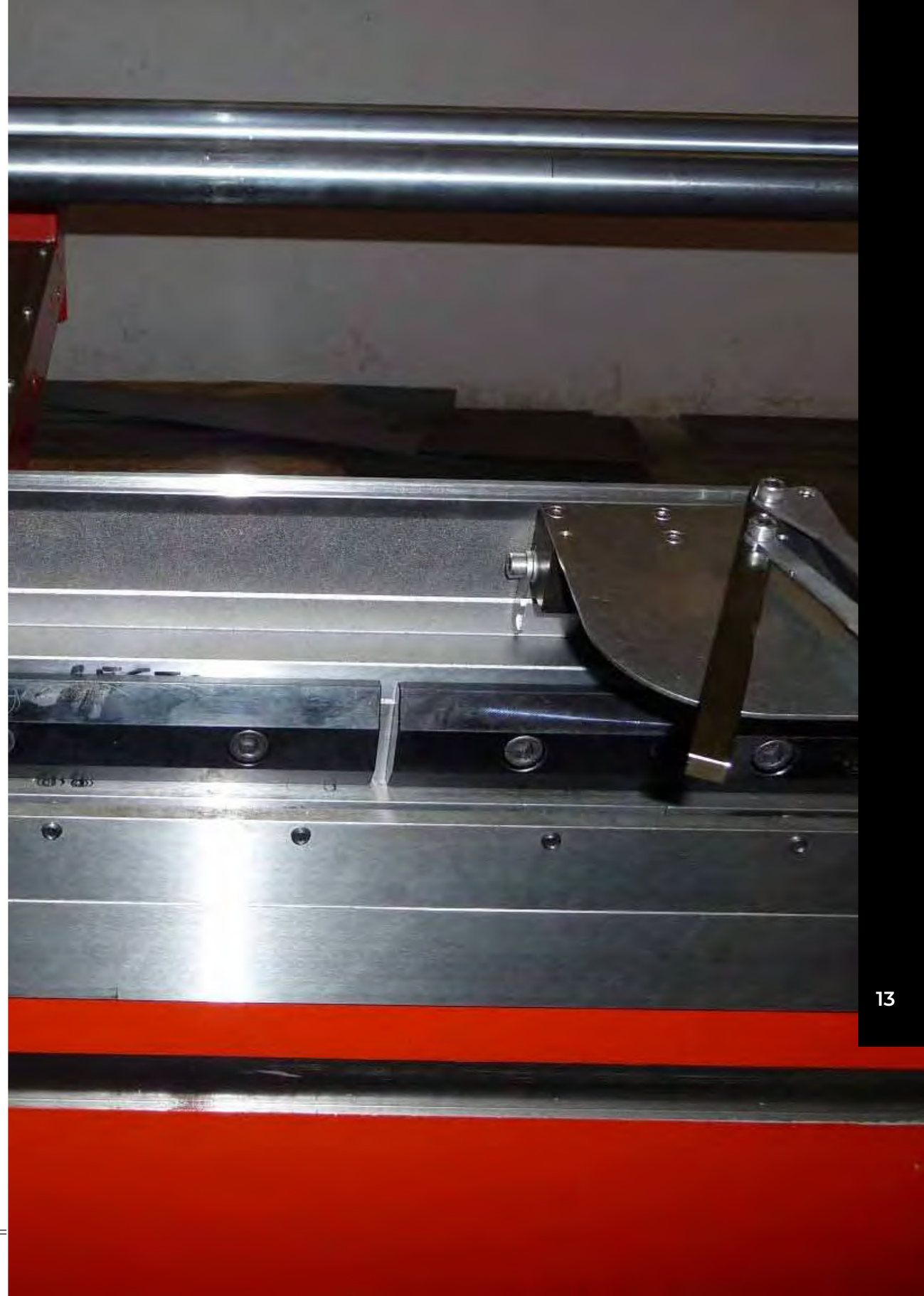
AS FIX

Per piece	3.0 kg

RIF-Supporting Arm

Rolleri Ref.	L [mm]	L [in]	Weight
RIF500	500	19.68	7.0 kg
RIF1000	1.000	39.37	12.0 kg
RIF1500	1.500	59.05	17.0 kg

- To position big sheet metal correctly
- Greater surface guarantees a trouble-free support for sheet metals
- Easy handling



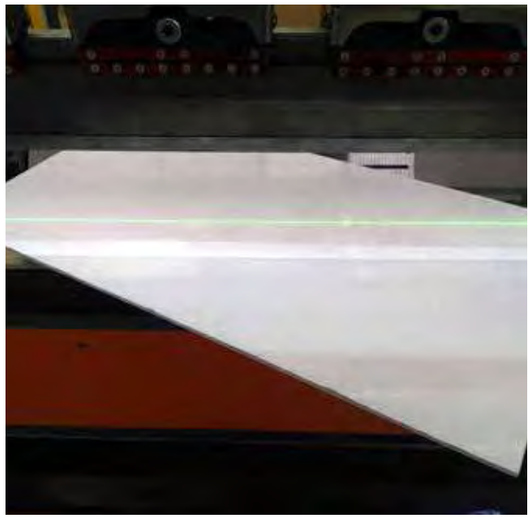
On stock Ask for delivery time

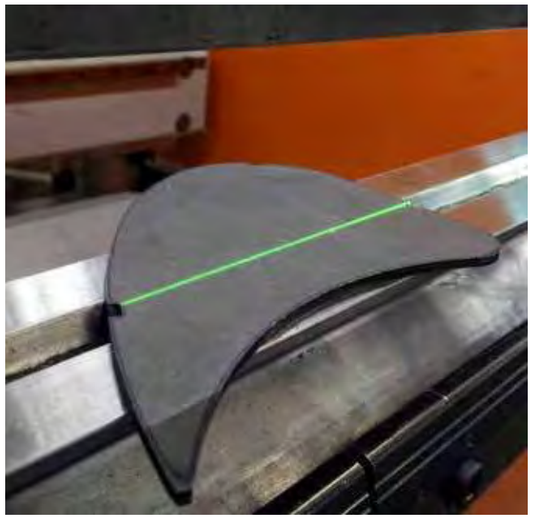
Laser Tracker

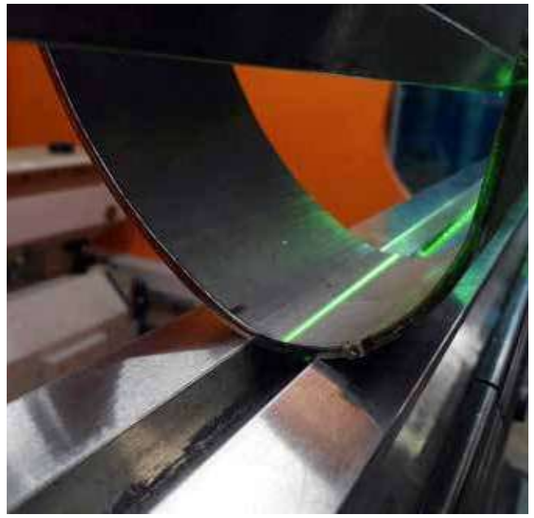
- There will be no need of some steps of programmation and the accuracy will be instantly millimetric
- Execution speed and accuracy
- Universal simple installation
- Compact and functional design
- Reliable result also in multi-station

Ideal for:

- Rolling
- Conic bending (funnels and hoppers)
- Dressing cycle (transverse stiffeners for thin panels)
- Irregular profiles difficult to be leant to posterior backgauges
- Marked bending (e.g: laser marking or other reference with marks)







	L [mm]	L [in]	Weight
Smart Holder	600	23.62	3.0 kg
Laser Tracker	-	-	3.0 kg

On stock

Ask for delivery time

MORE ROLLERI TOOLS

CLAMPING SYSTEMS	270 - 271
SHEAR BLADES	272 - 273
PANEL BENDING TOOLS	274
PUNCHING TOOLS	275
LASER CONSUMABLES	276 - 277

REQUEST NEW ROLLERI COMPLETE CATALOGUE

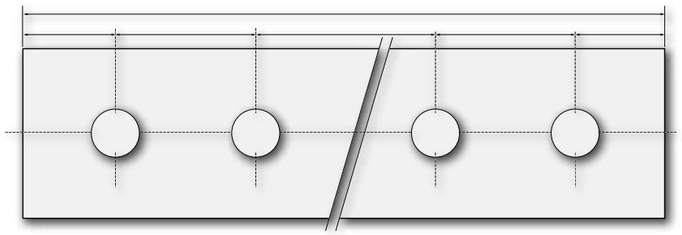
TOOLS	CLAMPING ROLLERI	UPPER SIDE	LOWER SIDE	VERTICAL CHANGE	HORIZONTAL CHANGE	PNEUMATIC VERSION	HYDRAULIC VERSION	MANUAL VERSION
R1	ROL200 KDS	●	-	●	●	●	●	-
R1	ROL200	●	-	●	-	●	●	●
R1	ROL4	●	-	-	●	-	●	●
R1	FAST CLAMP	●	-	●	●	-	-	●
R1	DOUBLE FAST CLAMP	●	-	●	●	-	-	●
R1	EASY CLAMP	●	-	-	●	-	-	●
R1	DOUBLE EASY CLAMP	●	-	-	●	-	-	●
R1	ROL2	-	●	-	-	●	●	●
R2	W ROL	●	-	●	●	●	●	-
R2	W ROL 2	-	●	-	-	●	●	-
R3 R4 RX	ROL3	●	-	●	●	-	●	-
R American	UNIVERSAL FAST CLAMP	●	-	●	-	-	-	●
R American	UNIVERSAL EASY CLAMP	●	-	-	●	-	-	●

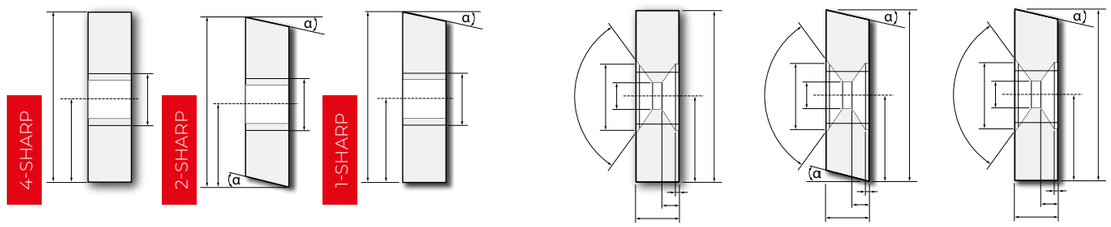
Shear Blades

Rolleri has been producing shear blades for more than 20 years, using high quality steel to guarantee reliability and wear resistance.

Each product is studied on customer's needs: material to cut, holes and hardening upon your request.
Blades with 1, 2 or 4 cutting edges with threaded holes or dimpled holes.

Available sizes mm (in)									
50 (1.97)	55 (2.17)	60 (2.36)	65 (2.56)	70 (2.76)	75 (2.95)	80 (3.15)	85 (3.35)	90 (3.54)	100 (3.94)
50x10 (1.97x0.39)									
50x11 (1.97x0.43)									
50x12 (1.97x0.47)	55x12 (2.17x0.47)	60x12 (2.36x0.47)							
50x13 (1.97x0.51)	55x13 (2.17x0.51)	60x13 (2.36x0.51)	65x13 (2.56x0.51)	70x13 (2.76x0.51)					
50x14 (1.97x0.55)	55x14 (2.17x0.55)	60x14 (2.36x0.55)	65x14 (2.56x0.55)	70x14 (2.76x0.55)					
50x15 (1.97x0.59)	55x15 (2.17x0.59)	60x15 (2.36x0.59)	65x15 (2.56x0.59)	70x15 (2.76x0.59)	75x15 (2.95x0.59)				
	55x16 (2.17x0.63)	60x16 (2.36x0.63)	65x16 (2.56x0.63)	70x16 (2.76x0.63)	75x16 (2.95x0.63)	80x16 (3.15x0.63)			
	55x17 (2.17x0.67)	60x17 (2.36x0.67)	65x17 (2.56x0.67)	70x17 (2.76x0.67)	75x17 (2.95x0.67)				
	55x18 (2.17x0.71)	60x18 (2.36x0.71)	65x18 (2.56x0.71)	70x18 (2.76x0.71)	75x18 (2.95x0.71)	80x18 (3.15x0.71)	85x18 (3.35x0.71)		
	55x19 (2.17x0.75)	60x19 (2.36x0.75)	65x19 (2.56x0.75)	70x19 (2.76x0.75)	75x19 (2.95x0.75)	80x19 (3.15x0.75)	85x19 (3.35x0.75)		
	55x20 (2.17x0.79)	60x20(2.36x0.79)	65x20(2.56x0.79)	70x20(2.76x0.79)	75x20(2.95x0.79)	80x20 (3.15x0.79)	85x20(3.35x0.79)	90x20(3.54x0.79)	100x20(3.94x0.79)
					75x21 (2.95x0.83)	80x21 (3.15x0.83)	85x21 (3.35x0.83)	90x21(3.54x0.87)	
					75x22 (2.95x0.87)	80x22 (3.15x0.87)	85x22 (3.35x0.87)	90x22(3.54x0.87)	100x22(3.94x0.87)
					75x23 (2.95x0.91)	80x23 (3.15x0.91)	85x23 (3.35x0.91)	90x23 (3.54x0.91)	
					75x24(2.95x0.94)	80x24 (3.15x0.94)	85x24(3.35x0.94)	90x24(3.54x0.94)	
					75x25 (2.95x0.98)	80x25 (3.15x0.98)	85x25(3.35x0.98)	90x25(3.54x0.98)	100x25(3.94x0.98)
									100x26(3.94x1.02)
									100x27(3.94x1.06)
									100x28(3.94x1.10)
									100x29(3.94x1.14)
									100x30(3.94x1.18)





Please provide us with the following information:

- What material are you cutting with your machines: Steel, Stainless Steel, Aluminium, etc.?
- How thick is the material?
- How often do you use your cutting machine? (per hour, day, week)
- How many upper and lower shear blades are needed?

Panel bending tools

- In-house construction (no reseller or dealer)
- Production according to your specifications
- Every single tool is traceable thanks to a unique serial number stamped after the first quality control
- Precision grinding (tolerance of +/-0.01 mm)
- Exact parallelism
- Use of the best materials, guaranteed high resistance and tensile strength

Punching Tools

ROLLERI TYPE R1 → Compatible with OEM: Amada, Amada ABS, Wilson HP, Wilson HP WLS and Mate Ultra Tec
- A-E Station
- Multitools
- Accessories

ROLLERI TYPE R2 → Compatible with OEM: Trumpf
- Standard Tools
- Multitools
- Slitting Tools
- Accessories

ROLLERI TYPE RS → Compatible with OEM: Salvagnini
- Type 3 Tools

ROLLERI TYPE R4 → Compatible with OEM: Geka,Peddinghaus,Mubéa-Sunrise,Selfer,Alfra,Imac,Ficep,Kingsland
- Ironworker

SPECIAL TOOLS → Fully compatible with Thick Turret punching machine

REQUEST NEW
ROLLERI COMPLETE CATALOGUE

Laser consumables

CO2 LASER LENSES

ROLLERI Type A Lenses
- <0.2% absorption
- Extended life
- Guaranteed quality
- Meniscus and plano-convex lenses

ROLLERI Type C Lenses
- <0.13% absorption
- Extended life
- Suitable for high-power lasers
- Compatible with heNe lasers beam
- Meniscus and plano-convex lenses

FIBER LASER LENSES

- Made of fused silica for high power
- Minimal absorption percentage
- Coated surface

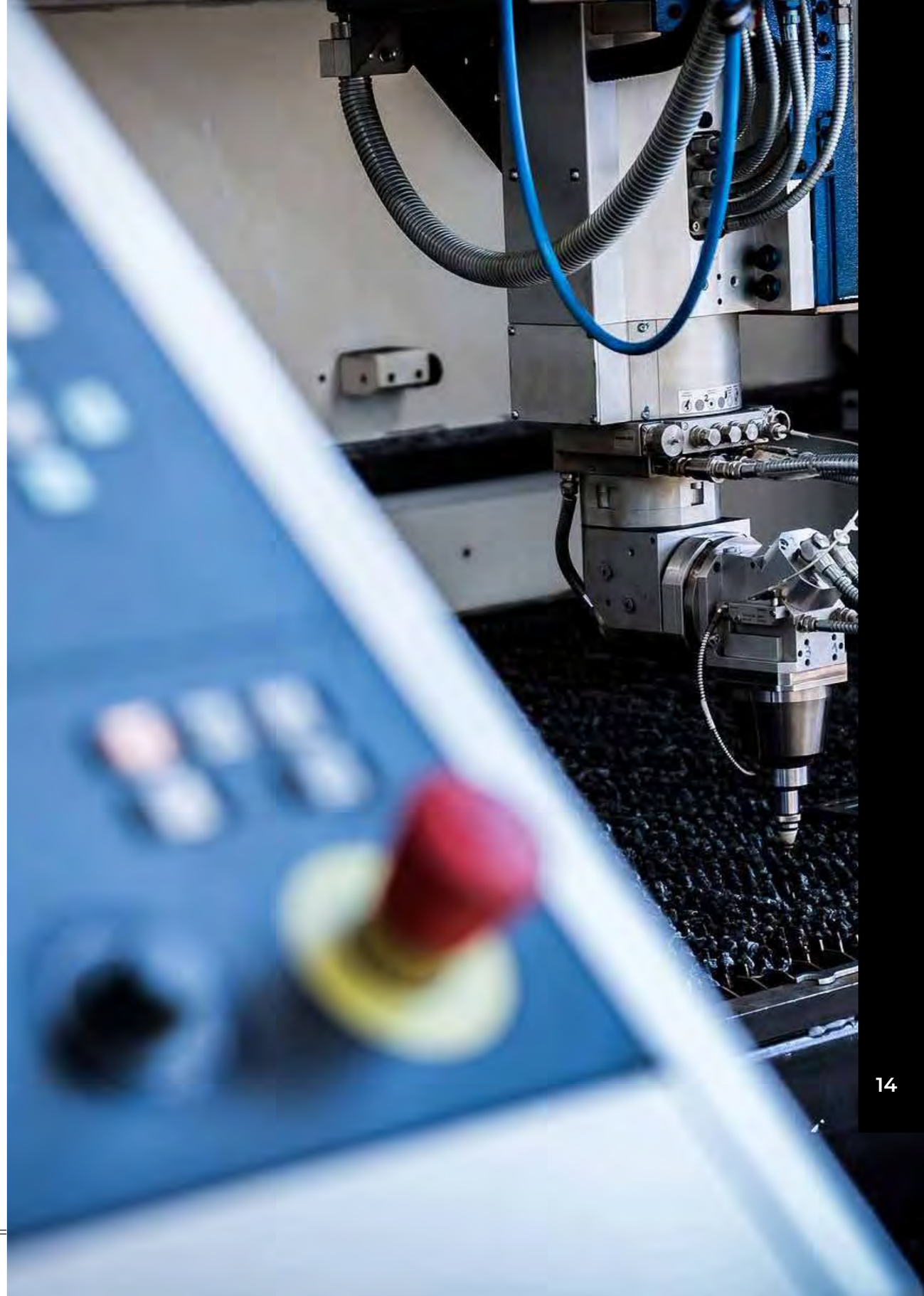
PROTECTIVE WINDOWS

- Better results
- Better quality-price ratio
- Surface coated
- Low absorption

NOZZLES

- Compatible with most OEM lasers
- Tight production tolerance
- Normal and chromed nozzles for Co2 lasers
- Nozzles for fiber lasers
- Ceramics
- Accessories and spare parts

REQUEST NEW
ROLLERI COMPLETE CATALOGUE



TOOLS SPECIFICATION AND MODIFICATIONS

SPECIFICATION OF ROLLERI TOOLING	280 - 281
TOOLS MODIFICATIONS	282 - 289
R1 - Modification of standard tang	282
R2 - Modification of standard tang	283
R3 - Modification of standard tang	284
Special Sectioning	284
Horn Pieces	285
Modifying the V-Opening	285
Radius modifications	285
Angle Modifications	286
Grooves for Dies	286
Modified Tangs	287
Gaps	288
Windows	288
SPECIAL TREATMENTS	289
PRESS FORCE TABLE	290 - 291
U-TABLE	292 -295

- Every single tool is traceable thanks to a unique serial number stamped after the first quality control
- All tools with batch number and therefore a complete tool traceability
- All tools induction hardened to 54-60 HRc
- Precision grinding (tolerance of +/-0.01 mm)
- ISO 9001:2015 Certification
- Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

Standard Tools material

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4 **42Cr: 900-1150 N/mm²**	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45 **C45: 560-710 N/mm²**	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC

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

Rolla-V Dies material

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1 / 2 / 2.5 / 3 / 4	42CrMo4 **42Cr: 900-1150 N/mm²**	900-1150 N/mm²	55 HRc
Inserts	1 / 2 / 2.5	Toolox 44 **Toolox 44**	1450 N/mm²	through hardened 44 HRc
Inserts	3 / 4	Toolox 33 **Toolox 33**	1100 N/mm²	55 HRc

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

Special and Heavy duty Tools material

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4 **42Cr: 900-1150 N/mm²**	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45 **C45: 560-710 N/mm²**	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC
1.2767 **1.2767: 1100-1320 N/mm²**	1100-1320 N/mm²	36 - 42 HRC	54 - 60 HRC
C53 **C53: 610-760 N/mm²**	610-760 N/mm²	16 - 19 HRC	60 - 62 HRC

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

Specification of Rolleri tooling

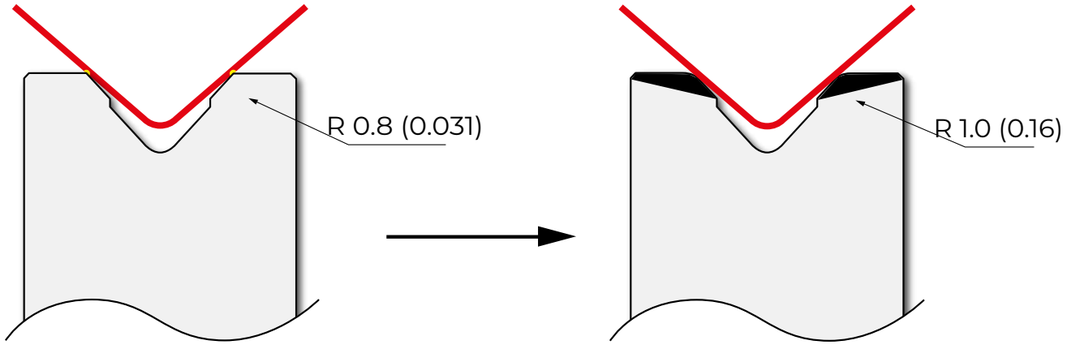
Prevention or Reduction of Bending Marks

One of the challenges of bending is preventing the profile from having bending marks, such as scratches and abrasions on the surface areas. Especially profiles made of:

- Stainless Steel
- Aluminium
- Painted metal panels

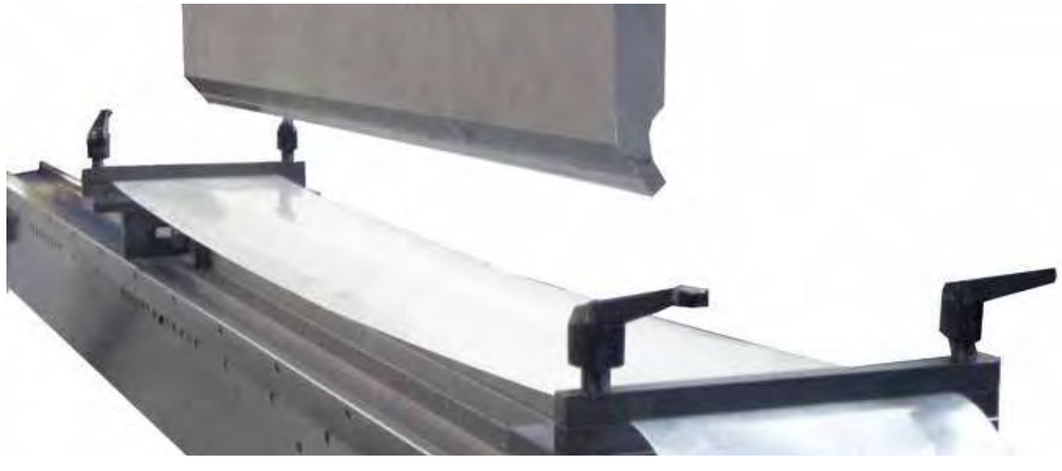
Often because of friction between sheet metal and die, after bending process, you could see some marks on material. In order to avoid this inconvenience, Rolleri suggests you some possible solutions:

- Bending Foil
- Polyurethane inserts
- Synthetic Dies
- Rolla-V
- Roll Prime NEW
- Enlarged radius on the V opening of a die



Standard T-Die
with small radius on the V opening
causes visible bending marks

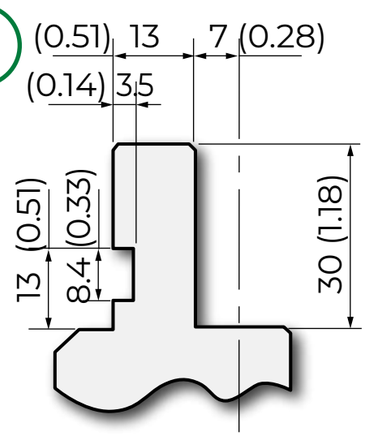
T-Die TR
with an enlarged radius on the V opening
reduces visibly the bending marks



Modified Tangs

- Rolleri Punches Type R1, R2, and R3 can be used on other press brake machines by modifying the tang
- Precision ground (Tolerance of +/-0.01 mm)
- Exact parallelism

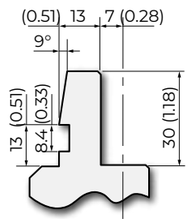
R1



OT

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

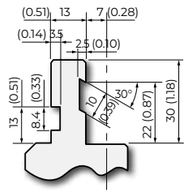
For:
Amada fast clamping system



A1

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

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

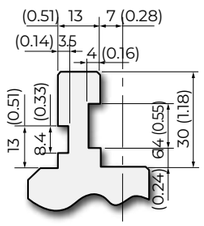


A6

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

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

- R3
- Bystronic-Beyeler Euro
- Safan

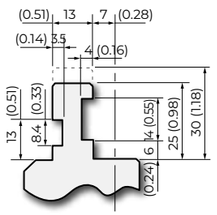


A7

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:

- R3
- Bystronic-Beyeler Euro
- Safan

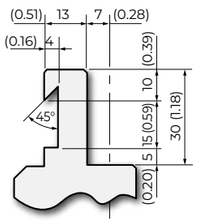


A8

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

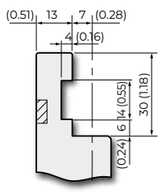
Groove for:

- Hydraulic clamping system Gasparini



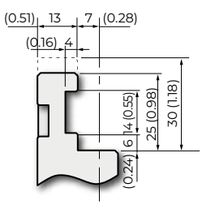
A41

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in



A42

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

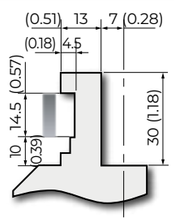


A43

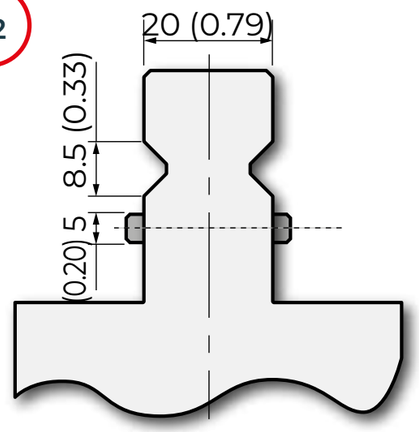
835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Groove with steel bar for:

- Segmented punches

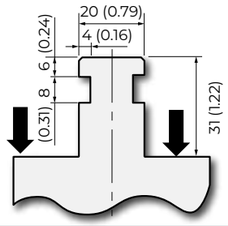


R2



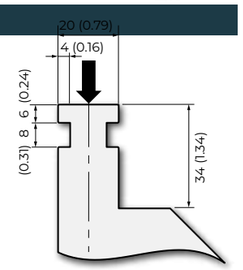
Example 1

Modification of R2 punch with shoulder bearing

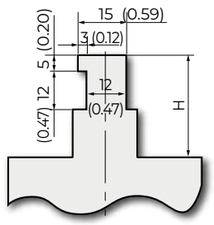


Example 2

Modification of R2 punch with head bearing



Example 3



1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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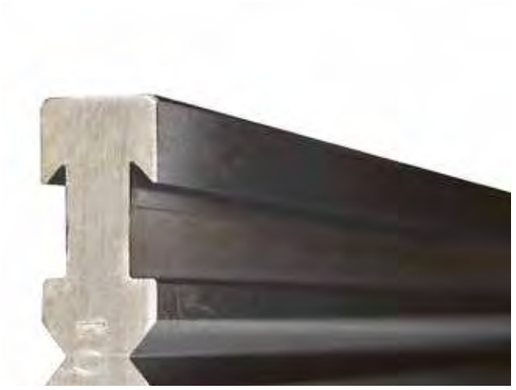
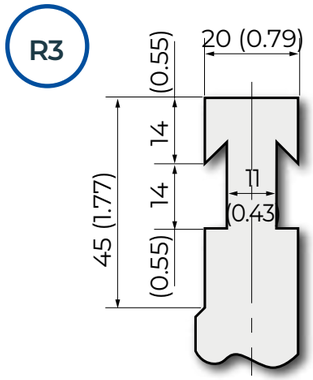
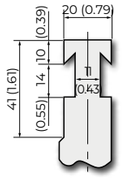
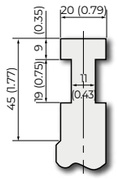




Example 1



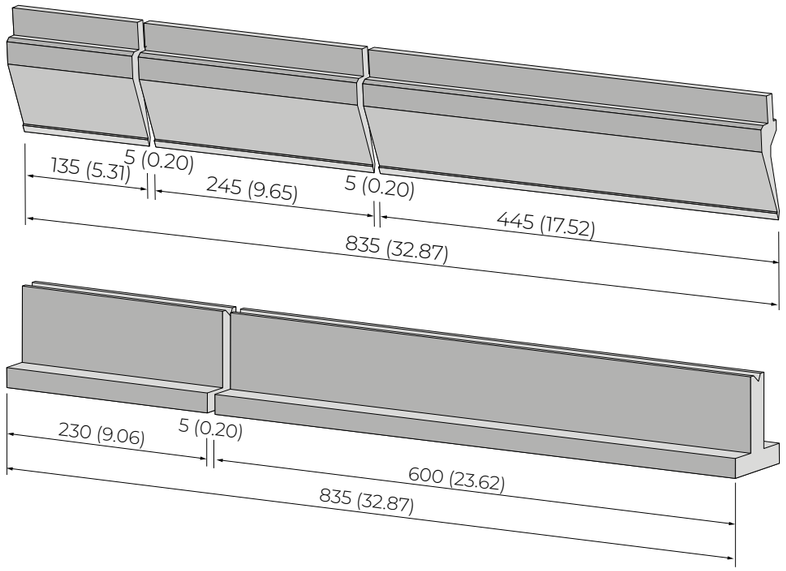
Example 2



Special Sectioning

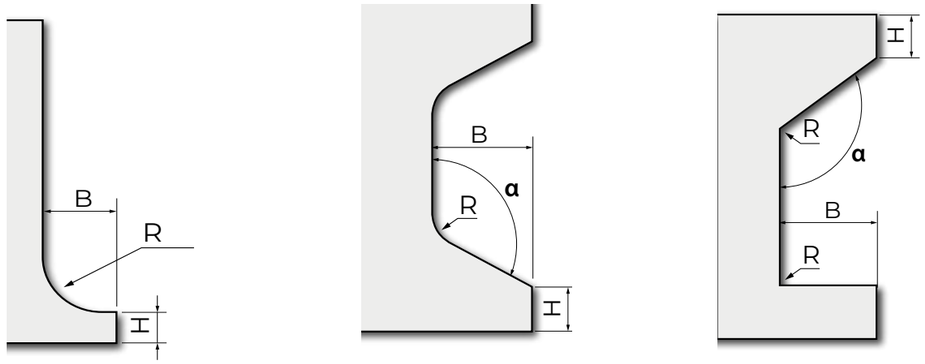
- Individual sectioning of your punches and dies
- Every cut wastes about 5 mm material
- Production according to your specifications

Example:



Horn Pieces

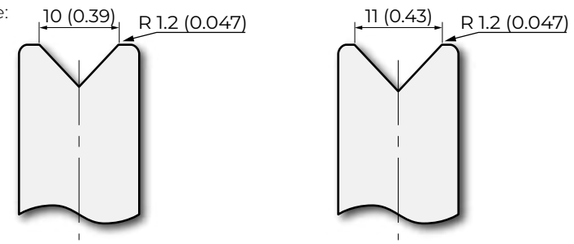
- Individual horn pieces on punches and dies
- On one or both sides



Modifying the V-Opening

- Individual modification for dies
- Production according to your specifications

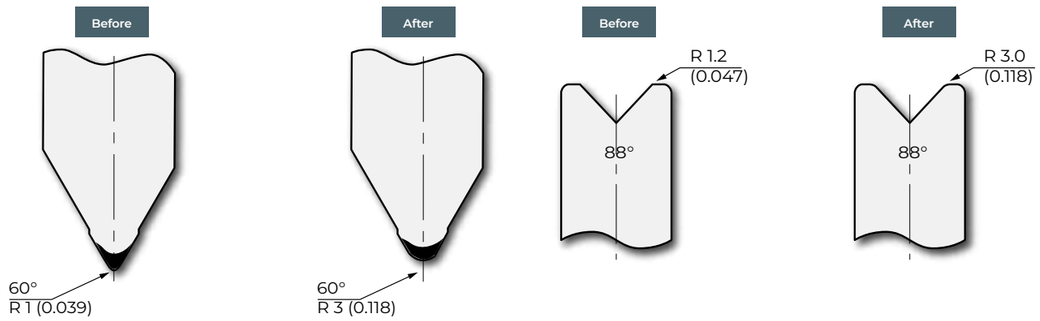
Example:



Radius Modifications

- Production according to your specifications

Example:



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100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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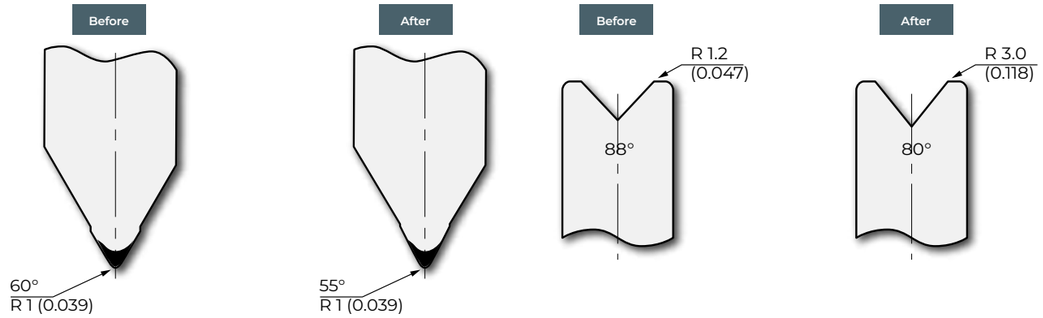
Angle Modifications

- Production according to your specifications

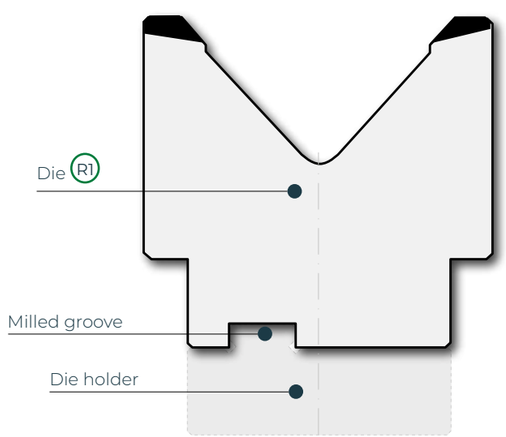
Example:



Grooves for Dies

- Milling of grooves to use in other press brakes

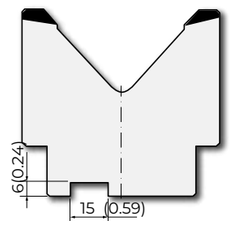
Example of Application



A28

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

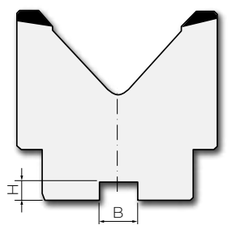
Groove for die holder



A29

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

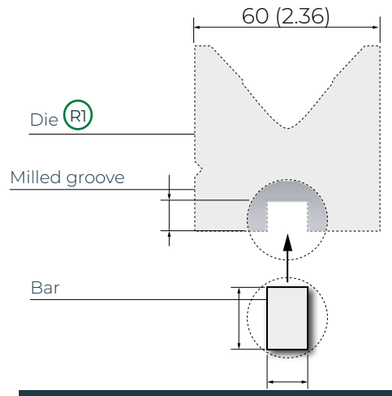
Groove production according to your specifications



Modified Tangs

Rolleri can mill a groove in the die base and insert a bar of the correct dimensions to use the die in a different clamping system.

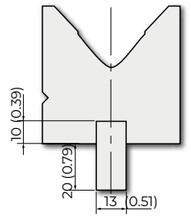
Example of Application



A30

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

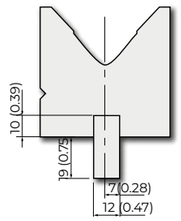
Groove Bars:
13 x 30 mm (0.51 x 1.18 in) for
- R2
- R3



A31

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

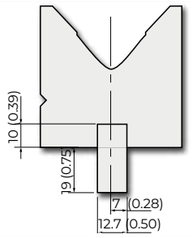
Groove Bars:
12 x 29 mm (0.47 x 1.14 in) for
- R4



A32

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

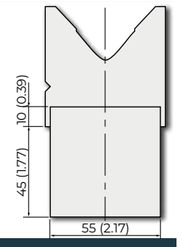
Groove Bars:
12.7 x 29 mm (0.50 x 1.14 in) for
- R4



A44

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

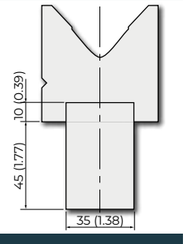
Groove Bars:
55 x 55 mm (2.17 x 2.17 in) for
- RX EHT



A45

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

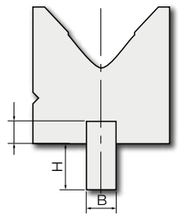
Groove Bars:
35 x 55 mm (1.38 x 2.17 in) for
- RX Weinbrenner



AX

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

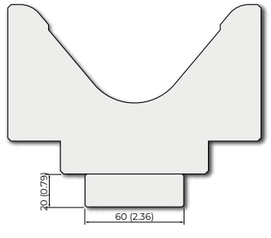
Individual Groove Bars
for other systems



A60

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

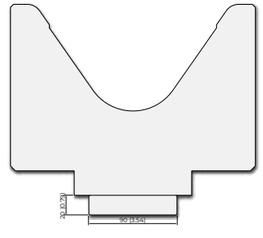
Plate for R1 dies:
- M103.80.125
- M130.80.160
- M195.70.200



A90

835 mm	32.87 in
415 mm	16.34 in
805 mm	31.69 in

Plate for:
- M195.70.200 R1
- RVM90-4 Rolla-V die



1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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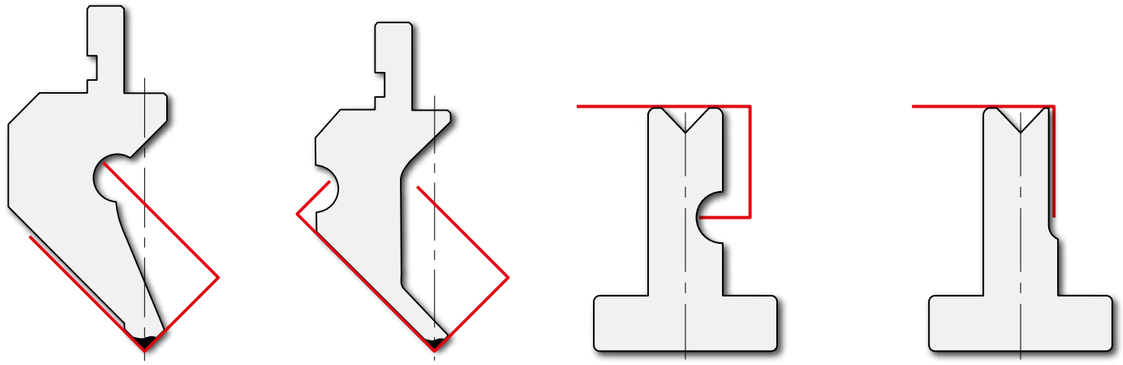
Tools modifications

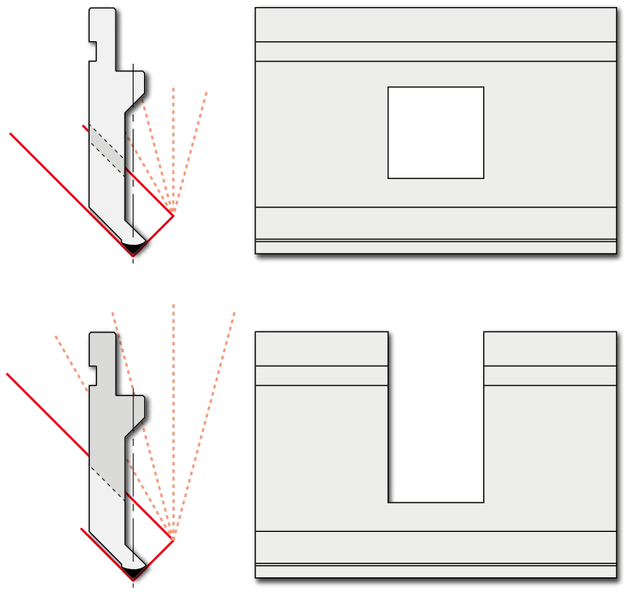
Gaps

- Production according to your specifications



Windows

- Production according to your specifications



Special Treatments

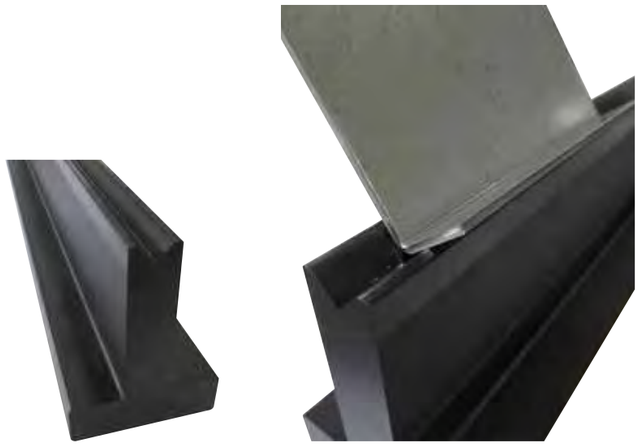
Rolleri BLACKFIRE

Rolleri BLACKFIRE is a particular tool coating which guarantees corrosion resistance and special design.
This chemical treatment is a long-lasting solution to surface oxidation. During the phosphatising process, the metal surface of tools changes because of phosphatic crystals formation, which are chemically bound to the tool steel. We can take advantage of these chemical compounds to increase corrosion resistance, so that your tools will have longer operational life.
The glossy black colour of BLACKFIRE represents a new technology which combines usage advantages and better aesthetics.
Tools with BLACKFIRE treatment have different delivery time than standard tools.

Rolleri FREEZINC

Take advantage of Rolleri new and special surface treatment. This new improvement gives you the following big advantages:

- No metal residue left on tools during bending of galvanized sheet metal or other sheet metal that tends to leave residue
- No need to clean tools from residue
- Down-time reduction due to tool cleaning and consequently increase in productivity
- Tool protection from oxidation
- Tools aesthetically stand out
- Reduced tool wear and consequently longer operational life
- Lower chances to damage the sheet metal
- Lower risk that the sheet metal gets stuck in the V die opening.



1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

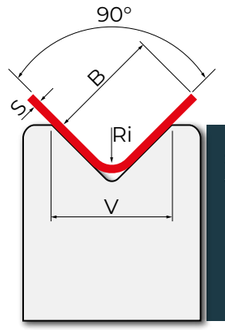
On stock Ask for delivery time

Press Force Table

The press force table works exactly in the same way as the bending ruler and is very useful to those who deal with sheet metal profiles. It can assist you from the design of profiles, to technical construction, to the buying of tools, and to the finished profile made with a press brake.

In the first column on the left the thickness of the sheet metal is marked as (S). In the three first lines you can find the die V opening (V), the minimum internal edge (B), and the ideal inner profile radius (Ri).

By crossing the thickness with the die opening, you will find the necessary press force per meter. As you can see, for each sheet metal thickness you can choose among 5 different V openings. On the bottom of the page you can find correction factors.



S = Thickness
V = Die V opening
B = Min. internal edge
Ri = Inner Profile Radius

420 N/mm²																				
S (mm)	4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
	3.0	3.5	4.0	5.5	6.5	8.0	10.5	13.0	16.5	21.0	26.0	32.5	41.0	52.0	65.0	81.5	104.0	130.0	163.0	B
	0.5	0.7	0.8	1.0	1.3	1.5	2.0	2.5	3.2	4.4	5.0	6.5	8.0	10.0	12.0	15.0	20.0	25.0	37.0	Ri
0.6	60	50	30	20																
0.8	120	90	70	50	40															
1.0		150	110	80	60	50														
1.2			180	120	90	70	50													
1.5				210	150	120	80	60												
2.0					300	230	160	120	90											
2.5						390	270	200	140	110										
3.0							430	310	230	160	120									
4.0								600	440	320	230	180								F kN/m
5.0									760	540	390	290	220							
6.0										850	620	450	330	250						
8.0											1210	880	700	460	350					
10.0												1510	1090	790	580	440				
12.0													1730	1240	910	660	500			
15.0														2130	1550	1130	810	620		
20.0															3020	2200	1580	1150	890	
25.0																3780	2690	1970	1440	

INOX – stainless steel R 700 N/mm² F x 1.7
AL – aluminium R 200 N/mm² F x 0.5
(R = tensile strength)

30°	B x 1.6	R=200 N/mm²	r x 0.8	Al
60°	B x 1.1			
90°	B x 1.0	R=420 N/mm²	r x 1.0	Fe
120°	B x 0.9			
150°	B x 0.7	R=700 N/mm²	r x 1.4	INOX

1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

On stock

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	A x B	10x10	10x15	10x20	10x25	10x30	15x10	15x15	15x20	15x25	15x30	15x35	15x40	20x10	20x15	20x20	20x25	20x30	20x35	20x40	20x45	20x50	20x55	25x10	25x15	25x20	25x25	25x30	25x35	25x40	25x45	25x50	25x55	25x60	25x65	25x70	25x75	30x10	30x15	30x20	30x25	30x30	30x35	30x40	30x45	30x50	30x55	30x60	30x65	30x70	30x75	30x80
04702							✓	✓	✓					✓	✓	✓	✓	✓	✓					✓	✓	✓	✓	✓	✓	✓	✓	✓					✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓			
D.116.88.R08							✓							✓										✓	✓													✓	✓	✓	✓												
LPW23.126.R2							✓							✓	✓									✓	✓	✓												✓	✓	✓													
LPW23.126.R2-A							✓							✓	✓									✓	✓	✓												✓	✓	✓	✓												
LPW23.178.R2-A							✓							✓	✓	✓	✓							✓	✓	✓	✓	✓	✓	✓								✓	✓	✓	✓	✓	✓	✓									
LPW23.178.R2-B														✓	✓	✓								✓	✓	✓	✓	✓	✓	✓								✓	✓	✓	✓	✓	✓	✓	✓								
LPW23.178.R2-C							✓	✓						✓	✓	✓								✓	✓	✓	✓											✓	✓	✓	✓	✓											
LPW23.178.R3																																						✓															
P.114.88.R06		✓	✓	✓	✓		✓	✓	✓	✓	✓			✓	✓	✓	✓	✓	✓					✓	✓	✓	✓	✓	✓									✓	✓	✓	✓	✓	✓	✓									
P.115.60.R08							✓	✓	✓					✓	✓	✓	✓	✓						✓	✓	✓	✓	✓	✓	✓								✓	✓	✓	✓	✓	✓	✓									
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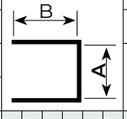

1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

✓ On stock

Ask for delivery time

Tel. +39 0523 87 09 05
sales@rolleri.it

AxB	10x10	10x15	10x20	10x25	10x30	15x10	15x15	15x20	15x25	15x30	15x35	15x40	20x10	20x15	20x20	20x25	20x30	20x35	20x40	20x45	20x50	20x55	25x10	25x15	25x20	25x25	25x30	25x35	25x40	25x45	25x50	25x55	25x60	25x65	25x70	25x75	30x10	30x15	30x20	30x25	30x30	30x35	30x40	30x45	30x50	30x55	30x60	30x65	30x70	30x75	30x80
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TOP.175.85.R08.S	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
TOP.205.26.R08													✓										✓	✓													✓	✓	✓	✓											
TOP.205.85.R08						✓	✓	✓	✓				✓	✓	✓	✓	✓	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
TOP.250.26.R08													✓										✓	✓													✓	✓	✓	✓											
TOP.SP.134.28.8													✓										✓	✓													✓	✓	✓												
TOP.SP.134.24.10													✓										✓	✓													✓	✓	✓												
TOP.SP.134.24.12													✓										✓	✓													✓	✓	✓												
TPR.135.86.R1	✓					✓	✓	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓			✓	✓	✓	✓	✓	✓	✓	✓	✓						✓	✓	✓	✓	✓	✓	✓	✓	✓	✓					
TPR.157.28.R1													✓	✓									✓	✓	✓												✓	✓	✓	✓											
TPR.157.60.R1						✓	✓						✓	✓	✓	✓							✓	✓	✓	✓	✓	✓									✓	✓	✓	✓	✓	✓	✓								
TPR.157.60.R4																																					✓														
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TPR.157.86.R1-A						✓	✓						✓	✓	✓								✓	✓	✓	✓											✓	✓	✓	✓	✓										
TPR.176.28.R1						✓							✓	✓									✓	✓	✓	✓											✓	✓	✓	✓											
TPR.200.80.R1						✓	✓						✓	✓	✓								✓	✓	✓	✓											✓	✓	✓	✓	✓										
TPR.237.28.R1																							✓	✓	✓												✓	✓	✓	✓											
TPR.237.80.R1						✓	✓						✓	✓	✓								✓	✓	✓	✓											✓	✓	✓	✓	✓										
TPR.256.28.R1													✓	✓	✓								✓	✓	✓	✓											✓	✓	✓	✓	✓										
TPR.256.60.R4																																					✓														
TPR.256.86.R1						✓	✓						✓	✓	✓	✓	✓	✓					✓	✓	✓	✓	✓	✓	✓	✓	✓						✓	✓	✓	✓	✓	✓	✓	✓	✓	✓					
TPR.256.86.R1.A	✓					✓	✓						✓	✓	✓								✓	✓	✓	✓											✓	✓	✓	✓	✓										
TPR.276.28.R1						✓							✓	✓									✓	✓	✓												✓	✓	✓	✓											

AxB	30x85	40x10	40x15	40x20	40x25	40x30	40x35	40x40	40x45	40x50	40x55	40x60	40x65	40x70	40x75	40x80	40x85	40x90	40x95	50x10	50x15	50x20	50x25	50x30	50x35	50x40	50x45	50x50	50x55	50x60	50x65	50x70	50x75	50x80	50x85	50x90	50x95	50x100	50x105	60x10	60x20	60x30	60x40	60x50	60x60	60x70	60x80	60x90	60x100	60x110	70x10	70x20	70x30	70x40	70x50	70x60
P.97.85.R08																																																								
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TOP.175.85.R08.S	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
TOP.205.26.R08																																																								
TOP.205.85.R08	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
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TPR.256.86.R1.A																																																								
TPR.276.28.R1																																																								

1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

✓ On stock

Ask for delivery time

Tel. +39 0523 87 09 05
sales@rolleri.it

ABOUT US

- Since 1987 we have been producing standard and special tooling. The family owned company (Francesco and Marco Rolleri) can nowadays be considered one of the largest press brake tooling manufacturers in Europe. We offer a fast and reliable service through our partners all over Europe.
- The reorganization of our sales force, happened in 2012, has guaranteed a widespread presence of our products in every single market.
- For this reason, our production was enlarged considerably with an additional hall and many new machines in the year 2016.

ROLLERI WORLD
Today

Rolleri S.p.A. – Head Office it
Rolleri Baltic ba
Rolleri Benelux bx
Rolleri Do Brasil br
Rolleri Trad. Co. China cn
Rolleri Česká Republika cz
Rolleri Iberica es
Rolleri Finland fi

Rolleri France fr
Rolleri Deutschland GmbH de
Rolleri Polska pl
Rolleri Slovensko sk
Rolleri Ukraine LLC ua
Rolleri USA us
Rolleri UK gb

OUR PRODUCTION
Warehouse, Manufacturing and Quality

▸ Manufacturing

Besides manufacturing many special tools, our research and development team also designs fast clamping systems in order to increase your productivity.

Technicians and engineers develop for you convenient and practical solutions.

We work with highly complex 3D simulation models and we are able to create bending samples of various profiles.

▸ Quality

Rolleri is ISO 9001:2015 certified.

For us, being your supplier means helping you to find the best and most convenient tool and to develop a large number of bending solutions. Furthermore, we offer training for your bending department employees.

Our quality control department checks and tests every single tool after a complete production cycle. After a careful inspection, every tool is marked with a serial number and a batch number. This process guarantees complete tool traceability.

Rolleri also guarantees accurate reproduction, high-quality material, induction hardening and precision grinding.

OUR PRODUCTION
Raw Material and Production

▸ Raw Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

▸ Rolleri Tools

Every tool is manufactured in Rolleri's production facilities. This enables us to guarantee high quality, repeatability and parallelism thank to high precision grinding.

We use induction hardening at 54-60 HRc for all tools to get the best results for your punches and dies.

Each tool is subjected to quality control and then provided with a serial number to guarantee its traceability.

OUR PRODUCTION
Machinery

▸ Warehouse

With more than 20,000 press brake tools on stock, we hold one of the largest warehouses in Europe. Thanks to this, a large amount of tools is ready to be shipped all around the world.

▸ CNC-Milling

With our state-of-the-art milling centers we can quickly modify tools with high precision.

Very flexible tilting machine heads can carry out a wide variety of processes. This is where grooves, relieves, and other machining types are carried out.

▸ CNC-Profile Grinding

Our CNC-Professional grinding machines guarantee high precision (tolerance of +/-0.01 mm), accurate parallelism and repeatability.

Here you can also retrofit induction hardened and core hardened tools. Radius and angle modifications are precisely carried out upon request.

OUR PRODUCTION
Machinery

▸ Hardening

Tool working areas are exposed to the highest mechanical stress, because press brake force is concentrated on small surfaces. For this reason, press force on tool working areas is very high and it results in high friction between tools and sheet metal to be bent.

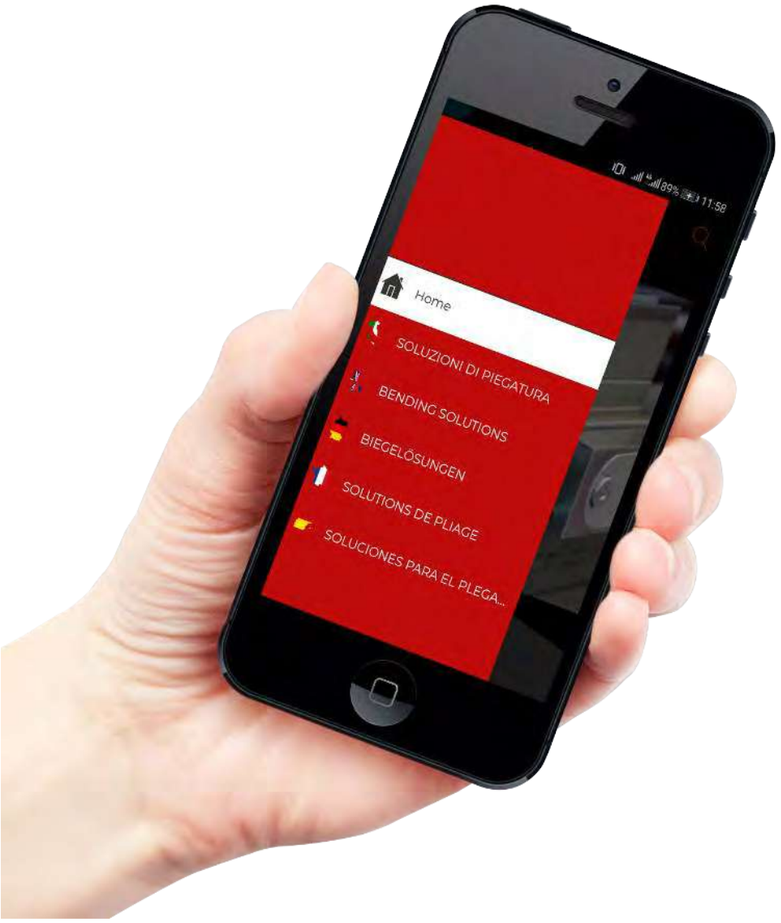
In order to have more resistant tools, their surface is hardened. Rolleri uses induction hardening, which penetrates about 3 mm into the tool steel, to guarantee high wear resistance and to offer customers the best solution to competitive prices.

▸ EDM

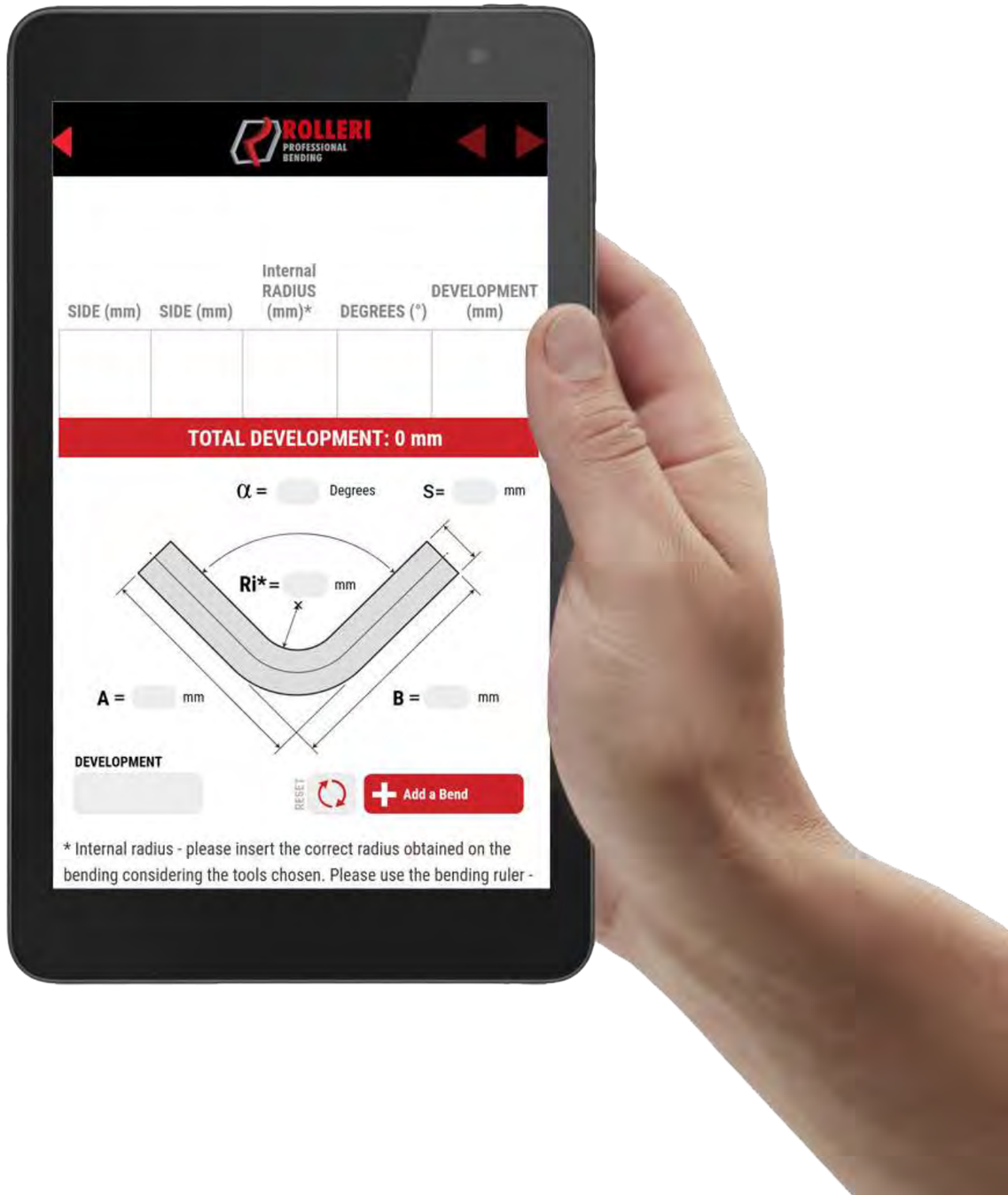
By using electro-discharge machines, Rolleri can machine hardened and tough materials. This process is based on the definition of the tool shape with a high precision CAD software and the manufacturing of simple and complicated shapes.

▸ 3D printer

The introduction of new “Additive” machines with the possibility of constructing any object with materials similar to steel starting from a 3D design. Thanks to this technology it’s possible to reduce the production time of very complex tools and to have fast delivery times



ROLLERI
BENDING APP



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